

TF1102

## REASSEMBLY

### HINT:

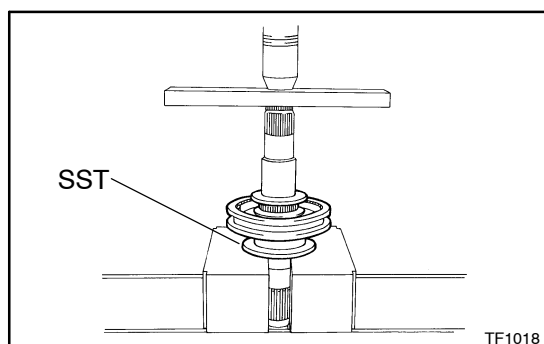
Coat all of the sliding and rotating surfaces with gear oil before reassembly.

### 1. INSTALL CLUTCH HUB INTO HIGH AND LOW HUB SLEEVE

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

### NOTICE:

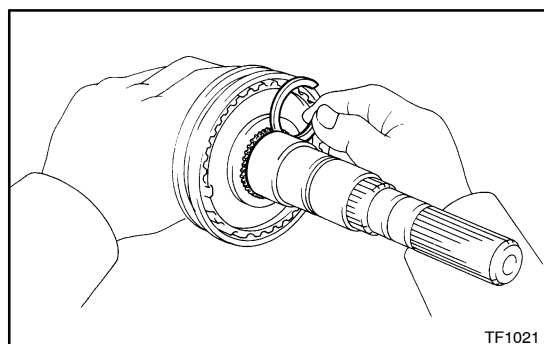
Position the key springs so that their end gaps are not aligned.



TF1018

### 2. INSTALL HIGH AND LOW HUB SLEEVE ASSEMBLY

- Using SST and a press, install the high and low hub sleeve assembly.  
SST 093 16-20011

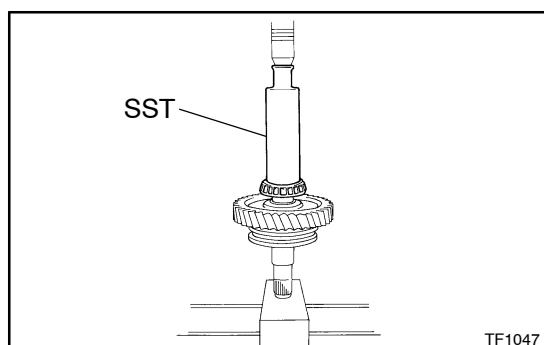


TF1021

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

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.60 (0. 1024)	E	2.80 (0. 1102)
B	2.65 (0. 1043)	F	2.85 (0. 1122)
C	2.70 (0. 1063)	G	2.90 (0. 1142)
D	2.75 (0. 1083)	-	-

- Using a snap ring expander, install a new snap ring.



TF1047

### 3. INSTALL NEEDLE ROLLER BEARING, LOW SPEED GEAR AND REAR TAPER ROLLER BEARING

- Apply gear oil to the needle roller bearing.
- Install the needle roller bearing and low speed gear.
- Using SST and a press, install the rear taper roller bearing.  
SST 093 16-60011 (09316-00011)

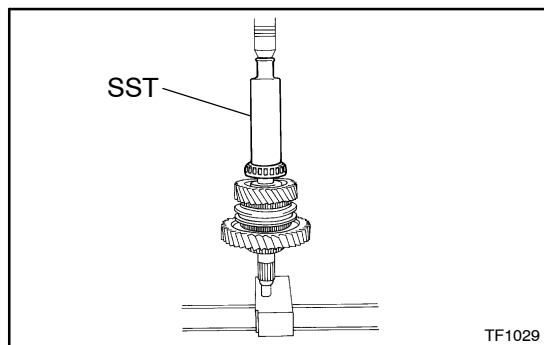
#### 4. INSTALL NEEDLE ROLLER BEARING, SPACER, SYNCHRONIZER RING (M/T) AND HIGH SPEED GEAR

- (a) Apply gear oil to the needle roller bearing.
- (b) Install the needle roller bearing, spacer, synchronizer ring (M/T) and high speed gear.

#### NOTICE:

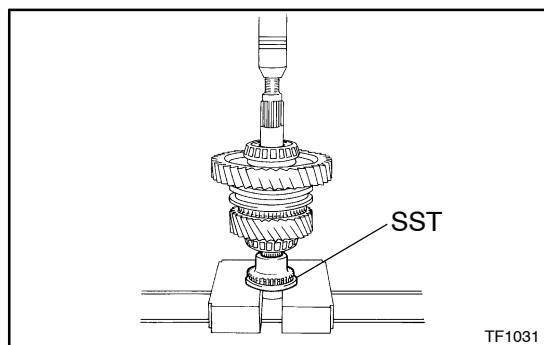
#### M/T:

Align the ring slots with the shifting keys.



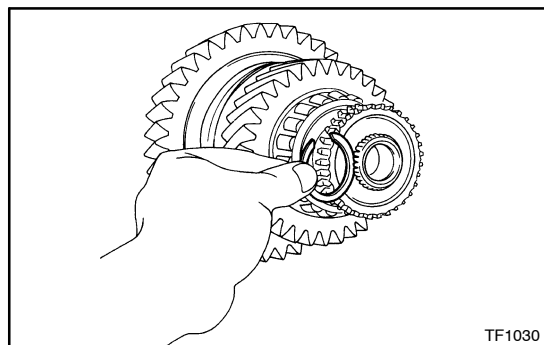
#### 5. INSTALL FRONT TAPER ROLLER BEARING

Using SST and a press, install the front taper roller bearing.  
SST 093 16-60011 (09316-00011)



#### 6. INSTALL FRONT DRIVE GEAR PIECE

- (a) Using SST and a press, install the front drive gear piece.  
SST 093 16-60011 (09316-00031)



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

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.00 (0.0787)	D	2.30 (0.0906)
B	2.10 (0.0827)	E	2.40 (0.0945)
C	2.20 (0.0866)	–	–

- (c) Using a snap ring expander, install a new snap ring.