



**ALLIANCE[™]
PARTS**

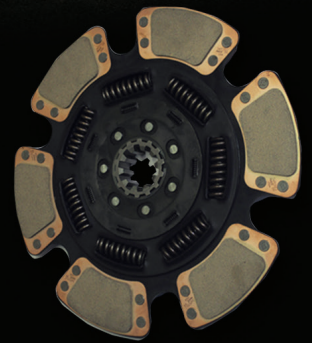
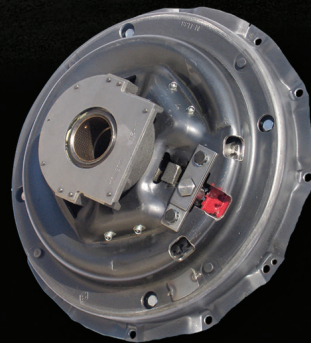
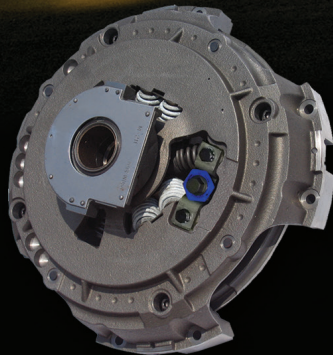
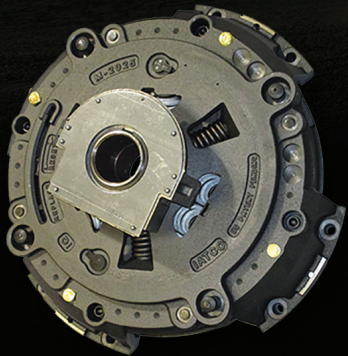
NEW CLUTCH ASSEMBLIES

Clutch Tools &
Replacement Clutch
Components

The most complete line of
NEW clutch assemblies,
flywheels and supplemental parts
for class 6, 7 & 8 vehicles

O.E.M. Quality

100% New Components



844-854-8034
allianceparts.com

Quality Products Manufactured
in the United States of America



08/2023 VER. 2.0



EXTENDED CLUTCH WARRANTY

Receive a 3-Year, Unlimited Mile Warranty

when you purchase an Alliance Easy Effort,[®] AutoSet Clutch,[®] & MaxShift Clutch[®] along with an Alliance Clutch Installation Kit.

Must provide proof of purchase of both Alliance Clutch and Alliance Installation Kit at the time of filing.

Applicable only on Alliance Easy Effort,[®] AutoSet Clutch,[®] & MaxShift Clutch.[®]

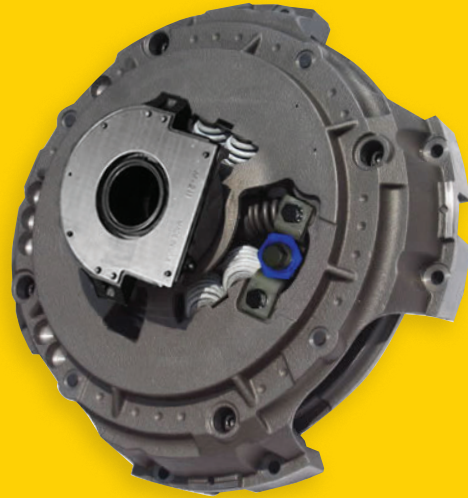
All Alliance Clutch Installation Kits apply.

Must provide proof of purchase of a new or ground flywheel.

Applicable only on purchases after January 1, 2019.

Applicable only for sales in USA and Canada.

For more information contact Alliance Clutch Program's Customer Service Department
844-854-8034 or
email at sales@iatcoinc.com

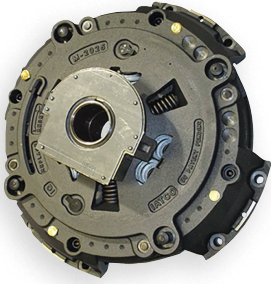


3-YEAR, UNLIMITED MILE WARRANTY

Easy Effort,[®] AutoSet Clutch,[®] & MasShift Clutch[®] are registered trademarks of Illinois Auto Truck Co., Inc.

AutoSet Clutch[®] - U.S. Patent No. 10,094,429

CLUTCH ASSEMBLIES



SELF-ADJUSTING – AUTOSET CLUTCH®

The *AutoSet Clutch*® improves on all previous available versions of self-adjusting heavy duty clutches. With every push of the clutch pedal, clutches and the associated parts wear over time. The *AutoSet Clutch*® compensates for wear by auto-adjusting to maintain the clutch pedal free play.

Alliance Parts are available at the following locations:

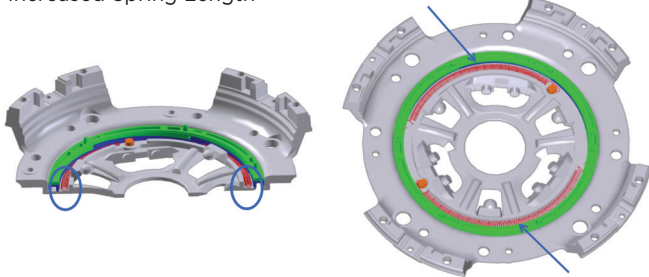
- Freightliner
- Western Star
- Thomas Built Bus
- Travel Centers of America
- Petro

Alliance Part Number	O.E.M. Reference	Adjustment Type	Bearing Type	Plate Load, lb	Torque Rating (lb-ft)	Carrier Style	No. of Springs	Min. Flywheel Opening
15-1/2" X 2" AUTOSET CLUTCH®								
ABP N25 209701 74	209701-74	Auto-Adjust	Triple-Zerk	3600	1650	4-Paddle	10	8.5"
ABP N25 209701 82	309701-82	Auto-Adjust	Triple-Zerk	3600	1700	4-Paddle	7	10"
ABP N25 309701 24	309701-24 309701-34	Auto-Adjust	Triple-Zerk	3600	1750	4-Paddle	7 (Pre-Damper)	10"
ABP N25 209701 51 (MACK® Only)	309701-51	Auto-Adjust	Triple-Zerk	3600	1760	4-Paddle	9	10"
ABP N25 209701 91 (MACK® Only)	309701-91	Auto-Adjust	Triple-Zerk	3600	1760	6-Paddle	9	10"
ABP N25 209391 93	209391-93	Auto-Adjust	Triple-Zerk	4000	1810	6-Paddle	10	8.5"
ABP N25 209701 94 (MACK® Only)	309701-98	Auto-Adjust	Triple-Zerk	4000	1850	6-Paddle	9	10"
ABP N25 209701 20	209701-20	Auto-Adjust	Triple-Zerk	4000	1860	6-Paddle	7	10"
ABP N25 309701 25	309701-25	Auto-Adjust	Triple-Zerk	4000	2050	6-Paddle	7 (Pre-Damper)	10"

Mack® is a registered trademark of the Volvo Group.

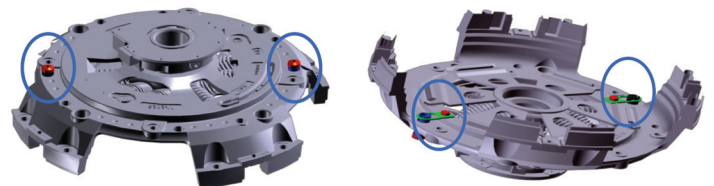
Two Heavy Duty Springs create a strong and balanced actuation

- High Grade / Stainless Steel Spring
- Increased Spring Length



Over Adjustment Protection

Two internal straps connect the clutch cover to the adjusting ring. The internal straps hold the adjusting ring and cams in place when shock to the truck occurs (dock collision or terrain impact)



WARRANTY COVERAGE

Heavy Duty Clutches: 2 Years, Unlimited Miles

Receive an additional year warranty when installing an Alliance clutch with an Alliance clutch installation kit (refer to page 7 for further details).

Must provide proof of installation of both components at the time of filing.
Must use a ground or new flywheel.

Medium Duty Clutches: 1 Year, Unlimited Miles

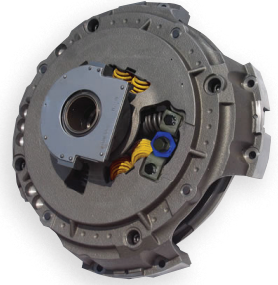
PRODUCT COMPARISON

	Alliance Clutches	Eaton Easy Pedal Advantage® & Solo Advantage®	Eaton EverTough®
Friction Material	O.E.M. Quality Facings	O.E.M. Facings	Aftermarket Facings
Bearing	3 Grease Zerks	3 Grease Zerks	2 Grease Zerks
Lube Intervals	50,000 Miles	50,000 Miles	25,000 Miles

Eaton Easy Pedal Advantage, Solo Advantage & EverTough are all registered trademarks of Eaton Corporation.

HEAVY DUTY – EASY EFFORT®

EASY EFFORT® clutch line decreases the pedal effort required once the clutch has reached the disengagement point. The combined effort of the 6 pressure springs with the 3 extra assist springs allows for a 30% reduction.



Alliance Part Number	O.E.M. Reference	Adjustment Type	Bearing Type	Plate Load, lb	Torque Rating (lb-ft)	Carrier Style	No. of Springs	Min. Flywheel Opening
14" X 2" EASY EFFORT®								
ABP N25 108050 59	108050-59	Spring-A-Just	Single-Zerk	3200	1400	4-Paddle	8	7"

15-1/2" X 2" EASY EFFORT®								
ABP N25 108391 81	108391-81	Spring-A-Just	Triple-Zerk	3600	1450	4-Paddle	8	7"
ABP N25 208925 74	208925-74	Spring-A-Just	Triple-Zerk	3600	1650	4-Paddle	10	8.5"
ABP N25 208925 82	308925-82	Spring-A-Just	Triple-Zerk	3600	1700	4-Paddle	7	10"
ABP N25 308925 24	308925-24 308925-34	Spring-A-Just	Triple-Zerk	3600	1750	4-Paddle	7 (Pre-Damper)	10"
ABP N25 208925 51 (MACK® Only)	308925-51	Spring-A-Just	Triple-Zerk	3600	1760	4-Paddle	9	10"
ABP N25 208925 91 (MACK® Only)	308925-91	Spring-A-Just	Triple-Zerk	3600	1760	6-Paddle	9	10"
ABP N25 108391 93	108391-93	Spring-A-Just	Triple-Zerk	4000	1810	6-Paddle	10	8.5"
ABP N25 208925 94 (MACK® Only)	308925-98	Spring-A-Just	Triple-Zerk	4000	1850	6-Paddle	9	10"
ABP N25 208925 20	308925-20	Spring-A-Just	Triple-Zerk	4000	1860	6-Paddle	7	10"
ABP N25 308925 25	308925-25	Spring-A-Just	Triple-Zerk	4000	2050	6-Paddle	7 (Pre-Damper)	10"

Product listed is a sampling of part numbers available, contact your local distributor for additional offering.

15-1/2" X 2" EASY EFFORT® TORQUE PERFORMANCE (INCLUDES SPLINE SAVER)

ABP N25 208925 25 TP	308925-25	Spring-A-Just	Triple-Zerk	4000	2050	6-Paddle	6	10"
ABP N25 EA60289 TP	EA60289	Spring-A-Just	Triple-Zerk	4200	2400	6-Paddle	6	10"
ABP N25 208925 3000 TP	N/A	Spring-A-Just	Triple-Zerk	4800	3000	6-Paddle	6	10"

AMT – MaxShift CLUTCH®

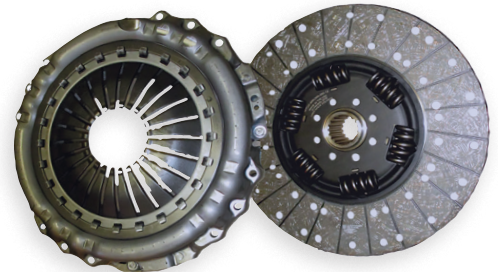
Alliance Part Number	O.E.M. Reference	Spline	Plate Load, lb.	Torque Rating (lb-ft)	No. of Springs	Application	Clutch Brake (Included)
15-1/2" MaxShift CLUTCH®							
ABP N25 122002 35A	122002-35A	14	4200	1850	7 (Pre-Damper)	UltraShift® & UltraShift Plus®	ABP N25 K4134
ABP N25 122003 42A	122003-42A	14	4200	2250	7 (Pre-Damper)	UltraShift® & UltraShift Plus®	ABP N25 K4134

UltraShift® & UltraShift Plus® are registered trademarks of Eaton Corporation



AMT – DETROIT DT12

IAT Part Number	O.E.M. Reference	Spline	Torque Rating (lb-ft)	No. of Springs	Alliance Alignment Tool	Alliance Actuator
430MM X 50MM STAMPED STEEL SINGLE PLATE						
IAT K4489CL	A02-82500-001 A02-14027-008 A02-14135-000 K-4489CL	18-Involute	1850	6	ABP N25 M2195	ABP N25 A0032502115
IAT A0214108001	A02-14108-001, A02-14108-002	18-Involute	1850	5	ABP N25 M2195	ABP N25 A0032502115



AMT – VOLVO I-SHIFT / MACK® mDRIVE

Alliance Part Number	O.E.M. Reference	Spline	Torque Rating (lb-ft)	Friction Material	No. of Springs	Application	Alignment Tool (not included)	Actuator
430MM X 50MM STAMPED STEEL SINGLE PLATE								
ABP N25 104461 1	104461-1 (Eaton) 3400 700 359 (Sachs)	24-Involute	1850	Organic	6	A, B, C, D, E Series	ABP N25 HT 50mm A	ABP N25 22429963
ABP N25 3400700601	3400 700 601	24-Involute	2360	Organic	5	F Series	ABP N25 HT 50mm A	ABP N25 22429963

Mack® is a registered trademark of the Volvo Group.

CLUTCH ASSEMBLIES

MEDIUM DUTY – STAMPED STEEL



Alliance Part Number	O.E.M. Reference	Adjustment Type	Plate Load, lb	Torque Rating (lb-ft)	Carrier Style	No. of Springs	Min. Flywheel Opening
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14" X 1-3/4" STAMPED STEEL SINGLE PLATE

ABP N25 107683 5	107683-5	Spring-A-Just	3200	650	3-Paddle	8	7"
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14" X 1-3/4" STAMPED STEEL TWO PLATE

ABP N25 107137 8	107137-8	Manual	2000	900	3-Paddle	8	7"
ABP N25 107237 10	107237-10	Spring-A-Just	2000	900	3-Paddle	8	7"
ABP N25 107237 22	107237-22	Spring-A-Just	2500	950	3-Paddle	8	7"
ABP N25 107237 24	107237-24	Spring-A-Just	2500	1050	4-Paddle	8	7"

14" X 2" STAMPED STEEL TWO PLATE

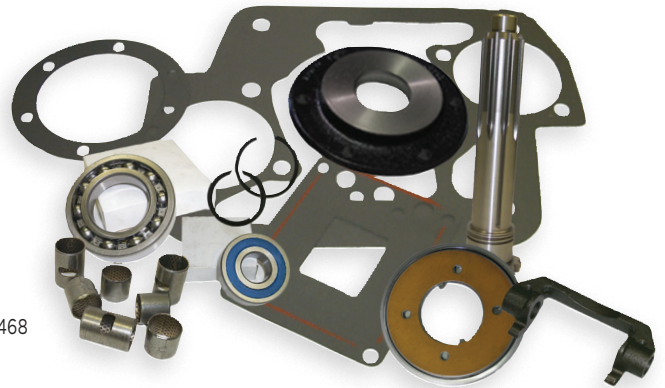
ABP N25 107342 11	107342-11	Spring-A-Just	2000	900	3-Paddle	8	7"
ABP N25 107342 22	107342-22	Spring-A-Just	2500	950	3-Paddle	8	7"
ABP N25 107342 20	107342-20	Spring-A-Just	2500	1050	4-Paddle	8	7"
ABP N25 107508 11	107508-11	Spring-A-Just	2800	1150	4-Paddle	8	7"

365MM X 1-3/4" SINGLE & TWO PLATE

ABP N25 104100 1	104100-1	External	3200	520	3-Paddle	8	7"
ABP N25 104100 2	104100-2	External	3200	660	3-Paddle	8	7"
ABP N25 104200 1	104200-1	External	2500	860	3-Paddle	8	7"
ABP N25 153400000015	400001167 153400000015 153482128802	External	3200	660	3-Paddle	6	7.5"

CLUTCH INSTALLATION KIT

Prevent the need to pull your transmission again after you have completed your clutch installation. Replace all clutch related wear components to ensure smooth engagement and reduce the chance of misalignment. Receive an additional year warranty when installing an Alliance clutch installation kit with an Alliance clutch (refer to page 7 for additional details).



ABP N25 K2468

Parts Included:

- Clutch Brake
- Clutch Release Fork
- Cross Shaft Bushings
- Front Bearing Cover
- Gaskets (Clutch Housing, Shift Lever & Front Bearing Cover)
- High Temperature Pilot Bearing
- Input Shaft
- Input Shaft Bearing
- Retaining Rings

Alliance Part Number	O.E.M. Reference	Application
ABP N25 K2468	K-2468	Fuller RT Series
ABP N25 K2468 HCB	K-2468	Fuller RT Series (With Hinged Clutch Brake)
ABP N25 K3762	K-3762	Fuller RT Series (Severe Duty - PTO Applications)
ABP N25 K3599	K-3599	Fuller MACK® RT Series
ABP N25 K4125	K-4125	Fuller RT Series (With Hydraulic Clutch Fork)
ABP N25 K3768	K-3768	Fuller RT Series (With 14-Spline Input Shaft)
ABP N25 K3600	K-3600	Fuller FR Series
ABP N25 K3601	K-3601	Fuller MACK® FR Series
ABP N25 K4124	K-4124	Fuller FR Series (With Hydraulic Clutch Fork)
ABP N25 K3602	K-3602	Fuller FR Series (With Original Design Input Shaft - 4302315)
ABP N25 K4145	K-4145	UltraShift PLUS Series
ABP N25 M2059		Meritor RM, RMO, RMX & G Series
ABP N25 M2031		Basic Clutch Installation Kit: 2" Torque Limiting Clutch Brake, Clutch Fork, & (4) Cross Shaft Bushings
ABP N25 CBK MAN		Clutch Bundle Kit - Manual (used with new / rebuilt transmission): High Temp Pilot Bearing, 2" Torque Limiting Clutch Brake, Clutch Fork, Gasket Kit, Cross Shaft Bushing Kit
ABP N25 CBK HYD		Clutch Bundle Kit - Hydraulic (used with new / rebuilt transmission): High Temp Pilot Bearing, 2" Torque Limiting Clutch Brake, Hydraulic Clutch Fork, Gasket Kit

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ALLIANCE PARTS CLUTCH PROGRAM HOTLINE: 844-854-8034 / allianceparts.com

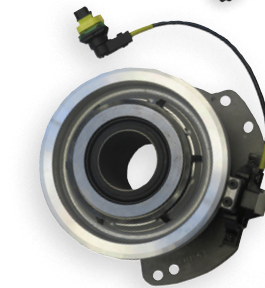
CLUTCH FORKS, CROSS SHAFTS, INPUT SHAFTS, & BUSHINGS

Alliance Part Number	O.E.M. Reference	Description
ABP N25 105C137	105C-137	Clutch Release Fork
ABP N25 A7786	A-7786	Clutch Release Fork (Hydraulic)
ABP N25 106C1185	106C-1185	Cross Shaft (5-3/4")
ABP N25 125596	125596	Clutch Roller Fork (365mm Clutches)
ABP N25 A8133	A-8133	Roller Clutch Fork (UltraShift PLUS)
ABP N25 A7414	A-7414	Hydraulic Clutch Fork (Volvo)
ABP N25 106C1498	106C-1498	Cross Shaft (6-1/2")
ABP N25 106C1047	106C-1047	Cross Shaft (9-1/2")
ABP N25 2005406C1	2005406C1	9-3/4" Cross Shaft (International - 5000 & 900 Series)
ABP N25 483767C1	483767C1	8" Cross Shaft (International - 3000 / 4000 Series)
ABP N25 476337C2	476337C2	8-1/2" Cross Shaft (International - 2000 Heavy Duty, 3000 School Bus & 4000 Medium Duty Trucks)
ABP N25 K210883	K210-883	9" Cross Shaft (Kenworth)
ABP N25 25173583	25173583	9-1/8" Cross Shaft (MACK®)
ABP N25 601093	06-01093	9-5/8" Cross Shaft (Peterbilt - 387 Series)
ABP N25 S1659	S-1659	10-Spline Input Shaft
ABP N25 S2890	S-2890	14-Spline Input Shaft
ABP N25 S3127	S-3127	Input Shaft - UltraShift®
ABP N25 128C20 4	128C-20	Set of 4 Cross Shaft Bushings



AMT CLUTCH ACTUATORS & SOLENOID VALVES

Alliance Part Number	O.E.M. Reference	Application
ABP N25 22429963	22429963, 22809232, 21580956, 21465235, 21320923, 20806451, 6482000155	Volvo I-Shift
ABP N25 22327069	22327069	Solenoid Valve 12V (Mack/Volvo)
ABP N25 A0032502115	A 003 250 21 15, 6482 000 218	Detroit Diesel DT12



PILOT BEARINGS

Alliance Part Number	O.E.M. Reference	Description
ABP N25 6203ZZ	6203-ZZ	Pilot Bearing (1.574" x .668")
ABP N25 62052RS	6205-2RS	High Temp Pilot Bearing (2.046" x .983")
ABP N25 6205ZZ	6205-ZZ	Pilot Bearing (2.046" x .983")
ABP N25 6206ZZ	6206-ZZ	Pilot Bearing (2.440" x 1.180")
ABP N25 62062RS	6206-2RS	High Temp Pilot Bearing (2.440" x 1.180")
ABP N25 63062RS	6306-2RS	High Temp Pilot Bearing (2.833" x 1.179")
ABP N25 63062RS SR	46AX540	High Temp Pilot Bearing w/Snap Ring (MACK®) (2.833" x 1.179")

Mack® is a registered trademark of the Volvo Group.

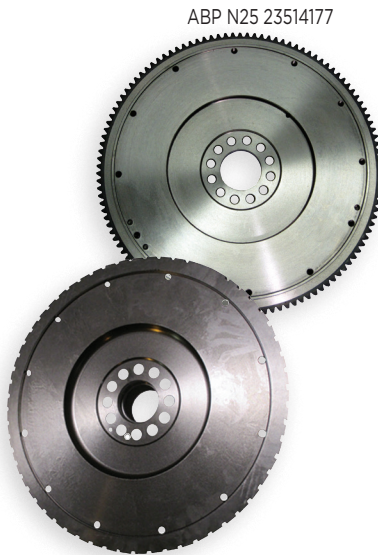
CLUTCH BRAKES

Alliance Part Number	O.E.M. Reference	Description
ABP N25 127760	127760	2" Torque Limiting Clutch Brake (.380" thick)
ABP N25 127760 450		2" Torque Limiting Clutch Brake (.450" thick)
ABP N25 127760 500		2" Torque Limiting Clutch Brake (.500" thick)
ABP N25 127175	127175	1-3/4" Two-Piece Clutch Brake
ABP N25 127200	127200	2" Two-Piece Clutch Brake
ABP N25 BK312	BK-312	1-3/4" Hinged Clutch Brake (.380" thick)
ABP N25 BK312 500		1-3/4" Hinged Clutch Brake (.500" thick)
ABP N25 BK313	BK-313	2" Hinged Clutch Brake (.380" thick)
ABP N25 BK313 450		2" Hinged Clutch Brake (.450" thick)
ABP N25 BK313 500		2" Hinged Clutch Brake (.500" thick)
ABP N25 BK313 550		2" Hinged Clutch Brake (.550" thick)
ABP N25 125C41	125C-41	2" Clutch Brake Washer (.125" thick)
ABP N25 125C41 187		2" Clutch Brake Washer (.187" thick)
ABP N25 K4134	K-4134	MaxShift Clutch® Clutch Brake (used with UltraShift® & UltraShift Plus® Transmissions)



UltraShift® is a registered trademark of Eaton Corporation.

FLYWHEELS



ABP N25 23514177

ABP N25 A472030110572

Alliance Part Number	O.E.M. Reference	Application
ABP N25 2569653	256-9653	CAT C-15, C-16, C-18, 3406
ABP N25 1265875	1265875	CAT 3116 / 3126
ABP N25 3071615	3071615	Cummins L-10 / M-11
ABP N25 3609903	3071535 3609903	Cummins NT855, Small Cam / Big Cam, N14
ABP N25 3016495	3016495	Cummins NT855, Small Cam / Big Cam, N14, (Pot-Type)
ABP N25 3680922	3680922	Cummins ISX Signature 600
ABP N25 4933458	3921263 4933458	Cummins 5.9L (B Series)
ABP N25 23514177	23514177	Detroit Series 60
ABP N25 A4710300705	A471 030 07 05	Detroit DD15 (w/ AMT)
ABP N25 A472030110572	A472 030 11 05	Detroit DD15 (w/ manual transmission)
ABP N25 A4600300305	A460 030 0305	Detroit Diesel MBE 4000
ABP N25 530GB3145BM	530GB3145BM	MACK® E7
ABP N25 530GB3170M	530GB3170M	MACK® E7-E Tech
ABP N25 21514061	21514061	MACK® / Volvo MP7
ABP N25 1818214C91	1818214C91	Navistar 7.3L 444E
ABP N25 1821915C91	1821915C91	Navistar DT466E
ABP N25 1809144C91	1809144C91	Navistar 6.9L / 7.3L
ABP N25 21184666	21184666	Volvo I-Shift
ABP N25 20730056	20730056	Volvo VED12

BELL HOUSING COVER KITS & HOSES



ABP N25 4305230 8

Alliance Part Number	O.E.M. Reference	Description
ABP N25 4305230 8	4305230-8	Bell Housing Inspection Plate w/ 8" Hose
ABP N25 4305230 9	4305230-9	Bell Housing Inspection Plate w/ 9" Hose
ABP N25 CLT007P	CLT007P	7" Grease Hose
ABP N25 CLT008P	CLT008P	8" Grease Hose
ABP N25 CLT009P	CLT009P	9" Grease Hose
ABP N25 CLT012P	CLT012P	12" Grease Hose

CLUTCH ALIGNMENT TOOLS



Alliance Part Number	O.E.M. Reference	Description
ABP N25 AT175AEX	AT175AEX	1-3/4" Spline x 1" Pilot
ABP N25 AT175EX	AT175EX	1-3/4" Spline x 1.18" Pilot
ABP N25 AT200EX	AT200EX	2" Spline x 1.18" Pilot
ABP N25 AT214	AT214	2" Spline x 1.18" Pilot (14-Spline Input Shaft)
ABP N25 RR1009CL	RR1009CL	2" Spline x 1.18" Pilot (Hardened Steel, 14-Spline, UltraShift®)
ABP N25 HT 50mmA	HT 50mmA	50mm x 1.18 Pilot (24-Spline, Volvo I-Shift / Mack® mDrive)

Mack® is a registered trademark of the Volvo Group.

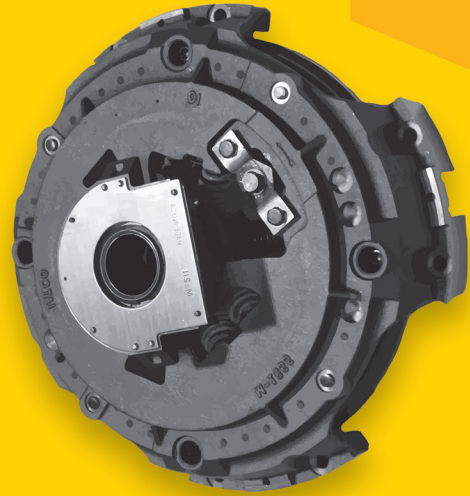
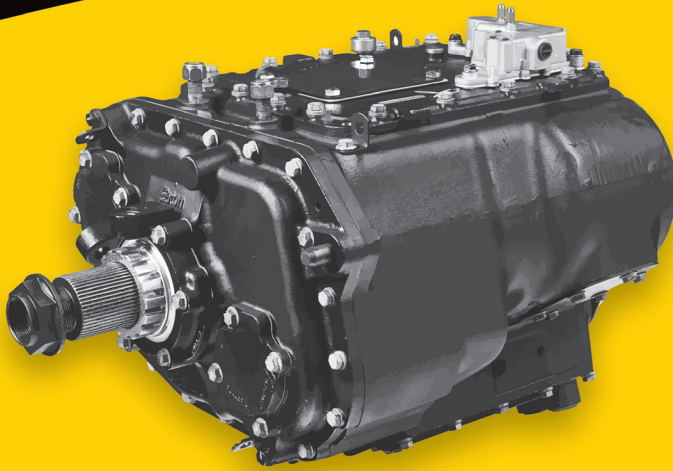
CLUTCH JACK

Alliance Part Number	O.E.M. Reference
ABP N25 CJ40500	14" & 15-1/2" Clutch Jack (Includes 1-3/4" & 2" Spline) (300 lb capacity)
ABP N25 T109	14-Spline Clutch Jack Shaft Adapter (Used w/ UltraShift® or MaxShift Clutch®)

UltraShift® is a registered trademark of Eaton Corporation.

ABP N25 CJ40500





TRANSMISSION + CLUTCH BUNDLE

3 YEAR/UNLIMITED MILE TRANSMISSION & CLUTCH WARRANTY

STEP
01

SELECT A REMAN TRANSMISSION

Alliance Truck Parts products are remanufactured following a strict teardown, cleaning, inspection, assembly and testing process that is unmatched in the industry and ensures uptime and reliability.

All Alliance remanufactured transmissions pass rigorous testing methods to exceed customer quality demands.

STEP
02

SELECT AN ALLIANCE AUTOSET OR EASY EFFORT CLUTCH

Alliance Truck Parts line of clutches are built new to OE specifications for most makes and models to ensure confident, smooth, shifting and long clutch life. Plus, Alliance's Easy Effort clutches feature a spring assist to prevent driver fatigue by reducing pedal effort by 30%.

Alliance clutches are backed by a 2 year standard National warranty, which is upgraded to 3 years when bundled.

STEP
03

SELECT CLUTCH BUNDLE KIT

The clutch bundle kit provides all necessary components to complete the clutch installation. Determine the type of linkage the vehicle is equipped with and choose a clutch bundle kit:

Manual Linkage System : ABP N25 CBK MAN

- 2" Torque Limiting Clutch Brake
- High Temperature Pilot Bearing
- Standard Clutch Fork
- Gasket Kit
- Cross Shaft Bushings

Hydraulic Linkage System: ABP N25 CBK HYD

- 2" Torque Limiting Clutch Brake
- High Temperature Pilot Bearing
- Hydraulic Clutch Fork
- Gasket Kit

STEP
04

INSTALL WITH A PS-386 APPROVED LUBRICANT

Approved PS-386 transmission fluid reduces wear as well as improving fuel economy. When you use PS-386 approved transmission fluid in conjunction with the Alliance Transmission + Clutch bundle you're ensuring reduced operation costs and extending the life of your transmission.

Approved PS-386 lubricants can be located on the registration page.

YOU MUST REGISTER AT ATPBUNDLEWARRANTY.COM TO RECEIVE THE ALLIANCE REMAN BUNDLE WARRANTY