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SECTION **MT**

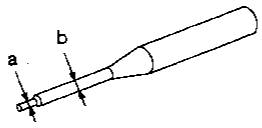
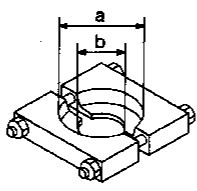
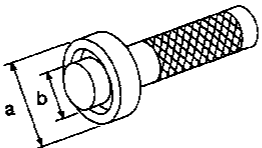
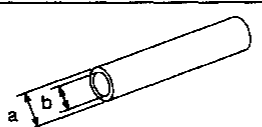
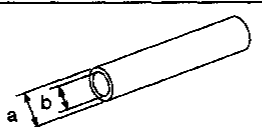
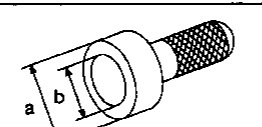
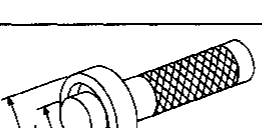
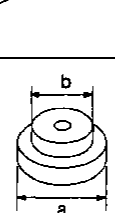
CONTENTS

PREPARATION	2	Synchronizers.....	19
Special Service Tools	2	Bearings	20
Commercial Service Tool.....	3	ASSEMBLY	21
NOISE, VIBRATION AND HARSHNESS (NVH)		Gear Components	21
TROUBLESHOOTING	4	Shift Control Components	29
NVH Troubleshooting Chart.....	4	Case Components.....	29
DESCRIPTION	5	SERVICE DATA AND SPECIFICATIONS (SDS)	32
Cross-sectional View	5	General Specifications.....	32
ON-VEHICLE SERVICE	6	Inspection and Adjustment	33
Position Switch Check.....	6	Gear End Play.....	33
REMOVAL AND INSTALLATION	7	Clearance Between Baulk Ring And Gear	33
Removal.....	7	2nd and 3rd baulk ring	33
Installation.....	8	Distance Between Rear Surface of Reverse	
MAJOR OVERHAUL	9	Cone And Reverse Baulk Ring.....	33
Case Components	9	Available Snap Ring.....	33
Gear Components	10	Main drive gear snap ring	33
Shift Control Components	12	Mainshaft front snap ring.....	33
DISASSEMBLY	13	Counter gear rear snap ring.....	34
Case Components	13	Available C-Ring	34
Shift Control Components	14	Mainshaft C-ring	34
Gear Components	15	Available Shim And Washer.....	34
INSPECTION	19	Table for selecting proper counter gear	
Shift Control Components	19	front bearing thrust washer	34
Gear Components	19	Reverse idler rear thrust washer.....	34
Gears And Shafts.....	19		

PREPARATION

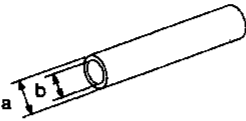
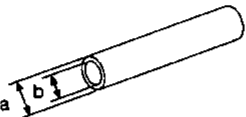
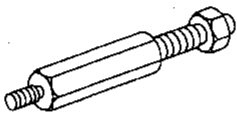
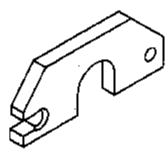
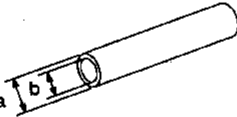
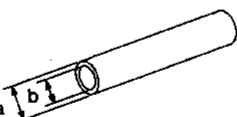
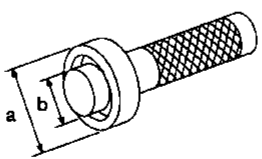
Special Service Tools

The actual shapes of Kent-Moore tools may differ from those of special service tools illustrated here.

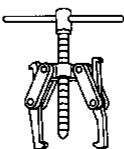
Tool number (Kent-Moore No.) Tool name	Description
ST23540000 (J25689-A) Pin punch	 <p>NT442</p> <p>Removing and installing retaining pin</p> <p>a: 2.3 mm (0.091 in) dia. b: 4 mm (0.16 in) dia.</p>
ST30031000 (J22912-01) Puller	 <p>NT411</p> <p>Removing 1st & 2nd synchronizer assembly Removing counter gear rear thrust bearing Removing main drive bearing</p> <p>a: 90 mm (3.54 in) dia. b: 50 mm (1.97 in) dia.</p>
ST33230000 (—) Drift	 <p>NT084</p> <p>Removing mainshaft and counter gear</p> <p>a: 51 mm (2.01 in) dia. b: 28.5 mm (1.122 in) dia.</p>
ST22350000 (J25678-01) Drift	 <p>NT065</p> <p>Removing counter gear front bearing (Use with KV38100300)</p> <p>a: 34 mm (1.34 in) dia. b: 28 mm (1.10 in) dia.</p>
KV38100300 (J25523) Drift	 <p>NT065</p> <p>Removing counter gear front bearing (Use with ST22350000) Installing counter gear rear bearing</p> <p>a: 54 mm (2.13 in) dia. b: 32 mm (1.26 in) dia.</p>
ST30720000 ① (J34286) ② (J34331) Drift	 <p>NT115</p> <p>① Removing mainshaft front bearing ② Installing mainshaft front bearing</p> <p>a: 77 mm (3.03 in) dia. b: 55.5 mm (2.185 in) dia.</p>
ST33210000 ① (J25523) ② (J25803-01) Drift	 <p>NT084</p> <p>① Installing counter gear front bearing ② Installing front cover oil seal</p> <p>a: 44 mm (1.73 in) dia. b: 24.5 mm (0.965 in) dia.</p>
ST30613000 (J25742-3) Drift	 <p>NT073</p> <p>Installing main drive gear bearing</p> <p>a: 72 mm (2.83 in) dia. b: 48 mm (1.89 in) dia.</p>

PREPARATION

Special Service Tools (Cont'd)

Tool number (Kent-Moore No.) Tool name	Description	
ST37750000 ① (J34286) ② (J34332) ③ (J34334) ④ (J25679-01) Drift	 NT065	① Removing counter gear rear bearing. ② Installing OD gear bushing ② Removing and installing mainshaft rear bearing ② Installing reverse cone ③ Installing reverse counter gear ④ Installing counter gear rear end bearing a: 40 mm (1.57 in) dia. b: 31 mm (1.22 in) dia.
ST22452000 (J34337) Drift	 NT065	Installing reverse hub Installing mainshaft rear bearing (2WD model) a: 45 mm (1.77 in) dia. b: 36 mm (1.42 in) dia.
(J26349-3) Puller leg	 NT078	Installing mainshaft and counter gear (Use with J34328)
(J34328) Puller	 NT079	Installing mainshaft and counter gear (Use with J26349-3)
(J26092) Drift	 NT065	Installing sub-gear snap ring a: 44.5 mm (1.752 in) dia. b: 38.5 mm (1.516 in) dia.
(J34342) Drift	 NT065	Installing OD main gear Installing reverse gear bushing a: 44.5 mm (1.752 in) dia. b: 40.5 mm (1.594 in) dia.
ST33220000 (J25804-01) Drift	 NT084	Installing mainshaft rear bearing a: 37 mm (1.46 in) dia. b: 22 mm (0.87 in) dia.

Commercial Service Tool

Tool name	Description	
Puller	 NT077	Removing counter gear rear end bearing Removing mainshaft rear bearing Removing reverse synchronizer hub Removing reverse counter gear

NOISE, VIBRATION AND HARSHNESS (NVH) TROUBLESHOOTING

NVH Troubleshooting Chart

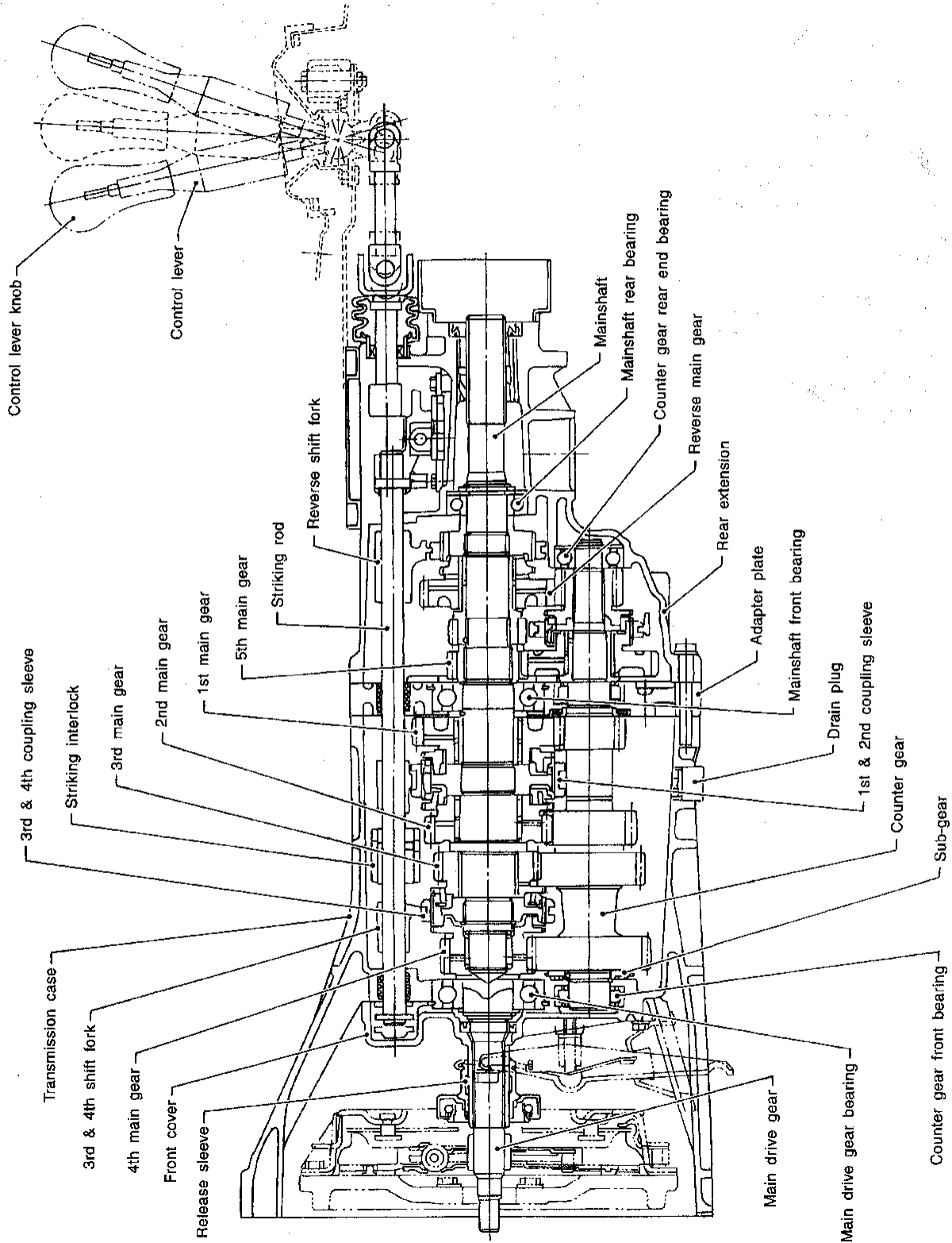
Use the chart below to help you find the cause of the symptom. The numbers indicate the order of the inspection. If necessary, repair or replace these parts.

MANUAL TRANSMISSION

Symptom		SUSPECTED PARTS (Possible cause)											Reference page		
		OIL (Level low)	OIL (Wrong)	OIL (Level too high)	GASKET (Damaged)	OIL SEAL (Worn or damaged)	O-RING (Worn or Damaged)	CHECK PLUG RETURN SPRING AND CHECK BALL (Worn or damaged)	SHIFT FORK (Worn)	GEAR (Worn or damaged)	BEARING (Worn or damaged)	BAULK RING (Worn or damaged)		INSERT SPRING (Damaged)	
Symptom	Noise	1	2							3	3			Refer to MA section ("Checking M/T Oil", CHASSIS AND BODY MAINTENANCE").	MT-9
	Oil leakage		3	1	2	2	2								MT-9
	Hard to shift or will not shift		1	1								2	2		MT-12
	Jumps out of gear							1	2	2					MT-12

DESCRIPTION

Cross-sectional View

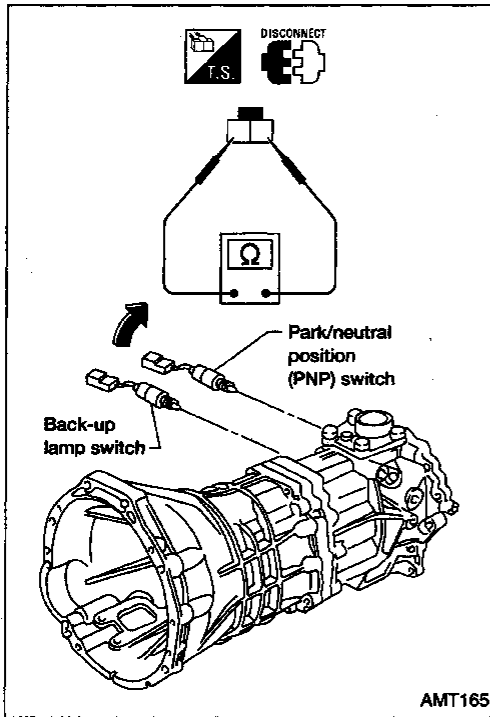


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ON-VEHICLE SERVICE



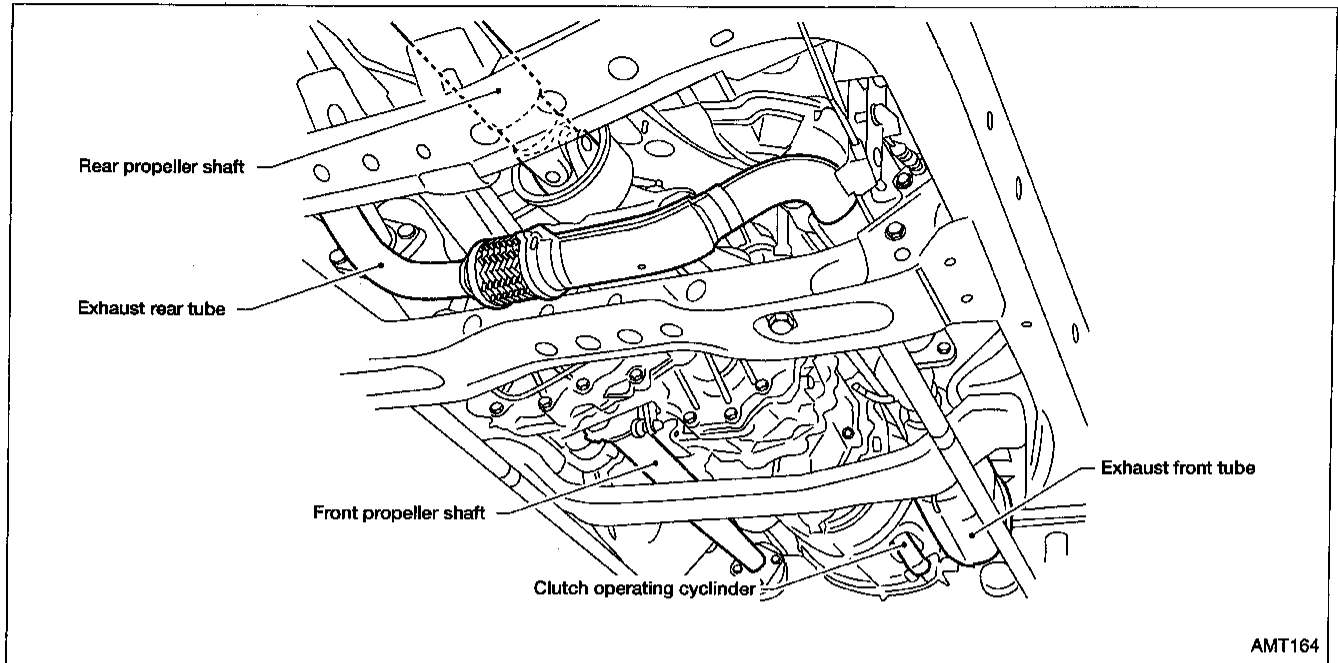
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Position Switch Check

Switch	Gear position	Continuity
Back-up lamp switch	Reverse	Yes
	Except reverse	No
Park/neutral position (PNP) switch	Neutral	Yes
	Except neutral	No

REMOVAL AND INSTALLATION

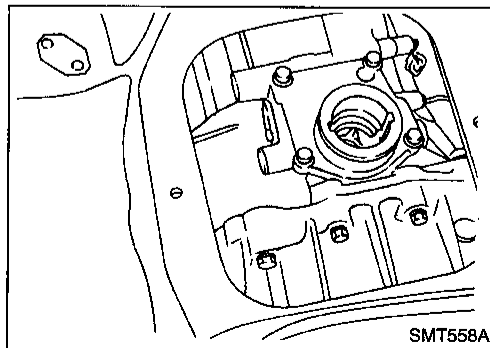
Removal



1. Remove battery negative terminal.
2. Remove control lever from transmission and transfer.
3. Remove clutch operating cylinder from transmission. Tighten clutch operating cylinder to the specified torque. Refer to CL section ("CLUTCH SYSTEM").
4. Disconnect speed sensor, back-up lamp switch, rear heated oxygen sensor and Park/neutral position (PNP) switch harness connectors.
5. Remove starter motor from transmission.
⚙️: 41 - 52 N·m (4.2 - 5.3 kg·m, 30 - 38 ft·lb)
6. Remove front and rear propeller shafts. Refer to PD section ("Removal", "PROPELLER SHAFT").
 - Insert plug into rear oil seal after removing propeller shaft.
 - Be careful not to damage spline, sleeve yoke and rear oil seal when removing propeller shaft.
7. Remove exhaust tube mounting bracket from transmission. Refer to FE section ("EXHAUST SYSTEM").
8. Remove front exhaust tubes and center pipe.
9. Remove torsion bars and mounts.
10. Remove rear torsion bar cross mount.
11. Remove gussets from transmission or engine.
12. Support manual transmission with a jack.
13. Remove rear mounting member. Tighten rear mounting member to the specified torque. Refer to EM section ("ENGINE REMOVAL").
14. Lower manual transmission as much as possible.
15. Remove crankshaft position sensor (OBD) from upper side of transmission case.
16. Remove transmission bolts.

WARNING:

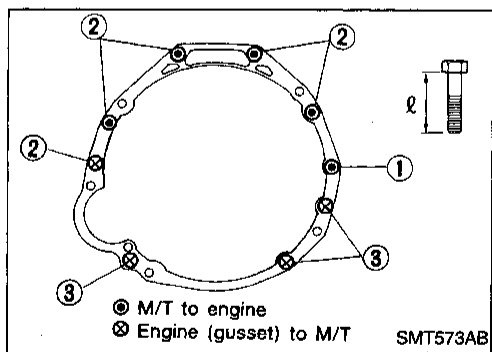
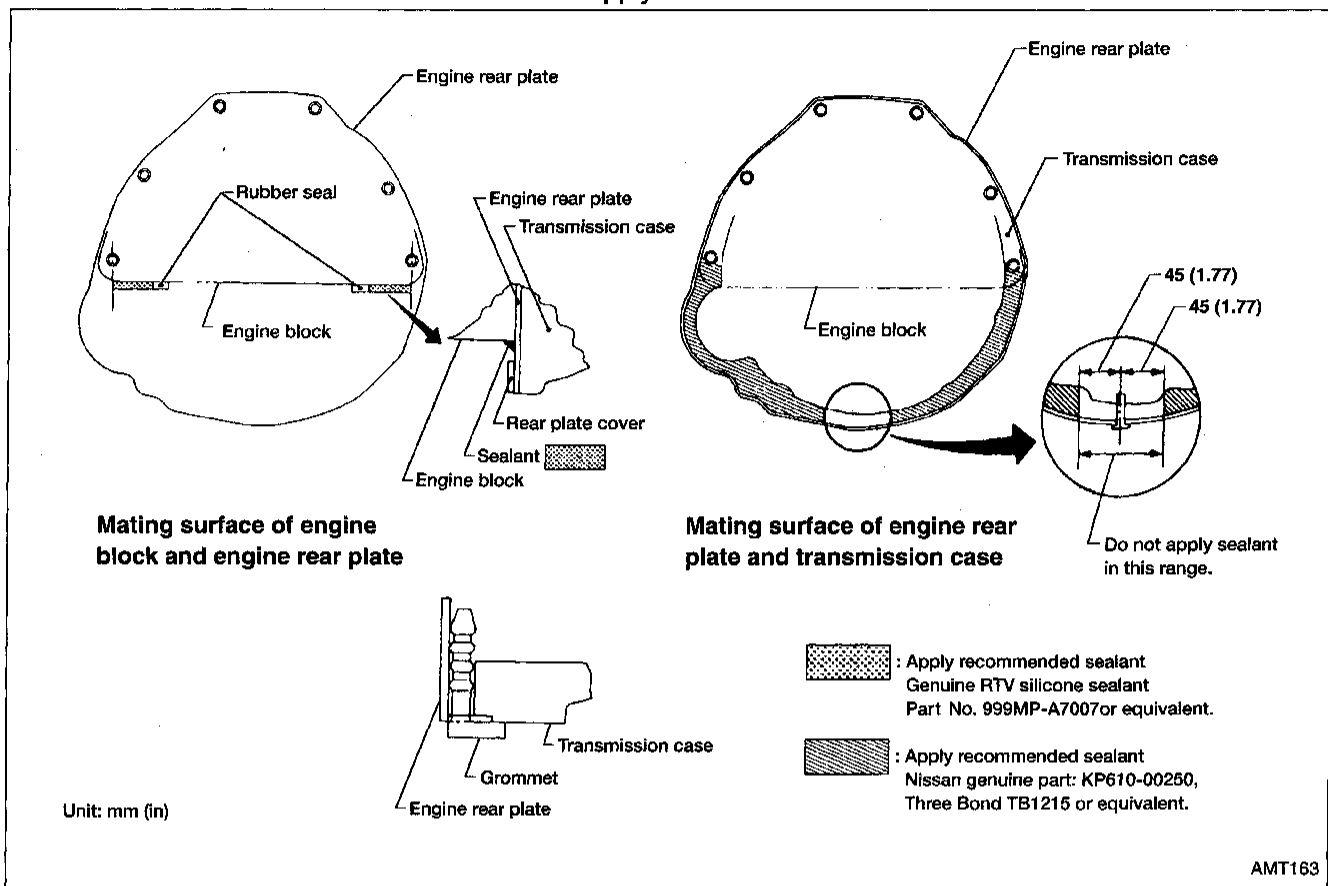
Support Manual Transmission together with transfer, while removing it.



REMOVAL AND INSTALLATION

Installation

- Apply sealant as below:

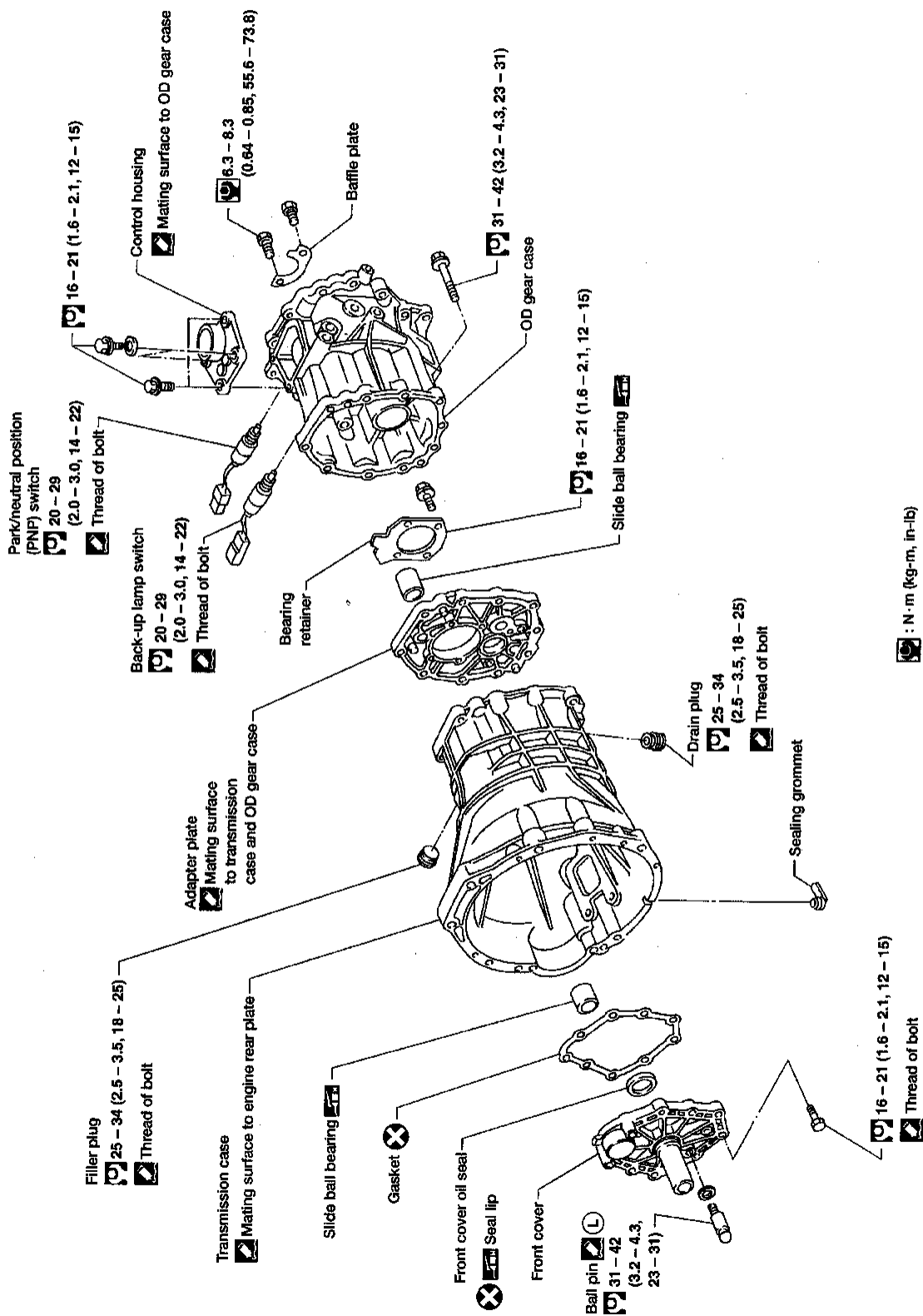


- Tighten bolt securing transmission.

Bolt No.	Tightening torque N·m (kg-m, ft-lb)	ℓ mm (in)
①	39 - 49 (4.0 - 5.0, 29 - 36)	65 (2.56)
②	39 - 49 (4.0 - 5.0, 29 - 36)	58 (2.28)
③	29 - 39 (3.0 - 4.0, 22 - 29)	25 (0.98)
Gusset to engine	29 - 39 (3.0 - 4.0, 22 - 29)	20 (0.79)

Case Components

SEC. 320-321



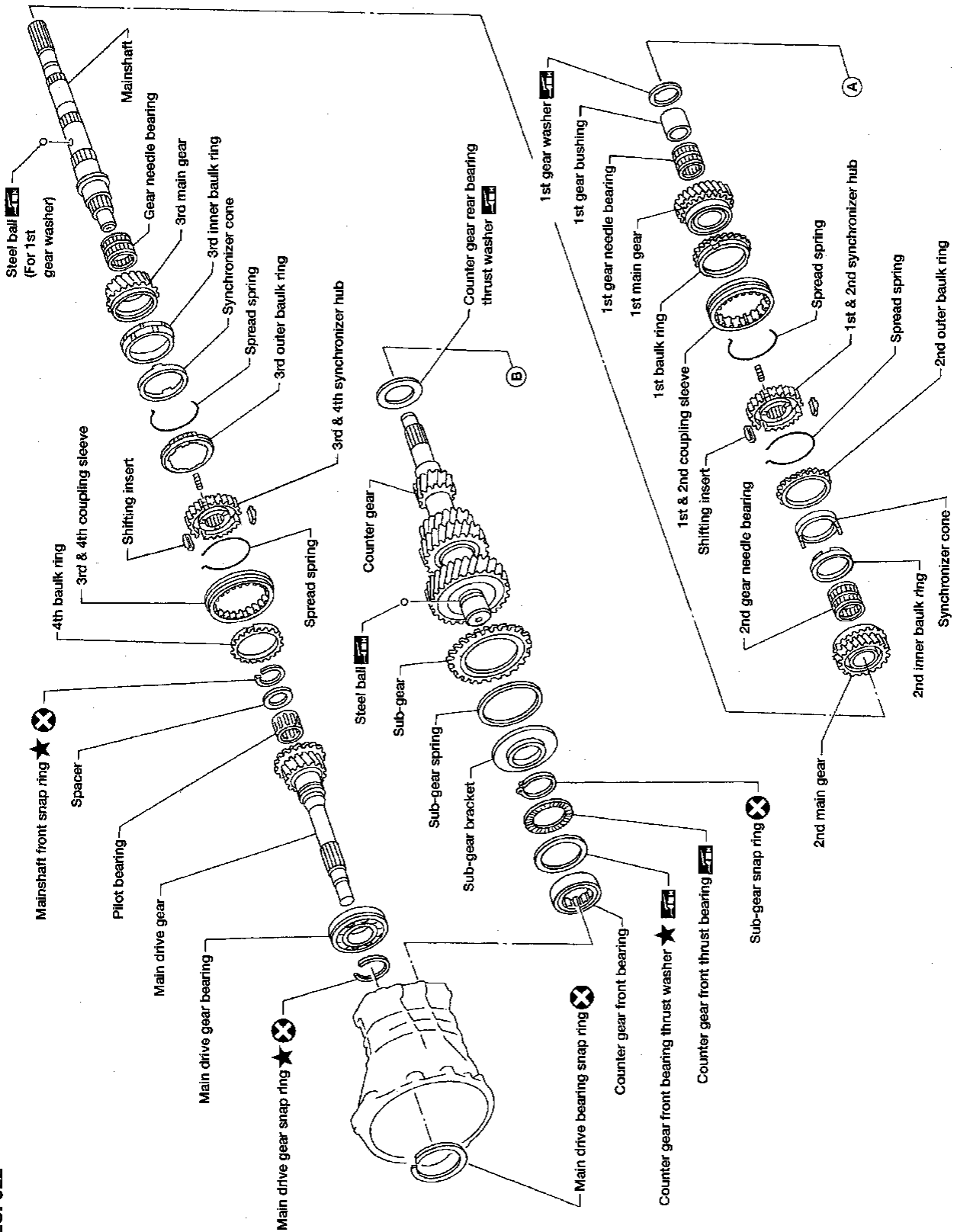
: N · m (kg-m, in-lb)
 : N · m (kg-m, ft-lb)

: Apply genuine liquid gasket, Three Bond TB1215, Loctite Part No. 51 813 or equivalent.
 : Apply genuine Three Bond TB1324, Loctite 271 or equivalent locking sealant.

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MAJOR OVERHAUL

Gear Components



SEC. 322

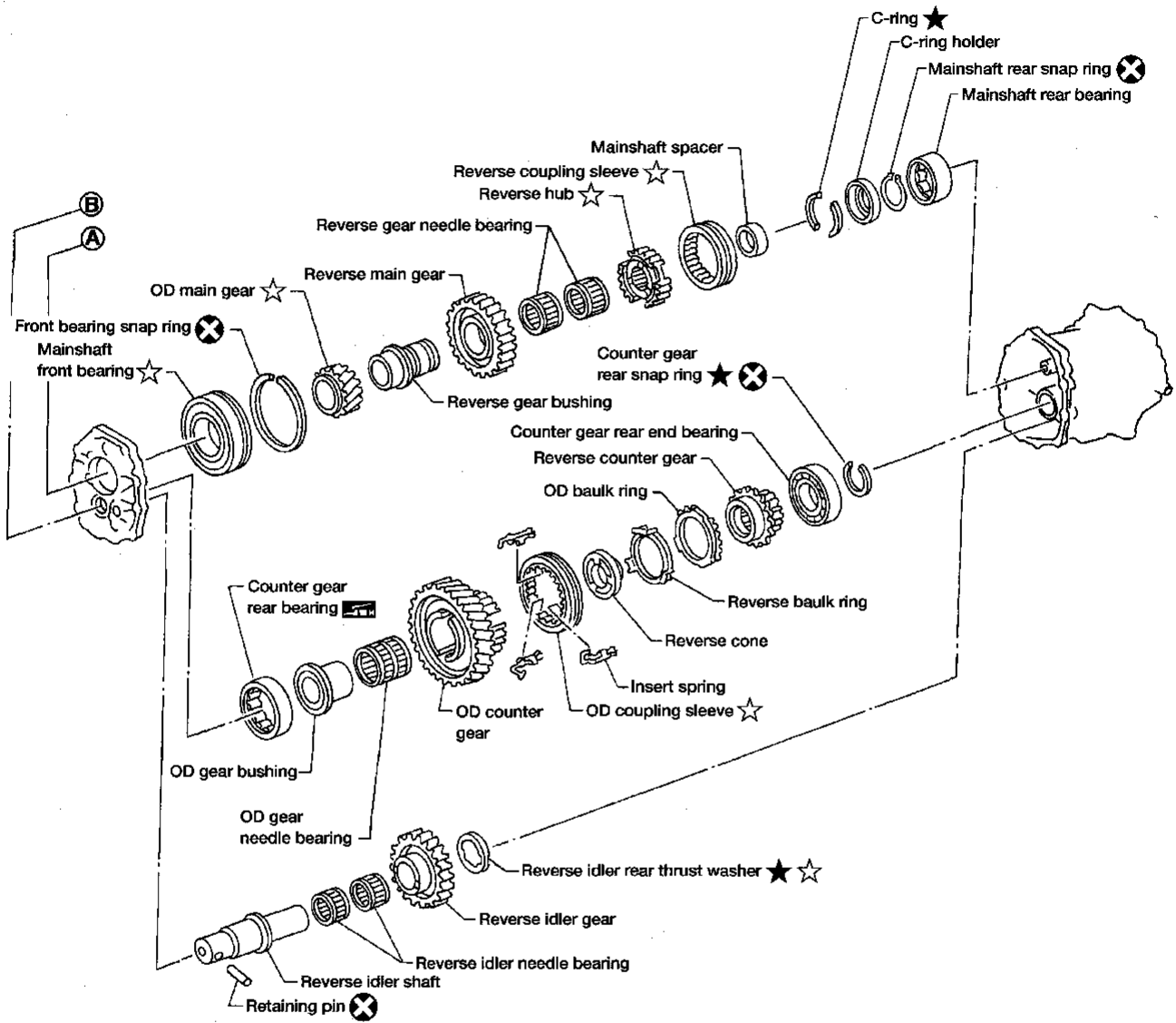
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AMT161

MAJOR OVERHAUL

Gear Components (Cont'd)

SEC. 322



Apply gear oil to gears, shafts, synchronizers and bearings when assembling.

★ : Select with proper thickness.

☆ : Pay attention to its direction.

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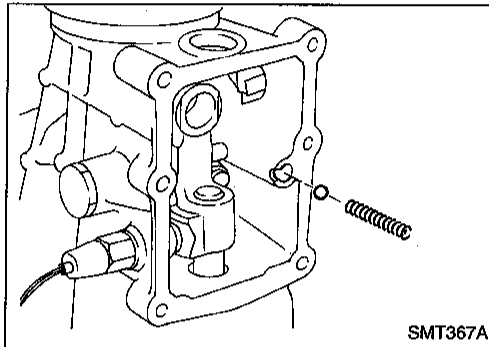
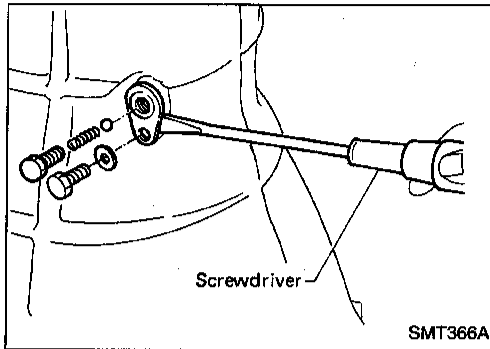
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MT-11

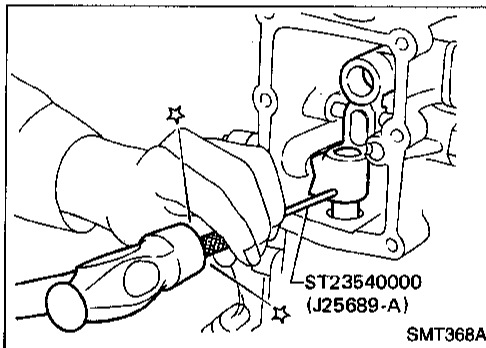
DISASSEMBLY

Case Components

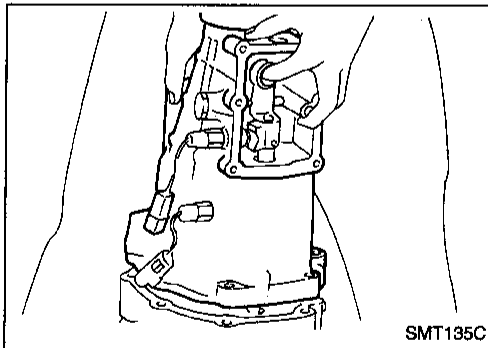
1. Remove check ball plug, check spring and check ball. Then remove interlock stopper.
 - If interlock assembly is removed as a unit, the check ball can fall into transmission case.
 - Be careful not to lose check ball.



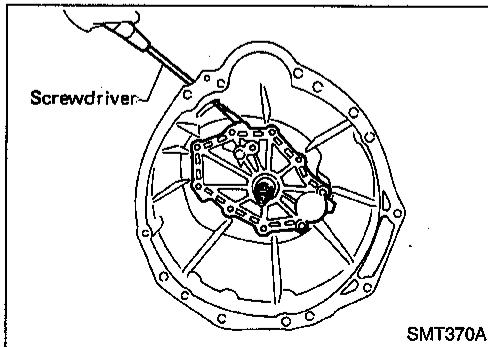
2. Remove control housing, return spring and check ball.
 - Be careful not to lose check ball.



3. Drive out retaining pin from striking arm.



4. Remove OD gear case together with striking arm by tapping lightly.



5. Remove front cover and gasket.

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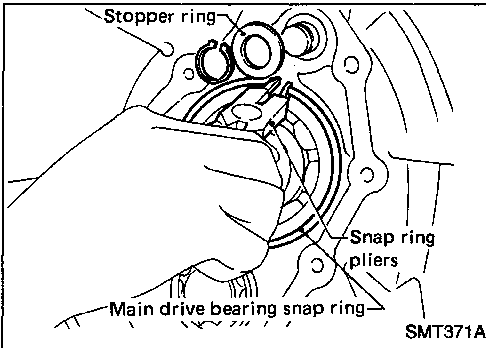
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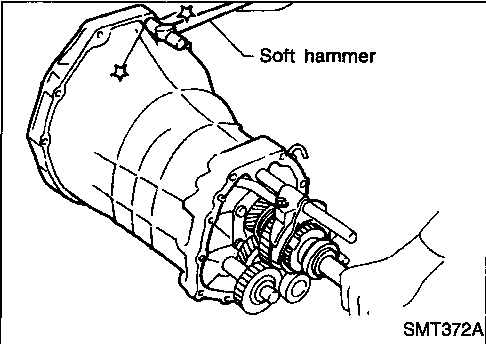
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DISASSEMBLY

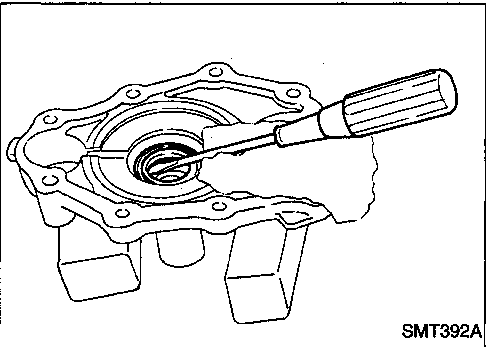
Case Components (Cont'd)



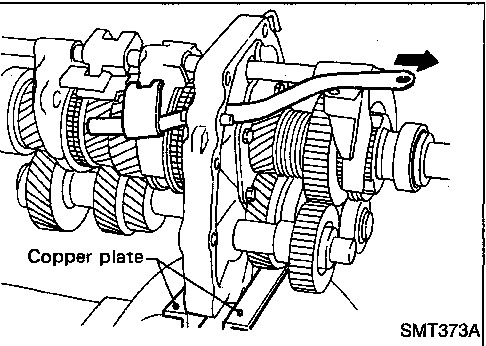
6. Remove stopper ring and main drive bearing snap ring.



7. Remove transmission case by tapping lightly.

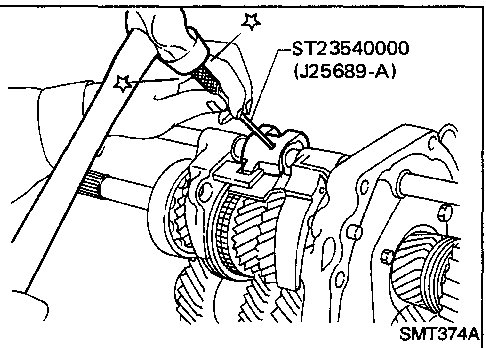


8. Remove front cover oil seal.



Shift Control Components

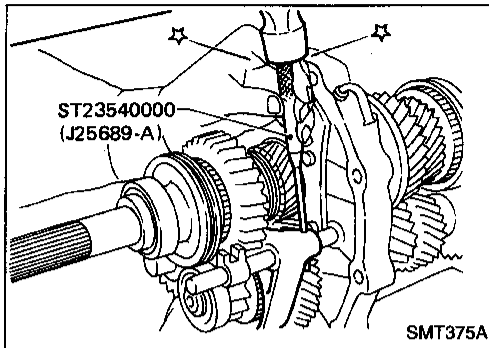
1. Mount adapter plate on vise.
2. Remove OD & reverse fork rod.



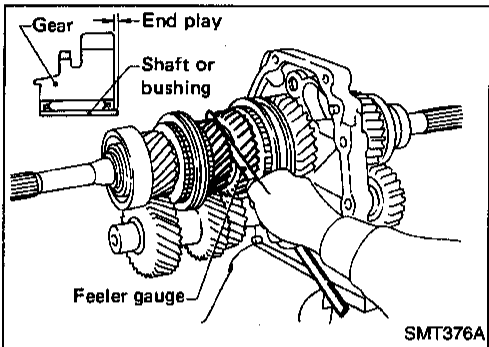
3. Drive out retaining pin from striking lever.
4. While pulling out striking rod, remove striking lever and striking interlock. Then remove 1st & 2nd, 3rd & 4th and reverse shift fork.

DISASSEMBLY

Shift Control Components (Cont'd)



5. Drive out retaining pin from OD shift fork.
6. Pull out OD fork rod and then remove OD shift fork.

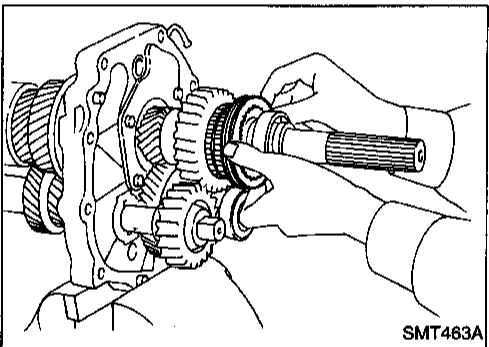


Gear Components

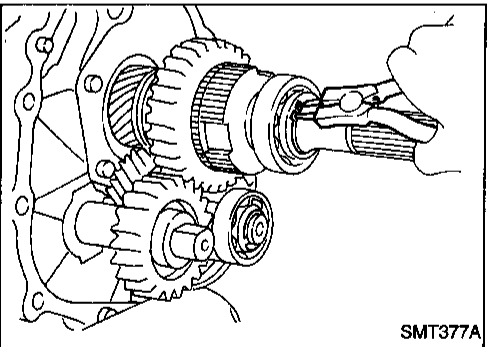
1. Before removing gears and shafts, measure each gear end play.

Gear end play:
Refer to SDS, MT-33.

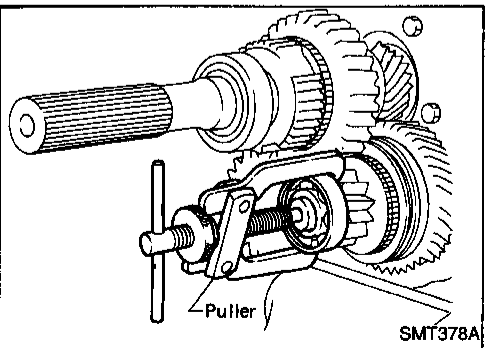
- If not within specification, disassemble and check contact surface of gear to hub, washer, bushing, needle bearing and shaft.



2. Remove rear side components on mainshaft and counter gear.
 - a. Remove reverse coupling sleeve.



- b. Remove mainshaft rear snap ring and counter gear rear snap ring.
 - c. Remove C-ring holder and mainshaft C-rings from mainshaft. Use punch and hammer to remove C-rings.



- d. Pull out counter gear rear end bearing.
 - e. Remove reverse idler gear and reverse idler thrust washers.

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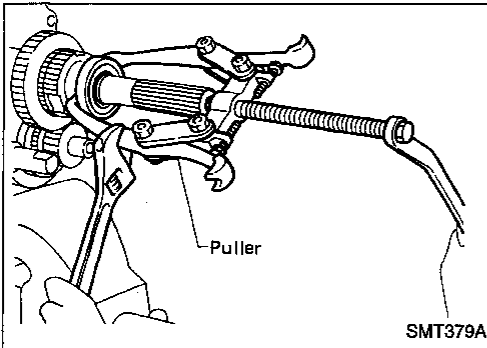
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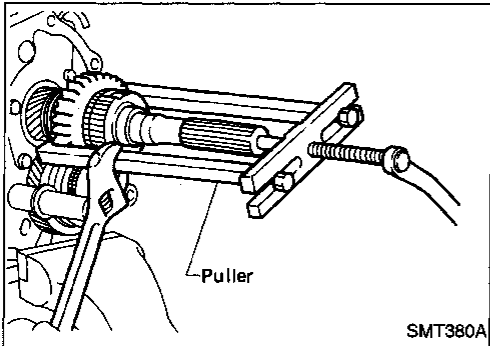
DISASSEMBLY

Gear Components (Cont'd)

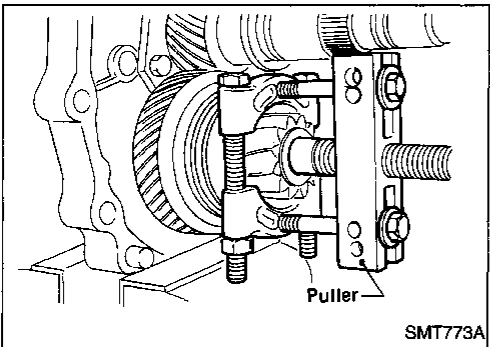
- f. Pull out mainshaft rear bearing.



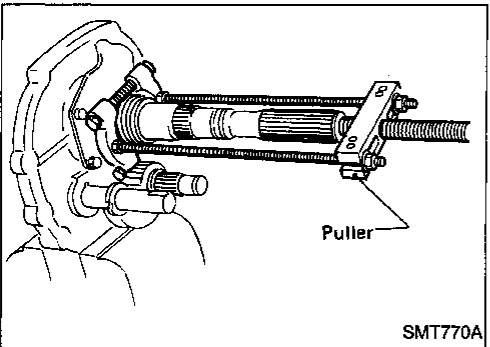
- g. Pull out reverse main gear together with mainshaft spacer and reverse synchronizer hub. Then remove reverse gear needle bearings.



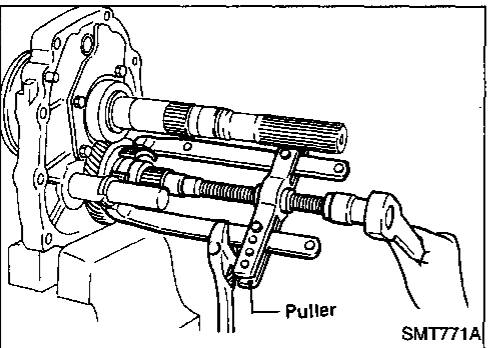
- h. Pull out reverse counter gear.
i. Remove OD coupling sleeve together with OD baulk ring, reverse baulk ring and spring inserts.



- j. Pull out reverse gear bushing.



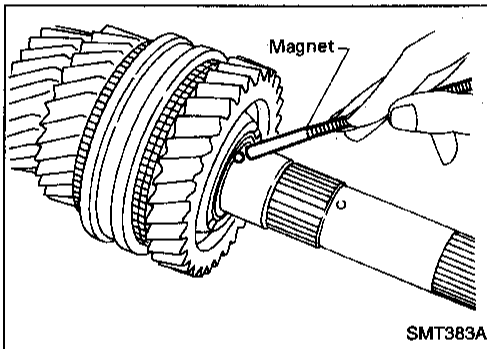
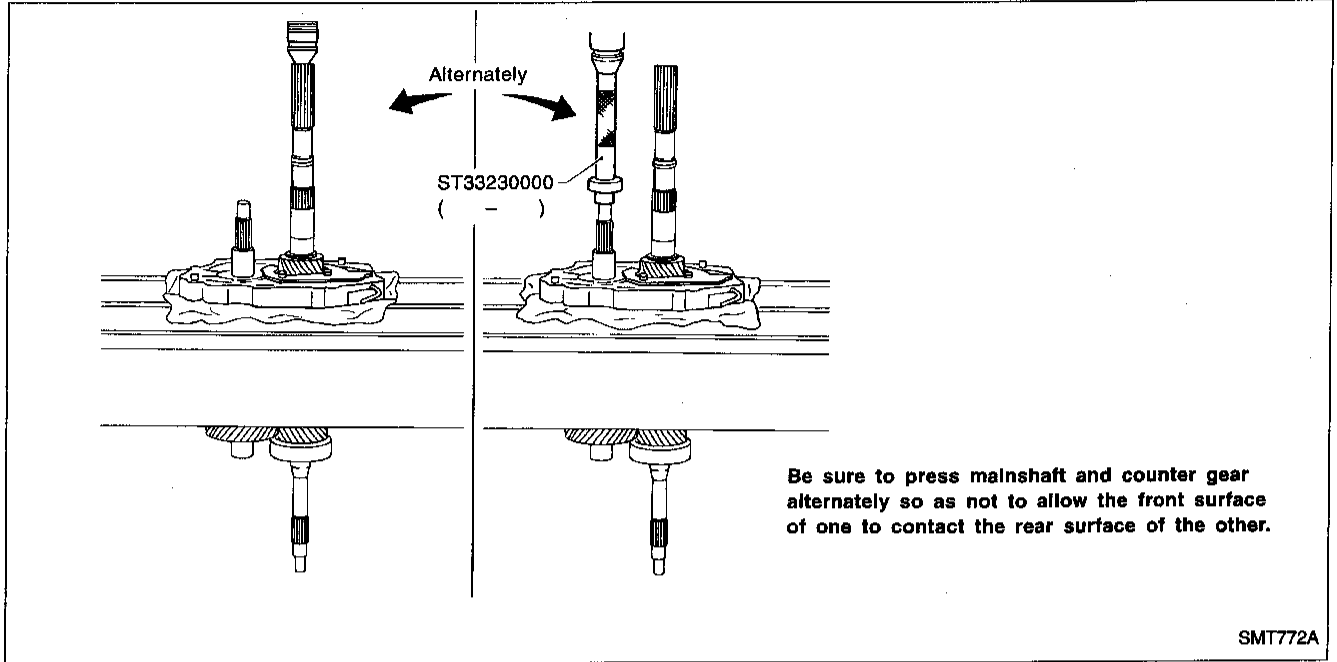
- k. Pull out OD counter gear together with reverse cone.



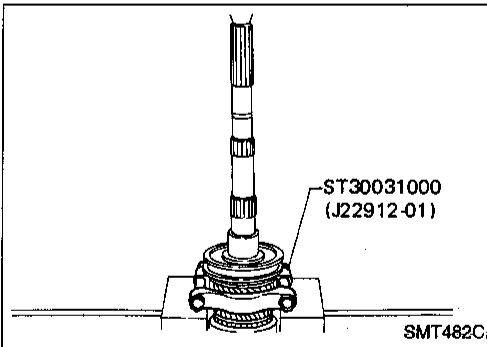
DISASSEMBLY

Gear Components (Cont'd)

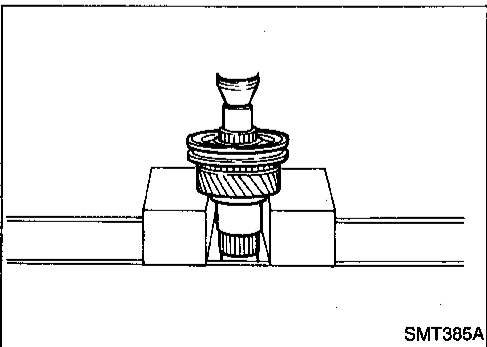
3. Press out mainshaft and counter gear alternately.



4. Remove front side components on mainshaft.
 - a. Remove 1st gear washer and steel ball.
 - b. Remove 1st main gear and 1st gear needle bearing.
 - Be careful not to lose steel ball.



- c. Press out 2nd main gear together with 1st gear bushing and 1st & 2nd synchronizer assembly.
- d. Remove mainshaft front snap ring.



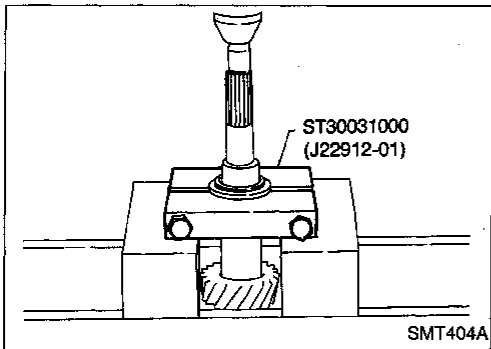
- e. Press out 3rd main gear together with 3rd & 4th synchronizer assembly and 3rd gear needle bearing.

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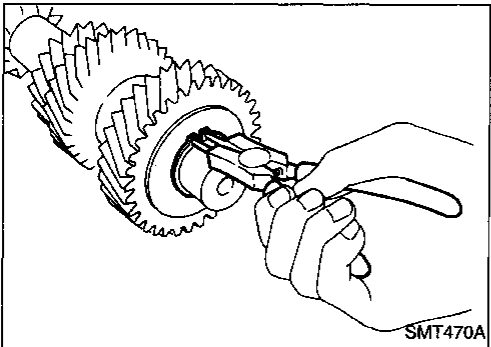
DISASSEMBLY

Gear Components (Cont'd)

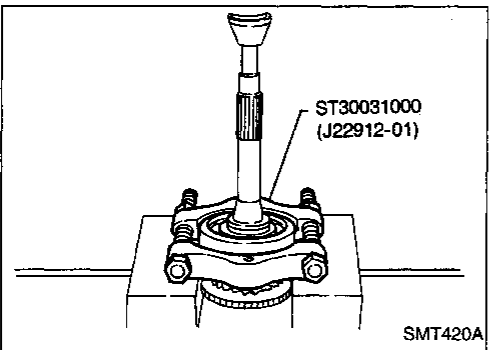
5. Remove front side components on counter gear.
 - a. Remove counter gear rear thrust bearing.



- b. Remove sub gear components.

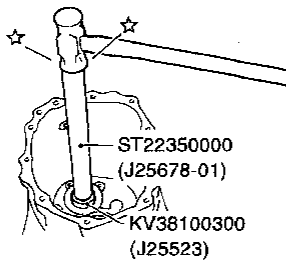


6. Remove main drive gear bearing.
 - a. Remove main drive gear snap ring.
 - b. Press out main drive gear bearing.

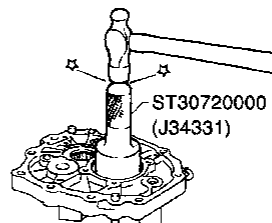


7. Remove bearings from case components.

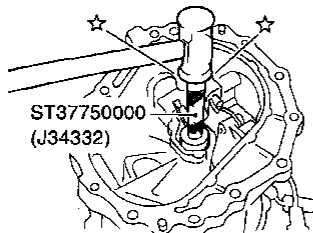
Counter gear front bearing in transmission case



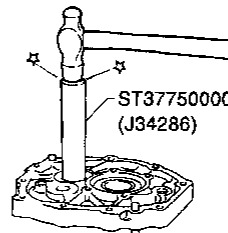
Mainshaft front bearing in adapter plate



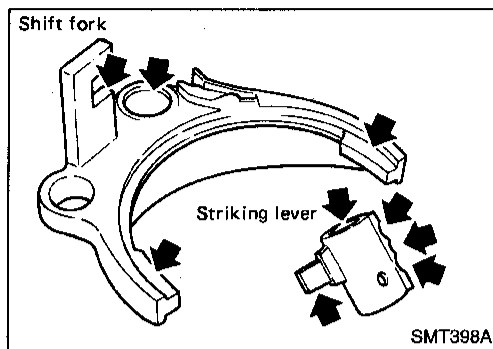
Mainshaft rear bearing in OD gear case



Counter gear rear bearing in adapter plate

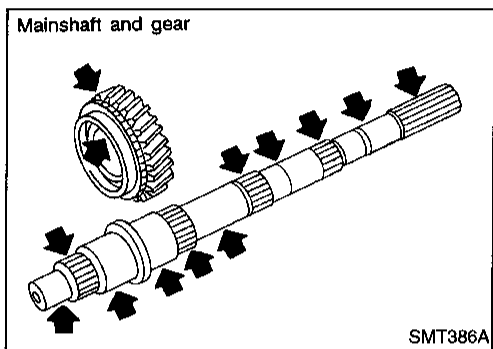


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Shift Control Components

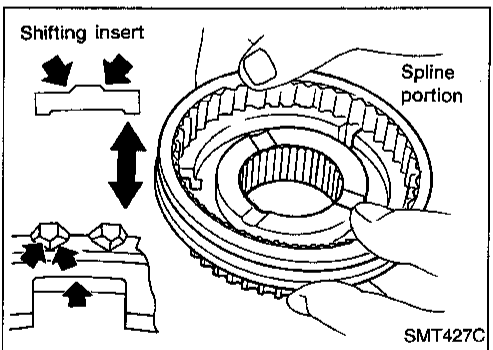
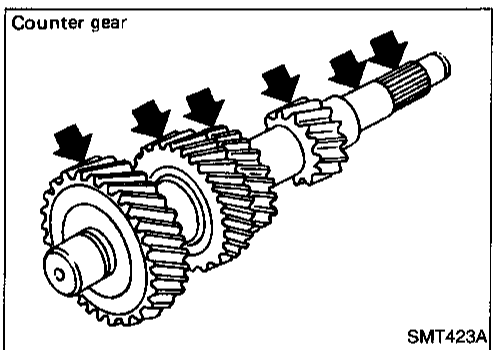
- Check contact surface and sliding surface for wear, scratches, projections or other damage.



Gear Components

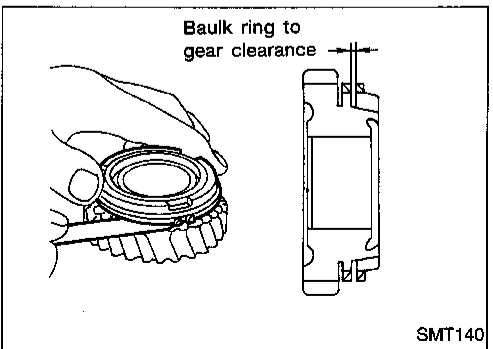
GEARS AND SHAFTS

- Check shafts for cracks, wear or bending.
- Check gears for excessive wear, chips or cracks.



SYNCHRONIZERS

- Check spline portion of coupling sleeves, hubs, and gears for wear or cracks.
- Check baulk rings for cracks or deformation.
- Check shifting inserts for wear or deformation.
- Check insert springs for deformation.



- Measure wear of main drive, 1st and OD baulk rings.
Clearance between baulk ring and gear:
Refer to SDS, MT-33.
- If the clearance is smaller than the wear limit, replace baulk ring.

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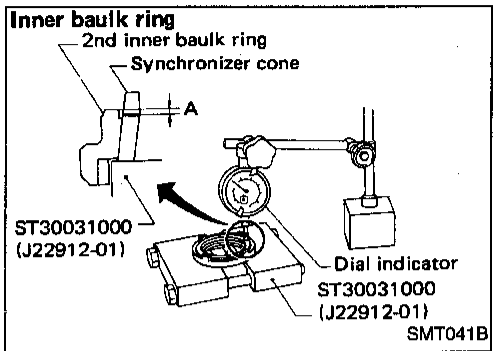
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INSPECTION

Gear Components (Cont'd)



- Measure wear of 2nd and 3rd baulk rings.
- a. Place baulk rings in position on synchronizer cone.
- b. While holding baulk rings against synchronizer cone as far as it will go, measure dimensions "A" and "B".

Standard:

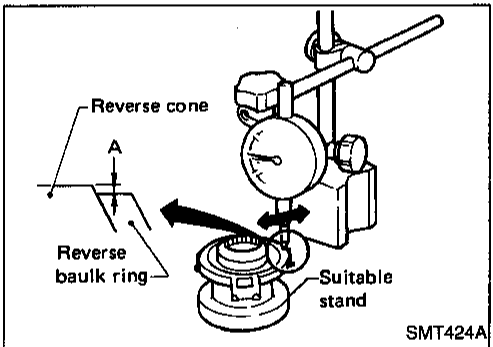
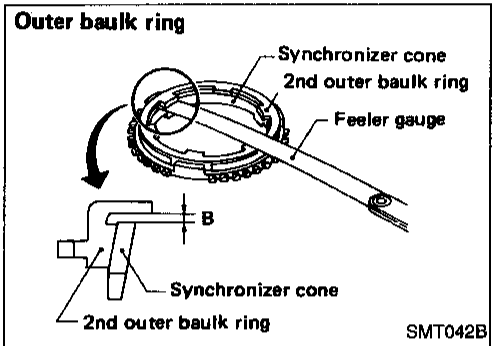
A 0.7 - 0.9 mm (0.028 - 0.035 in)

B 0.6 - 1.1 mm (0.024 - 0.043 in)

Wear limit:

0.2 mm (0.008 in)

- If dimension "A" or "B" is smaller than the wear limit, replace outer baulk ring, inner baulk ring and synchronizer cone as a set.



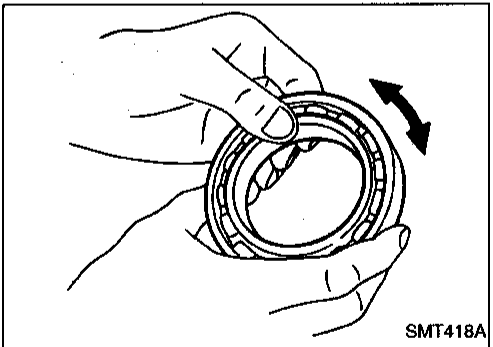
- Measure wear of reverse baulk ring.
- a. Place baulk ring in position on reverse cone.
- b. While holding baulk ring against reverse cone as far as it will go, measure dimension "A" with dial indicator.

Dimension "A":

Standard -0.1 to 0.35 mm (-0.0039 to 0.0138 in)

Wear limit 0.7 mm (0.028 in)

- c. If dimension "A" is larger than the wear limit, replace baulk ring.



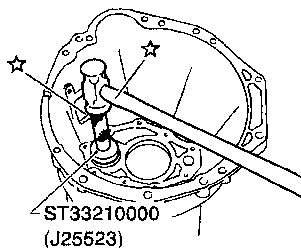
BEARINGS

- Make sure bearings roll freely and are free from noise, cracks, pitting or wear.

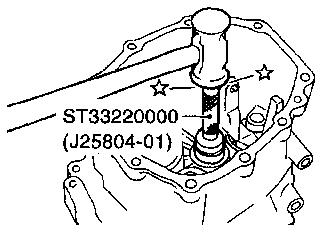
ASSEMBLY

Gear Components

Counter gear front bearing in transmission case

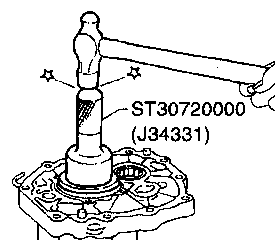


Mainshaft rear bearing in OD gear case

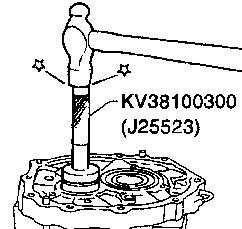


Be flush with front surface of OD gear case.

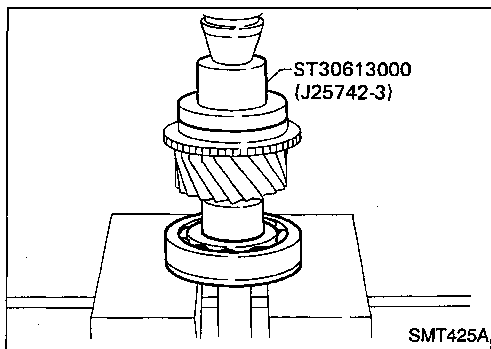
Mainshaft front bearing in adapter plate



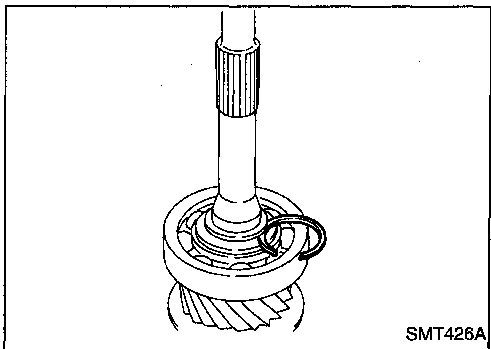
Counter gear rear bearing in adapter plate



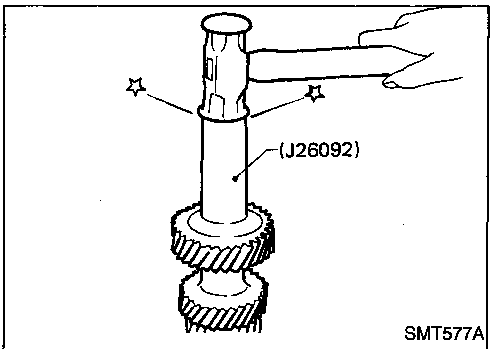
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SMT425A



SMT426A



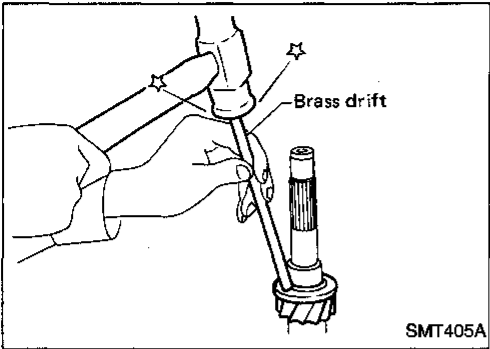
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1. Install bearings into case components.
2. Install main drive gear bearing.
 - a. Press main drive gear bearing.
 - b. Select proper main drive gear snap ring to minimize clearance of groove.
 - Allowable clearance of groove:**
0 - 0.1 mm (0 - 0.004 in)
 - Main drive gear snap ring:**
Refer to SDS, MT-33.
 - c. Install selected snap ring on main drive gear.
3. Install components on counter gear.
 - a. Install sub-gear components.
 - **When installing sub-gear snap ring, tap sub-gear snap ring into position on counter gear.**

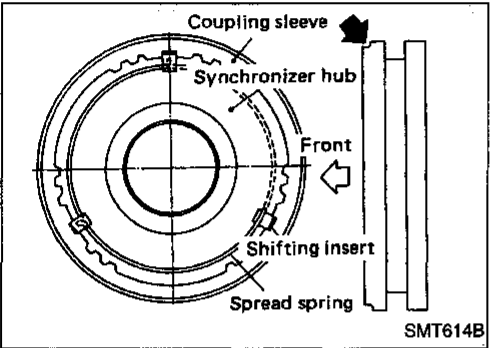
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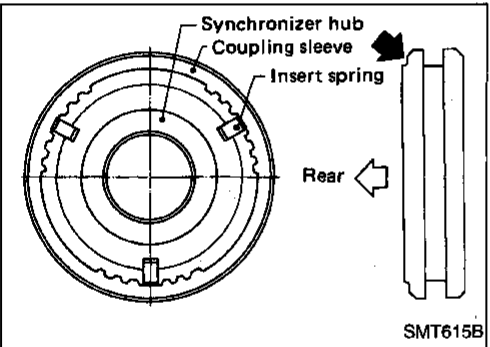
Gear Components (Cont'd)



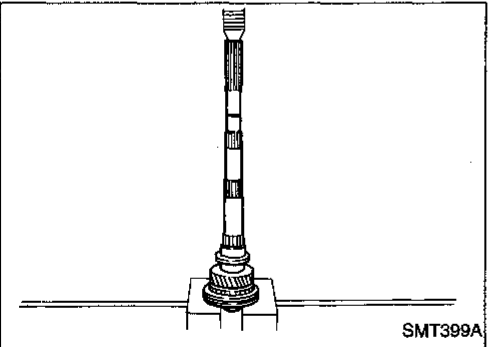
- b. Install counter gear rear thrust bearing.



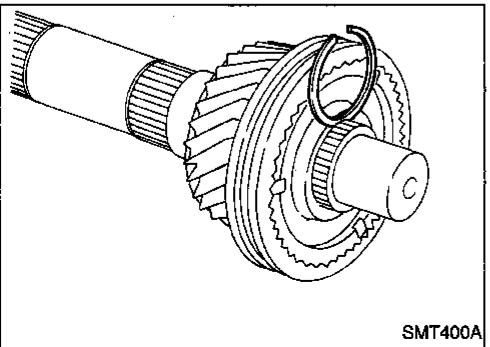
4. Install front side components on mainshaft.
a. Assemble 1st & 2nd synchronizer.



- b. Assemble 3rd & 4th synchronizer.



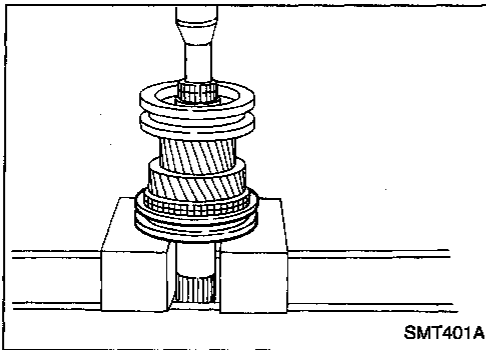
- c. Press on 3rd & 4th synchronizer assembly together with 3rd main gear and 3rd gear needle bearing.
● Pay attention to direction of synchronizer assembly.



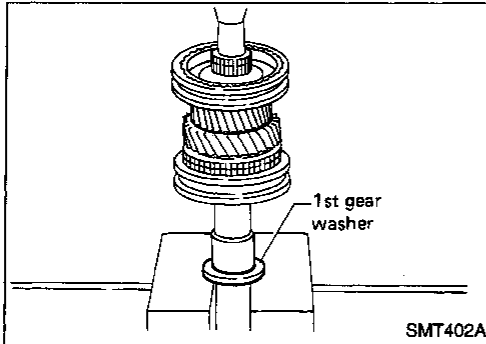
- d. Select proper snap ring to minimize clearance of groove.
Allowable clearance of groove:
0 - 0.1 mm (0 - 0.004 in)
Mainshaft front snap ring:
Refer to SDS, MT-33.
e. Install selected snap ring on mainshaft.

ASSEMBLY

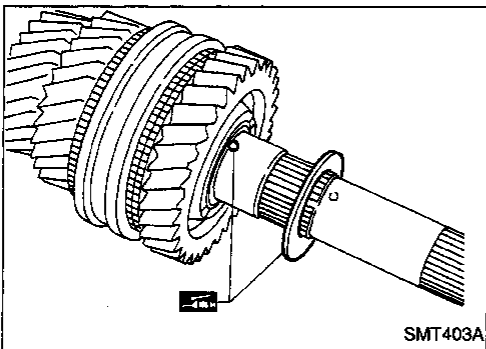
Gear Components (Cont'd)



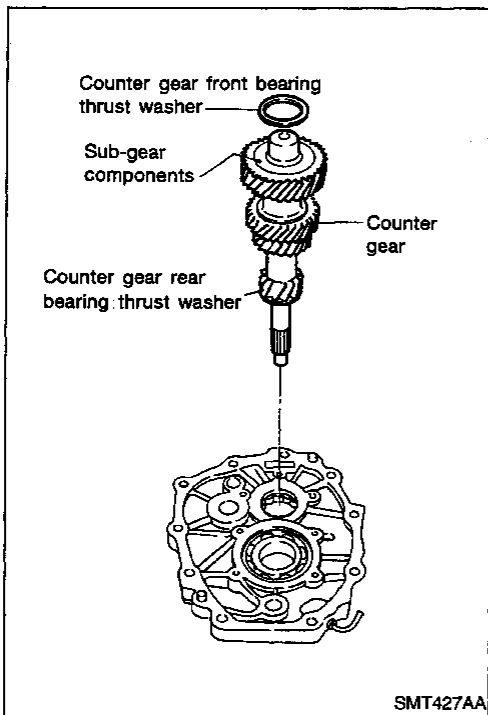
- f. Press on 1st & 2nd synchronizer assembly together with 2nd main gear and 2nd gear needle bearing.



- g. Press on 1st gear bushing using 1st gear washer.
h. Install 1st main gear and needle bearing.



- i. Install steel ball and 1st gear washer.
• Apply multi-purpose grease to steel ball and 1st gear washer before installing.

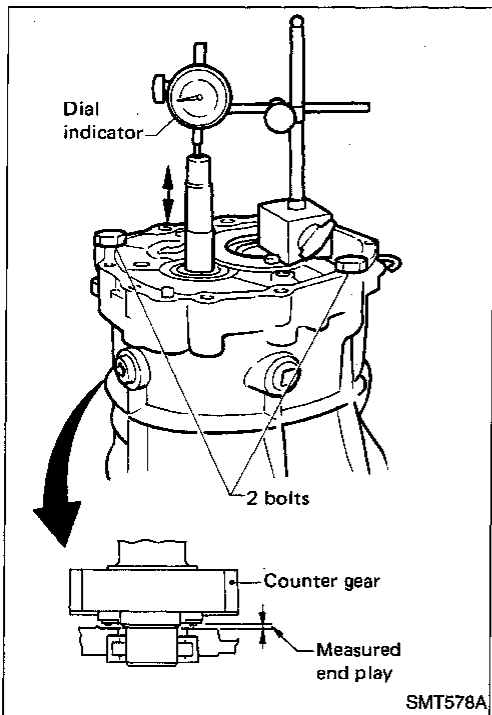


5. Select proper counter gear front bearing thrust washer when replacing transmission case, counter gear, counter gear rear thrust bearing or sub-gear components.
- a. Install counter gear with sub-gear components, counter gear front and rear bearing thrust washer on adapter plate.
- b. Remove counter gear front bearing thrust washer from transmission case.
- c. Place adapter plate and counter gear assembly in transmission case (case inverted).

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ASSEMBLY

Gear Components (Cont'd)



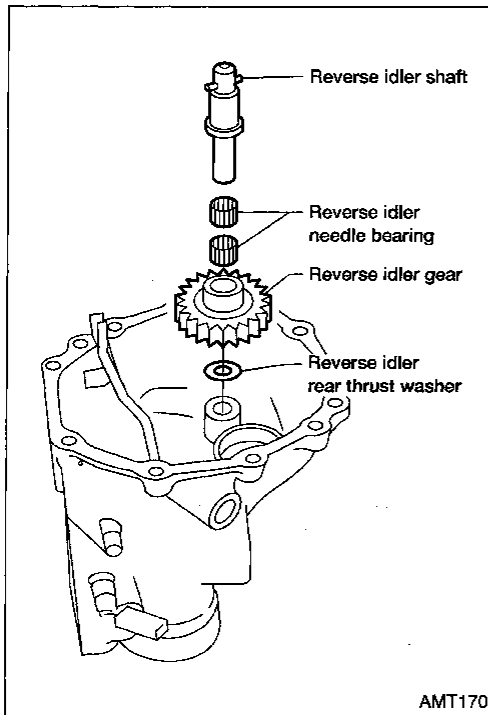
- d. Tighten adapter plate to transmission case using 2 bolts.
- e. Place dial indicator on rear end of counter gear.
- f. Move counter gear up and down and measure dial indicator deflection.
- g. Select proper thrust washer using table below as a guide.

Counter gear end play:

0.10 - 0.26 mm (0.0039 - 0.0098 in)

Table for selecting proper counter gear front bearing thrust washer:

Refer to SDS, MT-34.



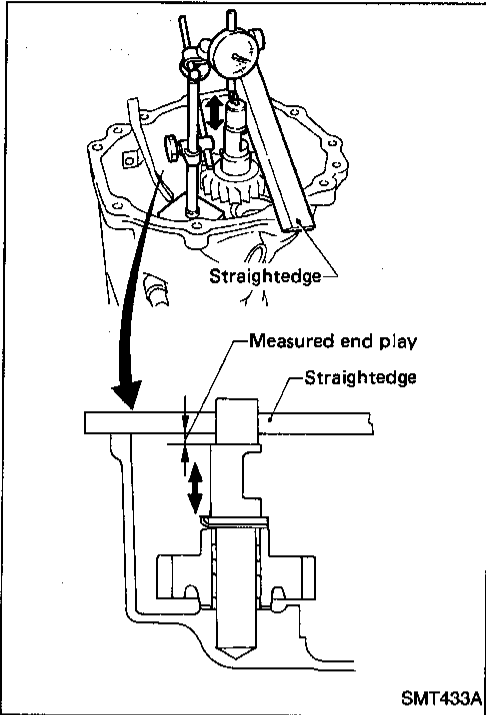
6. Select proper reverse idler rear thrust washer when replacing OD gear case, reverse idler gear, reverse idler shaft.
- a. Install reverse idler gear, reverse idler needle bearings, reverse idler front thrust washers and reverse idler shaft into OD gear case.
- **When replacing reverse idler rear thrust washer, install either A or B.**

Reverse idler rear thrust washer:

Refer to SDS, MT-34.

ASSEMBLY

Gear Components (Cont'd)

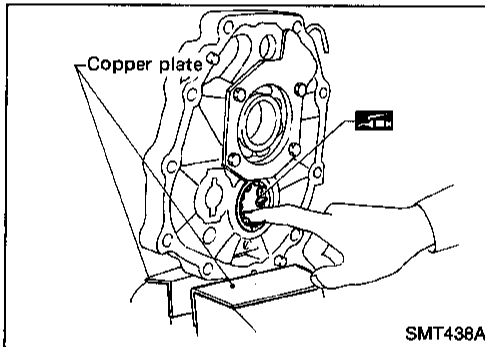


- b. Place dial indicator on front end of reverse idler shaft.
- c. Put straightedge on front surface of rear extension (or OD gear case) as a stopper of reverse idler shaft.
- d. Move reverse idler shaft up and down and measure reverse idler gear end play.

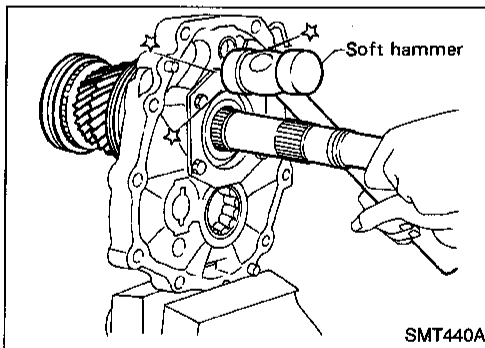
Reverse idler gear end play:

0.30 - 0.53 mm (0.0118 - 0.0209 in)

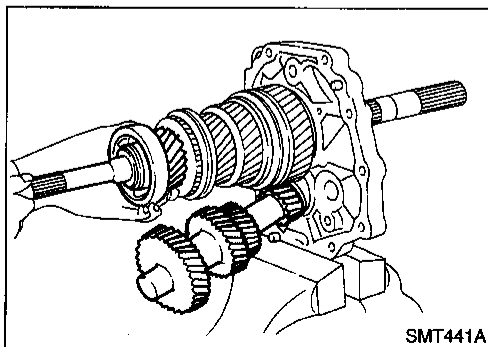
- e. If not within specification, replace reverse idler rear thrust washer with the other (A or B) and check again.



- 7. Install mainshaft and counter gear on adapter plate and main drive gear on mainshaft.
 - a. Mount adapter plate on vise and apply multi-purpose grease to counter gear rear bearing.



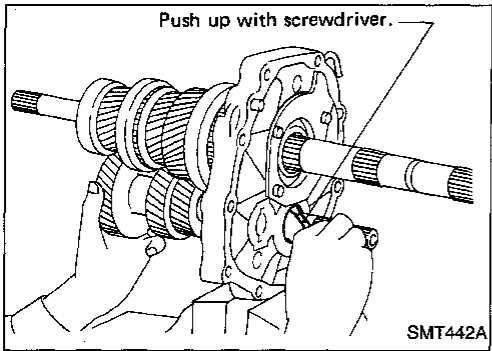
- b. Install mainshaft a little on mainshaft front bearing.
 - **To allow for installation of counter gear, do not install mainshaft completely.**



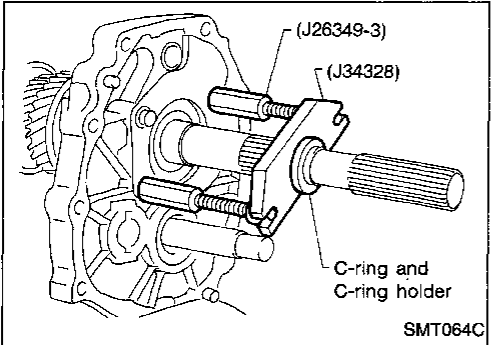
- c. Install counter gear on counter gear rear bearing and install main drive gear, pilot bearing and spacer on mainshaft.

ASSEMBLY

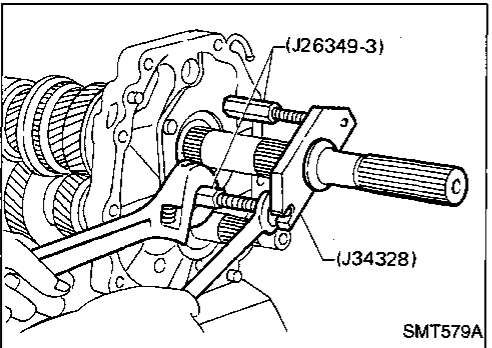
Gear Components (Cont'd)



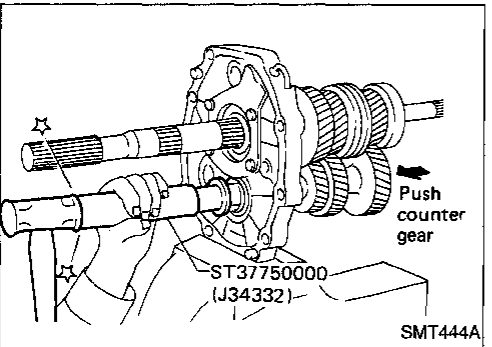
- When installing counter gear into counter gear rear bearing, push up on upper roller of counter gear rear bearing with screwdriver.



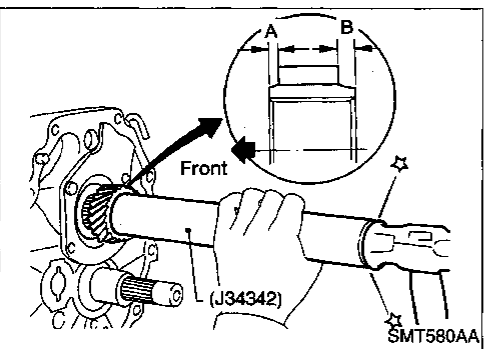
- Install Tools (J26349-3) onto adapter plate and C-ring and C-ring holder on mainshaft.
- Install Tool (J34328) on mainshaft.



- Install mainshaft and counter gear completely by extending length of (J26349-3).



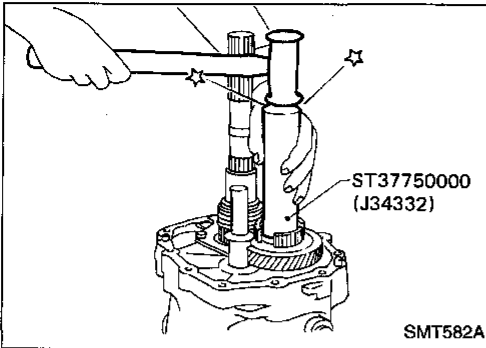
- Install rear side components on mainshaft and counter gear.
 - Install OD gear bushing while pushing on the front of counter gear.



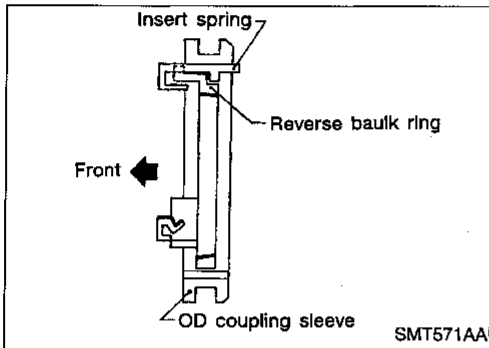
- Install OD main gear.
 - Pay attention to direction of OD main gear. (B is wider than A as shown at left.)
- Install adapter plate with gear assembly onto transmission case.
- Install OD gear needle bearing and then install OD counter gear and reverse idler shaft.

ASSEMBLY

Gear Components (Cont'd)

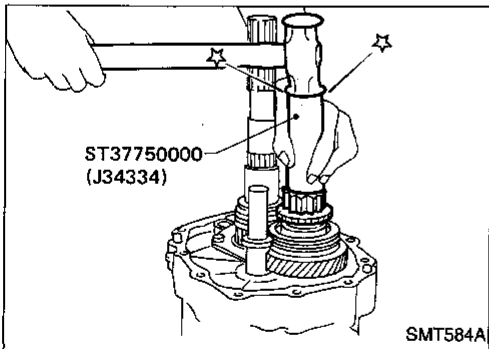
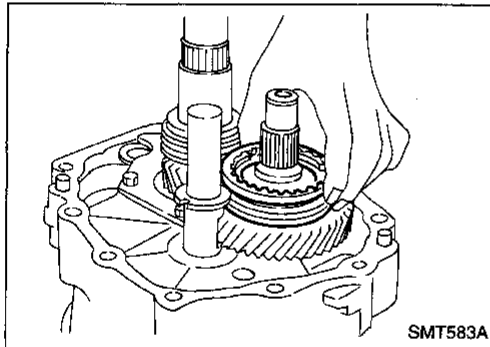


e. Install reverse cone.



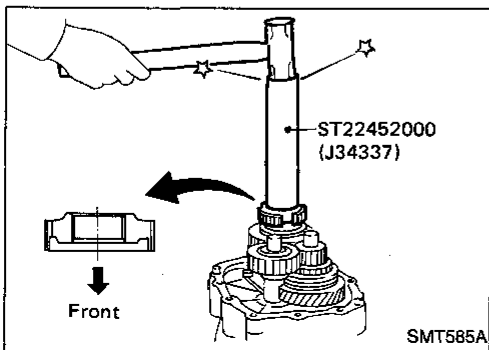
f. Install insert springs and reverse baulk ring on OD coupling sleeve. Then install them and OD baulk ring on OD counter gear.

- Pay attention to direction of OD coupling sleeve.



g. Install reverse counter gear.

h. Install reverse gear needle bearing and then install reverse main gear, reverse idler gear and reverse idler thrust washers.



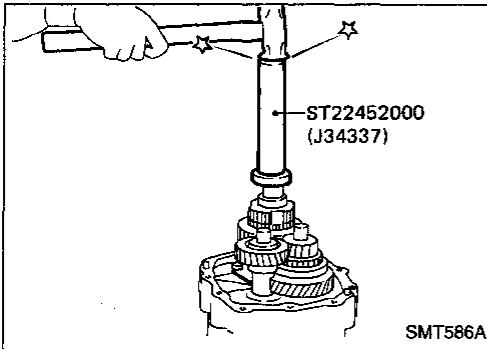
i. Install reverse hub.

- Pay attention to its direction.

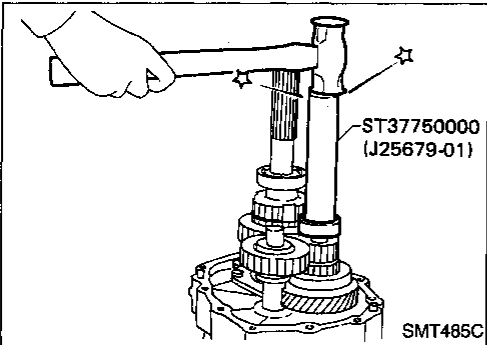
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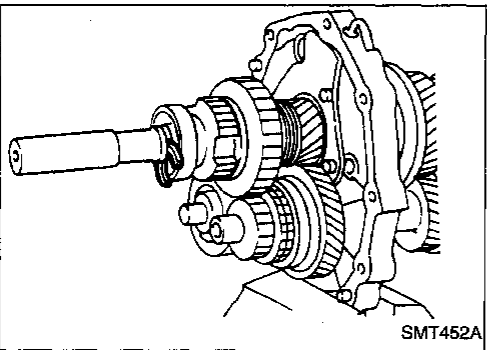
Gear Components (Cont'd)



- j. Install mainshaft spacer and mainshaft rear bearing.



- k. Install counter gear rear end bearing.
l. Separate adapter plate from transmission case and mount adapter plate on vice again.



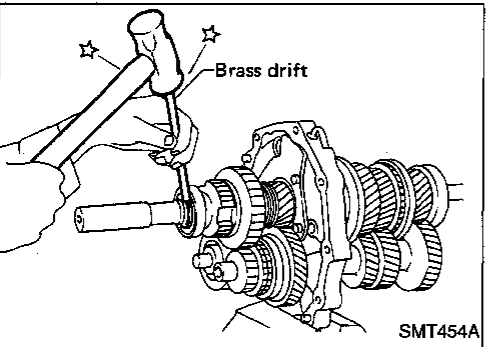
- m. Select proper mainshaft C-ring to minimize clearance of groove.

Allowable clearance of groove:

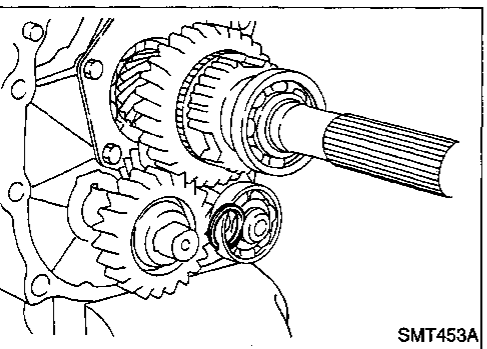
0 - 0.1 mm (0 - 0.004 in)

Mainshaft C-ring:

Refer to SDS, MT-34.



- n. Install selected C-ring, C-ring holder and mainshaft rear snap ring.



- o. Select proper counter gear rear snap ring to minimize clearance of groove.

Allowable clearance of groove:

0 - 0.1 mm (0 - 0.004 in)

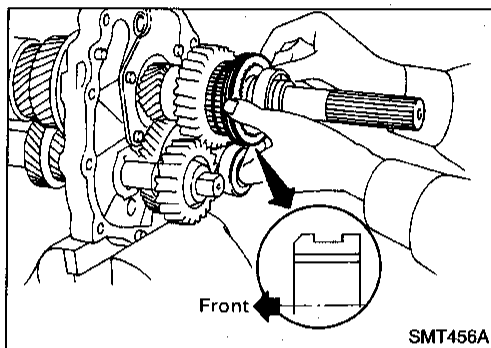
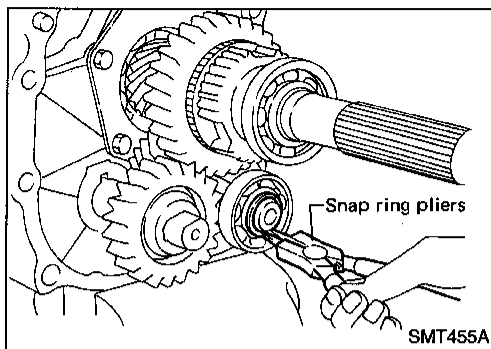
Counter gear rear snap ring:

Refer to SDS, MT-34.

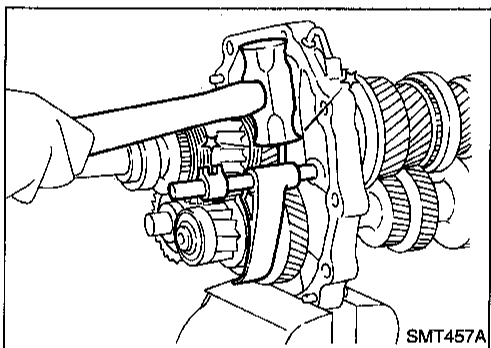
- p. Install selected counter gear rear snap ring.

ASSEMBLY

Gear Components (Cont'd)

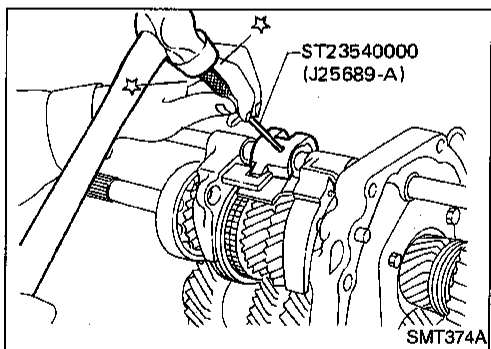


- q. Install reverse coupling sleeve.
 - **Pay attention to its direction.**
- r. Measure each gear end play as a final check. Refer to "DISASSEMBLY", MT-15.

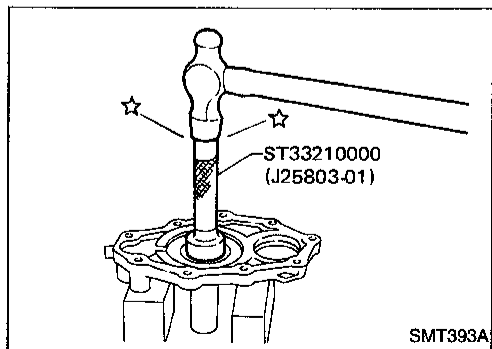


Shift Control Components

1. Install OD fork rod and OD shift fork. Then install retaining pin into OD shift fork.
2. Install 1st & 2nd, 3rd & 4th and reverse shift fork onto coupling sleeve.



3. Install striking rod into hole of shift forks, striking lever and interlock and then install retaining pin into striking lever.
 - **Make sure that striking rod moves smoothly.**



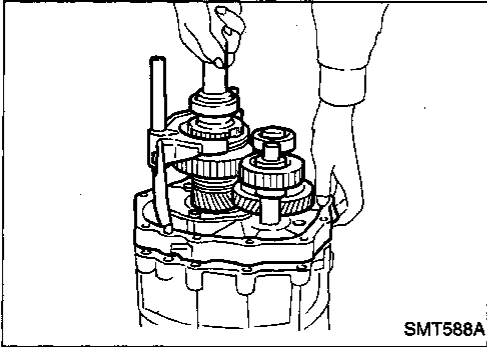
Case Components

1. Install front cover oil seal.
 - **Apply multi-purpose grease to seal lip.**
2. Install selected counter gear front bearing shim onto transmission case.
 - **Apply multi-purpose grease.**
3. Apply sealant to mating surface of transmission case.

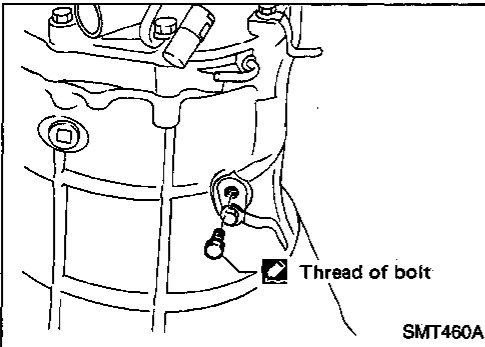
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ASSEMBLY

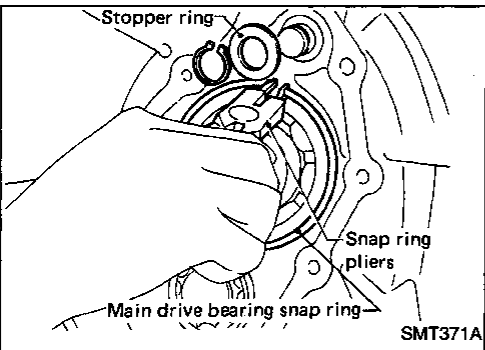
Case Components (Cont'd)



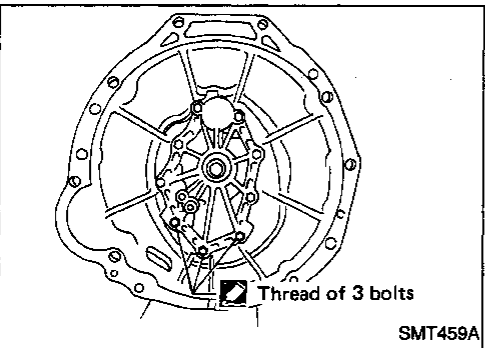
4. Install gear assembly onto transmission case.
 5. Install check spring and check ball into interlock stopper.
- **Apply multi-purpose grease to check ball.**



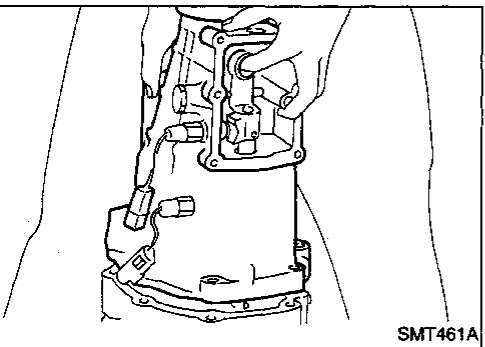
6. Install interlock stopper assembly and then tighten check ball plug.
- **Apply sealant to thread of check ball plug.**



7. Install stopper ring and main drive bearing snap ring.



8. Install front cover and gasket.
- **Apply sealant to thread of 3 bolts shown left.**
9. Apply sealant to mating surface of adapter plate.

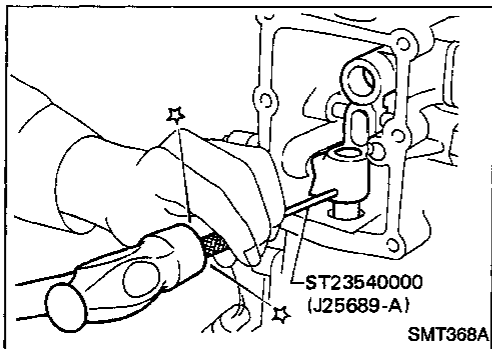


10. Install OD gear case together with striking arm.

ASSEMBLY

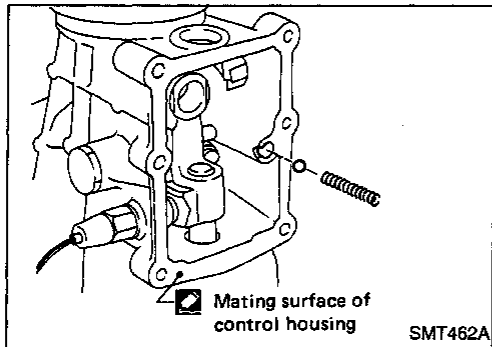
Case Components (Cont'd)

11. Install retaining pin into striking arm.



12. Install return spring and check ball and then install control housing.

- Apply sealant to mating surface of OD gear case.

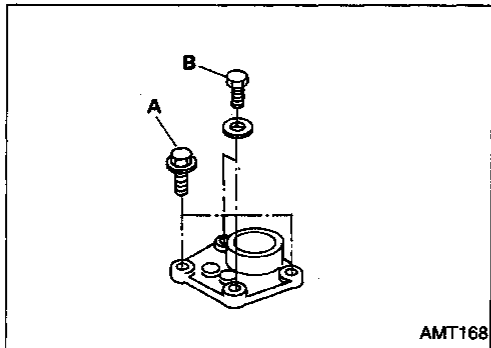


13. Tighten control housing bolts.

Bolt head size:

A bolts 12 mm (0.47 in)

B bolts 13 mm (0.51 in)



GI

MA

EM

LC

EC

FE

CL

MT

AT

TF

PD

FA

RA

BR

ST

RS

BT

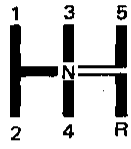
HA

EL

IDX

SERVICE DATA AND SPECIFICATIONS (SDS)

General Specifications

Applied model	VG33E
	4WD
Transmission	FS5R30A
Number of speed	5
Shift pattern	
Synchromesh type	Warner
Gear ratio	
1st	3.580
2nd	2.077
3rd	1.360
4th	1.000
OD	0.811
Reverse	3.636
Number of teeth	
Mainshaft	
Drive	22
1st	32
2nd	30
3rd	29
OD	24
Reverse	30
Countershaft	
Drive	32
1st	13
2nd	21
3rd	31
OD	43
Reverse	12
Reverse idler gear	22
Oil capacity ℓ (US pt, Imp pt)	5.1 (10-3/4, 9)
Remarks	2nd & 3rd double baulk ring type synchronizer

SERVICE DATA AND SPECIFICATIONS (SDS)

Inspection and Adjustment

GEAR END PLAY

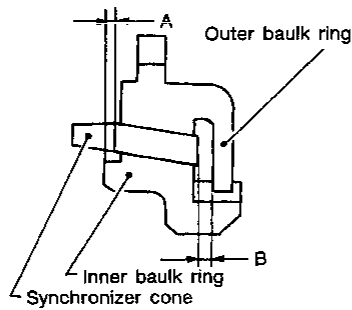
Gear	End play mm (in)
1st main gear	0.23 - 0.33 (0.0091 - 0.0130)
2nd main gear	0.23 - 0.33 (0.0091 - 0.0130)
3rd main gear	0.06 - 0.16 (0.0024 - 0.0063)
OD counter gear	0.23 - 0.33 (0.0091 - 0.0130)
Reverse main gear	0.33 - 0.43 (0.0130 - 0.0169)
Counter gear	0.10 - 0.25 (0.0039 - 0.0098)
Reverse idler gear	0.30 - 0.53 (0.0118 - 0.0209)

CLEARANCE BETWEEN BAULK RING AND GEAR

Unit: mm (in)

	Standard	Wear limit
1st	1.05 - 1.3 (0.0413 - 0.0512)	0.7 (0.028)
Main drive	1.05 - 1.3 (0.0413 - 0.0512)	
OD	1.05 - 1.3 (0.0413 - 0.0512)	

2nd and 3rd baulk ring

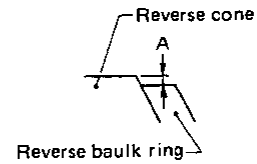


SMT742C

Unit: mm (in)

Dimension	Standard	Wear limit
A	0.7 - 0.9 (0.028 - 0.035)	0.2 (0.008)
B	0.6 - 1.1 (0.024 - 0.043)	

DISTANCE BETWEEN REAR SURFACE OF REVERSE CONE AND REVERSE BAULK RING



Unit: mm (in)

	Standard	Wear limit
Dimension "A"	-0.1 to 0.35 (-0.0039 to 0.0138)	0.7 (0.028)

AVAILABLE SNAP RING

Main drive gear snap ring

Allowable clearance 0 - 0.1 mm (0 - 0.004 in)

Thickness mm (in)	Part number
1.89 (0.0744)	32204-01G60
1.95 (0.0768)	32204-01G61
1.99 (0.0783)	32204-01G62
2.03 (0.0799)	32204-01G63
2.07 (0.0815)	32204-01G64
2.11 (0.0831)	32204-01G65

Mainshaft front snap ring

Allowable clearance 0 - 0.1 mm (0 - 0.004 in)

Thickness mm (in)	Part number
1.99 (0.0783)	32204-01G62
2.03 (0.0799)	32204-01G63
2.07 (0.0815)	32204-01G64
2.11 (0.0831)	32204-01G65
2.15 (0.0846)	32204-01G66
2.19 (0.0862)	32204-01G67

SERVICE DATA AND SPECIFICATIONS (SDS)

Inspection and Adjustment (Cont'd)

Counter gear rear snap ring

Allowable clearance		0 - 0.1 mm (0 - 0.004 in)
Thickness	mm (in)	Part number
1.32	(0.0520)	32236-01G00
1.38	(0.0543)	32236-01G01
1.44	(0.0567)	32236-01G02
1.50	(0.0591)	32236-01G03
1.56	(0.0614)	32236-01G04
1.62	(0.0638)	32236-01G05
1.68	(0.0661)	32236-01G06
1.74	(0.0685)	32236-01G07

AVAILABLE C-RING

Mainshaft C-ring

Allowable clearance		0 - 0.1 mm (0 - 0.004 in)
Thickness	mm (in)	Part number
2.63	(0.1035)	32348-01G15
2.70	(0.1063)	32348-01G00
2.77	(0.1091)	32348-01G01
2.84	(0.1118)	32348-01G02
2.91	(0.1146)	32348-01G03
2.98	(0.1173)	32348-01G04
3.05	(0.1201)	32348-01G05
3.12	(0.1228)	32348-01G06
3.19	(0.1256)	32348-01G07
3.26	(0.1283)	32348-01G08
3.33	(0.1311)	32348-01G09
3.40	(0.1339)	32348-01G10
3.47	(0.1366)	32348-01G11
3.54	(0.1394)	32348-01G12
3.61	(0.1421)	32348-01G13
3.68	(0.1449)	32348-01G14

AVAILABLE SHIM AND WASHER

Table for selecting proper counter gear front bearing thrust washer

Allowable end play		0.10 - 0.26 mm (0.00 - 0.10 in)	
Dial indicator deflection	mm (in)	Thickness of proper washer	Part number
		mm (in)	
0.93 - 1.02	(0.0366 - 0.0402)	0.80 (0.0315)	32218-01G00
1.01 - 1.10	(0.0398 - 0.0433)	0.88 (0.0346)	32218-01G11
1.09 - 1.18	(0.0429 - 0.0465)	0.96 (0.0378)	32218-01G12
1.17 - 1.26	(0.0461 - 0.0496)	1.04 (0.0409)	32218-01G13
1.25 - 1.34	(0.0492 - 0.0528)	1.12 (0.0441)	32218-01G14
1.33 - 1.42	(0.0524 - 0.0559)	1.20 (0.0472)	32218-01G04
1.41 - 1.50	(0.0555 - 0.0591)	1.28 (0.0504)	32218-01G15
1.49 - 1.58	(0.0587 - 0.0622)	1.36 (0.0535)	32218-01G16
1.57 - 1.66	(0.0618 - 0.0654)	1.44 (0.0567)	32218-01G17

Reverse idler rear thrust washer

Allowable end play		0.30 - 0.53 mm (0.01 - 0.02 in)	
		Thickness	Part number
		mm (in)	
A	1.97	(0.0776)	32284-01G10
B	2.07	(0.0815)	32284-01G11