

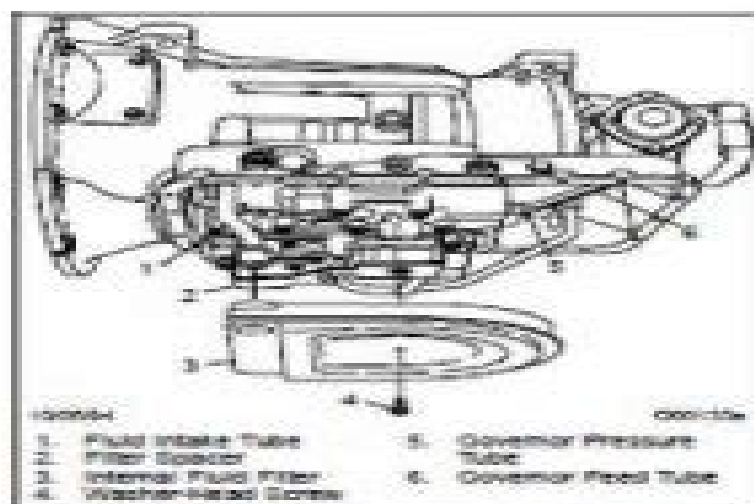


Fig. 1, AT Series Transmission Filter

11. Submerge a new oil pan gasket in transmission fluid for five minutes. Then, place the gasket on the pan; do not use any substance as a gasket retainer.

**IMPORTANT:** Do not use gasket-sealing compounds any place inside of the transmission or where they might be washed into the transmission. Also, non-soluble vegetable-based cooking compounds or fibrous greases must not be used inside of the transmission.

12. Install the oil pan and gasket.

- 12.1 Guide the pan and gasket carefully into place. Guard against dirt or foreign material entering the pan. Retain the pan with four 5/16-18 washer-head screws, installed by hand in the corners of the pan.
- 12.2 Install the remaining washer-head screws by hand, carefully threading each through the gasket and into the transmission. Bottom all of the screws before tightening any of them.

- 12.3 Tighten all of the screws evenly: 10 to 15 lbf-ft (14 to 20 N-m). Check the gasket fit while the screws are being tightened.

**IMPORTANT:** The oil pan bolts must maintain a minimum torque of 60 lbf-in (6.80 N-cm) after the oil pan gasket has taken a set.

13. Install the fill tube at the side of the pan. Tighten the tube fitting 90 to 100 lbf-ft (122 to 136 N-m).
14. Install the drain plug and gasket, and tighten the plug 15 to 20 lbf-ft (20 to 27 N-m).
15. Replace the external (auxiliary) fluid filter.
16. Clean the area around the fill tube and remove the dipstick. Using a clean funnel in the fill tube, add transmission fluid. See [Table 1](#) for approved transmission lubricants, and [Table 2](#) for lubricant capacities.

Approved Transmission Lubricants\*

| Lubricant Type         | Temperature                    |
|------------------------|--------------------------------|
| Devcon II ATF          | -28° to +130°F (-32° to +48°C) |
| Transynd Synthetic ATF | -28° to +130°F (-32° to +48°C) |

\* Fluids filled with Devcon II, for off-highway operation in where ambient temperature is consistently above -30°F (-30°C) or below -20°F (-20°C), see the manufacturer's fluid recommendations.

Table 1, Approved Transmission Lubricants

Lubricant Capacities, AT1000/2000/3400MD Series Transmissions

| Model                        | Refill Capacity**:<br>quarts (liters) |
|------------------------------|---------------------------------------|
| AT-642                       | 16.0 (16.1)                           |
| AT-648                       | 21.0 (19.9)                           |
| 1000/2000/3400 Standard Sump | 10.4 (10)                             |
| 1500/2000/3400 Shallow Sump  | 7.4 (7)                               |
| MD-3060P                     | 17.6 (16.6)                           |
| MD-3060PH                    |                                       |

\*\* Quantities listed are approximate. Add the recommended amount of fluid as listed under refill capacity, then perform a "wet check" and add fluid as needed. Do not overfill.

Table 2, Lubricant Capacities, AT1000/2000/3400MD Series Transmissions

17. Check and adjust the fluid level using the procedure under "Transmission Fluid Level Checking."

# Mb45 Owners Manual

**LL Leslie**



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