



SB-10044327-6332

Date	Group	No.	Release	Page
5.2012	437	002	01	1(16)

Allison Transmission Mount Replacement

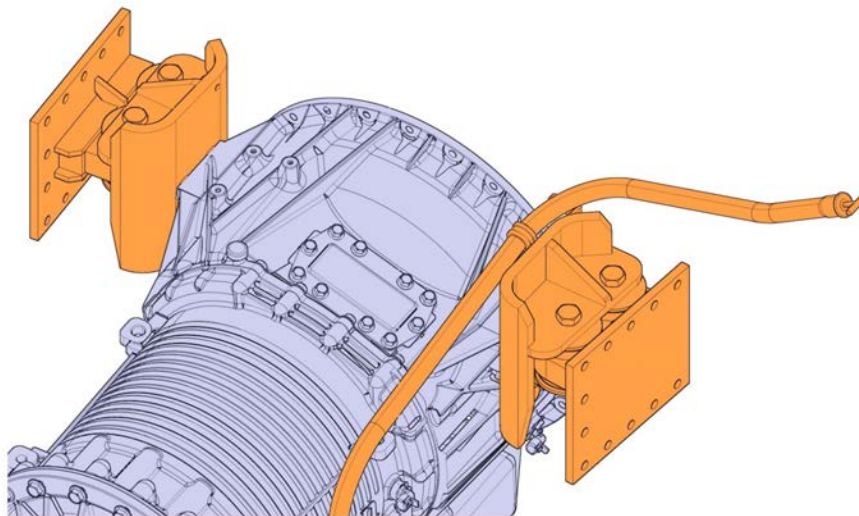
LEU, MRU
MP7

FSB 437-002, Transmission Mount, Replacement

(May 2012)

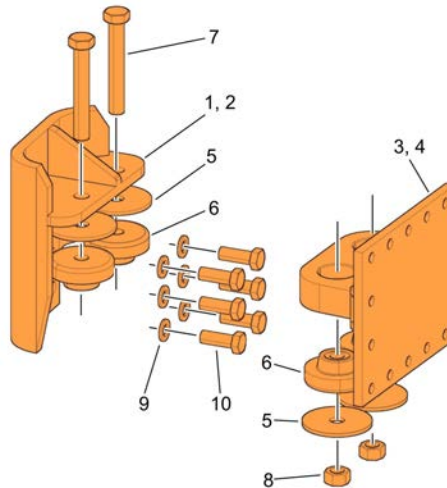
Allison transmissions on LEU and MRU MACK Truck models with an MP7 engine may experience cracks in the transmission housing under severe operating conditions. The cracks are located where the transmission/engine supports are attached. To resolve this issue, new frame brackets, transmission mounting brackets and mounting hardware is available for replacement of the existing transmission mounts. Additionally, the existing dipstick and dipstick tube assembly will be replaced due to interference of the new transmission mounting bracket. Applicable parts and procedures for replacing the transmission mounts are provided in this Field Service Bulletin.

Note: This bulletin does not apply to MACK Trucks Australia.



W4073826

Required Parts



W4073827

Transmission Mount Replacement Parts			
Item #	Part Number	QTY	Description
1	25156623	1	Bracket Trans Mounted, Right Side
2	25167424	1	Bracket Trans Mounted, Left Side
3	21892421	2	Bracket Frame Side W/Liner
4	21892458	2	Bracket Frame Side WO/Liner
5	25155021	8	Washer
6	25167342	8	Rubber Insulator
7	25091937	4	Bolt
8	25109333	4	Nut
9	20706115	12	Washer
10	25160670	12	Bolt
11	21475322	12	Bolt 14 mm (0.5 in) x 47 mm (1.8 in) W/ Liner
12	21475321	12	Bolt 14 mm (0.5) x 42 mm (1.6 in) WO/ Liner
13	21475706	12	Huckspin Collar

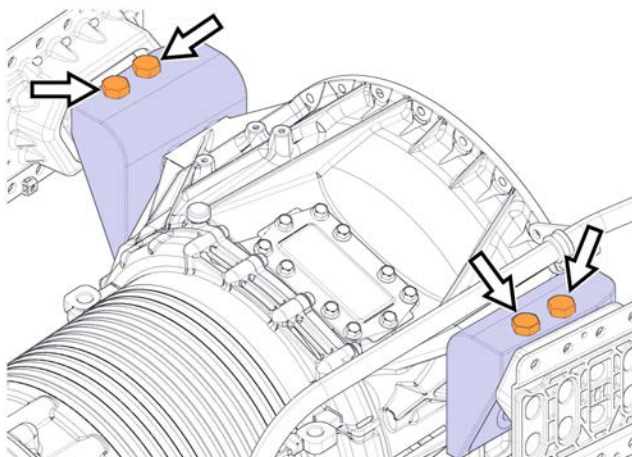
Replacement Dipstick and Dipstick Tube Assembly			
Item #	Part Number	QTY	Description
1	25152437	1	Allison, Dipstick Tube
2	20925236	1	Dipstick, Transmission Oil Level
3	25195153	1	Bracket
4	3968658	1	Screw
5	25087147	1	M6 Flange Screw
6	25095637	1	Clamp
7	25161716	1	Attaching Clamp, Straight P-Clamp-Rubber
8	20706309	1	Nut

Clamp Assembly			
Item #	Part Number	Qty	Description
1	995465	1	M8 x 35 Bolt
2	20960549	1	Clamp
3	990940	1	M8 Nut
4	N/A	N/A	Transmission Coolant Pipe

Procedure

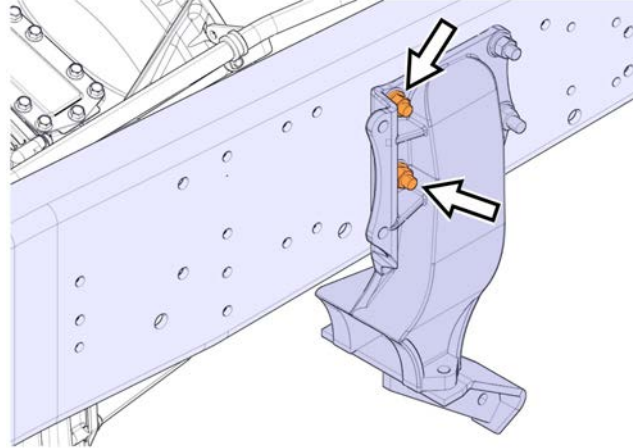
You must read and understand the precautions and guidelines in Service Information, group 40, "General Safety Practices, Transmission" before performing this procedure. If you are not properly trained and certified in this procedure, ask your supervisor for training before you perform it.

- 1 Chock wheels.
- 2 Disconnect all cables from the negative (ground) battery terminals to prevent personal injury from electrical shock and prevent damage to electrical components.
- 3 Raise the cab.
- 4 Use coolant extractor/injector 85112740 to drain coolant from engine and transmission.
- 5 Support transmission with suitable lifting device to enable access to engine/transmission mounts.
- 6 Remove vertical transmission support fasteners, passenger side.



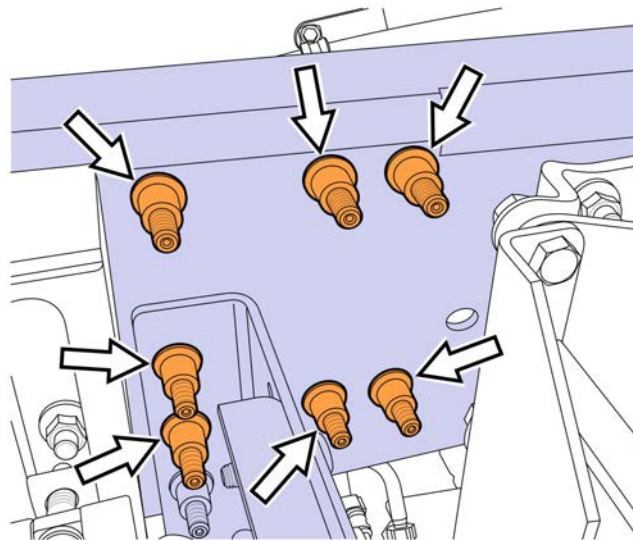
W4073828

- 7 Remove the two rear passenger side spring hanger fasteners.



W4073829

- 8 Using a huck splitter tool, remove the huck fasteners securing frame mounted transmission support and the applicable huck fasteners in the Diesel Exhaust Fluid (DEF) tank bracket.

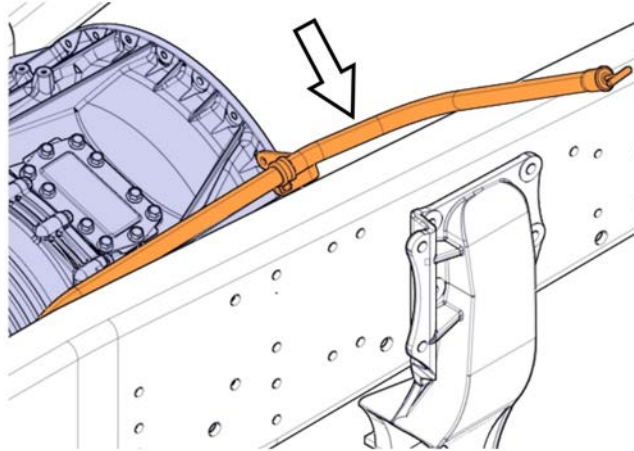


W4073830

- 9 Move the frame mounted transmission support forward of the transmission mounted support.
- 10 Clip applicable cable ties and relocate frame mount forward inside the frame rail to give access to transmission mounted support fasteners.

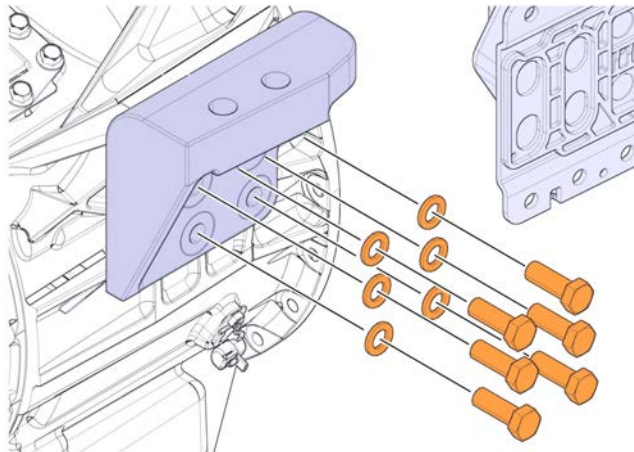
11 Remove the transmission dipstick tube and dipstick, then discard.

Note: Plug the access hole in the transmission with an appropriate size cap after removing dipstick tube and dipstick.



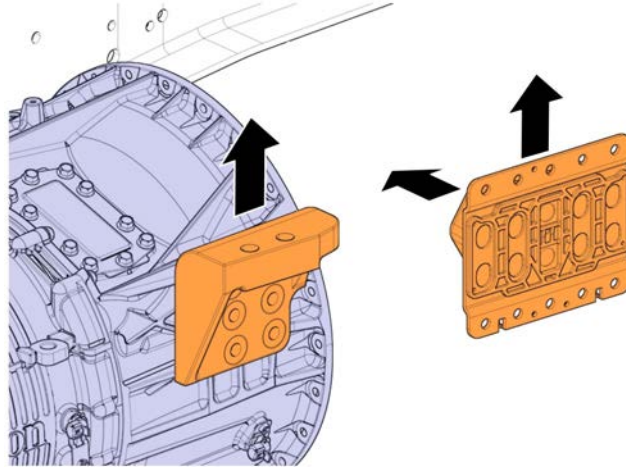
W4073831

12 Remove the fasteners securing passenger side transmission mounted support.



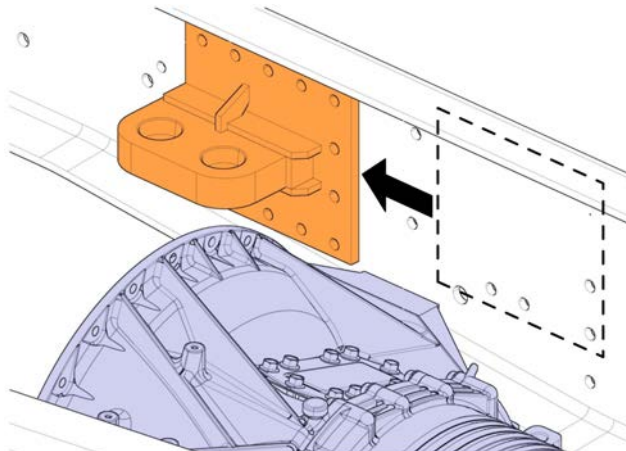
W4073832

13 Remove transmission mounted support and frame mounted support.



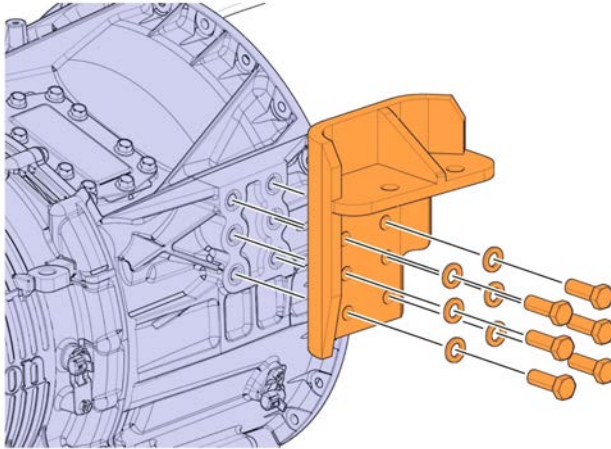
W4073833

14 Position passenger side replacement frame mounted support inside the frame rail and forward of the anticipated transmission mounted support location.



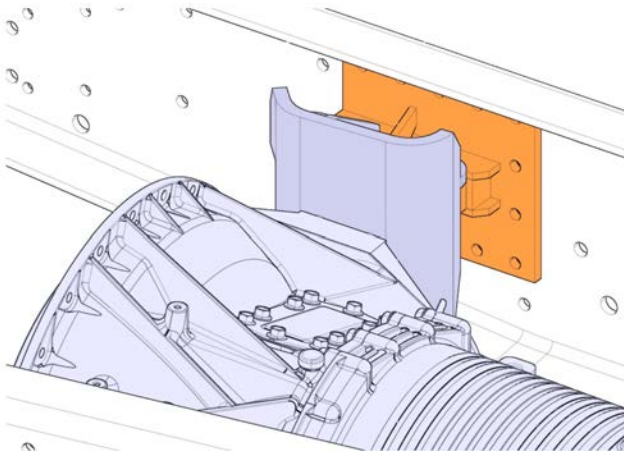
W4073834

15 Position and install the replacement passenger side transmission support and fasteners.
Tighten fasteners to 244 ± 16 Nm (180 ± 12 ft-lb).



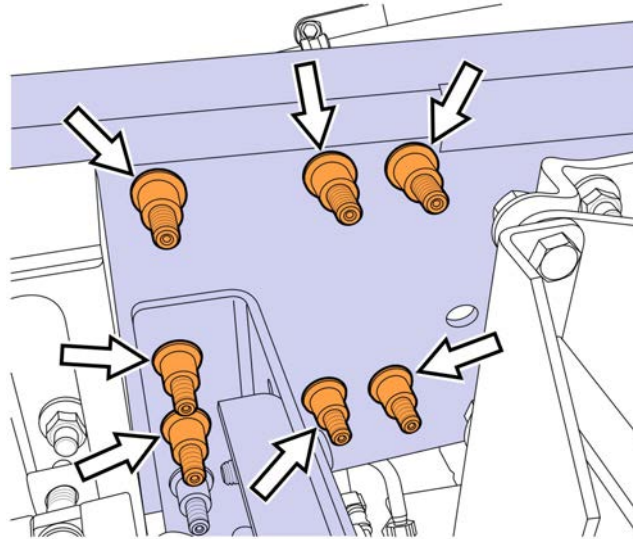
W4073835

16 Position frame mounted transmission support.



W4073836

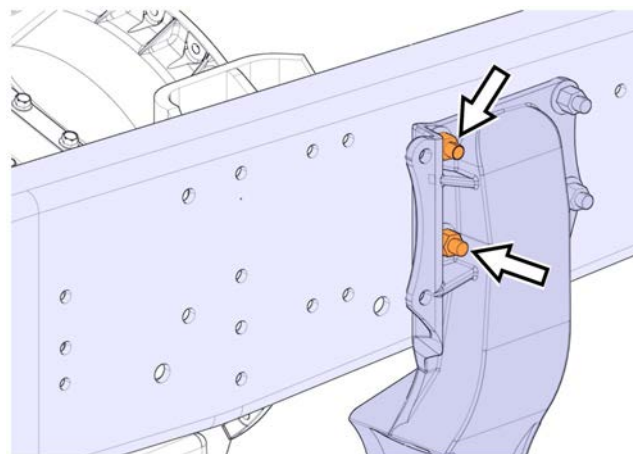
17 Install huck fasteners and collars.



W4073830

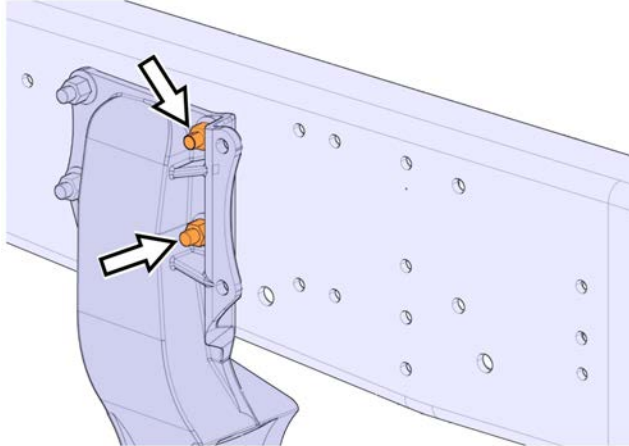
18 Using a huck fastener tool, Install new huck fasteners through the DEF tank bracket.

19 Install the two rear passenger side spring hanger fasteners.



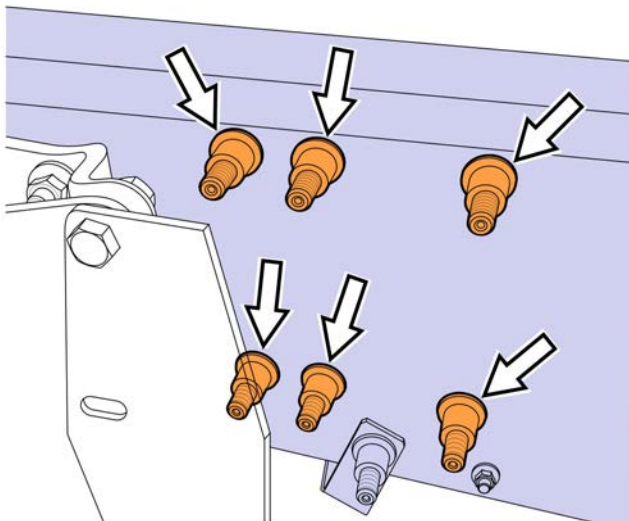
W4073837

20 Remove the two rear driver side spring hanger fasteners.



W4073838

21 Using a huck splitter tool, remove huck fasteners securing the driver side frame mounted transmission support.



W4073839

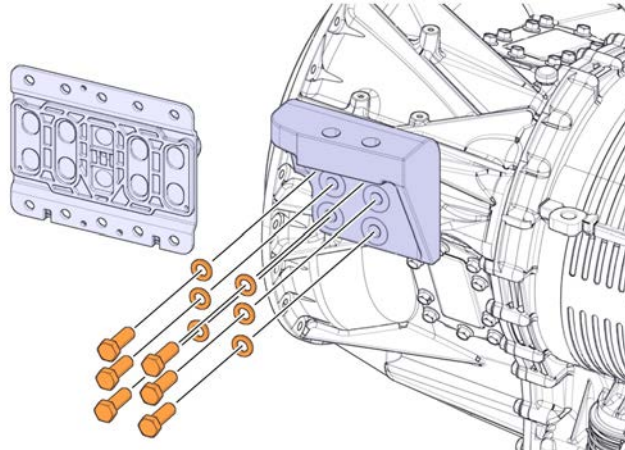
22 Move the frame mounted transmission support forward of the transmission mounted support.

23 Clip applicable cable ties and relocate frame mount forward inside the frame rail to give access to transmission mounted support fasteners.

24 Remove fasteners and brackets securing wet air tank to allow tank to hang freely.

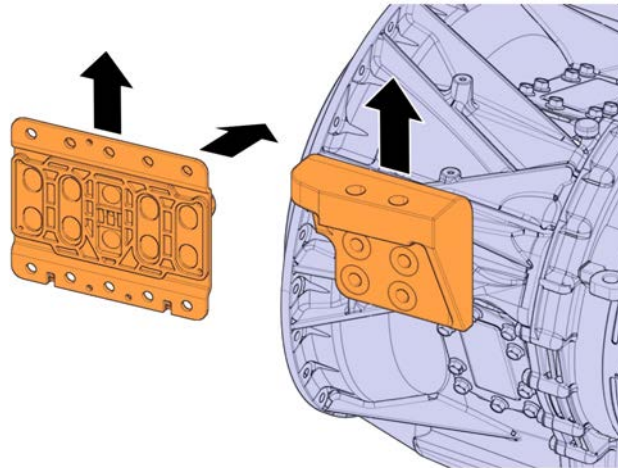
25 Remove transmission coolant pipe.

26 Remove fasteners securing driver side transmission mounted support.



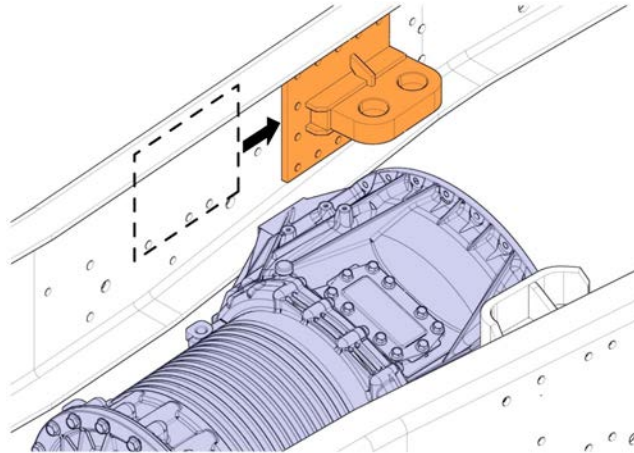
W4073840

27 Remove transmission mounted support and frame mounted support.



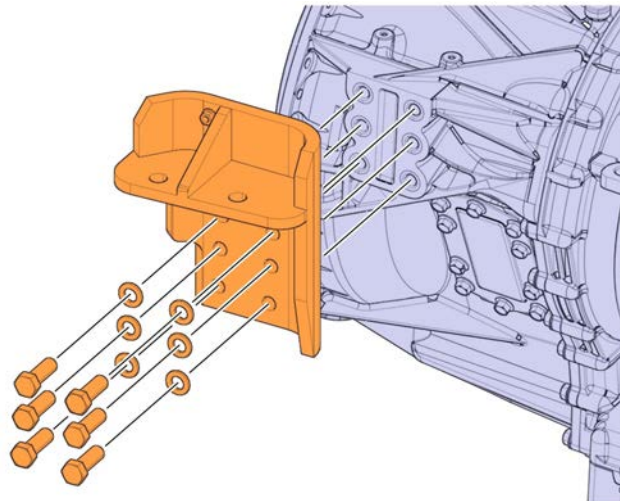
W4073841

28 Position driver side replacement frame mounted support inside the frame rail and forward of the anticipated transmission mounted support location.



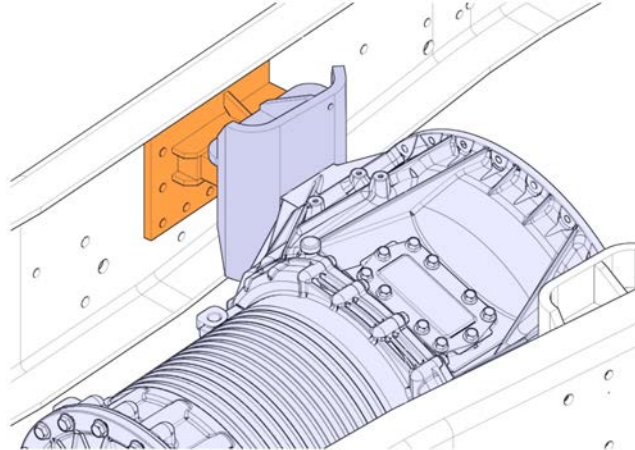
W4073842

29 Position and install the replacement driver side transmission support and fasteners. Tighten fasteners to 244 ± 16 Nm (180 ± 12 ft-lb).



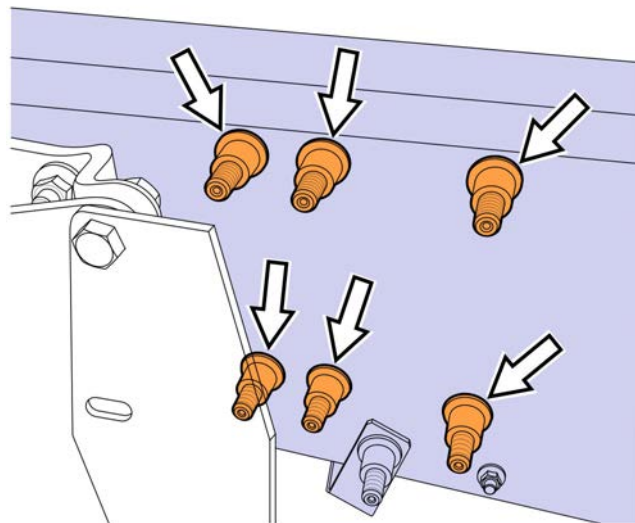
W4073843

30 Position frame mounted transmission support.



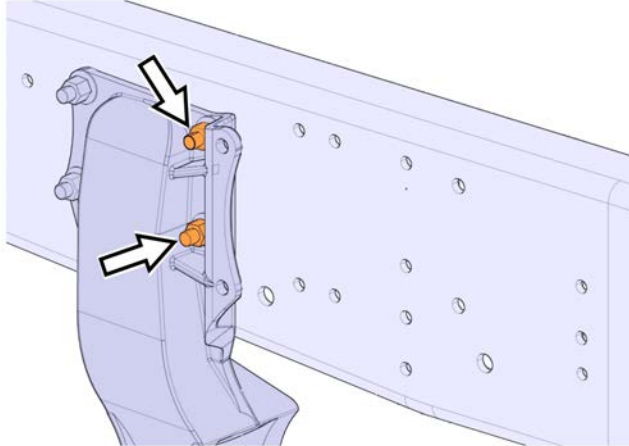
W4073844

31 Using a huck fastener tool, Install huck fasteners and collars.



W4073839

32 Install the two rear driver side spring hanger fasteners.

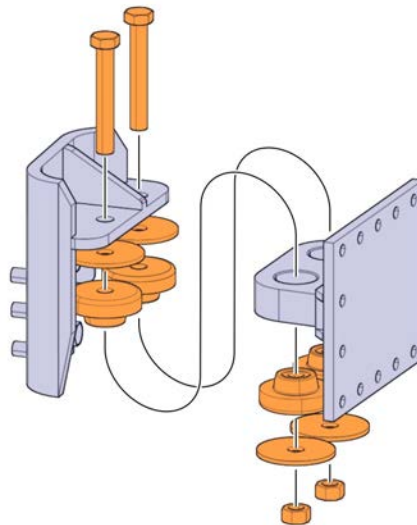


W4073838

33 Install cable ties around harnesses and secure hoses at the appropriate locations.

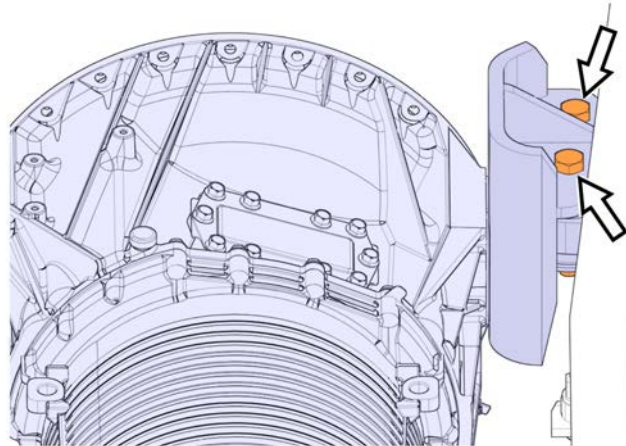
34 Assemble the top and bottom rubber mounts, washers, and fasteners between transmission mounted and frame mounted supports on both sides.

Note: Passenger side shown for instructional purposes.



W4073846

35 Tighten vertical transmission mount fasteners to 500 Nm (368 ft-lb) on the passenger and driver side.



W4073847

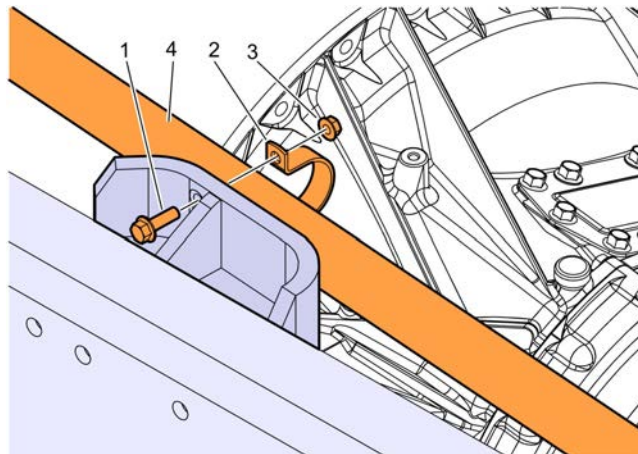
36 Install transmission coolant pipe.

37 Position the transmission coolant pipe, support clamp and fasteners on the frame mounted transmission support, drivers side and mark the location of the support clamp hole.

Note: See table on page 3 for clamp assembly parts.

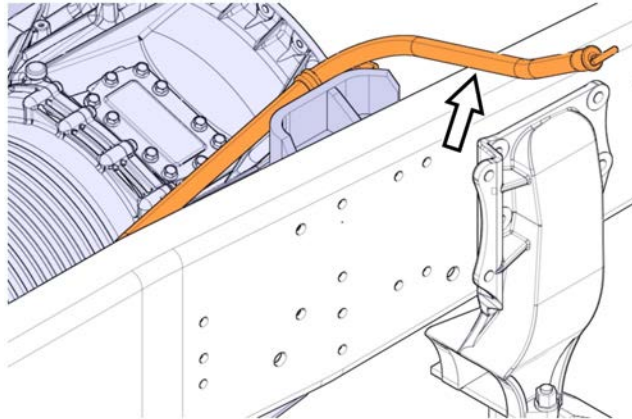
38 Drill one 8.5 mm (0.33 in) hole in the driver side transmission mounted support for the coolant pipe clamp assembly.

39 Install coolant pipe clamp assembly.



W4073848

40 Remove plug, install new transmission dipstick tube and dipstick assembly. See table on page 2 for parts list.



W4073849

41 Install wet air tank, brackets, and fasteners.

42 Use coolant extraction/injector 85112740 to fill the engine and transmission with coolant.

43 Reconnect all previously removed cables to the negative (ground) battery terminals.

44 Lower the cab.

45 Remove wheel chocks.

46 Start engine, check for proper operation, and Check for leaks.

Reimbursement

This repair may be eligible for reimbursement if a product failure was experienced within time and mileage limits of the applicable Warranty coverage. Reimbursement is obtained via the normal claim handling process.	
Claim Type (used only when uploading from the Dealer Bus. Sys.)	W
Labor Code	
Primary Labor Code	2992A-01-80 5.4 hrs.
Causal Part	21090653

MACK Trucks North America engages in a continuous program of testing and evaluating to provide the best possible product. MACK Trucks North America, however, is not committed to, or liable for updating existing chassis.