



ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

CHANGE: The rotating module which contains the C1 and C2 clutch and all related components has gone through a number of hardware modifications. This bulletin is to inform the rebuild technician of the modifications which are categorized as Pre-Model Year 2006, Post Model Year 2006 and 2010½ and later production in order to ensure that correct assembly of the rotating module is accomplished.

REASON: Most changes were implemented for durability to accommodate higher horsepower and torque handling capabilities.

PARTS AFFECTED:

Refer to the chart in figure 1.

INTERCHANGEABILITY:

Interchangeability possibilities will be shown in the chart in Figure 1.

SERVICE INFORMATION:

Figure 1.....Parts Change Identification Chart.
Figure 2.....Rotating Module.
Figure 3.....C1/C2 Clutch Housing Identification.
Figure 4.....C2 Piston Seal Identification.
Figure 5.....C2 Clutch Piston Identification.
Figure 6.....C2 Piston Return Spring Identification.
Figure 7.....C1 Piston Housing Identification.
Figure 8.....C1 Clutch Piston Identification.
Figure 9.....C1 Piston Return Spring Identification.
Figure 10.....C1 Balance Piston Identification.
Figure 11.....C1 Friction Plate Identification.
Figure 12.....C1/C2 Clutch Housing Internal Parts Assembly Identification.
Figure 13.....C1 Clutch Stack Identification.



Technical Service Information

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

COMPONENT	PRE-MY 06 PART #	POST MY 06 PART #	2010 UPRATE PART #	DESCRIPTION OF CHANGE
Rotating Module w/ Turbine Shaft - PTO Capable	29539507	29545811	29546281	Outside of drum went from sharp radius to smooth radius for modified parts identification.
Rotating Clutch Housing w/ PTO Gear Assembly	29540518	29542802	29547424	Reduced size lube orifice
Rotating Clutch Housing wo/ PTO Gear Assembly	29539508	29545812	29546282	Outside of drum went from sharp radius to smooth radius for modified parts identification.
Rotating Clutch Housing w/ Tone Wheel	29536097	29542804	29547425	Reduced size lube orifice.
Rotating Clutch Housing With Bushing	29543232	29542699	29546704	Reduced size lube orifice.
Rotating Clutch Housing	29543233	29542700		Reduced size lube orifice.
C2 Clutch Piston	29539653	29542807	29542807	Changed from smooth spring pocket to individual spring pockets.
C2 Balance Piston	29536105	N/A	N/A	Not used from Post MY 06 and later.
C2 Clutch Piston Return Spring Assembly	29539653	29542810	29542810	Changed from captured springs to open springs.
C1 Clutch Piston Housing	29537993	29542811	29546277	Bleed hole relocated to C1 Piston.
C1 Clutch Piston	29536109	29543239	29549579	Spring pockets moved from inside diameter to outside diameter and the bleed hole was removed.
C1 Spring Assembly	29536198	29542814	29542814	Changed from 2 indexing places to none.
C1 Balance Piston	29536203	29542815	29542815	Changed to a larger diameter.
C1 Friction Plates	29538468	29538468	29546276	Changed from 6 to 7 plates and are thinner for the 2010 Uprate.
C1 Reaction Plates	29530314	29530314	29530134	Changed from 6 to 7 plates for the 2010 Uprate.
C2 Clutch Hub	29536962	29536962	29546705	Vent holes were added for the 2010 Uprate.
P1 Drive Flange	29531094	29531094	29546706	Vent holes were added for the 2010 Uprate.
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Figure 1

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

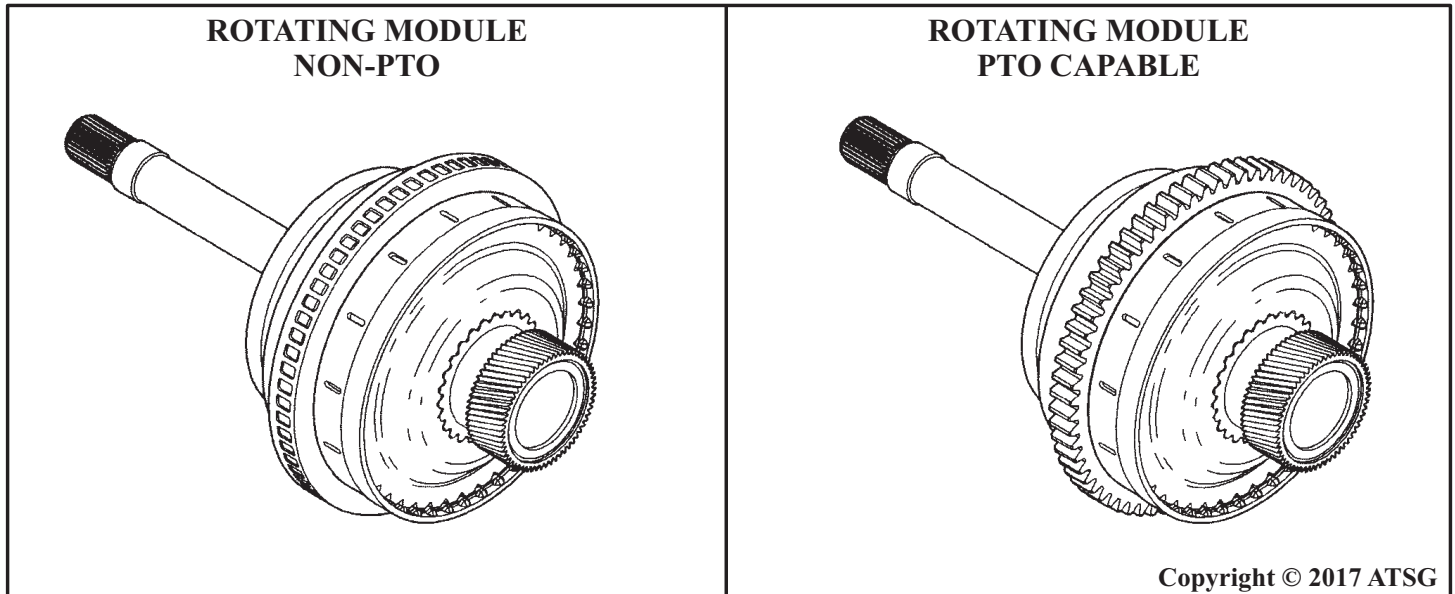


Figure 2

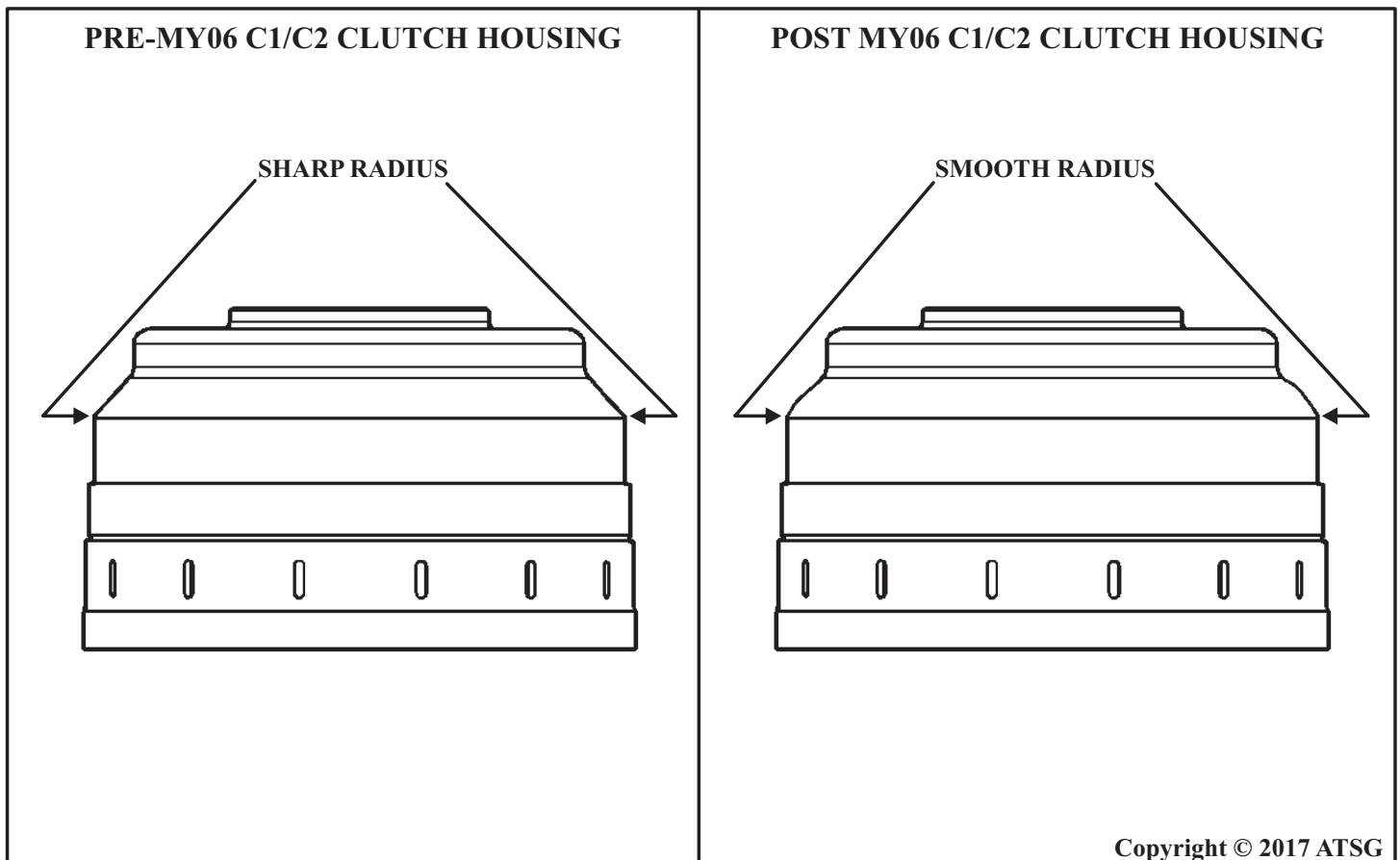


Figure 3

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

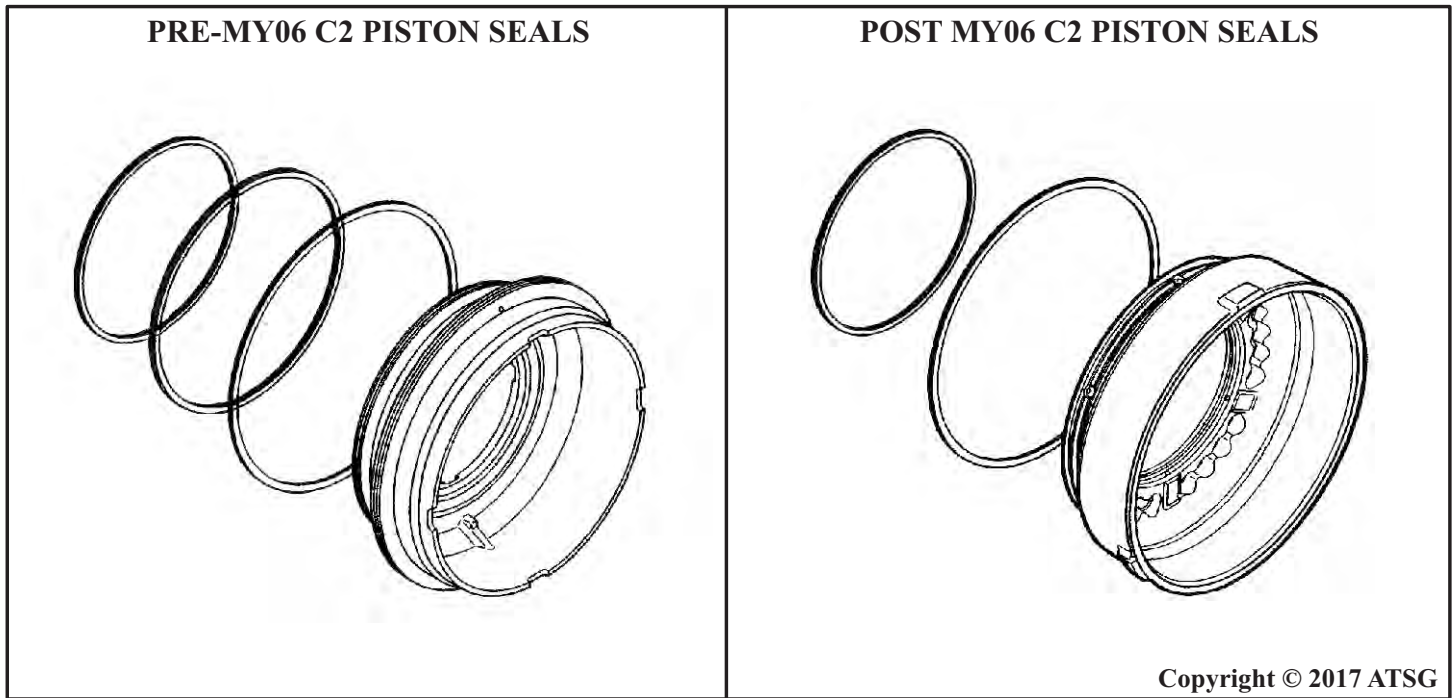


Figure 4

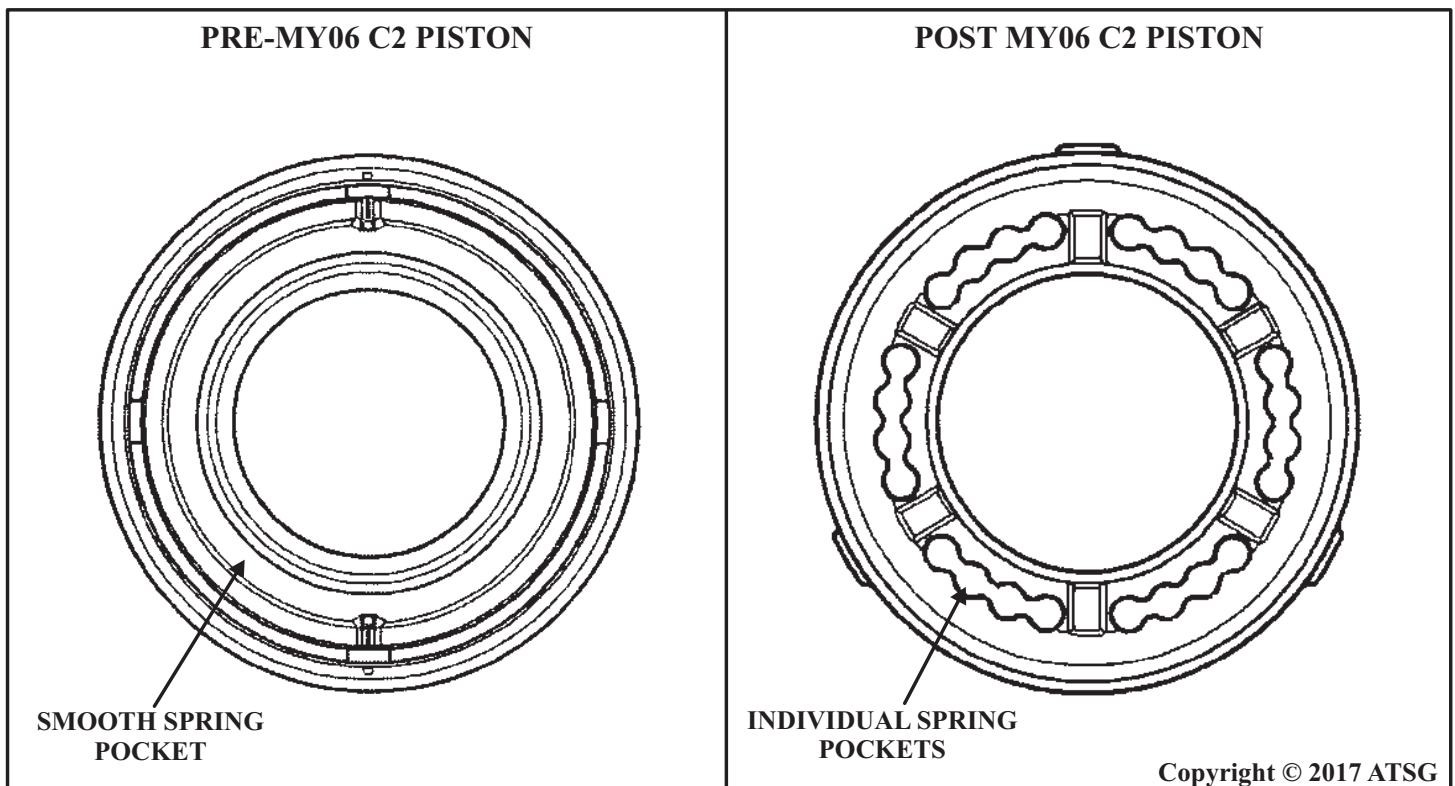


Figure 5

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

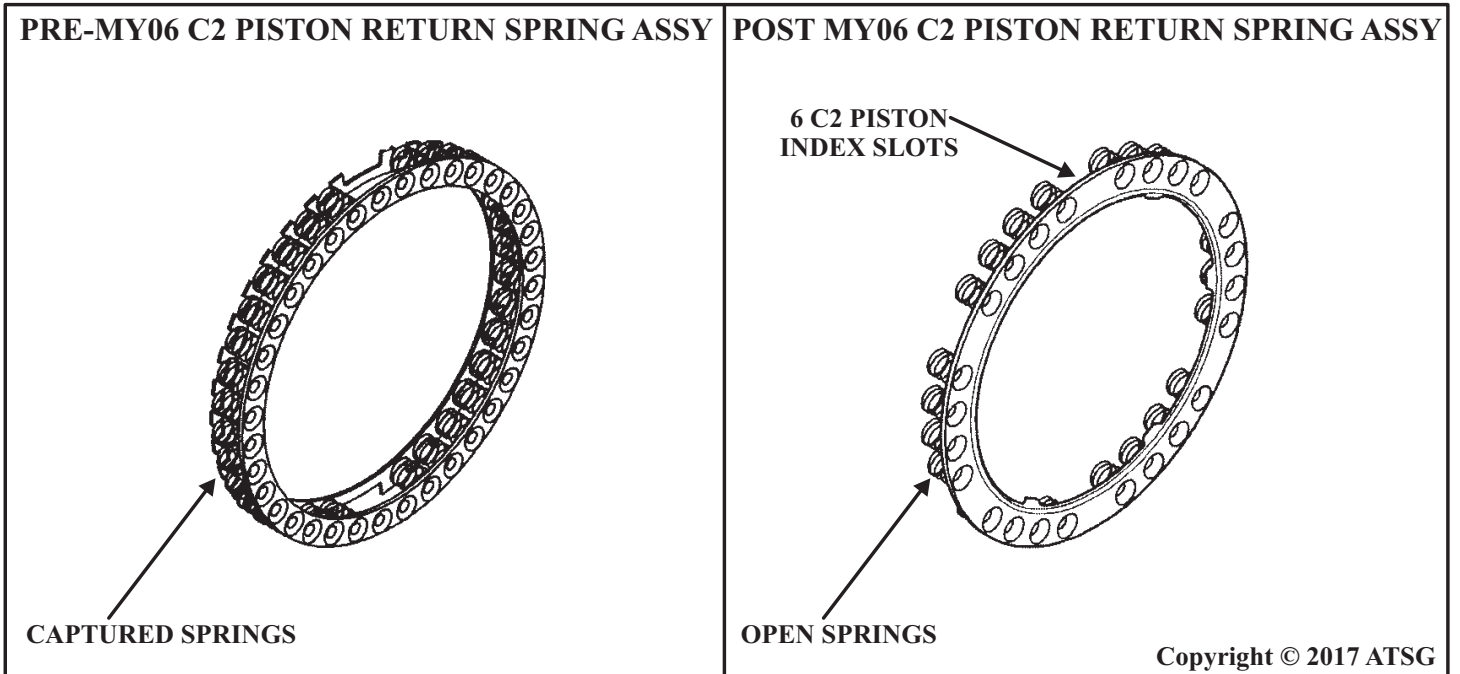


Figure 6

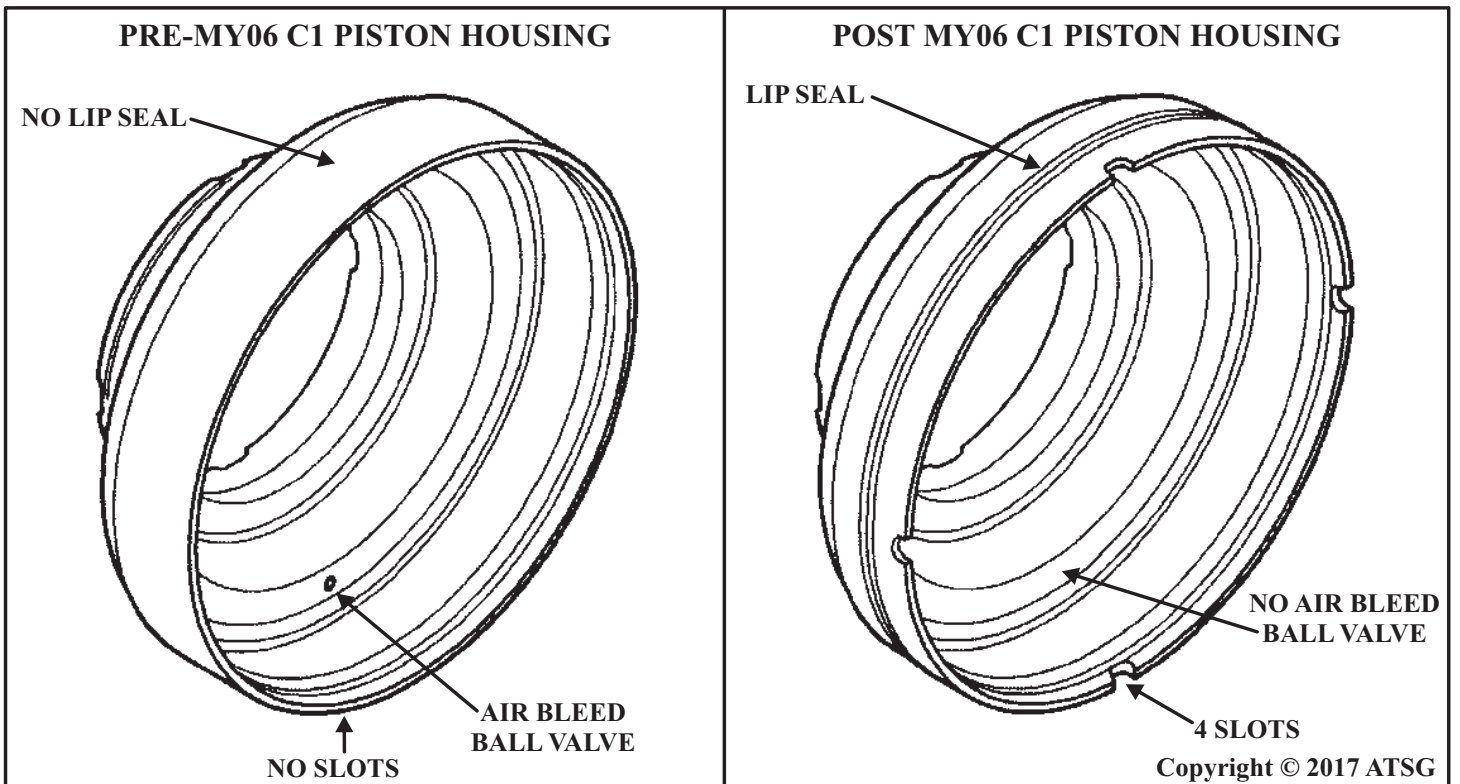


Figure 7

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

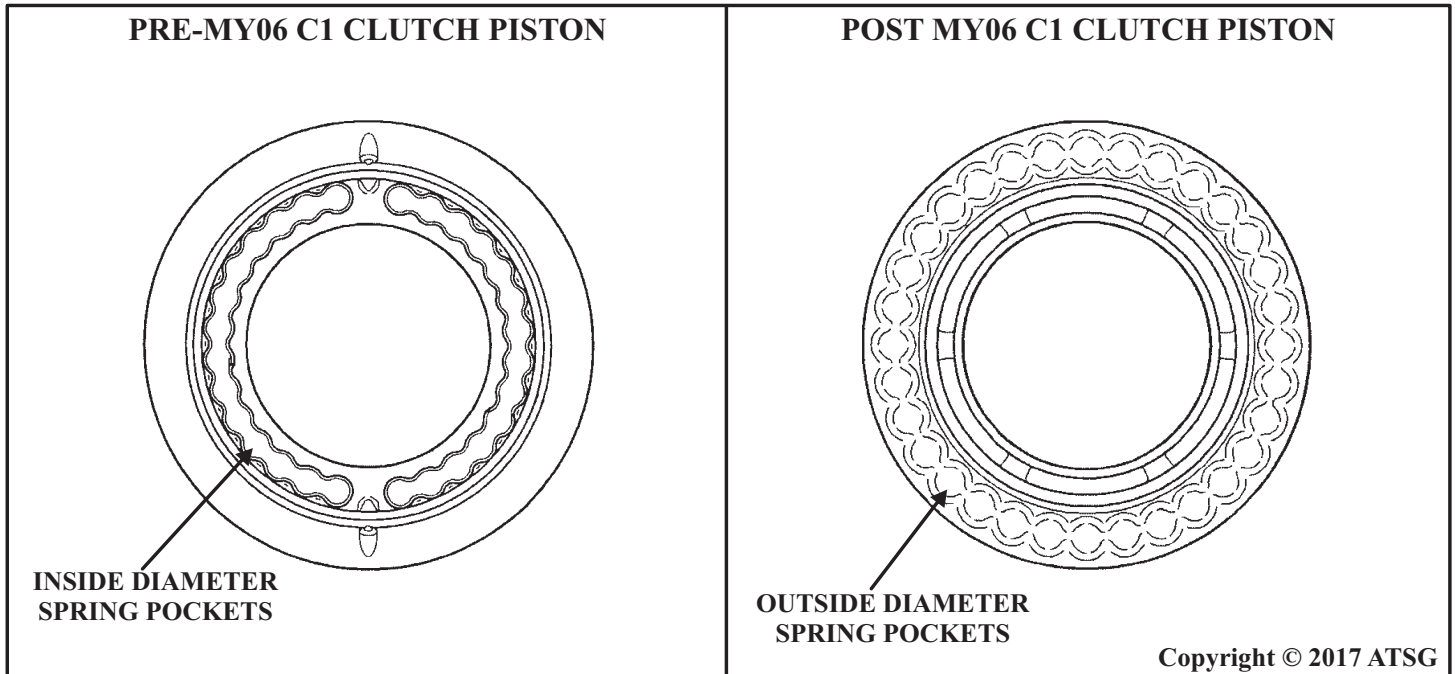


Figure 8

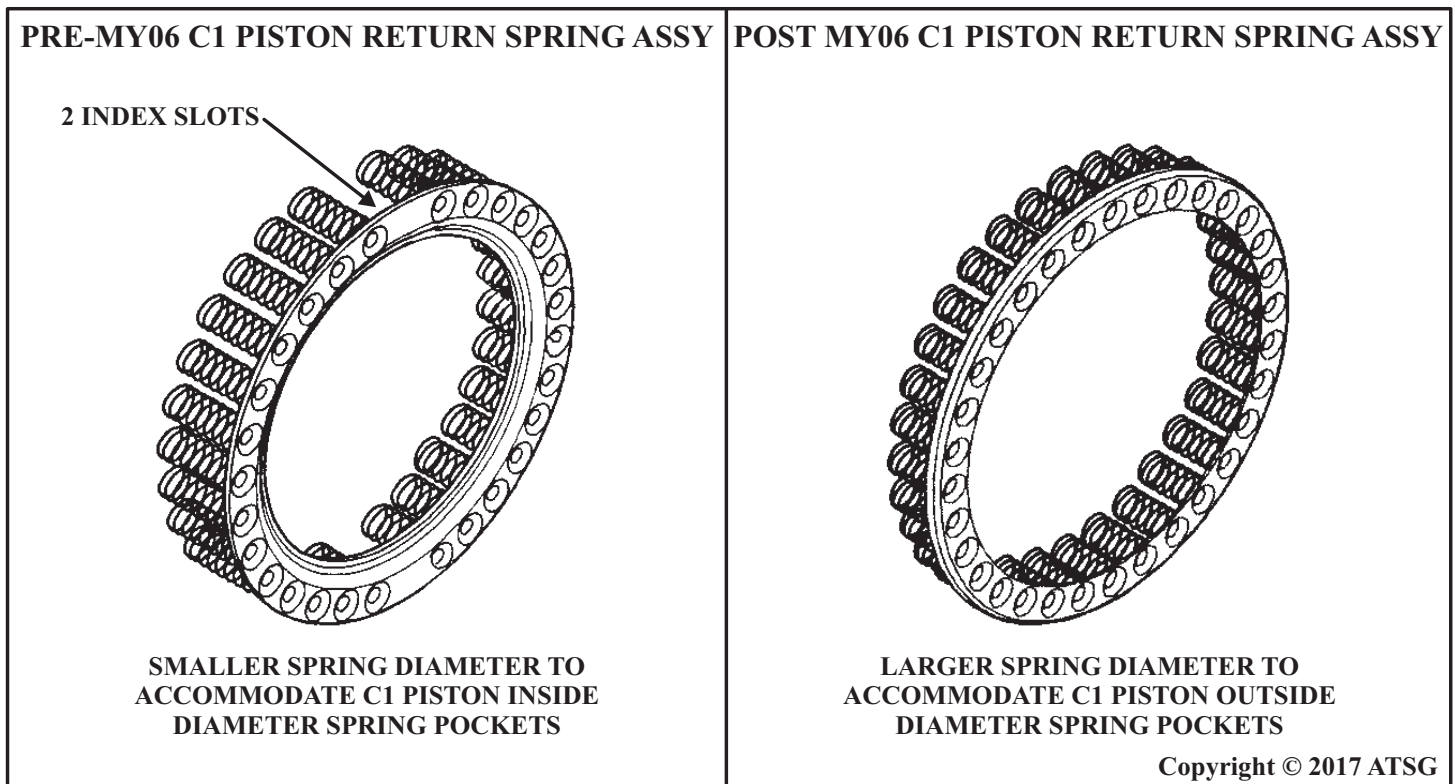


Figure 9

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

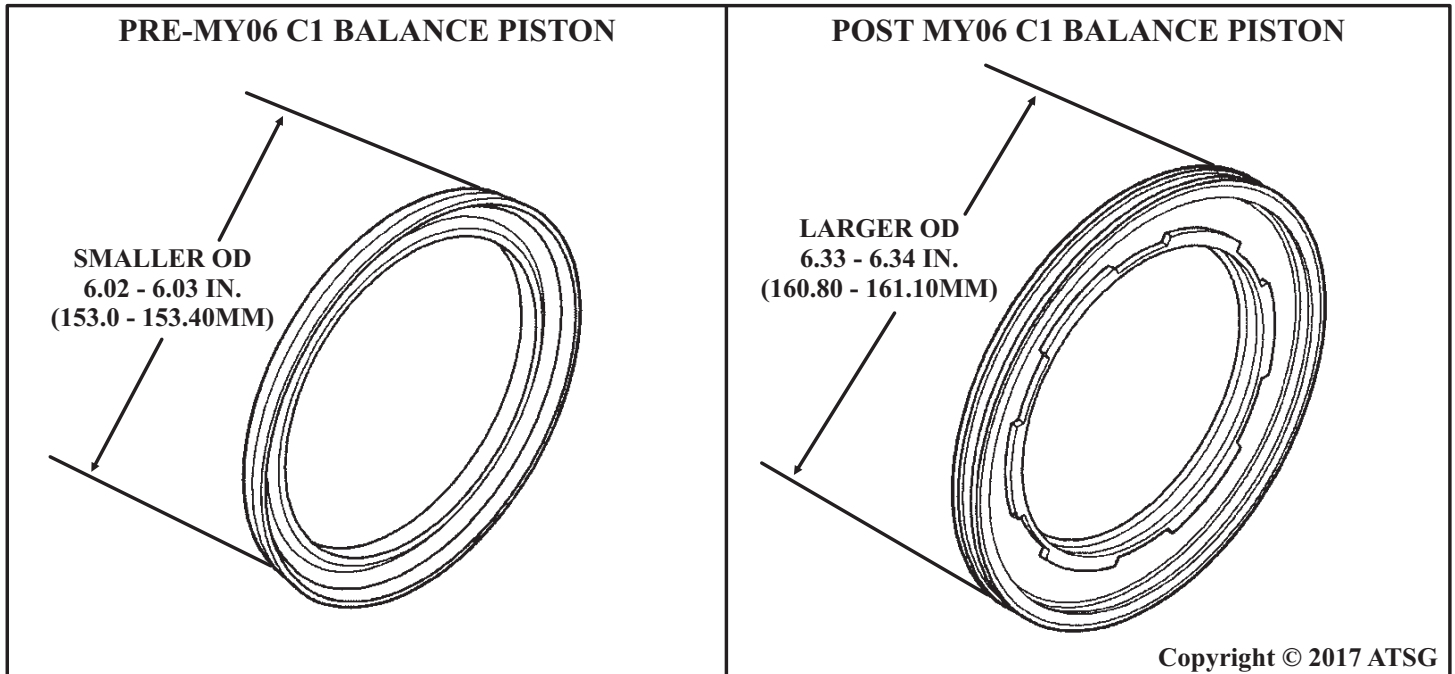


Figure 10

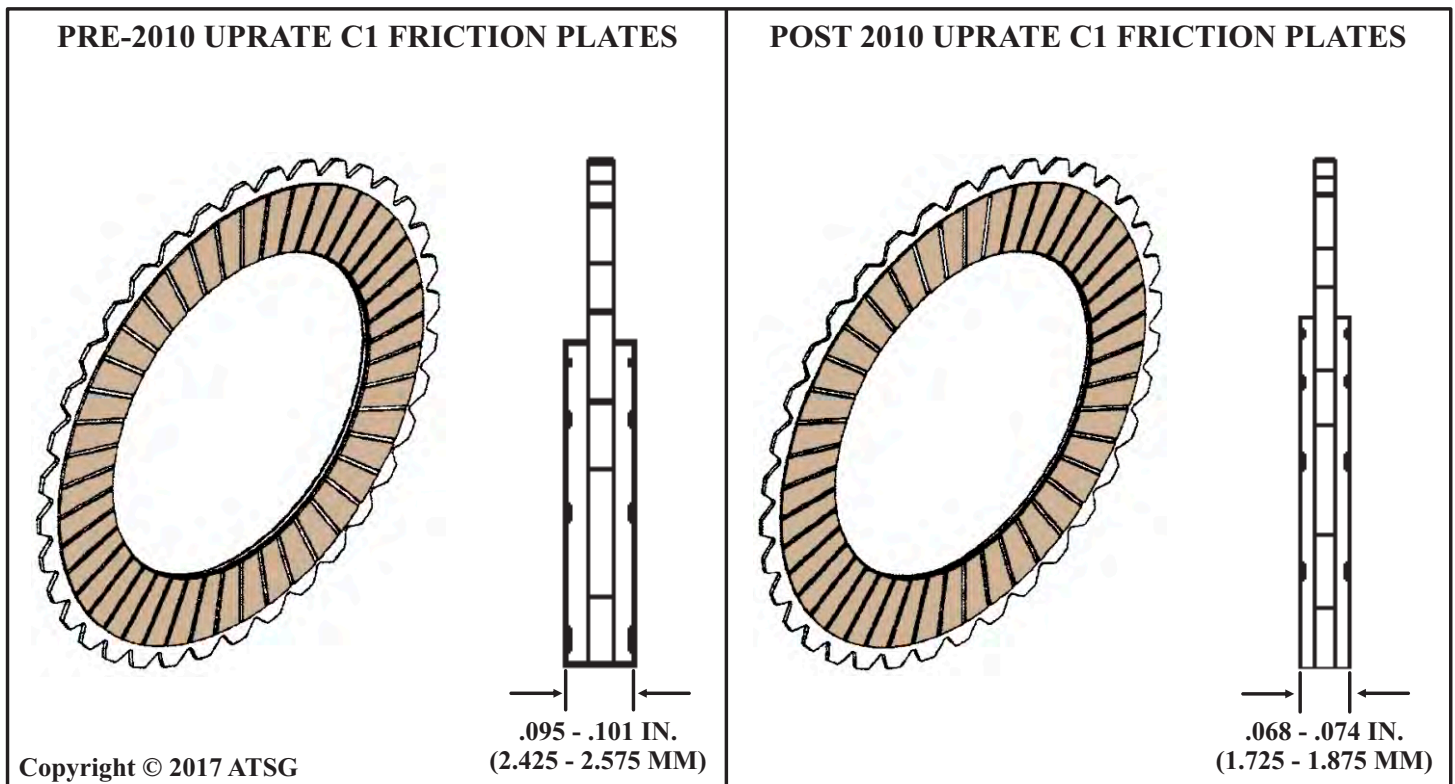
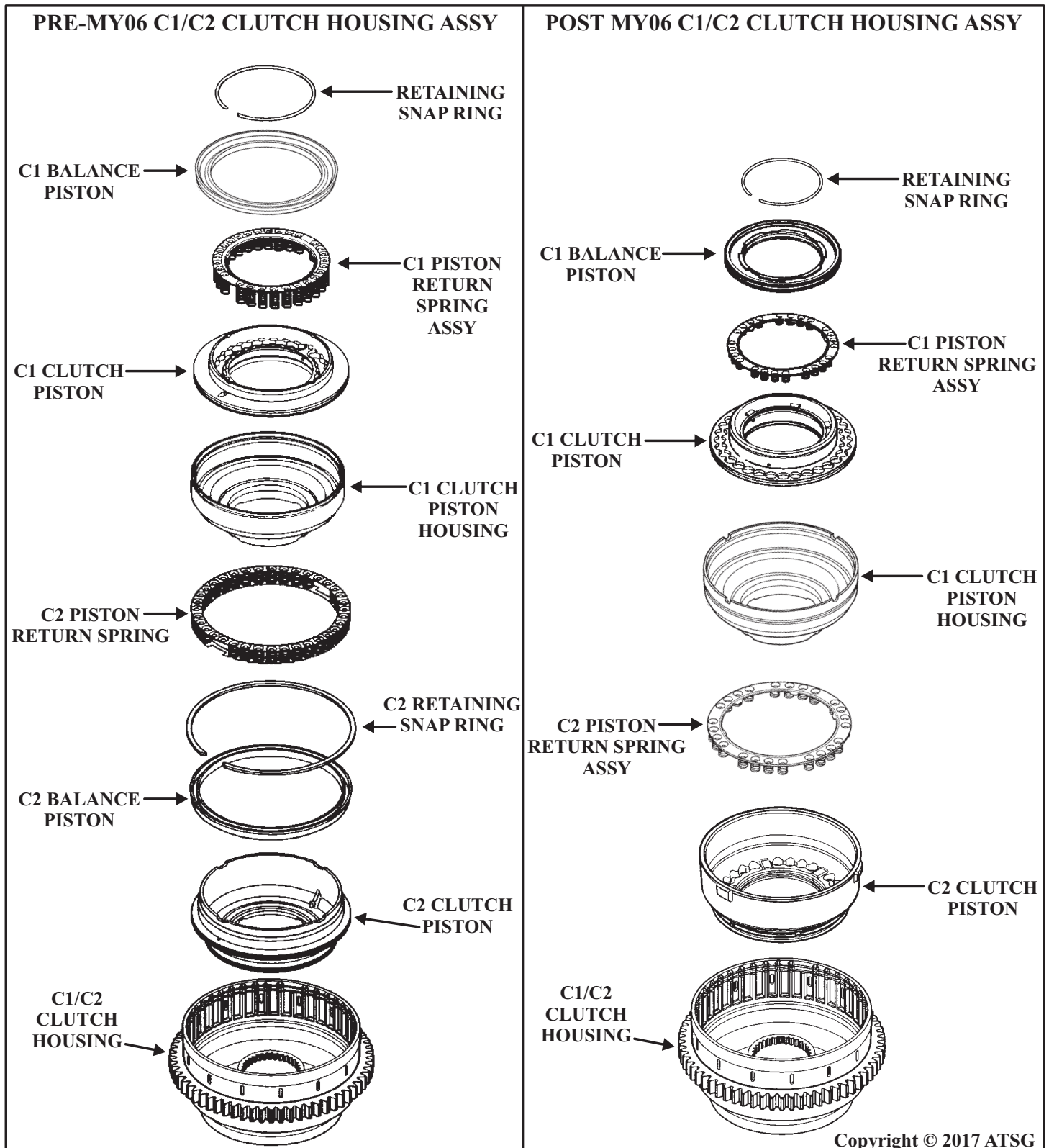


Figure 11

ALLISON 1000/2000 SERIES ROTATING MODULE CHANGES

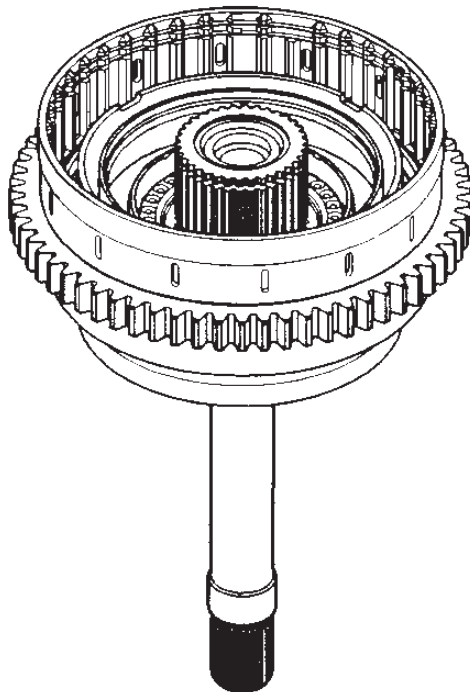
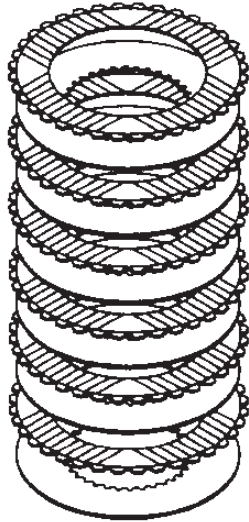


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Figure 12

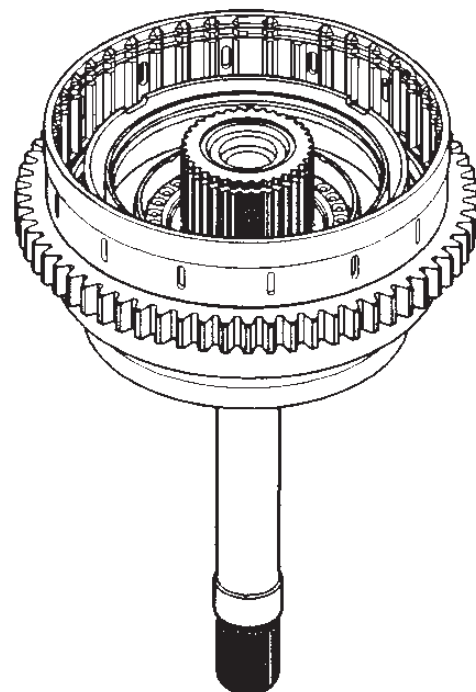
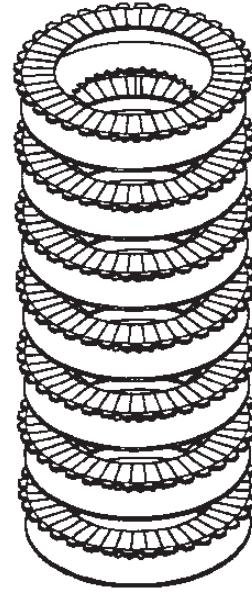
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PRE-2010 UPRATE C1 CLUTCH STACK



**6 C1 FRICTION PLATES
6 C1 REACTION PLATES**

POST 2010 UPRATE C1/C2 CLUTCH STACK



**7 C1 FRICTION PLATES
7 C1 REACTION PLATES**

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Figure 13