

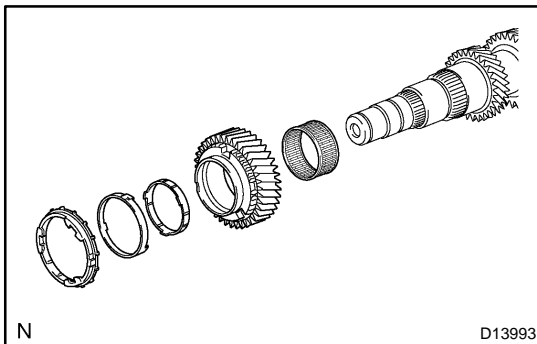
## REASSEMBLY

### 1. REASSEMBLE CLUTCH HUB NO.1

- Apply gear oil to the clutch hub sleeve and clutch hub.
- Install the clutch hub sleeve to the clutch hub.
- Install the 3 shifting keys to the clutch hub.
- Install the 3 shifting key springs to the clutch hub.
- Place the balls on the holes on the shifting keys, and install the hub sleeve while pushing down the balls.

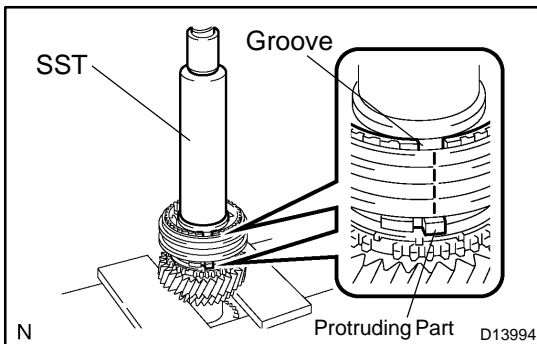
#### NOTICE:

Be careful not to scatter the balls.



### 2. INSTALL 2ND GEAR

- Apply gear oil to the needle roller bearing and 2nd gear taper cone.
- Install the needle roller bearing, 2nd gear and synchronizer ring set No.1 to the counter shaft.

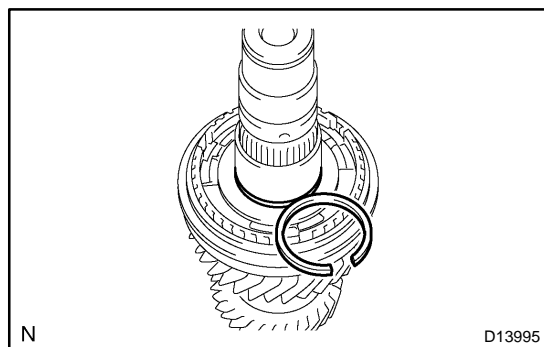


- Using SST and a press, install the clutch hub No.1.  
SST 09308-14010

#### HINT:

Make sure that the protruding part on the synchronizer ring is fitted into the groove of the clutch hub.

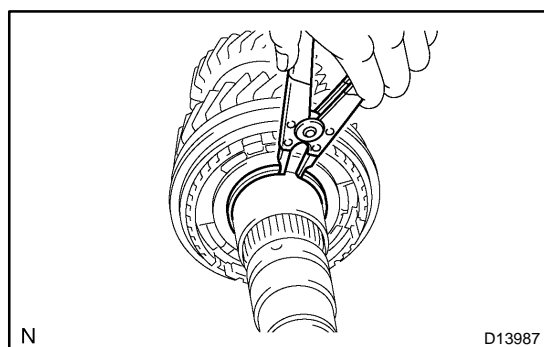
- Make sure that the gear and synchronizer ring move smoothly.



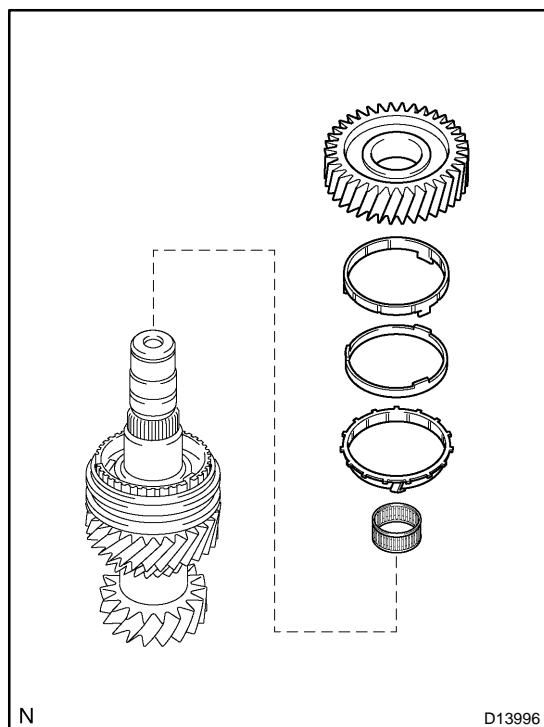
- (e) Select a snap ring that allows for the minimum amount of axial play.

**Standard clearance: 0.1 mm (0.0039 in.) or less**

Mark	Thickness mm (in.)
A	2.28 to 2.33 (0.0898 to 0.0917)
B	2.33 to 2.38 (0.917 to 0.0937)
C	2.38 to 2.43 (0.0937 to 0.0957)
D	2.43 to 2.48 (0.0957 to 0.0976)
E	2.48 to 2.53 (0.0976 to 0.0996)
F	2.53 to 2.58 (0.0996 to 0.1016)
G	2.58 to 2.63 (0.1016 to 0.1035)

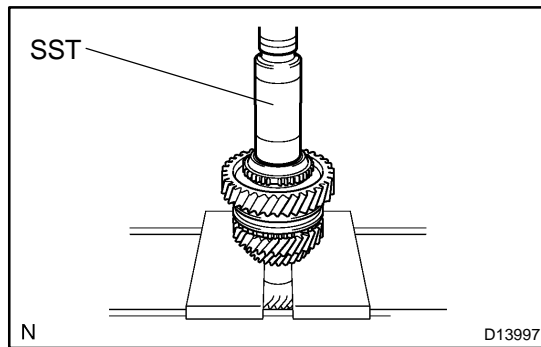


- (f) Using a snap ring expander, install the snap ring.

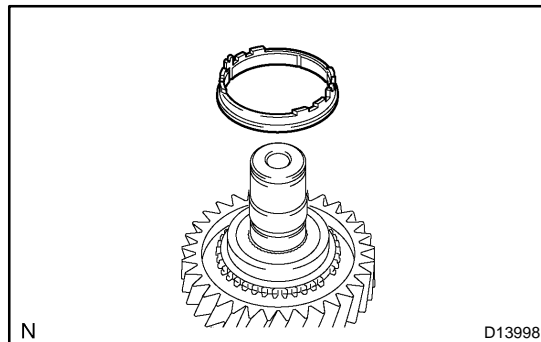


### 3. INSTALL 1ST GEAR

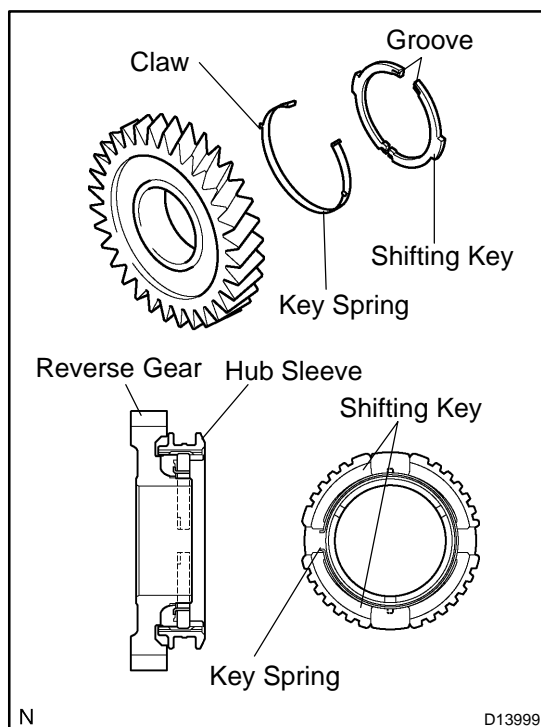
- Apply gear oil to the needle roller bearing and 1st gear taper cone.
- Install the needle roller bearing, synchronizer ring set No.1 and 1st gear.



- (c) Using SST and a press, install the reverse gear spline.  
SST 09309-37010



- (d) Install the reverse synchronizer ring to the reverse gear spline.



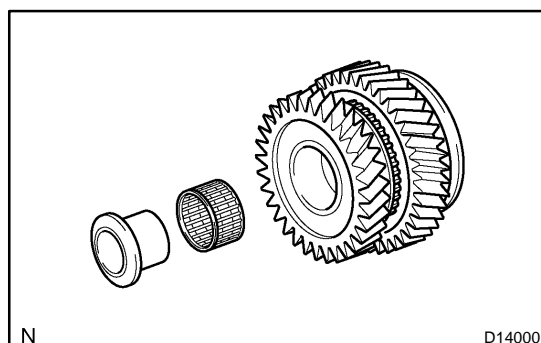
#### 4. REASSEMBLE REVERSE GEAR

- (a) Install the key spring and 2 shifting keys to the reverse gear.

##### HINT:

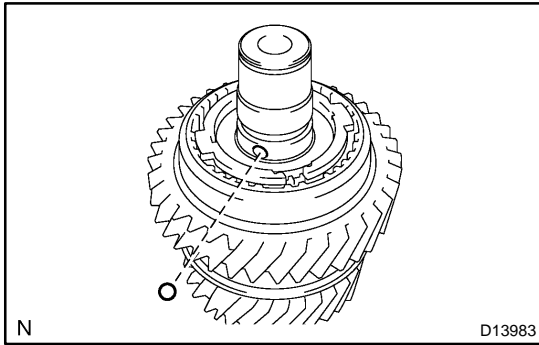
- Face the grooves on the shifting keys towards the reverse gear.
- Face the claws on the key spring towards the reverse gear.
- Make sure that the key spring is positioned as shown in the illustration.

- (b) Install the hub sleeve to the reverse gear.



#### 5. INSTALL REVERSE GEAR

- (a) Apply gear oil to the needle roller bearing and reverse gear bearing inner race.
- (b) Install the needle roller bearing and reverse gear bearing inner race to the reverse gear.

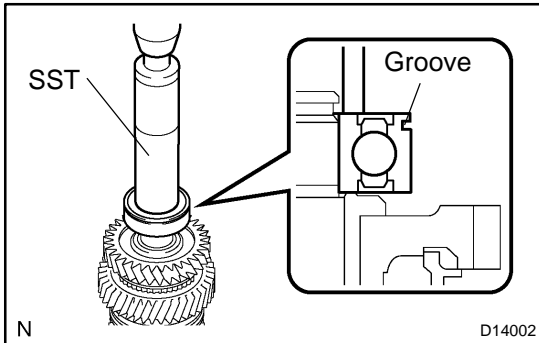


- (c) Install the ball to the counter shaft.
- (d) Install the reverse gear to the counter shaft.

**HINT:**

Make sure that the ball is fitted into the groove on the reverse gear bearing inner race.

- (e) Make sure that the gear and synchronizer ring move smoothly.



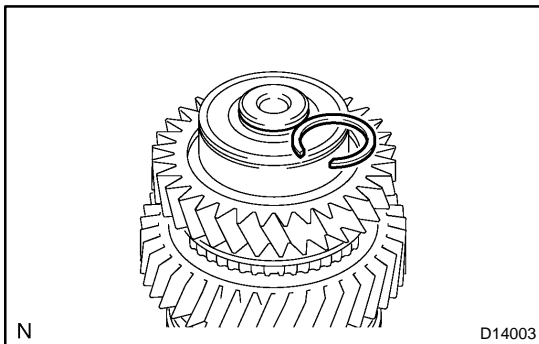
**6. INSTALL COUNTER GEAR SHAFT BEARING**

- (a) Using SST and a press, install a new counter gear shaft bearing to the counter shaft.

SST 09608-06041

**HINT:**

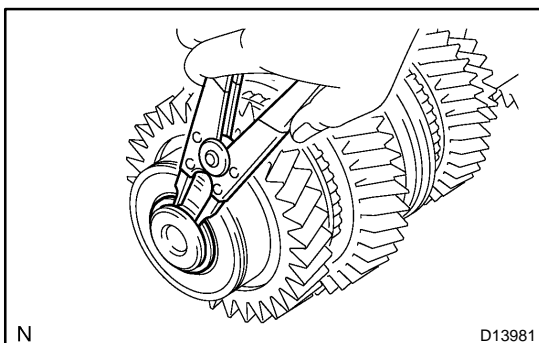
Make sure that the bearing is installed in the direction shown in the illustration.



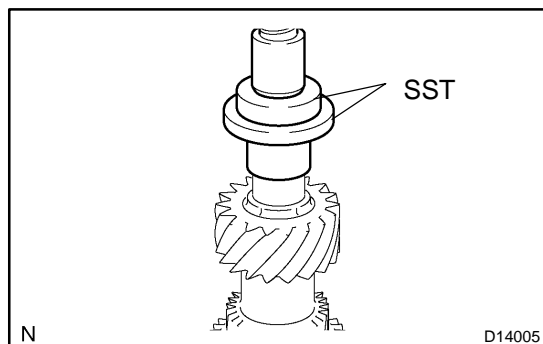
- (b) Select a snap ring that allows for the minimum amount of axial play.

**Standard clearance: 0.1 mm (0.0039 in.) or less**

Mark	Thickness mm (in.)
A	2.35 to 2.40 (0.0925 to 0.0945)
B	2.40 to 2.45 (0.0945 to 0.0965)
C	2.45 to 2.50 (0.0965 to 0.0984)
D	2.50 to 2.55 (0.0984 to 0.1004)
E	2.55 to 2.60 (0.1004 to 0.1024)
F	2.60 to 2.65 (0.1024 to 0.1043)
G	2.65 to 2.70 (0.1043 to 0.1063)
H	2.70 to 2.75 (0.1063 to 0.1083)
J	2.75 to 2.80 (0.1083 to 0.1102)
K	2.80 to 2.85 (0.1102 to 0.1122)
L	2.85 to 2.90 (0.1122 to 0.1142)
M	2.90 to 2.95 (0.1142 to 0.1161)



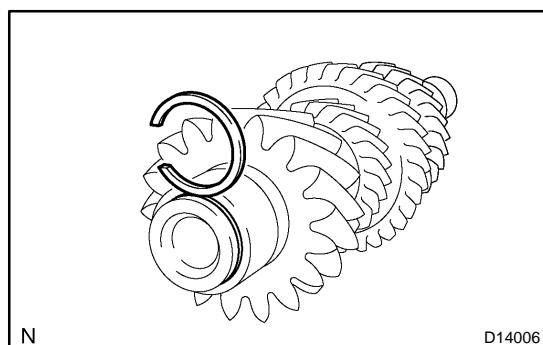
- (c) Using a snap ring expander, install the snap ring.



## 7. INSTALL NEEDLE ROLLER BEARING INNER RACE

- (a) Using SST and a press, install a new needle roller bearing inner race.

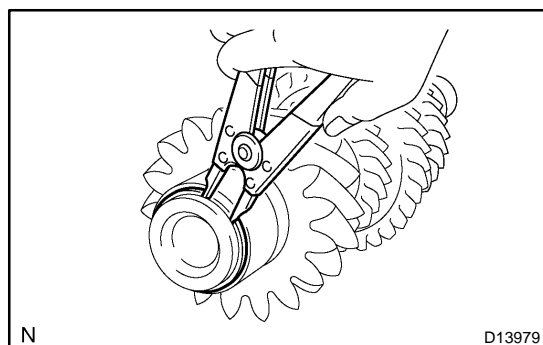
SST 09608-03070, 09950-60010 (09951-00540)



- (b) Select a snap ring that allows for the minimum amount of axial play.

**Standard clearance: 0.1 mm (0.0039 in.) or less**

Mark	Thickness mm (in.)
A	2.35 to 2.40 (0.0925 to 0.0945)
B	2.40 to 2.45 (0.0945 to 0.0965)
C	2.45 to 2.50 (0.0965 to 0.0984)
D	2.50 to 2.55 (0.0984 to 0.1004)
E	2.55 to 2.60 (0.1004 to 0.1024)
F	2.60 to 2.65 (0.1024 to 0.1043)
G	2.65 to 2.70 (0.1043 to 0.1063)
H	2.70 to 2.75 (0.1063 to 0.1083)
J	2.75 to 2.80 (0.1083 to 0.1102)
K	2.80 to 2.85 (0.1102 to 0.1122)
L	2.85 to 2.90 (0.1122 to 0.1142)
M	2.90 to 2.95 (0.1142 to 0.1161)



- (c) Using a snap ring expander, install the snap ring.