

## REASSEMBLY

### 1. INSTALL ASSEMBLED BEARING AND RACE

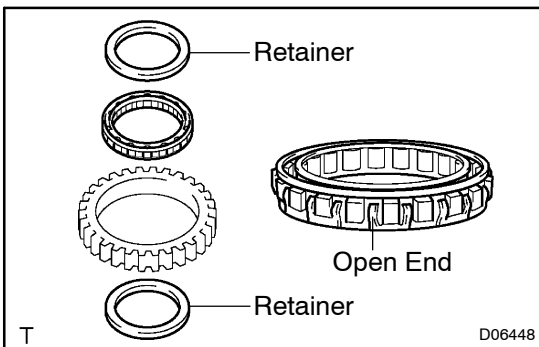
Coat the assembled bearing and race with petroleum jelly and install it onto the O/D planetary gear.

**Assembled bearing and race diameter:**

	Inside mm (in.)	Outside mm (in.)
Assembled bearing and race	37.3 (1.469)	52.5 (2.067)

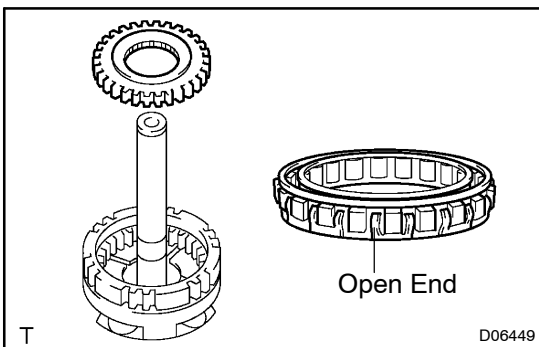
### 2. INSTALL THRUST WASHER

Install the thrust washer to the O/D planetary gear, the grooved side facing upward.

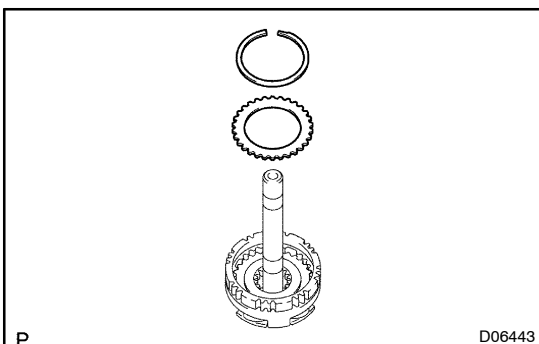


### 3. ASSEMBLE ONE-WAY CLUTCH

- (a) Install the one-way clutch into the outer race, the open end of the retainers facing upward.
- (b) Install the 2 retainers to both sides.

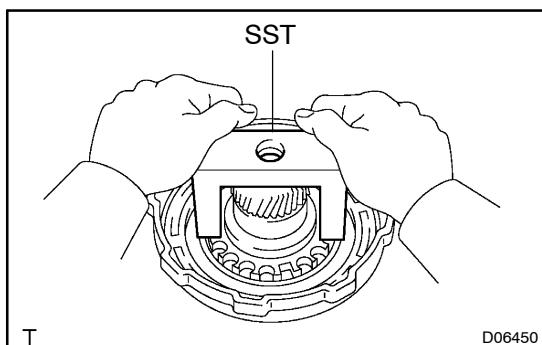


### 4. INSTALL ONE-WAY CLUTCH ASSEMBLY

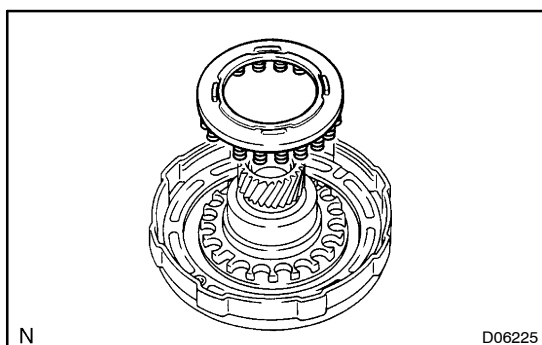


### 5. INSTALL THRUST WASHER

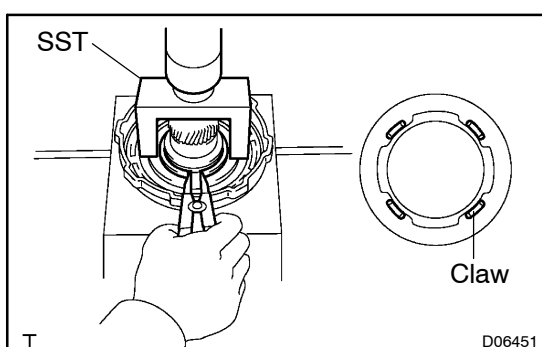
- (a) Install the thrust washer.
- (b) Using a screwdriver, install the snap ring.

**6. INSTALL O/D DIRECT CLUTCH PISTON**

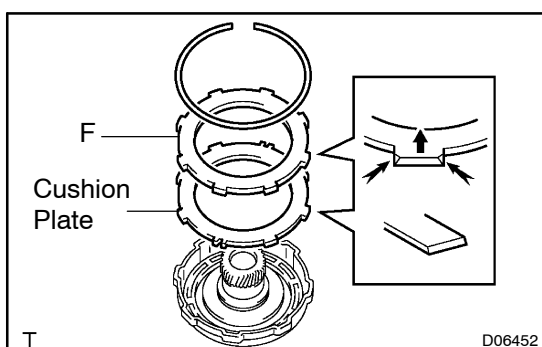
- (a) Coat new O-rings with ATF and install them on the O/D direct clutch piston.
- (b) Place SST on the direct clutch piston.  
SST 09350-20015 (09369-20040)
- (c) Being careful not to damage the O-rings, press in the direct clutch piston onto the clutch drum with both hands.

**7. INSTALL PISTON RETURN SPRING**

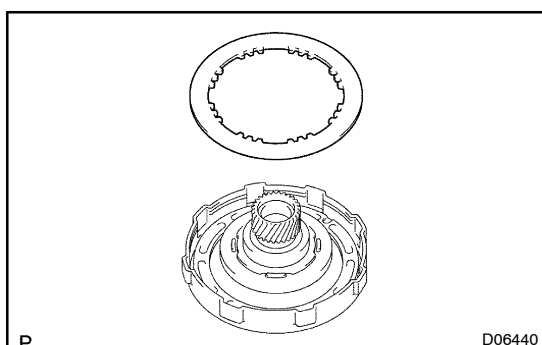
- (a) Install the piston return spring.

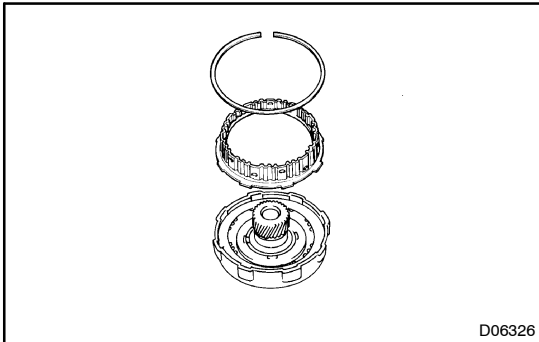


- (b) Place SST on the piston return spring, and compress the piston return spring with a shop press.  
SST 09350-20015 (09369-20040)
- (c) Install the snap ring with a snap ring expander. Be sure the end gap of the snap ring is not aligned with the spring seat claw.

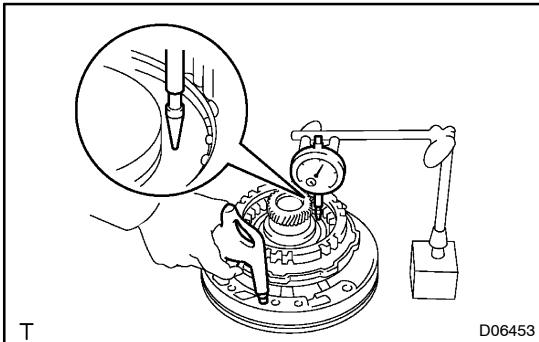
**8. INSTALL CUSHION PLATE AND FLANGE**

- (a) Install the cushion plate.
- (b) Install flange, the rounded edge facing upward.
- (c) Using a screwdriver, install the snap ring. Be sure the end gap of the snap ring is not aligned with the cutout portion of the drum.

**9. INSTALL DISC**

**10. INSTALL O/D BRAKE HUB**

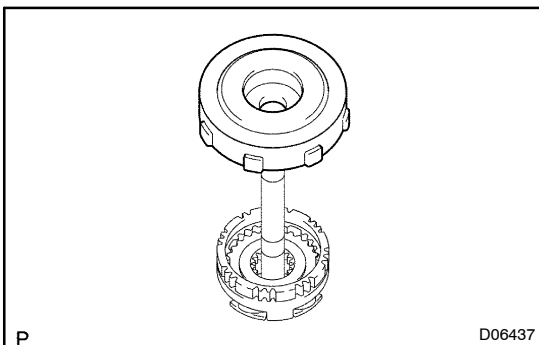
- (a) Install the O/D brake hub.
- (b) Using a screwdriver, install the snap ring. Be sure the end gap of the snap ring is not aligned with the cutout portion of the drum.

**11. CHECK PISTON STROKE OF O/D DIRECT CLUTCH**

- (a) Place the O/D direct clutch assembly onto the oil pump.
- (b) Using dial indicator, measure the O/D direct clutch piston stroke applying and releasing the compressed air (392 – 785 kPa, 4 – 8 kgf/cm<sup>2</sup>, 57 – 114 psi), as shown.

**Piston stroke: 1.74 – 2.44 mm (0.0685 – 0.0961 in.)**

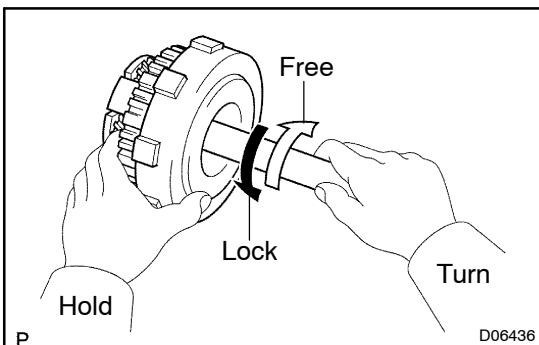
If the piston stroke is less than the limit, parts may have been assembled incorrectly, check and reassemble again.

**12. INSTALL O/D DIRECT CLUTCH ASSEMBLY**

Install the direct clutch assembly onto the O/D planetary gear.

**HINT:**

Mesh the splines of the O/D planetary gear with the flukes of the disc by rotating and pushing the O/D planetary gear.

**13. CHECK OPERATION OF ONE-WAY CLUTCH**

Hold the O/D direct clutch drum and turn the input shaft. The input shaft turns freely clockwise and locks counterclockwise.