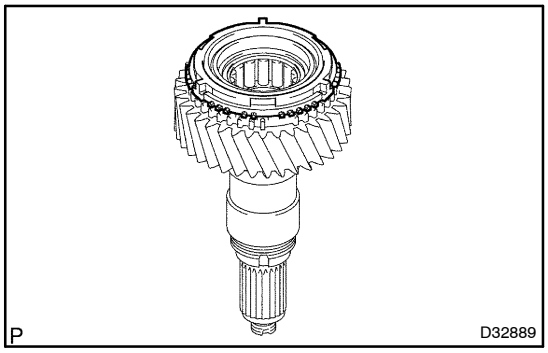
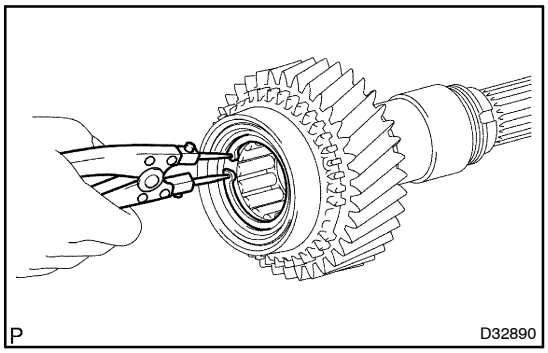
410HG–01

OVERHAUL



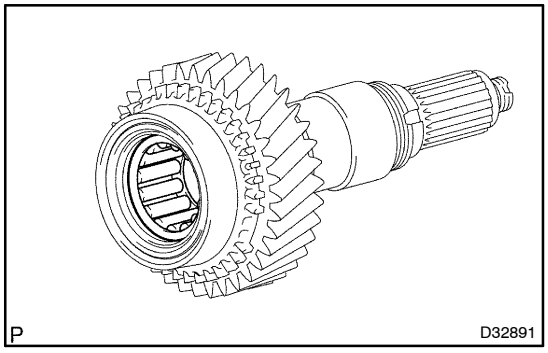
1. REMOVE SYNCHRONIZER RING NO. 4

(a) Remove the synchronizer ring.

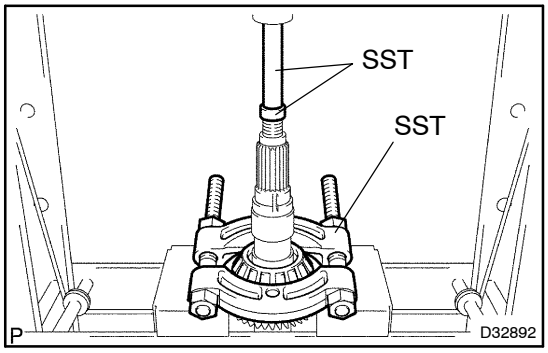


2. REMOVE OUTPUT SHAFT NEEDLE ROLLER BEARING

(a) Using a snap ring plier, remove the snap ring.



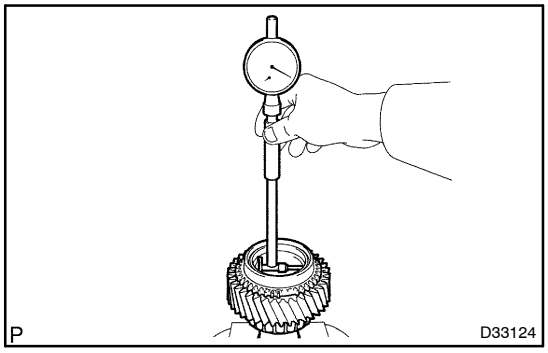
(b) Remove the needle roller bearing.



3. REMOVE OUTPUT SHAFT FRONT TAPERED ROLLER BEARING (INNER RACE)

(a) Using SST and a press, press in the roller bearing (inner race).

SST 09950–00020 09950–60010 (09951–00290) 09950–70010 (09951–07100)

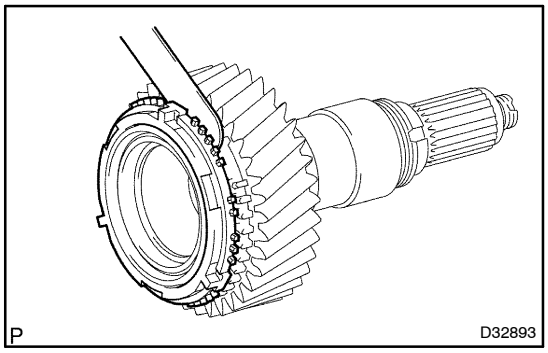


4. INSPECT OUTPUT SHAFT

(a) Using a cylinder gauge, measure the inside diameter of the output shaft bearing race.

Standard inside diameter:
54.17 to 54.187 mm (2.1327 to 2.1333 in.)
Maximum inside diameter: 54.187 mm (2.1333 in.)

If the diameter exceeds the maximum, replace the output shaft.

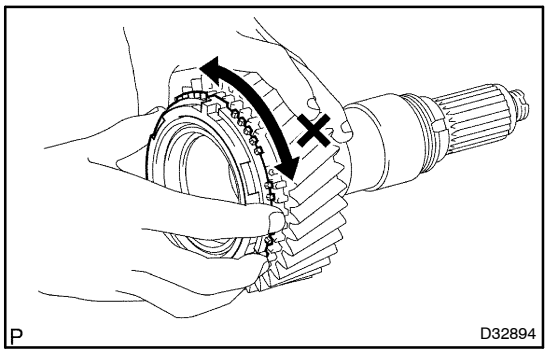


5. INSPECT SYNCHRONIZER RING NO. 4

(a) Using a feeder gauge, measure the clearance between the synchronizer ring and gear spline.

Standard clearance:
0.78 to 1.62 mm (0.0307 to 0.0638 in.)
Minimum clearance: 0.78 mm (0.0307 in.)

If the clearance is less than the minimum, replace the synchronizer ring.



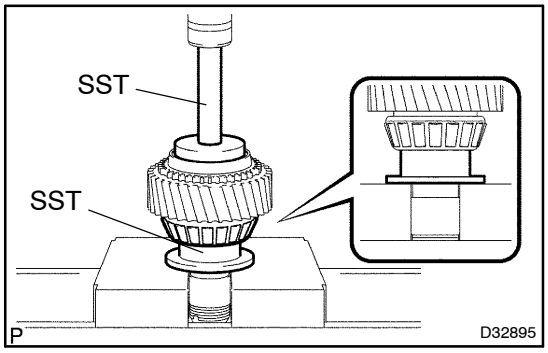
(b) Coat the output shaft and synchronizer ring cone with gear oil. Check the braking effect of the synchronizer ring. Turn the synchronizer ring in one direction while pushing it to the gear cone. Check that the ring locks.

If the braking effect is insufficient, apply a small amount of the fine lapping compound between the synchronizer ring and 4th gear cone. Lightly rub the synchronizer ring and 4th gear cone together.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.

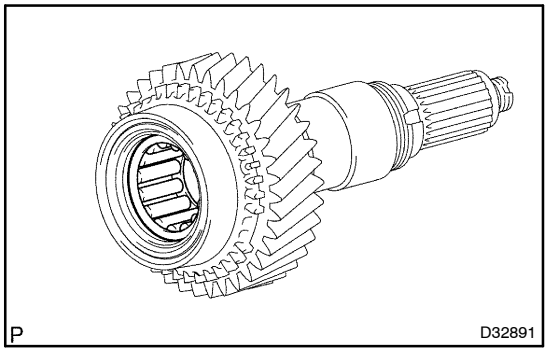
(c) Check again the braking effect of the synchronizer ring.



6. INSTALL OUTPUT SHAFT FRONT TAPERED ROLLER BEARING

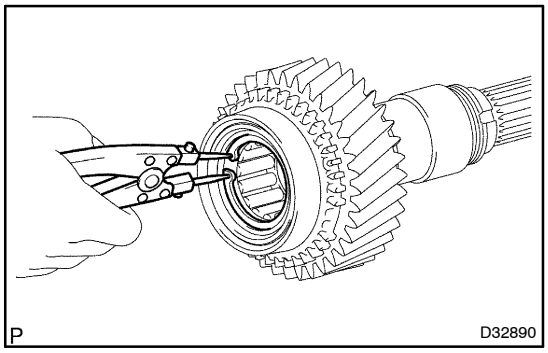
(a) Using SST and a press, press in a new bearing (inner race).

SST 09316–20011, 09950–70010 (09951–07100), 09951–00700

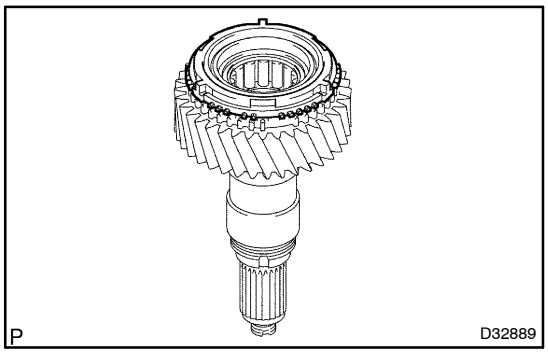


7. INSTALL OUTPUT SHAFT NEEDLE ROLLER BEARING

(a) Coat the needle roller bearing with gear oil, and install it.



(b) Using a snap ring plier, install a new snap ring.



8. INSTALL SYNCHRONIZER RING NO. 4

(a) Coat the synchronizer ring with gear oil and install it.