

## b. Tube Adapter — MTB 640, 643 (Older Models)

1. On later models, insert the two governor feed and pressure tubes into tube adapter 20 (Figure 7-40). Place the tube adapter in position on the transmission housing and insert the two tubes into their respective bores in the valve body. Simultaneously insert the first clutch feed tube into its bore in the tube adapter and valve body.

2. On earlier models, insert the first clutch feed tube and the two governor feed and pressure tubes into tube adapter 20 (Figure 7-41). Place the tube adapter in position on the transmission housing and insert the three tubes into their respective bores in the valve body.

3. Install four 16-20 x 1 1/4 inch bolts 21 to secure the tube adapter. Tighten the bolts to 5-12 ft-lb (7-16 Nm). Use grease finger wrench 1 29012 for this operation.

4. Engage the notch in the shift selector valve with the pin on the detent lever (Figure 7-42). Position the detent spring to engage a notch in the detent lever and install one 16-20 x 1 1/4 inch bolt 26 to secure it. Tighten the bolt to 5-12 ft-lb (7-16 Nm).

5. On later models, install the 16-20 x 1 inch bolt 28 that secures the first clutch feed tube. Working from the center outward, tighten two 16-20 x 1 inch bolts, and secure 16-20 x 2 1/4 inch bolts 29 (Figure 7-40) to 5-12 ft-lb (7-16 Nm). Earlier models use one 16-20 x 2 1/4 inch bolt 25 and secure 16-20 x 2 1/4 inch bolts 26. Use grease finger wrench 1 29012 for this operation.

## NOTE:

For MT 640, 643 proceed to Paragraph 7-43.

## c. Control Valve Assembly — MTB 640, 643 (Older Models)

1. Install governor check ball 49 (if used) into the deep pocket end of the governor pressure piston (Figure 7-38).

## NOTE:

Later model transmissions do not utilize governor check ball 49.



Figure 7-40. Installing Tube Adapter — MT 640 (Later Models)

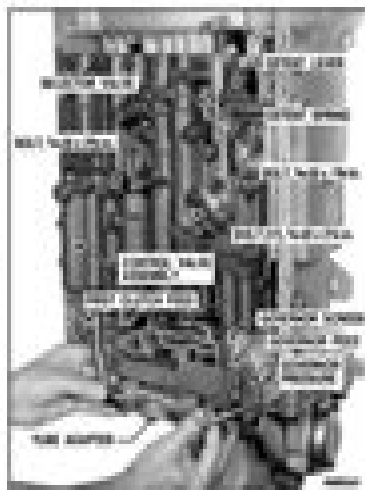


Figure 7-41. Installing Tube Adapter — MT 640, 643 (Earlier Models)

2. With the shift selector valve rotatably secured, position the control valve assembly (as assembled in Paragraph 6-4) on the advance pin across the housing bore (Figure 7-43). Install the control valve body and secure it with two 16-20 x 1 inch bolts 24 (Older Models), and secure 16-20 x 2 1/4 inch bolts 26. Earlier

models require one 16-20 x 2 1/4 inch bolt 25 and secure 16-20 x 2 1/4 inch bolts 26. Leave the bolts sufficiently loose to allow the valve body to engage the selector valve, and installation of the fractured external tubes wait on later models.

3. Later models discontinued the use of the governor oil screen (Figure 5-43). If the screen was not discarded during disassembly, discard it now.

4. Retain the oil transfer plate with two 16-20 x 1 1/4 inch bolts 21 (Figure 7-43). Temporarily install seven 16-20 x 2 1/4 inch bolts 22 to align the transfer plate. Tighten the two 16-20 x 1 1/4 inch bolts to 5-12 ft-lb (7-16 Nm), and remove the seven temporarily installed bolts 22.

5. Engage the groove in the shift selector valve with the pin on the detent lever (Figure 7-42). Position the detent spring to engage a notch in the detent lever and install one 16-20 x 1 1/4 inch bolt 26. Tighten the bolt to 5-12 ft-lb (7-16 Nm).

6. If the external tubes (illustrated in Figure 7-44) are used, tighten the right-hand control valve bolts, working from the center outward, to 5-12 ft-lb (7-16 Nm). Use grease finger wrench 1 29012 for this operation. Then proceed to Paragraph 7-46. If the external tubes illustrated in Figure 7-47 are used, do not tighten the bolts and proceed with Paragraph 7-46.

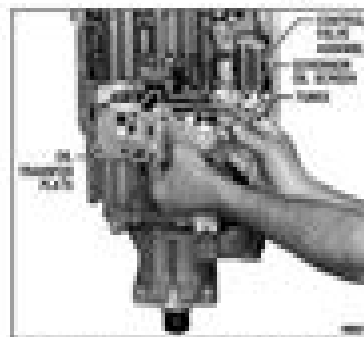


Figure 7-43. Installing Oil Transfer Plate — MT 640, 643

4. Later Shift Valve Body — MTB 640, 643. Install the separator plate and two shift valves (as assembled in Paragraph 6-5) onto the oil transfer plate (Figure 7-46). Install seven 16-20 x 2 1/4 inch bolts 22 (Older Models) to secure the two shift valves. Do not tighten the bolts at this time.



Figure 7-42. Tightening Control Valve Bolts



Figure 7-44. Installing External Tubes into Valve Bodies — MT 640, 643 (Earlier Models)

# Mt64allison Transmission Manual

**Tobias Bleicker**



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