

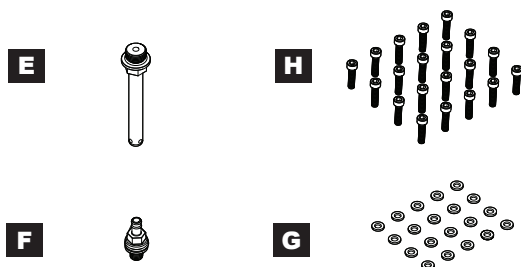
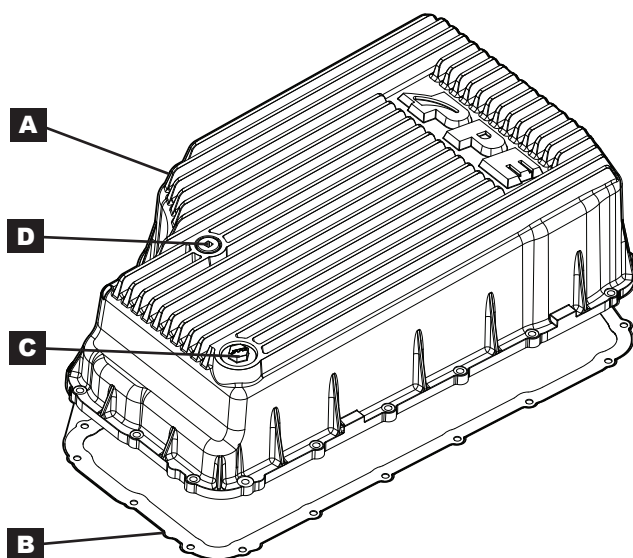
# **Heavy-Duty Cast Aluminum Deep Transmission Pan**

***2020-2024 Ford SuperDuty 6.7L Diesel  
with 10R140 Transmission***

***(328053500, 328053510, 328053520)***

## **Installation Guide**



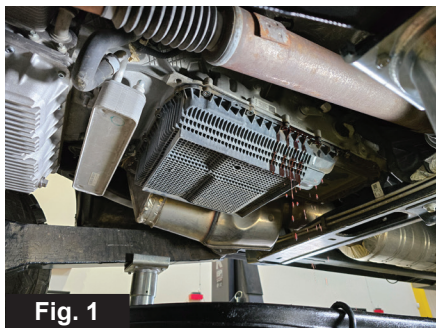


## **CONTENTS**

- A. (1) Transmission Pan
- B. (1) Flat Gasket (Optional)
- C. (1) Magnetic Drain Plug (with O-ring), Installed
- D. (1) Fill Plug (with O-ring), Installed
- E. (1) Standpipe (with O-ring)
- F. (1) Fill Fitting (with O-ring)
- G. (20) M6 Flat Washers
- H. (20) M6 Allen Bolts

## INSTALLATION

1. Park vehicle on a flat surface and allow transmission fluid to cool down.
2. Remove stock pan heat shields, then remove bolts and double-end studs.
3. Carefully drop stock pan and allow fluid to drain into a fluid drain pan. **(Fig.1)**
4. Remove stock pan gasket.
5. A. If reusing stock pan gasket, carefully check gasket condition, replace if necessary. Place gasket into the gasket seat on the PPE Transmission Pan Flange surface, with the side with the retaining ridges facing down. Align the half-moon shapes of the gasket with the corresponding locations of the gasket seat. Make sure the whole gasket is pressed all the way down into the seat. **(Fig. 2)**  
B. As an alternative, use the non-reusable paper gasket included in the kit. Simply align the bolt holes of the paper gasket and the pan surface



## 10R140 Deep Transmission Pan

6. Make sure the pre-applied anti-seize compound is present on the Standpipe E threads. Apply a thin layer of anti-seize if needed. Install Standpipe to the threaded port on the inside of the PPE pan (19mm or 3/4"), tighten until the two metal surfaces come in contact, do not over-torque. **(Fig. 3 and Fig. 4)**



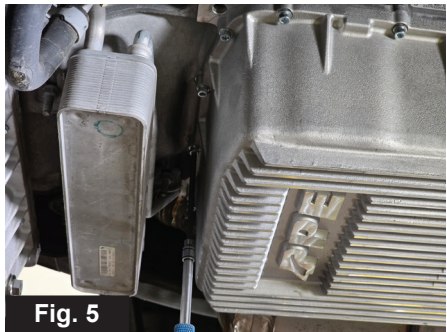
**Fig. 3**

7. Make sure the Drain Plug C is tightened (18 lb.-ft).



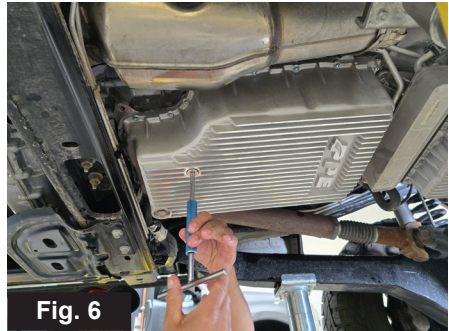
**Fig. 4**

8. Utilizing the washers and Allen bolts (5mm) included, install PPE Transmission Pan. Install all bolts finger-tight first, then tighten to 108 lb.-in in a crossing pattern. **(Fig. 5)**



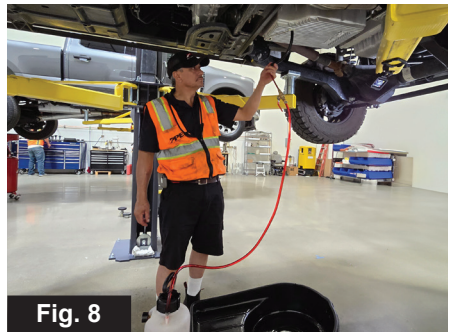
**Fig. 5**

9. Remove the preinstalled Fill Plug D (1/4" square). Make sure the pre-applied anti-seize compound is present on the threads of the Fill Fitting F. Apply a thin layer of anti-seize if needed. Install the Fill Fitting F to the same location to 12 lb.-ft. (Fig. 6 and Fig. 7)



## FILLING TRANSMISSION FLUID

10. Utilizing a 3/8" rubber hose and a universal fluid dispenser, add 12.5 quarts of transmission fluid as an initial fill through the Fill Fitting. (Fig. 8)



**Note:** The initial fill amount will vary if any additional components were removed or serviced (valve body, for instance). In that case, measure the total amount of fluid that was drained during the service, add that amount by 7 quarts, and use the summed result as the initial fill amount.

11. Start the engine and let it idle for approximately 30 seconds.
12. Remove the rubber hose from the Fill Fitting and observe if fluid starts seeping from the Fitting. If not, add fluid in an increment of 0.5 quart until fluid starts to free flow out of the fitting. Allow fluid to flow until it stops flowing continuously.
13. Remove the Fill Fitting and Install the Fill Plug, torque to 12 lb.-ft.
14. Test drive the vehicle, try to bring it across all the gears 1 through 10. Monitor the transmission temperature gauge until it reaches 200°F. Bring vehicle back to Park. While vehicle is in Park and engine is running, remove Fill Plug and repeat Step 12 and 13.

***Installation and fluid filling is now complete***

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