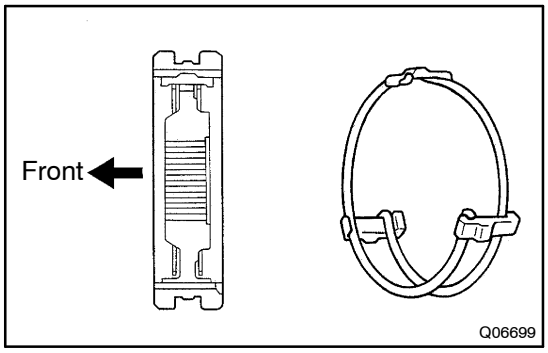
MT09M–02

REASSEMBLY

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

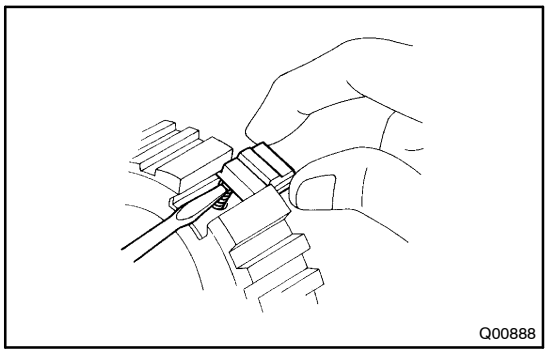
1. INSTALL CLUTCH HUB NO. 2 INTO HUB SLEEVE NO. 2

(a) Install the clutch hub No. 2 and 3 shifting keys to the hub sleeve No. 2.



(b) Install the 2 shifting key springs under the shifting keys.

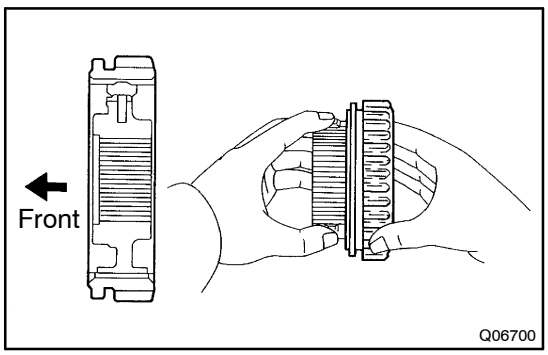
NOTICE:
Position the key springs so that their end gaps are not aligned.



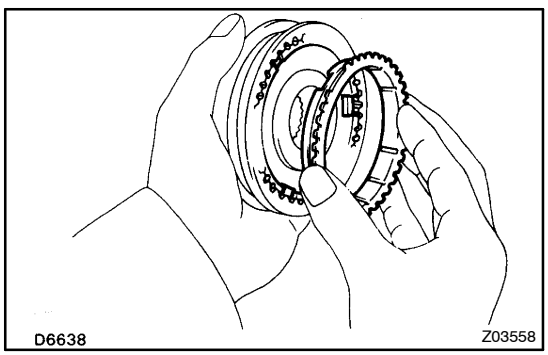
2. INSTALL CLUTCH HUB NO. 1 INTO REVERSE GEAR

(a) Install the 3 shifting key springs to the clutch hub No. 1.

(b) While pushing the shifting key spring with a screwdriver, install the 3 shifting keys.



(c) While pushing the 3 shifting keys, install the clutch hub No. 1 to the reverse gear, as shown.

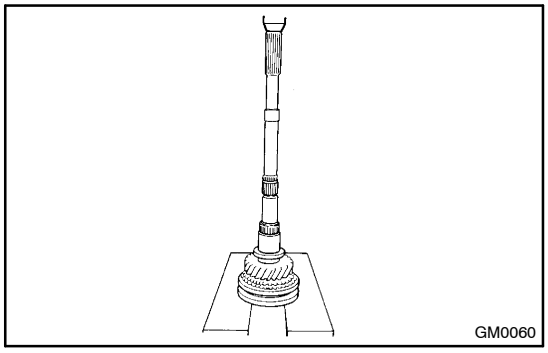


3. INSTALL 3RD GEAR AND HUB SLEEVE NO. 2 ON OUTPUT SHAFT

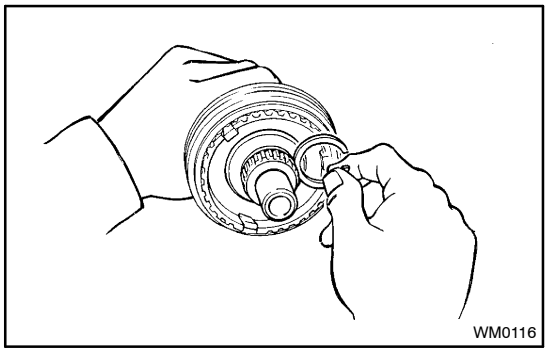
(a) Apply gear oil to the shaft and needle roller bearing.

(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 3rd gear.


GM0060

(d) Using a press, install the 3rd gear assembly and hub sleeve No. 2 assembly.


WM0116

4. INSTALL SNAP RING

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

Mark	Thickness mm (in.)
A	1.80 – 1.85 (0.0709 – 0.0728)
B	1.85 – 1.90 (0.0728 – 0.0748)
C	1.90 – 1.95 (0.0748 – 0.0768)
D	1.95 – 2.00 (0.0768 – 0.0787)
E	2.00 – 2.05 (0.0787 – 0.0807)
F	2.05 – 2.10 (0.0807 – 0.0827)
G	2.10 – 2.15 (0.0827 – 0.0846)

(b) Using a snap ring expander, install the snap ring.

5. INSPECT 3RD GEAR THRUST CLEARANCE
(See page MT–25)

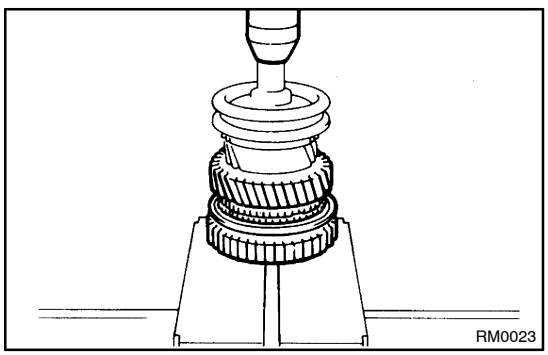
6. INSTALL 2ND GEAR AND REVERSE GEAR

(a) Apply gear oil to the shaft and needle roller bearing.

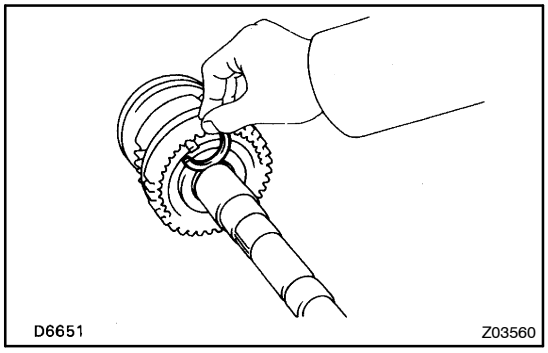
(b) Place the synchronizer inner ring, middle ring and outer ring on the 2nd gear and align the ring slots with the shifting keys.

(c) Align the projection of the synchronizer inner ring with the slots of the clutch hub No. 1.

(d) Install the needle roller bearing in the 2nd gear.


RM0023

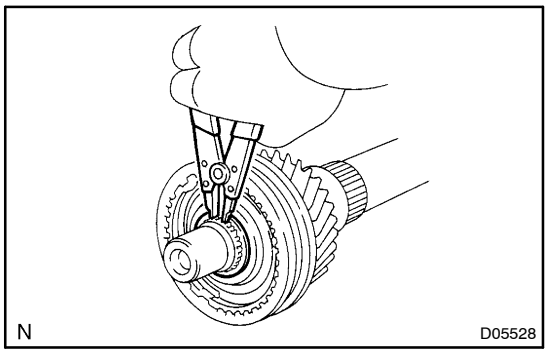
(e) Using a press, install the 2nd gear assembly and reverse gear assembly.



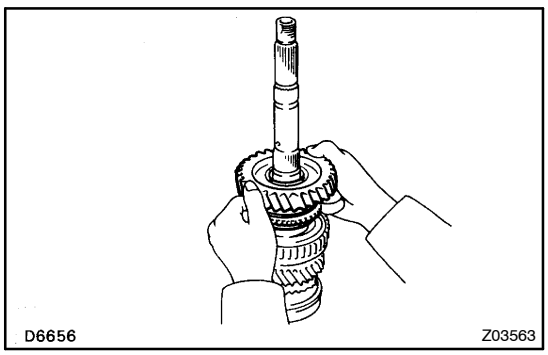
7. INSTALL SNAP RING

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

Mark	Thickness mm (in.)
A	2.30 – 2.35 (0.0906 – 0.0925)
B	2.35 – 2.40 (0.0925 – 0.0945)
C	2.40 – 2.45 (0.0945 – 0.0965)
D	2.45 – 2.50 (0.0965 – 0.0984)
E	2.50 – 2.55 (0.0984 – 0.1004)
F	2.55 – 2.60 (0.1004 – 0.1024)
G	2.60 – 2.65 (0.1024 – 0.1043)

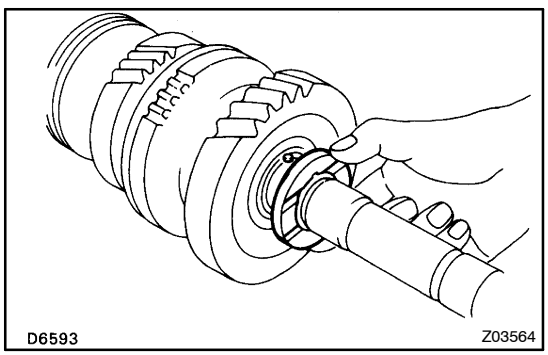


(b) Using a snap ring expander, install the snap ring.



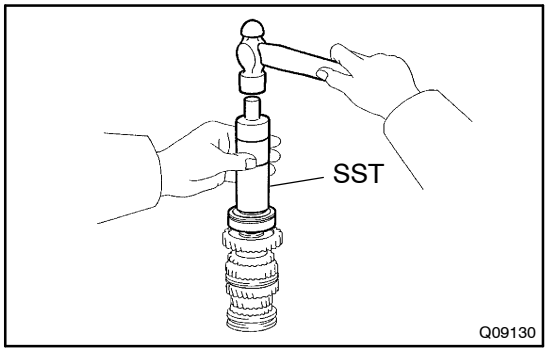
8. INSTALL SPACER AND 1ST GEAR ASSEMBLY

(a) Install the spacer on the output shaft.
(b) Apply gear oil to the needle roller bearing.
(c) Assemble the 1st gear, synchronizer inner ring, middle ring, outer ring and needle roller bearing.
(d) Install the 1st gear assembly on the output shaft with the synchronizer inner ring slots aligned with the shifting keys.



9. INSTALL STRAIGHT PIN AND 1ST GEAR THRUST WASHER

Install the 1st gear thrust washer onto the output shaft with the straight pin aligned with the 1st gear thrust washer.



10. INSTALL OUTPUT SHAFT CENTER BEARING

Using SST and a hammer, drive in the bearing with the outer race snap ring groove toward the rear.

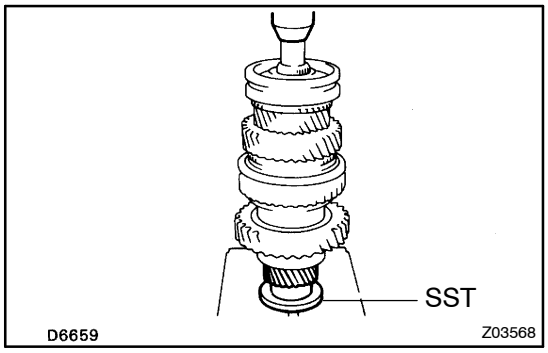
SST 09316–60011 (09316–00011, 09316–00071)

11. INSPECT 1ST GEAR THRUST CLEARANCE

(See page MT–25)

12. INSPECT 2ND GEAR THRUST CLEARANCE

(See page MT–25)



13. INSTALL 5TH GEAR

Using SST and a press, install the 5th gear.

SST 09316–60011 (09316–00031)