

Mag-Hytec

05/11/17

Installation Recommendations

ALLISON 1000 / 2000 / 2400 Series TRANSMISSION PAN

Please read these instructions and parts list completely before installing this new transmission pan. Consult your owner's or shop manual for transmission fluid requirements.

TOOLS REQUIRED

13 MM socket wrench and driver (for removing the old cover)
6 MM allen bit with a 3/8 ratchet drive (6MM allen key is furnished)
3/16 allen bit with a 3/8 ratchet drive (3/16 Allen key is furnished)
5/16 allen bit with a 3/8 ratchet drive (5/16 Allen key is furnished)
3/8 drive torque wrench
Gasket scraper
Smooth flat file 8 to 12 in. long
Oil drain pan (minimum 20 Qt. capacity)
LE 1150 Dextron III approved or (**"LE" 7500 Monolec Power Fluid for severe service and HD applications.**)

PARTS CONTENT

<u>Number</u>	<u>Quantity</u>	<u>Item</u>
1.	1	Mag-Hytec Transmission Pan with (<u>O-ring ARP 568-282</u>) (installed)
2.	13	8 MM x 25 MM zinc plated allen head cap screws (<u>Torque 12-16 ft. lbs</u>)
3.	14	5/16 stainless AN washers
4.	1	Drain plug assembly with magnet and <u>O-ring ARP 568-910</u> (installed)
5.	1	1/8 pipe plug SS (for optional temperature sender not included) Drain plug and 1/8 pipe plug (<u>Tighten with two fingers using the short side of allen wrench</u>)

A word of caution to the installer / vehicle owner:

The Mag-Hytec pan is designed to fit the factory Allison 1000 transmission as supplied as original equipment. However, in some applications, or because of the use of certain factory options and/or after market equipment, there may be clearance problems between your Mag-Hytec pan and other vehicle components. It is the responsibility of the vehicle owner and installer to ensure that there is no contact between the pan and other moving or fixed vehicle components. **Contact with any vehicle component or the modifying of the Mag-Hytec pan voids the warranty. Mag-Hytec assumes no liability, expressed or implied, for damage or injury to persons or property.**

**ALLISON 1000 / 2000 / 2400 SERIES
TRANSMISSION PAN**

Installation:

1. **Park your vehicle on level ground and apply the parking brake.** Use jack stands if the vehicle must be raised.
2. Position a large drain pan under the transmission to catch the fluid. Also drain the torque converter if equipped with drain plug.
3. Starting at the rear, remove 10 bolts. (Leave two bolts loose to hold pan from falling and making a huge mess.)
4. Using a gasket scraper, start at the rear of the pan and carefully (so as not to gouge the transmission case) insert between the existing pan and transmission housing and pry the old pan off. Tilt pan to cause fluid to flow into drain pan and remove last bolts.
5. Allow all of the old oil to drain.
6. Using a gasket scraper, carefully remove all of the old gasket material (dried silicone) from the transmission case.
7. Use clean lint free rags to clean the transmission case gasket surface. The surface must be clean and flat for the gasket to seal.
8. Before installing the new Mag-Hytec pan, check the gasket mating surface on the transmission case for dents, irregularities, or gouges. Should any exist, carefully remove the high spots using a smooth flat file. **BE CAREFUL NOT TO “ROUND OFF” THE FLAT GASKET SURFACE.**
9. Remove the filter and replace it with a **DEEP PAN FILTER ONLY!!!** Allison part #29537966. Available from local Allison dealer or from Mag-Hytec. At every change the **DEEP** filter **MUST** be used with the Mag-Hytec pan.
*** FAILURE TO USE THE DEEP PAN FILTER CAN RESULT IN TRANSMISSION FAILURE!!! ***
FILTER CAN BE PURCHASED FROM ALLISON DEALER OR MAG-HYTEC. PART #29537966
Note: This is an Allison specific part number not a GM part number.
10. Apply a thin layer of LE Dextron III to the Mag-Hytec O-ring.
11. Align the bolt holes and install the 12 cap screws and washers “finger tight.”
12. Using a 6 MM hex bit and 3/8 drive torque wrench, torque the zinc plated allen cap screws to **(12-16 ft. lbs.)** in a “cross tight” pattern. To keep bolts from backing out put a dab of RTV Silicone on the treads of bolts
13. **Check** the drain plug and 1/8 pipe plug for tightness. If you are going to install a temperature sender, do so at this time. Remove the 1/8 pipe plug and install the sender in its place. **Be Sure To Use LPS All Purpose Anti-Seize or equal On The Sender's Pipe Threads. "TIGHTEN" both the DRAIN PLUG and 1/8 PIPE PLUG (Tighten with two fingers using the short side of allen wrench) DO NOT OVER TIGHTEN.**
14. Remove the dipstick and add in the new LE 1150 Dextron III or **(“LE” 7500 Monolec Power Fluid for sever service and HD applications.)** The Mag-Hytec pan will hold about 10 quarts of oil . Fill to full line on dipstick.

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Maintenance:

The Mag-Hytec pan is constructed of high quality aircraft aluminum and has a powder-coated finish. The bolts are zinc plated allen head screws and the washers are stainless steel. These components require no maintenance.

We suggest you follow the manufacturer's recommendations for the transmission service intervals. You may drain your transmission oil without removing the Mag-Hytec pan. However, we recommend you remove the pan and change the filter at every transmission oil change. You may notice "fuzzy" metallic particles on the magnetic drain plug. This is normal wear. (If you notice any larger chips of metal on the magnetic portion of the plug, further inspection should be performed. We suggest that this inspection be performed by a professional mechanic who specializes in automatic transmissions.) Remember to clean the drain plug assembly prior to reinstallation. Apply a thin layer of oil to the drain plug O-ring and reinstall. **(Tighten with two fingers using the short side of allen wrench) DO NOT OVER TIGHTEN.** Follow the procedure for filling the transmission.

When it's time to service your transmission, **DO NOT USE ANYTHING TO "PRY" THE PAN FROM THE TRANSMISSION CASE that will damage the gasket surface. If you do damage the surface, use a mill smooth file carefully.**

We at Mag-Hytec invite your comments and suggestions. We are continually looking for better ways to provide the highest level of products and service for our customers. You may submit your comments and suggestions by writing or calling our office at:

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Mag-Hytec

Allison Trans Pan

Notice

THE ALLISON DEEP PAN
FILTER MUST BE USED WITH
THE MAG-HYTEC PAN!!!
FAILURE TO DO SO CAN
RESULT IN TRANSMISION
FAILURE!!!

**Filter is available at your local Allison dealer or from Mag-Hytec.
Allison deep filter part number is #29537966 This number has been
Superseded #29542824**

Note: Part # is Allison specific and is not a GM part number.