



INSTRUCTION TO SERVICE

ITS60844		19-Oct-2023
SECTION:	219-Engine and Transmission	
WRITTEN BY:	Mike Pearson	
SUBJECT:	Retorque Transmission Yoke as per Allison Document SIL 20-WT-23	
ISSUE:	<i>This is to inform you that your vehicle may be non-compliant with the requirements of the Motor Vehicle Safety Regulations and that the non-compliance could affect the safety of a person.</i> Allison Transmission has observed a potential concern that affects the output shaft yoke/flange retaining bolt	
SUMMARY:	As a Customer Satisfaction Initiative, Allison will support increasing the output shaft yoke/flange retaining bolt torque specification for B3400 R xFE™ and B400 R Series transmissions.	

ITS60844

Ref. NHTSA Recall No.	Ref. Transport Canada Recall No.
23V722	TC 2023-575

THIS ITS DOCUMENT SHOULD BE RETAINED AND REFERRED TO FOR FUTURE MAINTENANCE UNTIL THE NEW FLYER PARTS AND/OR SERVICE MANUAL IS UPDATED TO REFLECT WORK DONE AS A RESULT OF THIS DOCUMENT. ENSURE THAT THIS DOCUMENT IS AVAILABLE FOR PARTS AND MAINTENANCE STAFF GOING FORWARD.

PROCEDURE:

1. Set park brake and chock wheels.
2. Turn the main battery disconnect switch to the "OFF" position.
3. Retorque the transmission yoke bolts per the following Allison Field Action Letter SIL 20-WT-23.



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IMPLEMENTATION DATE: October 3, 2023

SUBJECT: Output Shaft Yoke/Flange Retaining Bolt Torque Specification Increase

MODELS AFFECTED: B3400 R xFE™, B400 R

VOCATIONS AFFECTED: Transit Bus Application

Introduction:

Allison Transmission has observed a potential concern that affects the output shaft yoke/flange retaining bolt P/N 29535219 on B3400 R xFE and B400 R transmissions operating in the Transit Bus Application. This may result in loss of torque on the bolt and a loss of clamp force. As a Customer Satisfaction Initiative, Allison will support increasing the output shaft yoke/flange retaining bolt torque specification to 130 N·m (95 lb ft) for B3400 R xFE and B400 R Series transmissions.

Procedure:

1. Lift bus to access driveline and transmission output bolt, following appropriate safety procedures and guidelines.
2. Disconnect driveline from transmission output yoke.



NOTE: Do not disconnect from the drive axle (differential) end of drive shaft.

3. After disconnecting driveline from transmission output yoke, secure transmission end of drive shaft away from output yoke. U-joint straps and bolts CANNOT be reused and must be discarded, and replaced with new hardware kit.

KH / SL9126EN

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Please Note: Allison Transmission Service Information Letters are intended for use by professional, trained technicians, not for the "do-it-yourselfer." They are written to inform those technicians of conditions that may occur on some transmission models (or serial numbers ranges) or to provide information that could assist in the proper servicing of a specific Allison transmission. Properly trained technicians have the equipment, tools, safety instructions, and know-how to do a job properly and safely. If a condition is described, do not assume that the Service Information Letter applies to your transmission, or that your transmission has the condition described. Product evolution and information updates are inevitable. Please see your authorized Allison Transmission service dealer or distributor to understand if your particular transmission may benefit from the information contained within the Service Information Letter.

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4. Using a pry bar or yoke holding fixture, secure the yoke so it will not rotate.
 - Make sure not to damage yoke u-joint cavity or other machined surfaces (refer to [Figure 1](#)).



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Figure 1.

5. Torque output shaft yoke/flange retaining bolt P/N 29535219 to new specification; 130 N-m (95 lb ft).
6. Clean original paint mark and reapply paint mark to the output retaining plate and output yoke bolt with one continuous mark.

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7. Reinstall driveline and secure u-joint to transmission output yoke with new straps and bolts from hardware kit.
- Follow manufacturer's torque procedure and specifications. Refer to [Figure 2](#).
 - Prior to lowering bus from lift, mark transmission nameplate with paint pen to indicate output shaft yoke/flange retaining bolt torque has been verified.

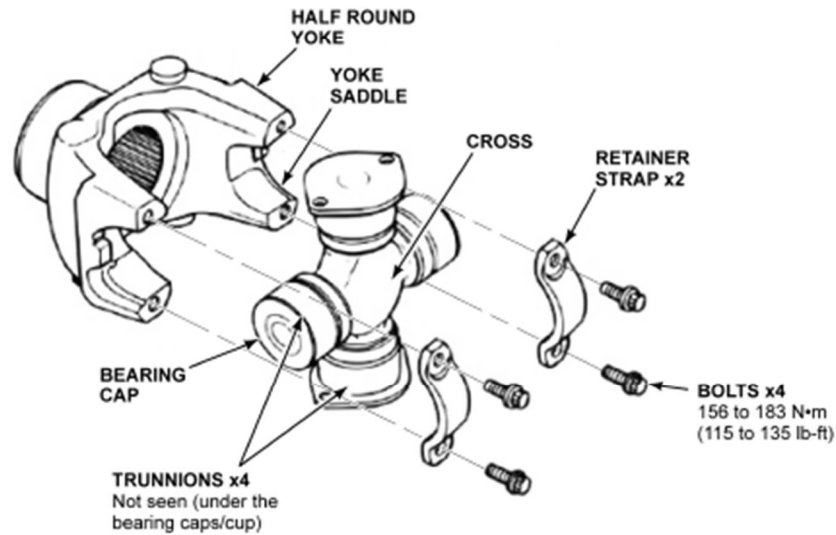


Figure 2.

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4. Remove all tools and debris from work area to return coach to service.
5. Turn the main battery disconnect switch to the "ON" position.

LABOUR ESTIMATE				
	Operation	Number of Technician(s)	Hours	Labor Time T X HR
1	Retorque Transmission Yoke as per Allison Document SIL 20-WT-23	1	1.0	As Required

PARTS REQUIRED					
Item	Part Number	Description	Qty. per Coach	Units	Notes
1	N/A	All parts supplied by Allison	1	EA	