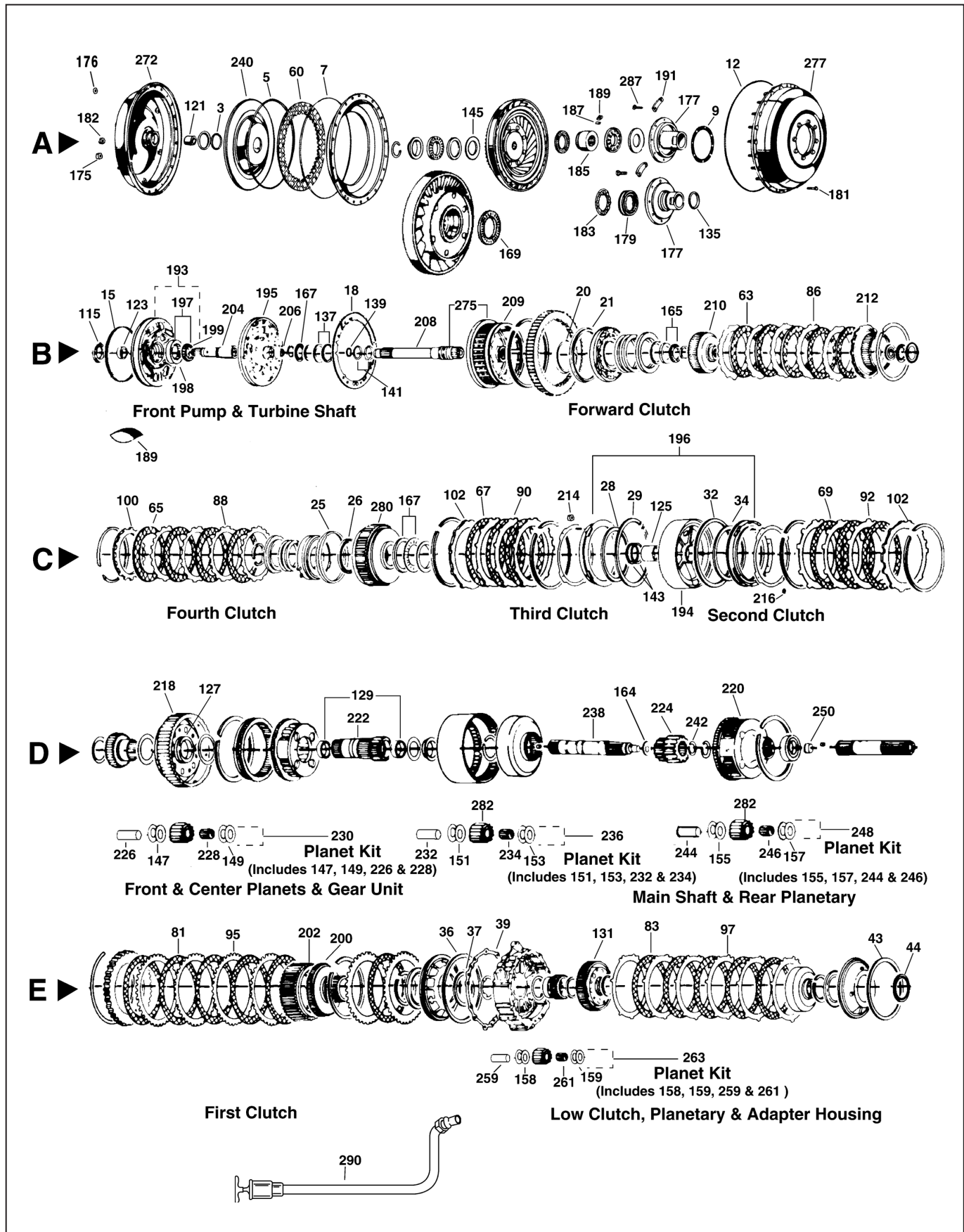


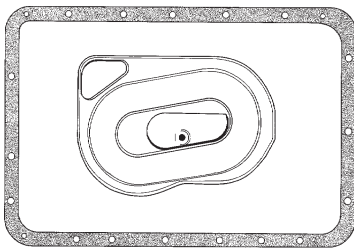
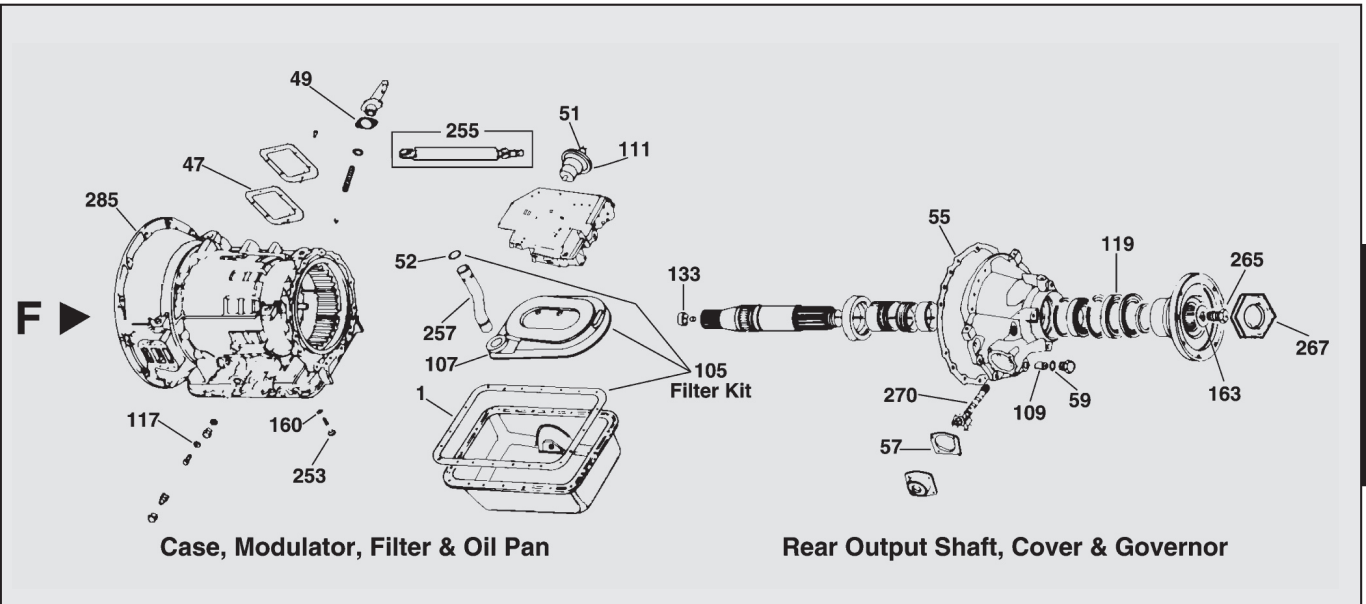
ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.



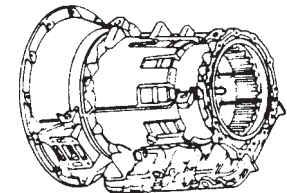
ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.



21 Bolt Pan

Allison Transmissions
MT/B 640, 643, 644, 647, 650, 653, 654



REBUILDER KITS

DESCRIPTION	QTY.	YEAR	DELUXE KIT	MASTER O/H KIT	LESS STEELS KIT	OVERHAUL KIT	GASKET & SEAL KIT
Kits - 640-643 (1)	1	-		K2100	K2100-LS		
Kits - 650-653 (2)	1	-		K2100A	K2100A-LS		
Kits - 644 - PH1,2	1	-		K2100B	K2100B-LS		
Kits - 654 - PH1,2	1	-		K2100D	K2100D-LS		
Kit - 640-643/650-653 - w/Cork Neo - w/Teflon Seal Kit	1	-				K21900	
Kit - 640-643/650-653 - w/Victopac - Vespel Ring Kit	1	-				K21900FW	
Kit - 644/654 - w/Cork/Neo - Standard Ring Kit	1	-				K21900B	
Kit - 644/654 - w/Victopac - Vespel Ring Kit (29530326)	1	-				K21900HW	
Front Pump Reseal Kit (3)	1	-					K21900-2
Kit - w/o Pan Gasket - 640/643/650/653	1	-				K21900NP	

(1) To replace 29502306 Factory Master Kit, also order K21950 bearing kit and 21800 filter.
 (2) To replace 29502307 Factory Master Kit, also order K21950 bearing kit and 21800 filter.
 (3) Contains front pump gasket, rubber lathe cut seal, o-ring and pump bolt washers.

ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
MISCELLANEOUS GASKETS & SEALS/PAN GASKETS					
1F	Gasket - Oil Pan - Cork & Neoprene	1	-	13540X	29501160
1F	Gasket - Oil Pan - Update - Armstrong® (23016682)	1	-	13540W	29501160
3A	O - Ring - Lockup Clutch - Inner - Polyacrylate - exc. 644,654	1	-	3366PL	6770820
3A	Seal - Lathe Cut - Lockup Clutch - Inner - 644, 654	1	-	13176	6770492
5A	Seal - Lathe Cut - Lockup Clutch - Outer - exc. 644, 654	1	-	13159	6758036
5A	Seal - Lathe Cut - Lockup Clutch - Outer - 644, 654	1	-	13177	6758740
7A	Seal - Lathe Cut - Lockup Clutch Backing Plate (Yellow Stripe)	1	-	13151	23016564
9A	Gasket - Converter Pump Hub - 640,650	1	-	13150W	29536726
9A	Gasket - Converter Pump Hub - 644, 654	1	-	13174	6771366
12A	Seal - Lathe Cut - Converter Pump Cover - exc. 644, 654 (Yellow Stripe)	1	-	13151	23016564
12A	Seal - Lathe Cut - Converter Pump Cover - 644, 654 (Green Stripe)	1	-	13175	6880389
15B	Seal - Lathe Cut - Front Pump (Green Stripe)	1	-	13160	23016347
N.I.	Seal - Washer - Front Pump Bolt	12	-	13161	29512113
18B	Gasket - Front Pump To Case	1	-	13162	23046344
20B	Lip Seal - Forward Clutch - Inner (8623121)	1	-	3284L	23015880
21B	Lip Seal - Forward Clutch - Outer	1	-	13163	6833981
25C	Lip Seal - Fourth Clutch - Outer	1	-	13163	6833981
26C	Lip Seal - Fourth Clutch - Inner	1	-	3284L	23015880
28C	Lip Seal - Third Clutch - Inner	1	-	13164	23011471
29C	Lip Seal - Third Clutch - Outer	1	-	13165	6883035
N.I.	O-ring - Center Support (Starting With Serial No. 100432)	1	-	13172	6761244
32C	Lip Seal - Second Clutch - Outer	1	-	13165	6883035
34C	Lip Seal - Second Clutch - Inner	1	-	13164	23011471
47F	Gasket - Power Takeoff Cover - Update - Armstrong® (23016683)	1	-	13158W	29501161
49F	Gasket - Lube Valve Adapter	1	-	13166	6884872
52F	O-ring - Oil Filter Tube (Polyacrylate)	1	-	3435PL	6762127
51F	O-ring - Modulator (23017367)	1	-	3410L	8658110
36E	Lip Seal - First Clutch - Outer	1	-	13169	6883033
37E	Lip Seal - First Clutch - Inner	1	-	13170	6883031
39E	Gasket - Adapter Housing (6837442)	1	-	13171	23045099
43E	Lip Seal - Low Clutch - Outer	1	-	13165	6883035
44E	Lip Seal - Low Clutch - Inner	1	-	13170	6883031
55F	Gasket - Rear Cover	1	-	13171	23045099
57F	Gasket - Governor Cover - Fibre	1	-	3914D	23011670
57F	Gasket - Governor Cover - Update - Armstrong® (23011670)	1	-	3914LW	23018625
59F	O-ring - Governor Filter/Cooler Fitting	1-2	-	13173	6882689
N.I.	Washer - Drain Plug -Coated	1	-	11423B	29507909
N.I.	Washer - Cover - Coated	1	-	21154	N.L.
N.I.	O-Ring - Converter Plug/Cooler Fitting (Brown)	1	-	13180	N.L.
CLUTCH PLATES					
60A	Friction - Lockup Clutch - Graphitec - 640, 643,650, 653 - Not In Kits (4)	1	-	R21106	23046108
60A	Friction - Lockup Clutch - 644, 654 - Not In Kits (5)	1	-	W31102	23048511
63B	Friction - Forward Clutch (4)	5/6	-	R21103	23042200
63B	Friction - Forward Clutch (5)	5/6	-	W21103	23042200
65C	Friction - Fourth Clutch (4)	4/5	-	R21103	23042200
65C	Friction - Fourth Clutch (5)	4/5	-	W21103	23042200
67C	Friction - Third Clutch (4)	3	-	R21104	23042201
67C	Friction - Third Clutch (5)	3	-	W21104	23042201
69C	Friction - Second Clutch (4)	3/4	-	R21104	23042201
69C	Friction - Second Clutch (5)	3/4	-	W21104	23042201
81E	Friction - First Clutch (4) (23042199)	6	-	R11104	29529492
81E	Friction - First Clutch (5)	6	-	W11104	23042199
	<i>(4) Raybestos brand plate. OEM approved heat-treated paper.</i>				
	<i>(5) S.K. Wellman plate. OEM approved graphitic.</i>				

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
CLUTCH PLATES (Cont.)					
83E	Friction - Low Clutch - 654 Phase 1 & 2 (4)	7	-	R21101	23042210
83E	Friction - Low Clutch - 654 Phase 1 & 2 (5)	7	-	W21101	23042210
83E	Friction - Low Clutch - exc. 654 Phase 1 & 2 (5)	5/6	-	W21104	23042201
83E	Friction - Low Clutch - exc. 654 Phase 1 & 2 (4)	5/6	-	R21104	23042201
86B	Steel - Forward Clutch.....	5/6	-	21100	23016610
88C	Steel - Fourth Clutch	4/5	-	21100	23016610
90C	Steel - Third Clutch	3	-	21105	29516333
92C	Steel - Second Clutch.....	3/4	-	21105	29516333
95E	Steel - First Clutch.....	6	-	21107	23016606
97E	Steel - Low Clutch (654 Phase 1 & 2)	8	-	21102	23045054
97E	Steel - Low Clutch (Exc. 654 Phase 1 & 2).....	6/7	-	21105	23016608
	<i>(4) NOTE: Raybestos brand plate. OEM approved heat-treated paper.</i>				
	<i>(5) NOTE: S.K. Wellman plate. OEM approved graphitic.</i>				
BACKING PLATES					
100C	Fourth Clutch	1	-	21108	29516333
102C	2-3 Clutch - .463 - .473	AR	-	21718-R	23046718
102C	2-3 Clutch - .476 - .486	AR	-	21745-R	23046745
102C	2-3 Clutch - .450 - .460	AR	-	21746-R	23046746
FILTERS/FILTER KITS					
105F	Filter Kit - Cork & Neoprene	1	-	FK21800	23019201
105F	Filter Kit - Armstrong® (Large Hole Grommet)	1	-	FK21800W	29502302
105F	Filter Kit - Armstrong® (Small Hole Grommet)	1	-	FK21800AW	N.L.
105F	Filter Kit - Stainless Steel Wire Mesh - 5" Pan (6)	1	-	FK21800L	29528215
107F	Filter - Paper (Large Hole Grommet)	1	-	21800	29527373
107F	Filter - Paper (Small Hole Grommet)	1	-	21800A	N.L.
107F	Filter - Stainless Steel Wire Mesh - 5" Pan (6)	1	-	21800L	29532584
N.I.	Filter - External Spin on Cartridge	1	-	HD-223	25010643
N.I.	Screen - Center Support.....	1	-	21713	23010654
109F	Screen - Governor - Early - Prior To S/N 58071	1	-	11712	23045247
109F	Screen - Governor - Late - Start With S/N 58071	1	-	21712	6882687
	<i>(6) Use with auxiliary filter only.</i>				
VACUUM MODULATORS					
111F	Modulator w/O-Ring (Large Can).....	1	-	11820	3039092
	Modulator w/O-Ring (Small Can).....	1	-	11820A	29501199
METAL CLAD SEALS					
115B	Front Pump - 3.355" O.D.	1	-	21200	6837228
115B	Front Pump - 3.881" O.D. - Update - Brown Viton	1	-	21200A	23016643
115B	Front Pump - 3.380" O.D. - Viton - Shielded.....	1	-	21200B	23045556
117F	Selector Shaft	1	-	38511	23010610
119F	Rear Cover 3.628" O.D.	1	-	11850	6778050
119F	Rear Cover 4.751" O.D.	1	-	21850	6773311
BUSHINGS					
N.I.	Bushing Kit	1	-	K21902	N.L.
121A	Converter Cover	1	-	21000	6756782
123B	Front Pump Body - MT640, 650, 653 (Not Included In Kit) - 2.530.....	1	-	21007	29527101
123B	Front Pump Body - MT644, 654 (Not Included In Kit) - 2.580.....	1	-	21008	23046152
123B	Front Pump Body	1	-	21005	6881926
125C	Center Support.....	1	-	21003	23011924
127D	Front Planetary Carrier - (I.D. Must Be Finished In Place)	1	-	21001	6835385
129D	Center Sun Gear - (I.D. Is Finished, No Further Machining Required)	2	-	21002	29516211
129D	Center Sun Gear - (I.D. Must Be Finished In Place).....	2	-	21002X	6834503

AT640

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
BUSHINGS (Cont.)					
131E	Low Planetary Carrier - (I.D. Must Be Finished In Place).....	1	-	21004	6835398
133F	Rear Output Shaft Bushing (Replaces Bearing 21219 In R. Output Shaft).....	1	-	21006	23016859
SEALING RINGS/RING KITS					
N.I.	Sealing Ring Kit - Complete - 8 Rings.....	1	-	K21901	N.L.
N.I.	Sealing Ring Kit - Complete - 8 Rings - Vespel.....	1	-	K21901V	N.L.
135A	Converter Pump Hub.....	1	-	21300	6830187
137B	Pump Support - Front.....	2	-	21301T	23015617
137B	Pump Support - Front - Vespel.....	1	-	K21301V	23014632
139B	Turbine/Converter.....	1	-	21302	6839163
139B	Turbine/Converter - Vespel.....	1	-	21302V	23019653
141B	Front - Turbine Shaft.....	2	-	21303	6833999
143C	Center Support.....	2	-	21301T	23015617
THRUST WASHERS/NEEDLE BEARINGS					
145A	Spacer - Turbine:				
	- .015" - Gold - exc. 644, 654.....	AR	-	11403	6837429
	- .015" - Gold - 644, 654.....	AR	-	21403	6839976
	- .030" - Silver - exc. 644, 654.....	AR	-	11403A	6837430
	- .030" - Silver - 644, 654.....	AR	-	21403A	6839977
	- .042" - Plain - exc. 644, 654.....	AR	-	11403B	6837431
	- .042" - Plain - 644, 654.....	AR	-	21403B	6839978
	- .060" - Black - exc. 644, 654.....	AR	-	11403C	6837432
	- .060" - Black - 644, 654.....	AR	-	21403C	6839979
	- .075" - Copper - exc. 644, 654.....	AR	-	11403D	6837433
	- .075" - Copper - 644, 654.....	AR	-	21403D	6839980
	Washer - Front Planetary:				
147D	- Bronze.....	12	-	11413	6839514
149D	- Steel.....	12	-	11414	6833991
	Washer - Center Planetary:				
151D	- Bronze.....	8	-	21415	6839375
153D	- Steel.....	8	-	21416	23018960
	Washer - Rear Planetary:				
155D	- Bronze.....	8	-	21415	6839375
157D	- Steel.....	8	-	21416	23018960
160F	Washer - Center Support Bolt.....	1	-	11422	23014094
	Washer - Low Planetary:				
158E	- Bronze (Exc. 644, 654).....	12	-	11416	6839376
159E	- Steel (644, 654).....	8	-	21424	23018961
163F	Washer - Output Flange.....	1	-	11421	29500739
N.I.	Washer - Drain Plug - Coated.....	1	-	11423B	29507909
164D	Washer - Rear Sun Gear (Plastic).....	1	-	21418	29524362
BEARINGS					
N.I.	Bearing Kit (Contains 2 Ea - 21782, 21799 & one 11404).....	1	-	K21950	N.L.
N.I.	Bearing Kit - Complete - 643.....	1	-	K21950C	N.L.
N.I.	Bearing Kit - Complete - 653.....	1	-	K21950D	N.L.
165B/ 165C	Thrust Bearing Assembly - Forward Clutch.....	2	-	21799	23015799
167B	Front & Center Support Bearing.....	2	-	21782	23019782
169A	Thrust Bearing - Converter Stator.....	1	-	11404	23016866
179A	Bearing - Converter Hub - 640, 650.....	1	-	21883	23048030
287A	Bolt - Torque Converter Hub.....	1	-	96-178	23014542

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REFERENCE NO.
HARD PARTS						
Hard Parts may only require the base number for OEM/Aftermarket New or a "-R" suffix for remanufactured. Exceptions are listed individually. NOTE: A separate column is provided to indicate a primary or specific brand/type.						
133F	Roller Bearing - See 21006 Under Bushings					
175A	Nut - Flex Plate.....		6	-	21214	23046154
176A	Washer - Flex Plate		6	-	21154	23014462
177A	Converter Hub:					
	- 1st Design - 640, 650 - Bushing Style - 8 Bolt.....		1	-	21206	6837203
	- 2nd Design - 640, 650 - Bearing Style (w/bearing) 8 Bolt.....		1	-	21204A	23013906
	- 2nd Design - 640, 650 - Bearing Style (w/o bearing) 8 Bolt		1	-	21204	23013906
	- 3rd Design - .683 Gear - Bushing Style - 8 Bolt		1	-	21204C	29507140
	- 4th Design - 1.00 Gear - MT644, 647, 654 - Bearing Style - 12 Bolt(23017446)		1	-	21204E	23046638
	- 4th Design - MT644, 647, 654 - Bushing Style - 12 Bolt.....		1	-	21204D	23016723
179A	Bearing - Converter Hub - 640, 650		1	-	21883	23048030
181A	Converter Cover Stud		6	-	21508	6839508
182A	Converter Cover Nut.....		24	-	21139	190139
183A	Race, Converter Hub Bearing - H.D. - 640, 650 (Bearing Style Hub).....		1	-	21907	23013907
183A	Race, Converter Hub Bearing - H.D. - 640, 650 (Bushing Style Hub).....		1	-	21907A	9440257
185A	Race, Converter Stator - MT643.....		1	-	21226	6837206
187A	Converter Stator Roller		10	-	11211	6774968
189A	Converter Stator Spring.....		10	-	11210	29513517
190B	Locking Key, Converter Cover - Football Key.....		1	-	21209	6772552
191A	Strip Lock - Converter Hub - 644, 654.....		6	-	21212	6880899
191A	Strip Lock - Converter Hub - exc. 644, 654		4	-	11212	6769631
193B	Pump Body w/Gears:					
	- .683 Gears - 640, 650		1	-	K21636	29527499
	- .683 Gears - Late 640, 650.....		1	-	K21636A	29527490
	- .818 Gears - MT654		1	-	K21637	23046638
	- 1.00 Gears - Bushing Design - Late MT644, 647, 654.....		1	-	K21637A	23017114
194C	Support - Center - w/ bushing.....	R	1	-	21940	23018593
195B	Pump Support:					
	- Early - MT643,653.....	R	1	-	21871	29515355
	- Early - MT644,654 - (Mates w/ Ref. #23046638 Body & Gears).....	R	1	-	21872	23015872
	- Late - MT643,653 - (Mates w/1" Pump Body Gear).....	R	1	-	21751	23016751
	- Late - MT644,654 - (Mates w/1" Pump Body Gear).....	R	1	-	21763	23016763
196C	Piston - Center Support - 2nd/3rd Clutch.....	R	2	-	21942	6834230
197B	Kit - Front Pump Gears:					
	- exc. 644/654 - Standard. O.D. - .6835 - .6845.....		1	-	K21201	N.L.
	- 644/654 - Standard. O.D. - .8185 - .8190		1	-	K21201C	N.L.
	- 647 - Standard. O.D. - 1.00 Gears.....		1	-	K21201D	N.L.
198B	Driven Gear Only:					
	- exc. 644/654 - Standard O.D. - .6835		1	-	21201-2	N.L.
	- exc. 644/654 - .060 Oversize O.D. - .6835		1	-	21201-4	N.L.
	- 644/654 - Standard O.D. - .8185		1	-	21201-7	N.L.
	- 644/654 - .060 Oversize O.D. - .8185		1	-	21201-9	N.L.
	- 647 - Standard O.D. - 1.00		1	-	21201-11	N.L.
	- 647 - .060 Oversize O.D. - 1.00		1	-	21201-13	N.L.
199B	Drive Gear Only:					
	- exc. 644/654 - Standard O.D. - .6835		1	-	21201-1	N.L.
	- exc. 644/654 - .060 Oversize O.D. - .6835		1	-	21201-3	N.L.
	- 644/654 - Standard O.D. - .8185		1	-	21201-6	N.L.
	- 644/654 - .060 Oversize O.D. - .8185		1	-	21201-8	N.L.
	- 647 - Standard O.D. - 1.00		1	-	21201-10	N.L.
	- 647 - .060 Oversize O.D. - 1.00		1	-	21201-12	N.L.

AT640

ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REFERENCE NO.
HARD PARTS (Cont.)						
200E	Ring Gear Hub - (Hardened) - MT653.....		1	-	21325	29506325
202E	Ring Gear - 1st Clutch - MT653.....		1	-	21568	6835568
204B	Ground Sleeve - Finished I.D. Bearing Installed: - 640, 650 Early Style - Silver Single Spline w/o Step.....		1	-	21202	23014527
	- 640/650 Late Style - Silver Single Spline w/ Step.....		1	-	21202A	23040476
	- 644, 654 Early Style - Silver Dual Spline w/o Step(23014306)		1	-	21203	29507674
	- 644/654 Late Style - Black Dual Spline w/ Step.....		1	-	21203A	29507673
206B	Roller Bearing - Front Pump (Ina Brand).....(9438017)		1	-	21223A	29503987
206B	Roller Bearing - Front Pump (Torrington Brand).....(9438017)		1	-	21223	29503987
208B	Turbine Shaft.....		1	-	21785	23012785
208B	Turbine Shaft - 654.....		1	-	21785B	23019222
209B	Housing - Forward - w/o Shaft - MT643, 653.....	R	1	-	21172	23017172
210B	Hub - Forward Clutch - exc. 644, 654.....		1	-	21222	6834222
212B	Hub - Fourth Clutch Driving - exc. 644, 654.....		1	-	21221	6834221
	Hub - Fourth Clutch Driving - 644, 654.....		1	-	21221B	23017267
214C	Lock Nut - Third Clutch Spring Retainer - Push On.....		4	-	11213	3909063
216C	Lock Nut - Second Clutch Spring Retainer - Push On.....		4	-	11213	3909063
218D	Front Carrier Replacement Housing w/6 Pins.....		1	-	RH21565	6882564
220D	Rear Carrier - MT653.....	R	1	-	21642	6835642
222D	Sun Gear - Center w/Bushings Installed.....		1	-	21606	29516215
224D	Sun Gear - Rear.....		1	-	21901	6883901
226D	Pin - Front Planetary.....		6	-	11215	6834309
228D	Needle Roller - Front Planetary.....		120	-	11919	9426919
230D	Kit - Front Planetary Repair.....		1	-	K21215	N.L.
232D	Pin - Center Planetary.....		4	-	21216	6835567
234D	Needle Roller - Center Planetary.....		72	-	21920	6834915
236D	Kit - Center Planetary Repair.....		1	-	K21216	N.L.
238D	Main Shaft - 643, 653.....		1	-	21456	23013456
238D	Main Shaft - 644/654.....		1	-	21456B	23017699
240A	Piston - L/U - 640, 650.....		1	-	21845	6770845
242D	Spiral Ring - Rear Sun Gear To Planetary.....		1	-	21224	6834583
244D	Pin - Rear Planetary.....		4	-	21216	6835567
246D	Needle Roller - Rear Planetary.....		72	-	21920	6834915
248D	Kit - Rear Planetary Repair.....		1	-	K21216	N.L.
250D	Roller Bearing - Output Shaft - 640, 643.....		1	-	21219	9418483
253F	Bolt - Case To Center Support - Anchor 2-1/4".....		1	-	21220	23013398
253F	Bolt - Case To Center Support - Anchor 3".....		1	-	31220	23045343
255F	Manual Selector Shaft Kit.....		1	-	K11235	23017610
257F	Tube - Oil Filter - Updates Prior To S/N 58071.....		1	-	21225	6883045
259E	Pin - Low Planetary - exc. 644, 654.....		6	-	11216	6831679
	Pin - Low Planetary - 644, 654.....		4	-	21211A	6880019
261E	Needle Roller - Low Planetary - exc. 644, 654.....		114	-	11920	9426920
	Needle Roller - Low Planetary - 644, 654.....		124	-	21920	6834915
263E	Kit - Low Planetary Repair - exc. 644, 654.....		1	-	K21217	N.L.
	Kit - Low Planetary Repair - 644, 654.....		1	-	K21211A	N.L.
265F	Bolt - Output Flange.....(23014159)		1	-	11222	29510838
267F	Nut - Self-lock Hex - Rear Output Shaft.....		1	-	21956	6771144
270F	Governor: - I.D. No. 461.....		1	-	11410A	6885570
	- I.D. No. 462.....		1	-	11410B	6885571
	- I.D. No. 463.....		1	-	21410	6885572
	- I.D. No. 465.....		1	-	21410A	6881471
	- I.D. No. 738.....		1	-	21410B	6882737
	- I.D. No. 739.....		1	-	21410C	6882736

ALLISON

MT/B 640, 643, 644, 647, 650, 653, 654

To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmisson Name Plate.

ILL.	DESCRIPTION	BRAND	QTY.	YEAR	PART NO.	REFERENCE NO.
HARD PARTS (Cont.)						
272A	Converter Cover..... (23046294)	R	1	-	21294	29524116
277A	Converter/Pump Assembly - (Impeller) - MT643, 653:					
	- Ratio TC350	R	1	-	21596	23018596
	- Ratio TC360	R	1	-	21594	23018594
	- Ratio TC370	R	1	-	21598	23018598
280C	Housing - 4th Clutch - MT643, 653	R	1	-	21825	23011825
280C	Housing - 4th Clutch - MT644, 654	R	1	-	21257	23017257
282D	Gears - Pinion - Center/Rear - MT643, 653 - (4 Per Set)		1	-	21804	6882804
285F	Main Case.....		1	-	650M-CASE	23011779
287A	Bolt - Torque Converter Hub		1	-	96-178	23014542
290E	Tube & Dip Stick Assembly - Universal		1	-	11999U	N.L.
N.I.	Carrier Replacement Pins		6	-	565P	N.L.
N.I.	Drain Plug - Oil Pan		1	-	DP-789	N.L.
N.I.	Kit - Governor Gear - Exc. Bronze		1	-	K34411A	6883938
N.I.	Pan Bolt.....		21	-	96-175A	29500738
N.I.	Reverse Signal Switch - Backup Light.....		1	-	11610	29503665
N.I.	Sleeve - Front Pump - Support - MT640		1	-	21870	23045870
N.I.	Support Repair Sleeve - Center - MT643		1	-	DF593B	N.L.
N.I.	Spring & Roller Kit, Converter Stator - 10 Springs & Rollers		1	-	K11250	6775657

AT640

MISCELLANEOUS PRODUCTS

N.I.	Plug-Cooling Line Ports MT600.....		2		PL3	N.I
N.I.	Plug-Oil Pan Fill Tube MT600.....		1		PL4	N.I

NOTES

TIP Use this chart to identify front support and charging pump applications for MT600 Series Allison Transmissions:

	MT640, 643,650, 653	MT644, 647, 654
Front Support, Early Models:	29515355 (23015871)	23015872 (23015872)
Front Support, Late Models:	29514491 (23016751)	23016763 (23016763)
Pump Assembly, Early Models:	29527499 (23046636)	29527509 (23046638)
Pump Assembly, Late Models:	29527490 (23016889)	29527481 (23017114)

NOTE: To correctly identify which application YOUR transmission requires, the assembly number on each unit must be provided. The old numbers are in parenthesis, the new ones are in bold.