

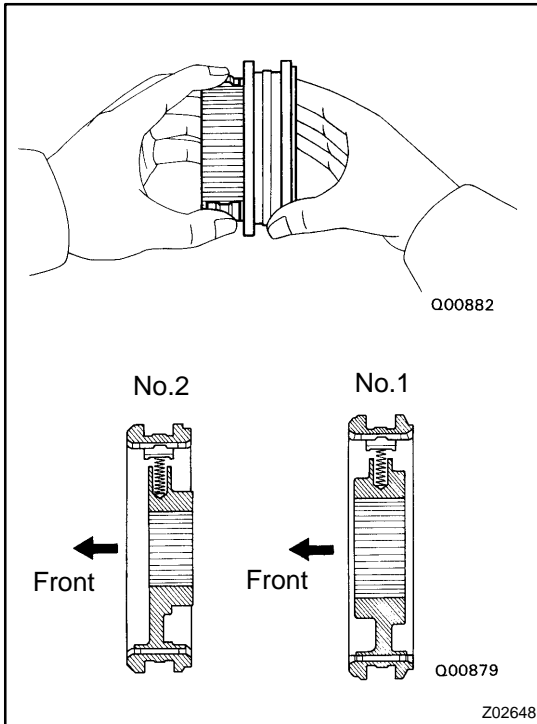
REASSEMBLY

HINT:

Coat all of the sliding and rotating surfaces with gear oil before assembly.

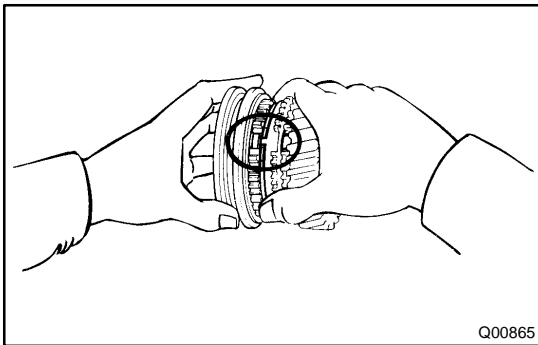
1. INSTALL NO.1 AND NO.2 CLUTCH HUBS INTO HUB SLEEVE

- (a) Install the 3 shifting key springs to the clutch hub.
- (b) While pushing the shifting key spring with a screwdriver, install the 3 shifting keys.
- (c) While pushing the 3 shifting keys, install the clutch hub to the hub sleeve, as shown.

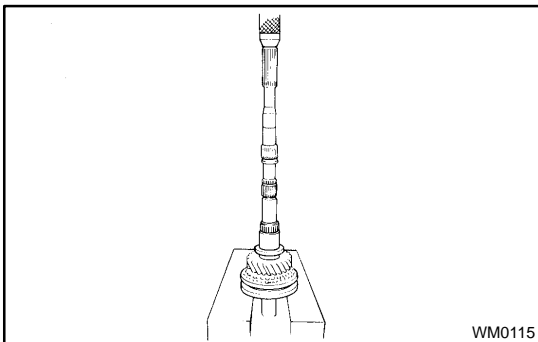


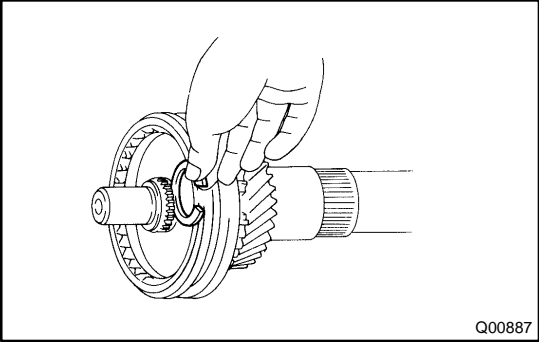
2. INSTALL 3RD GEAR AND NO.2 CLUTCH HUB ON OUTPUT SHAFT

- (a) Apply gear oil to the shaft.
- (b) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.



- (c) Using a press, install the 3rd gear and No.2 clutch hub.





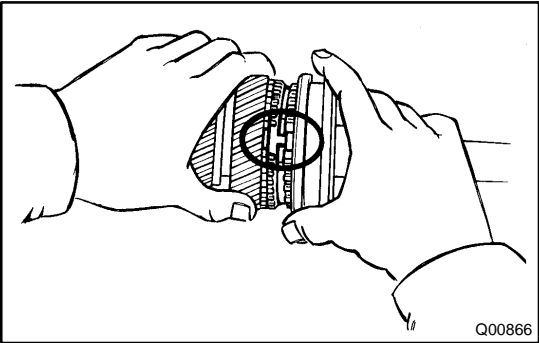
3. **INSTALL SNAP RING**

- (a) Select a snap ring that will allow minimum axial play.

| Mark | Thickness mm (in.) |
|------|---------------------------|
| C-1 | 1.75–1.80 (0.0689–0.0709) |
| D | 1.80–1.85 (0.0709–0.0728) |
| 11 | 1.86–1.91 (0.0732–0.0752) |
| 12 | 1.92–1.97 (0.0756–0.0776) |
| 13 | 1.98–2.03 (0.0780–0.0799) |
| 14 | 2.04–2.09 (0.0803–0.0823) |
| 15 | 2.10–2.15 (0.0827–0.0846) |

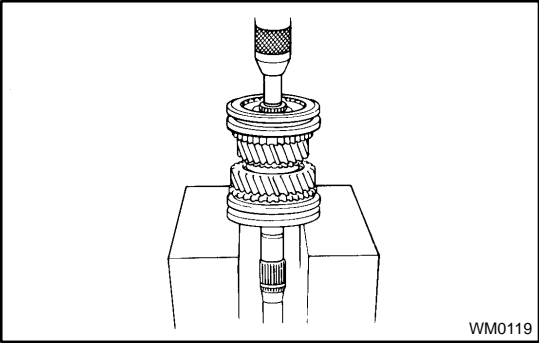
- (b) Using a snap ring expander, install the snap ring.

4. **INSPECT 3RD GEAR THRUST CLEARANCE**
(See page [MT-22](#))



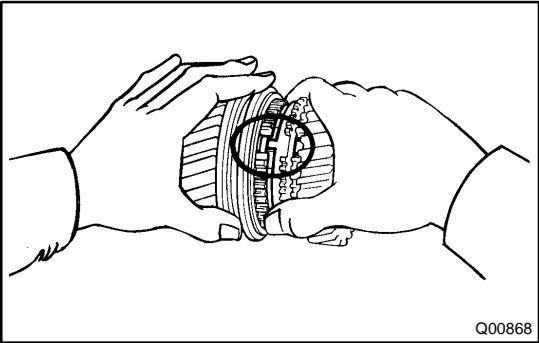
5. **INSTALL 2ND GEAR AND NO.1 CLUTCH HUB**

- (a) Apply gear oil to the shaft and needle roller bearing.
(b) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.
(c) Install the needle roller bearing in the 2nd gear.



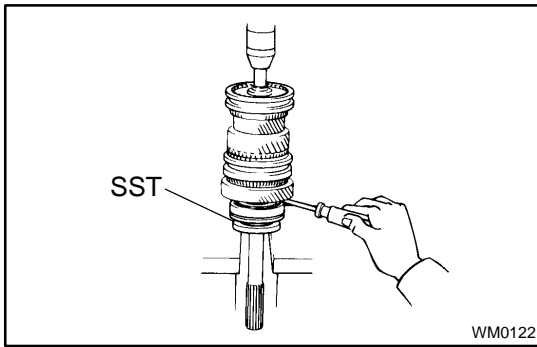
- (d) Using a press, install the 2nd gear and No.1 clutch hub.

6. **INSPECT 2ND GEAR THRUST CLEARANCE**
(See page [MT-22](#))



7. **INSTALL LOCKING BALL AND 1ST GEAR ASSEMBLY**

- (a) Install the locking ball in the shaft.
(b) Apply gear oil to the bearing.
(c) Assemble the 1st gear, synchronizer ring, needle roller bearing and bearing inner race.
(d) Install the assembly on the output shaft with the synchronizer ring slots aligned with the shifting keys and turn the inner race to align it with the locking ball.

**8. INSTALL OUTPUT SHAFT CENTER BEARING**

Using SST and a press, install the bearing on the output shaft with the outer race snap ring groove toward the rear.

HINT:

Hold the 1st gear inner race to prevent it from falling.

SST 09506-35010

9. INSPECT 1ST GEAR THRUST CLEARANCE

(See page [MT-22](#))