



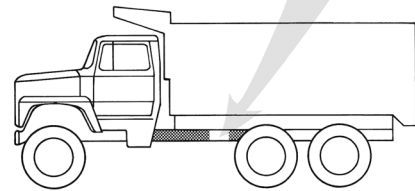
A20/A30 10-BOLT PTO INSTALLATION

Allison 3000/4000 Series Transmissions

1. Label Placement - The PTO ships with 4 WARNING LABELS. Make sure mounting surfaces are clean before placing labels. Place labels as shown below.

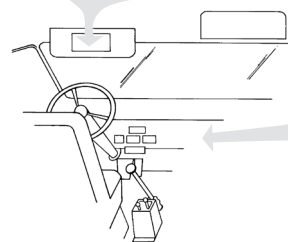


(1) 4" x 6.5"



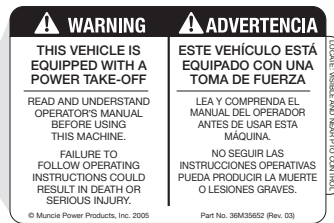
Frame Rail Labels

Place on frame rail or truck body on both sides of vehicle. Must be clearly visible by anyone who might go under truck or near PTO. Clean surface thoroughly before installation. **DO NOT PAINT OVER LABELS**



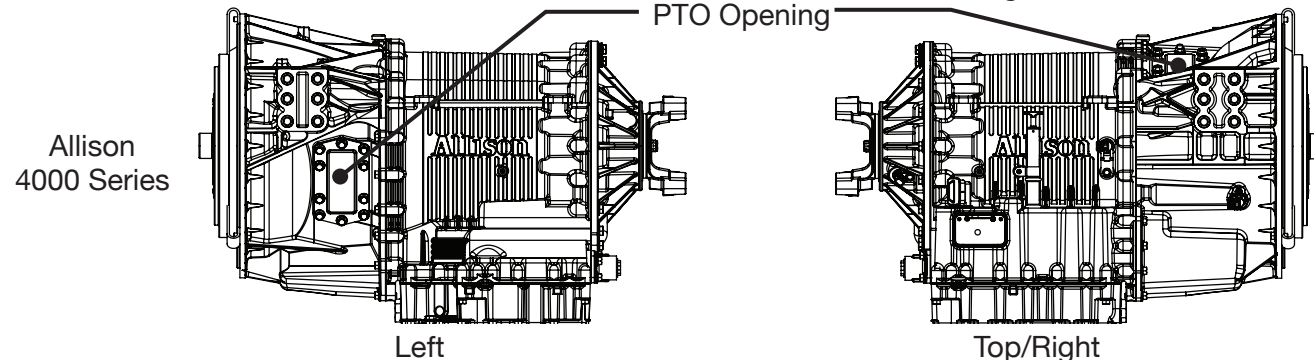
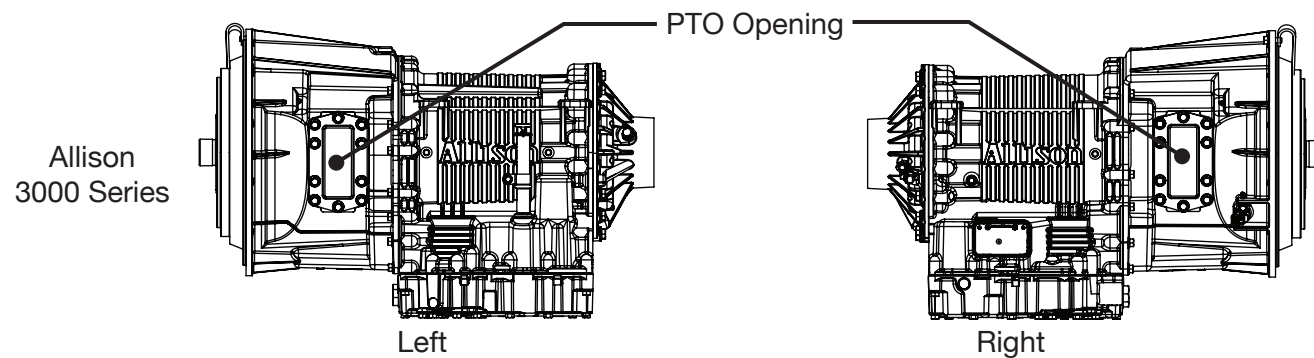
Interior Labels

Place 2" x 3" PTO Equipped Caution label within cab in clear view of operator and near PTO control. Place 4" x 6.5" Visor Label on visor on operator's side of vehicle. **DO NOT COVER ANY VEHICLE AIR BAG WARNING LABEL!**

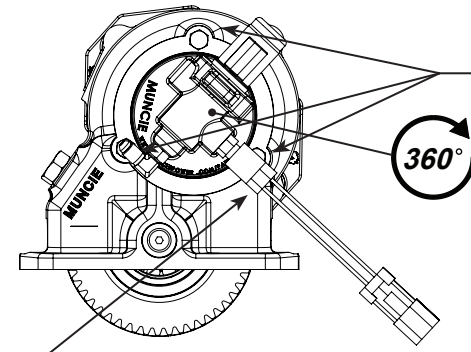


(1) 2" x 3"

2. With PARK brake set, place truck in neutral and start engine. Listen to engine and transmission. Any transmission gear noise may be more noticeable after PTO is installed. **STOP ENGINE. NEVER GO UNDER VEHICLE WITH ENGINE RUNNING!** Find PTO opening on transmission.

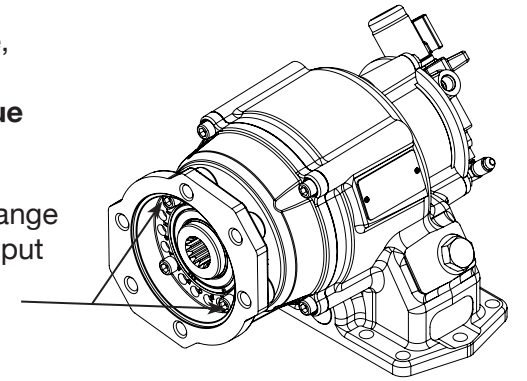


3. All units: Adjust output flange if necessary. If flange was shipped loose, it may be installed now, or after installation of PTO, if possible. **Clutch Shift units:** Install pressure switch on PTO and valve body as necessary. See below for proper torque values.



Pressure Switch Torque to 10 ft.lbs.

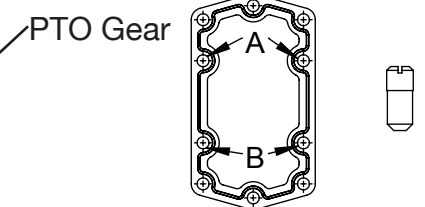
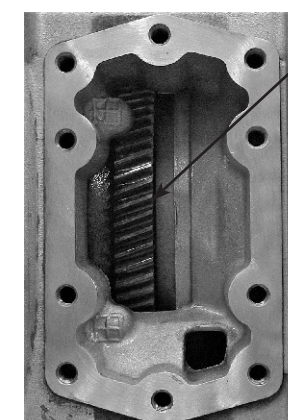
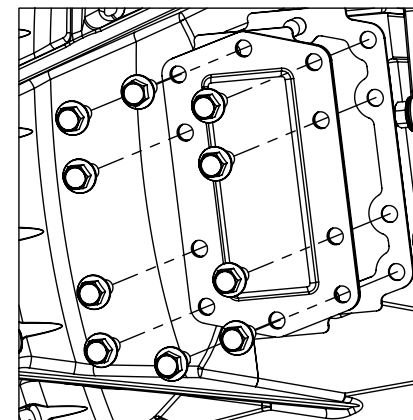
Loosen, but do not remove, to rotate valve body. **Once positioned, re-torque to 18 ft.lbs. (3 plcs)**



Remove cap screws and flange mounting ring to adjust output flange. **Once positioned, reinstall ring and torque to 22 ft.lbs. (4 plcs)**

DO NOT REMOVE COVER FROM HOUSING!

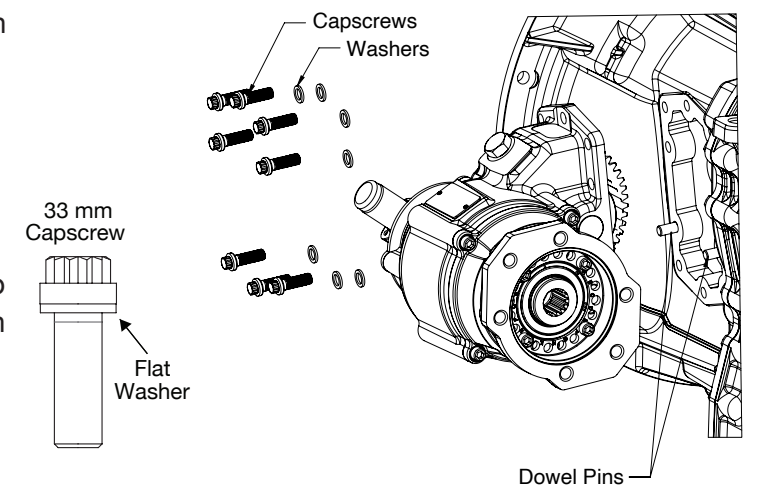
4. Remove transmission PTO cover plate and gasket. **Caution:** Some transmission fluid may escape opening. Take care to keep contaminants out of transmission with cover off. Verify PTO gear is present in transmission. Locate the PTO mounting kit. Find alignment studs (2 pcs), and install in the correct location (see below).



ALIGNMENT STUD LOCATION (2 PLCS)		
TRANSMISSION SIDE		
PTO ASS'Y	R.S.TOP (HD)	L.S.
ASS'Y 1	B	A
ASS'Y 3	A	B
ASS'Y 5	USE EITHER STUD LOCATION	

DISCARD FACTORY GASKET

5. Install supplied gasket over alignment studs. A thin coating of approved transmission fluid on gasket is recommended to help hold gasket to opening. Mount PTO with provided cap screws and washers. Check for proper PTO fit on transmission prior to tightening down fasteners. PTO mounting surface must be flush against transmission prior to tightening mounting fasteners! Failure to do so may result in damage to PTO housing. Tighten top and bottom cap screws first.



Install Following: Gasket (1 pc), 33 mm cap screws and washers used in remaining positions (8 plcs). **TORQUE ALL TO 45 ft.lbs. USE OF THREAD LOCKER IS NOT REQUIRED.**

Continue onto Activation Instructions (separate document).



A Member of the Interpump Group

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