

INSTALLATION INSTRUCTIONS

SUBJECT: INTERNAL WIRE HARNESS CONNECTOR SEAL FOR ALLISON 1000/2000 AND GM 4T65-E

FPE-2023-105
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FITMENT: Allison 1000/2000 (2001-2019), GM 4T65-E. Fits OE internal harness P/N's:
29545307, 29541371, 29539792, 29543336

KIT P/N: FPE-HAR-GM-LCT-SEAL and FPE-HAR-GM-LCT-SEAL-7P

INSTALL TIME: 1 hour for seal only, 2 hours for seal and connector body.

TOOLS REQUIRED: Needle nose pliers, flat head screwdriver, 13mm socket, 10mm socket.

KIT CONTENTS:

Item	Description	Qty
1	Seal	1
2	Pass Through Connector Body	1
3	O-ring	1



IMPORTANT NOTE: To remove the connector body, the transmission pan will need to be removed along with the internal wiring harness. The seal itself can be replaced without removal of the transmission pan and valve body.

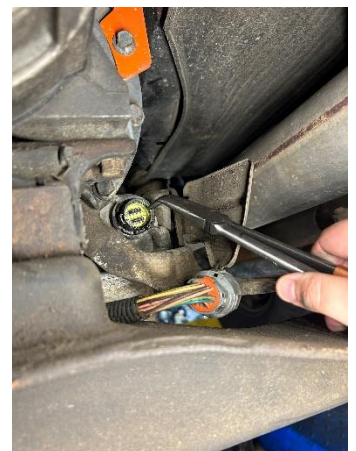
STEP 1: Ensure that the vehicle is parked on a flat and level surface. Remove the battery terminals.

STEP 2: Drain the transmission fluid and disconnect the chassis harness from the transmission. If connector body replacement is required, skip to STEP 5. Otherwise, if only replacing the connector body seal, continue to STEP 3.

STEP 3: Use a flat head screwdriver to lift the retainer and then pull the seal out of the connector body with pliers.

STEP 4: Install the new seal and reconnect the harness. Refill the transmission with fluid, reconnect the battery terminals and check for leaks during normal operation.

THE SEAL INSTALLATION IS NOW COMPLETE. IF REPLACING CONNECTOR BODY, MOVE TO STEP 5



STEP 5: Remove the transmission pan using a 13mm socket.

STEP 6: To release the locking tabs and remove the connector body from the housing, place a 1-1/4" socket on the outside portion of the body and tap it firmly. The body will push through and become free.

STEP 7: Remove the valve body. Use a 10mm socket to remove all 15 bolts retaining the valve body. Use a flat head screwdriver to gently lift the valve body off the mounting dowels.

STEP 8: Disconnect the harness. Remove the pins from the old connector body one at a time and install them into the new connector body.

STEP 9: Install the new seal and O-ring onto the connector body. Reconnect the harness to the valve body.

STEP 10: Reinstall the valve body. Torque the bolts to 108 in-lbs., starting from the center and working outwards in a spiral pattern. Seat the new connector body.

STEP 11: Reinstall the transmission pan and reconnect the chassis harness.

STEP 12: Refill the transmission with fluid per the Allison refill procedure. Reconnect the battery terminals and check for leaks during normal operation.

