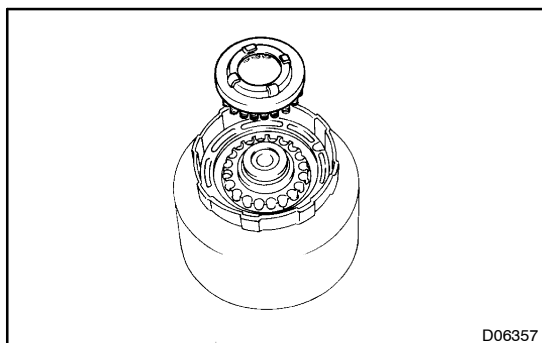


REASSEMBLY

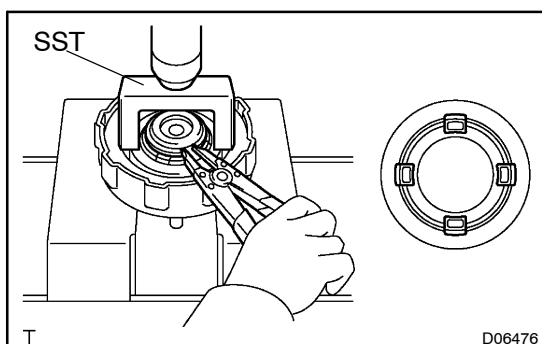
1. INSTALL FRONT CLUTCH PISTON

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

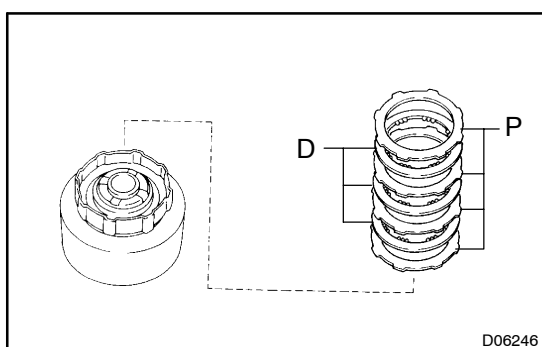


2. INSTALL PISTON RETURN SPRING

- (a) Install the piston return spring.

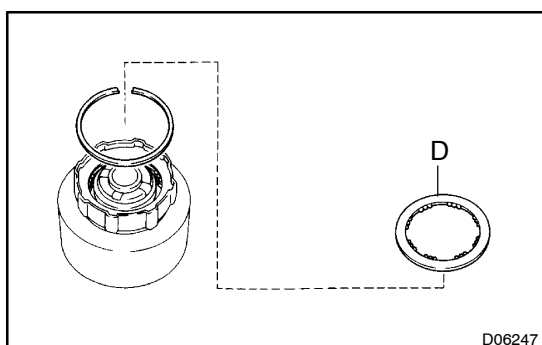


- (b) Place SST on the spring seat, and compress the return spring with a shop press.
SST 09350-20015 (09369-20040)
- (c) Install the snap ring with a snap ring expander. Be sure the end gap of the snap ring is not aligned with the spring seat claw.

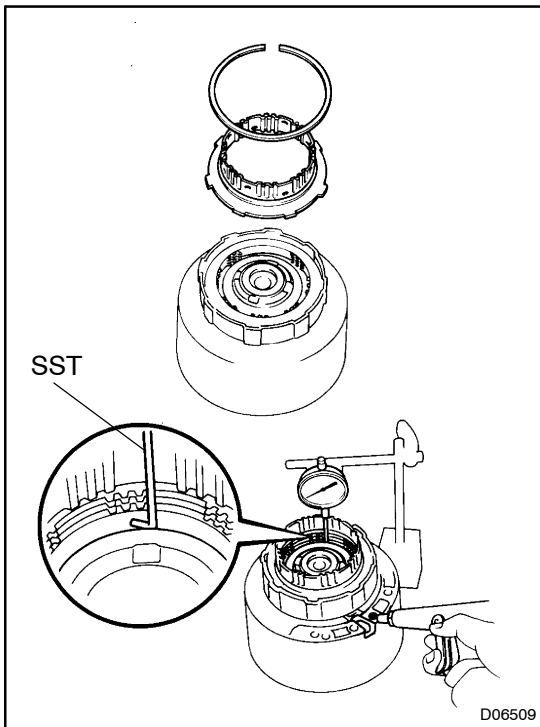


3. INSTALL PLATE AND DISC

- (a) Install the 4 plates and 3 discs.
Install in order: P = Plate D = Disc
P - D - P - D - P - D - P



- (b) Install the snap ring. Be sure the end gap of the snap ring is not aligned with the cutout portion of the front clutch drum.
- (c) Install the disc.



4. CHECK PISTON STROKE OF FRONT CLUTCH

- (a) For check of piston stroke, install the rear clutch hub.
- (b) Install the snap ring.
- (c) Using SST and a dial indicator, measure the front clutch piston stroke applying and releasing the compressed air (392 – 785 kPa, 4 – 8 kgf/cm², 57 – 114 psi), as shown. SST 09350-20015 (09350-06120)

Piston stroke:

1.40 – 1.60 mm (0.0551 – 0.0630 in.)

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

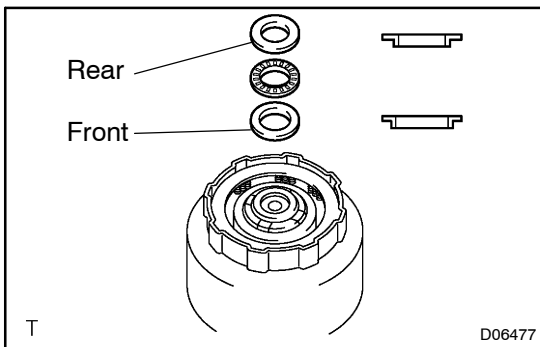
If the piston stroke is non-standard, select another plate.

HINT:

There are 2 different thicknesses for the plate.

Plate thickness:

1.8 mm (0.071 in.)	2.0 mm (0.079 in.)
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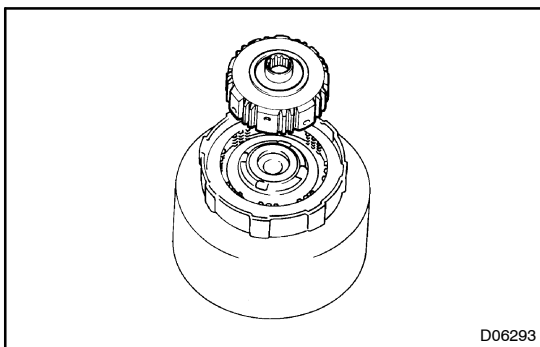
- (d) Remove the snap ring and rear clutch hub.

5. INSTALL FRONT CLUTCH HUB

- (a) Coat the bearing and races with petroleum jelly and install them onto the front clutch drum.

Bearing and races diameter:

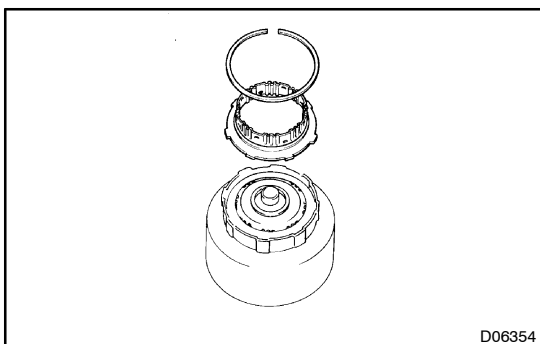
	Inside mm (in.)	Outside mm (in.)
Race (Rear)	21.4 (0.843)	37.3 (1.469)
Bearing	23.4 (0.921)	37.5 (1.476)
Race (Front)	24.1 (0.949)	37.3 (1.469)



- (b) Install the front clutch hub into the front clutch drum.

HINT:

Mesh the splines of the front clutch hub with the flukes of the discs by rotating and pushing the front clutch hub.



6. INSTALL REAR CLUTCH HUB

- (a) Install the rear clutch hub.
- (b) Install the snap ring. Be sure the end gap of the snap ring is not aligned with the cutout portion of the front clutch drum.