

REASSEMBLY

HINT:

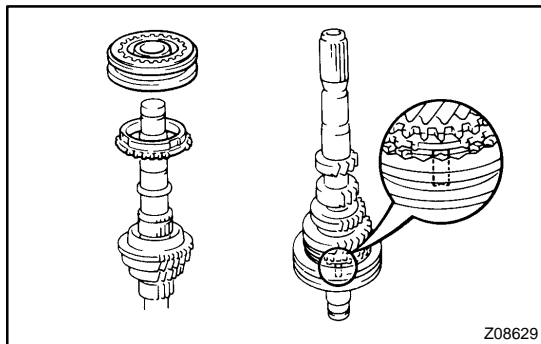
Coat all of the sliding and rotating surfaces with gear oil before reassembly.

1. ASSEMBLE NO. 2 HUB SLEEVE ASSEMBLY

- (a) Install the 3 shifting keys and No. 2 hub sleeve to the No. 2 clutch hub.
- (b) Install the 2 shifting key springs under the shifting keys.

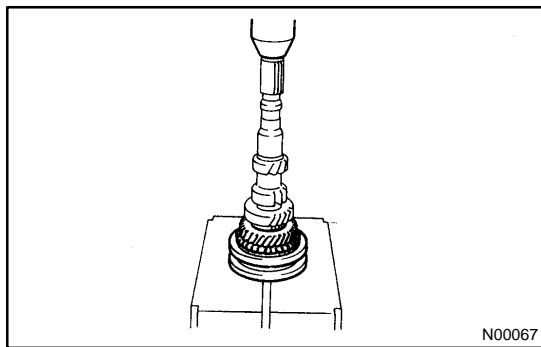
NOTICE:

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

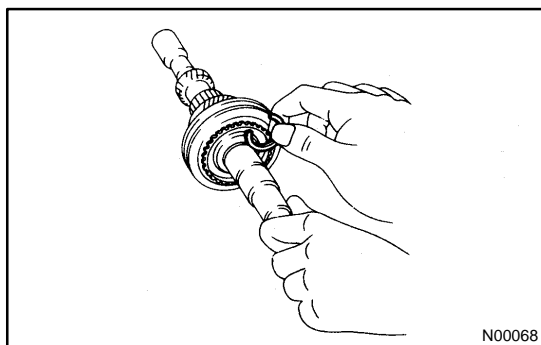


2. INSTALL NEEDLE ROLLER BEARING, 3RD GEAR, SYNCHRONIZER RING AND NO. 2 HUB SLEEVE ASSEMBLY TO INPUT SHAFT

- (a) Apply gear oil to the needle roller bearings and install it.
- (b) Install the 3rd gear and synchronizer ring.
- (c) Install the No. 2 hub sleeve assembly so that the synchronizer ring slots and shifting keys are aligned.



- (d) Using a press, install the No. 2 hub sleeve assembly.



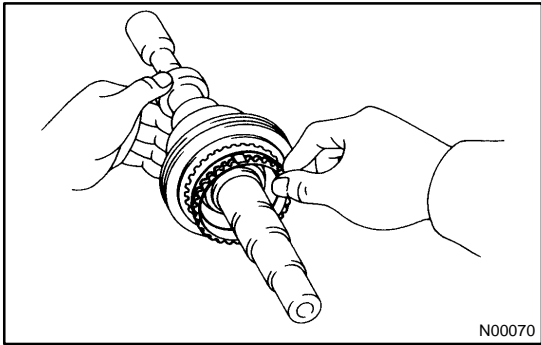
3. INSTALL SNAP RING

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

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
0	2.30 (0.0906)	3	2.48 (0.0976)
1	2.36 (0.0929)	4	2.54 (0.1000)
2	2.42 (0.0953)	5	2.60 (0.1024)

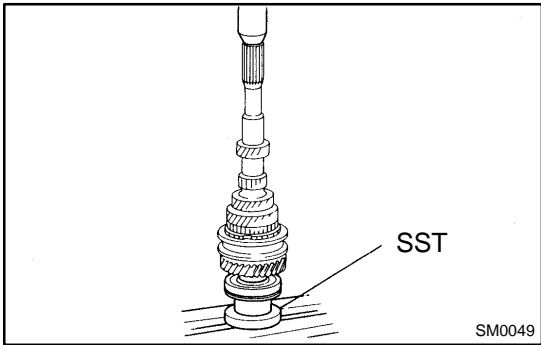
- (b) Using a screwdriver and hammer, tap in the snap ring.

4. INSPECT 3RD GEAR THRUST CLEARANCE (See page [MX-24](#))

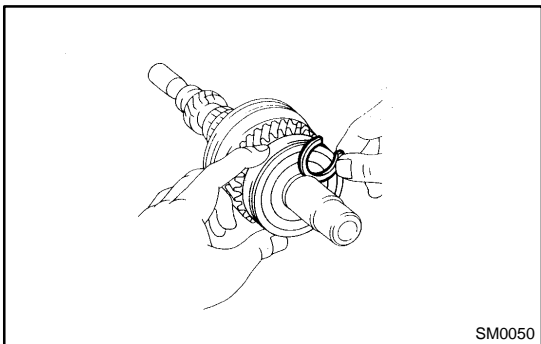


5. INSTALL SPACER, NEEDLE ROLLER BEARING, SYNCHRONIZER RING, 4TH GEAR AND REAR BALL BEARING

- (a) Install the spacer.
- (b) Apply gear oil to the needle roller bearings and install it.
- (c) Place the synchronizer ring on the No. 2 hub sleeve assembly and align the synchronizer ring slots with the shifting keys.
- (d) Install the 4th gear.



- (e) Using SST and a press, install the rear ball bearing.
SST 09608-00071



6. INSTALL SNAP RING

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

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.29 (0.0902)	D	2.47 (0.0972)
B	2.35 (0.0925)	E	2.53 (0.0996)
C	2.41 (0.0949)	F	2.59 (0.1020)

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

7. INSPECT 4TH GEAR THRUST CLEARANCE

(See page [MX-24](#))