

REASSEMBLY

HINT:

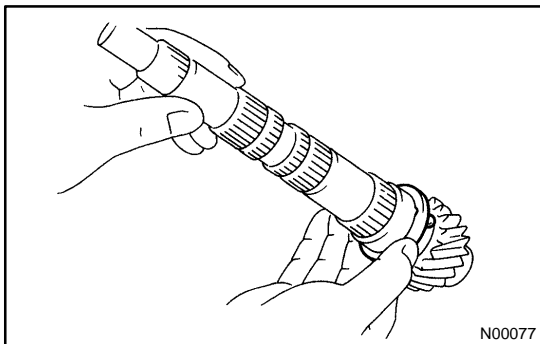
Coat all of the sliding and rotating surfaces with gear oil before reassembly.

1. ASSEMBLE REVERSE GEAR ASSEMBLY

- (a) Install the 3 shifting keys and reverse gear to the No. 1 clutch hub.
- (b) Install the 2 shifting key springs under the shifting keys.

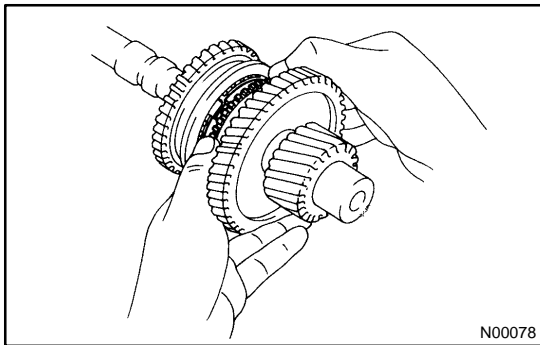
NOTICE:

Position the shifting key springs so that their end gaps are not in line.

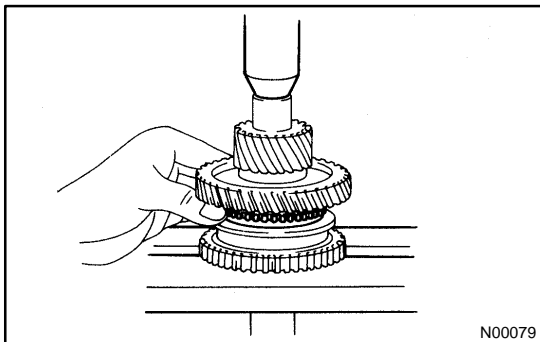


2. INSTALL BALL, THRUST WASHER, NEEDLE ROLLER BEARING, 1ST GEAR, SYNCHRONIZER RING AND REVERSE GEAR ASSEMBLY TO OUTPUT SHAFT

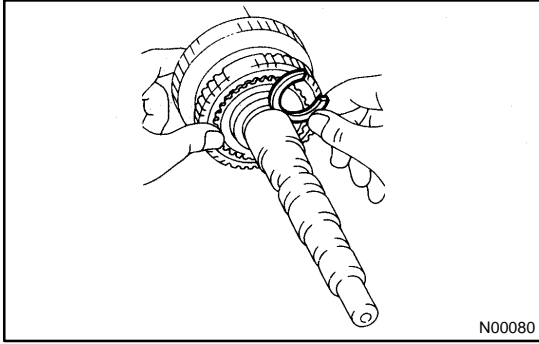
- (a) Install the ball to the output shaft.
- (b) Fit the thrust washer groove securely over the locking ball when installing the thrust on the output shaft.
- (c) Apply gear oil to the needle roller bearing and install it.
- (d) Install the 1st gear and synchronizer ring.



- (e) Place the reverse gear assembly and align the synchronizer ring slots with the shifting keys.



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



3. INSTALL SNAP RING

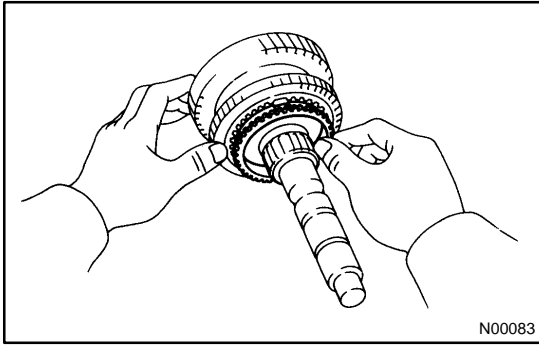
- (a) Select a snap ring that allows the minimum axial play.

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.

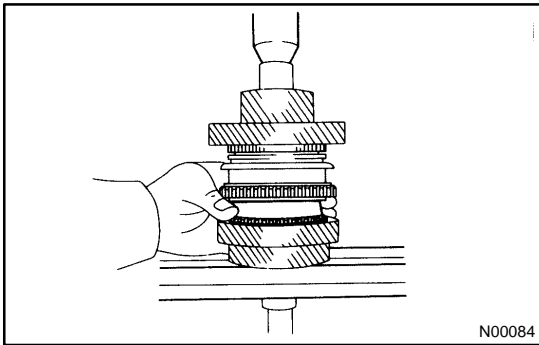
4. INSPECT 1ST GEAR THRUST CLEARANCE

(See page [MX-31](#))



5. INSTALL NEEDLE ROLLER BEARING, SYNCHRONIZER RING, 2ND GEAR AND 3RD DRIVEN GEAR

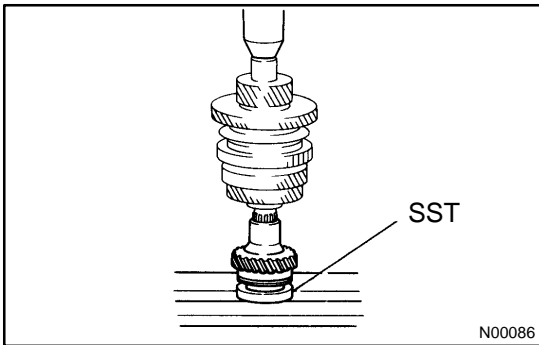
- (a) Apply gear oil to the needle roller bearing and install it.
 (b) Place the synchronizer ring on the reverse gear assembly and align the ring slots with the shifting keys.
 (c) Install the 2nd gear.



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

6. INSPECT 2ND GEAR THRUST CLEARANCE

(See page [MX-31](#))



7. INSTALL OUTPUT GEAR SPACER, 4TH DRIVEN GEAR AND REAR BALL BEARING

- (a) Install the output gear spacer.
 (b) Using SST and a press, install the 4th driven gear and rear ball bearing.

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