

TorqKit

Allison 1000 C4

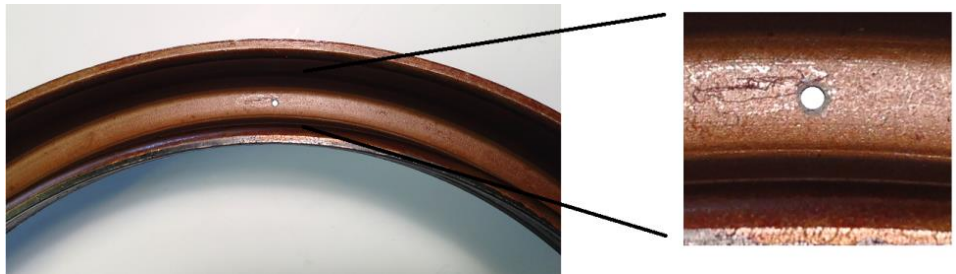
1999-2010

Components

1. 6 pcs GPZ196 Friction Plates (0.071")
2. 5 pcs 511642 Steel Reaction Plates (0.098")
3. 1 pc 511643 Apply Plate (0.125")

Installation Instructions

1. Install C4 piston with orifice at 12 o'clock position. Lube seal surface and install evenly.



2. Install in the following order (***TIP:** Remove or do not install piston return springs on apply plate at this time):

- 0.125" 511643 Apply Plate
- 0.071" GPZ196 Friction Plate
- 0.098" 511642 Steel Reaction Plate
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- 0.098" 511642 Steel Reaction Plate
- 0.071" GPZ196 Friction Plate
- OE Backing Plate
- Snap Ring

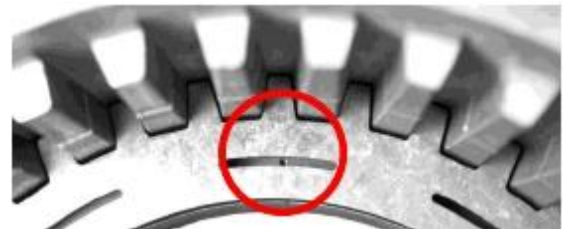
Check clutch clearance between C4 backing plate and top friction plate using a feeler gauge.

*Recommended clearance range: 0.050"-0.070".

3. Remove friction and steel components and saturate friction plates in either manufacturer-specified ATF or comparable synthetic ATF.
4. Confirm C4 piston orifice is located at the 12 o'clock position.
5. If removed in step 2, install piston return springs on 0.125" apply plate.



6. Install 0.125" apply plate with slot center over C4 piston orifice.



7. Install P1 planetary and P2 ring gear assembly.
8. Using the steel slots as a guide, align the friction plate slots during assembly.
9. Align slots in steel reaction plates, ensuring that slots do not block or partially block the C4 piston orifice.

Note: You may need to index or flip the steel reaction plate over to accurately locate and center the slot at 12 o'clock.

Note: The illustration at the right shows one method of aligning the steel reaction plates. The end of the slot just to the left of the red line is lined up with the right edge of the tooth just above it. That ensures that the slot in the red circle can be located at the 12 o'clock position in the case.



10. Install the C4 backing plate and snap ring.

End of Instructions