ALLIED
— POWERTRAIN GROUP —

Transmissions
Nut Torque Specs

Eaton Fuller Transmissions

Model	Fastener/ Location	Thread/Fastener	Torque ft-lb	Torque N-m
Eaton FO-18E/20E	Output yoke nut	—	450–500	610–678
Fuller AT-1202 / AT1202A	Input flange/yoke nut	Elastic stop nut	450–500	610–678
Fuller AT-1202 / AT1202A	Output flange/ yoke nut	Elastic stop nut	450–500	610–678
Eaton EEO-16F/17F/18F Endurant	Output yoke retainer bolt	M20 × 1.5	455–508	617–690
FRO16210C	Output	---	650-700	881-949
RTO16908LL	Output	---	650-700	881-949
RTLO16713A	Output	---	450-500	610-677
RTLO16913/18913A	Output	---	650-700	881-949
RTLO16718B/18718B	Output	---	650-700	881-949
RTLO16918B/18918B/20918B	Output	---	650-700	881-949
FS6406A /N	Output	---	300-350	406-474
FSO8406A	Output	---	300-350	406-474

Allison Transmissions

Model	Fastener/ Location	Thread/ Fastener	Torque ft-lb	Torque N-m
Allison 1000 Series	Output yoke retaining bolt	1/2"-20	80–100	108–136
Allison 2000 Series	Output yoke retaining bolt	1/2"-20	80–100	108–136
Allison 1000/2000	Rear yoke nut – when used	Nut	91	123
Allison 3000 – 6-speed	Output yoke/flange retaining bolt	—	85–107	115–145
Allison 4000 – 6/7-speed	Output yoke/flange retaining bolt	—	85–107	115–145
Allison MT640	Output flange retaining bolt	1/2"-20	102–121	138–164
Allison MT643	Output flange retaining bolt	1/2"-20	102–121	138–164
Allison MT644	Output flange retaining bolt	1/2"-20	102–121	138–164
Allison MT647	Output flange retaining bolt	1/2"-20	102–121	138–164
Allison MT650	Output self-locking nut	Large nut	600–800	813–1085

Model	Fastener/ Location	Thread/ Fastener	Torque ft-lb	Torque N-m
Allison MT653	Output self-locking nut	Large nut	600–800	813–1085
Allison MT654CR	Output self-locking nut	Large nut	600–800	813–1085
B400 / B400R – older 2-bolt design	Output flange bolts	---	22–26	30–35
B500 / B500R – older 2-bolt design	Output flange bolts	---	38–45	51–61
B400R – newer single-bolt, Transit Bus application	Output yoke/flange retaining bolt P/N 29535219	---	89–103	120–140
B500 – newer single-bolt design	Output yoke/flange retaining bolt	---	Use applicable 4000-family spec / verify build	---