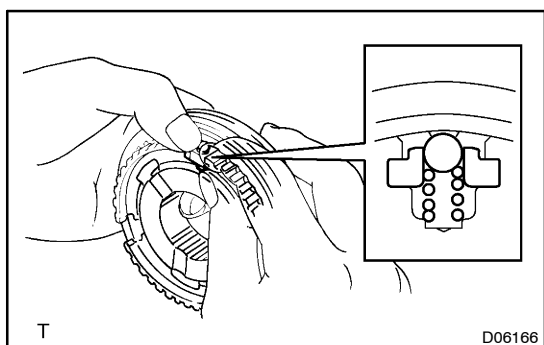


## REASSEMBLY

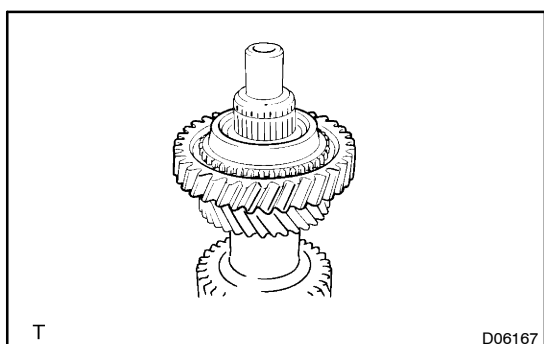
### 1. INSTALL HUB SLEEVE NO. 1

- (a) Install the hub sleeve No. 1 to clutch hub No. 1.
- (b) Install the shifting key and spring to clutch hub.
- (c) While pushing the spring, install the shifting key ball.



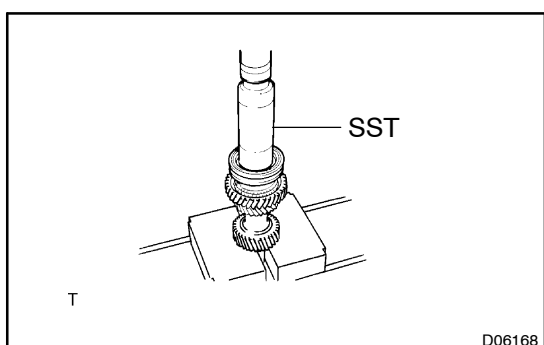
### 2. INSTALL HUB SLEEVE NO. 3

- (a) Install the hub sleeve No. 3 to clutch hub No. 3.
- (b) Install the shifting key and spring to clutch hub.
- (c) While pushing the spring, install the shifting key ball.



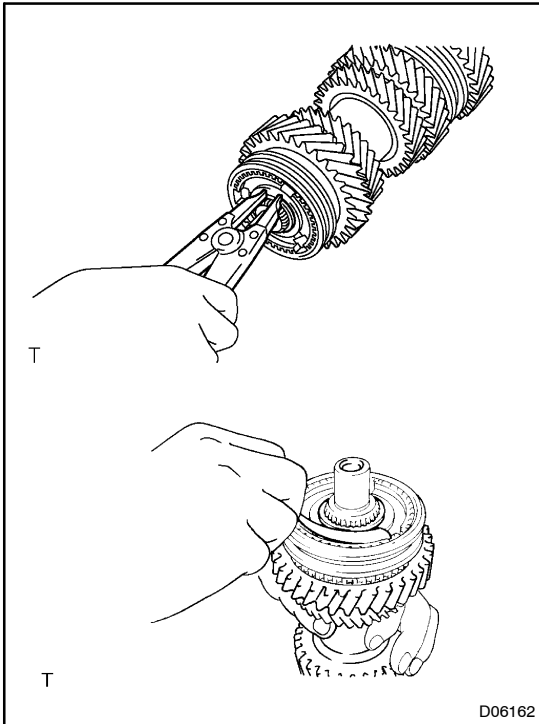
### 3. INSTALL REVERSE GEAR

- (a) Apply gear oil to the shaft, inner of reverse gear bearing, inner of reverse gear and cone of reverse gear.
- (b) Install the reverse gear bearing and reverse gear.



### 4. INSTALL TRANSMISSION CLUTCH HUB NO. 3

- (a) Install the synchronizer ring No. 3 to reverse gear.
- (b) Using SST and press, install the transmission clutch hub No. 3.  
SST 09309-37010



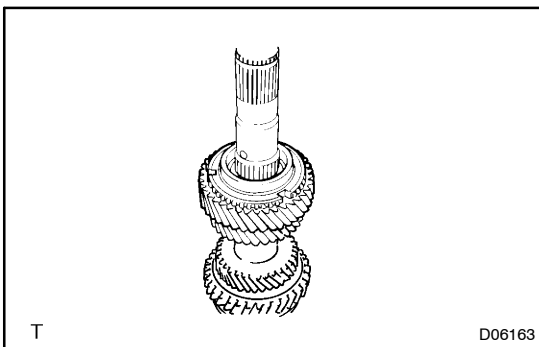
D06162

**5. INSTALL TRANSMISSION CLUTCH HUB NO. 3 SHAFT SNAP RING**

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

Mark	Thickness mm (in.)
A	1.80 (0.0709)
B	1.85 (0.0728)
C	1.90 (0.0748)
D	1.95 (0.0768)
E	2.00 (0.0787)
F	2.05 (0.0807)

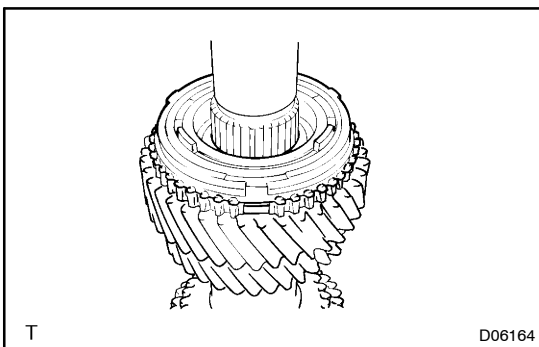
- (b) Using a snap ring expander, install the snap ring.



D06163

**6. INSTALL 2ND GEAR**

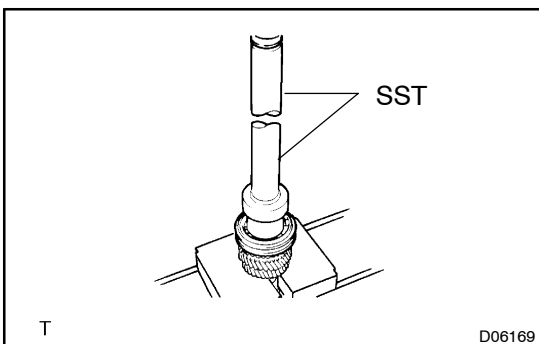
- (a) Apply gear oil to the shaft, inner of reverse gear bearing, inner of the 2nd gear needle roller bearing, inner of 2nd gear and cone of 2nd gear.  
 (b) Install the 2nd gear needle roller bearing and 2nd gear to output shaft.



D06164

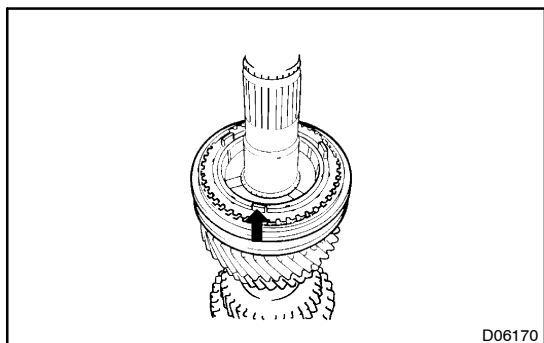
**7. INSTALL TRANSMISSION CLUTCH HUB NO. 1**

- (a) Place the synchronizer ring set (for 2nd gear) on the gear and align the ring slots with the shifting keys.

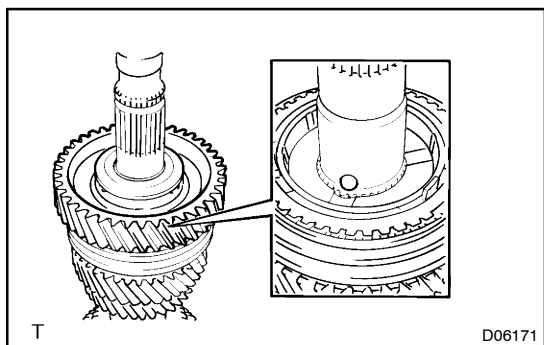


D06169

- (b) Using SST and press, install the clutch hub No. 1.  
 SST 09309-35010, 09631-12090

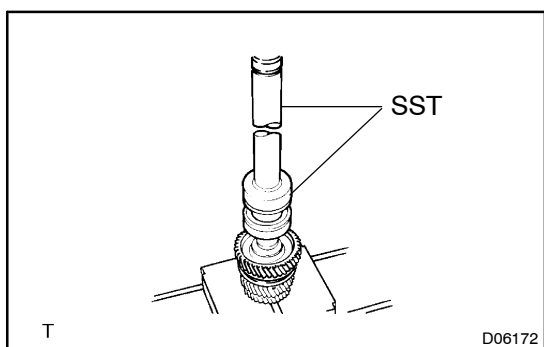


- (c) Place the synchronizer ring set (for 1st gear) on the gear and align the ring slots with the shifting keys.



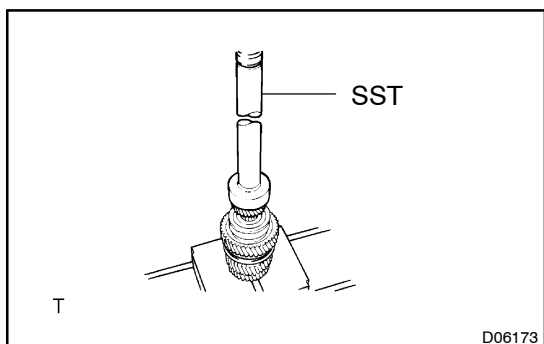
### 8. INSTALL 1ST GEAR

- (a) Apply gear oil to the shaft needle roller bearing inner race, inner of 1st gear and cone of 1st gear.
- (b) Install the 1st gear shift restrict ball, 1st gear, bearing inner race, 1st gear needle roller bearing and 1st gear.



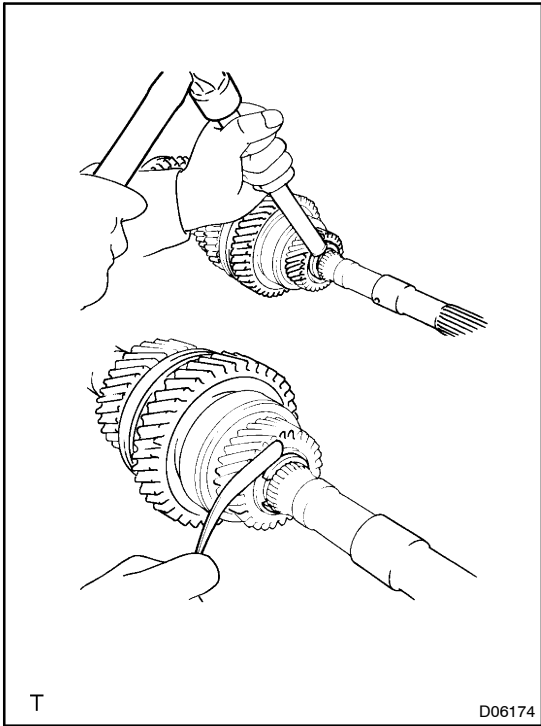
### 9. INSTALL REAR OUTPUT SHAFT BEARING

Using SST and press, install the rear output shaft bearing.  
SST 09309-35010, 09316-60011 (09316-00021)



### 10. INSTALL 6TH GEAR

Using SST and press, install the 6th gear.  
SST 09309-35010



**11. INSTALL 6TH GEAR SHAFT SNAP RING**

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

Mark	Thickness mm (in.)
A	2.67 (0.1051)
B	2.73 (0.1075)
C	2.79 (0.1098)
D	2.85 (0.1122)
E	2.91 (0.1146)
F	2.97 (0.1169)
G	3.03 (0.1192)
H	3.09 (0.1217)
J	3.15 (0.1240)
K	3.21 (0.1263)
L	3.27 (0.1287)

(b) Using a brass bar and hammer, install the snap ring.