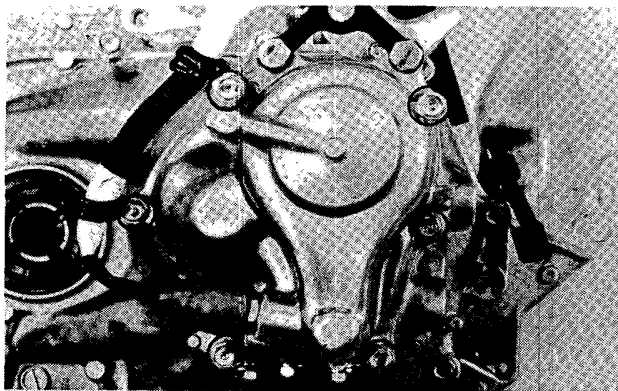


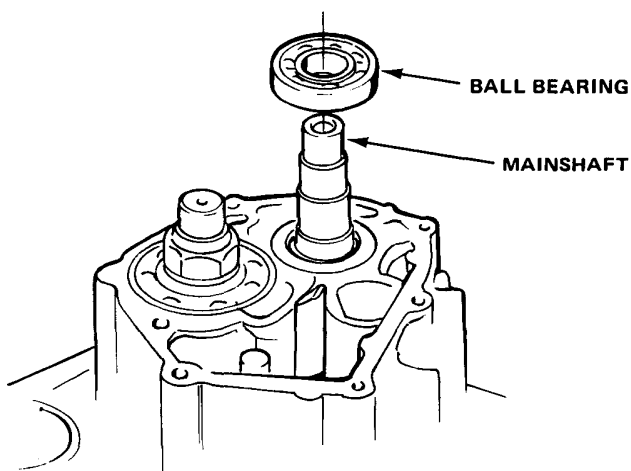
4-Speed Transmission

End Cover Snap Ring Inspection

1. Remove the bolts from the end cover, then remove it.

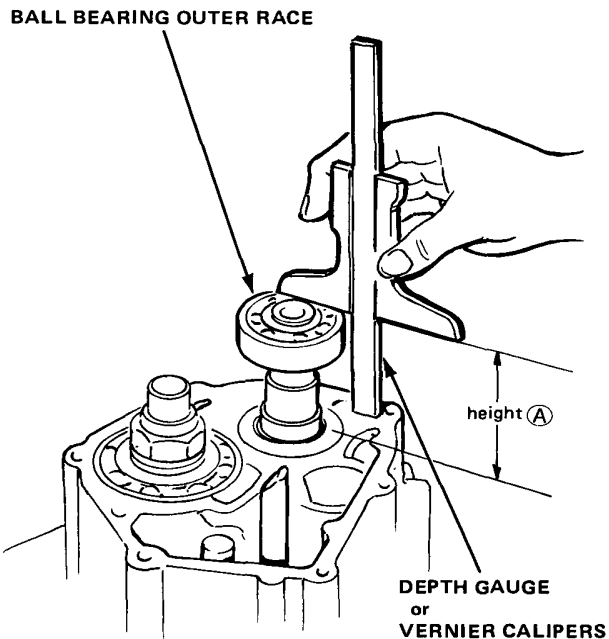


2. Remove the bearing and gears from the mainshaft.

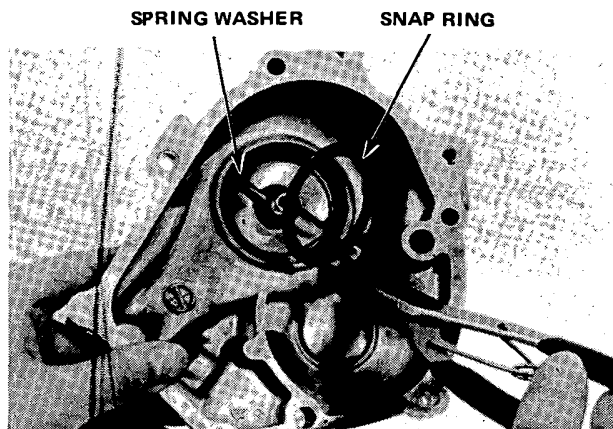


3. Reinstall the ball bearing onto the mainshaft.

4. Clean all sealant residue from the transmission housing, then measure from the top of the ball bearing's outer race to the mounting flange for the end cover. Measure at two points and average the readings.

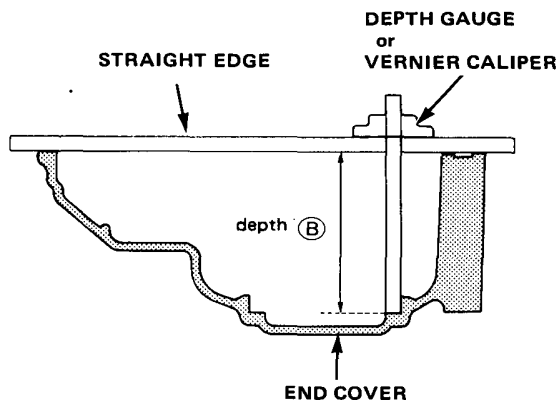


5. Remove the 52 mm spring washer and the snap ring from the end cover.





6. Place a straight edge on the end cover and measure the depth on the snap ring installation hole. Measure at two points and average the readings. Subtract the thickness of the straight edge from the reading.



7. Select the correct thickness snap ring as follows:

- (a) Subtract the bearing height (step 4) from the depth of the end cover (step 6).
(b) Subtract the spring washer free height (0.85 mm/0.033 in.) from the dimension determined in step 7a.

EXAMPLE:

Housing depth: 58.05 mm (2.285 in.)
Bearing height: -56.05 mm (2.207 in.)
Spring washer height: - 0.85 mm (0.033 in.)
Correct snap ring thickness: 1.15 mm (0.045 in.)

Parts Number	Thickness
23931-PE6-0000	0.5 mm (0.020 in.)
23932-PE6-0000	1.1 mm (0.043 in.)
23933-PE6-0000	1.15 mm (0.045 in.)
23934-PE6-0000	1.20 mm (0.047 in.)
23935-PE6-0000	1.25 mm (0.049 in.)
23936-PE6-0000	1.30 mm (0.051 in.)
23937-PE6-0000	1.35 mm (0.053 in.)
23938-PE6-0000	1.40 mm (0.055 in.)
23939-PE6-0000	1.45 mm (0.057 in.)
23940-PE6-0000	1.50 mm (0.059 in.)
23941-PE6-0000	1.55 mm (0.061 in.)