

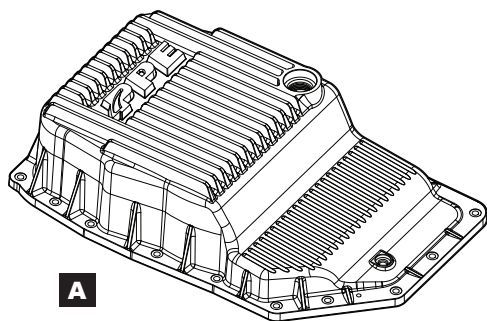
# **Heavy-Duty Cast Aluminum Transmission Pan**

***GM with 6L90 Transmission***

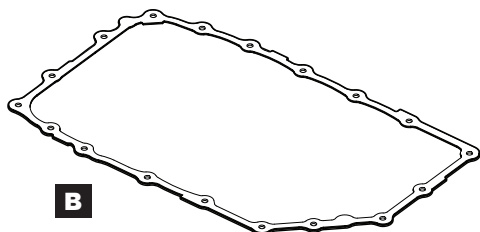
***(128051900, 128051910, 128051920)***

## **Installation Guide**

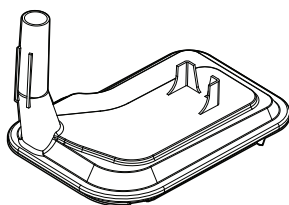




**A**



**B**



**C**

**D**



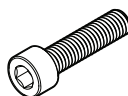
**E**



**F**



**G**



**H**



**I**



**J**

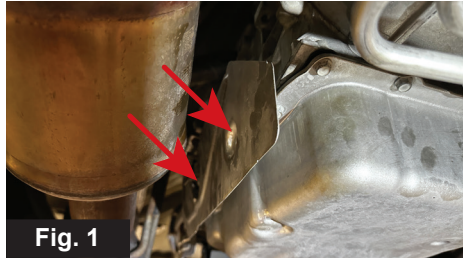


## CONTENTS:

- A (1) Transmission Pan
- B (1) Transmission Gasket (optional)
- C (1) Transmission Filter
- D (1) Magnetic Drain Plug with O-Ring (installed)
- E (1) 1/8" NPT plug (installed)
- F (1) Transmission Oil Level Check Plug (installed)
- G (18) M6 Allen Bolts
- H (18) M6 Flat Washers
- I (4) Aluminum Filter Support Pads (installed)
- J (4) M6 Flat Head Screws (installed)

## INSTALLATION:

1. Vehicle off and secure. Let the engine cool.
2. Remove the transmission pan heat shield. (**Fig. 1**)

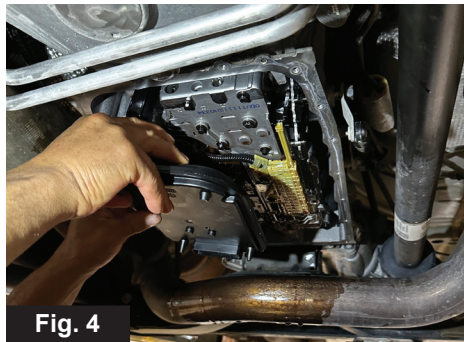


3. Remove the factory bolts and factory transmission pan. (**Fig. 2 & 3**)

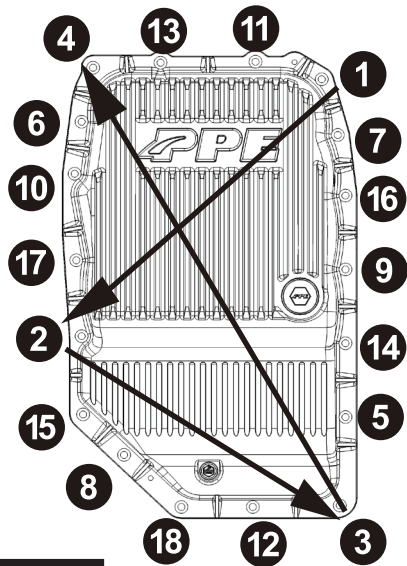


4. Replace the old transmission filter with the PPE Transmission Filter (**C**). Ensure the filter is properly aligned and securely seated. (**Fig. 4**)

**Note:** the old filter may be stuck in the pump after the filter is removed. Carefully remove the old seal, then remove the new seal from the PPE filter and gently tap into the fluid pick up tube before installing the PPE filter. It is also okay to keep using the old seal without removing it if the rubber lip seal is in good shape.



5. Double check the M6 Flat Head Screws (**J**) securing the Filter Support Pads (**I**) is tight. Install the Flat Gasket (**B**) or reuse the factory transmission gasket, then attach the Transmission Pan (**A**) using the supplied M6 Screws (**G**) and M6 Washers (**H**). Torque the bolts to 8-10 lb-ft following the crossing-pattern sequence shown below.  
(Fig. 5 & 6)



6. Check that the Drain Plug (**D**) and NPT Plug (**E**) are tight. Tighten the drain plug to 18 lb-ft.
7. Reinstall the heat shield.



## TRANSMISSION FLUID FILL PROCEDURE:

Follow GM Service Manual for exact steps.

The following steps were performed in our test fitment on a 2021 Silverado 2500HD 6.6L V8 Gas. The stock transmission pan in this truck had a fluid level check port. Only the PPE Deep Pan and Filter were installed during our test fitment.

### FOR REFERENCE ONLY:

1. Lift the plunger and remove the transmission fluid fill tube plug on the side of the transmission.
2. Roughly measure how much fluid drained out during installation.
3. Add 1.5 quarts to the amount of fluid measured in step 2 as an initial fill through the fill tube.
4. Start and idle the engine for 60 seconds.
5. Shift through each shifter position (R, N, D, L). Stay in each position for at least 3 seconds. Shift back to P.
6. Brake torque to bring the transmission fluid temperature to 95 F.
7. Remove PPE Fluid Level Check Plug.
8. **A.** If fluid starts flowing out from the level check port, wait until the fluid drips in a non-continuous manner  
  
**B.** If no fluid comes out, add more fluid through the fill tube until it drips.
9. Reinstall Fluid Level Check Plug to 12 lb-ft.

***Installation Complete***

## **DISCLAIMER OF LIABILITY**

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