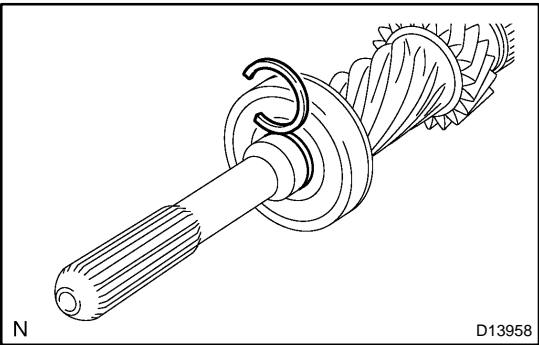


REASSEMBLY

1. INSTALL INPUT SHAFT BEARING

- (a) Using SST and a press, install the input shaft bearing to the input shaft.
SST 09950-00020

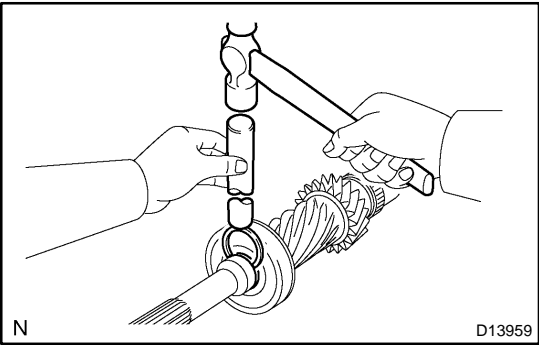
HINT:
Make sure that the bearing is installed in the direction shown in the illustration.



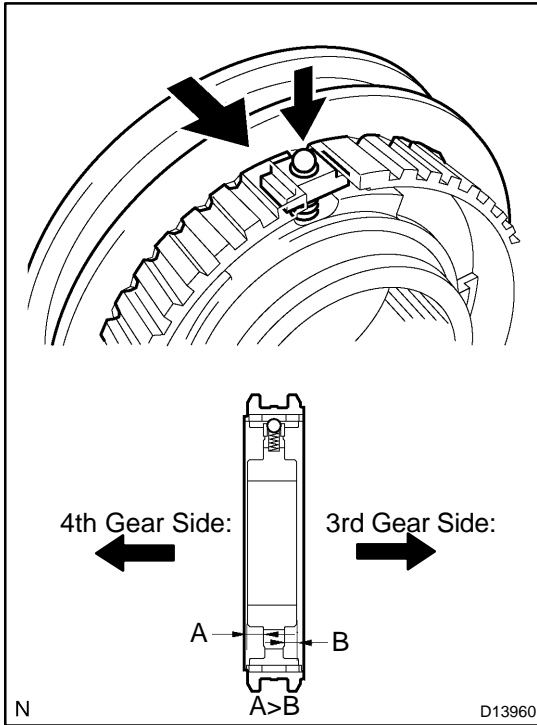
- (b) Select a snap ring that allows for the minimum amount of axial play.

Standard clearance: 0.1 mm (0.0039 in.) or less

Mark	Thickness mm (in.)
A	2.65 to 2.70 (0.1043 to 0.1063)
B	2.70 to 2.75 (0.1063 to 0.1083)
C	2.75 to 2.80 (0.1083 to 0.1102)
D	2.80 to 2.85 (0.1102 to 0.1122)
E	2.85 to 2.90 (0.1122 to 0.1142)
F	2.90 to 2.95 (0.1142 to 0.1161)



- (c) Using a brass bar and hammer, tap in the snap ring.



2. ASSEMBLE CLUTCH HUB NO.2

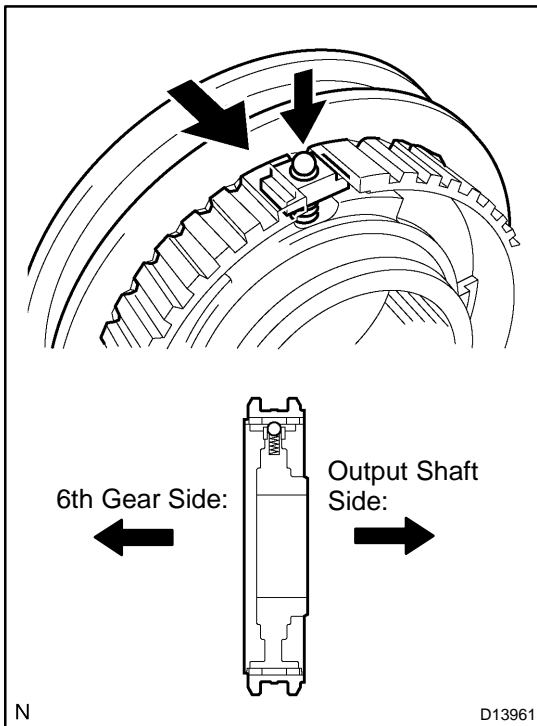
- Apply gear oil to the clutch hub sleeve and clutch hub.
- Install the clutch hub sleeve to the clutch hub No.2.
- Install the 3 shifting keys to the clutch hub.
- Install the 3 shifting key springs to the clutch hub.
- Place the balls on the holes on the shifting keys, and install the hub sleeve while pushing down the balls.

NOTICE:

Be careful not to scatter the balls.

HINT:

Make sure that the clutch hub No.2 is installed in the direction shown in the illustration.



3. ASSEMBLE CLUTCH HUB NO.3

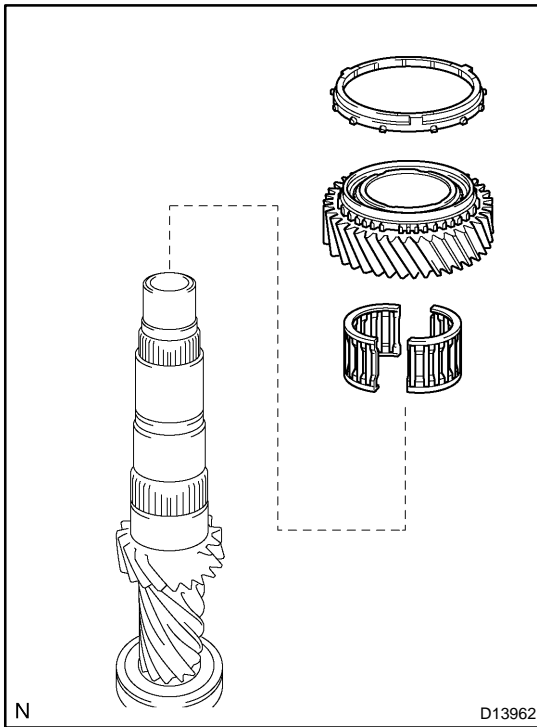
- Apply gear oil to the clutch hub sleeve and clutch hub.
- Install the clutch hub sleeve to the clutch hub No.3.
- Install the 3 shifting keys to the clutch hub.
- Install the 3 shifting key springs to the clutch hub.
- Place the balls on the holes on the shifting keys, and install the hub sleeve while pushing down the balls.

NOTICE:

Be careful not to scatter the balls.

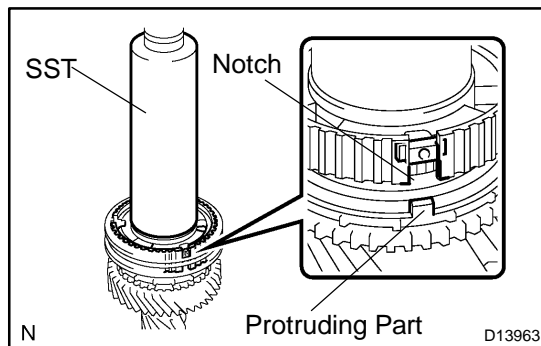
HINT:

Make sure that the clutch hub No.3 is installed in the direction shown in the illustration.



4. INSTALL 4TH GEAR

- Apply gear oil to the needle roller bearing and 4th gear taper cone.
- Install the needle roller bearing and 4th gear to the input shaft.
- Install the synchronizer ring No.3 to the 4th gear.



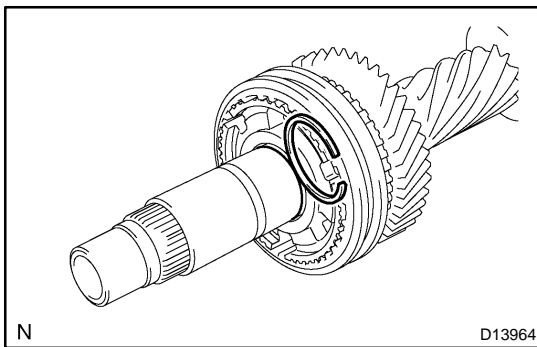
- Using SST and a press, install the clutch hub No.2 to the input shaft.

SST 09308-14010

HINT:

Make sure that the protruding part on the synchronizer ring is fitted into the notch or the clutch hub.

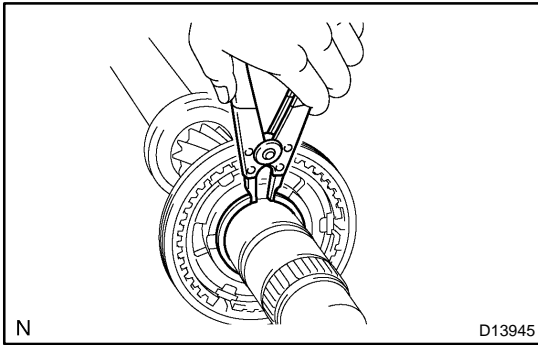
- Make sure that the gear and synchronizer ring move smoothly.



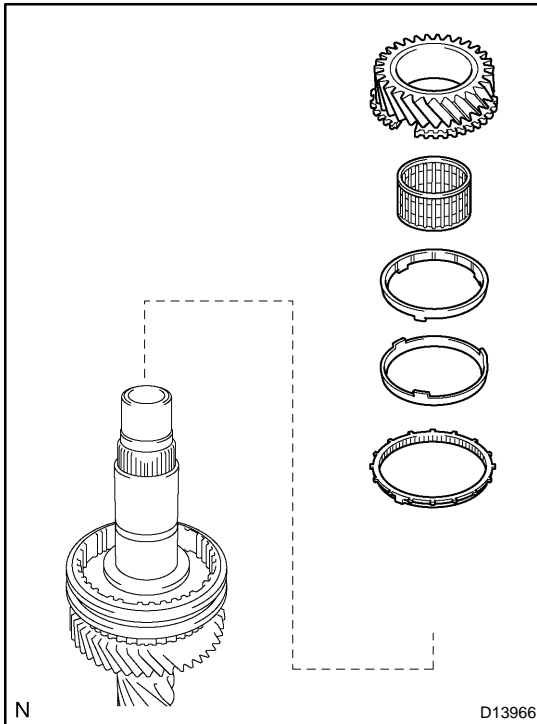
- Select a snap ring that allows for the minimum amount of axial play.

Standard clearance: 0.1 mm (0.0039 in.) or less

Mark	Thickness mm (in.)
A	1.77 to 1.82 (0.0697 to 0.0717)
B	1.82 to 1.87 (0.0717 to 0.0736)
C	1.87 to 1.92 (0.0726 to 0.0756)
D	1.92 to 1.97 (0.0756 to 0.0776)
E	1.97 to 2.02 (0.0776 to 0.0795)
F	2.02 to 2.07 (0.0795 to 0.0815)
G	2.07 to 2.12 (0.0815 to 0.0835)

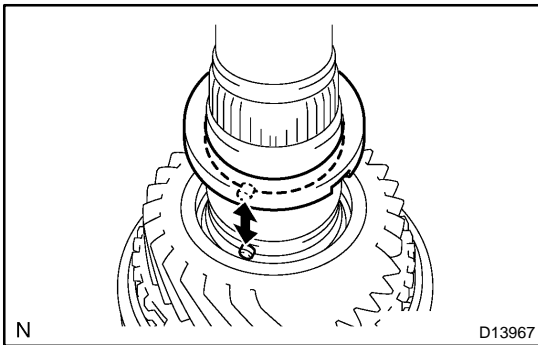


- (g) Using a snap ring expander, install the snap ring.
- (h) Install the spacer to the input shaft.

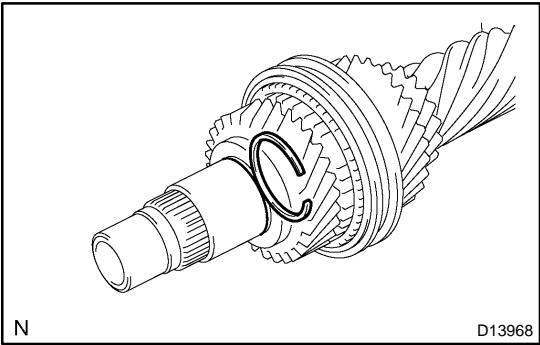


5. INSTALL 3RD GEAR

- (a) Apply gear oil to the needle roller bearing and 3rd gear taper cone.
- (b) Install the synchronizer ring set No.3 to the clutch hub No.2.
- (c) Install the needle roller bearing and 3rd gear to the input shaft.

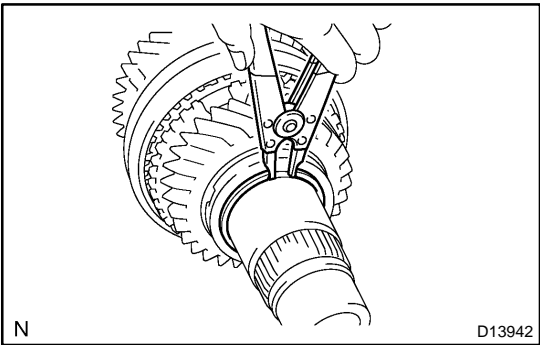


- (d) Install the pin and 3rd gear thrust washer to the input shaft.

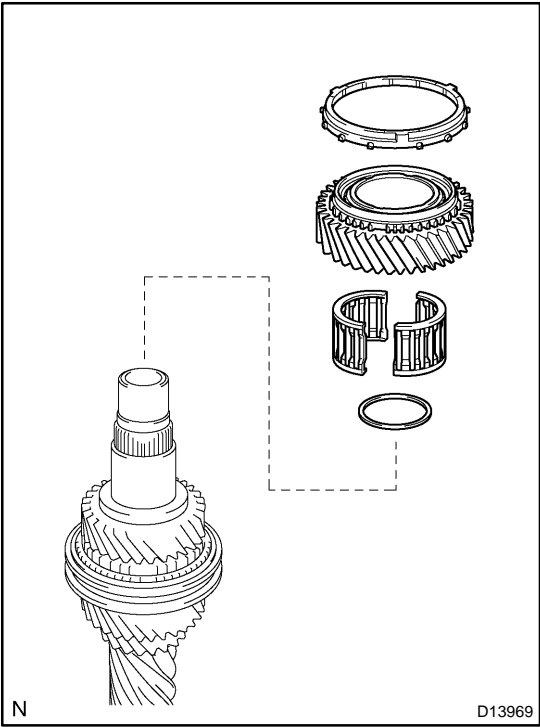


- (e) Select a snap ring that allows for the minimum amount of axial play.
Standard clearance: 0.1 mm (0.0039 in.) or less

Mark	Thickness mm (in.)
A	2.07 to 2.12 (0.0815 to 0.0835)
B	2.12 to 2.17 (0.0835 to 0.0854)
C	2.17 to 2.22 (0.0854 to 0.0874)
D	2.22 to 2.27 (0.0874 to 0.0894)
E	2.27 to 2.32 (0.0894 to 0.0913)
F	2.32 to 2.37 (0.0913 to 0.0933)

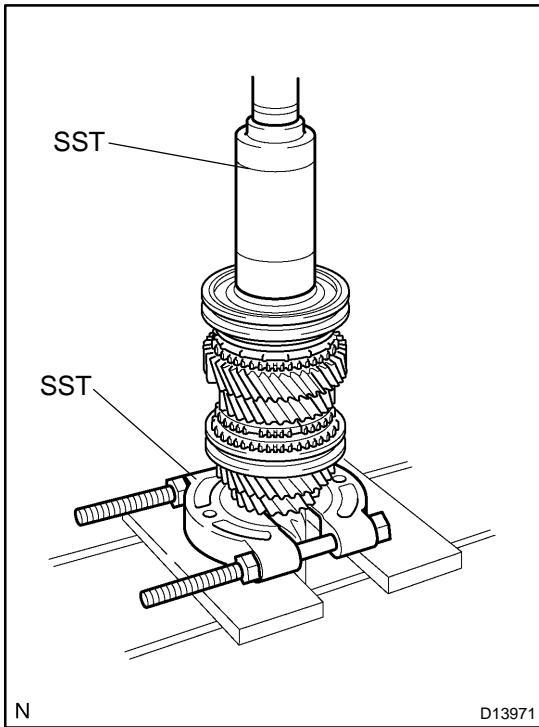


- (f) Using a snap ring expander, install the snap ring.

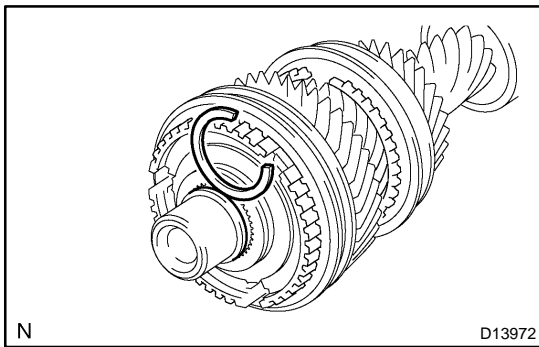


6. INSTALL 6TH GEAR

- (a) Apply gear oil to the needle roller bearing and 6th gear taper cone.
(b) Install the ring, needle roller bearing and 6th gear to the input shaft.
(c) Install the synchronizer ring to the 6th gear.

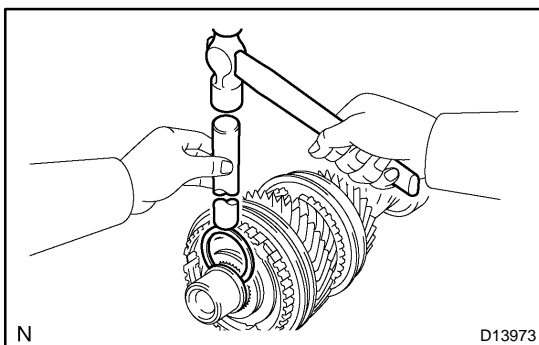


- (d) Using SST and a press, install the clutch hub No.3 to the input shaft.
SST 09309-37010, 09950-00020
- (e) Make sure that the gear and synchronizer ring move smoothly.



- (f) Select a snap ring that allow for the minimum amount of axial play.
Standard clearance: 0.1 mm (0.0039 in.) or less

Mark	Thickness mm (in.)
A	2.10 to 2.15 (0.0827 to 0.0846)
B	2.15 to 2.20 (0.0846 to 0.0866)
C	2.20 to 2.25 (0.0866 to 0.0886)
D	2.25 to 2.30 (0.0886 to 0.0906)
E	2.30 to 2.35 (0.0906 to 0.0925)
F	2.35 to 2.40 (0.0925 to 0.0945)
G	2.40 to 2.45 (0.0945 to 0.0965)



- (g) Using a brass bar and hammer, install the snap ring.