

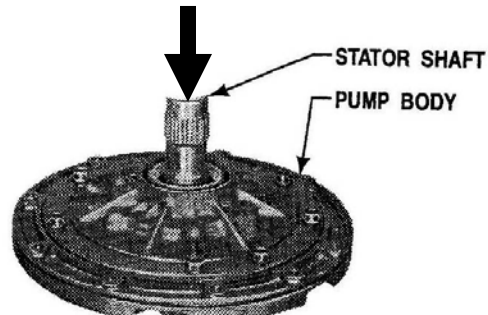


## Allison AT540 Series Stator Shaft

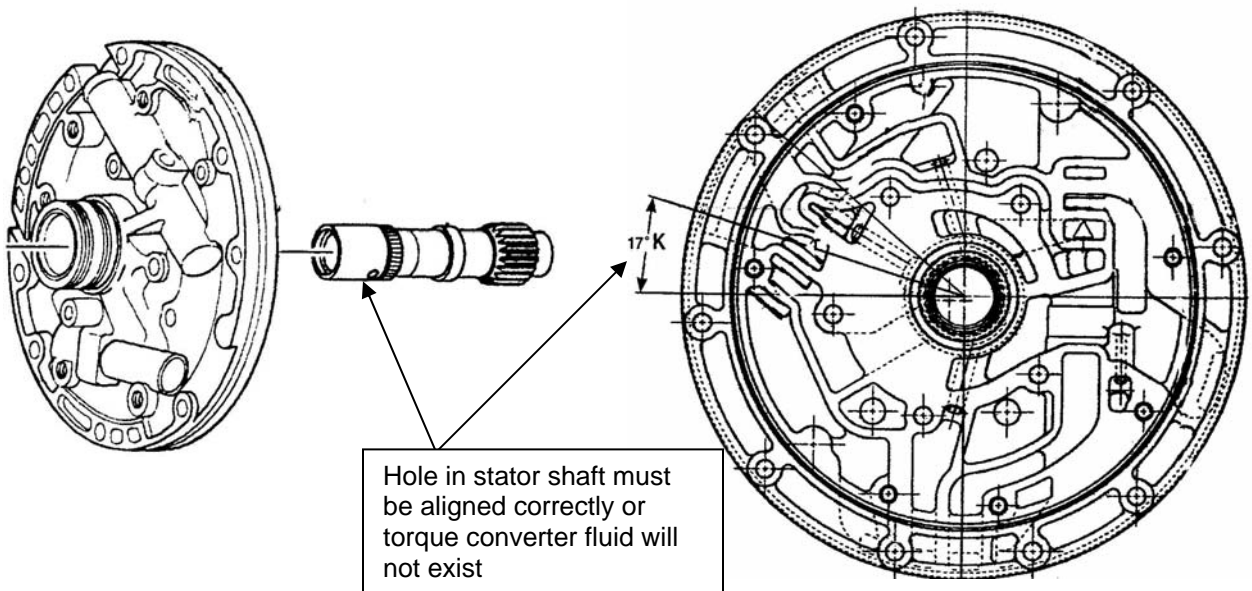
ALTO PART #055375

### INSTALLATION INSTRUCTIONS

**Removal:** Place pump body (front support) on a press bed, machined face downward, and press stator shaft from pump body.



**Installation:** Support the front pump support in a press with the pump face upward. Position the stator shaft in the center bore of the front support, aligning the hole in the stator shaft with Angle "K".



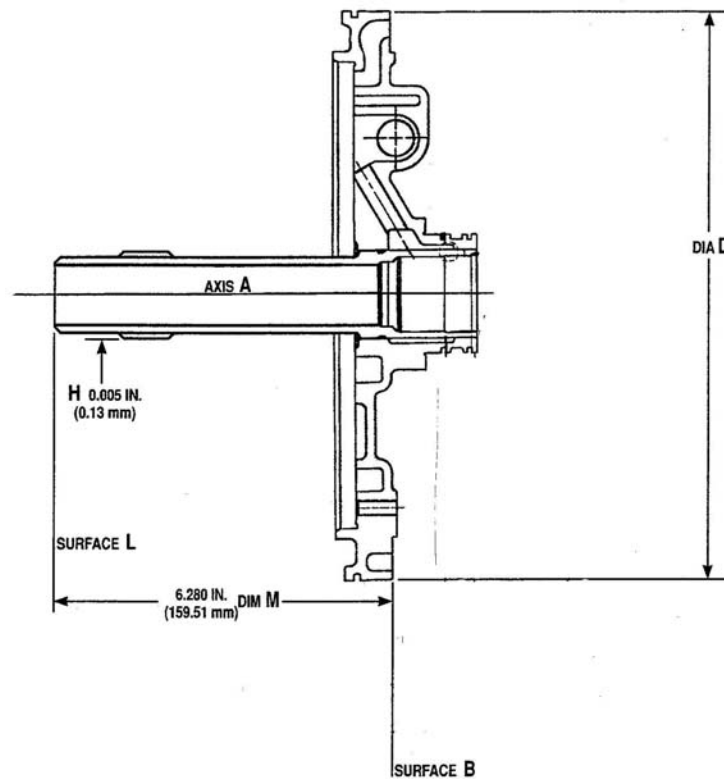


## Allison AT540 Series Stator Shaft

ALTO PART #055375

### INSTALLATION INSTRUCTIONS (Continued)

**Installation:** Press the stator shaft into the front pump support to “**Dimension M**” (6.280” / 159.51mm) as measured from “**Surface B**” to the end of the stator shaft “**Surface L**”



“**Axis A**” is established by “**Diameter D**” and “**Surface B**”.

When mounted on “**Diameter D**” and “**Surface B**” features shall be within the total runout specified by “**H**” (.005” / .13mm).

**Follow bushing installation as outlined in your AT Series On-Highway Transmission Service Manual.**