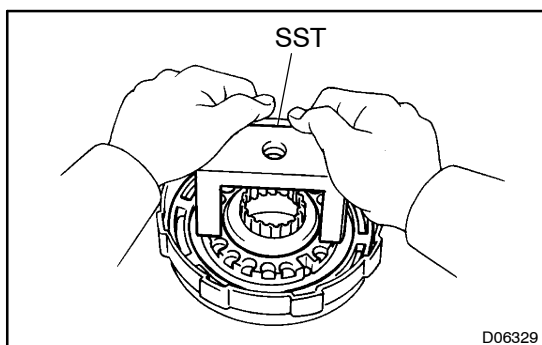


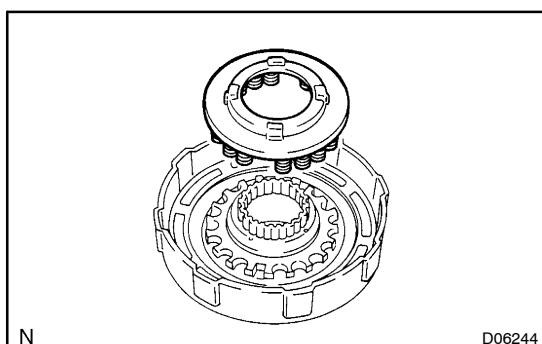
REASSEMBLY

1. INSTALL REAR CLUTCH PISTON

- (a) Coat new O-rings with ATF and install them on the rear clutch piston.

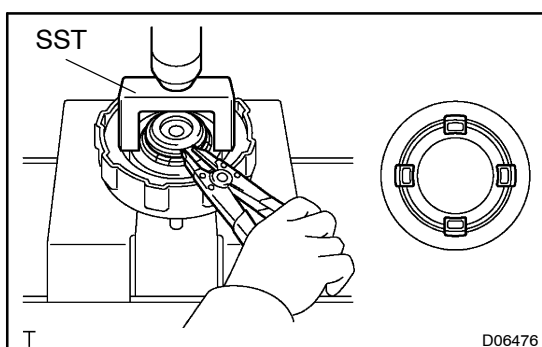


- (b) Install the rear clutch piston.
- (c) Place SST on the rear clutch piston.
SST 09350-20015 (09369-20040)
- (d) Being careful not to damage the O-rings, press in the rear clutch piston into the clutch drum with both hands.

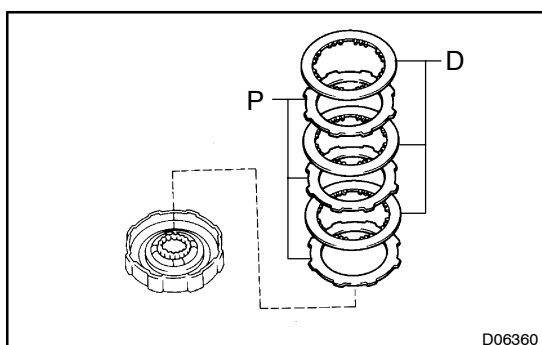


2. INSTALL PISTON RETURN SPRING

- (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.

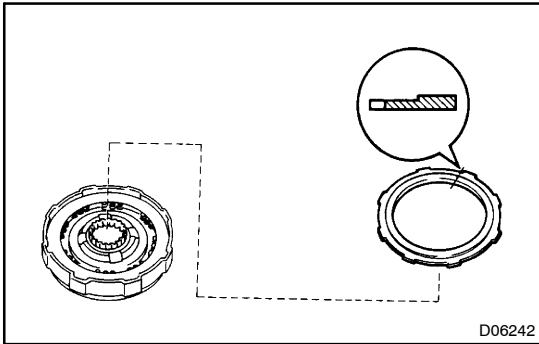


3. INSTALL PLATE AND DISC

Install the 3 plates and 3 discs.

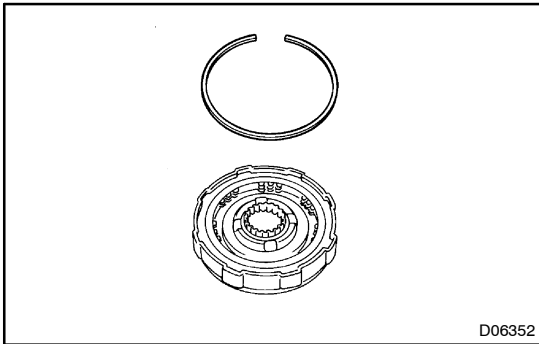
Install in order: P = Plate D = Disc

P - D - P - D - P - D

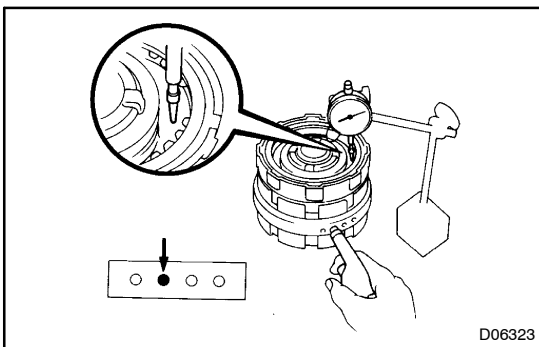


4. INSTALL FLANGE

- (a) Install the flange, the flat end facing downward.



- (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 rear clutch drum.



5. CHECK PISTON STROKE OF REAR CLUTCH

- (a) Plate the rear clutch assembly onto the center support.
- (b) Using a dial indicator, measure the rear clutch piston stroke applying and releasing the compressed air (392 – 785 kPa, 4 – 8 kgf/cm², 57 – 114 psi), as shown.

Piston stroke:

0.90 – 1.30 mm (0.0354 – 0.0512 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 nonstandard, select another flange.

HINT:

There are 3 different thickness for thee flange.

Flange thickness:

3.55mm (0.1398 in.)	4.00mm (0.1575 in.)
3.75mm (0.1477 in.)	-