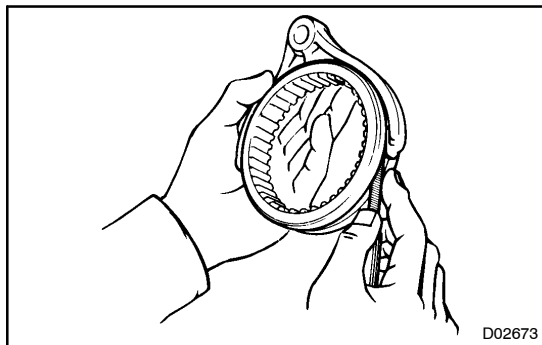




REASSEMBLY

1. INSPECT SHIFT FORK NO. 2 AND CLUTCH SLEEVE CLEARANCE

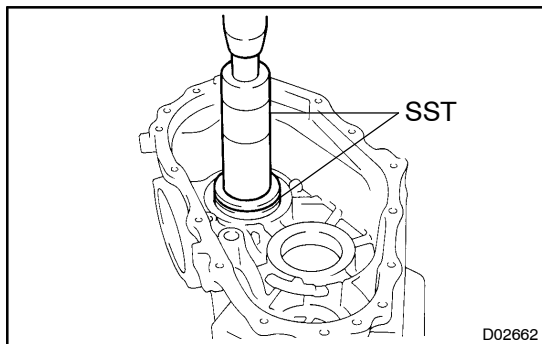
Using a feeler gauge, measure the clearance between the shift fork No. 2 and clutch sleeve.

Standard clearance:

0.10 – 0.40 mm (0.0039 – 0.0157 in.)

Maximum clearance:

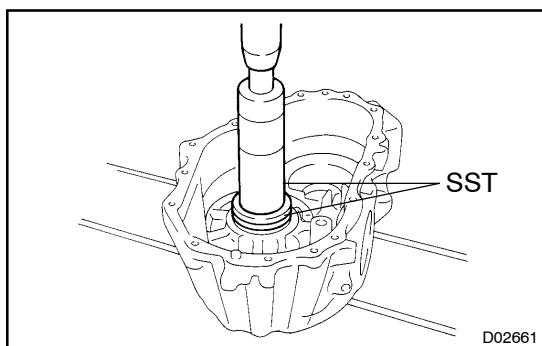
0.40 mm (0.0157 in.)



2. INSTALL THE BEARING RACE (FOR THE OUTPUT SHAFT)

Using SST and a press, install the bearing race.

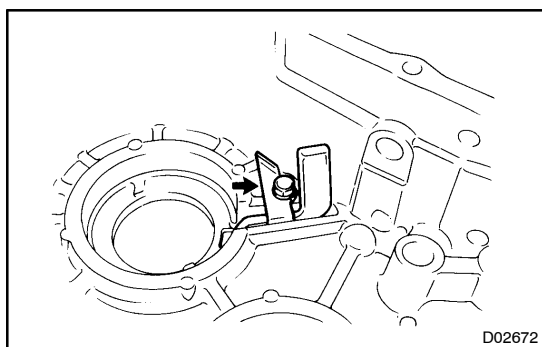
SST 09316-60011 (09316-00011, 09316-00031),
09950-60020 (09951-00890)



3. INSTALL THE BEARING RACE (FOR THE IDLER GEAR)

Using SST and a press, install the bearing race.

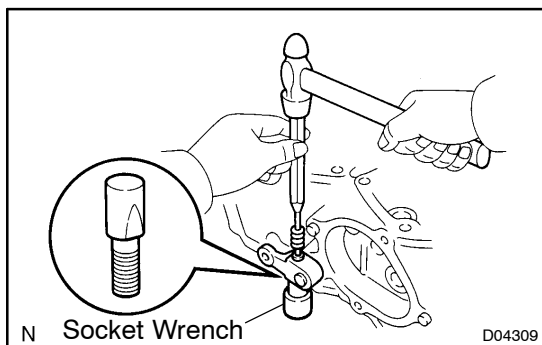
SST 09316-60011 (09316-00011, 09316-00031),
09950-60020 (09951-00790)



4. INSTALL OIL RECEIVER TO FRONT CASE

Install the oil receiver and bolt.

Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)



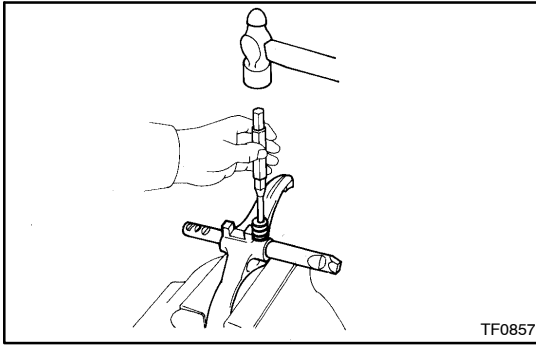
5. INSTALL SHIFT OUTER LEVER AND INNER LEVER

(a) Install the shift inner lever, washer and outer lever to the front case.

(b) Using a pin punch, hammer and socket wrench, tap in the lever lock pin.

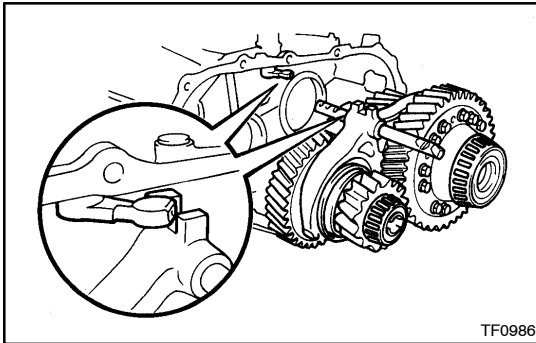
(c) Install the washer and nut to the shift outer lever.

Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)



6. ASSEMBLE SHIFT FORK NO. 1 AND SHIFT FORK NO. 1 SHAFT

- (a) Assemble the shift fork No. 1 and shift fork No. 1 shaft.
- (b) Using a pin punch and hammer, drive in the slotted spring pin.

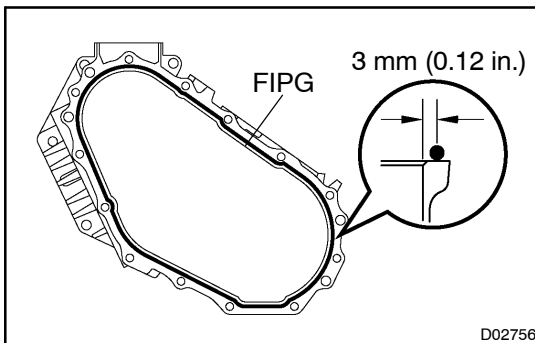


7. INSTALL IDLER GEAR ASSEMBLY WITH CENTER DIFFERENTIAL ASSEMBLY, SHIFT FORK NO. 1 AND SHIFT FORK NO. 1 SHAFT TO FRONT CASE

NOTICE:

Set the shift inner lever into the fork head part of the shift fork No. 1 securely.

8. INSTALL INPUT SHAFT ASSEMBLY
9. INSTALL 2 BEARING RACES TO REAR CASE



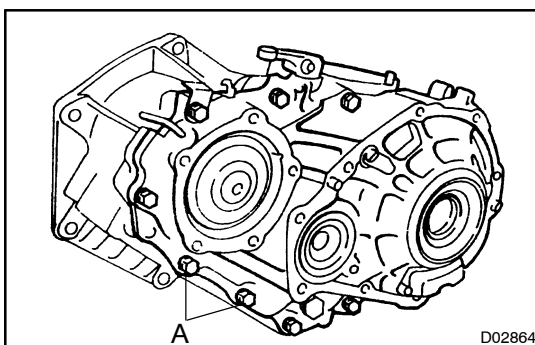
10. ASSEMBLY FRONT CASE AND REAR CASE

- (a) Apply FIPG to the front case.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent

- (b) Assemble the front case and rear case.



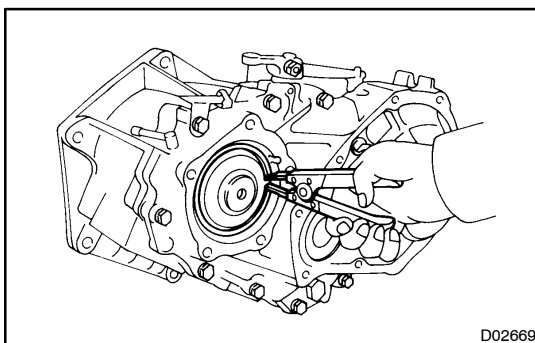
- (c) Apply liquid sealer to the "A" bolt threads.

Sealant:

Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

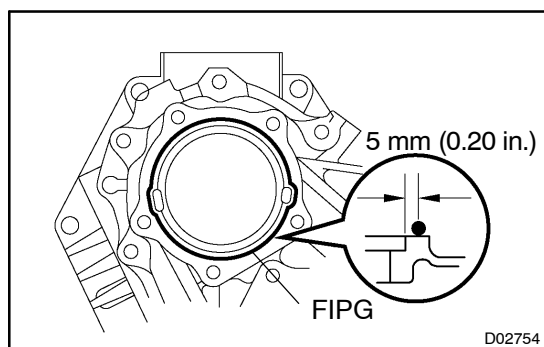
- (d) Install the 8 bolts.

Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)



11. ASSEMBLE FRONT CASE AND REAR CASE

Using a snap ring expander, install the snap ring to the rear case.

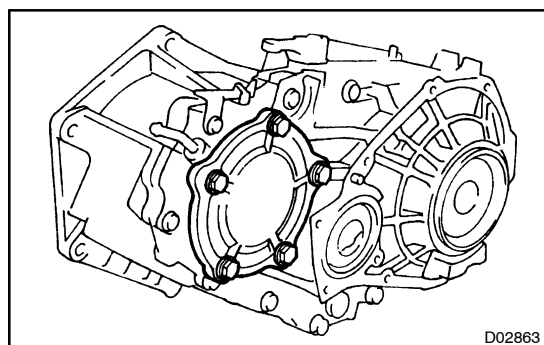
**12. INSTALL CASE COVER**

- (a) Apply FIPG to the rear case.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent

- (b) Install the case cover.



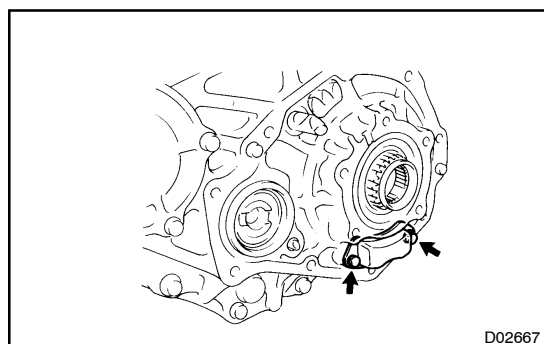
- (c) Apply liquid sealer to the bolt threads.

Sealant:

Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

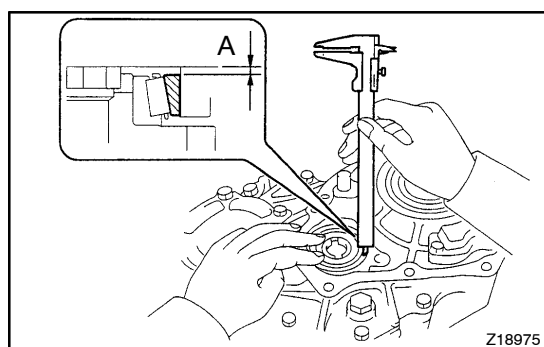
- (d) Install the 5 bolts.

Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)

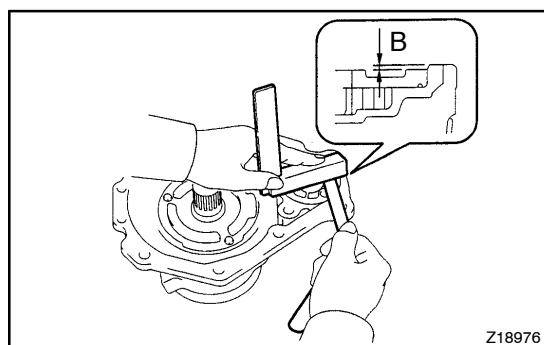
**13. INSTALL OIL STRAINER TO REAR CASE**

Install the oil strainer and 2 bolts.

Torque: 4.9 N·m (50 kgf·cm, 43 in·lbf)

**14. SELECT ADJUSTING SHIM FOR IDLER GEAR REAR TAPER ROLLER BEARING**

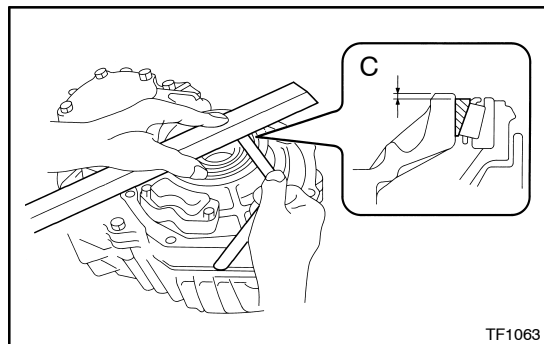
- (a) Using vernier calipers, measure dimension "A".
 (b) Lightly hold down the bearing outer race in the thrust direction to eliminate any looseness before making the measurement.



- (c) Using a steel straight edge and feeler gauge, measure the clearance of dimension "B".
 (d) Calculate the required thickness of the adjusting shim.
Thickness: Dimension "A" + Dimension "B" + [0.022 – 0.049 mm, (0.0009 – 0.0019 in.)]

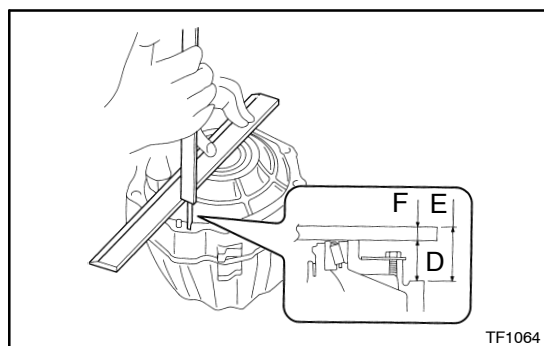
- (e) From the following table, select a shim so that its thickness is within the range of the calculation.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
2	0.30 (0.0118)	8	3.20 (0.1260)
3	0.45 (0.0177)	9	3.40 (0.1339)
4	2.40 (0.0945)	10	3.60 (0.1417)
5	2.60 (0.1024)	11	3.80 (0.1496)
6	2.80 (0.1102)	12	4.00 (0.1575)
7	3.00 (0.1181)	13	0.55 (0.0216)



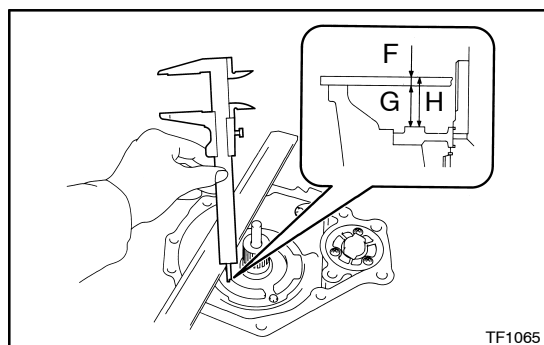
15. SELECT ADJUSTING SHIM FOR OUTPUT SHAFT TAPER ROLLER BEARING

- (a) Using a steel straight edge and feeler gauge, measure the clearance of dimension "C".
- (b) Lightly hold down the bearing outer race in the thrust direction to eliminate any looseness before making the measurement.



- (c) Using a steel straight edge and vernier calipers with depth gauge, measure dimension "D".
- (d) Dimension "D" is the straight edge thickness (Dimension "F") subtracted from dimension "E" in the illustration to the left.

Dimension "D": Dimension "E" – Dimension "F"

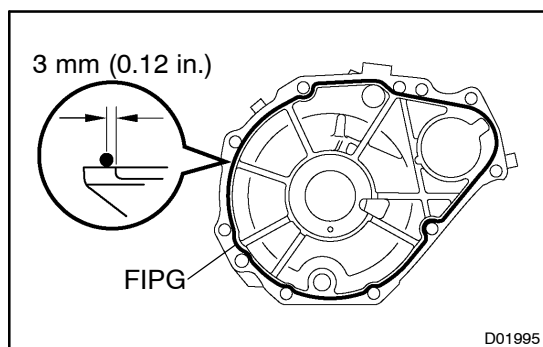


- (e) Using a steel straight edge and vernier calipers with depth gauge, measure dimension "G".
- (f) Dimension "G" is the straight edge thickness (Dimension "F") subtracted from Dimension "H".

Dimension "G": Dimension "H" – Dimension "F"

- (g) Calculate the required thickness of the adjusting shim.
Thickness: Dimension "G" – (Dimension "D" – Dimension "C") + [0.014 ~ 0.039 mm, (0.0006 ~ 0.0015 in.)]
- (h) From the following table, select a shim so that its thickness is within the range of the calculation.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
B	0.30 (0.0118)	H	1.80 (0.0709)
C	0.45 (0.0177)	J	2.00 (0.0787)
D	1.00 (0.0394)	K	2.20 (0.0866)
E	1.20 (0.0472)	L	2.40 (0.0945)
F	1.40 (0.0551)	M	2.60 (0.1024)
G	1.60 (0.0630)	N	0.55 (0.0216)

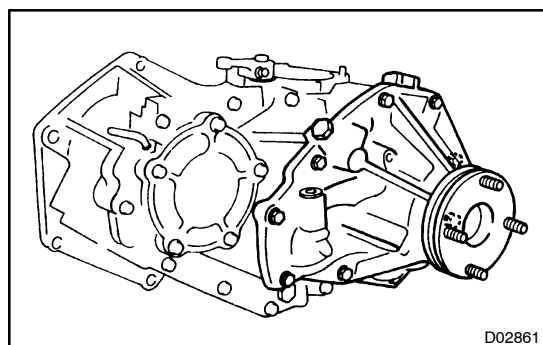


16. INSTALL REAR EXTENSION HOUSING

- (a) Apply FIPG to the rear extension housing.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent

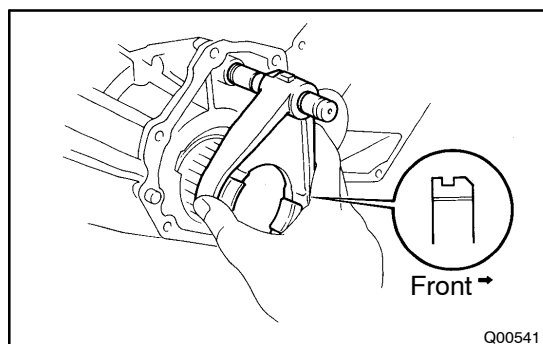


- (b) Install the rear extension housing and 9 bolts.

Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)

17. ASSEMBLE SHIFT FORK NO. 2 SHAFT AND SHIFT FORK NO. 2

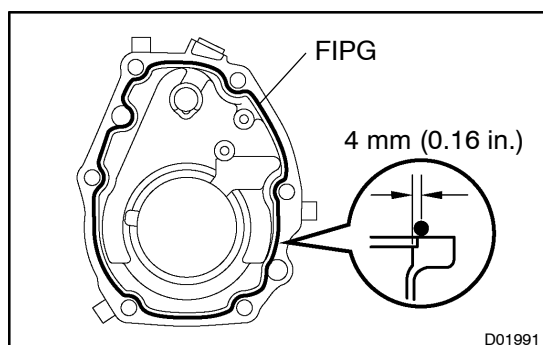
- (a) Install the shift fork No. 2 to the shift fork No. 2 shaft.
(b) Install the 3 snap rings to the shift fork No. 2 shaft.



18. INSTALL CLUTCH SLEEVE WITH SHIFT FORK NO. 2 SHAFT AND SHIFT FORK NO. 2

HINT:

Make sure to install the clutch sleeve in the correct direction.

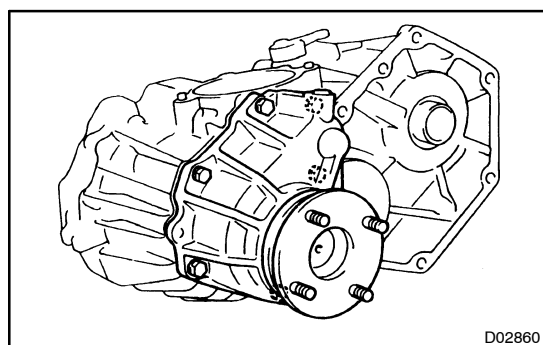


19. INSTALL FRONT EXTENSION HOUSING

- (a) Apply FIPG to the front extension housing.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent



- (b) Install the front extension housing and 6 bolts.

Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)

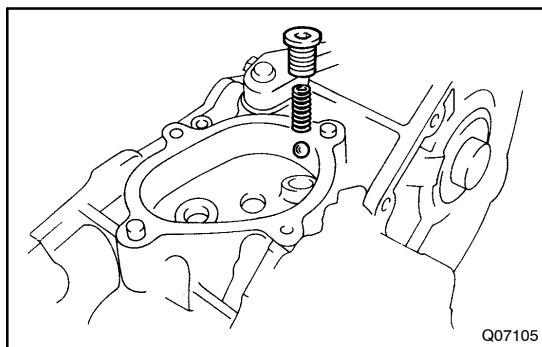
HINT:

Set the clutch sleeve in differential lock condition.

20. INSTALL TRANSFER INDICATOR SWITCH

Install the 3 transfer indicator switches with 3 new gaskets.

Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)

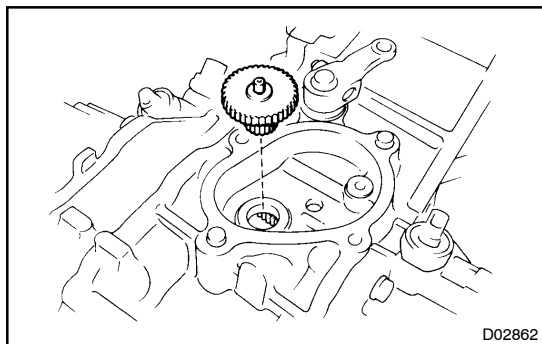
**21. INSTALL BALL, SPRING AND SCREW**

- (a) Install the ball and spring.
- (b) Apply liquid sealer to the screw plug threads.

Sealant:

Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

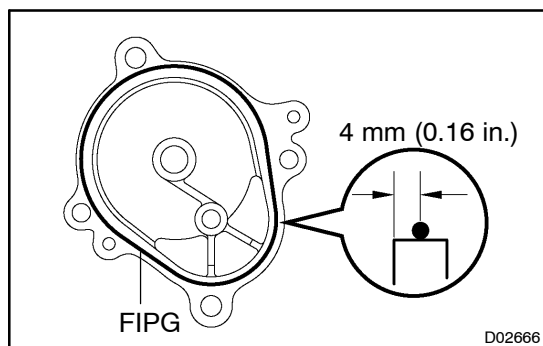
- (c) Using a torx socket wrench (T40), install the screw plug.
Torque: 19 N·m (190 kgf·cm, 14 ft·lbf)

**22. INSTALL OUTPUT GEAR TO FRONT CASE****HINT:**

Apply gear oil to the output gear.

NOTICE:

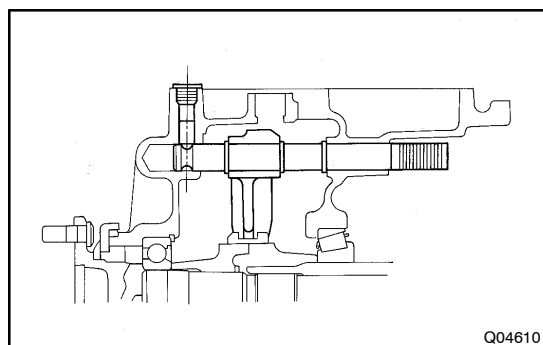
Do not turn the output gear.

**23. INSTALL MOTOR ACTUATOR**

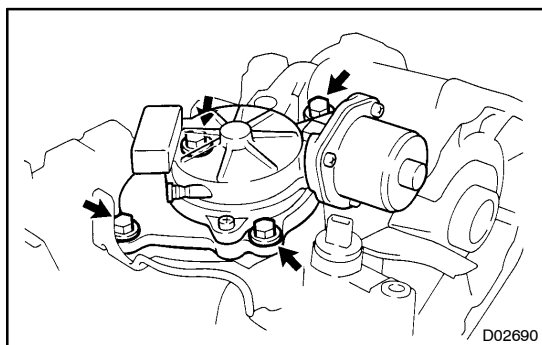
- (a) Apply FIPG to the motor actuator.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent

**HINT:**

Set the motor actuator in differential lock condition.



- (b) Install the motor actuator and 4 bolts.

Torque: 18 N·m (185 kgf·cm, 13 ft·lbf)

24. INSTALL SPEED SENSOR DRIVE GEAR

Install the driven gear and bolt.

Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)

25. INSTALL BREATHER HOSE