

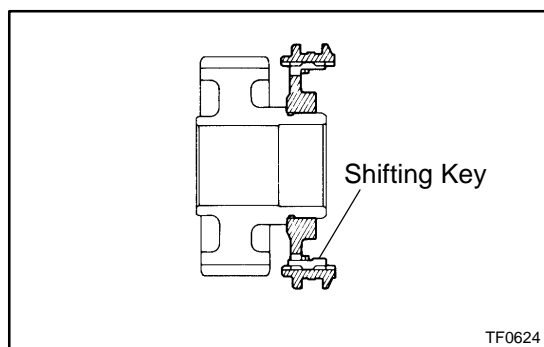
REASSEMBLY

1. **w/ A.D.D.:**
INSTALL FRONT DRIVE CLUTCH SLEEVE ONTO DRIVE SPROCKET

(a) Install the front drive clutch sleeve onto the drive sprocket.

HINT:

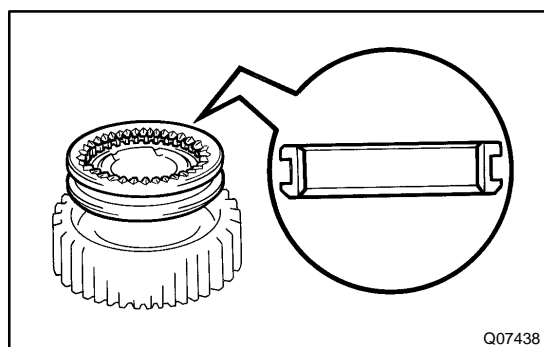
Make sure to install the clutch sleeve in the correct direction.



(b) Install the 3 shifting keys and 2 springs.

NOTICE:

Install the key springs positioned so that their end gaps are not in line.

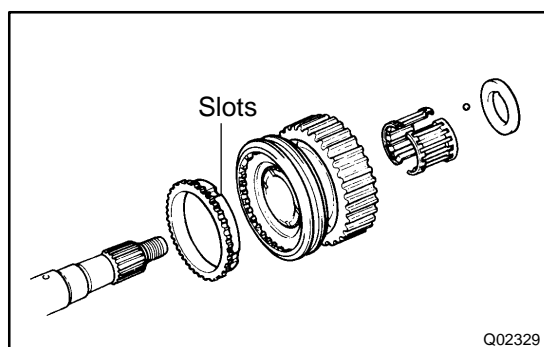


2. **w/o A.D.D.:**
INSTALL FRONT DRIVE CLUTCH SLEEVE ONTO DRIVE SPROCKET

Install the front drive clutch sleeve onto the drive sprocket.

HINT:

Make sure to install the clutch sleeve in the correct direction.

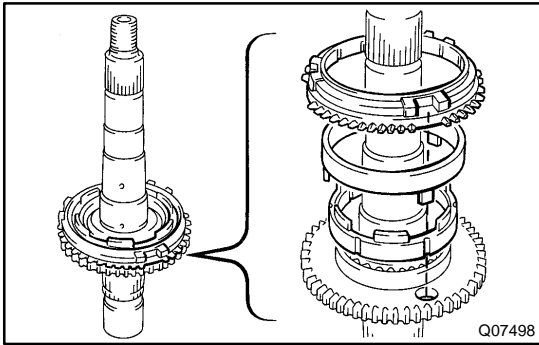


3. **w/ A.D.D.:**
INSTALL DRIVE SPROCKET WITH FRONT DRIVE CLUTCH SLEEVE ASSEMBLY, SPACER AND BEARING

(a) **w/o One touch 2-4 selector system:**

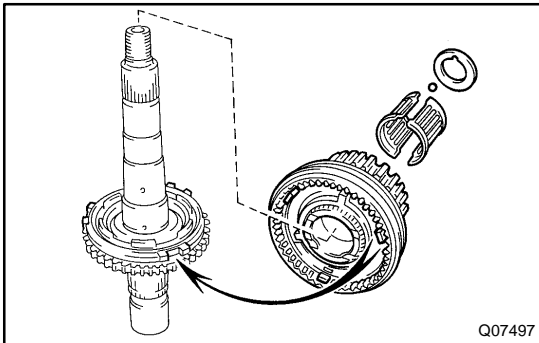
Install these parts.

- (1) Apply gear oil to the shaft and needle roller bearing.
- (2) Place the synchronizer ring on the spline and align the ring slots with the shifting keys.
- (3) Install the needle roller bearing in the drive sprocket.
- (4) Install the drive sprocket with the front drive clutch sleeve assembly.

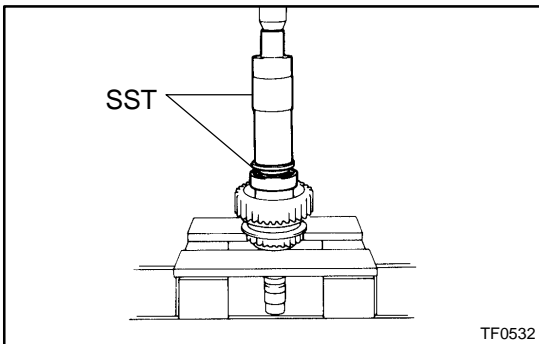


- (b) w/ One touch 2-4 selector system:
Install these parts.
- (1) Apply gear oil to the shaft and needle roller bearing.
 - (2) Install the synchronizer inner ring, center ring and outer ring.

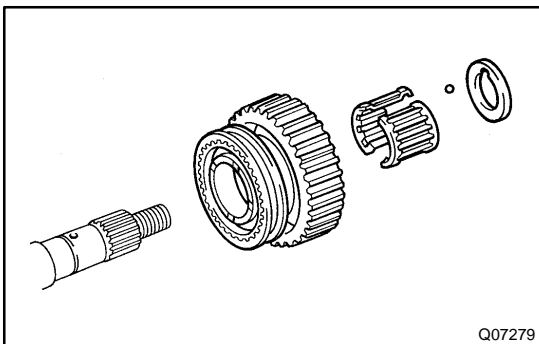
NOTICE:
Align the slots of outer and inner rings.



- (3) Install the needle roller bearing in the drive sprocket.
- (4) Install the drive sprocket with the front drive clutch sleeve assembly.

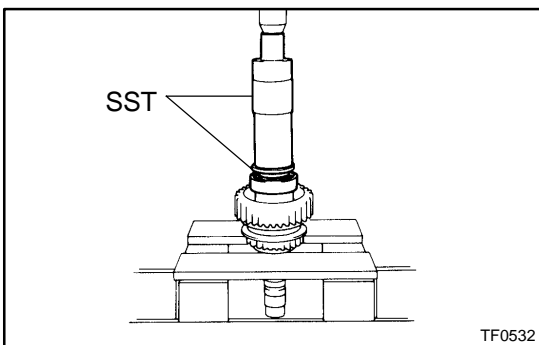


- (5) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.
 - (6) Install the spacer to align it with the ball.
 - (7) Using SST and a press, install a new bearing with the outer race snap ring groove toward the rear.
- SST 09316-60011 (09316-00011, 09316-00071)

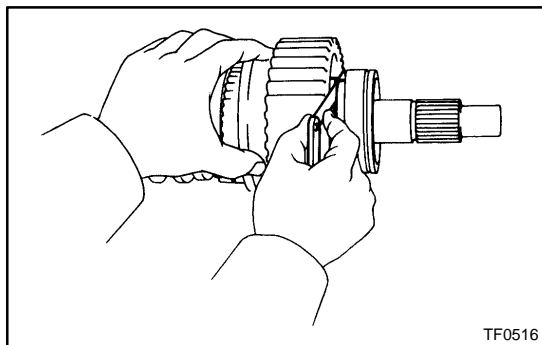


4. w/o A.D.D.:
INSTALL DRIVE SPROCKET WITH FRONT DRIVE CLUTCH SLEEVE, SPACER AND BEARING

- (a) Apply gear oil to the shaft and needle roller bearing.
- (b) Install the needle roller bearing in the drive sprocket.
- (c) Install the drive sprocket with the front drive clutch sleeve assembly.

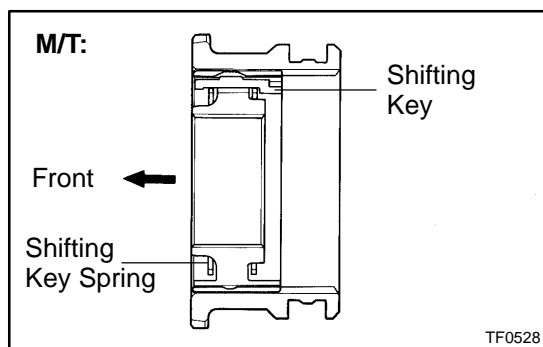


- (d) Install the spacer to align it with the ball.
 - (e) Using SST and a press, install a new bearing with the outer race snap ring groove toward the rear.
- SST 09316-60011 (09316-00011, 09316-00071)



- 5. INSPECT DRIVE SPROCKET THRUST CLEARANCE**
Using a feeler gauge, measure the drive sprocket thrust clearance.

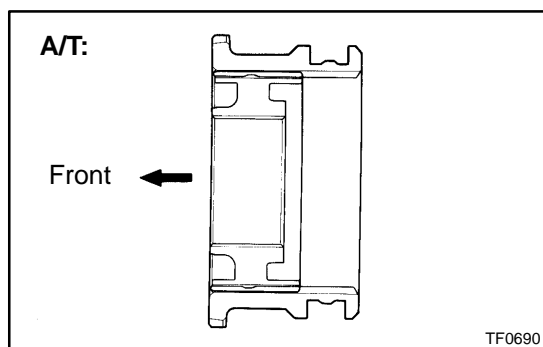
Standard clearance:
0.10 – 0.25 mm (0.0039 – 0.0098 in.)



- 6. M/T:**
INSERT HIGH AND LOW CLUTCH HUB ONTO CLUTCH SLEEVE

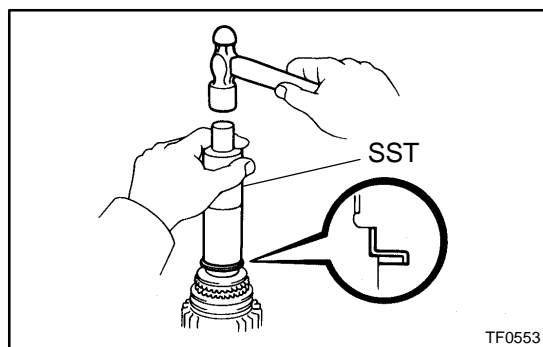
- (a) Install the clutch hub and 3 shifting keys onto the clutch sleeve.
(b) Install the 2 shifting key springs under the shifting keys.

NOTICE:
Install the key springs positioned so that their end gaps are not in line.



- 7. A/T:**
INSERT HIGH AND LOW CLUTCH HUB ONTO CLUTCH SLEEVE

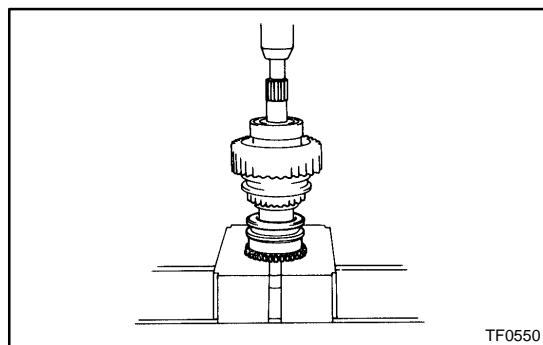
Install the clutch hub onto the clutch sleeve.



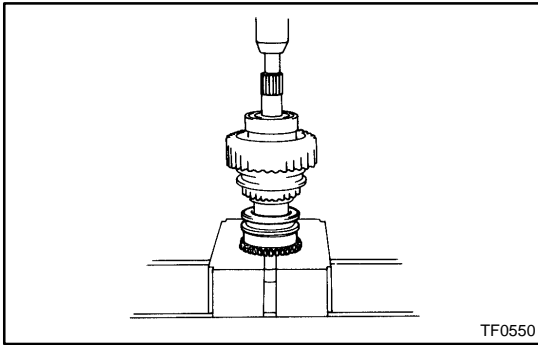
- 8. M/T:**
INSTALL HIGH AND LOW CLUTCH HUB ASSEMBLY

- (a) Using SST and a hammer, drive in a new key retainer.
SST 09316-60011 (09316-00011)

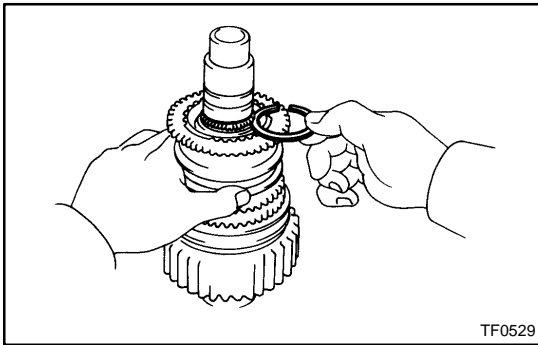
NOTICE:
Be careful not to deform or damage the key retainer.



- (b) Using a press, install the high and low clutch hub assembly.



- 9. A/T:**
INSTALL HIGH AND LOW CLUTCH HUB ASSEMBLY
 Using a press, install the high and low clutch hub assembly.



10. INSTALL SNAP RING

Select a snap ring that will allow minimum axial play and install it to the shaft.

Mark	Thickness mm (in.)
A	2.10 – 2.15 (0.0827 – 0.0846)
B	2.15 – 2.20 (0.0846 – 0.0866)
C	2.20 – 2.25 (0.0866 – 0.0886)
D	2.25 – 2.30 (0.0886 – 0.0906)
E	2.30 – 2.35 (0.0906 – 0.0925)
F	2.35 – 2.40 (0.0925 – 0.0945)
G	2.40 – 2.45 (0.0945 – 0.0965)
H	2.45 – 2.50 (0.0965 – 0.0984)
J	2.50 – 2.55 (0.0984 – 0.1004)
K	2.00 – 2.05 (0.0787 – 0.0807)
L	2.05 – 2.10 (0.0807 – 0.0827)