

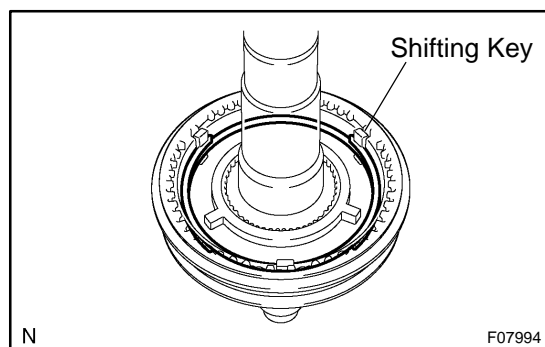
REASSEMBLY

1. INSTALL FRONT DRIVE CLUTCH SLEEVE ONTO REAR OUTPUT SHAFT

- (a) Install the front drive clutch sleeve onto the rear output shaft.

NOTICE:

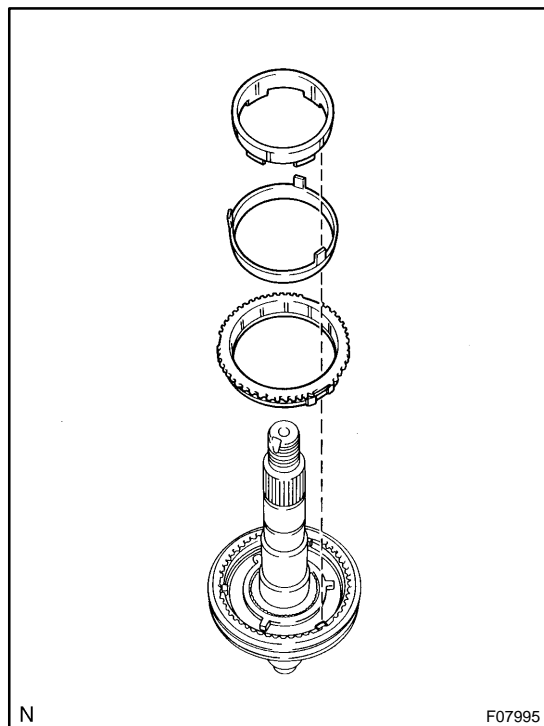
Make sure that the clutch sleeve is installed in the correct direction.



- (b) Install the 3 shifting keys and 2 springs.

NOTICE:

Install the key springs so that their end gaps are not in line.



2. INSTALL SYNCHRONIZER OUTER, CENTER AND INNER RINGS, DRIVE SPROCKET, SPACER AND BEARING

- (a) Apply gear oil to the rear output shaft and needle roller bearing.
- (b) Install the synchronizer outer ring to the rear output shaft.

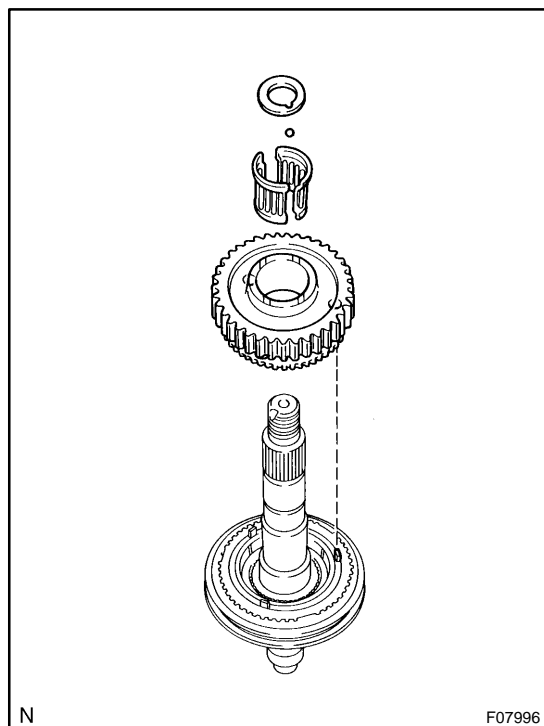
NOTICE:

Align the slots of the synchronizer outer ring with the shifting keys.

- (c) Install the synchronizer center and inner rings to the rear output shaft.

NOTICE:

Align the slots of the synchronizer outer with those of inner rings.

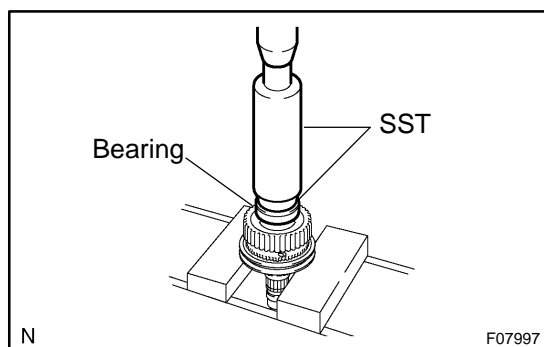


- (d) Install the needle roller bearing to the rear output shaft.
- (e) Install the drive sprocket to the rear output shaft.

NOTICE:

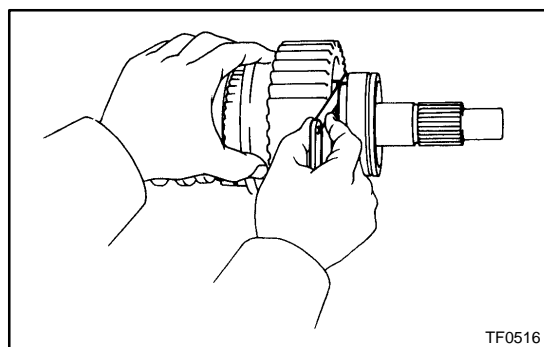
Align the holes in the drive sprocket with the protrusions of the synchronizer center ring.

- (f) Install the spacer and align it with the ball.



- (g) Using SST and a press, install a new bearing with the spacer groove facing the drive sprocket.

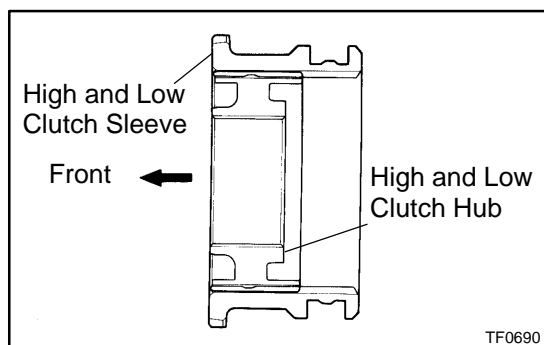
SST 09316-60011 (09316-00011, 09316-00071)

**3. INSPECT DRIVE SPROCKET THRUST CLEARANCE**

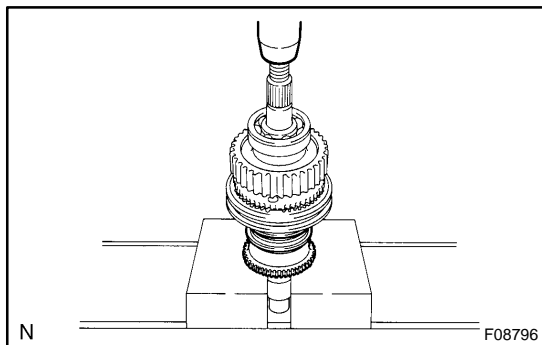
Using a feeler gauge, measure the drive sprocket thrust clearance.

Standard clearance:

0.10 to 0.25 mm (0.0039 to 0.0098 in.)

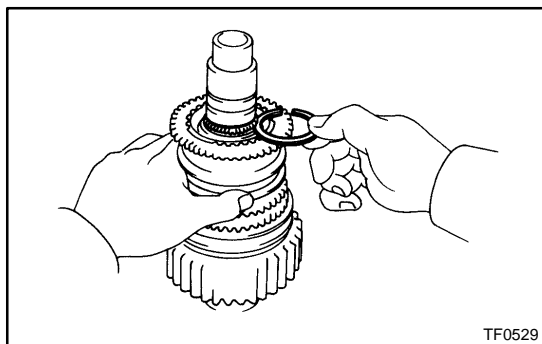
**4. INSERT HIGH AND LOW CLUTCH HUB ONTO CLUTCH SLEEVE****NOTICE:**

Make sure that the high and low clutch hub is installed in the correct direction.



5. INSTALL HIGH AND LOW CLUTCH HUB ASSEMBLY

Using a press, install the high and low clutch hub assembly.



6. INSTALL SNAP RING

Select a snap ring that allows for minimum axial play and install it to the shaft.

Mark	Thickness mm (in.)
K	2.00 to 2.05 (0.0787 to 0.0807)
L	2.05 to 2.10 (0.0807 to 0.0827)
A	2.10 to 2.15 (0.0827 to 0.0846)
B	2.15 to 2.20 (0.0846 to 0.0866)
C	2.20 to 2.25 (0.0866 to 0.0886)
D	2.25 to 2.30 (0.0886 to 0.0906)
E	2.30 to 2.35 (0.0906 to 0.0925)
F	2.35 to 2.40 (0.0925 to 0.0945)
G	2.40 to 2.45 (0.0945 to 0.0965)
H	2.45 to 2.50 (0.0965 to 0.0984)
J	2.50 to 2.55 (0.0984 to 0.1004)