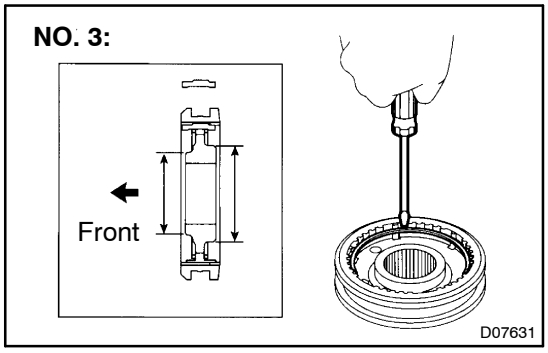
MT0B0–01

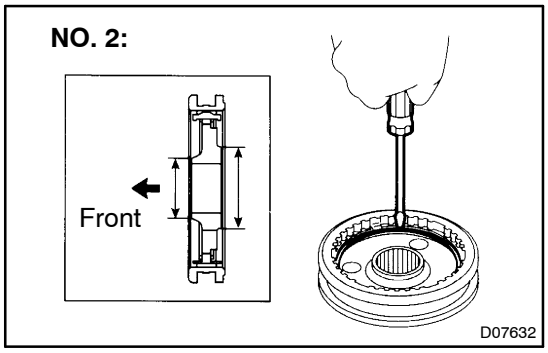
REASSEMBLY

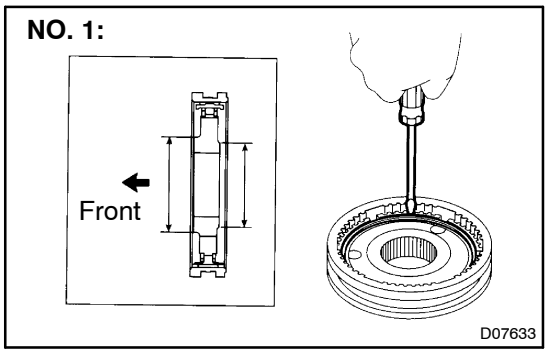
HINT:
Coat all of the sliding and rotating surfaces with gear oil before reassembly.

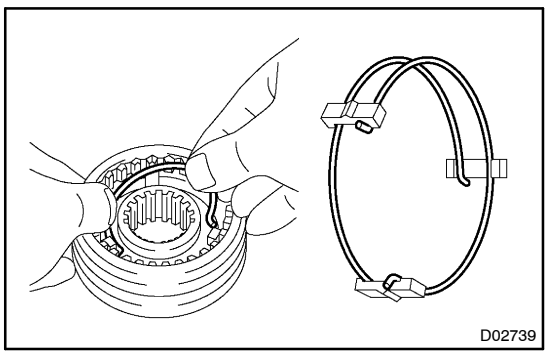
1. INSTALL CLUTCH HUB NO. 1, NO. 2 AND NO. 3 INTO HUB SLEEVE

(a) Install the clutch hub and 3 shifting keys to the hub sleeve.
(b) Install the 2 springs under the shifting keys.





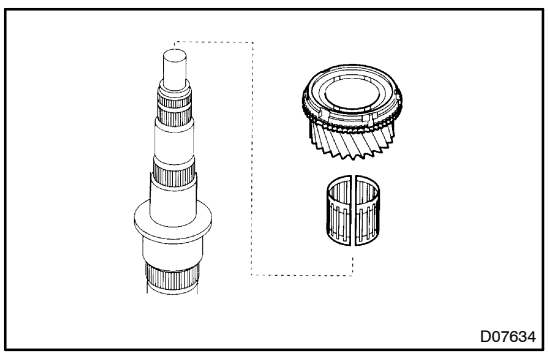


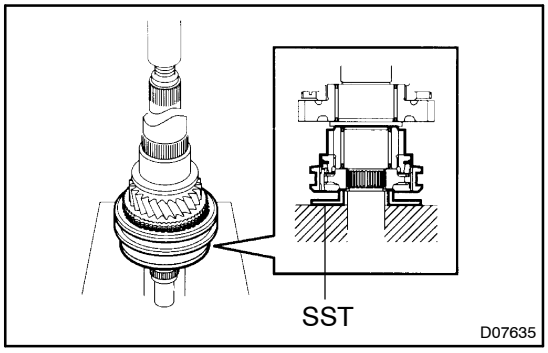


NOTICE:
Position the key springs so that their end gaps are not aligned.

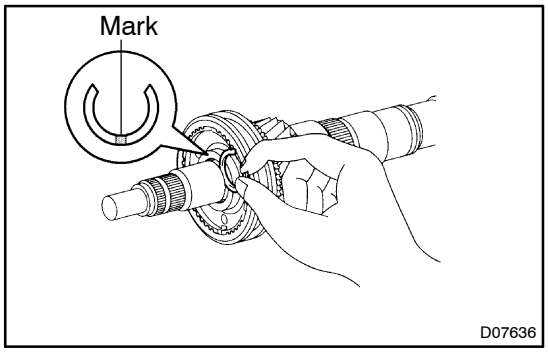
2. INSTALL 5TH GEAR AND HUB SLEEVE NO. 3 ASSEMBLY ON OUTPUT SHAFT

(a) Apply gear oil to the shaft and needle roller bearing.
(b) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.
(c) Install the needle roller bearing in the 5th gear.





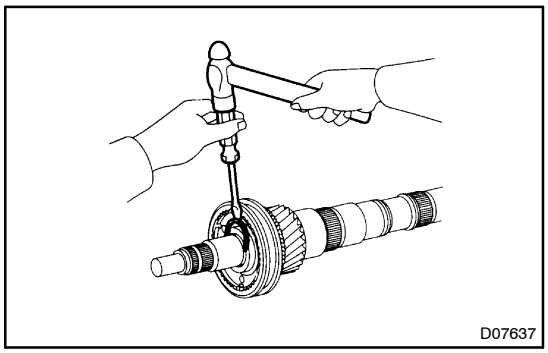
(d) Using SST and a press, install the 5th gear and hub sleeve No. 3 assembly.
SST 09316–60011 (09316–00041)



3. INSTALL SNAP RING

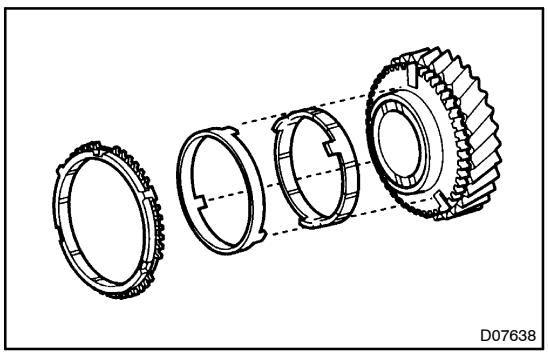
(a) Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)
A	2.40 – 2.45 (0.0945 – 0.0965)
B	2.45 – 2.50 (0.0965 – 0.0984)
C	2.50 – 2.55 (0.0984 – 0.1004)
D	2.55 – 2.60 (0.1004 – 0.1024)
E	2.60 – 2.65 (0.1024 – 0.1044)
F	2.65 – 2.70 (0.1044 – 0.1063)



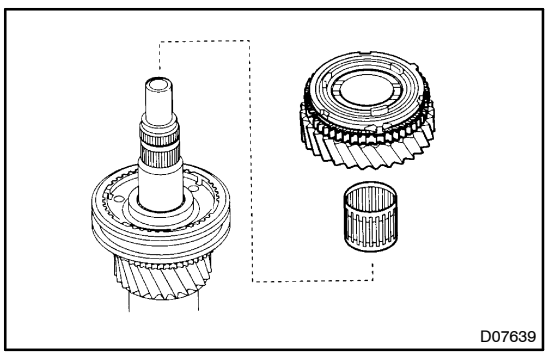
(b) Using a screwdriver and hammer, drive in the snap ring.

4. INSPECT 5TH GEAR THRUST CLEARANCE
(See page MT–28)

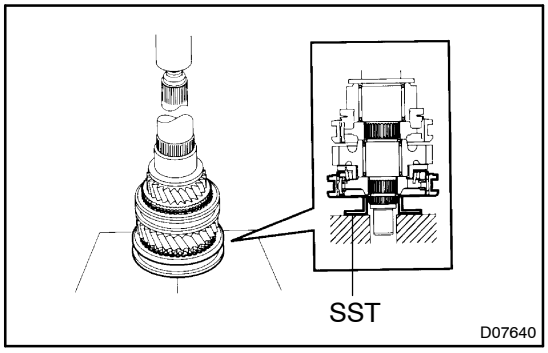


5. INSTALL 3RD GEAR AND HUB SLEEVE NO. 2 ASSEMBLY

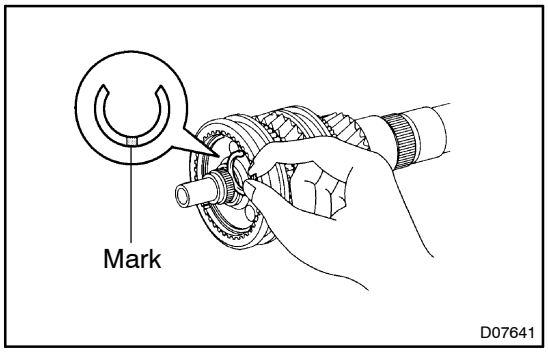
(a) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.



(b) Apply gear oil to the shaft and needle roller bearing.
(c) Install the needle roller bearing in the 3rd gear.



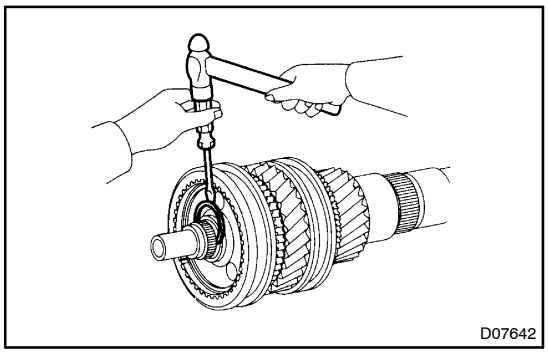
(d) Using SST and a press, install the 3rd gear and hub sleeve No. 2 assembly.
SST 09316–60011 (09316–00031)



6. INSTALL SNAP RING

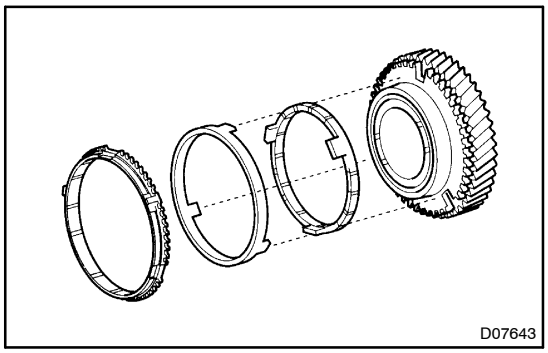
(a) Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)
4	1.90 – 1.95 (0.0748 – 0.0768)
5	1.95 – 2.00 (0.0768 – 0.0787)
6	2.00 – 2.05 (0.0787 – 0.0807)
7	2.05 – 2.10 (0.0807 – 0.0827)
8	2.10 – 2.15 (0.0827 – 0.0847)
9	2.15 – 2.20 (0.0847 – 0.0866)



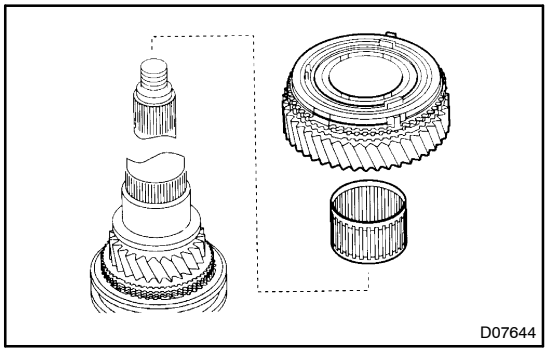
(b) Using a screwdriver and hammer, drive in the snap ring.

7. INSPECT 3RD GEAR THRUST CLEARANCE
(See page MT–28)

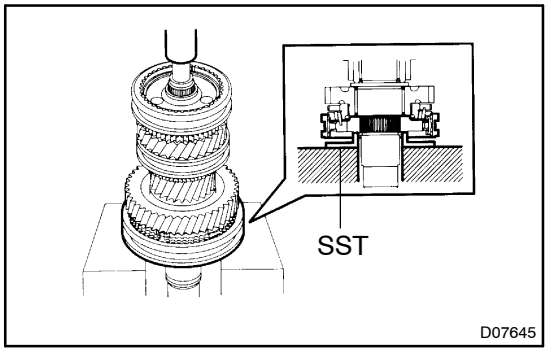


8. INSTALL 2ND GEAR AND HUB SLEEVE NO. 1 ASSEMBLY

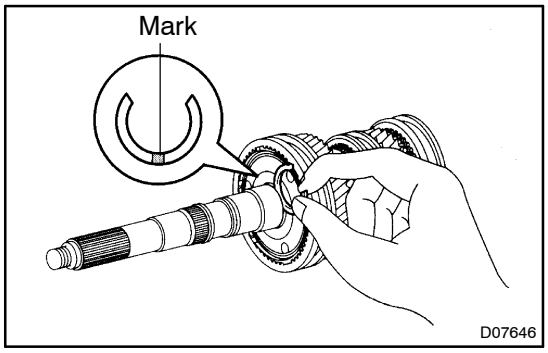
(a) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.



(b) Apply gear oil to the shaft and needle roller bearing.
(c) Install the needle roller bearing in the 2nd gear.



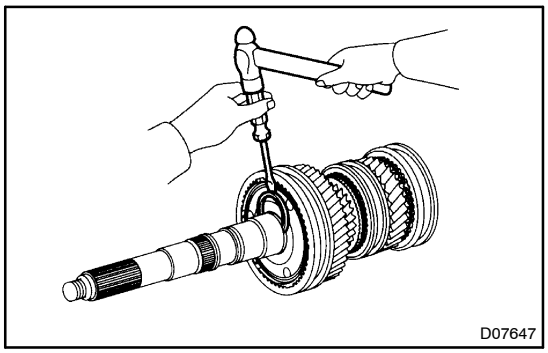
(d) Using SST and a press, install the 2nd gear and hub sleeve No. 1 assembly.



9. INSTALL SNAP RING

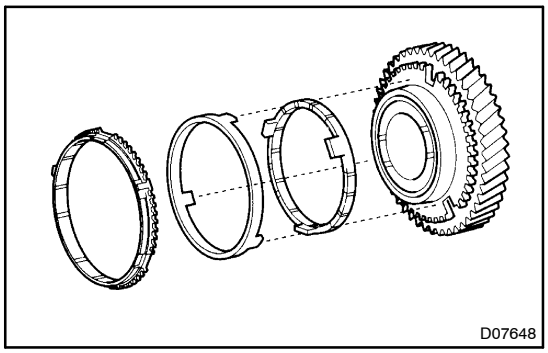
(a) Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)
A	2.90 – 2.95 (0.1142 – 0.1162)
B	2.95 – 3.00 (0.1162 – 0.1181)
C	3.00 – 3.05 (0.1181 – 0.1201)
D	3.05 – 3.10 (0.1201 – 0.1220)
E	3.10 – 3.15 (0.1220 – 0.1240)
F	3.15 – 3.20 (0.1240 – 0.1260)



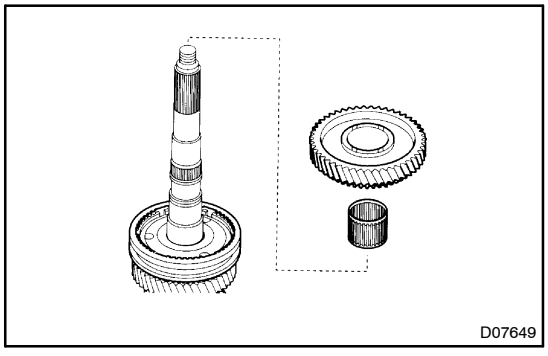
(b) Using a screwdriver and hammer, drive in the snap ring.

10. INSPECT 2ND GEAR THRUST CLEARANCE
(See page MT–28)

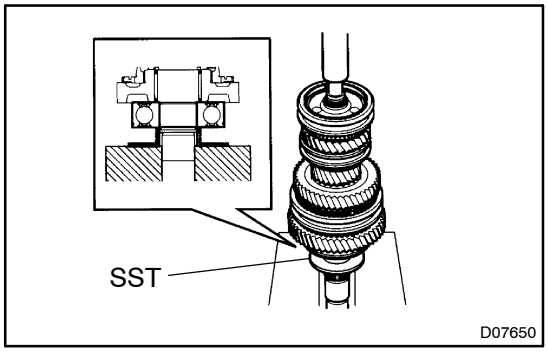


11. INSTALL 1ST GEAR

(a) Place the synchronizer ring on the gear and align the ring slots with shifting keys.



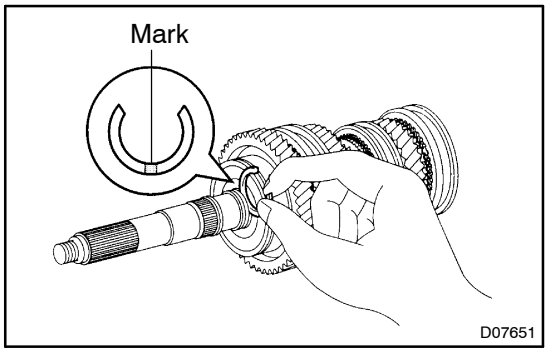
(b) Apply gear oil to the shaft and needle roller bearing.
(c) Install the needle roller bearing in the 1st gear.
(d) Install the 1st gear to the output shaft.



12. INSTALL CENTER BEARING

Using SST and a press, install the center bearing.

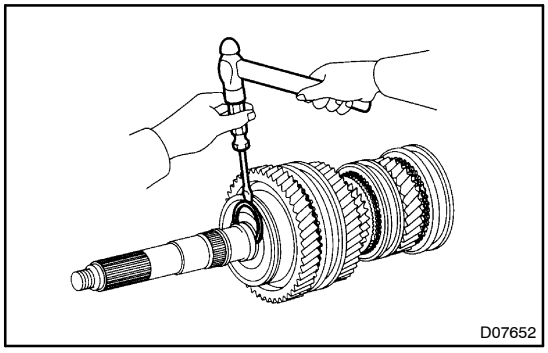
SST 09316–20011



13. INSTALL SNAP RING

(a) Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)
A	2.40 – 2.45 (0.0945 – 0.0965)
B	2.45 – 2.50 (0.0965 – 0.0984)
C	2.50 – 2.55 (0.0984 – 0.1004)
D	2.55 – 2.60 (0.1004 – 0.1024)
E	2.60 – 2.65 (0.1024 – 0.1044)
F	2.65 – 2.70 (0.1044 – 0.1063)
G	2.70 – 2.75 (0.1063 – 0.1083)
H	2.75 – 2.80 (0.1083 – 0.1102)



(b) Using a screwdriver and hammer, drive in the snap ring.

14. INSPECT 1ST GEAR THRUST CLEARANCE

(See page MT–28)