

## REASSEMBLY

### HINT:

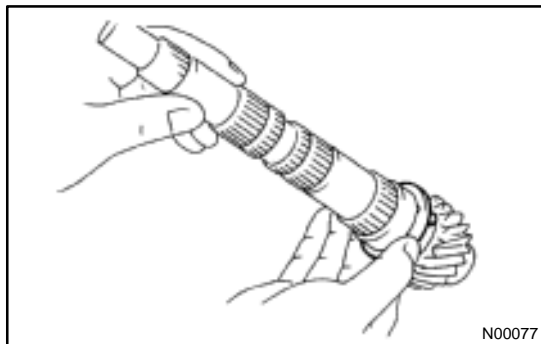
Coat all of the sliding and rotating surfaces with gear oil before assembly.

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

- Install the No.1 clutch hub and shifting keys to the No.1 hub sleeve.
- Install the shifting key springs under the shifting keys.

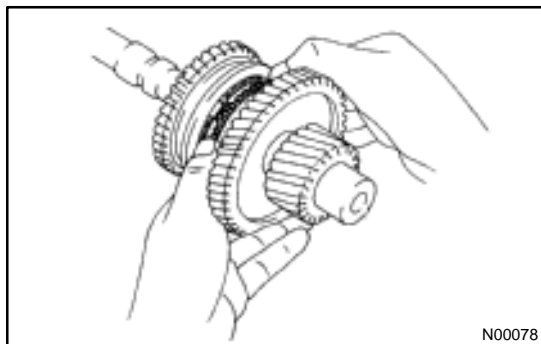
### NOTICE:

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

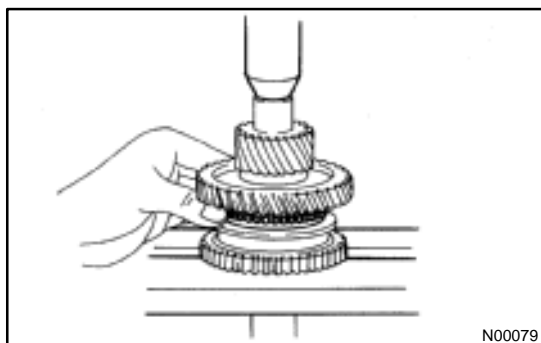


### 2. INSTALL BALL, THRUST WASHER, 1ST GEAR, NEEDLE ROLLER BEARING, SYNCHRONIZER RING AND NO.1 HUB SLEEVE ASSEMBLY TO OUTPUT SHAFT

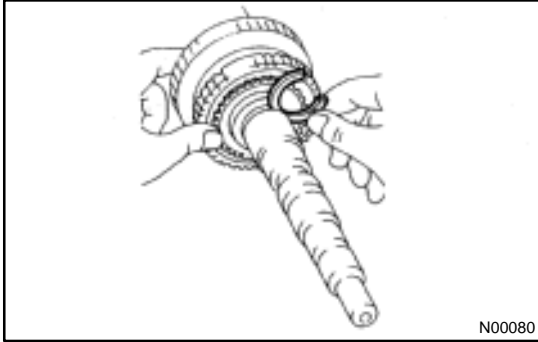
- Install the ball to the shaft.
- Fit the thrust washer groove securely over the locking ball when installing the thrust on the shaft.
- Apply gear oil to the needle roller bearing.



- Place the synchronizer ring on the gear and align the ring slots with the shifting keys.



- Using a press, install the 1st gear and No.1 hub sleeve.



### 3. INSTALL SNAP RING

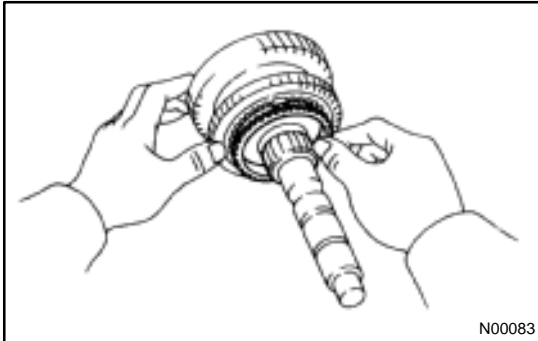
- (a) Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.50 (0.0984)	D	2.68 (0.1055)
B	2.56 (0.1008)	E	2.74 (0.1079)
C	2.62 (0.1031)	F	2.80 (0.1102)

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

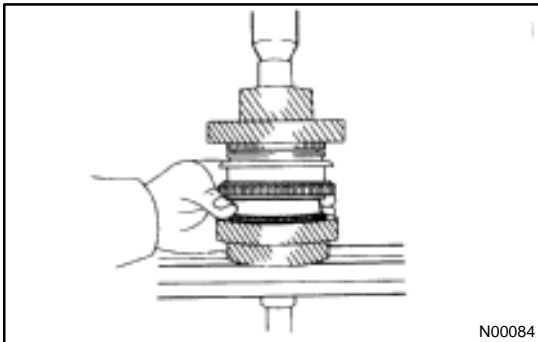
### 4. INSPECT 1ST GEAR THRUST CLEARANCE

(See page [MX-28](#))



### 5. INSTALL SYNCHRONIZER RING, 2ND GEAR, NEEDLE ROLLER BEARING AND 3RD DRIVEN GEAR

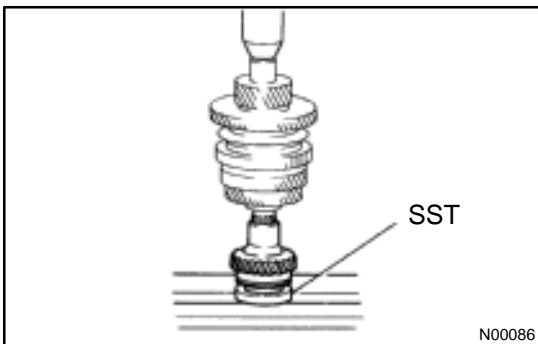
- (a) Place the synchronizer ring on the gear and align the ring slots with the shifting keys.  
 (b) Apply gear oil to the needle roller bearing.  
 (c) Install the 2nd gear.



- (d) Using a press, install the 3rd driven gear.

### 6. INSPECT 2ND GEAR THRUST CLEARANCE

(See page [MX-28](#))



### 7. INSTALL OUTPUT GEAR SPACER, 4TH DRIVEN GEAR AND REAR BALL BEARING

- (a) Install the output gear spacer.  
 (b) Using SST and a press, install the 4th driven gear and rear ball bearing.

SST 09608-00071