

VEHICLE MAKE AND MODEL _____	TRANSMISSION ASSEMBLY NO _____
SERVICE WORK ORDER # _____	VIN _____

1. This transmission contains NO LUBRICANTS. Use Mercedes approved transmission fluid (MB235.15 or MB235.11 Spec).
  - See Mercedes service manual section 2.1 for a complete list of approved products.\*
  - Fill transmission with the correct volume of fluid (6.1)\*
  - Follow the correct maintenance schedule (4.1)\*
  
2. Check clutch and related components. \*If equipped, reclaim Clutch Actuator Spacer from core
  - Inspect clutch and related parts for wear (7.1.2; 9.2)\*
  - Weller recommends flywheel resurface to OE specs
  - Weller recommends replacement of pilot bearing (16.1)\*
  - Ensure no grease or oil is on friction surfaces
  
3. Check driveline for worn or failed components
  - U-Joints
  - Carrier Bearing
  - Yoke seal surface and splines
  - Ride height
  - Check driveline phasing
  - Driveline angles (See job aid on pgs 15-18)
  - Inspect suspension hardware & bushing for wear
  
4. PTO (If equipped)
  - See Mercedes installation bulletin DDC-ENG-MAN-0001
  
5. Transmission heat exchanger (if equipped)
  - Clean and flush cooler system
  - Weller recommends pressure testing the cooler for leaks
  
6. Air system
  - Check air dryer
  - Check truck pressure and inspect for leaks
  - Inspect the purge valve (fluid drain) on the bottom of the air tank for proper operation
  
7. Connect the TCM to the transmission
  - Make sure harness connectors are clean and tight
  
8. After installation
  - Perform clutch calibration and gear re-learn
  - Perform tilt sensor re-learn procedure
  - Update software on truck to the latest version

\*Section contained within Mercedes service manual (reference number DDC-SVC-MAN-0140)

DT-12 TORQUE SPECS	
AIR LINES TO RANGE CYLINDER	105 IN/LBS
AIR LINES TO SHIFT CONTROLLER	105 IN/LBS
AIR PRESSURE SENSOR ADAPTER	52 FT/LBS
SUPPLY AIR LINE	40-47 FT/LBS
(3.2.2) AIR PRESSURE FITTINGS	105 IN/LBS
AIR PRESSURE SENSOR	26-29 FT/LBS
C/S SPEED SENSOR BOLT	90 IN/LBS
DRAIN PLUG	44 FT/LBS
PTO BOLTS	37 FT/LBS
PTO AIR SOLENOID BOLTS	21.2-31.8 IN/LBS
PTO AIR CONNECTION FITTING	71-107 IN/LBS
PTO COVER PLATE	18 FT/LBS
PTO POSITION SWITCH	35 FT/LBS
SHIFT CONTROLLER BOLTS	90 IN/LBS
RANGE CYLINDER BOLTS	37 FT/LBS
RANGE POSITION SENSOR	55 IN/LBS
TCM MOUNTING SCREWS	90 IN/LBS
EXHAUST SUPPORT BRACKET ON FLYWHEEL HOUSING	18 FT/LBS
OIL PUMP COVER BOLTS	44 FT/LBS
ATD INLET PIPE ASSEMBLY	9.5-10.5 FT/LBS
ADT INLET PIPE CLAMPS	115-125 IN/LBS
ADT INLET PIPE BRACKET	14-16 FT/LBS
CLUTCH ACTUATOR BOLTS	40 FT/LBS
CLUTCH POSITION SENSOR	44 IN/LBS
C/S BRAKE VALVE AIR LINE W/ RETAINING PLATE	90 IN/LBS
C/S BRAKE VALVE AIR LINE W/ QUICK CONNECT	105 IN/LBS
DRIVELINE STRAP BOLTS	115-135 FT/LBS
YOKE (HEAT TO 175 DEG. F)	295-370 FT/LBS
FLYWHEEL HOUSING TO CLUTCH HOUSING BOLTS	45-53 FT/LBS
FLYWHEEL HOUSING TO CLUTCH HOUSING STUDS	35-45 FT/LBS
AIR SUPPLY CONNECTION TO SHIFT CONTROLLER	43-47 FT/LBS
C/S BRAKE MOUNT BOLTS	18 FT/LBS
M/S SPEED SENSOR BOLTS	90 IN/LBS
RANGE HOUSING FLANGE BOLTS	59 FT/LBS
SHIFT FORK DETENT SPRING CAP	74 FT/LBS
HARNESS RACEWAY	90 IN/LBS
CLUTCH BOLTS	44 FT/LBS



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