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BD ALLISON HD TRANSMISSION PAN
For GMC/Chevrolet Duramax Diesels

Part# 1061650

Please read all instructions before installation of this product.

Kit Contents

1601651	1200208	1601613	1601715
Transmission Oil Pan	Temp Sensor Port Plug	Magnetic Drain Plug	Bolt (8mm x 30mm)
			
Qty: 1	Qty: 1	Qty: 1	Qty: 12
50496228	1601512	29537966	
Pan Gasket	Flat Washer	Deep Filter	
			
Qty: 1	Qty: 12	Qty: 1	
1601615			
Filter Support Strap			
			
Qty: 1			

1601614
Deep Pan Filter Support Bracket

Qty: 1

Tools & Equipment Required

- 13 Quarts of Automatic Transmission Fluid (refer to the vehicle owner’s manual for correct type)
- 1 Can “Brake Clean” or equivalent
- 3/8” Drive Torque Wrench
- 3/8” Drive Ratchet
- 3/8” Drive 6” Extension
- 3/8” Drive 13mm & 15mm Socket
- 3/8” Drive 5/16” & 7/16” Socket
- 3/8” Drive 6mm & 8mm Allen Driver
- Pipe sealant or Teflon tape

Pan Gasket Notes

This kit has been updated to use the OEM bonded rubber Allison transmission pan gasket (50496228).

Old style pans (identifiable by a machined o-ring groove on the pan gasket surface) utilize a reusable o-ring. BD part number 1601610 / Daemar 16.401-.139-V-C / A.R. Thomson V75D-1/8x51.50”.

Torque Specs

Pan Bolts	15 lbs-ft		Pan Drain Plug	20 lbs-ft
Sensor Plug	12-15 lbs-ft		Filter Support	10 lbs-ft

IMPORTANT REPLACEMENT FILTER NOTE

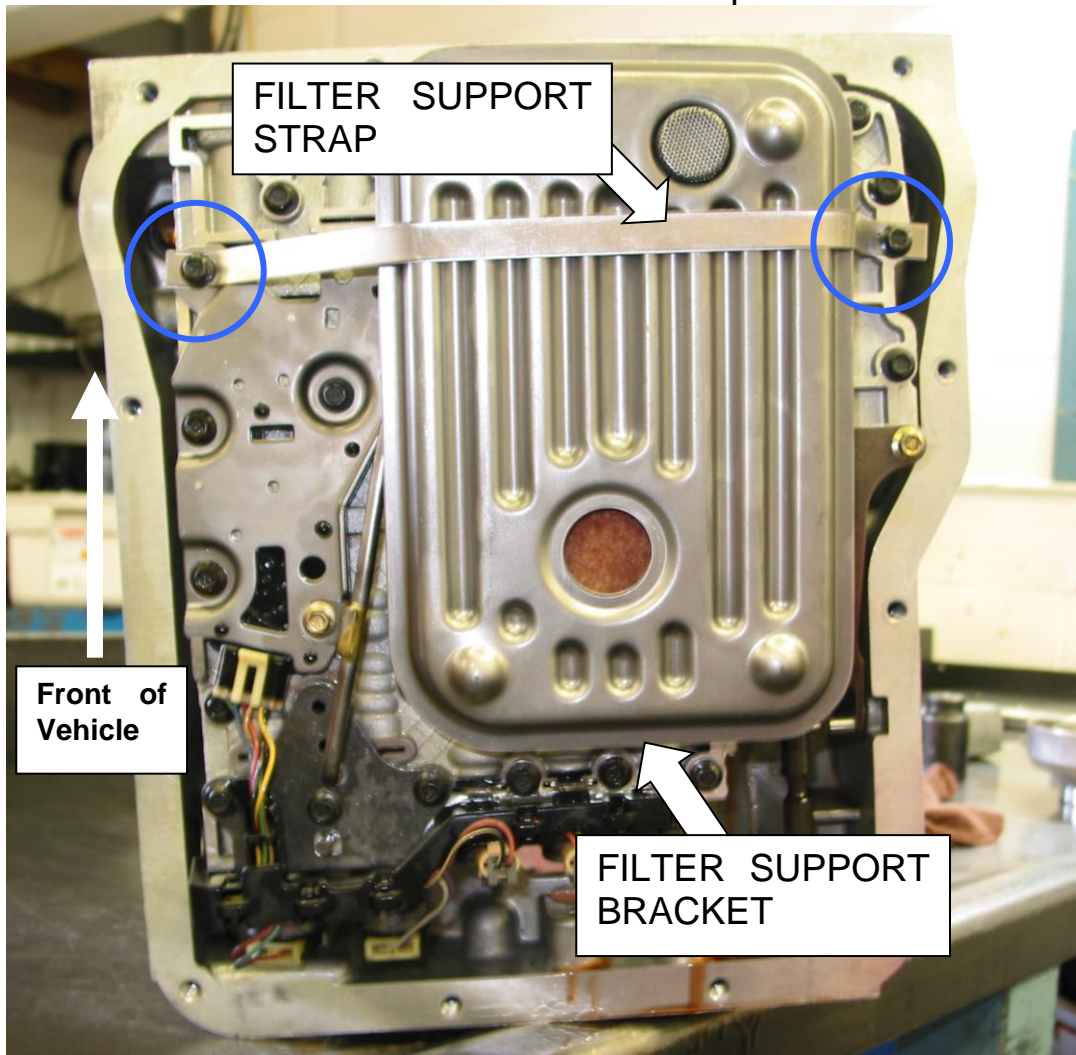
You must use the Deep Allison filter # **29537966**. One is included in this kit

NOTE: Please use a torque wrench when installing any transmission component.

INSTALLATION

- Park the vehicle on flat and level ground with the park brake applied and the transmission in park.
- Drain the transmission pan of any existing fluid and remove the 12 existing bolts that secure the pan to the transmission case.
- Remove the pan slowly. If the pan is stuck to the case, tap the side of the pan lightly with a soft-faced mallet until it breaks free.
- Carefully pull the pan off of the transmission. Inspect the magnet that is in the bed of the pan for any excess material (dust type material is normal). If any debris found looks abnormal, consult with a transmission professional for diagnostics.

- Remove old filter and seal and discard. (*It's advisable to change the spin on filter, since you will be using new oil*) Lightly lubricate the lip seal of the new deep filter (provided in the kit). Insert snout into valve body filter opening, and press until the lip seal is fully inserted and cannot be inserted any farther.
- When the new pan is removed from the packing box, it is advisable to clean the inside of the pan with "Brake Clean" or an equivalent cleaner to ensure any unwanted residue is removed from the inside of the pan.



- Remove the two bolts as shown in the picture. Attach the stainless strap over the top of the filter so that it secures the filter snout in place. Install the filter support bracket on the rear of the filter. Tighten bolts to **10 lbs-ft**.
- Line up the pan with the bolt holes in the case and install two 8mm x 25mm pan bolts with washers on either side of the pan to hold it in position.
- While the pan is still loose, install the remaining ten bolts and washers until they are hand tight. Snug up the first two bolts that were installed in the previous step.

- Torque all pan bolts to **15 lbs-ft.**
- Install and torque the pan plug to **20 lbs-ft.**
- Apply pipe sealant or Teflon tape to the brass plug (1200208).
- Install and torque the brass plug or temperature sender unit (if equipped) to **12 lbs-ft.**
- Fill the transmission to the proper level, with the recommended fluid. Filling at a maximum of 5 quarts at a time, and then re-check the fluid level. This will take approximately 10.9 quarts (10.3L) of **TES-668 Approved Fluid**. Fluid should **ALWAYS** be measured with the proper transmission dipstick to verify correct filling. Do **NOT** use any other type of fluid as it is not recommended by Allison.
- This pan is designed to fit with no parts rubbing or touching the pan once it is installed on the transmission. If for some reason there is something rubbing or touching the pan, please contact BD Technical Support at (800) 887-5030 before operating the vehicle.