



**SPICER<sup>®</sup>**  
*Off-Highway Products*

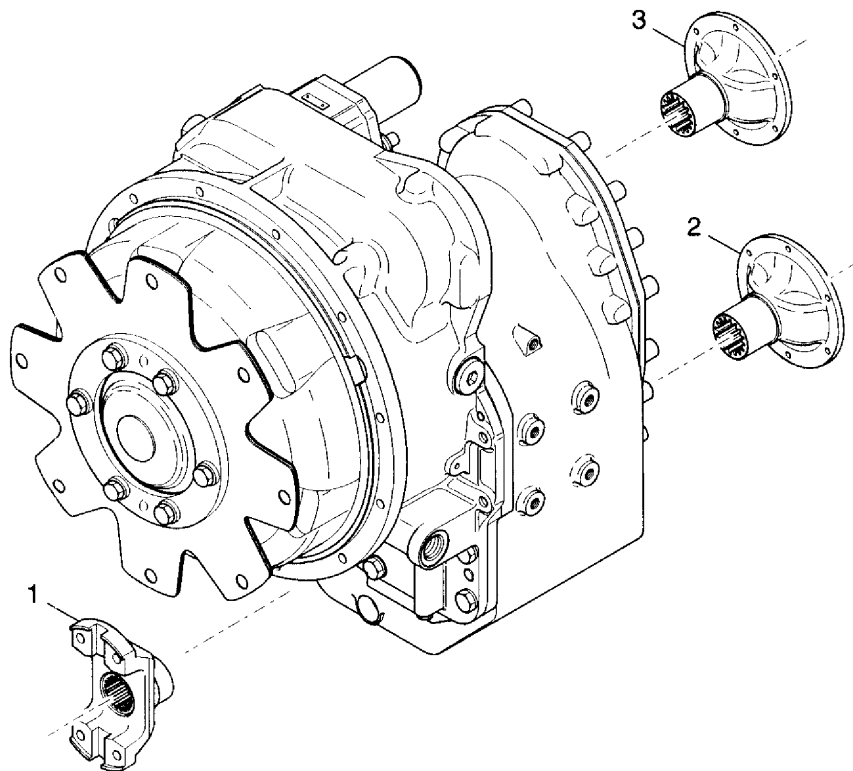
## Service Parts List

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Transmission  
1202FT20311-101  
10078133

TPL-2993  
jul 2017

# T20000 Series

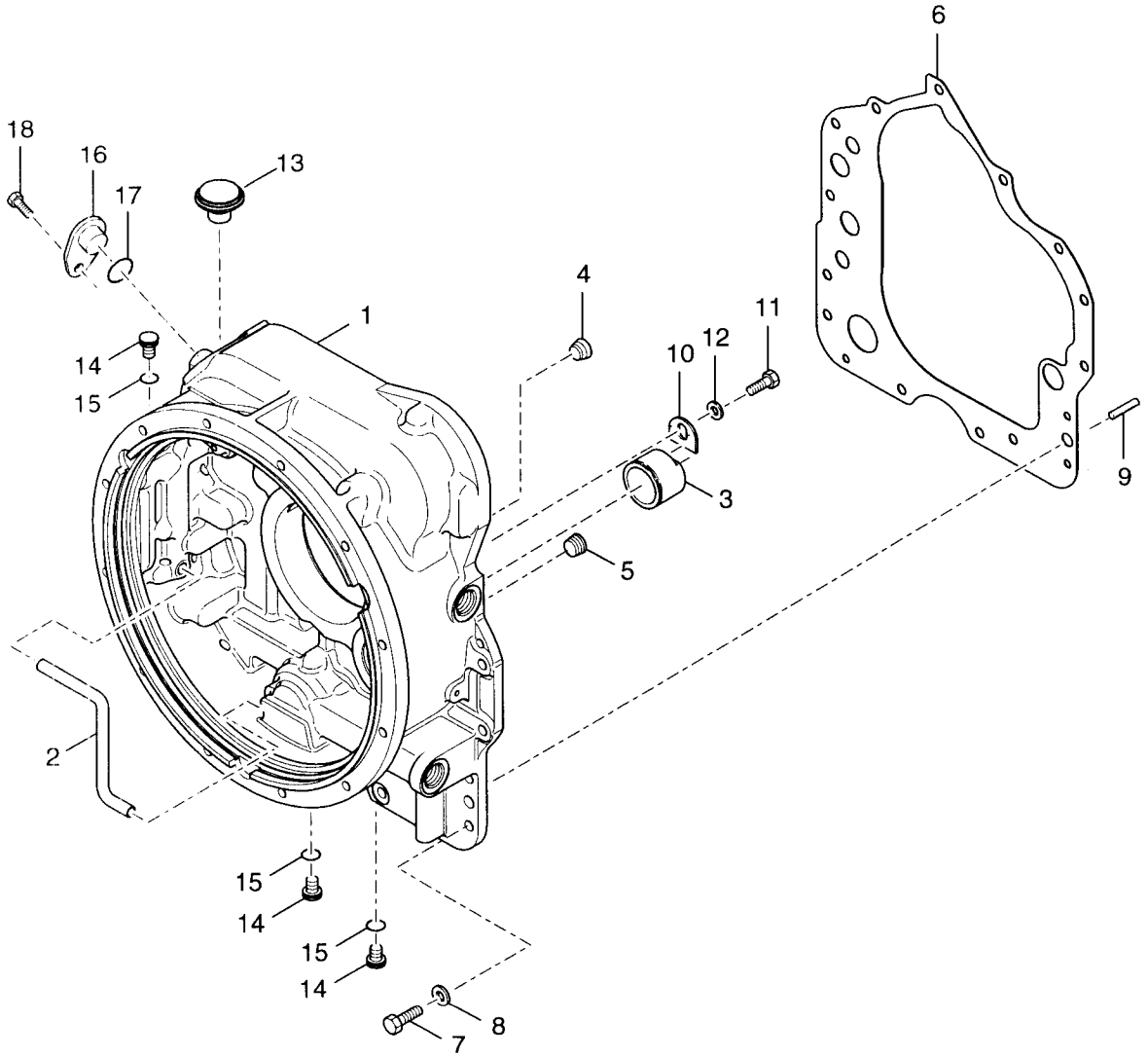


**GRP-T20-03** rev. 040302

T20000  
ASSY-T2000 TRANSMISSION FOR BRP-RICO

Seq	PartNr	Qty	%	Description / Remark
	4205320	1	D	CAB-CONTROL GRIP STANDARD (Not Illustrated)
1				Not Used On This Model
2	215550	1	E	FLANGE-REAR OUTPUT 6C
3				Not Used On This Model

T20000  
GROUP CONVERTER HOUSING

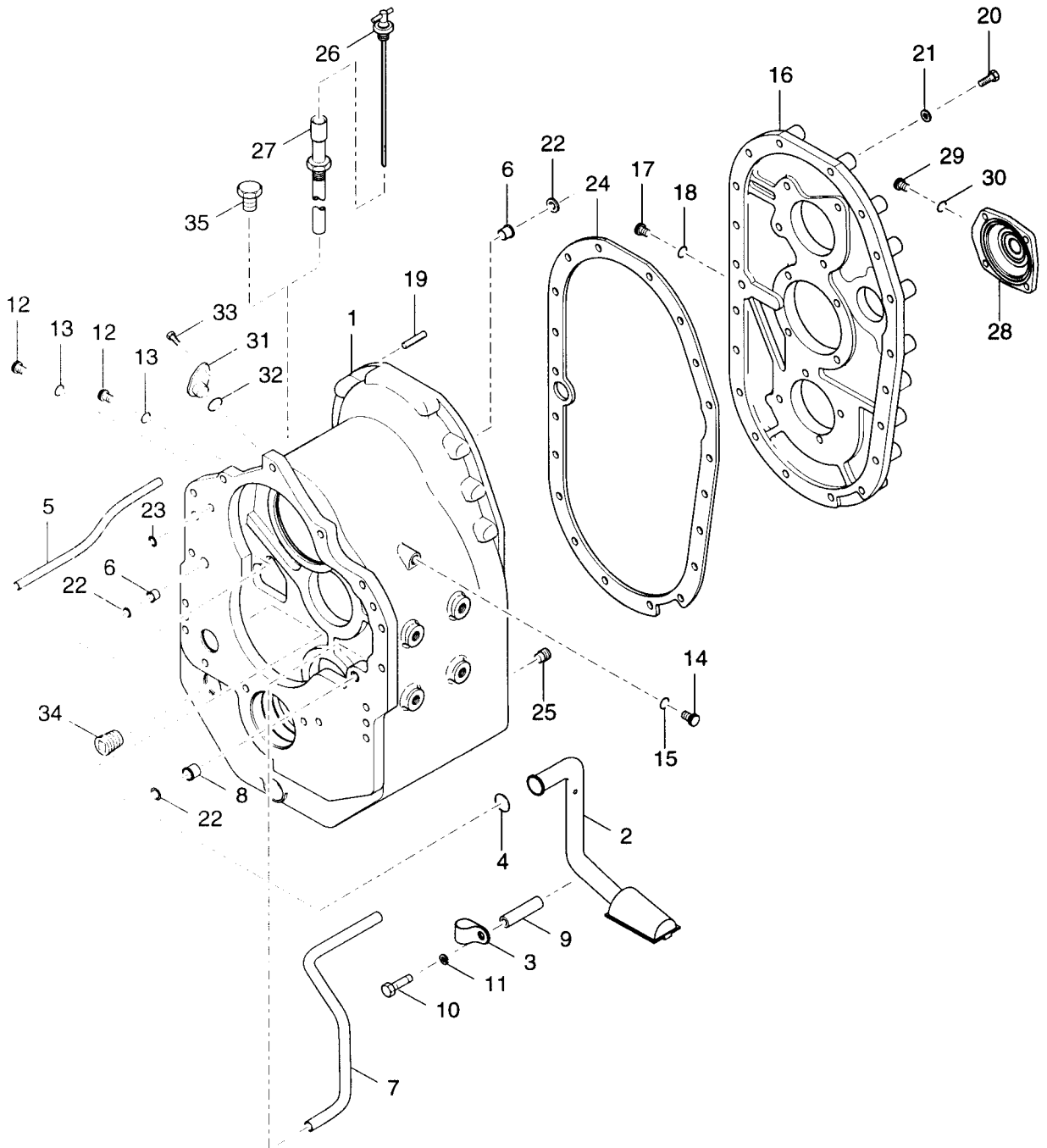


T20000  
GROUP-CONVERTER HOUSING

Seq	PartNr	Qty	%	Description / Remark
1	4205585	1	E	ASSY-CONVERTER HOUSING - INCL. ITEM 2
2	242832	1		TUBE-LUBE - PART OF ITEM 1
3	248612	1	C	SLEEVE-CONVERTER HOUSING
4	16F8	1		PLUG
5	239244	1		PLUG-PIPE
6	4205578	1	B	GASKET-CONV. HSG TO TRANS. CASE
7	17C720	16		SCREW-CONV HSG TO TRANS CASE
8	4E7	16		LOCKWASHER-CONV HSG TO TRANS CASE
9	4203907	1		PIN-CONV HSG TO TRANS CASE DOWEL
10	230851	1		CLIP
11	1C510	1		SCREW-CLIP
12	4E5	1	E	LOCKWASHER-CLIP SCREW
13	238535	1	C	AIR-BREATHER
14	47K5	3		PLUG - INCLUDING ITEM 15
15	91F5	3	B	O RING - PLUG - PART OF ITEM 14
16	4202489	1		PLUG-SPEED SENSOR PORT
17	4203422	1	B	"O" RING-SPEED SENSOR
18	3GM612	1		SCREW-SPEED SENSOR

# T20000

## CASE & REAR COVER GROUP



T20000  
GROUP-TRANSMISSION CASE & COVER

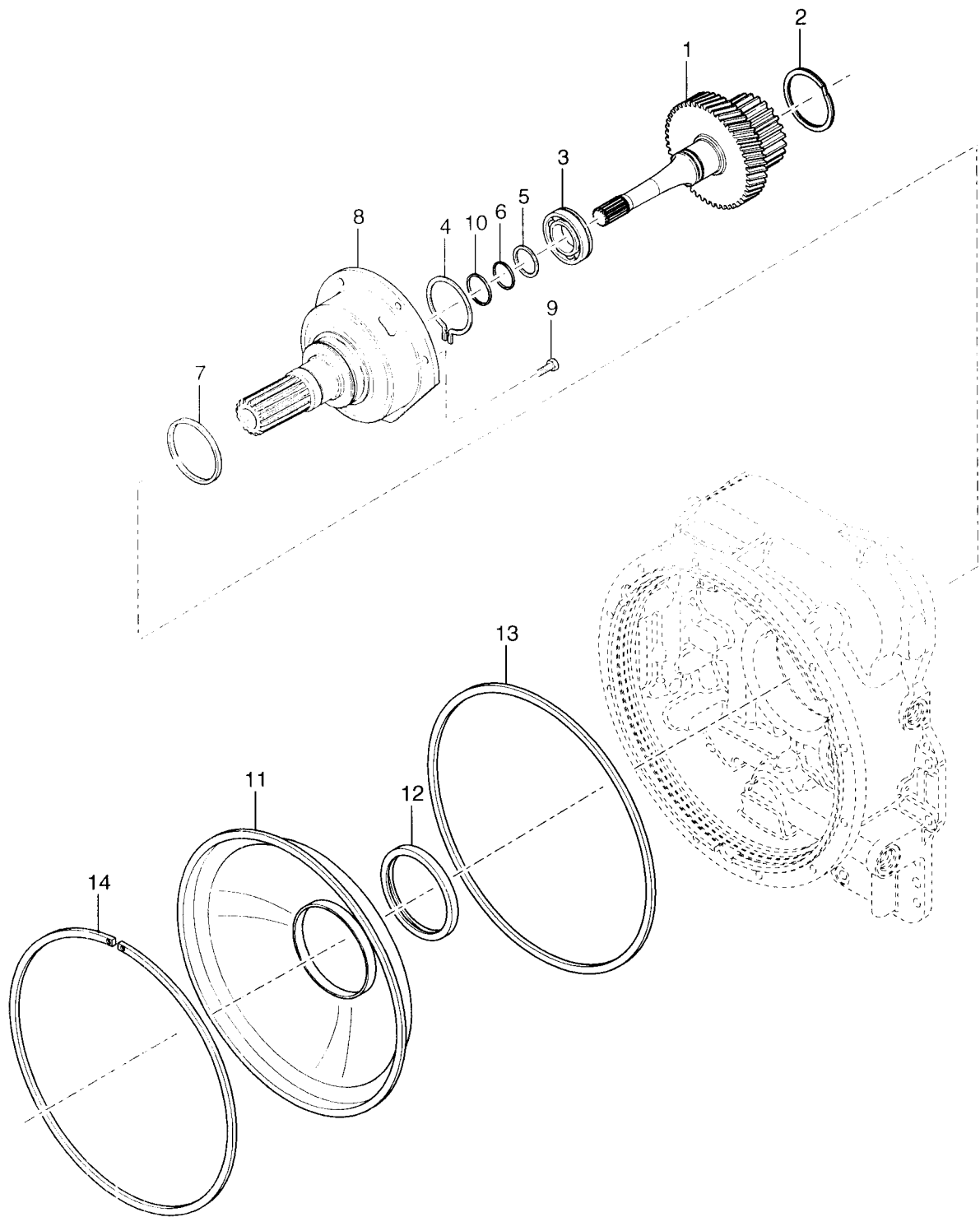
Seq	PartNr	Qty	%	Description / Remark
1	4206290	1	E	ASSY-TRANSMISSION CASE
2	4206289	1		ASSY-SUCTION TUBE
3	6H42	1		CLIP-CLOSED
4	4205097	1	B	O RING-SUCTION TUBE ASSEMBLY
5	234157	1	D	TUBE-LOW CLUTCH
6	222067	2	E	SLEEVE-PRESSURE & LUBRICATION TUBE
7	4205588	1		TUBE-LUBE
8	221871	1		TUBE SLEEVE
9	4206341	1		SPACER-TUBE CLIP
10	1C752	1		SCREW-TUBE CLIP
11	4E7	1		LOCKWASHER-TUBE CLIP SCREW
12	47K5	2		PLUG-FWD & 3RD PORT-INCLUDING ITEM 13
13	91F5	2	B	O RING-PLUG - PART OF ITEM 12
14	47K6	1		PLUG-LUBE PORT - INCLUDING ITEM 15
15	91F6	1	B	O RING-PLUG - PART OF ITEM 14
16	4206293	1	E	ASSY-REAR COVER & PLUG-INCLUDING ITEM 17
17	47K5	1		PLUG-INCLUDING ITEM 18
18	91F5	1	B	O RING-PLUG - PART OF ITEM 17
19	4203907	2		PIN-TRANS CASE TO REAR COVER DOWEL
20	17C728	20		SCREW-REAR COVER TO CASE

T20000  
GROUP-TRANSMISSION CASE & COVER

Seq	PartNr	Qty	%	Description / Remark
21	4E7	20		LOCKWASHER-REAR COVER TO CASE SCREW
22	60K40026	3	B	"O" RING-CLUTCH PRESSURE TUBE
23	60K30018	2	B	"O" RING-CLUTCH PRESSURE
24	4206294	1	B	GASKET-REAR COVER TO TRANSMISSION CASE
25	215757	2		PLUG-MAGNETIC DRAIN
26	244365	1		DIPSTICK
27	244366	1	C	ASSY-DIPSTICK
28	4206296	1	E	ASSY-LOW SHAFT BRG CAP-INCLUDING ITEM 29
29	47K5	1		PLUG-INCLUDING ITEM 30
30	91F5	1	B	O RING-PLUG - PART OF ITEM 29
31	4202489	1		PLUG-SPEED SENSOR PORT
32	4203422	1	B	"O" RING-SPEED SENSOR
33	3GM612	1		SCREW-SPEED SENSOR
34	11F16	1		PLUG-DRAIN BACK HOLE
35				Not Used On This Model



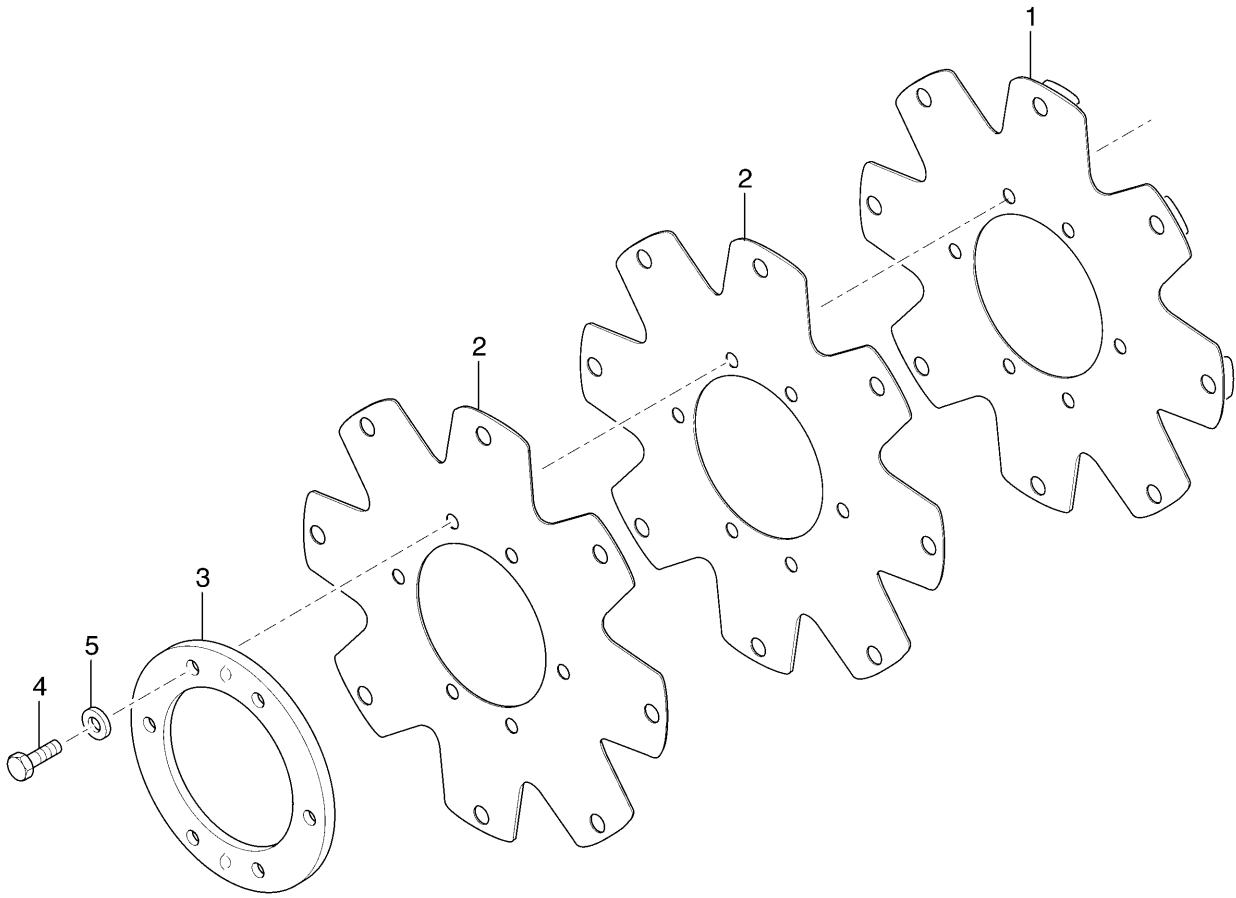
T20000  
GROUP TURBINE SHAFT



T20000  
GROUP-TURBINE SHAFT

Seq	PartNr	Qty	%	Description / Remark
1	4205762	1	D	ASSY-TURBINE SHAFT,HUB & RET.RING-INCL.ITEM 2
2	240617	1	D	RING-RETAINING - PART OF ITEM 1
3	4205105	1	C	BEARING-BALL
4	234229	1	C	SNAP RING-BEARING
5	234230	1	D	WASHER-BEARING SUPPORT
6	231776	1	C	RING-BEARING RETAINING
7	4205235	1	B	RING-PISTON
8	4205236	1	D	SUPPORT-STATOR
9	241308	6		SCREW-STATOR SUPPORT
10	250219	1	B	RING-PISTON
11	242831	1	E	ASSY-OIL BAFFLE & SEAL - INCLUDING ITEM 12
12	4204710	1	B	SEAL-OIL BAFFLE - PART OF ITEM 11
13	241237	1	B	RING-OIL BAFFLE SEAL
14	245787	1	D	RING-OIL BAFFLE RETAINING

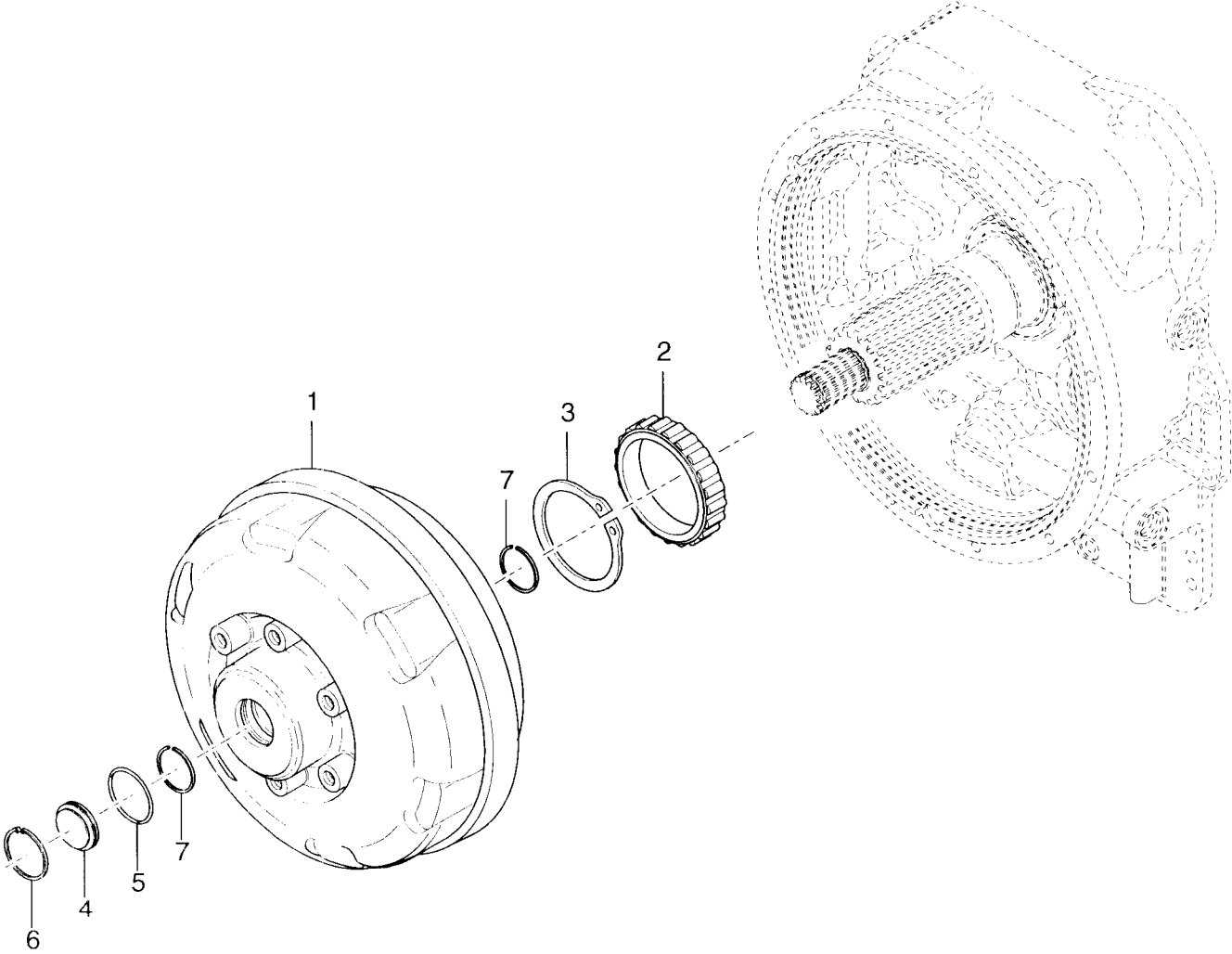
**T20000**  
**DRIVE PLATE GROUP**



T20000  
GROUP-DRIVE PLATE

Seq	PartNr	Qty	%	Description / Remark
	814977	1	E	KIT - DRIVE PLATE - INCL. ITEMS 1 THRU 5 (Not Illustrated)
1		1		ASSY-DRIVE PLATE - INCLUDING IN ITEM 6 (Not Sold Seperately)
2		2		PLATE-DRIVE - INCLUDING IN ITEM 6 (Not Sold Seperately)
3	4205107	1		RING-DRIVE PLATE BACKING
4	1CM1016	6		CAPSCREW
5	6EM100	6	A	LOCKWASHER-DRIVE PLATE MTG

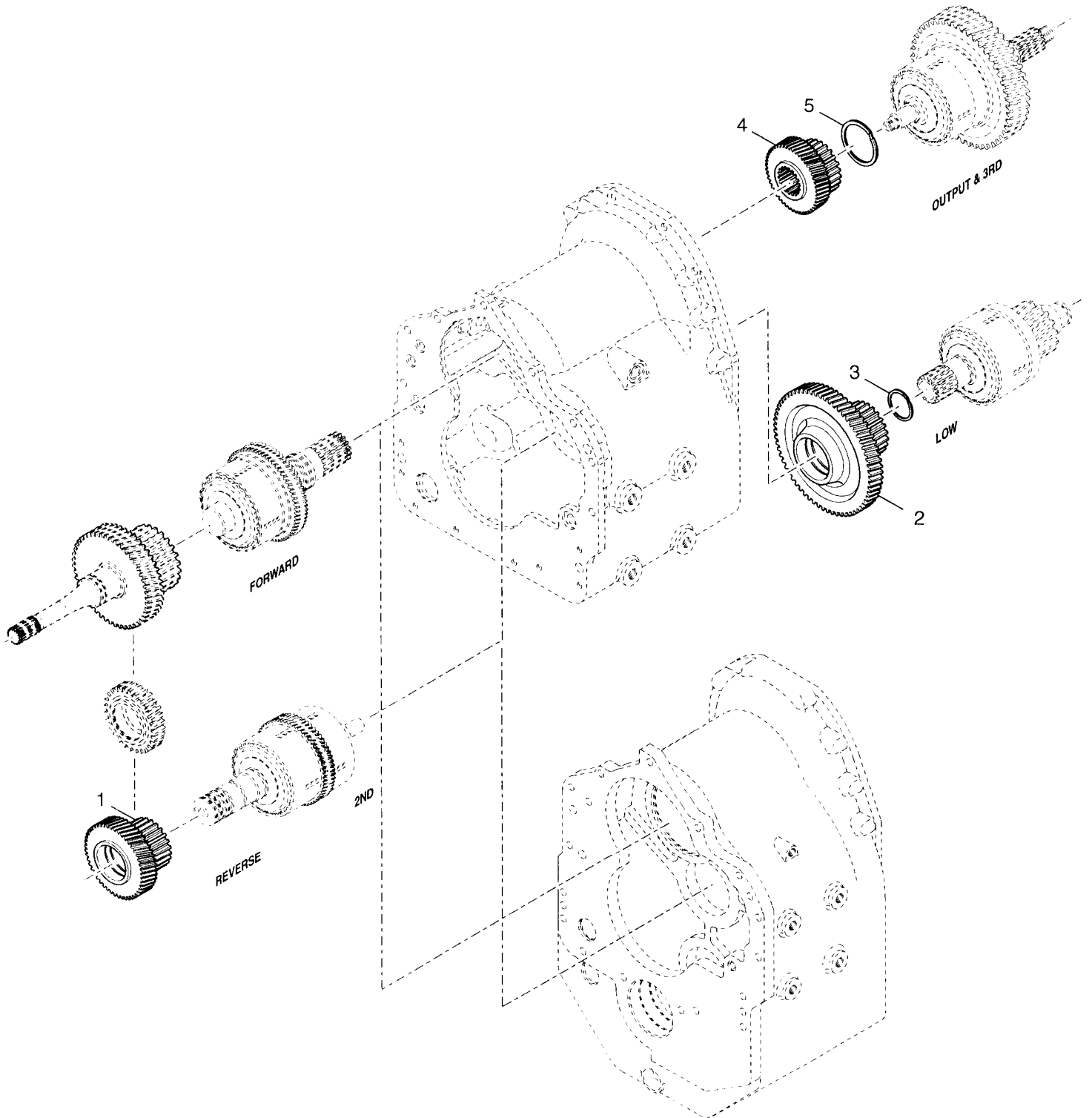
T20000  
GROUP TORQUE CONVERTER



T20000  
GROUP-TORQUE CONVERTER ASSY 1202F

<b>Seq</b>	<b>PartNr</b>	<b>Qty</b>	<b>%</b>	<b>Description / Remark</b>
1	4205109	1	E	ASSY-TORQUE CONVERTER 1202F
2	238391	1	D	BEARING-IMPELLER HUB GEAR
3	5JM45	1	C	RING-EXTERNAL SNAP
4	223015	1	C	PLUG-TORQUE CONVERTER
5	60K30114	1	B	"O" RING-TORQUE CONVERTER PLUG
6	246354	1	C	RING-SNAP
7	4205114	2	C	RING-TURBINE RETAINING

# T20000 GEAR GROUP

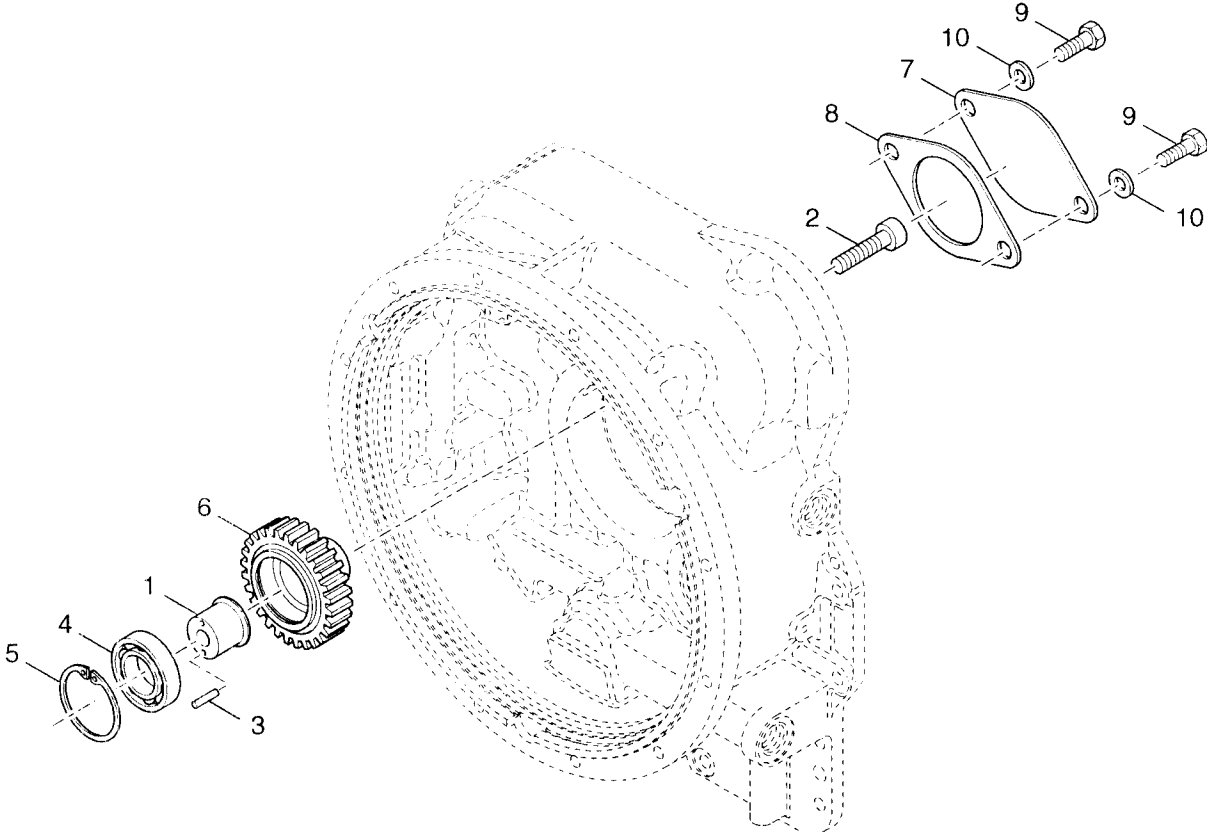


T20000  
GROUP-GEAR

<b>Seq</b>	<b>PartNr</b>	<b>Qty</b>	<b>%</b>	<b>Description / Remark</b>
1	4205115	1	D	GEAR-REVERSE CLUTCH 43T
2	4208019	1	D	GEAR-LOW CLUTCH
3				Not Used On This Model
4	4218749	1		ASSY-3RD GEAR CLUTCH HUB 33T
5				Not Used On This Model



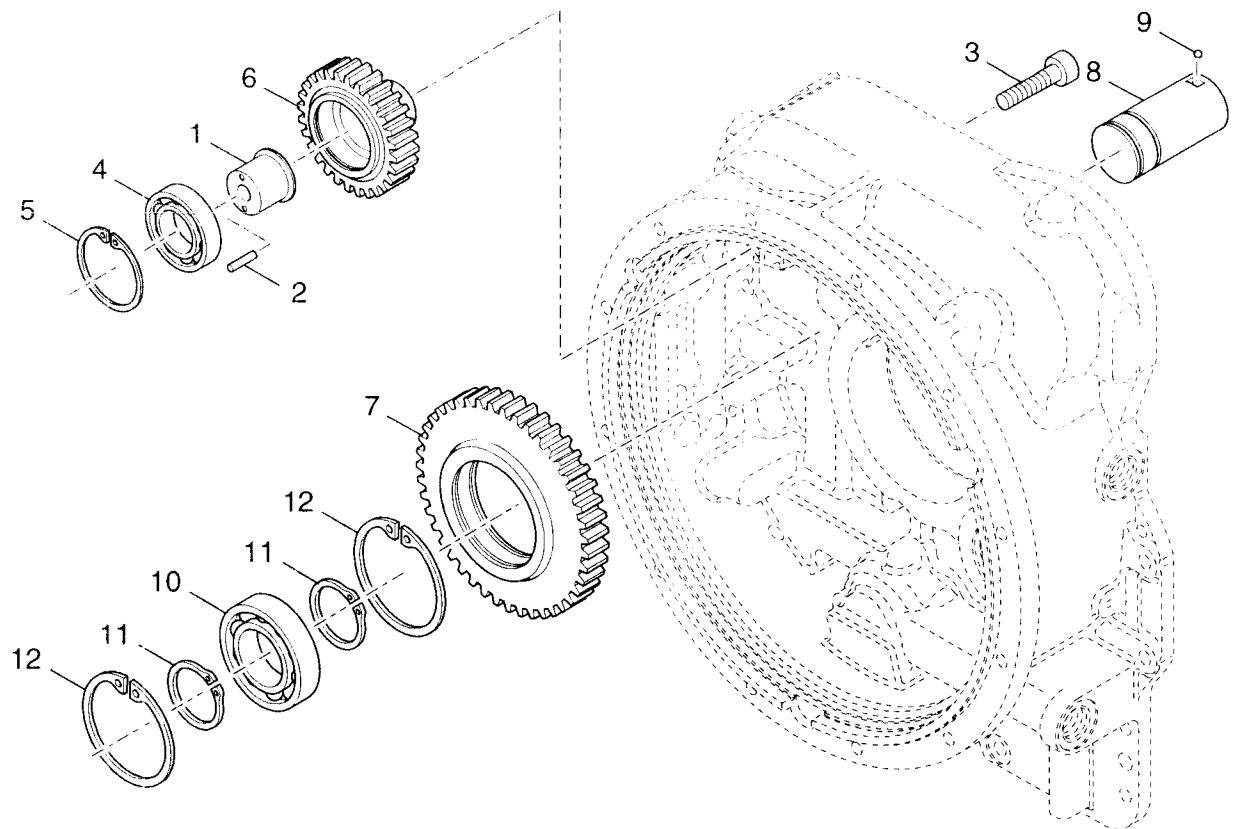
T20000  
GROUP AUXILIARY PUMP DRIVE



T20000  
GROUP-PUMP DRIVE SAE B AUXILIARY

Seq	PartNr	Qty	%	Description / Remark
1	4205121	1	D	SUPPORT-PUMP DRIVE BEARING
2	73G828	1		SCREW-BEARING SUPPORT
3	4205122	1	C	PIN-BEARING SUPPORT
4	238222	1	C	BEARING-BALL
5	223878	1	C	RING-DRIVE GEAR BEARING RETAINING
6	4205123	1	D	GEAR-AUX PUMP DRIVE 37T
7	3614642	1	E	COVER-PUMP MOUNTING PERMANENT
8	4205272	1	B	GASKET-PUMP MOUNTING
9	1C816	2		SCREW-PUMP MOUNTING PERMANENT COVER
10	4E8	2		LOCKWASHER-PUMP COVER SCREW

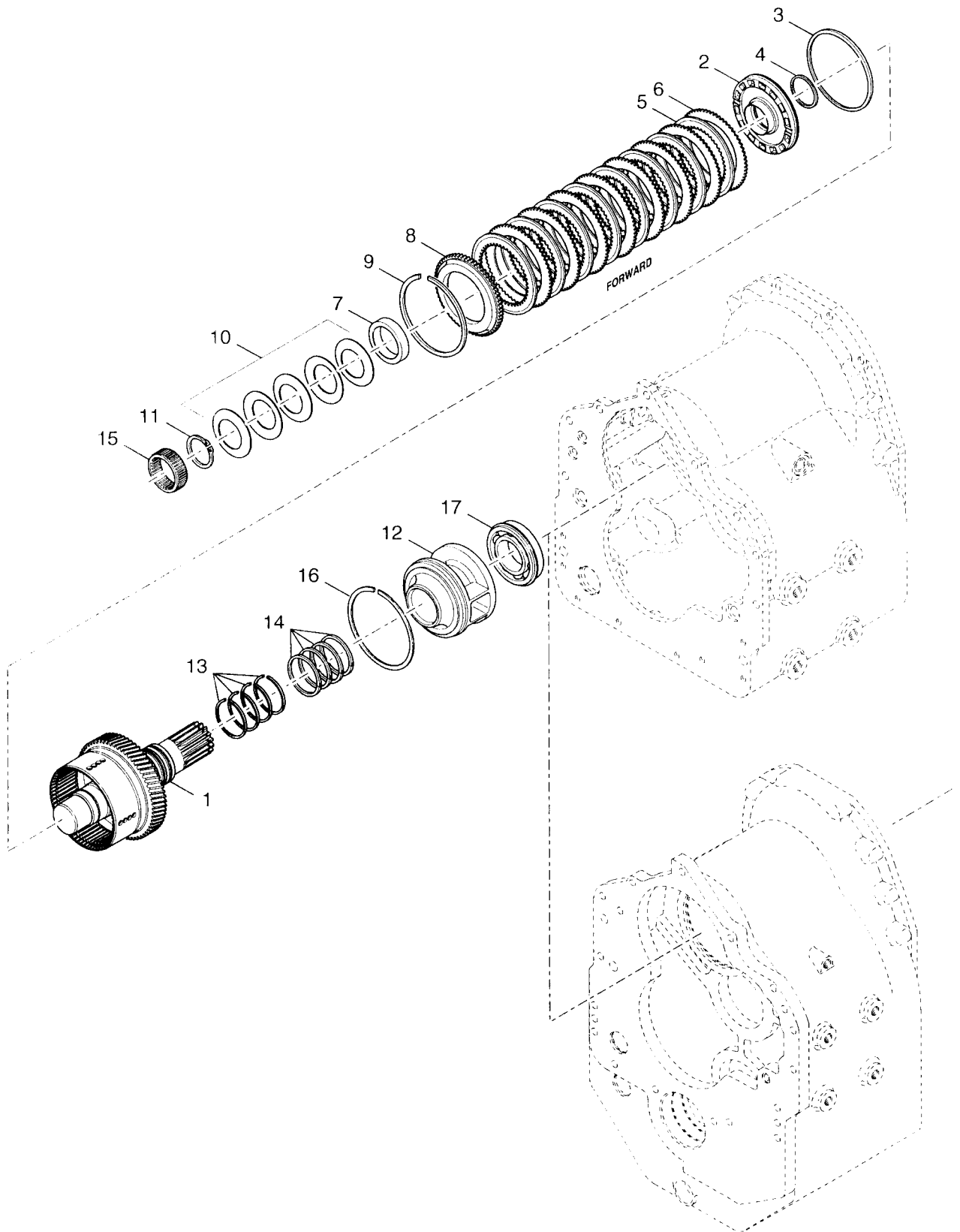
# T20000 GROUP PUMP DRIVE



T20000  
GROUP-PUMP DRIVE CHARGING

Seq	PartNr	Qty	%	Description / Remark
1	4205121	1	D	SUPPORT-PUMP DRIVE BEARING
2	4205122	1	C	PIN-BEARING SUPPORT
3	73G828	1		SCREW-BEARING SUPPORT
4	238222	1	C	BEARING-BALL PUMP DRIVE
5	223878	1	C	RING-DRIVE GEAR BEARING RETAINING
6	4205124	1	D	GEAR-CHARGING PUMP DRIVE -37T-
7	4205125	1	D	GEAR-PUMP DRIVE IDLER -55T-
8	238215	1	D	SHAFT-IDLER GEAR STUB
9	10J8	1	B	BALL-IDLER SHAFT LOCK
10	238223	1	C	BEARING-BALL PUMP IDLER
11	234908	2	C	RING-IDLER GEAR BEARING LOCATING
12	223964	2	C	RING-IDLER GEAR BEARING RET.

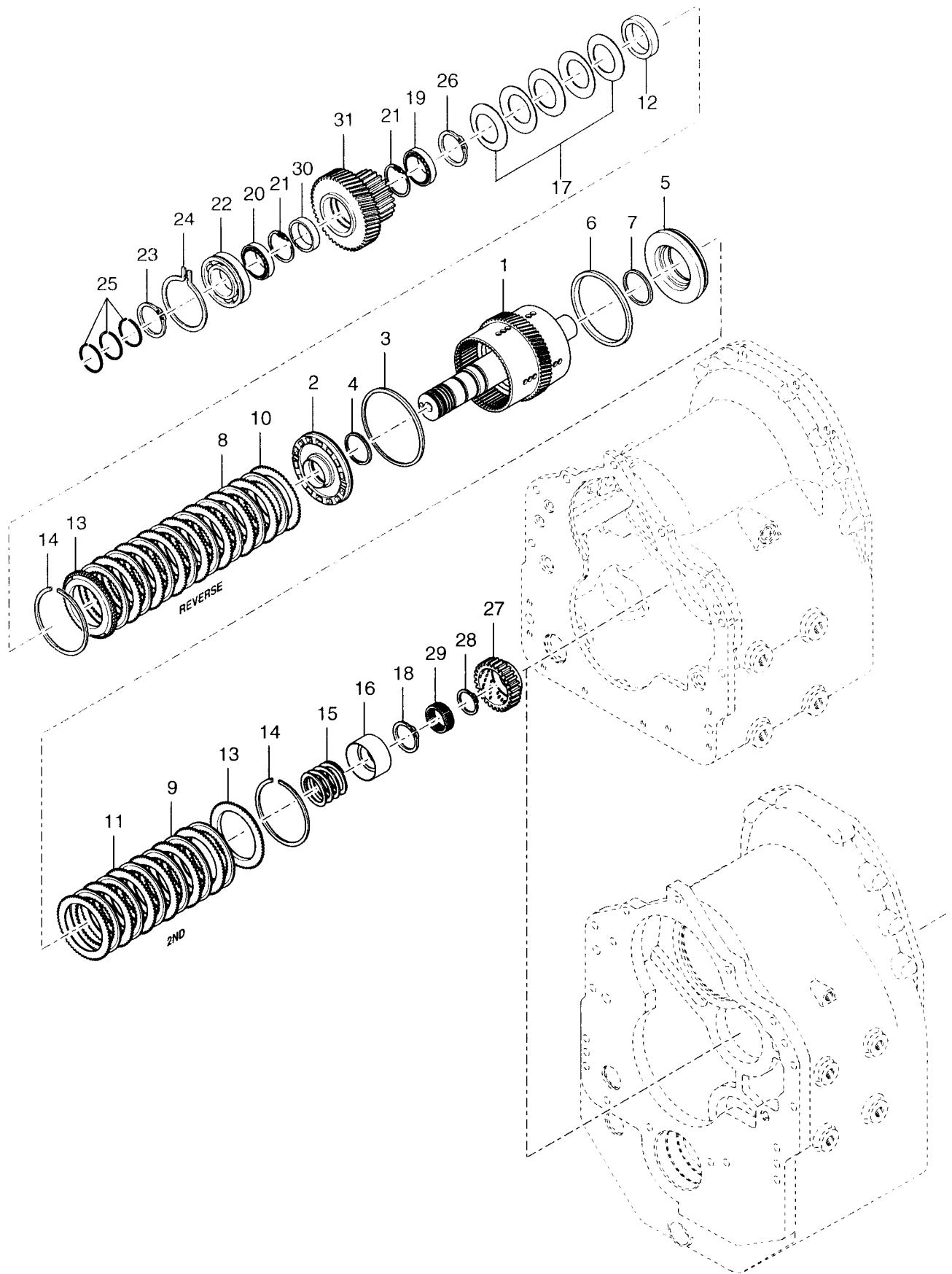
# T20000 GROUP FORWARD SHAFT



T20000  
GROUP-FORWARD SHAFT

Seq	PartNr	Qty	%	Description / Remark
1	4209370	1	E	ASSY-FWD SHAFT, DRUM & PLUG
2	4207202	1	D	ASSY-CLUTCH PISTON AND SEALS-INCL.ITEMS 3 & 4
3	237032	1	B	SEAL-CLUTCH PISTON - OUTER - PART OF ITEM 2
4	234113	1	B	SEAL-CLUTCH PISTON - INNER - PART OF ITEM 2
5	237016	8	C	DISC-CLUTCH INNER
6	234109	8	C	DISC-CLUTCH OUTER
7	237442	1		SPACER
8	4204253	1	C	END PLATE
9	234111	1	C	SNAP RING
10	247656	1	D	ASSY-DISC SPRING - INCL. 5 WASHERS
11	237669	1	D	RETAINING RING
12	241037	1	B	PISTON RING SLEEVE
13				Not Used On This Model
14	4207676	4	B	RING-PISTON
15	235763	1	C	FORWARD SHAFT FRONT BEARING
16	235764	1	D	INTERNAL SNAP RING
17	241819	1	D	FORWARD SHAFT REAR BEARING

# T20000 GROUP REVERSE AND 2ND SHAFT



T20000  
GROUP-REVERSE 2ND SHAFT

Seq	PartNr	Qty	%	Description / Remark
1	4209371	1	E	ASSY-REV. & 2ND SHAFT, DRUM & PLUG
2	4207202	1	D	ASSY-CLUTCH PISTON AND SEALS-INCL.ITEMS 3 & 4
3	237032	1	B	SEAL-CLUTCH PISTON - OUTER - PART OF ITEM 2
4	234113	1	B	SEAL-CLUTCH PISTON - INNER - PART OF ITEM 2
5	4207175	1	B	ASSY-CLUTCH PISTON AND SEALS-INCL.ITEMS 6 & 7
6	237032	1	B	SEAL-CLUTCH PISTON - OUTER - PART OF ITEM 5
7	234113	1	B	SEAL-CLUTCH PISTON - INNER - PART OF ITEM 5
8	237016	8	C	DISC-CLUTCH INNER REV
9	237016	6	C	DISC-CLUTCH INNER 2ND
10	234109	8	C	DISC-CLUTCH OUTER REV
11	234109	6	C	DISC-CLUTCH OUTER 2ND
12	237442	1		SPACER-PISTON RETURN SPRING REV CLUTCH
13	4204253	2	C	END PLATE
14	234111	2	C	SNAP RING-BACKING PLATE
15	235960	1	D	SPRING-PISTON RETURN 2ND CLUTCH
16	235959	1	E	RETAINER-SPRING 2ND CLUTCH
17	247656	1	D	ASSY-DISC SPRING - INCLUDING 5 WASHERS
18	234350	1	D	SNAP RING-SPRING RETAINING 2ND CLUTCH
19	230829	1	C	BEARING-CLUTCH DRIVEN GEAR
20	233389	1	C	BEARING-CLUTCH DRIVEN GEAR

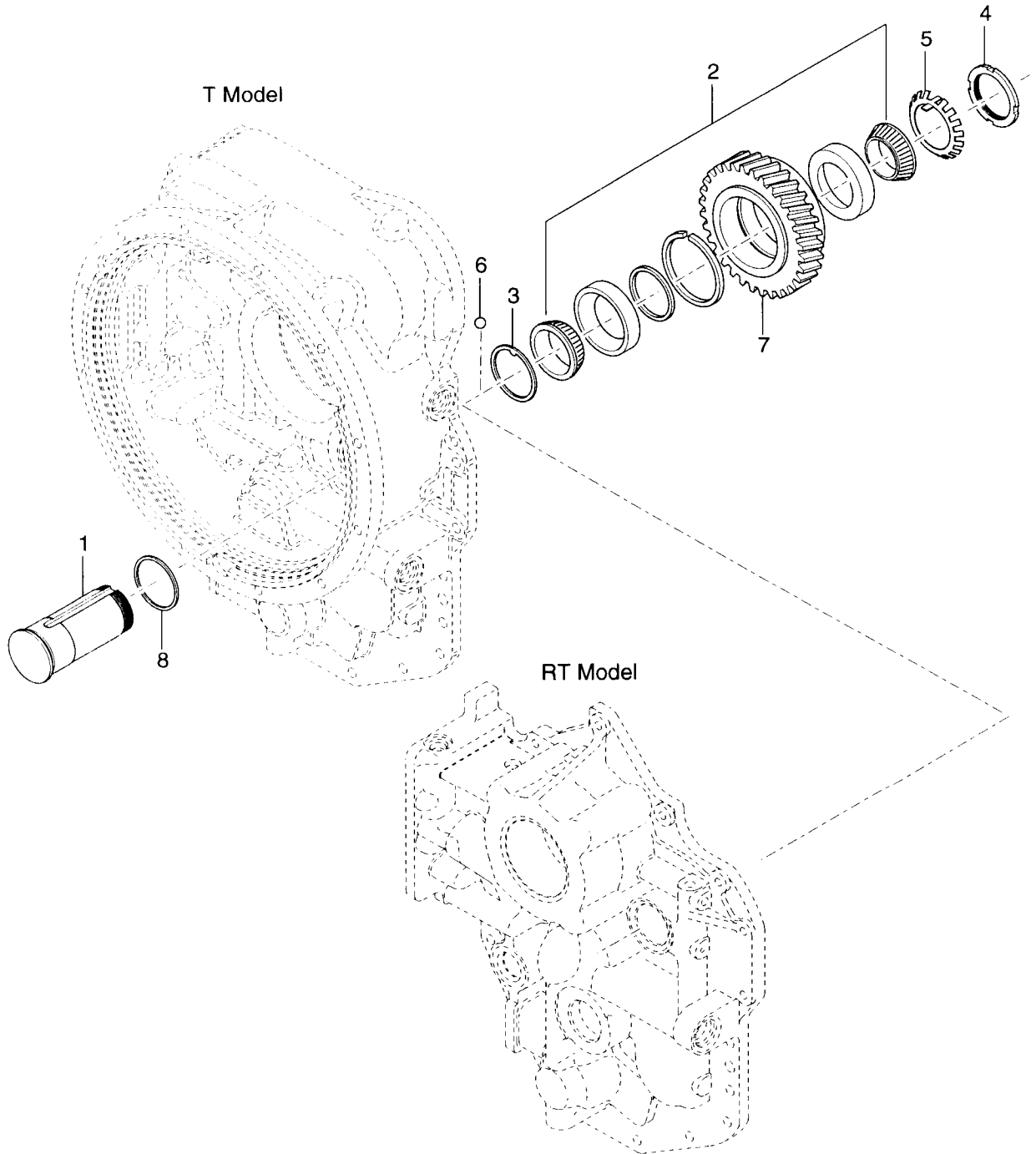


T20000  
GROUP-REVERSE 2ND SHAFT

<b>Seq</b>	<b>PartNr</b>	<b>Qty</b>	<b>%</b>	<b>Description / Remark</b>
21	234141	2	D	RING-CLUTCH GEAR BRG RETAINING
22	241606	1	C	BALL-BEARING
23	247949	1	D	RING-FRONT BEARING RETAINING
24	230889	1	D	SNAP RING-FRONT BEARING
25	4208098	3	B	PISTON-RING
26	237669	1	D	SNAP RING-SPRING RETAINING REV CLUTCH
27	4203199	1	E	HUB-2ND CLUTCH
28	234347	1	D	RING-2ND CLUTCH DISC HUB RETAINING
29	233065	1	C	BEARING-REV. & 2ND SHAFT REAR
30	4205141	1		SPACER-CLUTCH DRIVEN GEAR BEARING
31				GEAR-REVERSE CLUTCH - SEE GEAR GROUP

# T20000

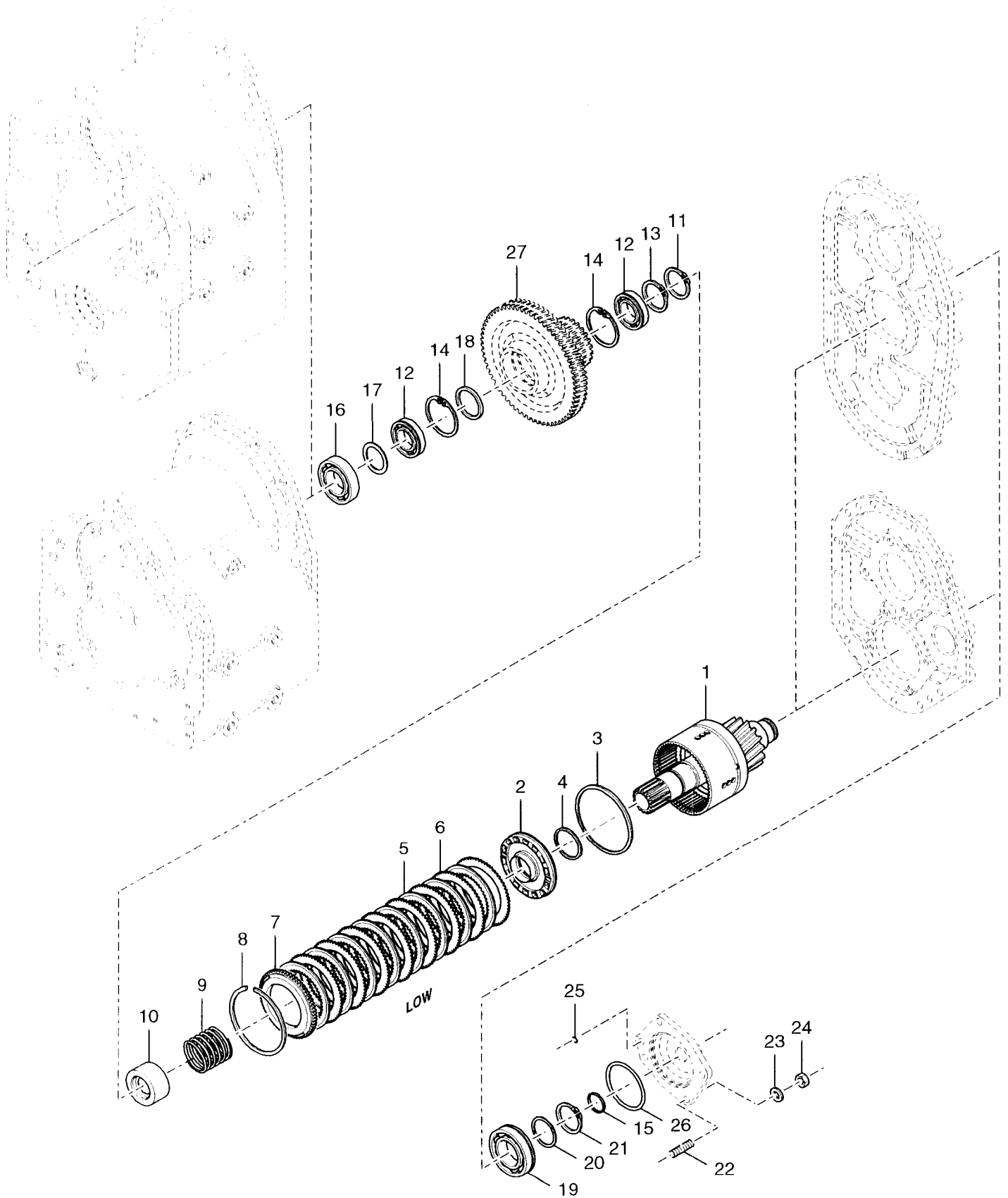
## REVERSE IDLER GROUP



T20000  
GROUP-REVERSE IDLER

Seq	PartNr	Qty	%	Description / Remark
1	4205237	1	D	SHAFT-REVERSE IDLER
2	247664	1	C	ASSY-REVERSE IDLER GEAR BEARING
3	4205134	1		WASHER
4	24H9	1		NUT-BEARING RETAINING
5	4221376	1	C	LOCKWASHER FOR BEARING LOCKNUT
6	10J10	1		LOCKBALL-IDLER SHAFT
7	4205179	1	D	GEAR-REVERSE IDLER 32T
8	76K223	1	B	"O" RING-IDLER SHAFT

# T20000 GROUP LOW SPEED SHAFT



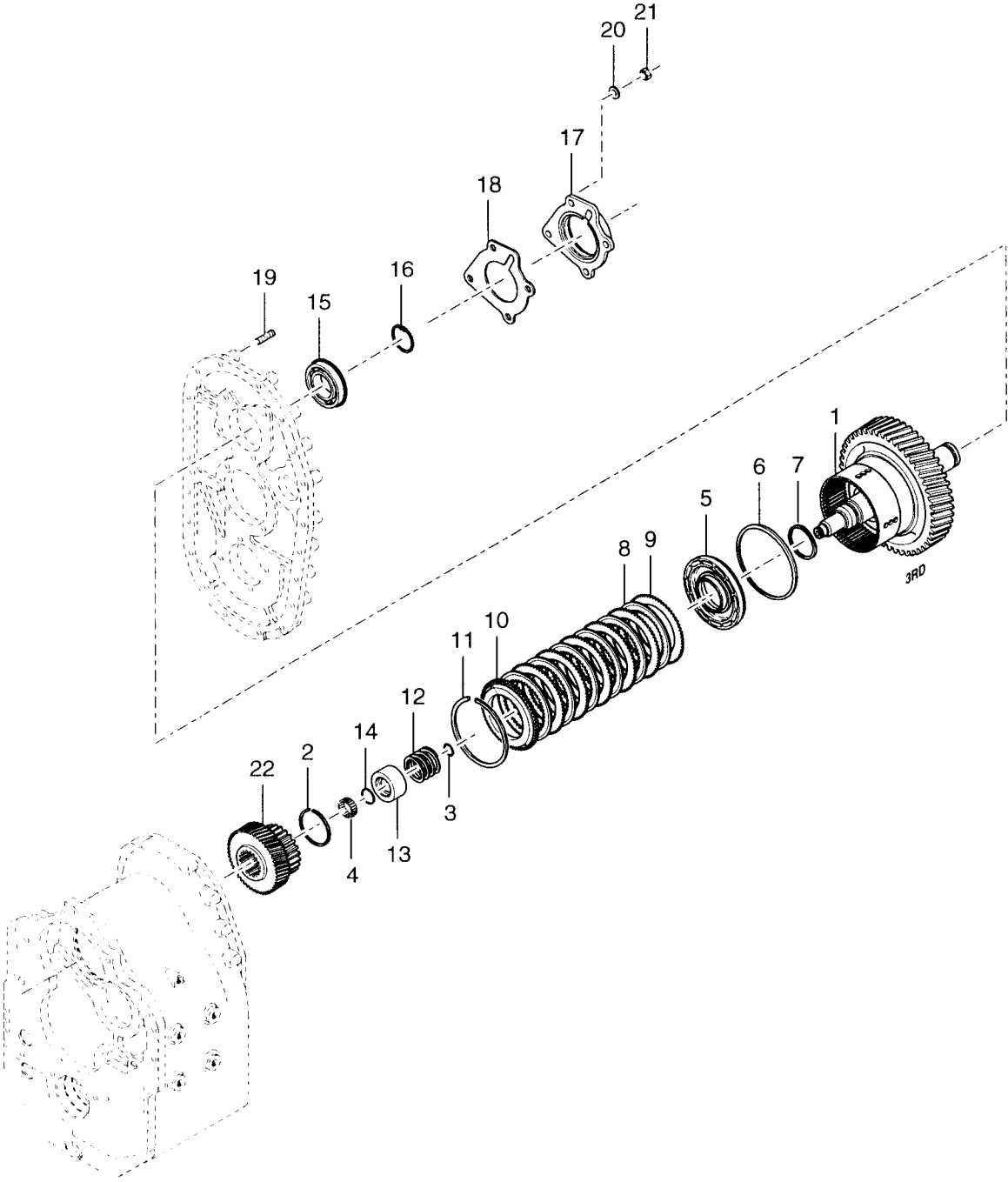
T20000  
GROUP-LOW SPEED SHAFT

Seq	PartNr	Qty	%	Description / Remark
1	237211	1	E	ASSY-LOW CLUTCH SHAFT DRUM & BLEED VALVE
2	4204050	1	D	ASSY-CLUTCH PISTON AND SEALS-INCL.ITEMS 3 & 4
3	237032	1	B	SEAL-CLUTCH PISTON - OUTER - PART OF ITEM 2
4	234113	1	B	SEAL-CLUTCH PISTON - INNER - PART OF ITEM 2
5	234336	8	C	DISC-CLUTCH INNER
6	234109	8	C	DISC-CLUTCH OUTER
7	4204253	1	C	END PLATE
8	234111	1	C	RING-BACKING PLATE RETAINER
9	235960	1	D	SPRING-PISTON RETURN
10	235959	1	E	RETAINER-SPRING
11	234350	1	D	SNAP RING-SPRING RETAINER
12	230885	2	C	BEARING-LOW SPEED GEAR
13	234347	1	D	RING-LOW GEAR BRG RETAINING
14	223964	2	C	RING-LOW SPEED GEAR BRG LOCATING
15	234130	1	B	RING-LOW SHAFT PISTON
16	4213026	1	C	BEARING-BALL
17	234145	1	D	SPACER-LOW SPEED SHAFT FRONT BRG
18	234305	1		SPACER-LOW SPEED GEAR
19	225842	1	C	BEARING
20	234230	1	D	WASHER-REAR BEARING SUPPORT

T20000  
GROUP-LOW SPEED SHAFT

<b>Seq</b>	<b>PartNr</b>	<b>Qty</b>	<b>%</b>	<b>Description / Remark</b>
21	234347	1	D	RING-REAR BEARING RETAINER
22	247988	4		STUD-BEARING CAP
23	4E7	4		LOCKWASHER-BEARING CAP STUD
24	62D7	4		NUT-BEARING CAP STUD
25	60K30012	1	B	"O" RING-REAR BEARING CAP
26	60K40420	1	B	"O" RING-REAR BEARING CAP
27				GEAR - LOW CLUTCH - SEE GEAR GROUP

**T20000  
GROUP 3RD SHAFT**



T20000  
GROUP-3RD SHAFT CLUTCH

Seq	PartNr	Qty	%	Description / Remark
1	244741	1	E	ASSY-3RD CLUTCH SHAFT, DRUM & HUB
2	238034	1	D	RING-3RD CLUTCH GEAR & HUB RETAINING
3	234130	1	B	RING-3RD SHAFT PISTON
4	234132	1	D	BEARING-3RD SHAFT PILO
5	4207175	1	B	ASSY-CLUTCH PISTON AND SEALS-INCL ITEMS 6 & 7
6	237032	1	B	SEAL-CLUTCH PISTON - OUTER - PART OF ITEM 5
7	234113	1	B	SEAL-CLUTCH PISTON - INNER - PART OF ITEM 5
8	237016	6	C	DISC-CLUTCH INNER
9	234109	6	C	DISC-CLUTCH OUTER
10	4204253	1	C	END PLATE
11	234111	1	C	SNAP RING
12	235960	1	D	SPRING-PISTON RETURN
13	235959	1	E	RETAINER-SPRING
14	234350	1	D	RING-SPRING RETAINER SNAP
15	4213025	1	C	BEARING-BALL
16	247949	1	D	RING-3RD SHAFT REAR BEARING RETAINING
17	240300	1	E	CAP-3RD SHAFT REAR BEARING
18	240299	1	B	GASKET-3RD SHAFT BEARING CAP
19	231728	4		STUD-REAR BEARING CAP
20	4E6	4		LOCKWASHER-REAR BEARING CAP STUD

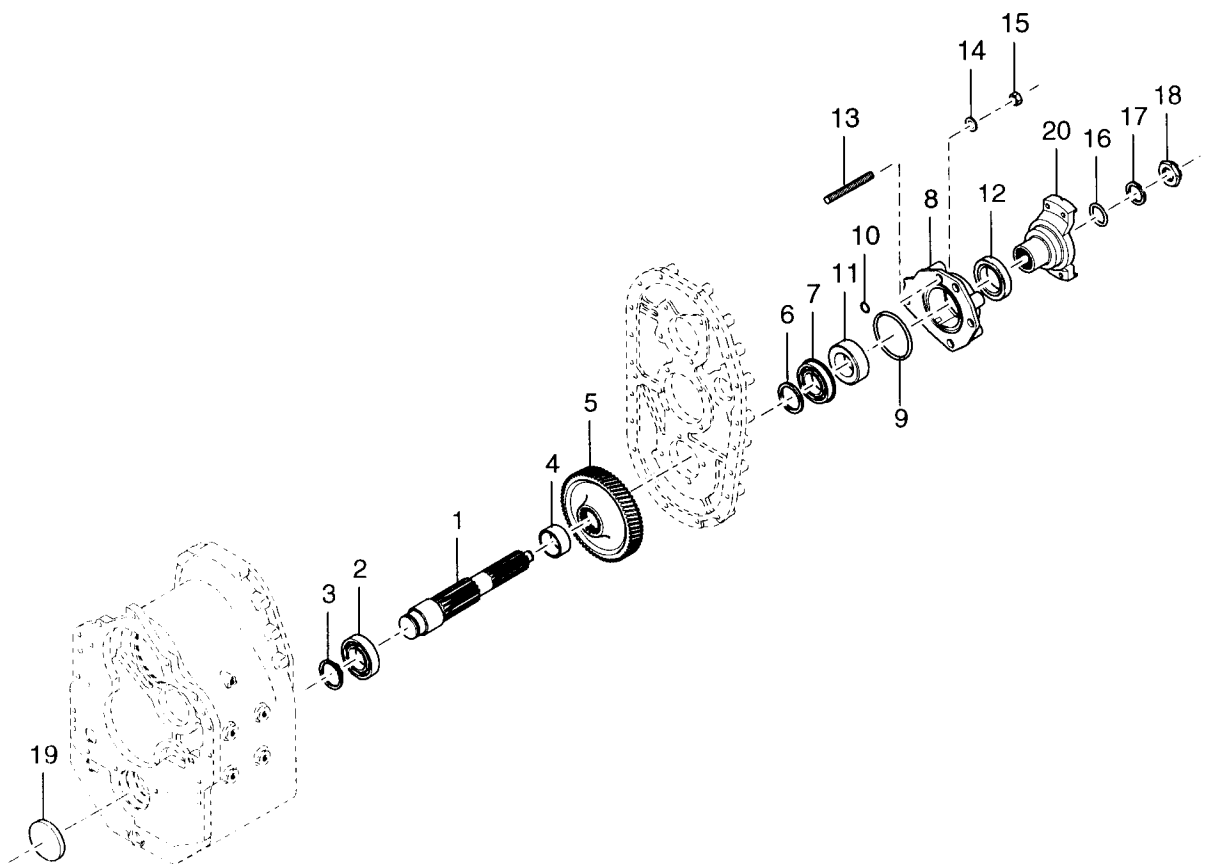


Date : 20-jul-17  
Revision : F  
PartNr : 265984

T20000  
GROUP-3RD SHAFT CLUTCH

<b>Seq</b>	<b>PartNr</b>	<b>Qty</b>	<b>%</b>	<b>Description / Remark</b>
21	62D6	4		NUT-REAR BEARING CAP STUD
22				GEAR-3RD CLUTCH - SEE GEAR GROUP

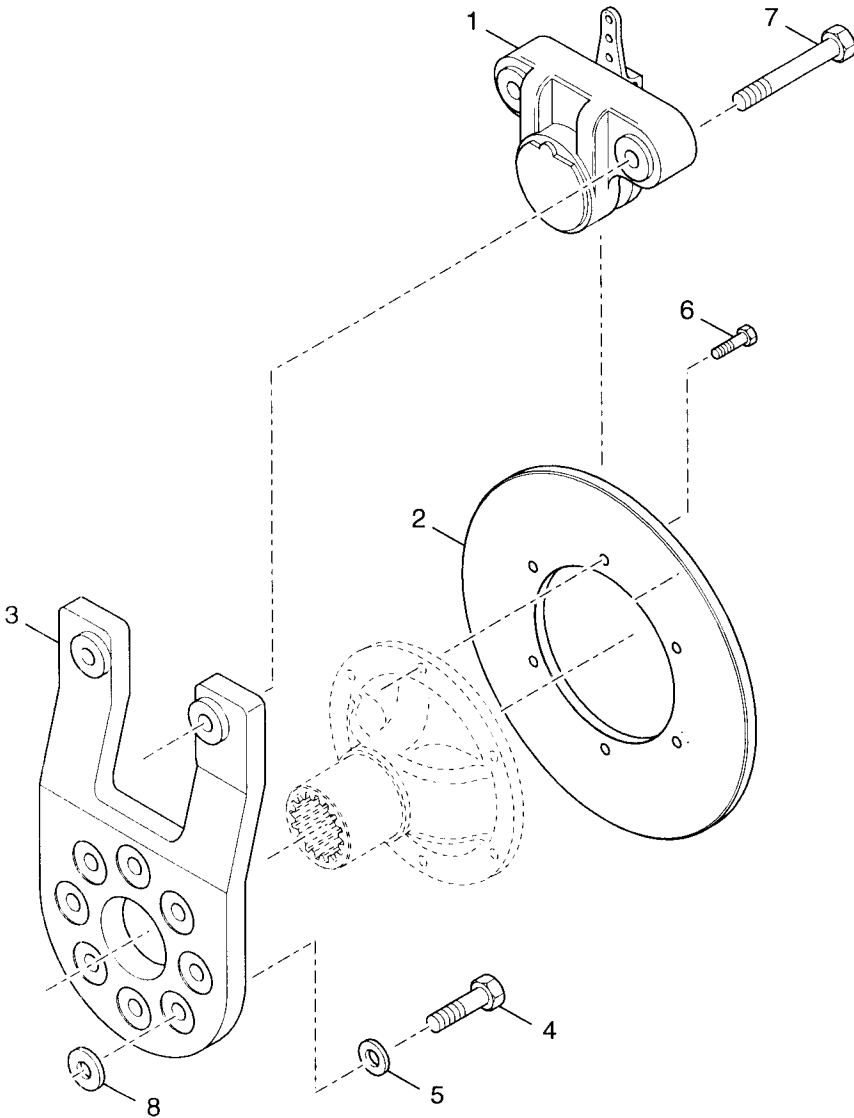
# T20000 GROUP OUTPUT SHAFT



T20000  
GROUP-OUTPUT SHAFT

Seq	PartNr	Qty	%	Description / Remark
1	244377	1	E	SHAFT-OUTPUT
2	4213026	1	C	BEARING-BALL
3	231776	1	C	RING-BEARING RETAINING
4	235910	1	D	SPACER-SHAFT TO GEAR
5	244742	1	E	GEAR-OUTPUT SHAFT 48T
6	237841	1		WASHER-THRUST
7	4213025	1	C	BEARING-BALL
8	236283	1	E	CAP-OUTPUT SHAFT REAR BEARING
9	60K40328	1	B	"O" RING-BEARING CAP
10	60K30022	1	B	"O" RING-BEARING CAP
11	234927	1		SPACER-BRG TO FLANGE
12	235751	1	B	SEAL-REAR BEARING CAP OIL NAT'L - 412016
13	238903	4		STUD-REAR BEARING CAP
14	4E9	4		LOCKWASHER-REAR BEARING CAP STUD
15	62D9	4		NUT-REAR BEARING CAP STUD
16	60K40112	1	B	"O" RING-FLANGE
17	102745	1		WASHER-FLANGE
18	216058	1	C	NUT-FLANGE
19	230862	1		PLUG-FRONT BORE
20				FLANGE - REAR - SEE FRONT PAGE

**T20000  
GROUP DISC BRAKE**



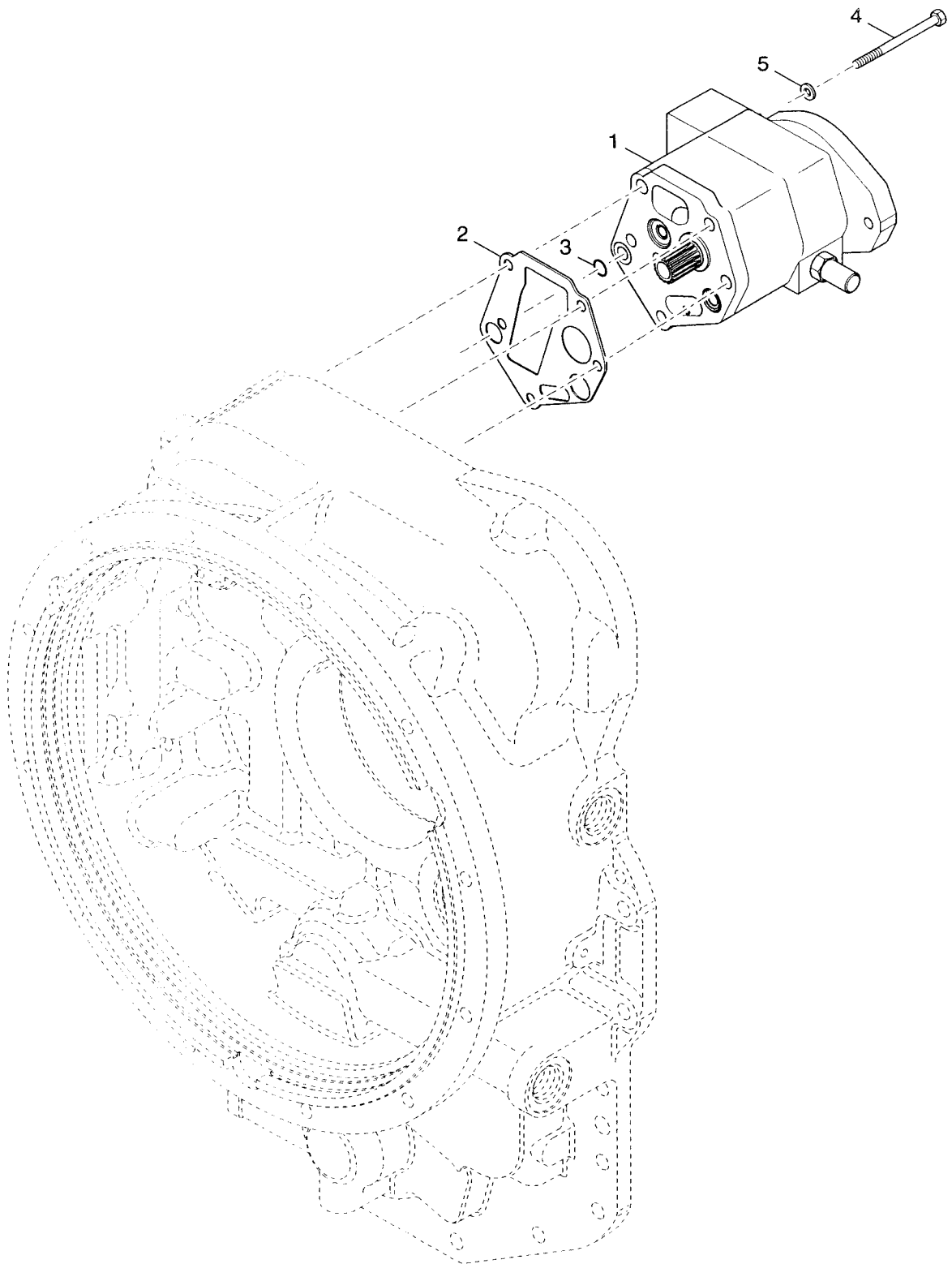
T20000

GROUP-CALIPER DISC BRAKE ( POS 3 OCLOCK, CCW ACTUATION )

Seq	PartNr	Qty	%	Description / Remark
1	4206917	1	E	CALIPER-PARKING BRAKE ( CCW ACTUATION VIEWED FROM REAR ) IF PARTS HAVE TO BE REPLACED ORDER COMPLETE BRAKE
2	244770	1	E	DISC-BRAKE
3	4204496	1		ASSEMBLY-MOUNTING BRACKET
4	17C924H	4		SCREW-BRACKET ASSY TO BRG CAP MTG
5	27E9H	4		WASHER-BRAK ASSY TO BRG CAP MTG FLAT SCREW
6	18C616H	6	D	SCREW-FLANGE
7	17C1044H	2		SCREW-CALIPER TO MOUNTING BRACKET
8				Not Used On This Model

# T20000

## CHARGING PUMP GROUP

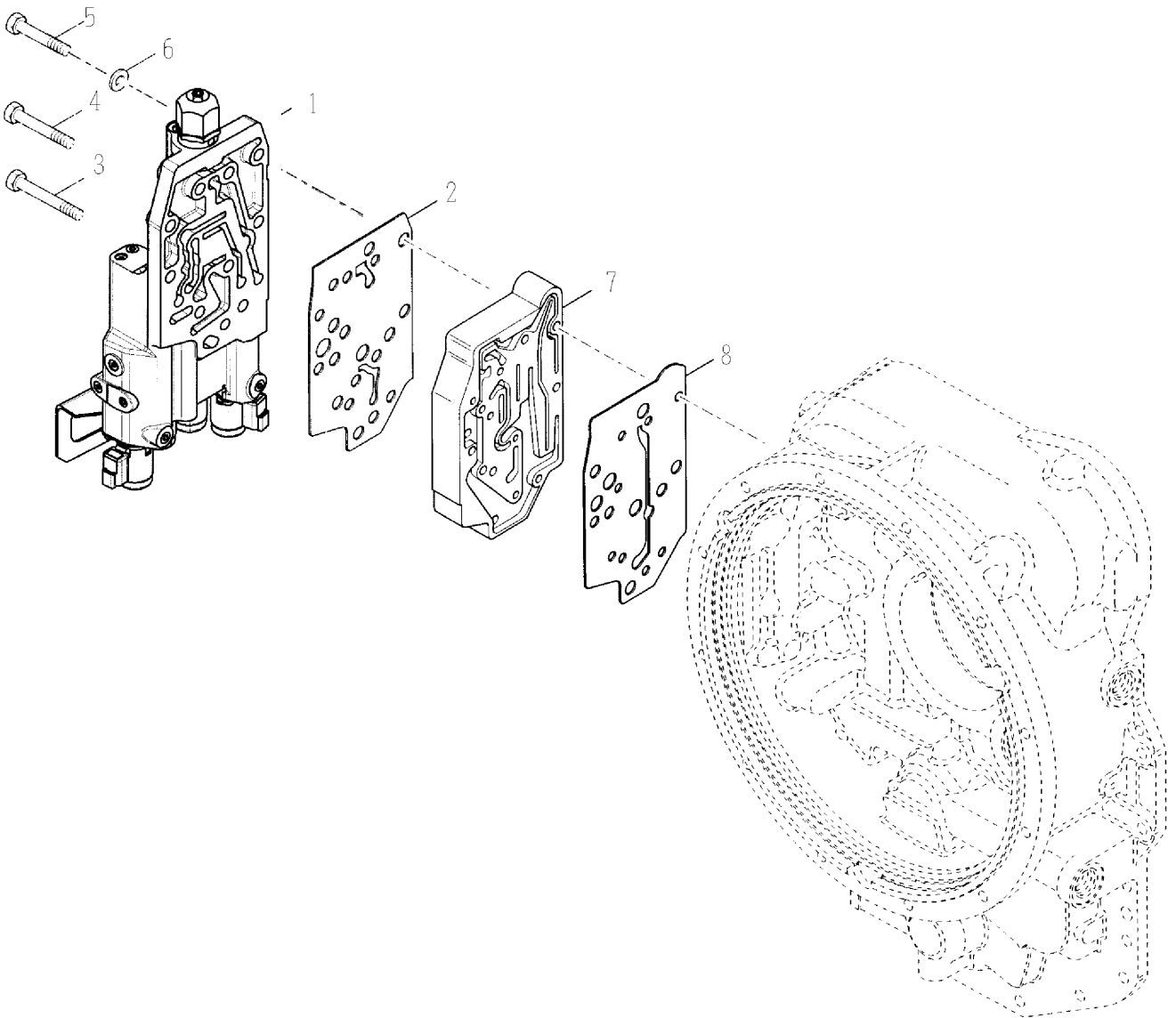


T20000  
GROUP-THRU DRIVE PUMP ASSEMBLY

Seq	PartNr	Qty	%	Description / Remark
	1C816	2		SCREW-SHIPPING COVER (Not Illustrated)
	25K30400	1		O RING (Not Illustrated)
	2FM12170	2	B	WASHER-SEALING (Not Illustrated)
	3614642	1	E	COVER-PUMP ADAPTOR SHIPPING (Not Illustrated)
	4205272	1	B	GASKET-SHIPPING COVER (Not Illustrated)
	4E8	2		LOCKWASHER-SHIPPING COVER SCREW (Not Illustrated)
1	4219887	1		PUMP-THRU DRIVE STANDARD (240-280 PSI)
2	235283	1	B	GASKET-PUMP ASSEMBLY TO CONVERTER HOUSING
3	60K30018	1	B	"O" RING
4	73G788	5		SCREW- PUMP MOUNTING
5	4E7	3		LOCKWASHER-PUMP MOUNTING SCREW

# T20000

GROUP-VALVE 3-6 SPD RS  
W/HYDR INCHING, W/O DECLUTCH  
AND W/MODULATION



GRPT20387revOCT05



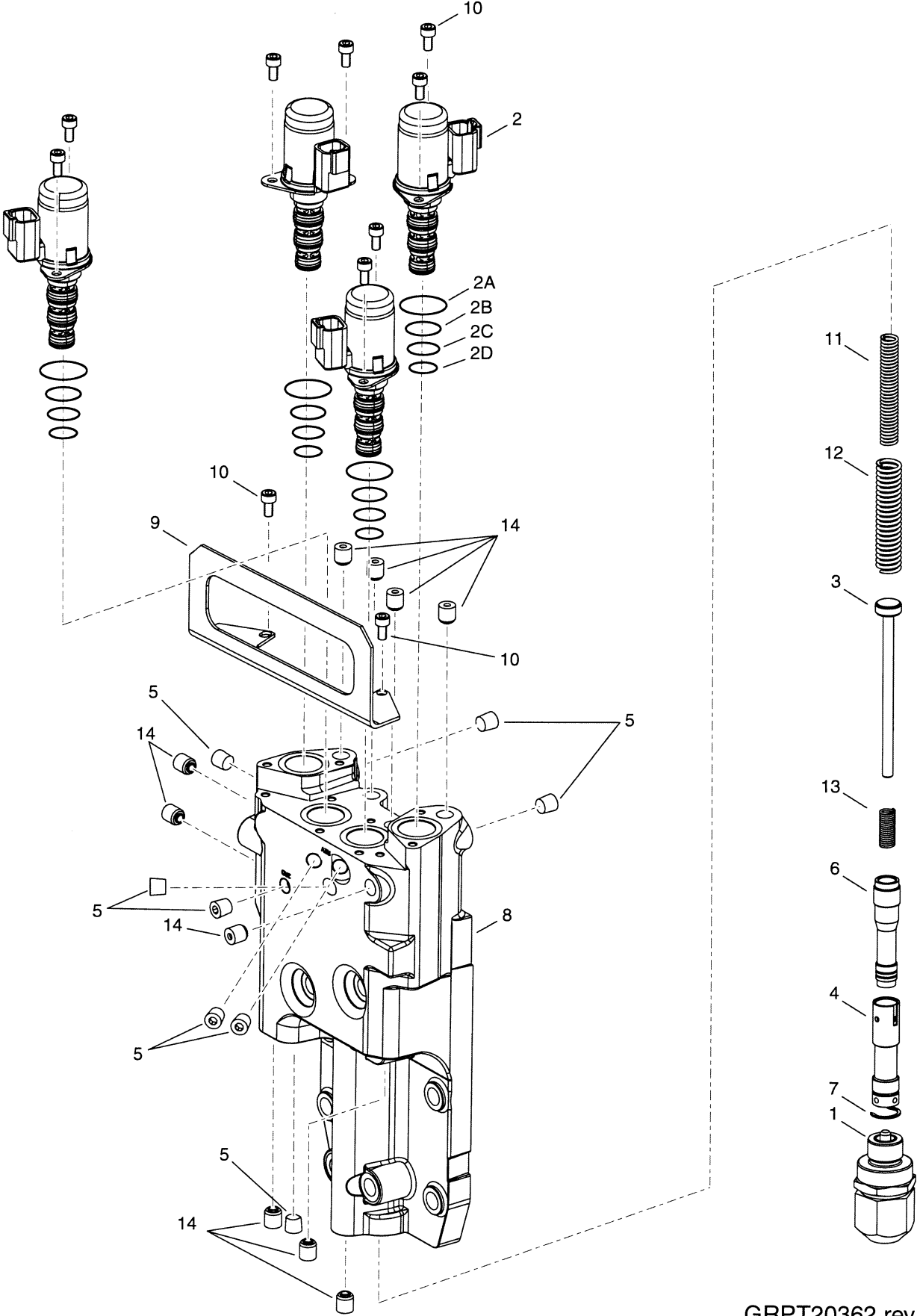
T20000  
GROUP-3 SPEED

Seq	PartNr	Qty	%	Description / Remark
	4213159	1		SHIPPING COVER DROPIN SOLENOIDS (Not Illustrated)
1	4211259	1	E	ASSY-3 SPEED
2	4211196	1	B	GASKET
3	1C652	4		SCREW
4	1C664	3		SCREW
5	1C676	2		SCREW
6	4E6	9		LOCKWASHER
7	4502406	1	E	ASSEMBLY-MODULATOR VALVE
8	247615	1	B	GASKET-MODULATION VALVE TO CONV. HSG.

# T20000

## ASSY-VALVE 3/6 SPD RS

### W/HYDRAULIC INCHING, W/O DECLUTCH

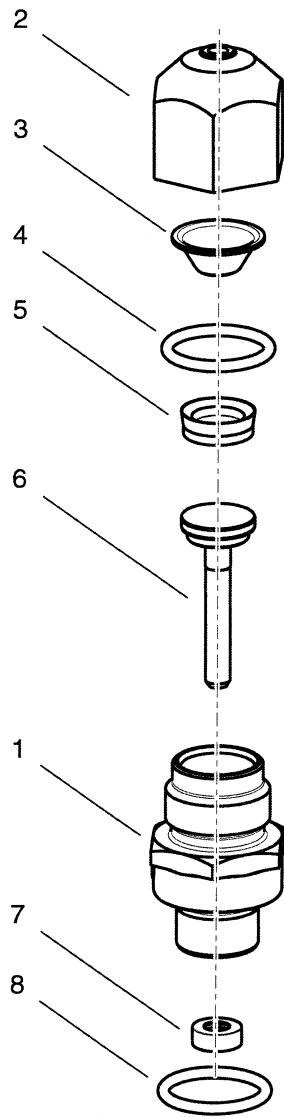


T20000  
ASSY-3 SPEED

Seq	PartNr	Qty	%	Description / Remark
1	240009	1	D	ASSY-INCHING
2	4210835	4	D	SOLENOID-DEUTSCH 12V-INCL.ITEMS 2A,2B,2C & 2D
2A	4210660	4	B	O-RING 21.5X1.5 MM VITON - PART OF ITEM 2
2B	4210661	4	B	O-RING 15.1X1.60 MM VITON - PART OF ITEM 2
2C	4210662	4	B	O-RING 14.1X1.60 MM VITON - PART OF ITEM 2
2D	4210663	4	B	O-RING 12.1X1.60 MM VITON - PART OF ITEM 2
3	236560	1	E	ROD-INCHING VALVE
4	236562	1	E	SLEEVE-INCHING VALVE
5	239244	8		PLUG
6	244414	1	E	SPOOL-INCHING
7	247494	1	D	SNAP RING
8		1	E	BODY (Not Sold Separately) order partnumber 4211259 to service body
9	4211435	1	D	COVER-SOLENOID
10	1GM510	10		CAPSCREW M5X10
11	236557	1	C	SPRING-INCHING INNER
12	236558	1	C	SPRING-INCHING OUTER
13	241068	1	C	SPRING-INCHING
14		10		PLUG-EXPANSION DIA 10 (Not Sold Separately) plug expansions are part of assembly 4211259

# 36000

## GROUP-HYDRAULIC SLAVE CYLINDER ASSY

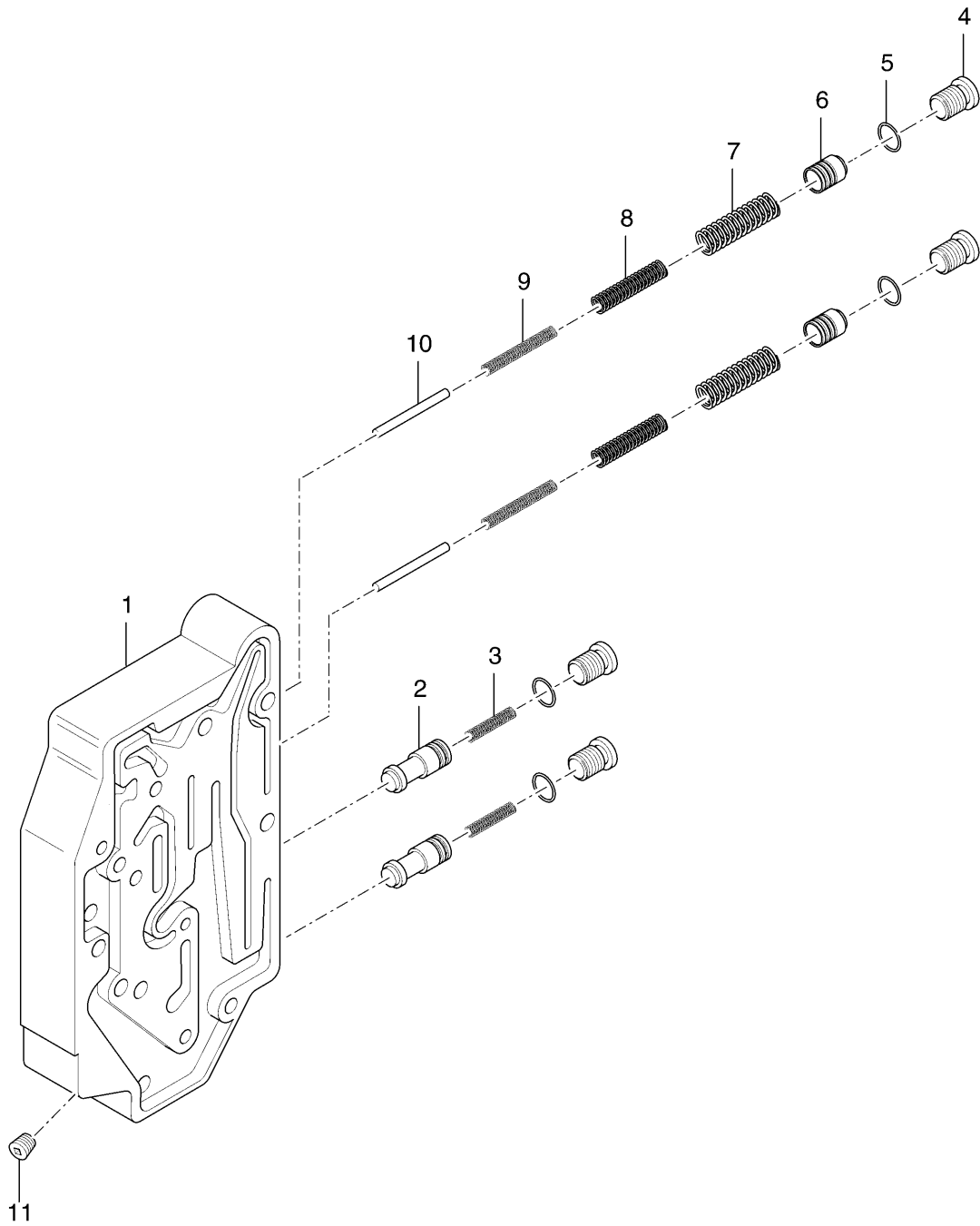


T20000  
ASSY-INCHING

Seq	PartNr	Qty	%	Description / Remark
	16F2	1		PLUG (Not Illustrated)
1	240007	1	E	INCHING SLAVE CYLINDER HOUSING & FILTER ASSEMBLY
2	236565	1		END CAP SLEEVE CYL.
3	236566	1	E	CUP STOP
4	91F8	1	B	"O" RING
5	238414	1	C	PISTON
6	240003	1	E	INCHING SLAVE CYLINDER PISTON
7	237698	1	B	OIL SEAL
8	25K30022	1	B	"O" RING

# T20000

## MODULATOR VALVE ASSEMBLY

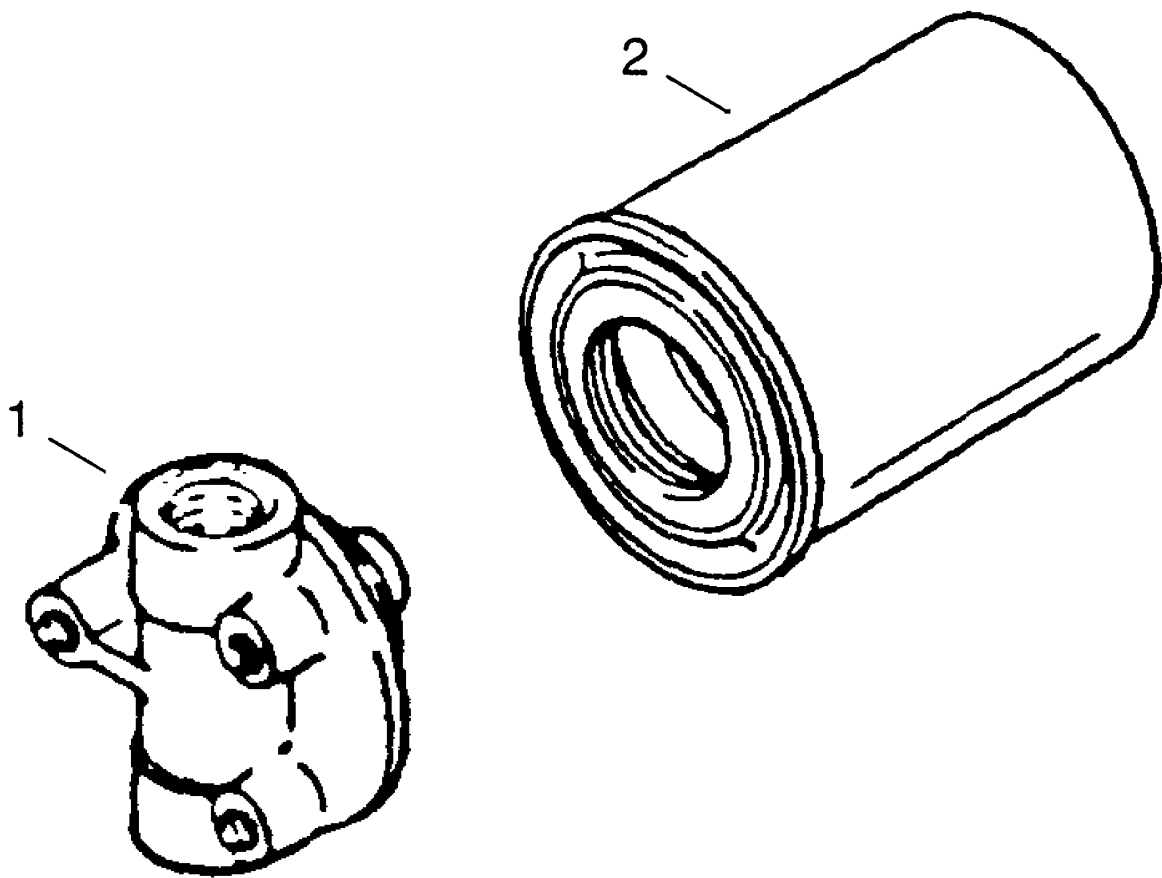


T20000  
ASSEMBLY-MODULATOR VALVE

Seq	PartNr	Qty	%	Description / Remark
1		1		HOUSING-MODULATOR - PART OF VALVE ASSEMBLY (Not Sold Seperately)
2		2		REGULATOR-SPOOL - PART OF VALVE ASSEMBLY (Not Sold Seperately)
3	241670	2	D	SPRING-REGULATOR
4	47K7	4		PLUG - INCLUDING ITEM 5
5	91F7	4	B	"O" RING - PLUG - PART OF ITEM 4
6		2		ACCUMULATOR-SPOOL - PART OF VALVE ASSEMBLY (Not Sold Seperately)
7	243506	2	D	SPRING-ACCUMULATOR OUTER
8	237879	2	D	SPRING-ACCUMULATOR MIDDLE
9	241666	2	D	SPRING-ACCUMULATOR INNER
10	237881	2	E	PIN-ACCUMULATOR STOP
11	40K2	1		PLUG

# T20000

GROUP - REMOTE FILTER





T20000  
ASSEMBLY-OIL FILTER AND ADAPTOR

<b>Seq</b>	<b>PartNr</b>	<b>Qty</b>	<b>%</b>	<b>Description / Remark</b>
1	236645	1	E	ADAPTOR-FILTER
2	247052	1	D	ASSEMBLY-OIL FILTER



**SPICER OFF-HIGHWAY**

# Technical Service Bulletin

N°. BEA 280 E

Month - Year : 03 - 00

**Subject :** T20000 Series Transmissions – drive plate kits

**Reason for bulletin :** Proper identification by bolt circle diameter

**Models affected :** T20000 Series Transmissions

**Ref. :** Installation sheet 814974

Please see attached two pages.

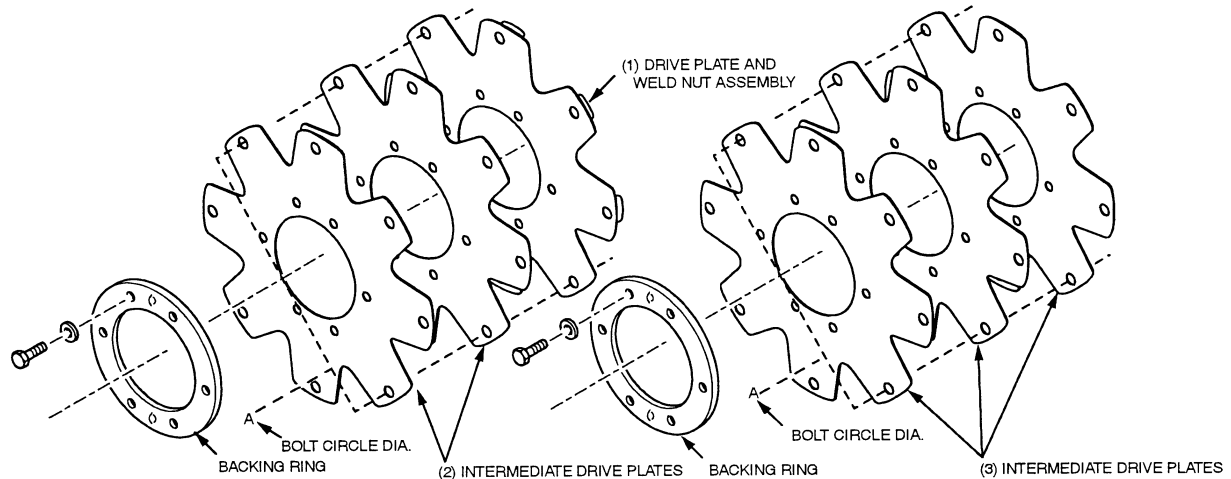
Additional copies of bulletin available upon request. Phone Spicer Off-Highway :  
(704) 878-5850 ( U.S.A.) – (39) 0464-580214 (Italy) – (32) 50-402442 (Belgium).

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## T20000 SERIES TRANSMISSIONS DRIVE PLATE KITS

Measure the “A” dimension (bolt circle diameter) and order drive plate kit listed below. Note three (3) kits have two (2) intermediate drive plates and one (1) drive plate and weld nut assembly. Three (3) kits with three intermediate drive plates.



### “A” Dimension (Bolt circle diameter)

- 11.380 ” (288.900 mm)diameter  
Kit No.**814978**.
- 13.125 ” (333.38 mm)diameter  
Kit No.**814977**.
- 13.500 ” (342.90 mm)diameter  
Kit No.**814975**.

Each kit will include the following parts:

- 2 Intermediate drive plates.
- 1 Drive plate and weld nut assembly.
- 1 Backing ring.
- Mounting screws.
- 6 Lockwashers.
- 1 Instruction sheet.

### “A” Dimension (Bolt circle diameter)

- 11.380 ” (288.900 mm)diameter  
Kit No.**814979**.
- 13.125 ” (333.38 mm)diameter  
Kit No.**814980**.
- 13.500 ” (342.90 mm)diameter  
Kit No.**814981**.

Each kit will include the following parts:

- 3 Intermediate drive plates.
- 1 Backing ring.
- 6 Mounting screws.
- 6 Lockwashers.
- 1 Instruction sheet.

Position drive plate and weld nut assembly on torque converter assembly with weld nuts toward converter. Align intermediate drive plates and backing plate with holes in torque converter assembly.

### NOTE



Two dimples 180° apart in backing ring must be out toward engine flywheel (hollow side facing torque converter assembly). Install cap screws and lockwashers. Tighten cap screws torque 40 - 50 Nm. (30 - 37 lb. ft.).



## TRANSMISSION TO ENGINE INSTALLATION PROCEDURE

1. Remove all burrs from flywheel mounting face and nose pilot bore. Clean drive plate surface with solvent.
  2. Check engine flywheel & housing for conformance to standard SAE No. 3 per SAE J927 and J1033 tolerance specifications for pilot bore size, pilot bore runout and mounting face flatness. Measure and record engine crankshaft end play (Fig. 1).
  3. Install two 63,50 mm (2.50") long transmission to flywheel housing guide studs in the engine flywheel housing as shown. Rotate the engine flywheel to align a drive plate mounting screw hole with the flywheel housing access hole (Fig. 2).
  - \*4. Install a 101,60 mm (4.00") long drive plate locating stud .3750-24 fine thread in a drive plate nut. Align the locating stud in the drive plate with the flywheel drive plate mounting screw hole positioned in step No. 3.
  5. Rotate the transmission torque converter to align the locating stud in the drive plate with the flywheel drive plate mounting screw hole positioned in step No. 3. Locate transmission on flywheel housing.
- Aligning drive plate to flywheel and transmission to flywheel housing guide studs. Install transmission to flywheel housing screws. Tighten screws to specified torque. Remove transmission to engine guide studs. Install remaining screws and tighten to specified torque.
- \*6. Remove drive plate locating stud.
  7. Install drive plate attaching screw and washer. Snug screw but **do not tighten**. Some engine flywheel housings have a hole located on the flywheel housing circumference in line with the drive plate screw access hole. A screwdriver or pry bar used to hold the drive plate against the flywheel will facilitate installation of the drive plate screws. Rotate the engine flywheel and install the remaining seven (7) flywheel to drive plate attaching screws. Snug screws but **do not tighten**. After all eight (8) screws are installed. Torque each one 35 to 39 Nm. (26- 29ft.lbs.). This will require tightening each screw and rotating the engine flywheel until the full amount of eight (8) screws have been tightened to specified torque.
  8. Measure engine crankshaft end play after transmission has been completely installed on engine flywheel. This value must be within 0,025 mm (0.001") of the end play recorded in step No. 2.

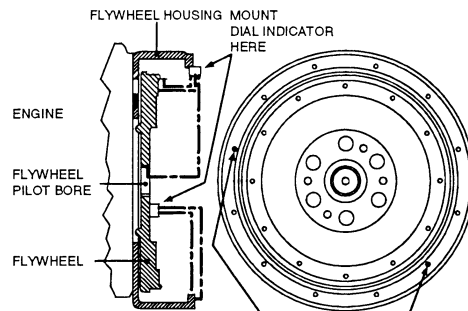


FIG. 1

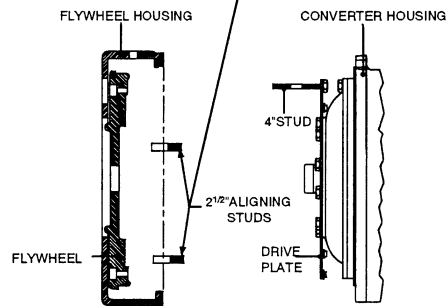


FIG. 2

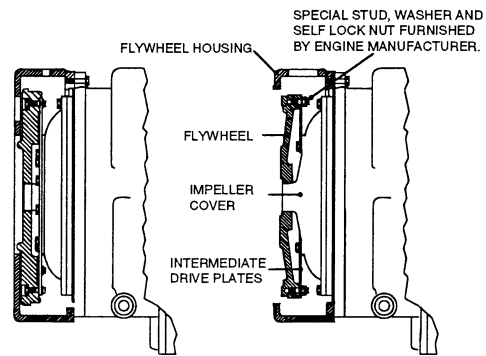


FIG. 3

FIG. 4

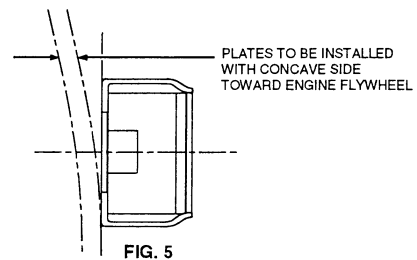


FIG. 5

\*Does not apply to units having 3 intermediate drive plates. See Fig.4.

T20000

KIT-GASKET AND SEALING FOR SHORT DROP, INT DROP AND INLINE

<b>PartNr</b>	<b>QTY</b>	<b>Description / Remark</b>
4205578	1	CONVERTER HSG OR FRONT COVER TO TRANS CASE GASKET
231798	1	OIL SEAL-INPUT FLANGE
60K40112	1	O RING-INPUT FLANGE
219373	1	FRONT COVER PLUG SEAL RING
91F5	7	O RING-PLUG
91F6	6	O RING-PLUG
91F8	2	O RING-PLUG
4205097	1	O RING-SUCTION TUBE ASSEMBLY
234312	2	SEAL-OIL BAFFLE
60K40026	3	O RING-TUBE
60K30018	3	O RING-TUBE & CHARGING PUMP GASKET
4205924	1	GASKET-REAR COVER (INLINE)
4206294	1	GASKET-REAR COVER (INTERMEDIATE DROP)
4203422	2	O RING-SPEED SENSOR
4205235	1	RING-PISTON STATOR SUPPORT
250219	1	RING-PISTON TURBINE SHAFT
4204710	1	SEAL-OIL BAFFLE
241237	1	SEALING-RING OIL BAFFLE
60K30114	1	O RING-CONVERTER PLUG
4205272	1	GASKET-PUMP HOLE COVER

T20000

KIT-GASKET AND SEALING FOR SHORT DROP, INT DROP AND INLINE

<b>PartNr</b>	<b>QTY</b>	<b>Description / Remark</b>
243915	1	GASKET-PUMP ADAPTOR
4206098	2	GASKET-ADAPTER PLATE
235283	1	GASKET-CHARGING PUMP
76K223	1	O RING-IDLER SHAFT
247614	1	GASKET-CONTROL VALVE
247615	1	GASKET-MODULATION VALVE
247616	1	GASKET-CONTROL VALVE COVER
60K20012	1	O RING-PLUG
76K12	4	O RING-CARTRIDGE
76K13	4	O RING-CARTRIDGE
78K8	4	O RING-CARTRIDGE
76K20	8	O RING-NUT TO COIL & COIL TO CARTRIDGE
25K30022	1	O RING-PISTON HOUSING
237698	1	OIL-SEAL
241893	1	OIL-SEAL
91F7	5	O RING-PLUG
234650	2	SPOOL SEAL
227881	1	SEALING CUP
237032	5	SEAL-CLUTCH PISTON - OUTER
234113	5	SEAL-CLUTCH PISTON - INNER

T20000

KIT-GASKET AND SEALING FOR SHORT DROP, INT DROP AND INLINE

<b>PartNr</b>	<b>QTY</b>	<b>Description / Remark</b>
4208098	6	PISTON-RING
4207676	4	RING-PISTON
234130	2	RING-CLUTCH SHAFT PISTON
60K30012	1	O RING-LOW SHAFT BEARING CAP
60K40420	1	O RING-LOW SHAFT BEARING CAP
240299	1	3RD SHAFT BEARING CAP "O" RING
60K40328	1	"O" RING-OUTPUT BEARING CAP
60K30022	1	"O" RING-OUTPUT BEARING CAP
235751	1	OUTPUT SHAFT OIL SEAL
230954	1	OUTPUT SHAFT OIL SEAL
60K40112	1	O RING-FLANGE
60K60116	1	O-RING-FLANGE
247699	1	GASKET-OUTPUT BEARING CAP
60K40508	1	O RING-OUTPUT BEARING CAP
241894	1	SPEEDO OIL SEAL
91F8	1	O RING-SPEEDO
60K40112	1	O RING
241152	1	SEAL
25K20012	1	O RING
60K30122	1	O RING

Date : 20-jul-17  
Revision : D  
PartNr : 8100050

T20000

KIT-GASKET AND SEALING FOR SHORT DROP, INT DROP AND INLINE

<b>PartNr</b>	<b>QTY</b>	<b>Description / Remark</b>
241153	1	SEAL-CUP
4211196	1	GASKET





## Part Stocking Recommendation

The table below is a minimum spare parts inventory recommendation designated by letter code in each Service Parts List. Each letter code indicates a percentage for determining stock quantities to support the field population. Any quantity less than 1 or partial quantities need not be stocked.

Letter Code	Percentage	Example
A	15%	Part quantity = 10 per unit Field Population = 240 units Recommended stock = 240 units x 10 per unit x .15 = 360 parts
B	10%	Part quantity = 4 per unit Field Population = 66 units Recommended stock = 66 units x 4 per unit x .10 = 26.4 or 26 parts
C	6%	Part quantity = 2 per unit Field Population = 203 units Recommended stock = 203 units x 2 per unit x .06 = 24.4 or 24 parts
D	4%	Part quantity = AR* Field Population = 42 units Recommended stock = 42 units x 3 per unit x .04 = 5.04 or 5 parts
E	2%	Part quantity = 1 per unit Field Population = 75 units Recommended stock = 75 units x 1 per unit x .02 = 1.5 or 1 part
*Part quantities denoted by "AR" (as required) should be ordered by a quantity of 3 per unit.		



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