

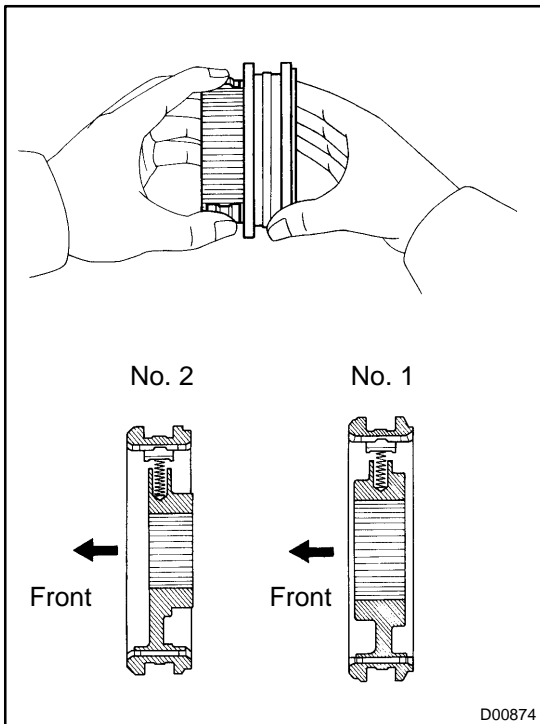
## REASSEMBLY

### HINT:

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

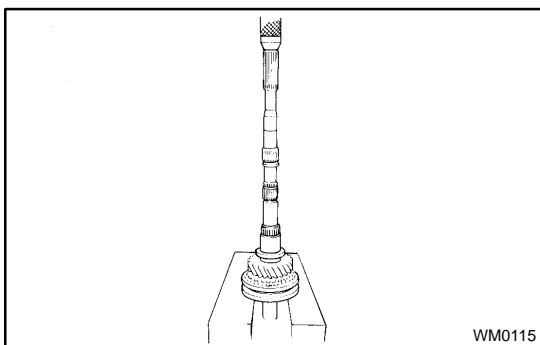
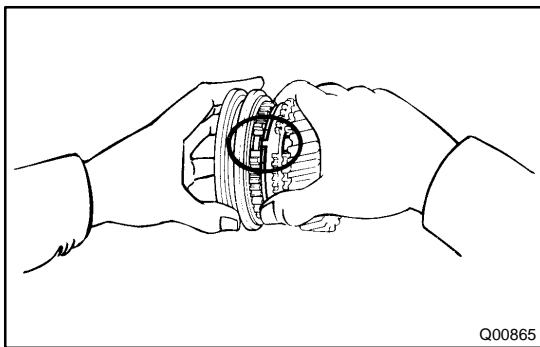
### 1. INSTALL NO.1 AND NO.2 CLUTCH HUBS INTO HUB SLEEVE

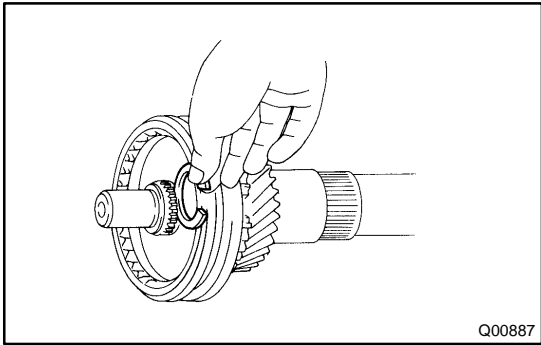
- (a) Install the 3 shifting key springs to the clutch hub.
- (b) While pushing the shifting key spring with a screwdriver, install the 3 shifting keys.
- (c) While pushing the 3 shifting keys, install the clutch hub to the hub sleeve, as shown.



### 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**

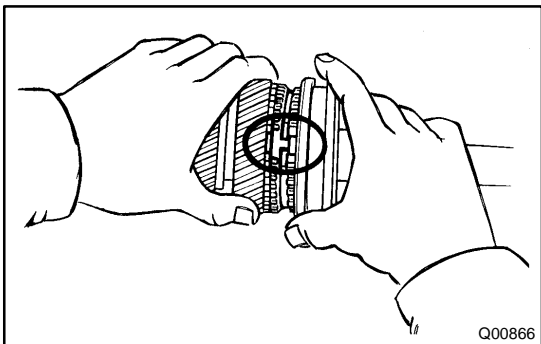
(a) Select a snap ring that allows the minimum axial play.

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.

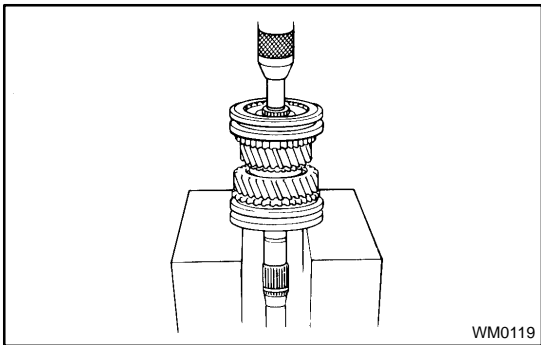
**4. INSPECT 3RD GEAR THRUST CLEARANCE**

(See page [MT-28](#))



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

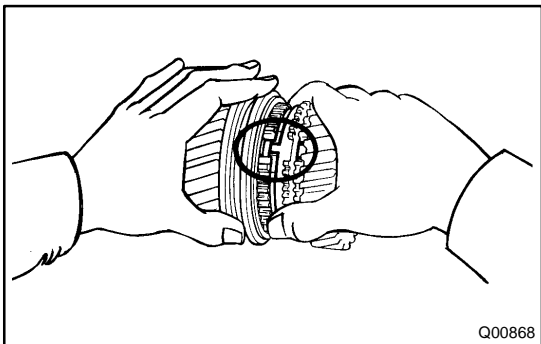
- (a) Apply gear oil to the shaft and needle roller bearing.
- (b) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.
- (c) Install the needle roller bearing in the 2nd gear.



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

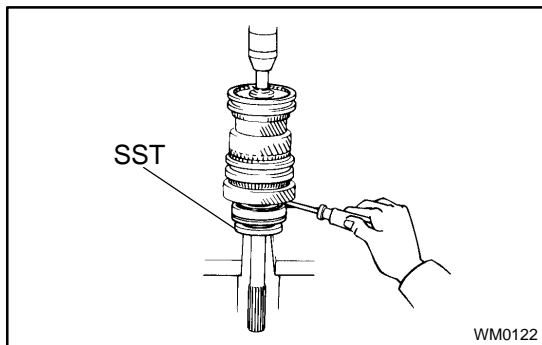
**6. INSPECT 2ND GEAR THRUST CLEARANCE**

(See page [MT-28](#))



**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**

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