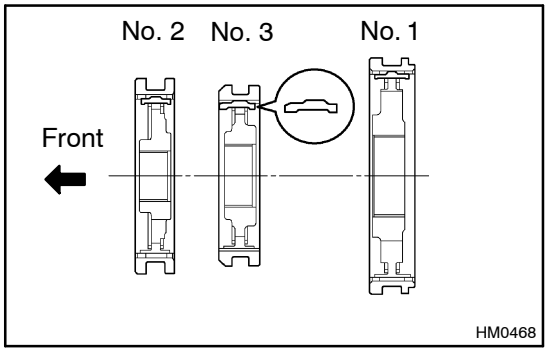
MT0BL–01

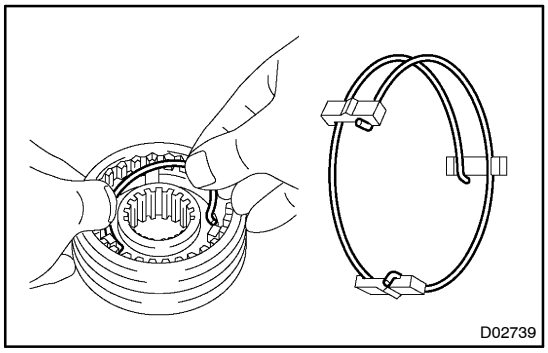
# REASSEMBLY




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

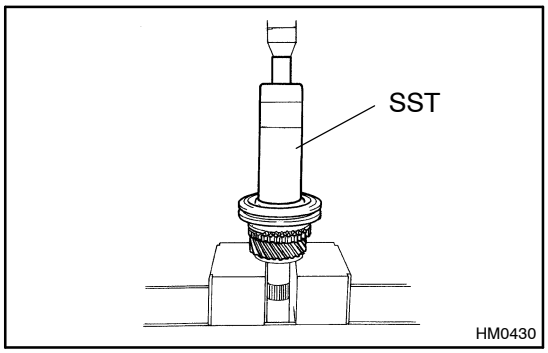
**1. INSTALL CLUTCH HUB NO. 1, NO. 2 AND NO. 3 INTO HUB SLEEVE**

(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.**



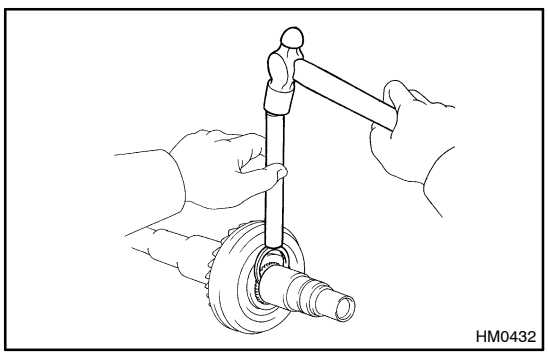

**2. INSTALL 5TH GEAR AND HUB SLEEVE NO. 3 ASSEMBLY ON OUTPUT SHAFT**

(a) Apply gear oil to the shaft and needle roller bearing.
(b) Place the synchronizer ring on the 5th 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 (09316–00011)

**3. INSTALL SNAP RING**

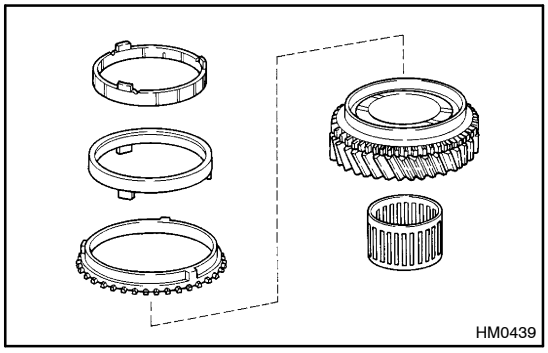
(a) Select a snap ring that allows the minimum axial play.

| 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 brass bar and hammer, drive in the snap ring.

**4. INSPECT 5TH GEAR THRUST CLEARANCE**
**(See page MT–2)**

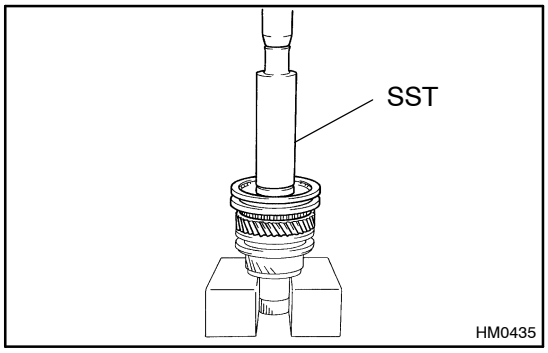



**5. INSTALL 3RD GEAR AND HUB SLEEVE NO. 2 ASSEMBLY**

(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.

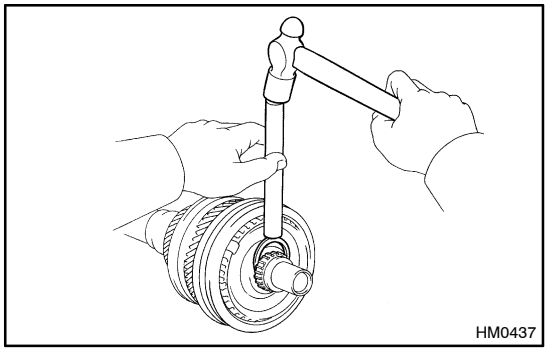



(d) Using SST and a press, install the 3rd gear and hub sleeve No. 2 assembly.
SST 09316–60011 (09316–00011)

**6. INSTALL SNAP RING**

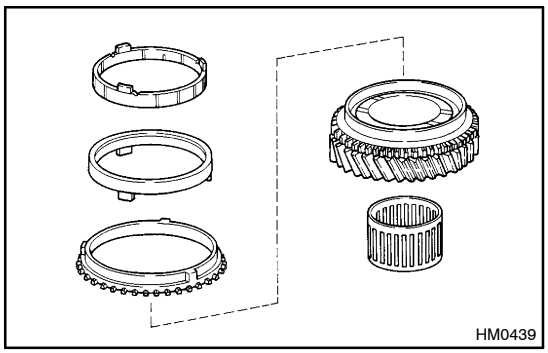
(a) Select a snap ring that allows the minimum axial play.

| 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 brass bar and hammer, drive in the snap ring.

**7. INSPECT 3RD GEAR THRUST CLEARANCE**
**(See page MT–2)**

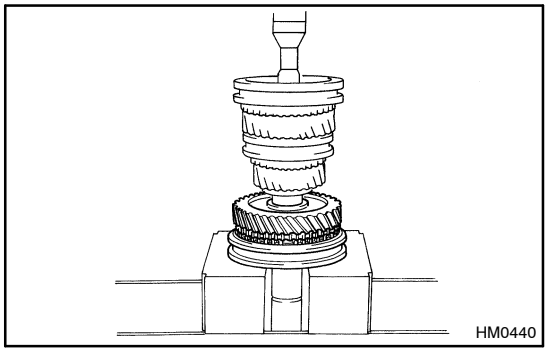



**8. INSTALL 2ND GEAR AND HUB SLEEVE NO. 1 ASSEMBLY**

(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 2nd gear.

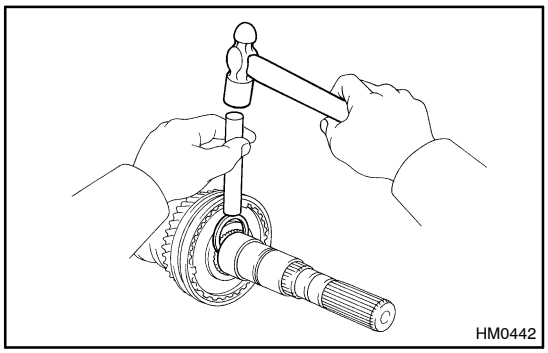

HM0440

(d) Using 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) |

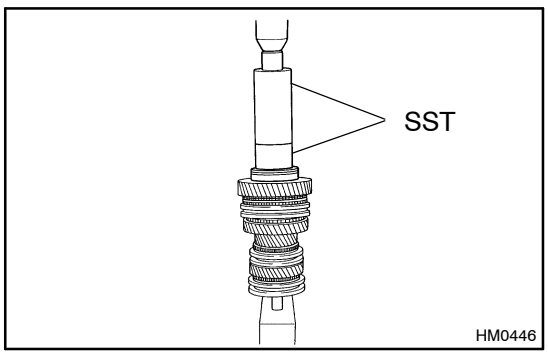

HM0442

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

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

**11. INSTALL 1ST GEAR**

(a) Apply gear oil to the shaft and needle roller bearing.
(b) Place the synchronizer ring on the 1st gear and align the ring slots with the shifting keys.
(c) Install the needle roller bearing in the 1st gear.
(d) Install the 1st gear to the output shaft.



HM0446

**12. INSTALL BALL BEARING**

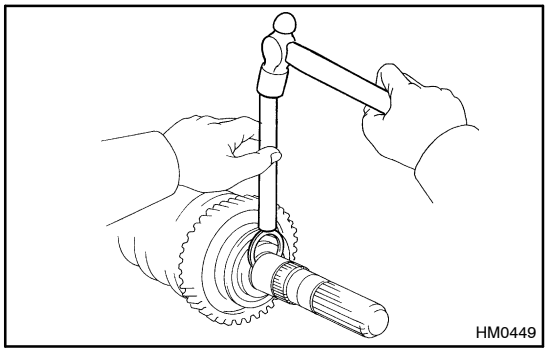
Using SST and a press, install the ball bearing.

SST 09316–60011 (09316–00011), 09523–36010

**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 brass bar and hammer, drive in the snap ring.

**14. INSPECT 1ST GEAR THRUST CLEARANCE**
**(See page MT–2)**