



**Stage4  
C1  
Clutch Pack**

*Allison 1000, 2000, 2400  
(128134101)*

***Installation Guide***

## **DISCLAIMER OF LIABILITY**

Performance products can increase horsepower above and beyond factory specifications. Additional horsepower creates more stress on the drive-train components, which could result in drive-train failure.

Note regarding emissions-related, non-E.O.-legal products: THESE PRODUCTS ARE LEGAL IN CALIFORNIA ONLY FOR RACING VEHICLES THAT MAY NEVER BE USED, OR REGISTERED OR LICENSED FOR HIGHWAY OR OFF-ROAD USE.

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## **LIMITATION OF WARRANTY**

The Seller gives Limited Warranty as to description, quality, merchantability, and fitness for a particular purpose, productiveness, or any other matter of Seller's product sold herewith. The Seller shall not be responsible for the products proper use and service and the Buyer hereby waives all rights other than those expressly written herein. This warranty shall not be extended, altered or varied except by a written instrument signed by Seller and Buyer.

The Warranty on PPE Manifolds and Up-Pipes Kits, OEM-Length Up-Pipes is three (3) years, a limited lifetime warranty on PPE cast aluminum pans and covers, and a limited lifetime warranty on PPE Transmission Coolers and one (1) year limited warranty on all other PPE products from the date of sale to original buyer and limited solely to the parts contained within the products kit. All products that are in question of Warranty must be returned prepaid to the Seller and must be accompanied by a dated proof of purchase receipt. All Warranty claims are subject to approval by Seller. Under no circumstances will the Seller be liable for any labor charged or travel time incurred in diagnosis for defects, removal, or re-installation - of this product or any other contingent expenses. Under no circumstances will the Seller be liable for any damage or expenses incurred by reason of the use or sale of any such equipment. In the event that the buyer does not agree with this agreement: the buyer may promptly return this product, in a new and unused condition in its original packaging, with a dated proof of purchase to the place of purchase within ten (10) days from date of purchase for a full refund. The installation of this product indicates that the buyer has read and understands this agreement and accepts its terms and conditions.

**CONTENTS:**

- 7 - (.0675") HEG 1-sided External Spline Frictions
- 7 - (.0675") HEG 1-sided Internal Spline Frictions
- 1 - (.201") Bottom Apply Plate Internal Spline

**INSTALLATION INSTRUCTIONS**

- 1) Install the Bottom Apply Plate against the apply piston. Install externally splined friction with the friction lining facing down. (Away from you)
- 2) Alternate installation of Internally Splined Plates and Externally Splined Plates ending with an internally Splined Plate. All linings should be face down. (Failure to install plates correctly will result in catastrophic failure; steel sides of plates must not make contact with each other)
- 3) Install top pressure plate, install snap ring, (Do not install spiral ring at this time).
- 4) Apply air to the clutch pack several times.
- 5) Check clutch pack clearance (.090" to .110").
- 6) Install spiral ring.



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