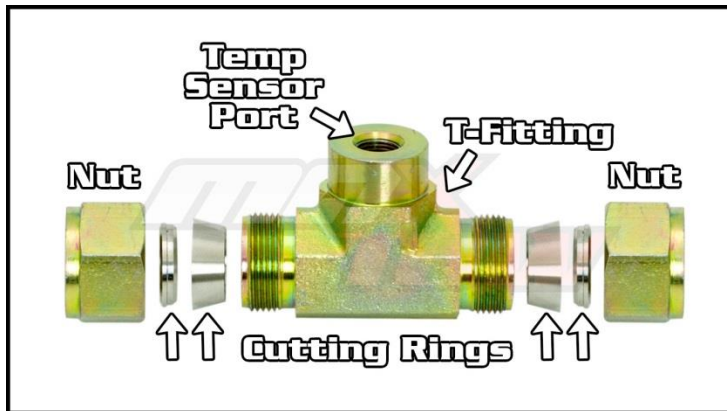


GM Duramax Allison 1000 Transmission T-Fitting



1. Disconnect the negative cables from both batteries.

2. Locate the cooler feed line on the passenger side of the transmission housing. **Note:** The lower line is the cooler feed line and the upper line is the return line from the cooler.

3. Using a pick tool, release the plastic retaining clip cover and slide out of the way. Release and remove the retaining clip from the transmission. Slide the line out of

the transmission case and drain the fluid. **Note:** Use a drain pan to catch the fluid.

4. Measure and mark the location where you would like to install the T-fitting. Cut 1 7/8" out of the cooler feed line with a pipe cutter (make sure to always use a new blade). **Note:** You can also remove the cooler feed line entirely from the truck and cut it on a work bench. If the cooler feed line is removed from the truck, up to 4 quarts of transmission fluid will need to be drained from the system and must be refilled with fresh transmission fluid once the T-fitting has been installed. Use a drain pan to catch the fluid.
5. Deburr both ends of the cut line with a deburring tool to ensure proper fitment of the T-fitting onto the cooler feed line.
6. Install the cooler line T-fitting's female fittings over each end of the cut line. Then place the metal cutting rings over each end of the cooler line. Refer to the schematic above for proper placement of the cutting rings.
7. Hold the body of the T-fitting with a 24mm wrench and hand tighten each nut. Then tighten 1 1/4 more turns with a 26mm wrench to ensure proper sealing of the cutting rings.
8. Now you can install the 1/8-27 NPT temperature sensor into the port on the T-fitting housing. **Note:** Be sure to use Teflon tape on the threads of the temperature sensor to prevent any leaks.
9. If the line was removed, reinstall the line onto the truck and refill the transmission with up to 4 quarts of proper grade transmission fluid. **Note:** Check the dipstick to ensure the proper amount of fluid is in the transmission.
10. Reconnect the battery cables to the negative posts of each battery and check for any leaks.

