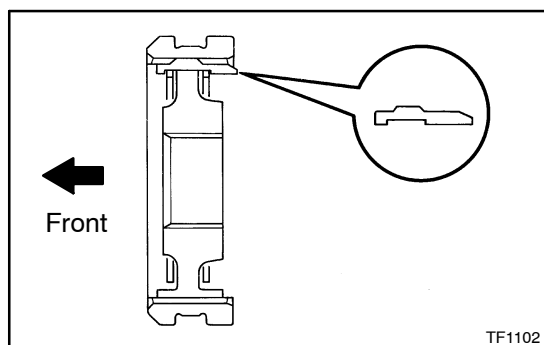


REASSEMBLY

HINT:

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

1. **A/T:**
INSTALL CLUTCH HUB INTO HIGH AND LOW HUB SLEEVE

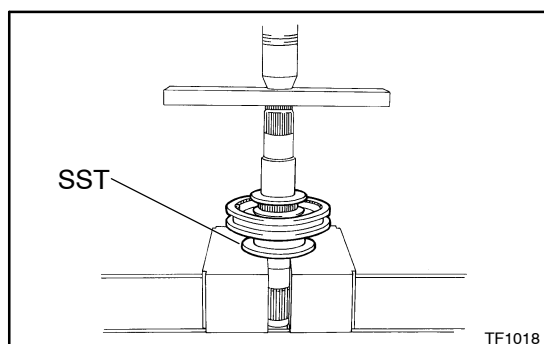


2. **M/T:**
INSTALL CLUTCH HUB INTO HIGH AND LOW HUB SLEEVE

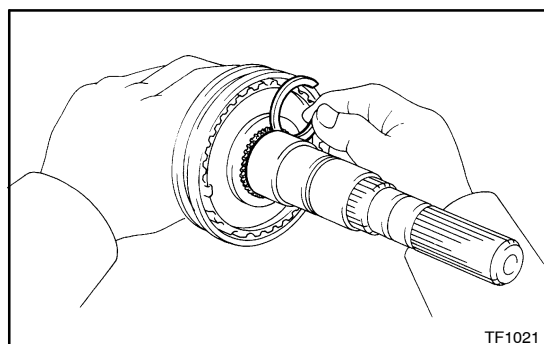
- (a) Install the clutch hub and 3 shifting keys to the high and low hub sleeve.
- (b) Install the 2 shifting key springs under the shifting keys.

NOTICE:

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



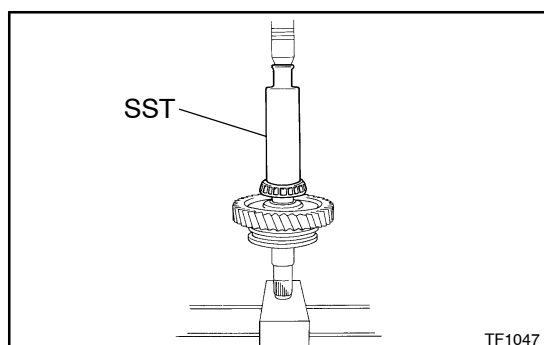
3. **INSTALL HIGH AND LOW HUB SLEEVE ASSEMBLY**
- (a) Using SST and a press, install the high and low hub sleeve assembly to the output shaft.
SST 09316-20011



- (b) 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)	–	–

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



4. **INSTALL NEEDLE ROLLER BEARING, LOW SPEED GEAR AND REAR TAPER ROLLER BEARING**

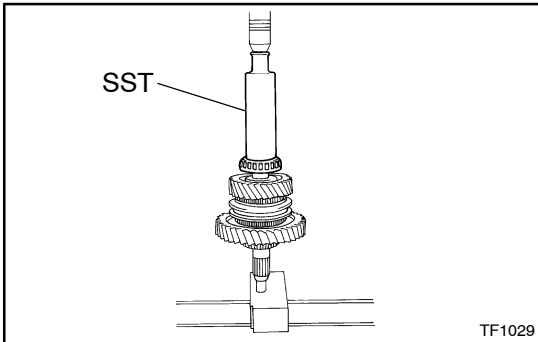
- (a) Apply gear oil to the needle roller bearing.
- (b) Install the needle roller bearing and low speed gear.
- (c) Using SST and a press, install the rear taper roller bearing.
SST 09316-60011 (09316-00011)

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

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

NOTICE:**M/T:**

Align the ring slots with the shifting keys.

**6. INSTALL FRONT TAPER ROLLER BEARING**

Using SST and a press, install the front taper roller bearing.

SST 09316-60011 (09316-00011)