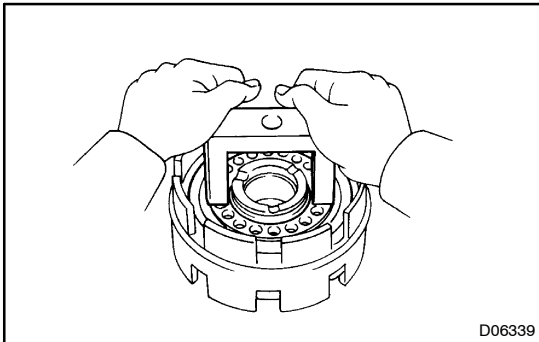


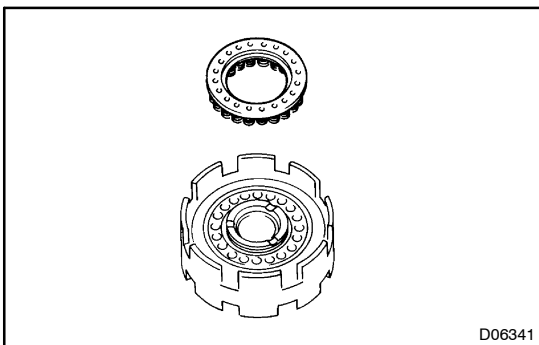
## REASSEMBLY

### 1. INSTALL NO. 2 BRAKE PISTON

- (a) Coat new O-ring with ATF and install it on the center support.

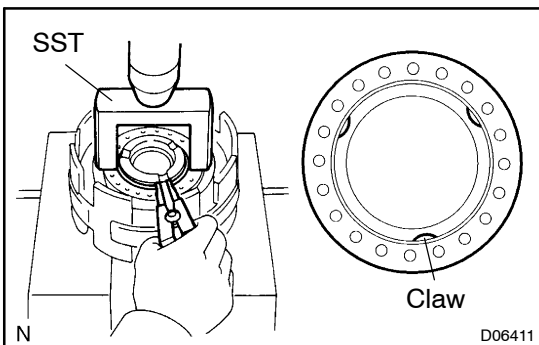


- (b) Coat a new O-ring with ATF and install it on the No. 2 brake piston.  
 (c) Place SST on the No. 2 brake piston.  
 SST 09350-20015 (09369-20040)  
 (d) Being careful not damage the O-rings, press in the No. 2 brake piston into the center support with both hands.  
 (e) Install the thrust washer into the front planetary gear.

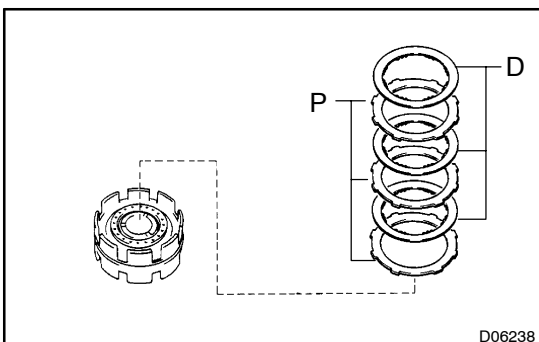


### 2. INSTALL PISTON RETURN SPRING

- (a) Install the piston return spring.



- (b) Place SST on the spring seat, and compress the return springs 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.

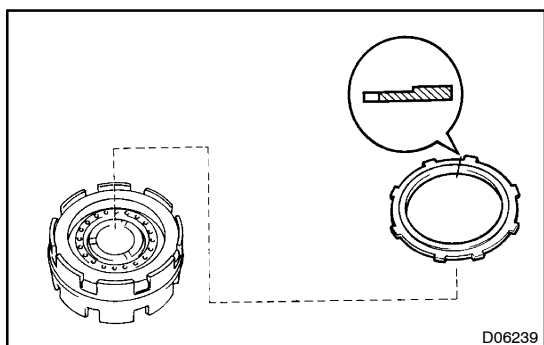


### 3. INSTALL PLATE AND DISC

Install the 3 plates and 3 discs.

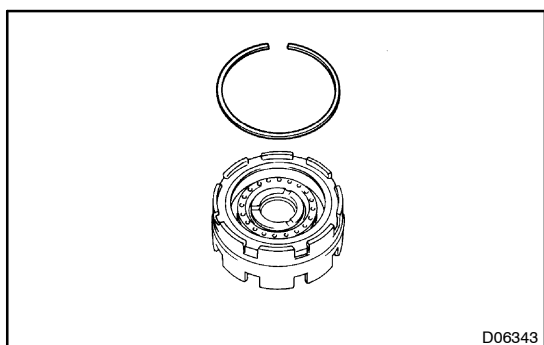
**Install in order: P = Plate D = Disc**

**P - D - P - D - P - D**

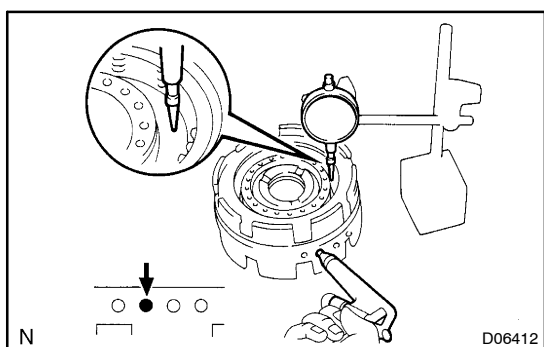


#### 4. INSTALL FLANGE

(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 center support.



#### 5. CHECK PISTON STROKE OF NO. 2 BRAKE

Using a dial indicator, measure the No. 2 brake piston stroke applying and releasing the compressed air (392 - 785 kPa, 4 - 8 kgf/cm<sup>2</sup>, 57 - 144 psi), as shown.

**Piston stroke:**

**0.98 - 1.71 mm (0.0386 - 0.0673 in.)**

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

6. INSTALL PLANETARY SUN GEAR AND NO. 1 ONE-WAY CLUTCH (See page AT-69)