

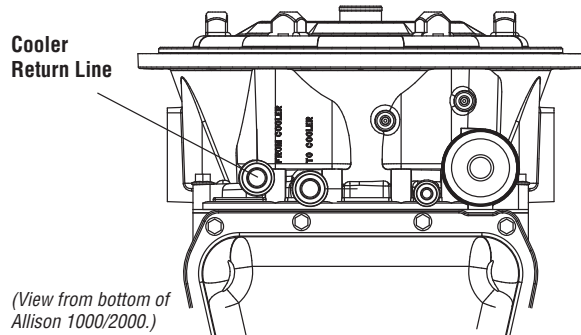


Allison Tee Fitting

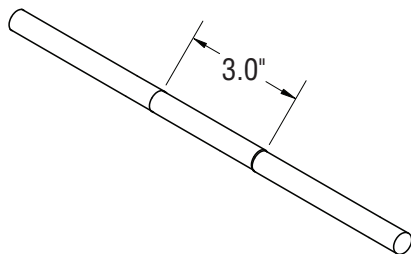
Installation Instructions for Allison Lubrication Fitting Kit

43TK4497 Use for -10 Steel Lubrication Lines
43TK4503 Use for -12 Steel Lubrication Lines

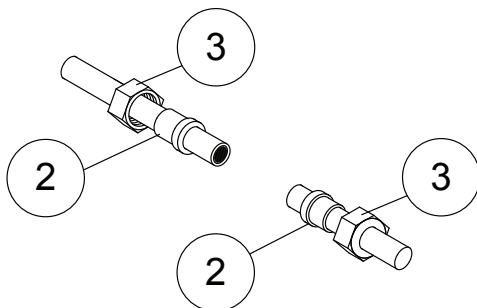
43TK4606 Use for 15mm Steel Lubrication Lines



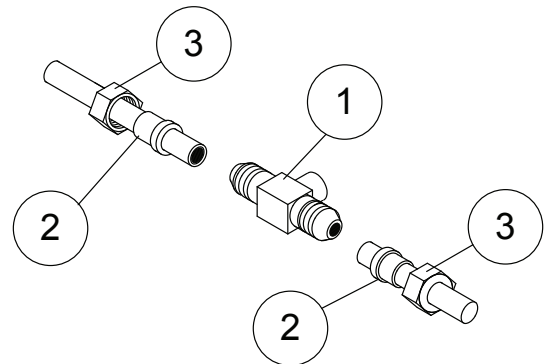
1. Locate an area along the "return" cooling line from the transmission oil cooler to install the tee.



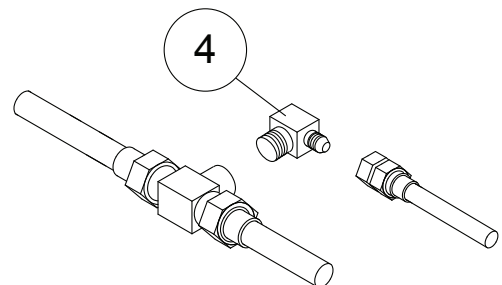
2. Measure and Cut a 3" section from the steel tubing. Tubing cutter recommended. (See page 2 for additional instructions.)



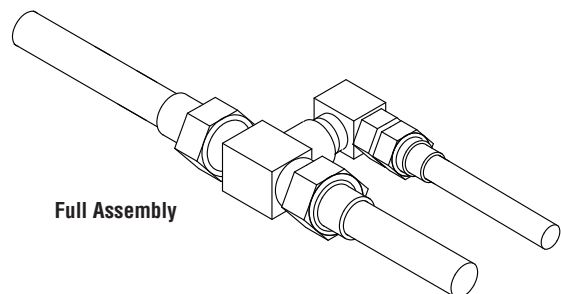
3. Slide the hex nut (3) onto the steel tubing, then slide the flareless ferrule (2) on to the tubing.



4. NOTE: Refer to assembly instructions on page 2 for proper fitting installation. Install the hex nuts (3) on to the Tee fitting (1) and position the 1/2" port so that the elbow (4) can be installed.



5. Install the elbow (4) and the PTO lubrication line supplied with PTO.



Full Assembly

6. Connect the lubrication hose to the PTO port. Route hose away from rotating components and heat source. Shield hose from heat if routed by exhaust.

Assembly Instructions for Versil-Flare Tube Fittings*



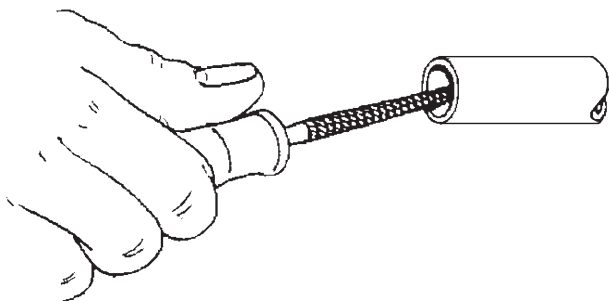
Out of Square Cut



Square Cut

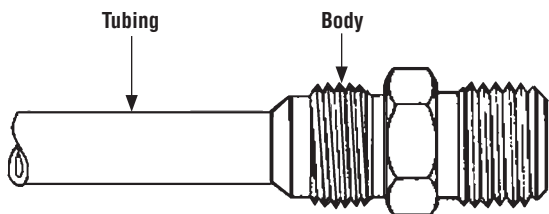
CUTTING

To ensure a leak-proof joint, the tubing should be cut square (+-1). A tube cutter is preferred but a hacksaw or abrasive wheel can be used.



DEBURRING

All cut tubes should be deburred. However, deburring is even more important if the tubing was cut with a hacksaw or abrasive wheel. Remove any burrs both internally and externally, with a deburring tool, emery paper or fine file. Thoroughly clean the tube, including all dirt and grit from the I.D. and O.D. before assembly.

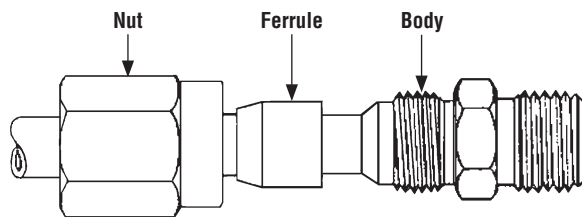


TUBING CUT-OFF

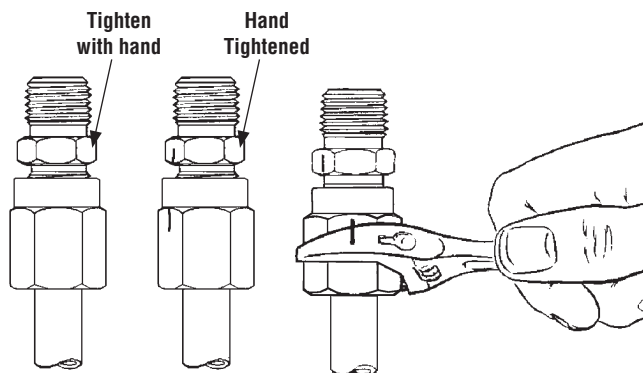
Tube should be cut to fit tight against the face of standard SAE 37 flare body.

INITIAL ASSEMBLY

1. Deburr the end internally and externally. Clean all dirt and grit from I.D. and O.D.
2. Slide the nut and then the ferrule into the tube. Make sure the tapered end of ferrule points toward the nut.



3. Lubricate all mating surfaces of nut, ferrule and body with a heavy lubricant.
4. Place end of tube against standard SAE 37 flare body.
5. Slide the ferrule and nut against body and tighten the nut onto the body "Hand Tight". Mark the nut in relation to the body for location.



6. Hold tube against body and tighten nut a total of 1¼ turns on -10 & 15mm tubing and 1½ turns on -12 tubing.

REASSEMBLY

1. Slide nut against the body and tighten to "Hand Tight." Mark the nut for location.
2. Tighten nut a minimum of one "Hex" flat. The Versil-Flare flareless tube fitting is designed for a maximum of 10 reassemblies.

* From EATON Aeroquip A-HOOV-MC001-E January 2005



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