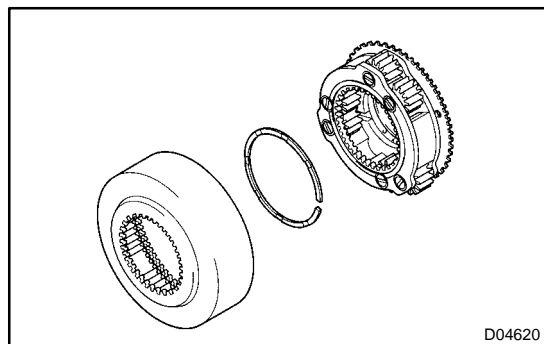


REASSEMBLY

HINT:

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

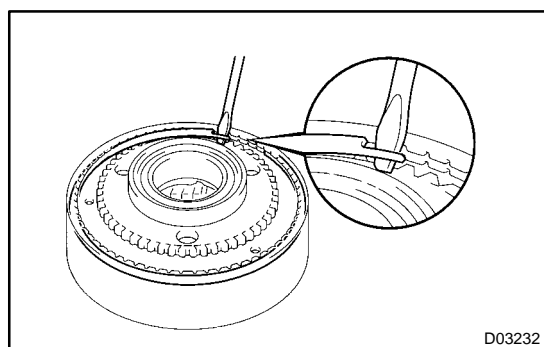


1. INSTALL CENTER DIFFERENTIAL PLANETARY GEAR ASSEMBLY

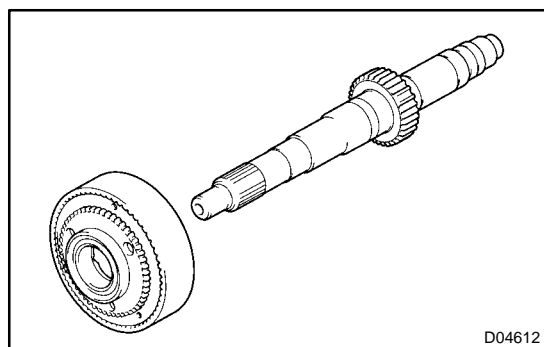
- (a) Install the center differential planetary ring gear and No. 1 center differential planetary gear washer to the center differential planetary gear.

HINT:

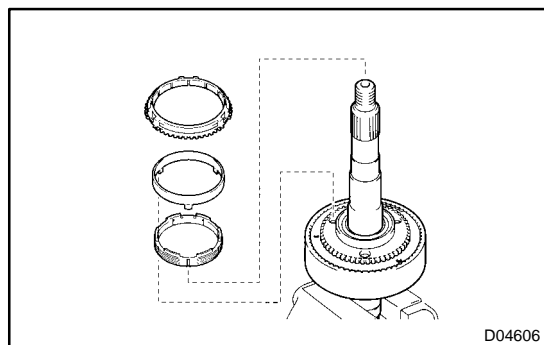
There is no specific direction for the No. 1 center differential planetary gear washer.



- (b) Using a screwdriver, install the center differential planetary ring gear snap ring.



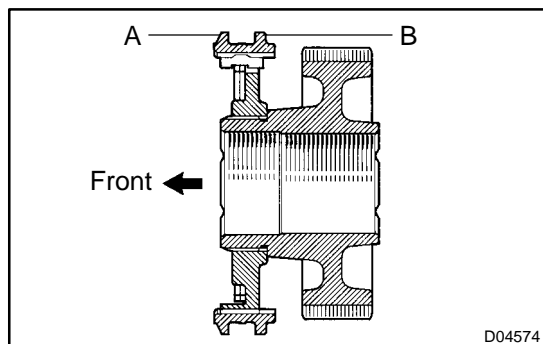
- (c) Install the center differential planetary gear assembly to the rear output shaft.



2. INSTALL SYNCHRONIZER INNER RING, SYNCHRONIZER CENTER RING AND SYNCHRONIZER OUTER RING TO CENTER DIFFERENTIAL PLANETARY GEAR ASSEMBLY

NOTICE:

Be sure that the synchronizer center ring claw matches the cut-out portion of the planetary gear.

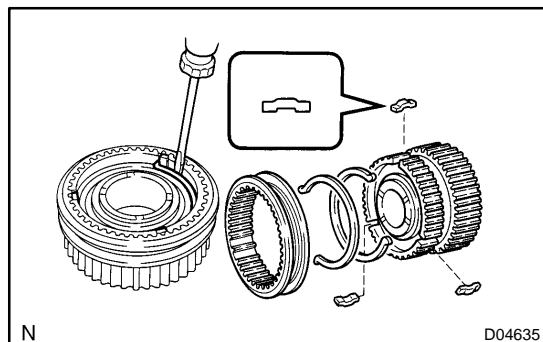


3. ASSEMBLE FRONT DRIVE CLUTCH SLEEVE

(a) Install the front drive clutch sleeve to the drive sprocket.

NOTICE:

The direction of the front drive clutch sleeve can be distinguished by the difference in the shape of the external surface areas "A" and "B".



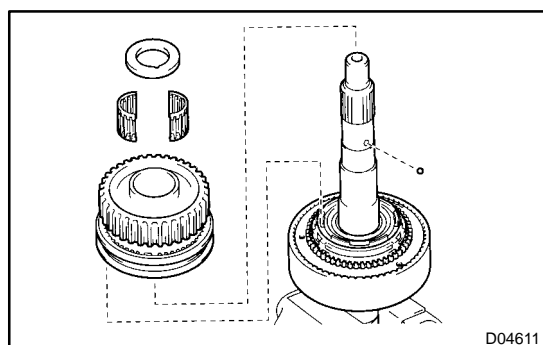
(b) Install the 3 shifting keys and fix them with the 2 shifting key springs.

NOTICE:

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

HINT:

There is no specific direction for the shifting key.

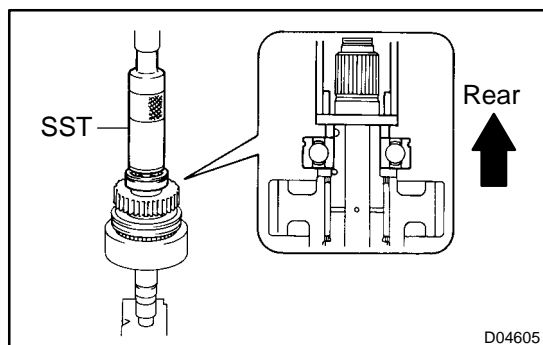


4. INSTALL DRIVE SPROCKET AND FRONT DRIVE CLUTCH SLEEVE ASSEMBLY

Install the needle roller bearing, drive sprocket and front drive clutch sleeve assembly, output shaft spacer ball and No. 1 spacer.

NOTICE:

- Be sure that the slot of the synchronizer inner ring matches the protrusion of the drive sprocket.
- Align the synchronizer ring slots with the shifting keys.



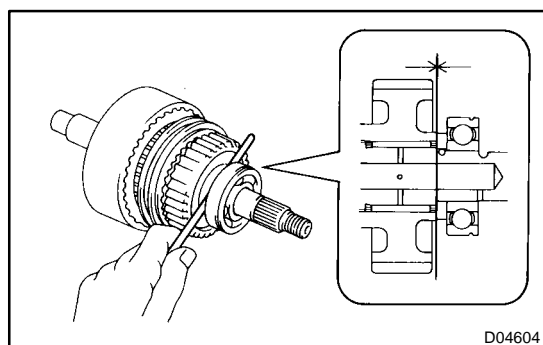
5. INSTALL OUTPUT SHAFT RADIAL BALL BEARING

Using SST and a press, install a new output shaft radial ball bearing.

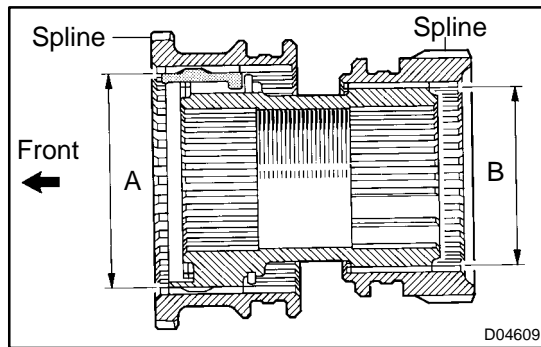
SST 09316-6001 1 (09316-00011, 09316-00071)

NOTICE:

Install the output shaft radial ball bearing so that the bearing snap ring groove faces to the rear.



6. INSPECT DRIVE SPROCKET THRUST CLEARANCE (See page [TR-31](#))

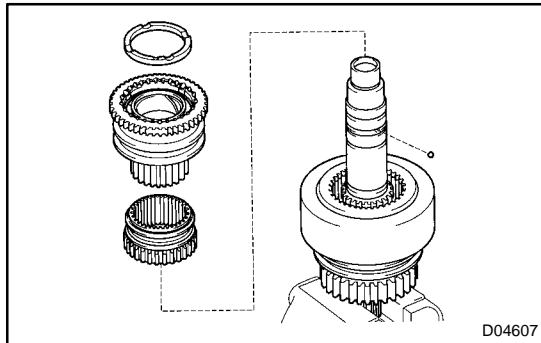


7. ASSEMBLE CLUTCH HUB

Install the high and low clutch sleeve and center differential lock sleeve to the clutch hub.

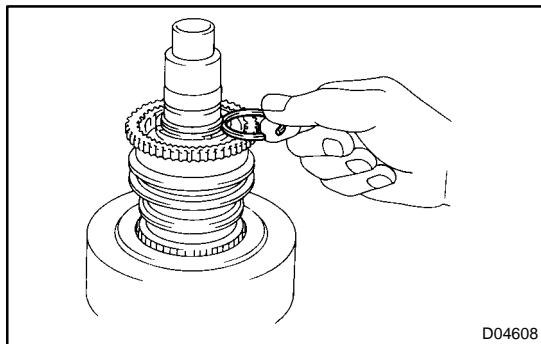
NOTICE:

- The direction of the clutch hub can be distinguished by size of outer diameters "A" and "B" of the boss.
- The direction of the high and low clutch sleeve can be distinguished by width of the spline.



8. INSTALL CLUTCH HUB ASSEMBLY

- (a) Install the clutch hub assembly, input gear stopper ball and No. 2 spacer to the rear output shaft.



- (b) Select a snap ring so that the clearance between the clutch hub and snap ring will be less than 0.15 mm (0.0059 in.).

Mark	Thickness mm (in.)
K	2.00 - 2.05 (0.0787 - 0.0807)
L	2.05 - 2.10 (0.0807 - 0.0827)
A	2.10 - 2.15 (0.0827 - 0.0846)
B	2.15 - 2.20 (0.0846 - 0.0866)
C	2.20 - 2.25 (0.0866 - 0.0886)
D	2.25 - 2.30 (0.0886 - 0.0906)
E	2.30 - 2.35 (0.0906 - 0.0925)
F	2.35 - 2.40 (0.0925 - 0.0945)
G	2.40 - 2.45 (0.0945 - 0.0965)
H	2.45 - 2.50 (0.0965 - 0.0984)
J	2.50 - 2.55 (0.0984 - 0.1004)

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

9. INSPECT DRIVE SPROCKET RADIAL CLEARANCE (See page [TR-31](#))