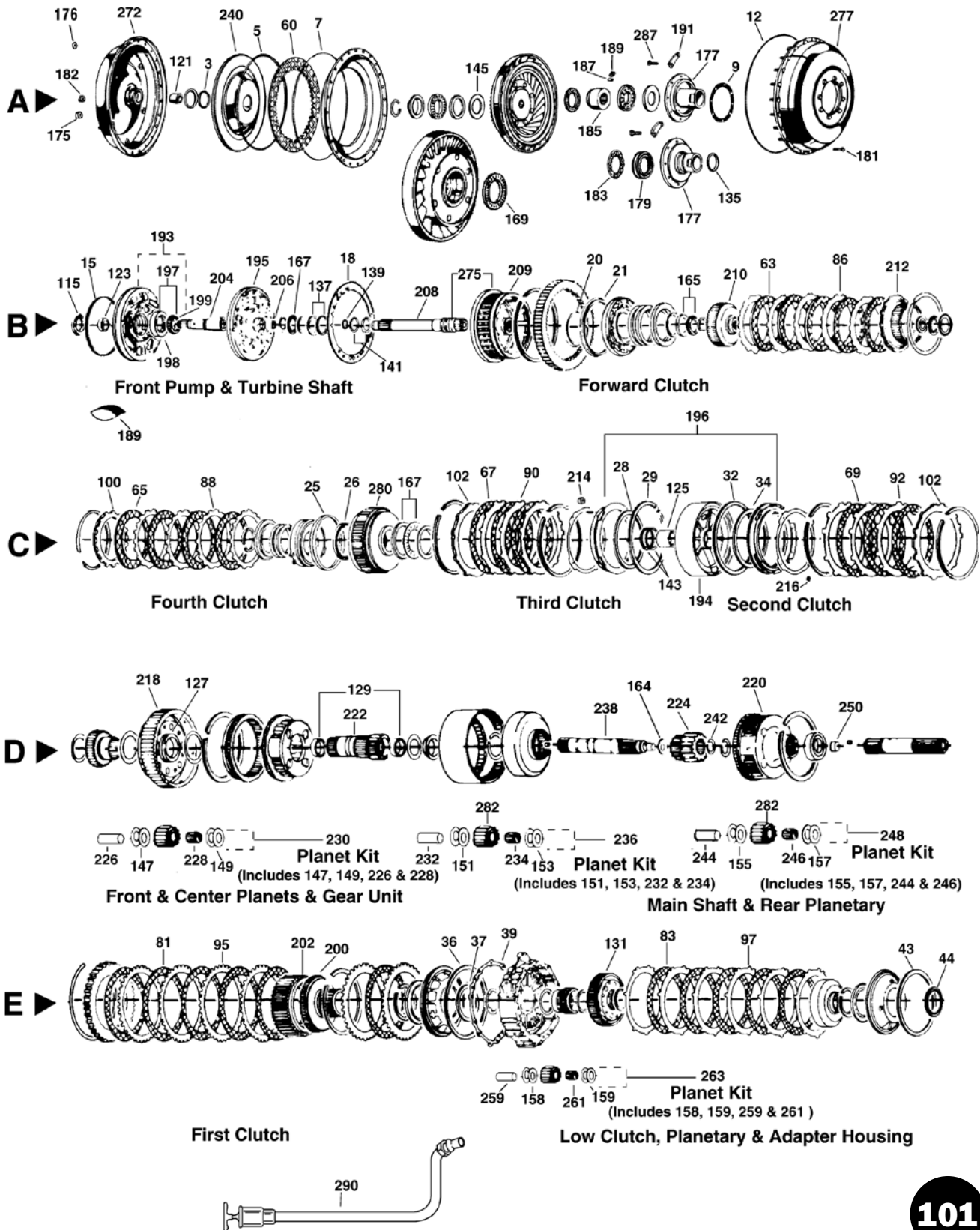
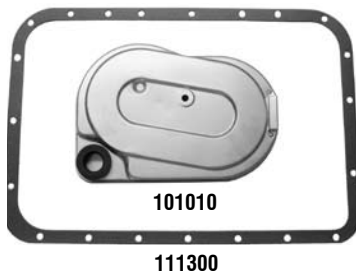
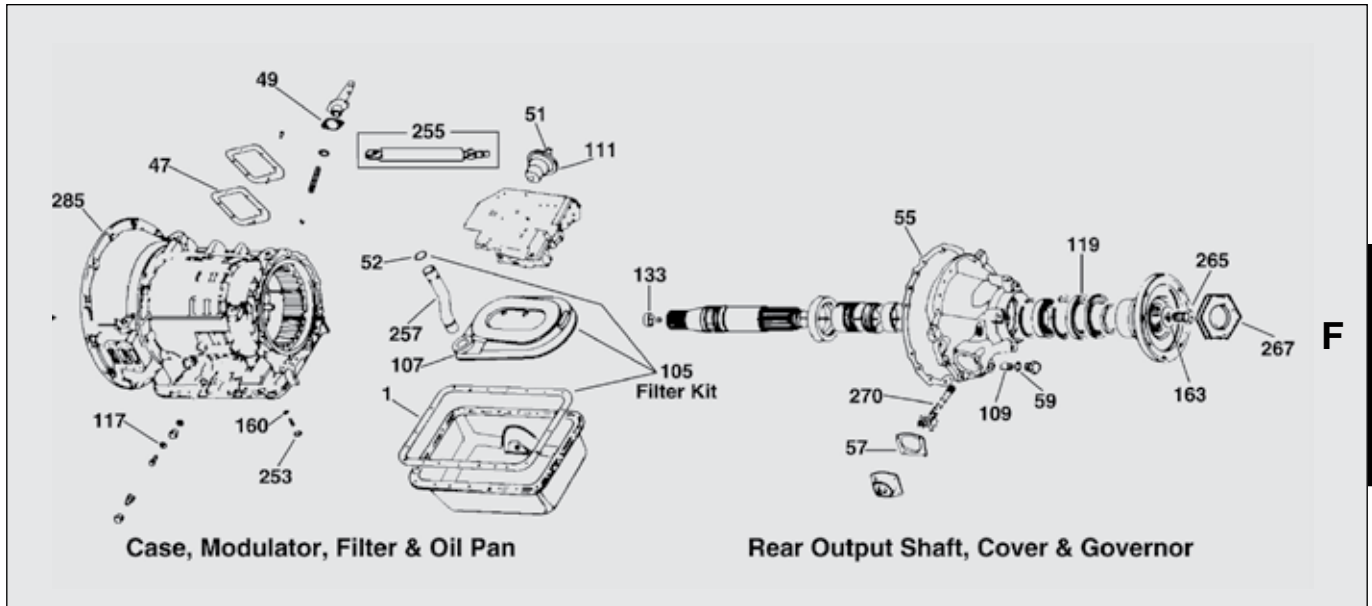


# ALLISON MT/B 640, 643, 644, 647, 650, 653, 654

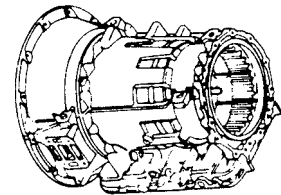
To Get The Correct Parts, You Must Provide The Assembly Number Found On The Transmission Name Plate.



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



Allison Transmissions  
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.**

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>MASTER OVERHAUL KITS (WITH STEELS)</b>					
N.I.	MT640, 643 (Armstrong® & Vespel Rings).....	1	72-Up	101006	K2100
N.I.	MT650, 653 (Armstrong® & Vespel Rings).....	1	72-Up	101006A	K2100A
N.I.	MT644 PH1, PH2.....	1	72-Up	101006D	K2100B
N.I.	MT654 PH1, PH2.....	1	72-Up	101006E	K2100D
<b>LESS STEEL KITS</b>					
N.I.	MT640, 643 (Armstrong® & Vespel Rings).....	1	72-Up	101004	K2100-LS
N.I.	MT650, 653 (Armstrong® & Vespel Rings).....	1	72-Up	101004A	K2100A-LS
N.I.	MT644 PH1, PH2.....	1	72-Up	101004D	K2100B-LS
N.I.	MT654 PH1, PH2.....	1	72-Up	101004E	K2100D-LS
<b>OVERHAUL KITS (W/ RINGS &amp; SEALS)</b>					
N.I.	MT640, 643, 650, 653 (Armstrong® & Vespel Rings).....	1	72-Up	101002A	K21900FW
N.I.	MT644, 654 (Cork & Standard Rings) .....	1	72-Up	101002D	K21900B
N.I.	MT644, 654 (Armstrong® & Vespel Rings).....	1	72-Up	101002H	K21900HW
<b>FILTER KITS</b>					
105F	Filter Kit, Cork & Neoprene .....	1	72-Up	101011	FK21800
105F	Filter Kit, Armstrong® (Large Hole Grommet).....	1	72-Up	101011A	FK21800W
105F	Filter Kit, Armstrong® (Small Hole Grommet).....	1	72-Up	101011B	FK21800AW
105F	Filter Kit, Stainless Steel Wire Mesh (5" Pan)..... (Use w/ Auxiliary Filter Only) .....	1	72-Up	101011C	FK21800L

MT640

# 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.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>FILTERS</b>					
107F	Paper (Large Hole Grommet).....	1	72-Up	101010	21800
107F	Paper (Small Hole Grommet).....	1	72-Up	101010B	21800A
107F	Stainless Steel Wire Mesh (5" Pan)..... (Use w/ Auxiliary Filter Only) .....	1	72-Up	101010C	21800L
N.I.	External Spin on Cartridge.....	1	72-Up	101013	HD-223
109F	Screen, Governor (Early up to S# 58071).....	1	72-Up	101014	21712
109F	Screen, Governor (Late S# 58071 & up).....	1	72-Up	111014	11712
N.I.	Screen, Center Support.....	1	72-Up	101017	21713
<b>BUSHINGS</b>					
N.I.	Bushing Kit .....	1	72-Up	101030	K21902
123B	Pump (2.443" OD).....	1	72-Up	101034	21005
123B	Pump (2.530" OD).....	1	72-Up	101034A	21007
123B	Pump (2.580" OD).....	1	72-Up	101034B	21008
125C	Center Support.....	1	72-Up	101044	21003
129D	Center Sun Gear (Finish In Place) .....	2	72-Up	101052	21002
129D	Center Sun Gear (Unfinished In Place) .....	2	72-Up	101052A	21002X
127D	Front Planet Carrier (Finish In Place).....	1	72-Up	101053	21001
131E	Low Planetary Carrier (ID Must Be Finished In Place).....	1	72-Up	101059	21004
133F	Rear Output Shaft (Replaces Bearing In Rear Output Shaft).....	1	72-Up	101062	21006
<b>METAL CLAD SEALS</b>					
115B	Front Pump (3.335" OD) .....	1	72-Up	101070	21200
115B	Front Pump (3.380" OD) (Viton Shielded) .....	1	72-Up	101070A	21200B
115B	Front Pump (3.881" OD) (Update, Brown) .....	1	72-Up	101070B	21200A
117F	Selector Shaft .....	1	72-Up	44072	38511
119F	Extension Housing (3.628" OD).....	1	72-Up	121074	11850
119F	Extension Housing (4.751" OD).....	1	72-Up	101080	21850
<b>FRICTION PLATES</b>					
81E	1st.....	6	72-Up	111106	11104
69C	2nd.....	3-4	72-Up	101106	21104
67C	3rd .....	3	72-Up	101106	21104
65C	4th.....	4-5	72-Up	101108	21103
63B	Forward .....	5-6	72-Up	101108	21103
83E	Low (50 T) (Exc 654 Phase 1 & 2).....	6	72-Up	101106	21104
83E	Low (71 T) (654 Phase 1 & 2) .....	7	72-Up	101106A	21101
<b>STEEL PLATES</b>					
95E	1st.....	6	72-Up	101124	21107
92C	2nd.....	3-4	72-Up	101126	21105
90C	3rd .....	3	72-Up	101126	21105
88C	4th.....	4-5	72-Up	101128	21100
86B	Forward .....	5-6	72-Up	101128	21100
97E	Low (8.825" ID) (Exc 654 Phase 1 & 2) .....	6-7	72-Up	101126	21105
97E	Low (9.198" ID) (654 Phase 1 & 2).....	8	72-Up	101126B	21102
<b>BACKING PLATES</b>					
100C	4th Clutch .....	1	72-Up	101142	21108
102C	2-3 Clutch (.450"-.460") .....	AR	72-Up	101148C	21746
102C	2-3 Clutch (.463"-.473") .....	AR	72-Up	101148A	21718
102C	2-3 Clutch (.476"-.486") .....	AR	72-Up	101148B	21745

# 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.**

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>MODULATORS</b>					
111F	Modulator w/ O-Ring (Small Can) .....	1	72-Up	111160	11820A
111F	Modulator w/ O-Ring (Large Can) .....	1	72-Up	111160A	11820
<b>SEALING RINGS</b>					
N.I.	Ring Kit (Complete 8 Rings) .....	1	72-Up	101175	K21901
N.I.	Ring Kit (Complete 8 Rings) (Vespel) .....	1	72-Up	101175A	K21901V
N.I.	Ring Kit (Pump Support, Front Vespel) .....	1	72-Up	101175D	K21301V
137B	Pump Support (Front) .....	2	72-Up	101176	21301T
143C	Center Support .....	2	72-Up	101176	21301T
141B	Turbine Shaft (Front) .....	2	72-Up	101178	21303
139B	Turbine / Converter .....	1	72-Up	101181	21302
139B	Turbine / Converter (Vespel) .....	1	72-Up	101181V	21302V
<b>THRUST WASHERS &amp; SPACERS</b>					
N.I.	Washer, Drain Plug (Coated) .....	1	72-Up	111202A	11423B
147D	Washer, Front Planet (Bronze) .....	12	72-Up	111582-1A	11413
149D	Washer, Front Planet (Steel) .....	12	72-Up	111582-1B	11414
151D	Washer, Center Planet (Bronze) .....	8	72-Up	101250A	21415
153D	Washer, Center Planet (Steel) .....	8	72-Up	101250B	21416
155D	Washer, Rear Planet (Bronze) .....	8	72-Up	101250A	21415
157D	Washer, Rear Planet (Steel) .....	8	72-Up	101250B	21416
158E	Washer, Low Planet (Bronze) (Exc 644, 654) .....	12	72-Up	111250A	11416
159E	Washer, Low Planet (Steel) (644, 654) .....	8	72-Up	101250D	21424
160F	Washer, Center Support Bolt .....	1	72-Up	111783W	11422
163F	Washer, Output Flange .....	1	72-Up	111790W	11421
164D	Washer, Rear Sun Gear (Plastic) .....	1	72-Up	101247	21418
<b>BEARINGS &amp; RACES</b>					
N.I.	Bearing Kit (101299 not included) .....	1	72-Up	101201	K21950
N.I.	Bearing Kit, Complete 643 .....	1	72-Up	101201C	K21950C
N.I.	Bearing Kit, Complete 653 .....	1	72-Up	101201D	K21950D
206B	Roller Bearing, Front Pump (Ina Brand) .....	1	72-Up	111211N	21223A
206B	Roller Bearing, Front Pump (Torrington ) .....	1	72-Up	111211M	21223
167B	Front & Center Support .....	2	72-Up	12214	21782
165B	Forward Clutch .....	2	72-Up	101235	21799
250D	Roller Bearing, Output Shaft 640, 643 .....	1	72-Up	101268	21219
<b>GASKETS &amp; O-RINGS</b>					
1F	Gasket, Pan Gasket (Cork) .....	1	72-Up	111300	13540X
1F	Gasket, Pan Gasket (Armstrong®) .....	1	72-Up	111300A	13540W
39E	Gasket - Adapter Housing .....	1	72-Up	101303	13171
55F	Gasket - Rear Cover .....	1	72-Up	101303	13171
57F	Gasket, Governor Cover .....	1	72-Up	34306	3914D
57F	Gasket, Governor Cover (Updated) .....	1	72-Up	111306	3914LW
47F	Gasket, PTO Cover (Update - Armstrong®) .....	1	72-Up	111319	13158W
52F	O-Ring, Oil Filter Tube (Polyacrylate) .....	1	72-Up	101363	3435PL
51F	O-Ring, Modulator .....	1	72-Up	44369B	3410L
59F	O-Ring, Governor Filter & Cooler Fitting .....	1-2	72-Up	34370	13173
N.I.	O-Ring, Center Support (Starting With Serial No. 100432) .....	1	72-Up	101372	13172
N.I.	External Reseal Kit, Front Pump .....	1	72-Up	101390	K21900-2
49F	Gasket, Lube Valve Adapter .....	1	72-Up	101398	13166
N.I.	Washer, Drain Plug (Coated) .....	1	72-Up	111202A	11423B
N.I.	Washer, Cover (Coated) .....	1	72-Up	101249A	21154

MT640

# 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.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>TECHNICAL MANUALS</b>					
N.I.	Service Manual (643, 653).....	1	72-Up	101400AM	TM-600M
N.I.	Service Manual (644, 654).....	1	72-Up	101400BM	TM-644M
N.I.	Parts Catalog (643, 653).....	1	72-Up	101400AP	TM-600P
N.I.	Parts Catalog (644, 654).....	1	72-Up	101400BP	TM-644P
<b>HARD PARTS</b>					
<b>Prefix Key: D = OEM, A = Aftermarket New, R = Remanufactured</b>					
<b>PUMPS</b>					
193B	Pump Body w/ .683" Gears Early 640, 650 (29527499 or 23046636) .....	1	72-Up	101510	K21636
193B	Pump Body w/ .683" Gears Late 640, 650 (29527490 or 23016889) .....	1	72-Up	101510A	K21636A
193B	Pump Body w/ .818" Gears Early 654 (29527509 or 23046638) .....	1	72-Up	101510B	K21637
193B	Pump Body w/ 1.000" Gears Late 644, 647, 654 (29527481 or 23017114) .....	1	72-Up	101510C	K21637A
195B	Pump Support Early 643, 653 (29515355 or 23015871).....	1	72-Up	101520	21871
195B	Pump Support Late 643, 653 (29514491 or 23016751).....	1	72-Up	101520A	21751
195B	Pump Support Early 644, 654 (23015872).....	1	72-Up	101520B	21872
195B	Pump Support Late 644, 654 (23016763).....	1	72-Up	101520D	21763
<b>PUMP GEARS</b>					
197B	Pump Gears (.683") Exc 644, 654 .....	1	72-Up	101530	K21201
197B	Pump Gears (.818") 644, 654 .....	1	72-Up	101530A	K21201C
197B	Pump Gears (1.000") 647 .....	1	72-Up	101530D	K21201D
199B	Inner Gear (.683") Exc 644, 654 .....	1	72-Up	101532A	21201-1
199B	Inner Gear (.683" w/ .060" Oversize OD) Exc 644, 654 .....	1	72-Up	101532AH	21201-3
199B	Inner Gear (.818") 644, 654 .....	1	72-Up	101532B	21201-6
199B	Inner Gear (.818" w/ .060" Oversize OD) 644, 654.....	1	72-Up	101532BH	21201-8
199B	Inner Gear (1.000") 647 .....	1	72-Up	101532C	21201-10
199B	Inner Gear (1.000" w/ .060" Oversize OD) 647 .....	1	72-Up	101532CH	21201-12
198B	Outer Gear (.683") Exc 644, 654 .....	1	72-Up	101534A	21201-2
198B	Outer Gear (.683" w/ .060" Oversize OD) Exc 644, 654 .....	1	72-Up	101534AH	21201-4
198B	Outer Gear (.818") 644, 654.....	1	72-Up	101534B	21201-7
198B	Outer Gear (.818" w/ .060" Oversize OD) 644, 654 .....	1	72-Up	101534BH	21201-9
198B	Outer Gear (1.000") 647.....	1	72-Up	101534C	21201-11
198B	Outer Gear (1.000" w/ .060" Oversize OD) 647 .....	1	72-Up	101534CH	21201-13
<b>DRUMS &amp; CLUTCH HUBS</b>					
209B	Housing, Forward (w/o Shaft) 643, 653 .....	1	72-Up	101551-1	21172
280C	Housing, 4th Clutch 643, 653.....	1	72-Up	101558	21825
280C	Housing, 4th Clutch 644, 654.....	1	72-Up	101558A	21257
210B	Hub, Forward Clutch Exc 644, 654 .....	1	72-Up	101574	21222
212B	Hub, Fourth Clutch Driving Exc 644, 654 .....	1	72-Up	101578	21221
212B	Hub, Fourth Clutch Driving 644, 654 .....	1	72-Up	101578A	21221B
<b>PLANETS</b>					
218D	Front Carrier Replacement Housing w/6 Pins .....	1	72-Up	101582	RH21565
220D	Rear Carrier 653 .....	1	72-Up	101584A	21642
282D	Gears, Pinion Center / Rear 643, 653 (4 Per Set) .....	1	72-Up	101584-2	21804
236D	Kit, Center Planet Repair .....	1	72-Up	101584-7K	K21216
230D	Kit, Front Planet Repair .....	1	72-Up	101584-7	K21215
263E	Kit, Low Planet Repair Exc 644, 654.....	1	72-Up	101584-7A	K21217
263E	Kit, Low Planet Repair 644, 654 .....	1	72-Up	101584-7B	K21211A
248D	Kit, Rear Planet Repair.....	1	72-Up	101584-7K	K21216
234D	Needle Roller, Center Planet.....	72	72-Up	181585-4A	21920
228D	Needle Roller, Front Planet.....	120	72-Up	111582-4	11919
261E	Needle Roller, Low Planet Exc 644, 654.....	114	72-Up	111584-4	11920
261E	Needle Roller, Low Planet 644, 654 .....	124	72-Up	181585-4A	21920

# 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.**

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>PLANETS (Cont.)</b>					
246D	Needle Roller, Rear Planet.....	72	72-Up	181585-4A	21920
N.I.	Pins, Front Carrier Replacement .....	6	72-Up	101582-3	565P
226D	Pins, Front Planet .....	6	72-Up	111582-3	11215
232D	Pins, Center Planet.....	4	72-Up	101585-3	21216
259E	Pins, Low Planet Exc 644, 654.....	6	72-Up	111584-3	11216
259E	Pins, Low Planet 644, 654 .....	4	72-Up	101589-3	21211A
244D	Pins, Rear Planet.....	4	72-Up	101585-3	21216
202E	Ring Gear, 1st Clutch 653.....	1	72-Up	101594	21568
200E	Ring Gear Hub (Hardened) 653 .....	1	72-Up	101604	21325
<b>SUN GEARS, SHELLS &amp; SUPPORTS</b>					
222D	Sun Gear, Center w/ Bushings Installed.....	1	72-Up	101610	21606
224D	Sun Gear, Rear .....	1	72-Up	101614	21901
194C	Support, Center (w/ Bushing).....	1	72-Up	101630	21940
N.I.	Spring & Roller Kit, Converter Stator (10 Springs & Rollers).....	1	72-Up	111659	K11250
<b>SHAFTS</b>					
238D	Main Shaft 643, 653 .....	1	72-Up	101672	21456
238D	Main Shaft 644, 654 .....	1	72-Up	101672A	21456B
208B	Turbine Shaft Exc 654 .....	1	72-Up	101673	21785
208B	Turbine Shaft 654.....	1	72-Up	101673A	21785B
<b>GOVERNORS</b>					
270F	Governor (Code # 461) 2200-2600 RPM Range 643.....	1	72-Up	111680A	11410A
270F	Governor (Code # 463) 3000-3400 RPM Range 643 .....	1	72-Up	101680	21410
270F	Governor (Code # 462) 2400-2600 RPM Range 653.....	1	72-Up	111680B	11410B
270F	Governor (Code # 463) 2800 RPM Range 653 .....	1	72-Up	101680	21410
270F	Governor (Code # 465) 3000 RPM Range 653 .....	1	72-Up	101680A	21410A
270F	Governor (Code # 738) 3200-3800 RPM Range 653 (Bronze Gear).....	1	72-Up	101680B	21410B
270F	Governor (Code # 739) 3600-3800 RPM Range 653 (Bronze Gear).....	1	72-Up	101680C	21410C
270F	Governor (Caterpillar Engine w/ Blower) 2600 RPM Range .....	1	72-Up	101680B	21410B
270F	Governor (Caterpillar Engine w/o Blower) 2800 RPM Range.....	1	72-Up	101680C	21410C
N.I.	Kit, Governor Gear (Exc Bronze) .....	1	72-Up	34684B	K34411A
<b>CASES &amp; HOUSINGS</b>					
285F	Main Case.....	1	72-Up	101760	650M-CASE
<b>MISCELLANEOUS COMPONENTS</b>					
N.I.	Reverse Signal Switch, Backup Light.....	1	72-Up	111414	11610
204B	Ground Sleeve 640, 650 Silver Single Spline w/o Step .....	1	72-Up	101449	21202
204B	Ground Sleeve 640, 650 Silver Single Spline w/ Step .....	1	72-Up	101449A	21202A
204B	Ground Sleeve 644, 654 Silver Dual Spline w/o Step.....	1	72-Up	101449B	21203
204B	Ground Sleeve 644, 654 Black Dual Spline w/ Step.....	1	72-Up	101449C	21203A
N.I.	Drain Plug, Oil Pan .....	1	72-Up	111483	DP-789
290E	Tube & Dip Stick Assembly, Universal.....	1	72-Up	111494U	11999U
257F	Tube, Oil Filter (Updates Prior To S# 58071) .....	1	72-Up	101495	21225
N.I.	Sleeve, Front Pump Support 640.....	1	72-Up	101695E	21870
N.I.	Support Repair Sleeve, Center 643 .....	1	72-Up	101695A	DF593B
253F	Bolt, Case To Center Support (Anchor 2-1/4").....	1	72-Up	101783	21220
253F	Bolt, Case To Center Support (Anchor 3") .....	1	72-Up	181783	31220
265F	Bolt, Output Flange.....	1	72-Up	111790	11222
267F	Nut, Self-lock Hex - Rear Output Shaft .....	1	72-Up	101798	21956
214C	Lock Nut, Third Clutch Spring Retainer (Push On) .....	4	72-Up	111799	11213

MT640



# 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.

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>MISCELLANEOUS COMPONENTS (Cont.)</b>					
216C	Lock Nut, Second Clutch Spring Retainer (Push On) .....	4	72-Up	111799	11213
242D	Spiral Ring - Rear Sun Gear To Planetary .....	1	72-Up	101888	21224
196C	Piston, 2-3 640, 650 .....	1	72-Up	101965	21942
255F	Manual Selector Shaft Kit .....	1	72-Up	101991	K11235
N.I.	Plug, Cooling Line Ports MT600 .....	2	72-Up	M479-3	PL3
N.I.	Plug, Oil Pan Fill Tube MT600 (Pkg of 100) .....	1	72-Up	M479-4	PL4
<b>CONVERTER COMPONENTS</b>					
121A	Bushing, Converter Cover .....	1	72-Up	101032	21000
191A	Strip Lock, Converter Hub 644, 654 .....	6	72-Up	101088B	21212
191A	Strip Lock, Converter Hub Exc 644, 654 .....	4	72-Up	101088A	11212
60A	Friction, Lockup (Can use 181104) .....	1	72-Up	101115	21106
135A	Sealing Ring, Converter Pump Hub .....	1	72-Up	101186	21300
183A	Race, Converter Stator 643 .....	1	72-Up	101210A	21226
183A	Race, Converter Hub Bearing 640, 650 (Bearing Style Hub) .....	1	72-Up	101210	21907
183A	Race, Converter Hub Bearing 640, 650 (Bushing Style Hub) .....	1	72-Up	101210B	21907A
145A	Spacer, Turbine (.015" Gold) Exc 644, 654 .....	1	72-Up	111212	11403
145A	Spacer, Turbine (.015" Gold) 644, 654 .....	1	72-Up	101212	21403
145A	Spacer, Turbine (.030" Silver) Exc 644, 654 .....	1	72-Up	111212A	11403A
145A	Spacer, Turbine (.030" Silver) 644, 654 .....	1	72-Up	101212A	21403A
145A	Spacer, Turbine (.042" Plain) Exc 644, 654 .....	1	72-Up	111212B	11403B
145A	Spacer, Turbine (.042" Plain) 644, 654 .....	1	72-Up	101212B	21403B
145A	Spacer, Turbine (.060" Black) Exc 644, 654 .....	1	72-Up	111212C	11403C
145A	Spacer, Turbine (.060" Black) 644, 654 .....	1	72-Up	101212C	21403C
145A	Spacer, Turbine (.075" Copper) Exc 644, 654 .....	1	72-Up	111212D	11403D
145A	Spacer, Turbine (.075" Copper) 644, 654 .....	1	72-Up	101212D	21403D
N.I.	Washer, Cover (Coated) .....	6	72-Up	101249A	21154
N.I.	Washer, Flex Plate .....	6	72-Up	101249A	21154
169A	Bearing, Converter Stator .....	1	72-Up	111299A	11404
179A	Bearing, Converter Hub, 640, 650 .....	1	72-Up	101299	21883
N.I.	Seal, Washer-Front Pump Bolt .....	12	72-Up	101309	13161
18B	Gasket, Front Pump to Case .....	1	72-Up	101310	13162
15B	Seal, Lathe Cut (Front Pump) (Green Stripe) .....	1	72-Up	101311	13160
12A	Seal, Lathe Cut (Front Pump Cover) 644, 654 (Green Stripe) .....	1	72-Up	101311A	13175
12A	Seal, Lathe Cut (Front Pump Cover) Exc 644, 654 (Yellow Stripe) .....	1	72-Up	101311B	13151
9A	Gasket, Converter Pump Hub 640, 650 .....	1	72-Up	111323	13150W
9A	Gasket, Converter Pump Hub 644, 654 .....	1	72-Up	101323	13174
3A	O-Ring, Lockup Clutch (Inner) Exc 644, 654 .....	1	72-Up	101363A	3366PL
3A	Seal, Lockup Clutch (Inner) 644, 654 .....	1	72-Up	101330A	13176
5A	Seal, Lathe Cut Lockup Clutch (Outer) Exc 644, 654 .....	1	72-Up	101331B	13159
5A	Seal, Lathe Cut Lockup Clutch (Outer) 644, 654 .....	1	72-Up	101331A	13177
7A	Seal, Lathe Cut Lockup Clutch (Backing Plate Yellow Stripe) .....	1	72-Up	101311B	13151
N.I.	O-Ring, Converter Plug / Cooler Fitting (Brown) .....	1	72-Up	181397	13180
272A	Converter Cover .....	1	72-Up	101526	21294
277A	Converter / Pump Assembly (Impeller) 643, 653 Ratio TC350 .....	1	72-Up	101525A	21596
277A	Converter / Pump Assembly (Impeller) 643, 653 Ratio TC360 .....	1	72-Up	101525B	21594
277A	Converter / Pump Assembly (Impeller) 643, 653 Ratio TC370 .....	1	72-Up	101525C	21598
177A	Converter Hub, 1st Design (8 Bolt) 640, 650 Bushing Style .....	1	72-Up	101607B	21206
177A	Converter Hub, 2nd Design (8 Bolt) 640, 650 Bearing Style (w/ bearing) .....	1	72-Up	101607A	21204A
177A	Converter Hub, 2nd Design (8 Bolt) 640, 650 Bearing Style (w/o bearing) .....	1	72-Up	101607	21204
177A	Converter Hub, 3rd Design (8 Bolt) .683" Gear Bushing Style .....	1	72-Up	101607C	21204C
177A	Converter Hub, 4th Design (12 Bolt) 644, 647, 654 Bearing Style .....	1	72-Up	101607E	21204E
177A	Converter Hub, 4th Design (12 Bolt) 644, 647, 654 Bushing Style .....	1	72-Up	101607D	21204D
190B	Locking Key, Converter Cover (Football Key) .....	1	72-Up	101755-6	21209
287A	Bolt, Torque Converter Hub .....	1	72-Up	M464GE	96-178

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

ILL.	DESCRIPTION	QTY.	YEAR	PART NO.	REFERENCE NO.
<b>CONVERTER COMPONENTS (Cont.)</b>					
287A	Bolt, Torque Converter Hub .....	1	72-Up	M464GE	96-178
175A	Nut, Flex Plate .....	6	72-Up	101795C	21214
181A	Stud, Converter Cover .....	6	72-Up	101795B	21508
182A	Nut, Converter Cover.....	24	72-Up	101795A	21139
187A	Roller, Converter Stator .....	10	72-Up	111836	11211
189A	Spring, Converter Stator.....	10	72-Up	111837	11210
240A	Piston, Converter Lock-up 640, 650.....	1	72-Up	101960	21845

**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:	<b>29515355</b> (23015871)	<b>23015872</b> (23015872)
Front Support, Late Models:	<b>29514491</b> (23016751)	<b>23016763</b> (23016763)
Pump Assembly, Early Models:	<b>29527499</b> (23046636)	<b>29527509</b> (23046638)
Pump Assembly, Late Models:	<b>29527490</b> (23016889)	<b>29527481</b> (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.

**NOTES**

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MT640