

## REASSEMBLY

### HINT:

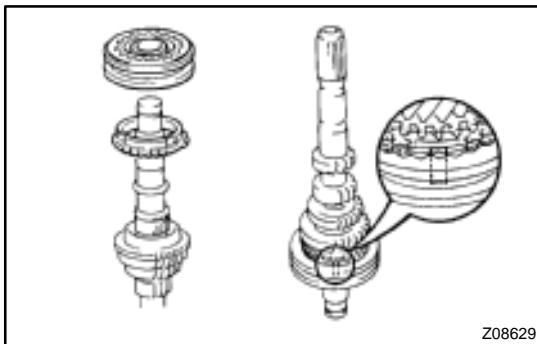
Coat all of the sliding and rotating surfaces with gear oil before assembly.

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

- Install the clutch hub and shifting keys to the hub sleeve.
- Install the shifting key springs under the shifting keys.

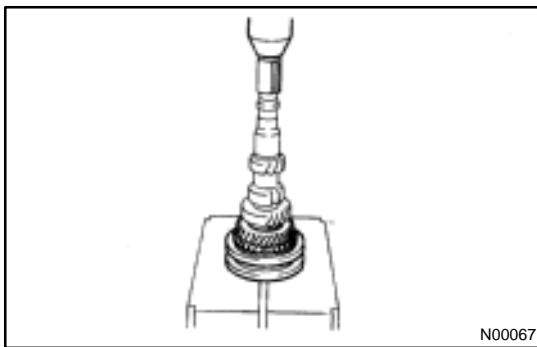
### NOTICE:

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

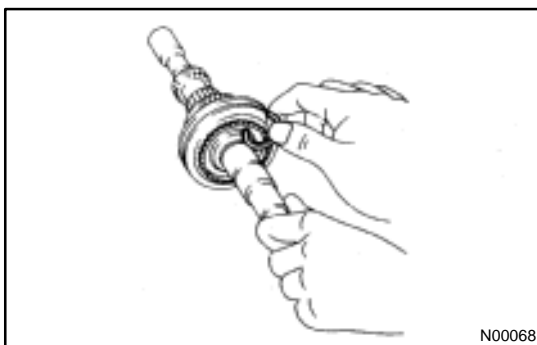


### 2. INSTALL 3RD GEAR, NEEDLE ROLLER BEARING, SYNCHRONIZER RING AND NO.2 HUB SLEEVE ASSEMBLY TO INPUT SHAFT

- Apply gear oil to the needle roller bearings.
- Place the synchronizer ring on the gear and align the ring slots with the shifting keys.



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



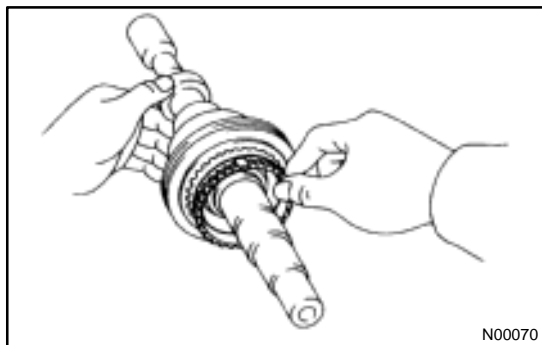
### 3. INSTALL SNAP RING

- 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)

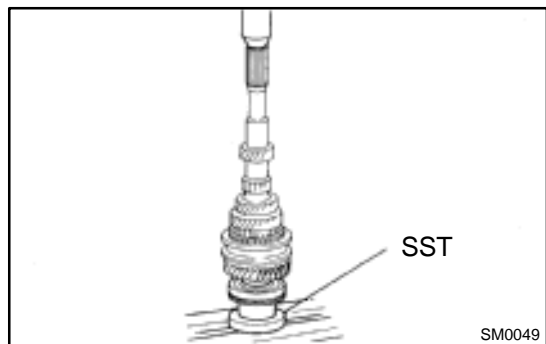
- Using a screwdriver and hammer, tap in the snap ring.

### 4. INSPECT 3RD GEAR THRUST CLEARANCE (See page [MX-21](#))

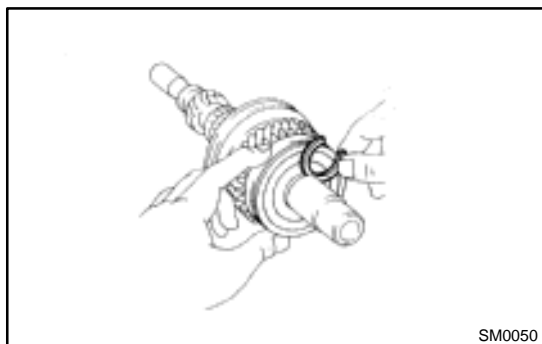


**5. INSTALL SYNCHRONIZER RING, NEEDLE ROLLER BEARING, SPACER, 4TH GEAR AND REAR BALL BEARING**

- (a) Apply gear oil to the needle roller bearings.
- (b) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.



- (c) 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-21](#))