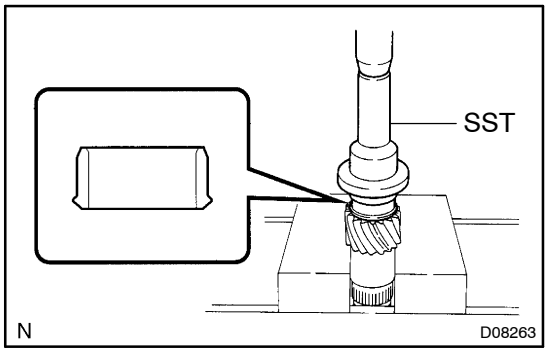
MX0A3–02

REASSEMBLY

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



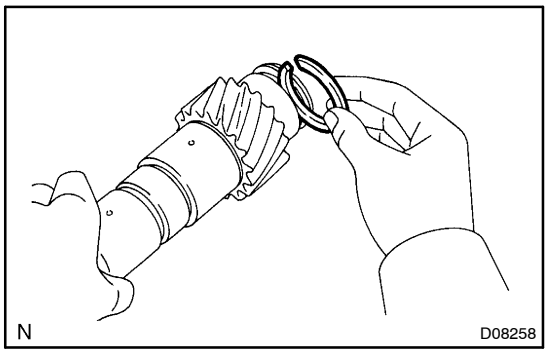
1. INSTALL FRONT BEARING INNER RACE

Using SST and a press, install the front bearing inner race.

SST 09223–50010

NOTICE:

Be sure to install the front bearing inner race in the correct direction, as shown in the illustration.



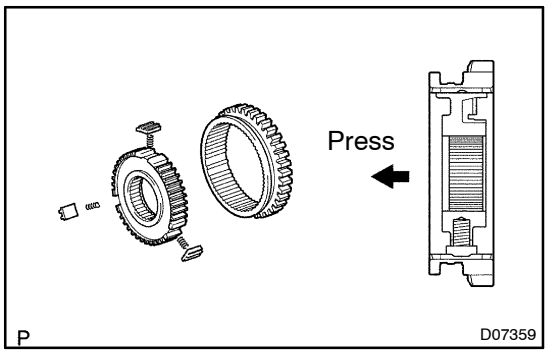
2. INSTALL SNAP RING

(a) Select a snap ring from the table below that will make the thrust clearance of the front bearing inner race less than 0.1 mm (0.0039 in.).

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
7	1.85 (0.0728)	3	2.05 (0.0807)
8	1.90 (0.0748)	4	2.10 (0.0827)
1	1.95 (0.0768)	5	2.15 (0.0846)
2	2.00 (0.0787)	6	2.20 (0.0866)

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

HINT:
Take care not to damage the journal surface of the output shaft.



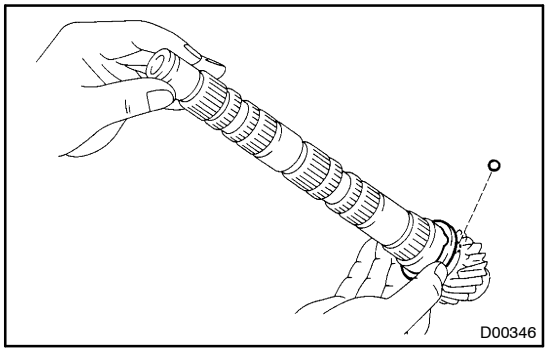
3. ASSEMBLE REVERSE GEAR ASSEMBLY

(a) Install the 3 No. 1 shifting key springs and No. 1 shifting keys to the No. 1 clutch hub.

(b) Install the No. 1 clutch hub to the reverse gear.

NOTICE:

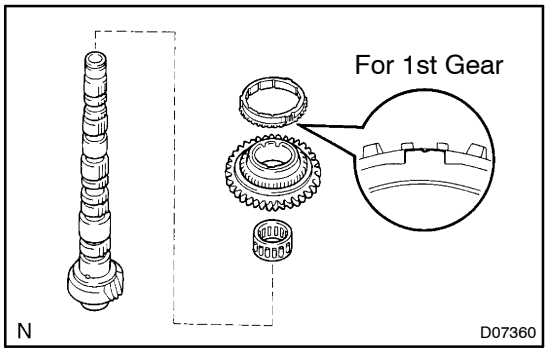
Assemble the No. 1 clutch hub and reverse gear in the direction shown in the illustration.



4. INSTALL BALL, 1ST GEAR THRUST WASHER, NEEDLE ROLLER BEARING, 1ST GEAR, NO. 1 SYNCHRONIZER RING AND REVERSE GEAR ASSEMBLY TO OUTPUT SHAFT

(a) Using a magnetic finger, install the ball to the output shaft.

(b) Fit the 1st gear thrust washer groove securely over the locking ball when installing the thrust on the output shaft.

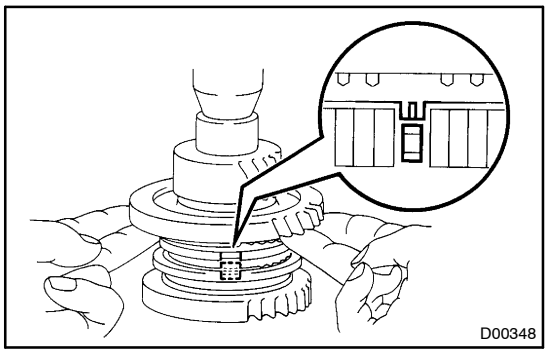


(c) Apply gear oil to the needle roller bearing and install it.

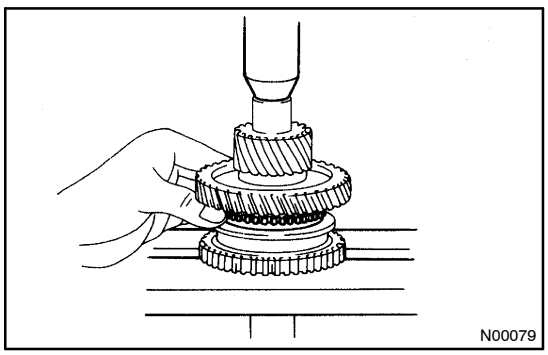
(d) Install the 1st gear and No. 1 synchronizer ring.

NOTICE:

Distinguish the No. 1 synchronizer ring by the teeth on the synchronizer ring.



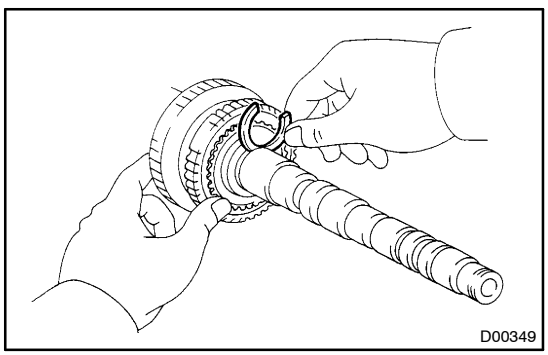
(e) Place the reverse gear assembly and align the No. 1 synchronizer ring slots with the No. 1 shifting keys.



(f) Using a press, install the reverse gear assembly.

NOTICE:

- **Be sure to install the reverse gear assembly in the correct direction, as shown in the illustration.**
- **When installing, make sure that the ball is placed in a groove of the 1st gear thrust washer.**



5. INSTALL SNAP RING

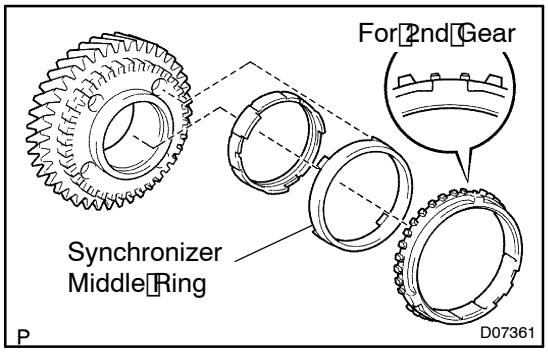
(a) Select a snap ring from the table below that will make the thrust clearance of the No. 1 clutch hub less than 0.1 mm (0.0039 in.).

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.

HINT:
Take care not to damage the journal surface of the output shaft.

6. INSPECT 1ST GEAR THRUST CLEARANCE (See page MX–40)



7. INSTALL SPACER, NEEDLE ROLLER BEARING, NO.2 SYNCHRONIZER RING, 2ND GEAR AND 3RD DRIVEN GEAR

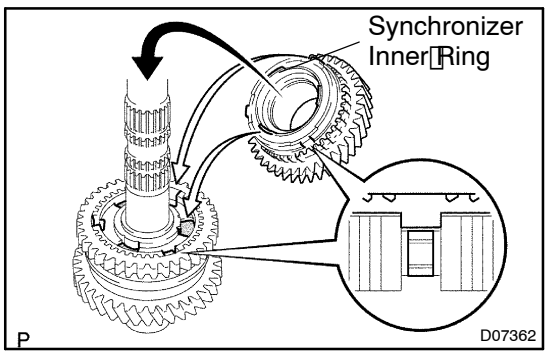
(a) Install the spacer.

(b) Apply gear oil to the needle roller bearing and install it.

(c) Place the No. 2 synchronizer rings on the 2nd gear.

NOTICE:

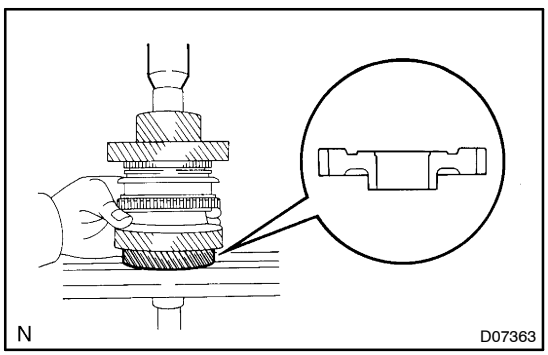
- **Properly fit the synchronizer middle ring claws into the holes in the 2nd gear.**
- **Distinguish the No. 2 synchronizer ring by the teeth on the synchronizer ring.**



(d) Place the 2nd gear with the No. 2 synchronizer rings and align the No. 2 synchronizer ring slots with the No. 1 shifting keys.

NOTICE:

Fit the synchronizer inner ring claws into the slots in the No. 1 clutch hub.

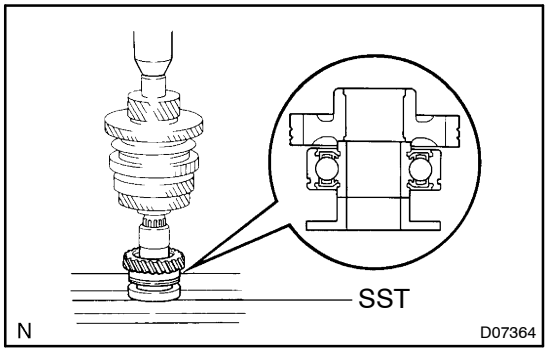


(e) Using a press, install the 3rd driven gear.

NOTICE:

Be sure to install the 3rd driven gear in the correct direction, as shown in the illustration.

8. INSPECT 2ND GEAR THRUST CLEARANCE (See page MX–45)



9. INSTALL OUTPUT GEAR SPACER, 4TH DRIVEN GEAR AND CENTER RADIAL BALL BEARING

(a) Install the output gear spacer.

(b) Using SST and a press, install the 4th driven gear and center radial ball bearing.
SST 09608–00071

NOTICE:

Be sure to install the 4th driven gear and center radial ball bearing in the correct direction, as shown in the illustration.

HINT:

Set SST to the bearing inner race securely.