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Service Information Bulletin

SUBJECT	DATE
External Component Repair	March 2015

Additions, Revisions, or Updates

Publication Number / Title	Platform	Section Title	Change
DDC-SVC-MAN-0140	Transmission	Oil Plug Repair	This is a new section.



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2 Oil Plug Repair

Repair as follows:



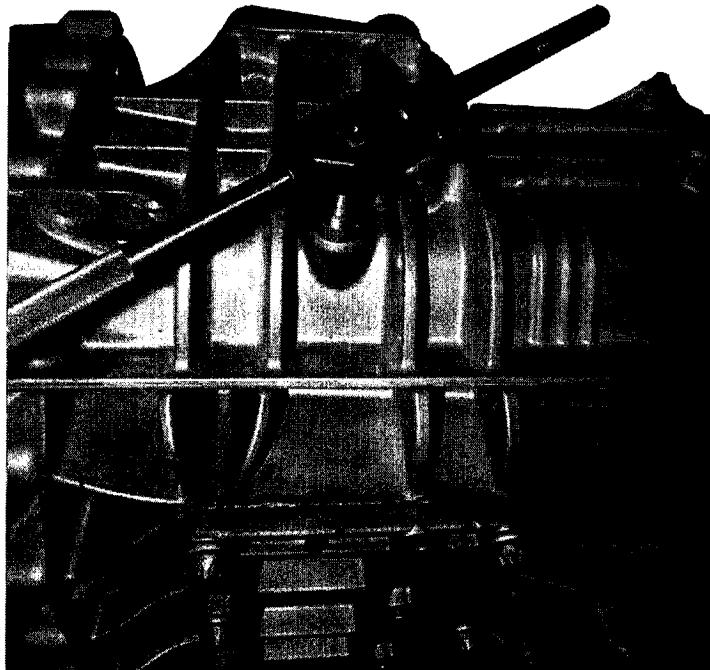
WARNING: PERSONAL INJURY

To avoid injury from hot surfaces, wear protective gloves, or allow engine to cool before removing any component.

1. Obtain a $\frac{3}{4}$ -14 NPT tap and plug, similar to part# MBA 6803570089.
2. Lightly coat tap with grease (to catch the chips).

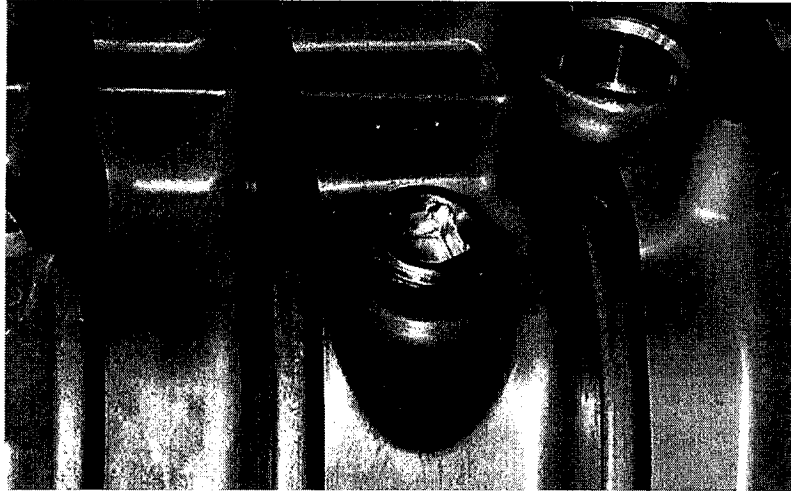
NOTE: The tap can easily become crossed in the hole at the beginning of the process, resulting in damage to the case that would make the transmission unusable. Ensure the tap is tracking straight into the original hole, progressing slowly, and having an assistant observe from the side and provide feedback, during the taping operation.

3. Tap the hole.
 - a. Keep the tap in-line to the original bore, which is the most risky at the start.



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- b. Proceed slowly, taking the time to check the fit of the new plug often.
- c. When you check the fit of the new plug, clean and re-grease the tap to reduce the number of chips that could accidentally drop into the transmission.
- d. Stop tapping as soon as the new plug is two or three threads from being level with the top of the plug boss.



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4. Clean the chips from the housing.
 - a. Reach through the fill hole, and clean the inside surfaces of the transmission case adjacent the hole.
 - b. Use a small amount of solvent on a brush to clean any chips or grease out of the threads.
5. Install the pipe plug.
 - a. For plugs without thread sealant, apply sealant to the outer 2/3 of the plug.
 - b. Torque the pipe plug to 61 N·m (45 lb·ft).