

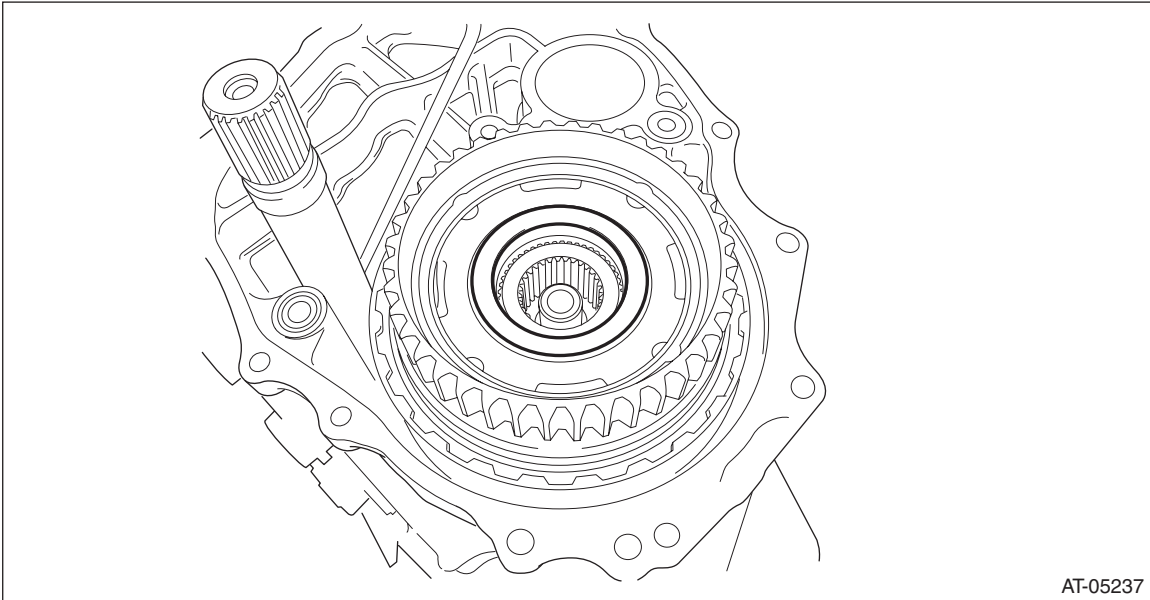
# Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

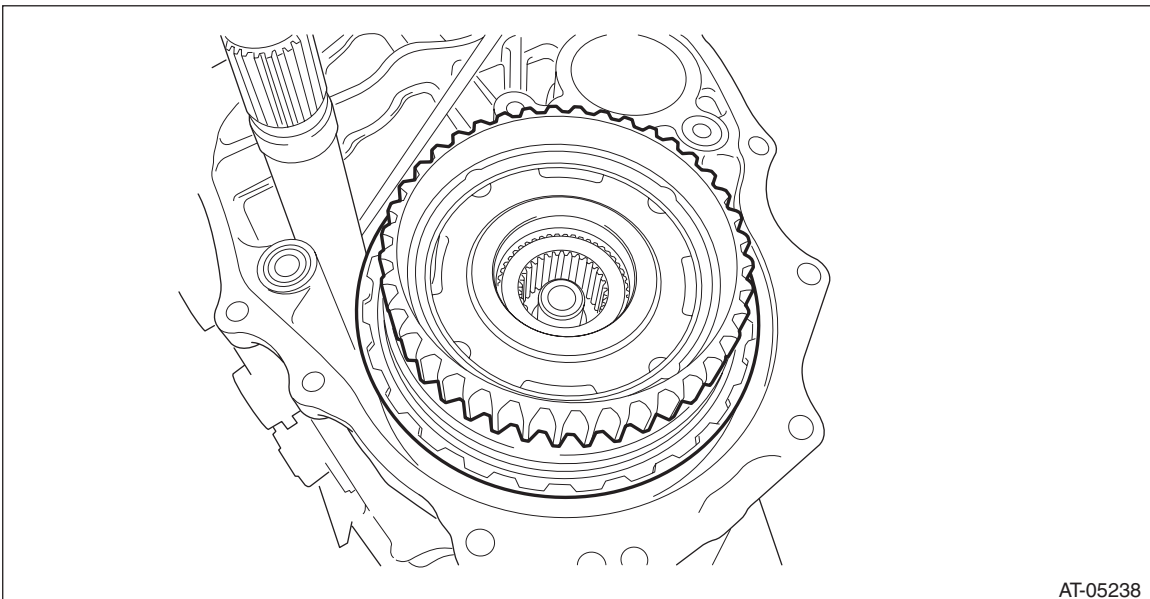
## 37.Forward Clutch Assembly

### A: REMOVAL

- 1) Remove the transmission from the vehicle. <Ref. to CVT(TR690)-56, REMOVAL, Automatic Transmission Assembly.>
- 2) Remove the extension case. <Ref. to CVT(TR690)-140, REMOVAL, Extension Case.>
- 3) Remove the rear drive shaft. <Ref. to CVT(TR690)-143, REMOVAL, Rear Drive Shaft.>
- 4) Remove the transfer clutch assembly. <Ref. to CVT(TR690)-148, REMOVAL, Transfer Clutch.>
- 5) Remove the transfer reduction driven gear. <Ref. to CVT(TR690)-160, REMOVAL, Transfer Reduction Driven Gear.>
- 6) Remove the intermediate case. <Ref. to CVT(TR690)-167, REMOVAL, Intermediate Case.>
- 7) Remove the thrust needle bearing.



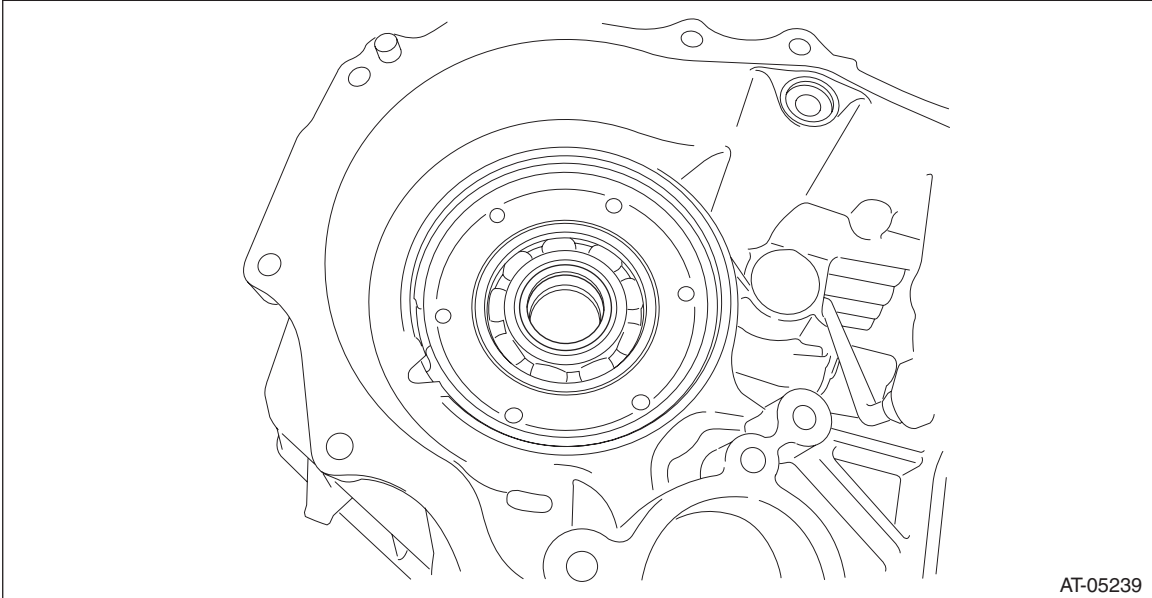
- 8) Remove the forward clutch assembly.



# Forward Clutch Assembly

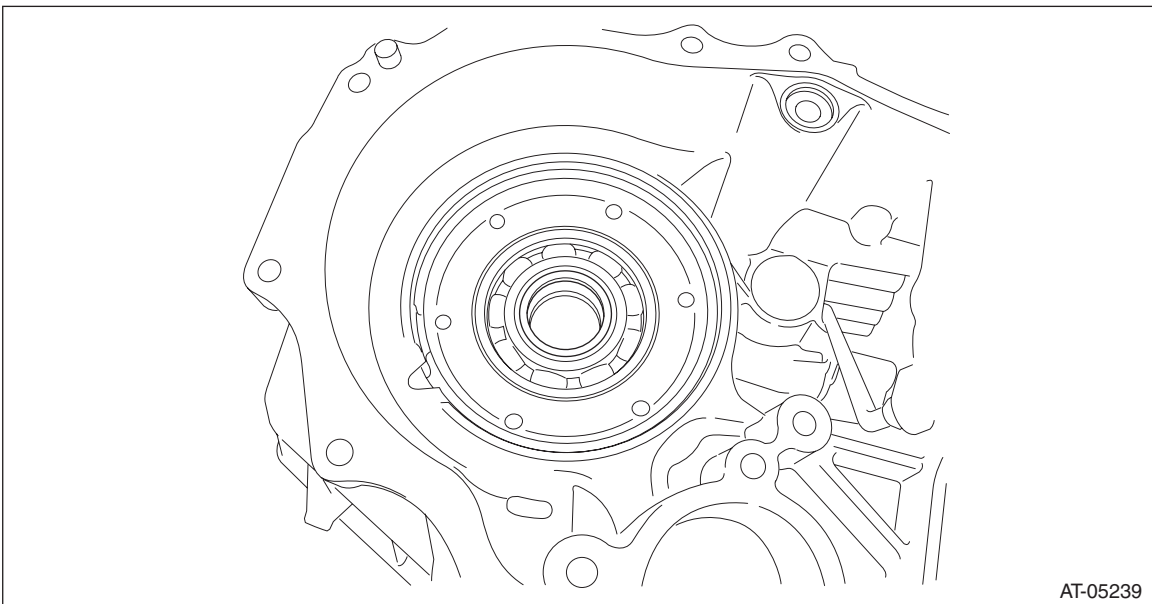
CONTINUOUSLY VARIABLE TRANSMISSION

9) Remove the washer.



## B: INSTALLATION

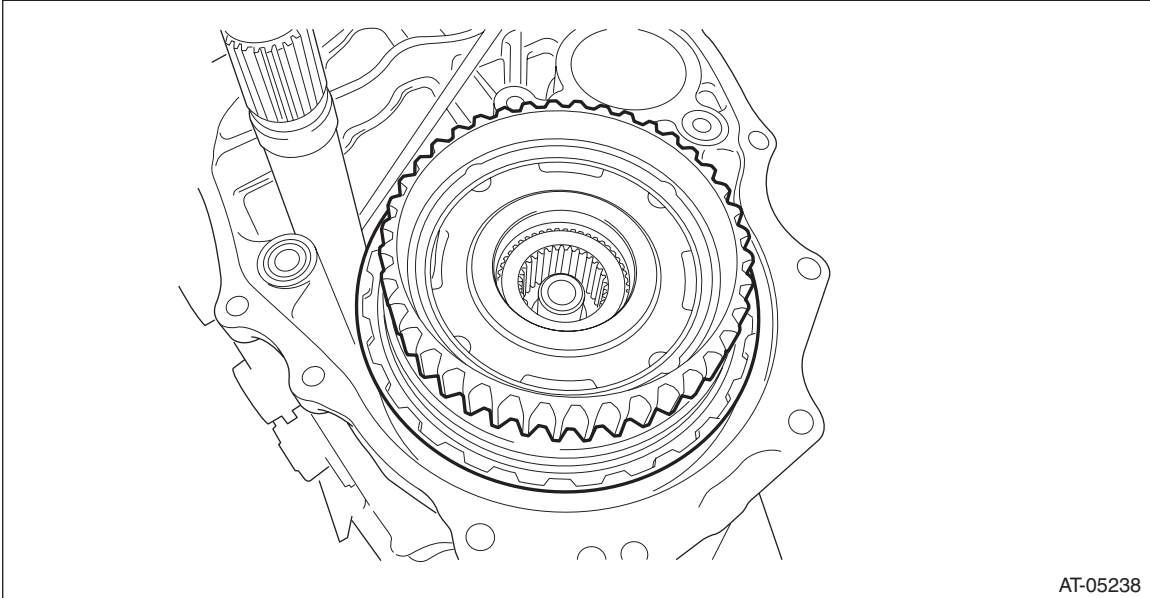
- 1) Select a washer. <Ref. to CVT(TR690)-200, ADJUSTMENT, Forward Clutch Assembly.>
- 2) Install the selected washer.



## Forward Clutch Assembly

### CONTINUOUSLY VARIABLE TRANSMISSION

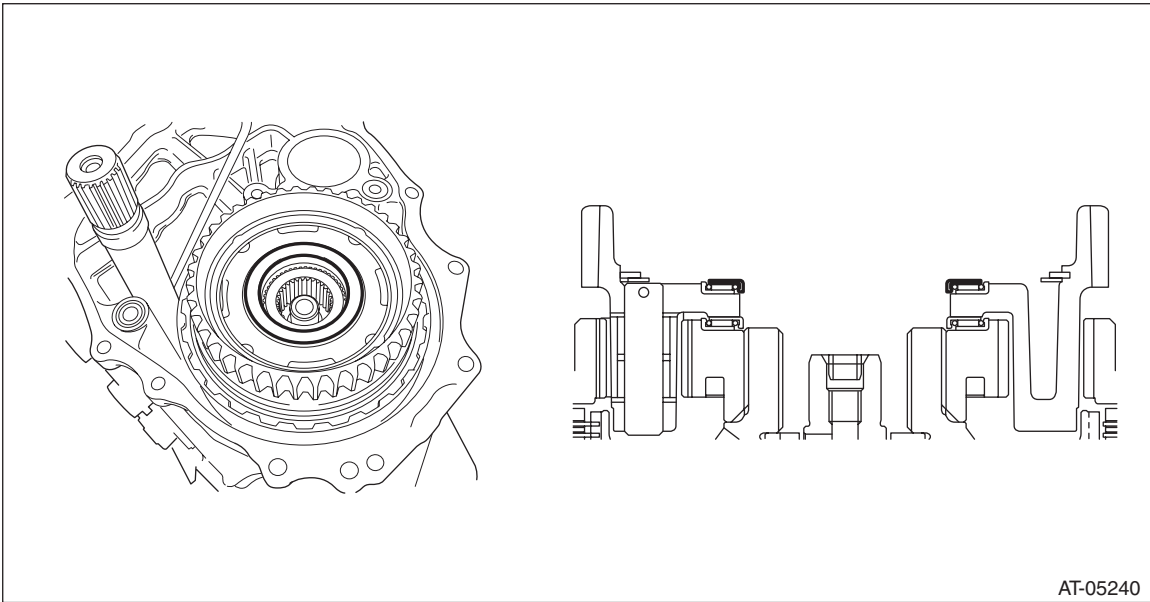
3) Install the forward clutch assembly.



4) Install the thrust needle bearing.

#### NOTE:

Install the thrust needle bearing in the correct direction.



5) Install the intermediate case. <Ref. to CVT(TR690)-168, INSTALLATION, Intermediate Case.>

6) Install the transfer reduction driven gear assembly. <Ref. to CVT(TR690)-160, INSTALLATION, Transfer Reduction Driven Gear.>

7) Install the transfer clutch assembly. <Ref. to CVT(TR690)-149, INSTALLATION, Transfer Clutch.>

8) Install the rear drive shaft. <Ref. to CVT(TR690)-143, INSTALLATION, Rear Drive Shaft.>

9) Install the extension case. <Ref. to CVT(TR690)-141, INSTALLATION, Extension Case.>

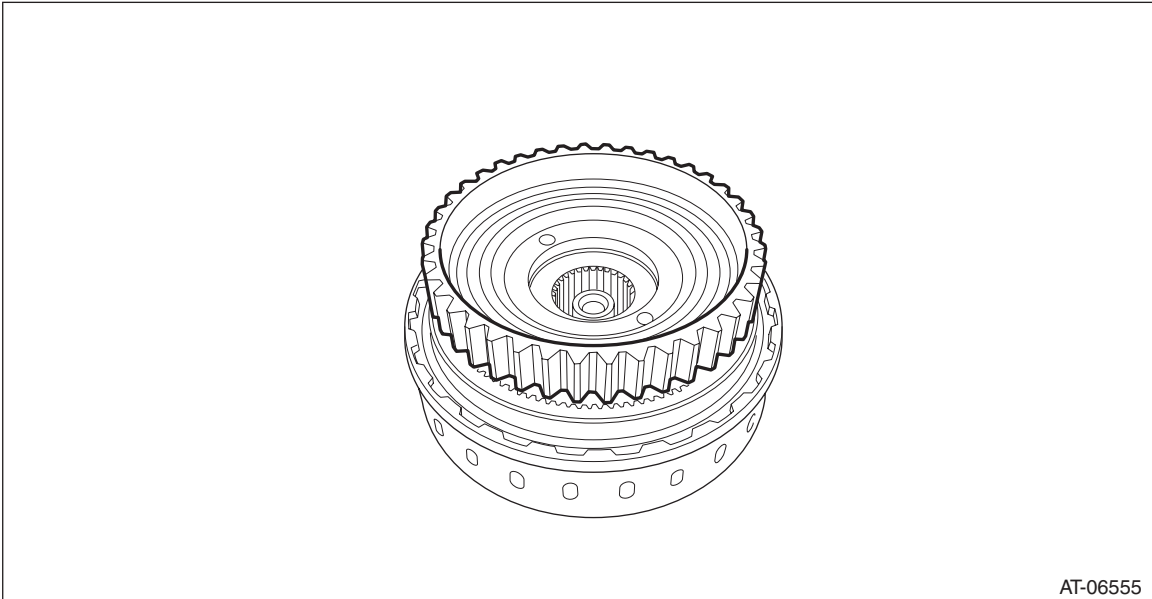
10) Install the transmission to vehicle. <Ref. to CVT(TR690)-69, INSTALLATION, Automatic Transmission Assembly.>

# Forward Clutch Assembly

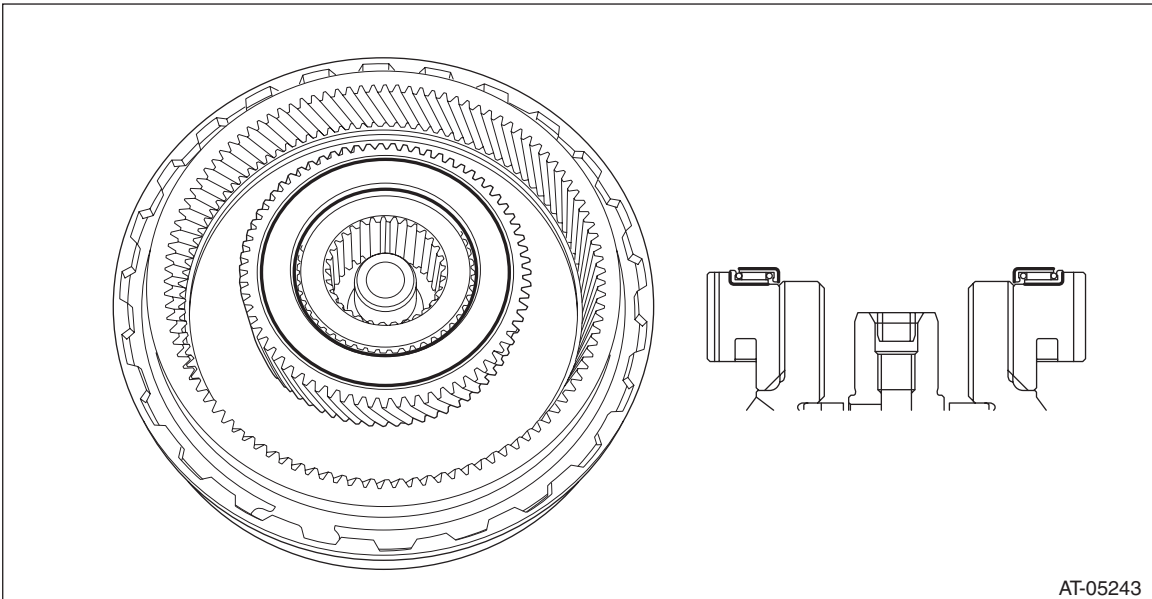
CONTINUOUSLY VARIABLE TRANSMISSION

## C: DISASSEMBLY

- 1) Remove the planetary carrier assembly.



- 2) Remove the thrust needle bearing.



## Forward Clutch Assembly

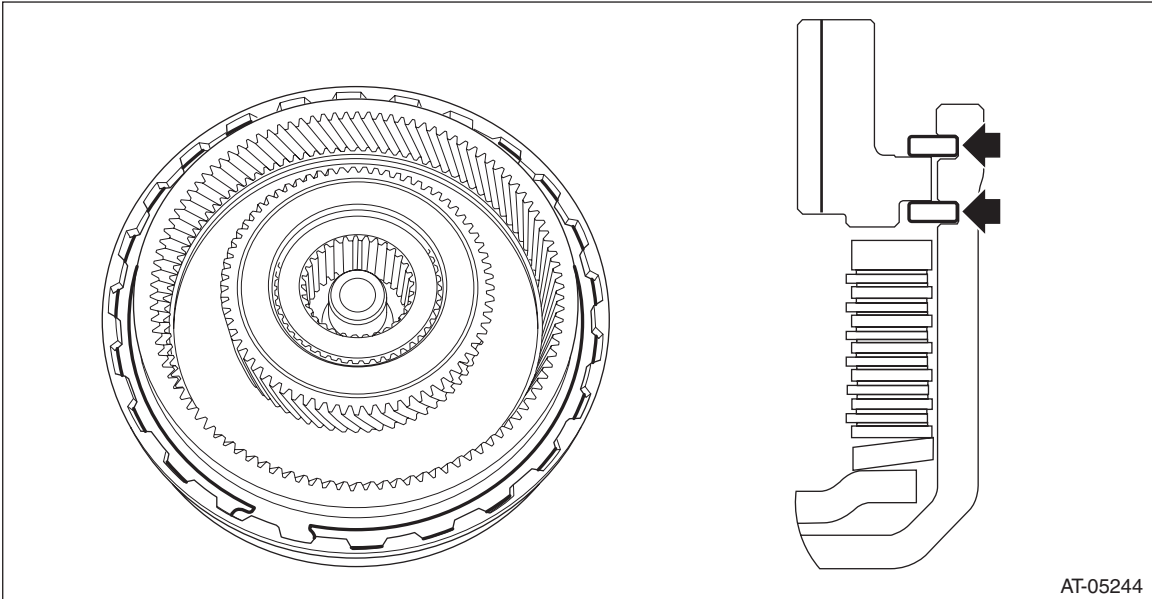
### CONTINUOUSLY VARIABLE TRANSMISSION

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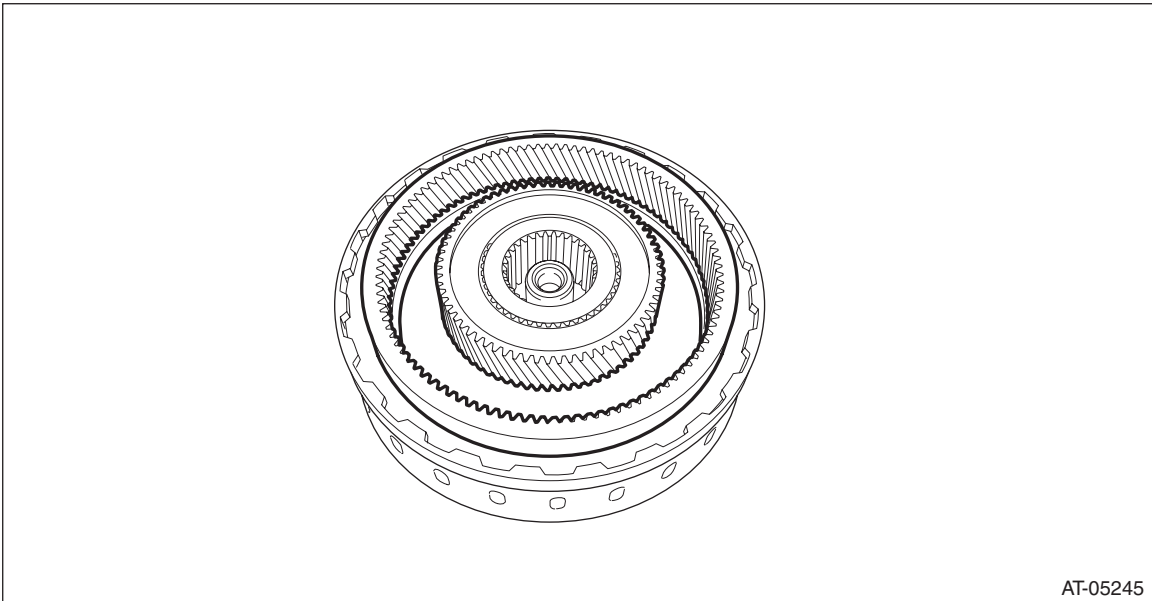
3) Remove the snap ring.

**NOTE:**

Use marking or labeling to the upper snap ring for measurement of the snap ring thickness when selecting the retaining plate.



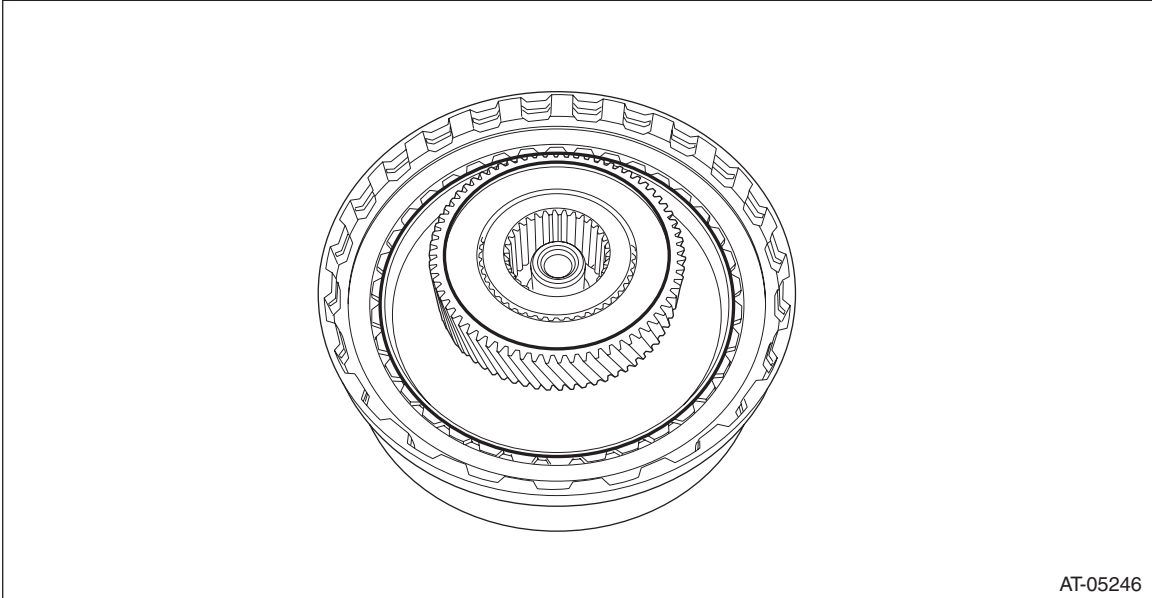
4) Remove the internal gear.



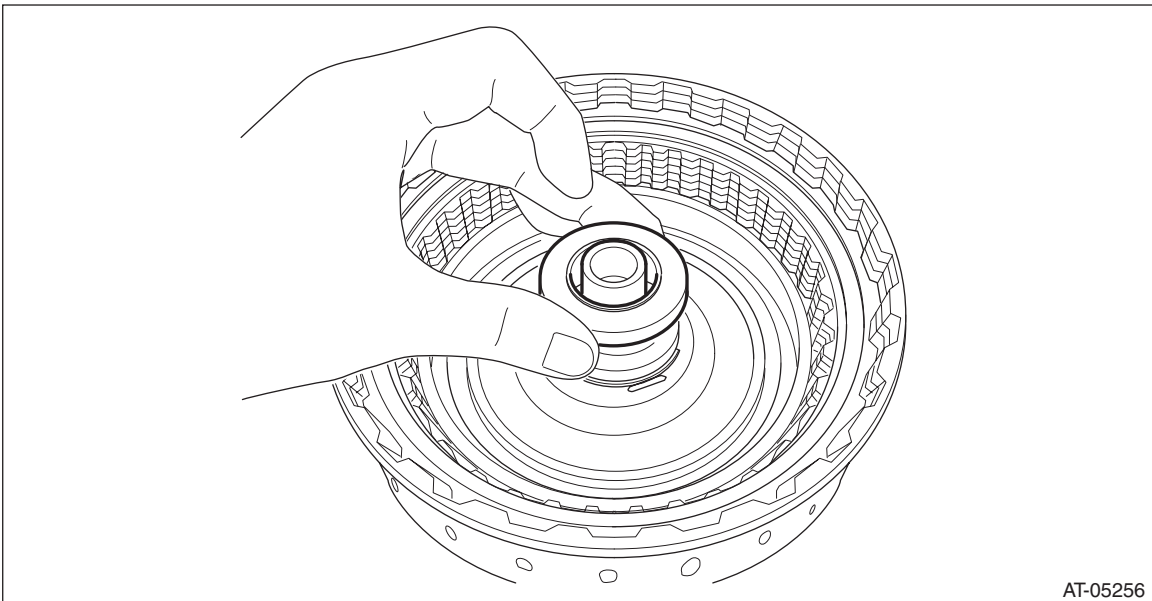
# Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

5) Remove the sun gear.



6) Remove the washer.

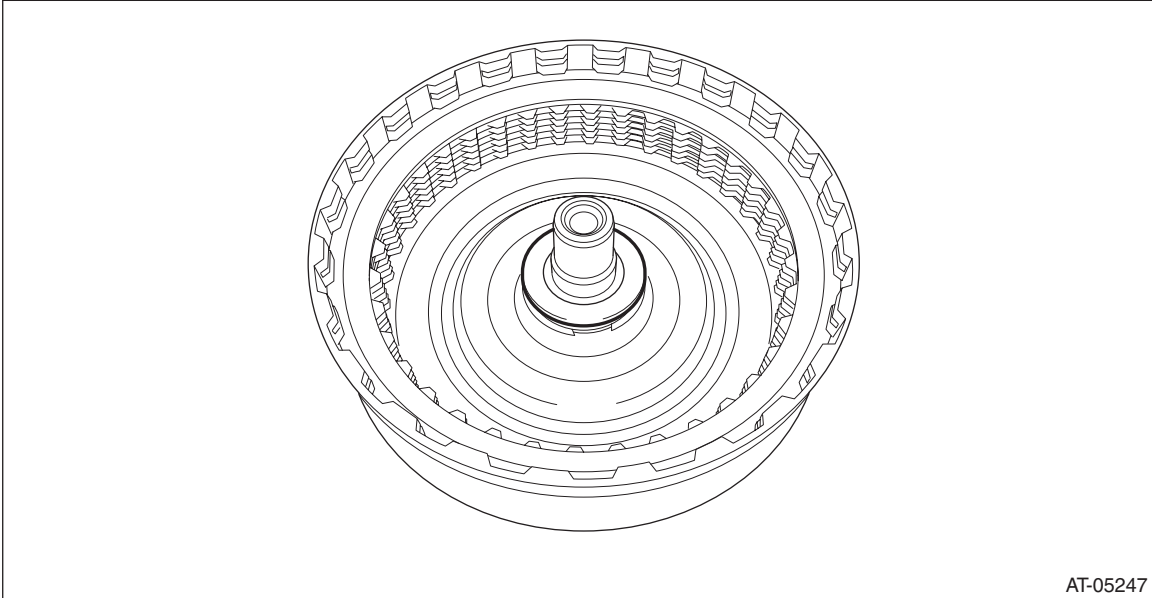


## Forward Clutch Assembly

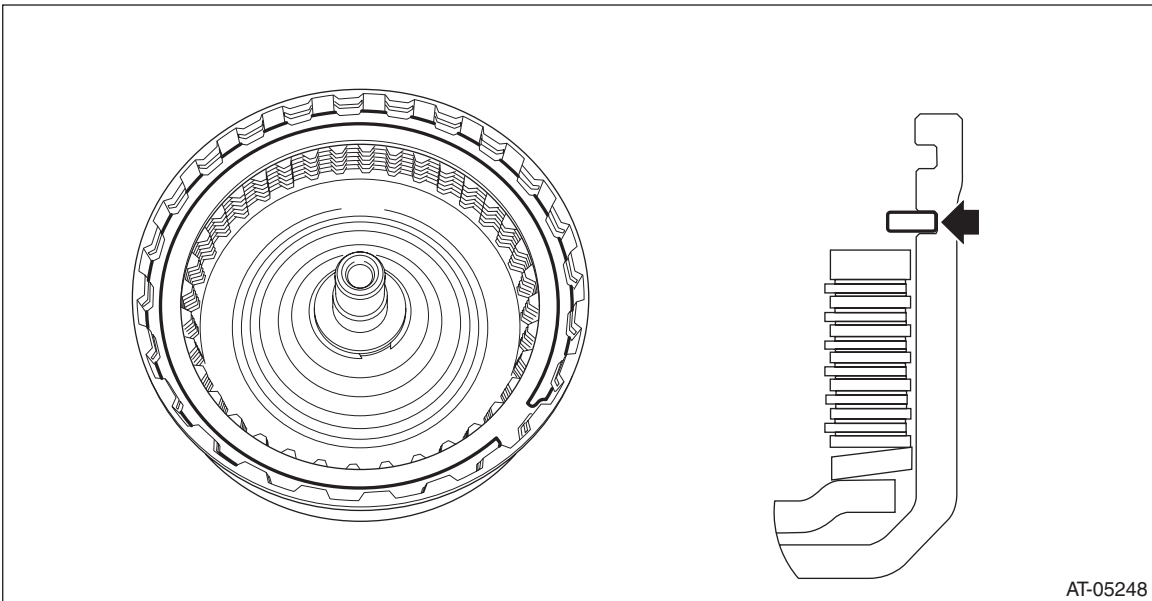
### CONTINUOUSLY VARIABLE TRANSMISSION

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7) Remove the thrust needle bearing.



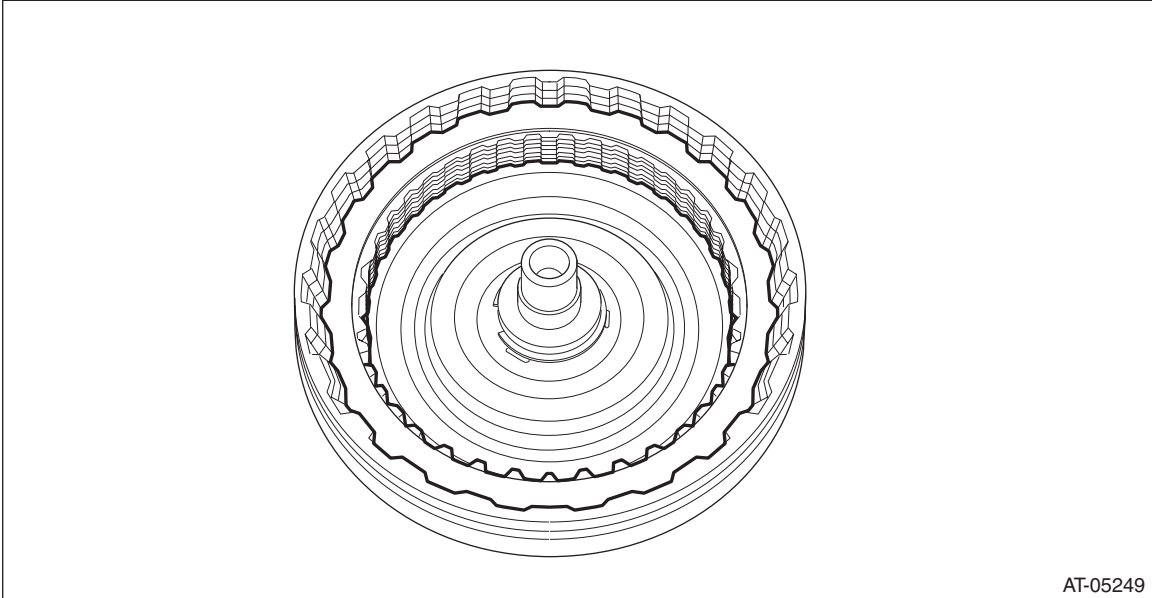
8) Remove the snap ring.



# Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

9) Remove the retaining plate, drive plate, driven plate and dish plate.

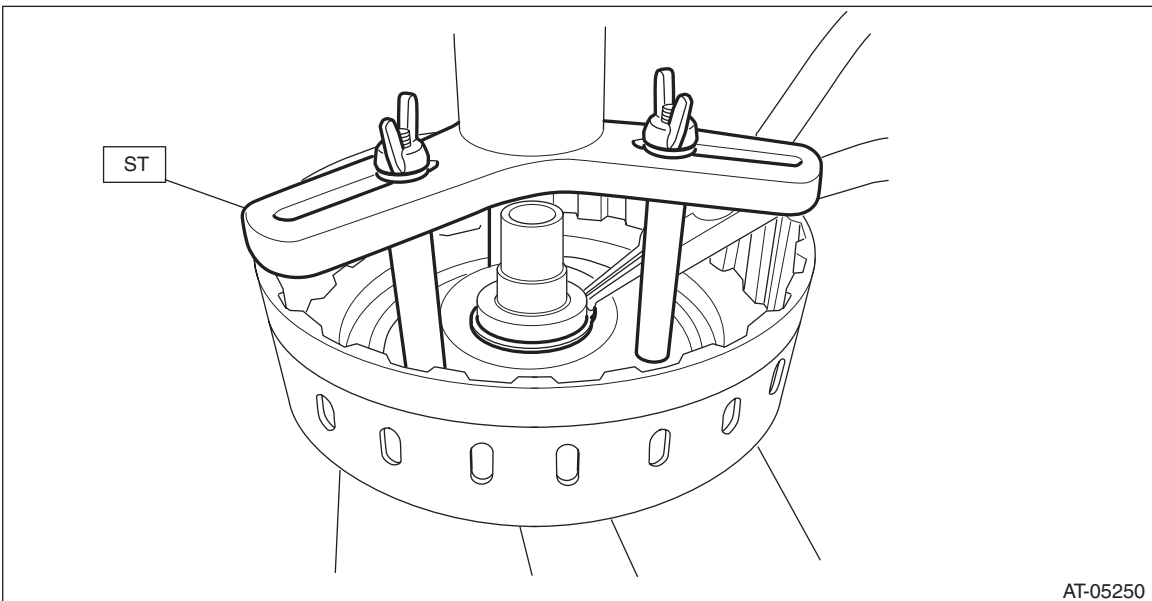


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10) Using the ST, remove the snap ring.

ST 18762AA000 or 18762AA001

COMPRESSOR SPECIAL TOOL



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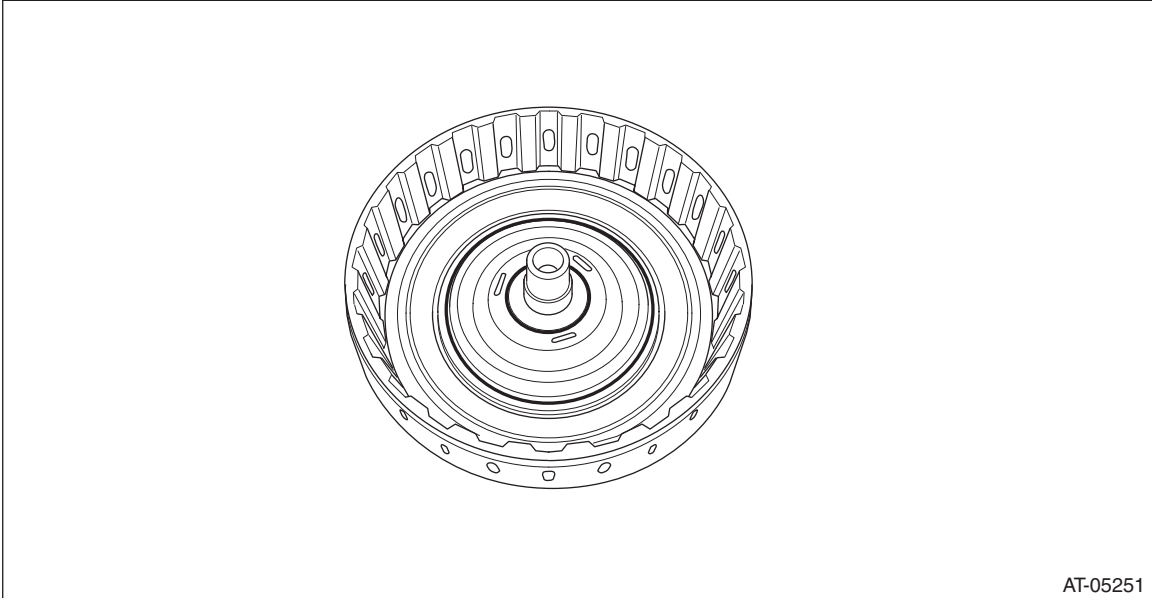


## Forward Clutch Assembly

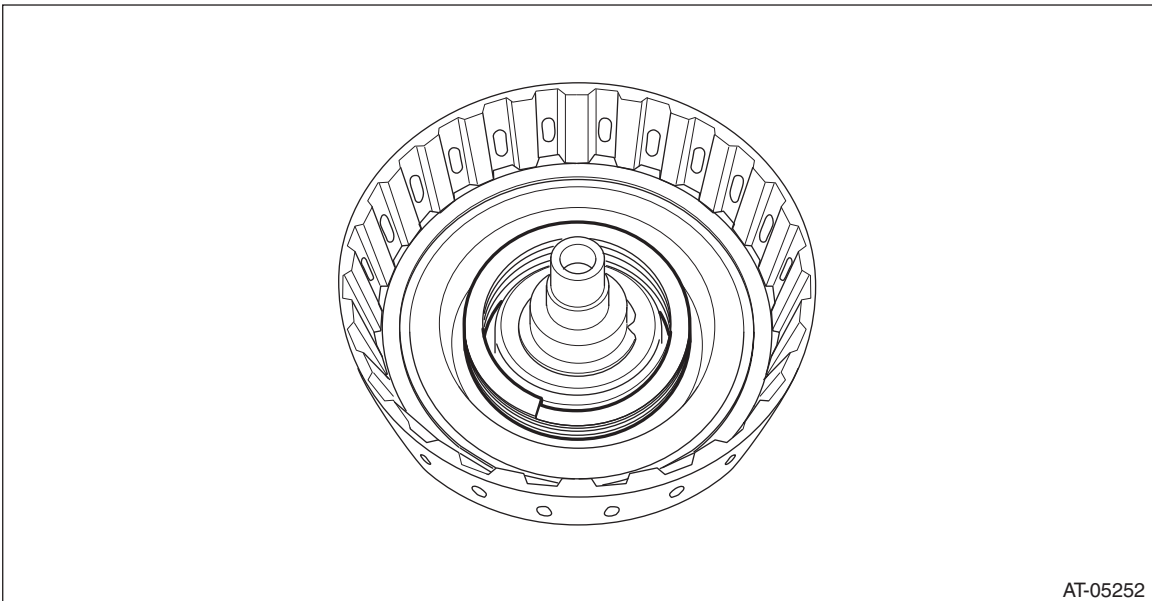
### CONTINUOUSLY VARIABLE TRANSMISSION

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11) Remove the forward clutch piston retainer.



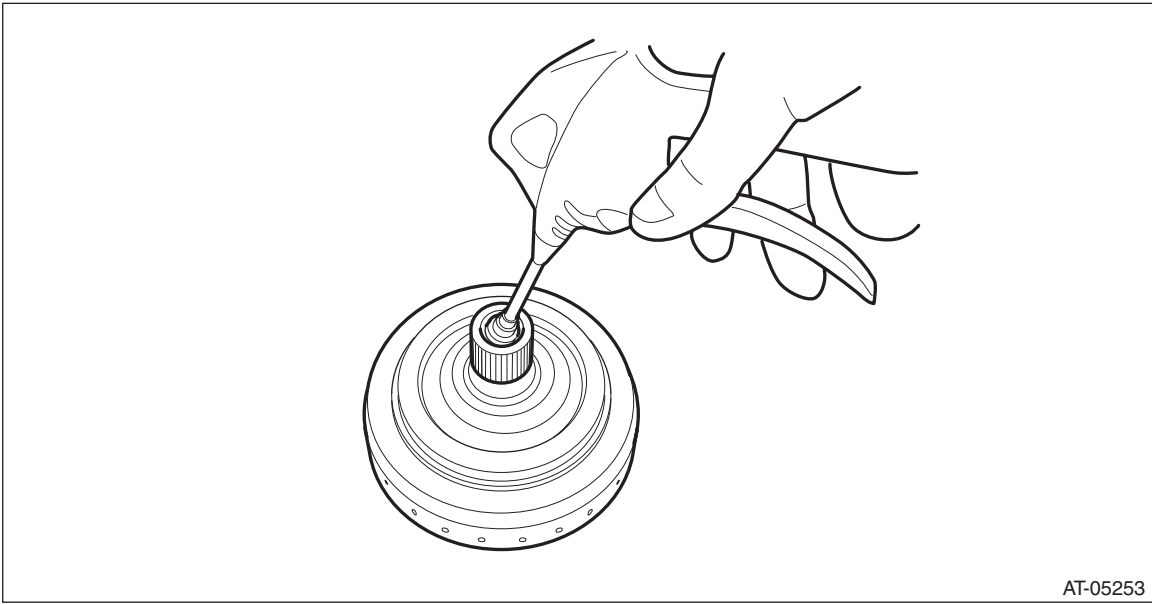
12) Remove the return spring.



## Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

13) Remove the forward clutch piston by blowing compressed air intermittently from end of forward clutch drum.

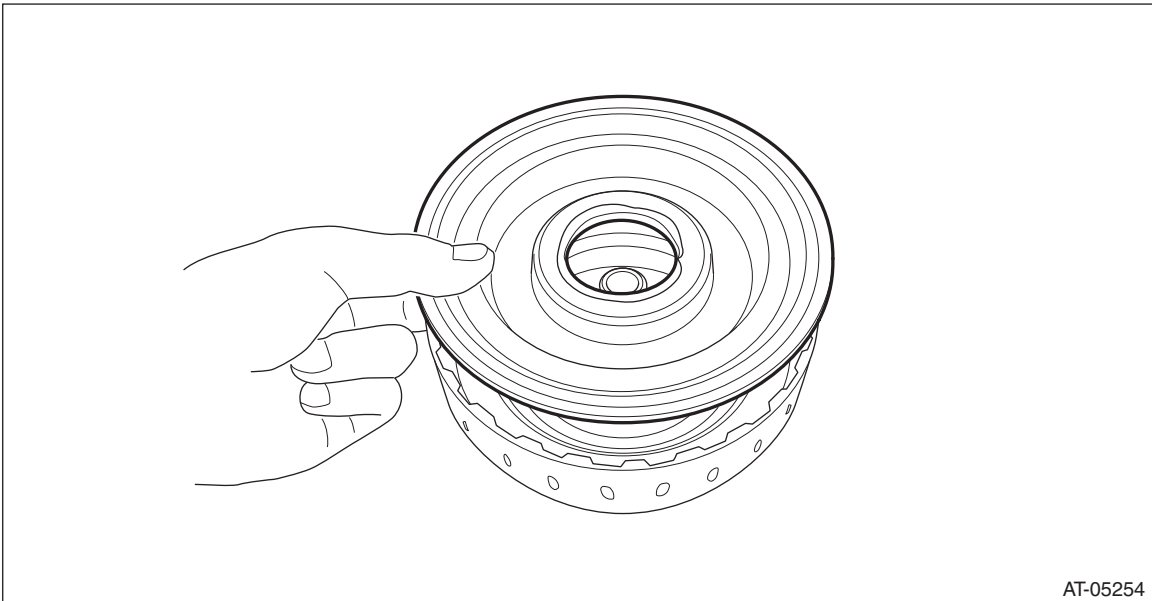


### D: ASSEMBLY

1) Install the forward clutch piston to forward clutch drum.

NOTE:

- Apply CVTF to the seal of forward clutch piston.
- Insert it all the way to the end.

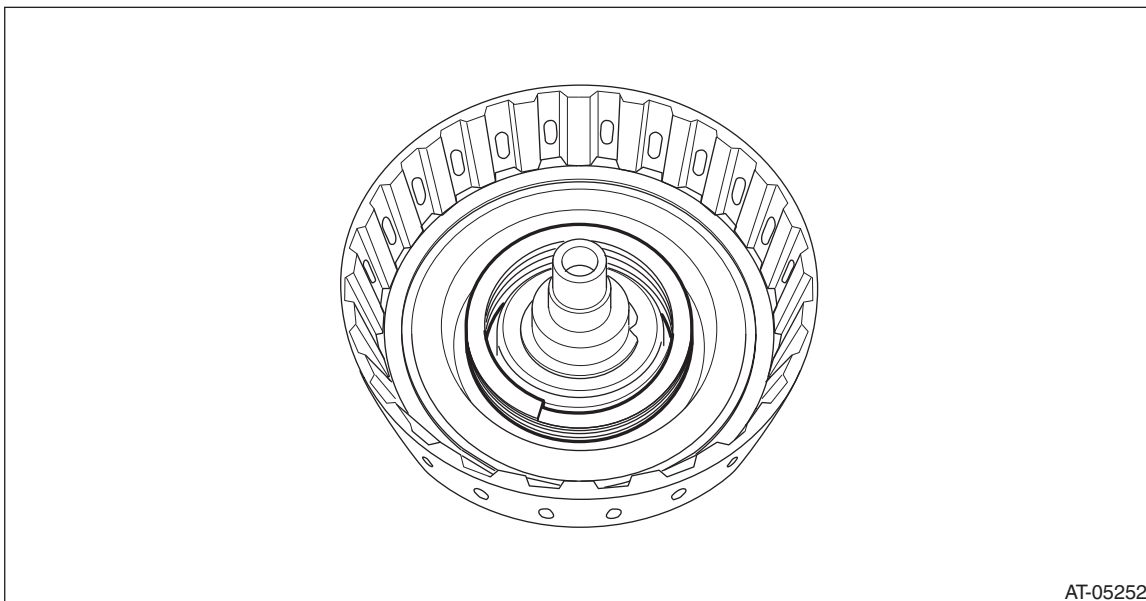


## Forward Clutch Assembly

### CONTINUOUSLY VARIABLE TRANSMISSION

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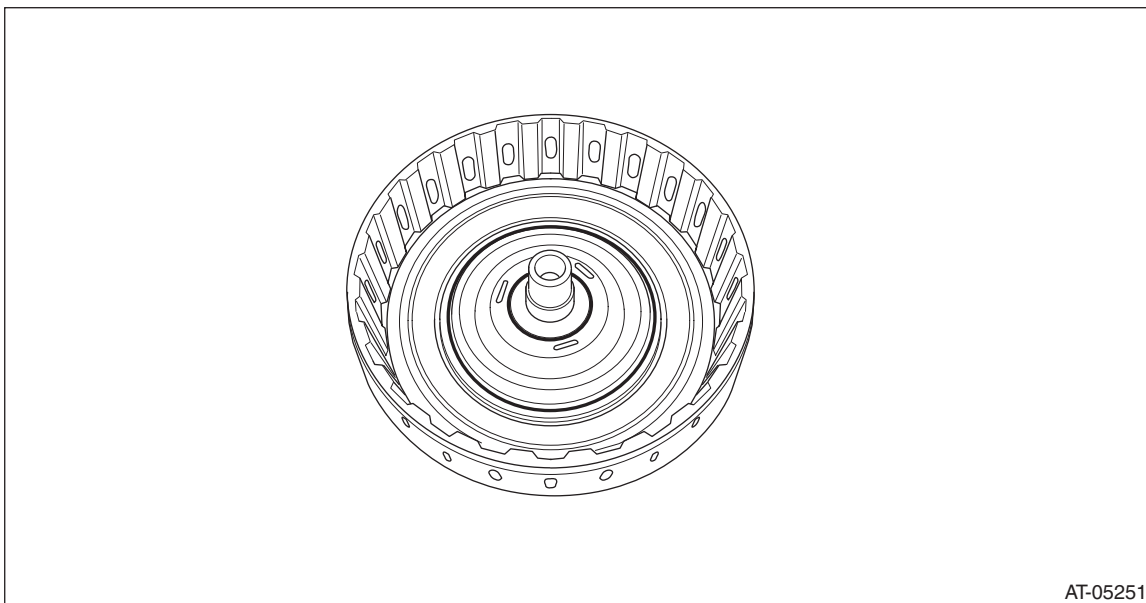
2) Install the return spring.



3) Install the forward clutch piston retainer.

NOTE:

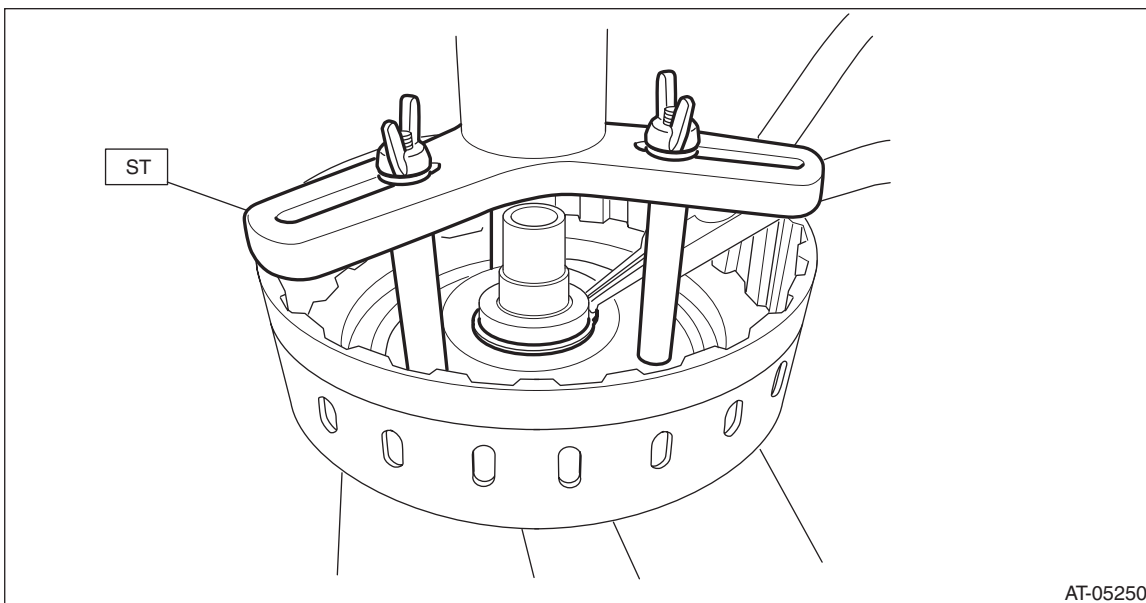
Apply CVTF to the sealing area of forward clutch piston retainer.



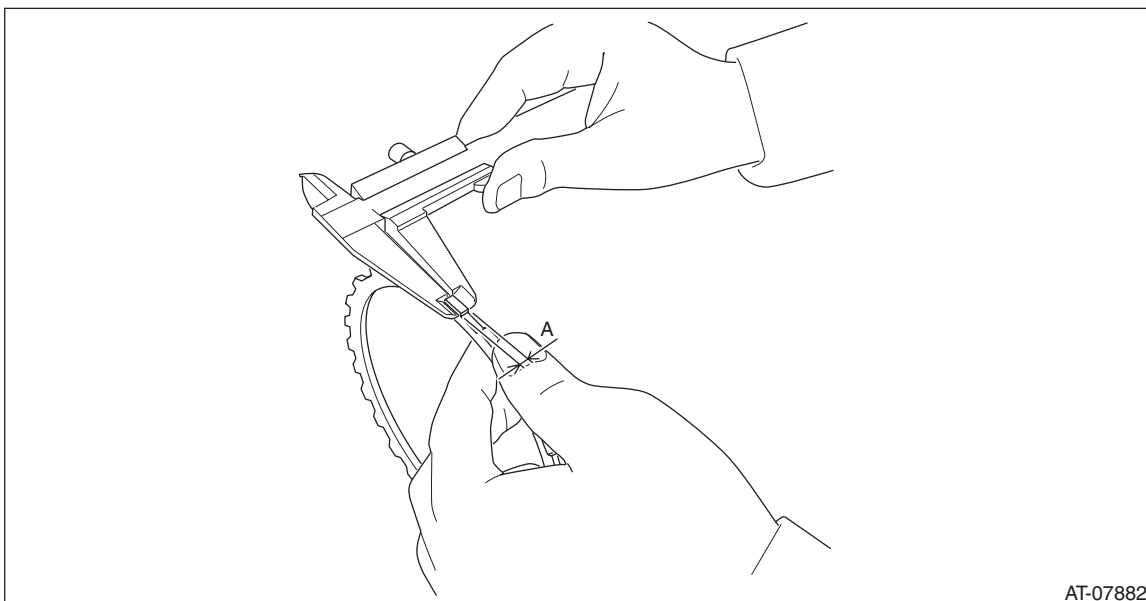
## Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

- 4) Compress the return spring using the ST to install the snap ring.  
ST 18762AA000 or 18762AA001 COMPRESSOR SPECIAL TOOL



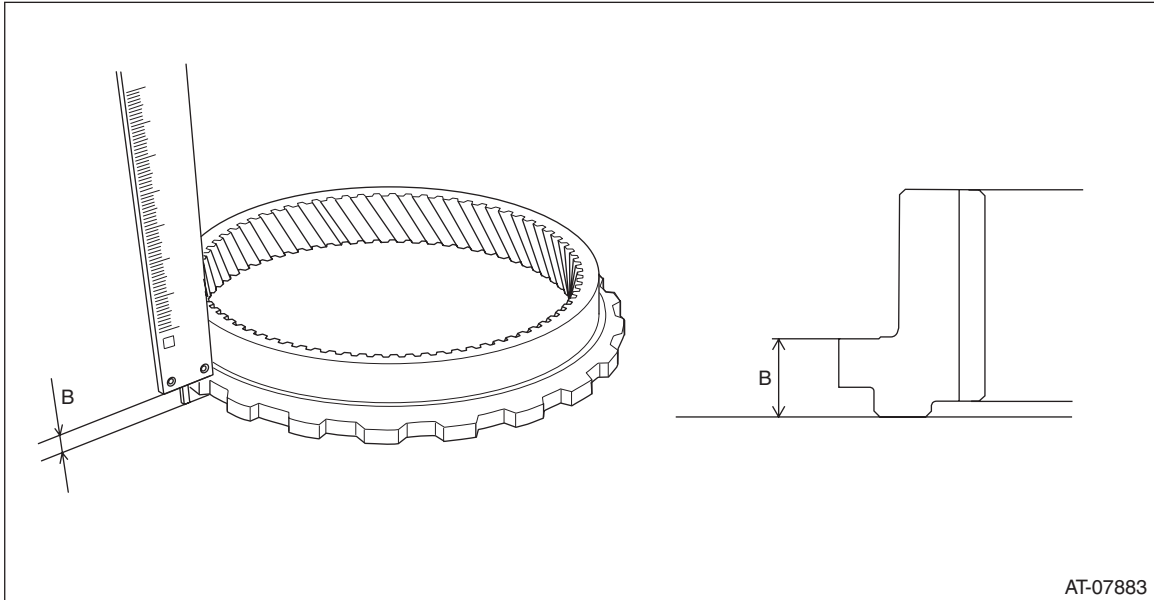
- 5) Measure thickness "A" of the retaining plate installed.



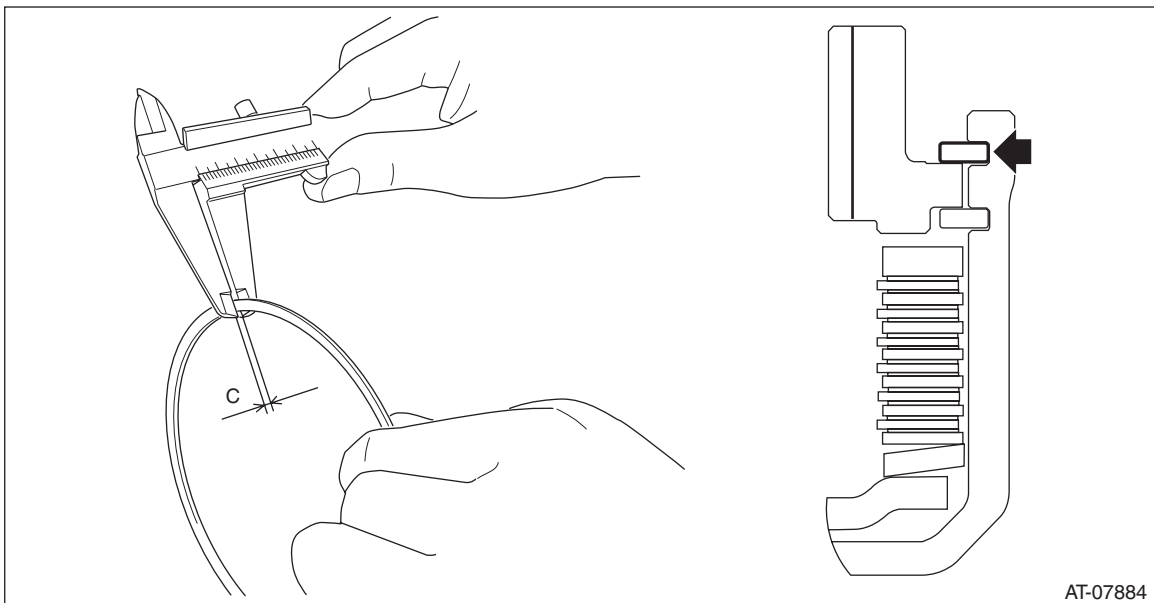
# Forward Clutch Assembly

## CONTINUOUSLY VARIABLE TRANSMISSION

6) Measure thickness “B” of the internal gear on a surface plate.



7) Measure thickness “C” of labelled or marked snap ring.

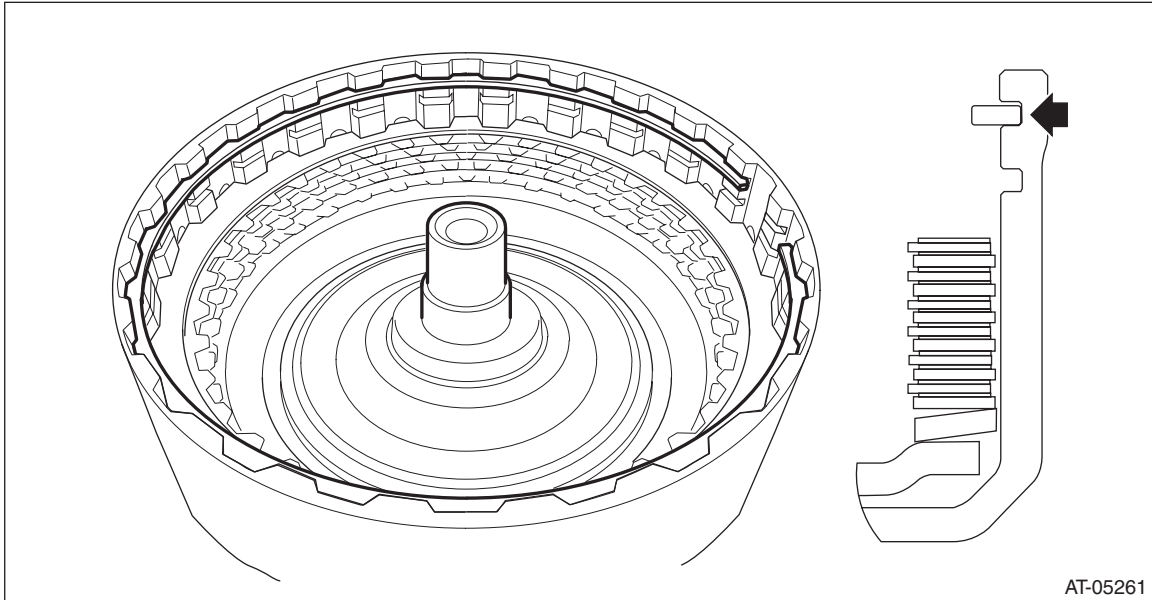


8) Install the dish plate, drive plate and driven plate.

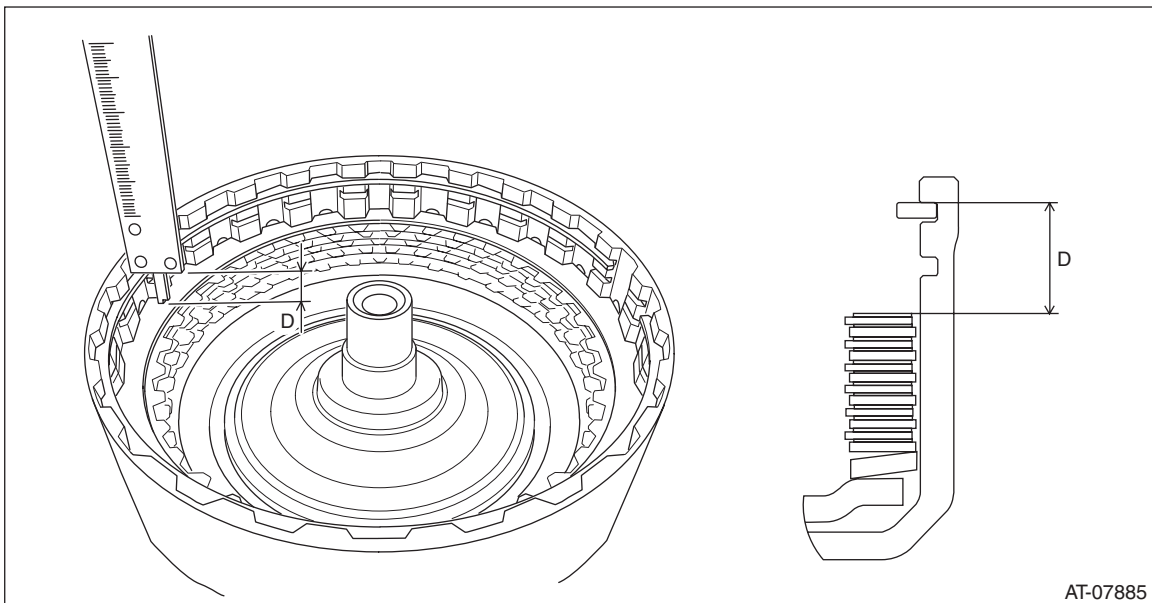
# Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

9) Install the snap ring at the location (upper groove) indicated in the figure.



10) Measure depth "D" of snap ring and driven plate while lifting the snap ring.

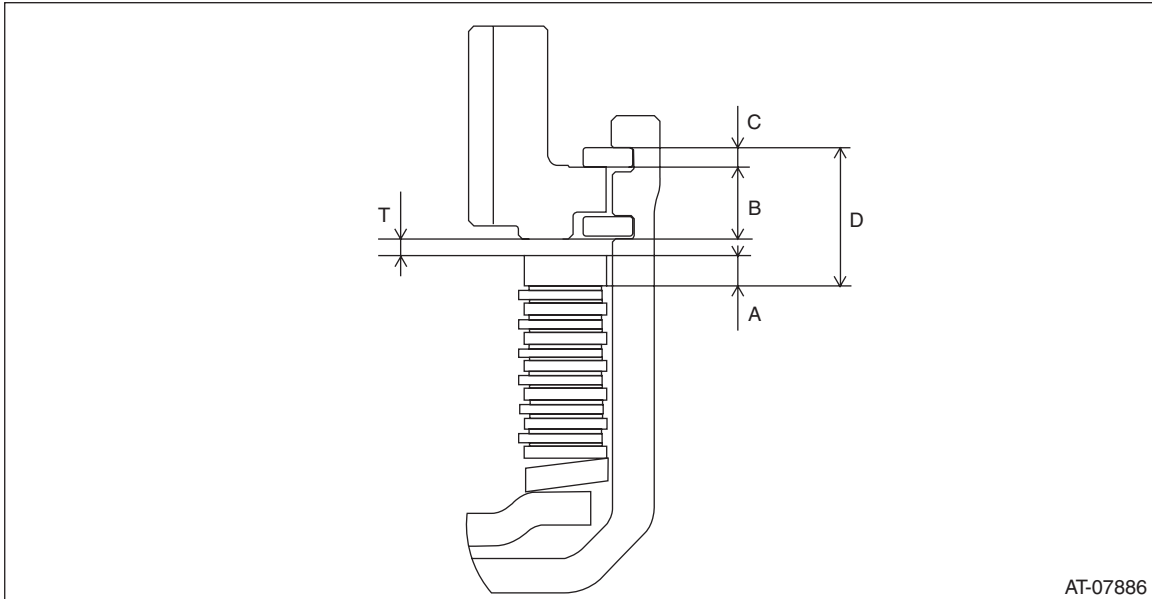


# Forward Clutch Assembly

## CONTINUOUSLY VARIABLE TRANSMISSION

11) Calculate clearance “T” from internal gear to retaining plate with the obtained value from step 5) through step 10).

Formula:  $T \text{ mm (in)} = D - A - B - C$



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12) If the value “T” obtained from step 11) exceeds the limit for use, replace the drive plate and driven plate with new parts and select the retaining plate within the initial standard value.

**Initial standard:**

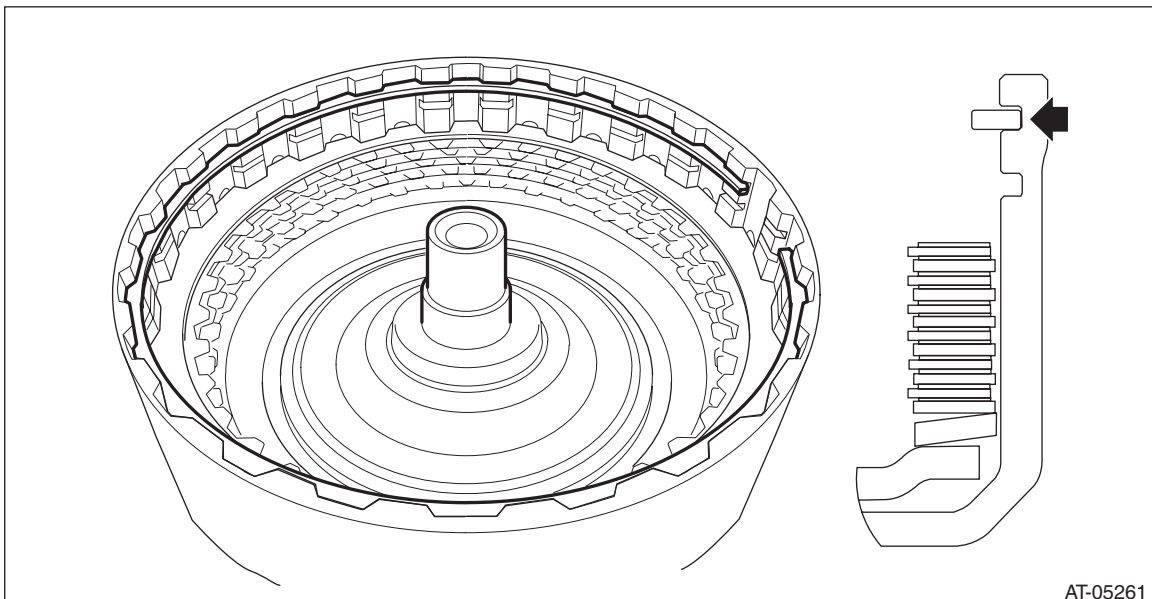
**1.2 — 1.6 mm (0.047 — 0.063 in)**

**Limit thickness:**

**2.4 mm (0.09 in)**

Retaining plate	
Item number	Thickness mm (in)
31567AB670	3.2 (0.126)
31567AB660	3.0 (0.118)
31567AB650	2.8 (0.110)
31567AB640	2.6 (0.102)

13) Remove the snap ring.

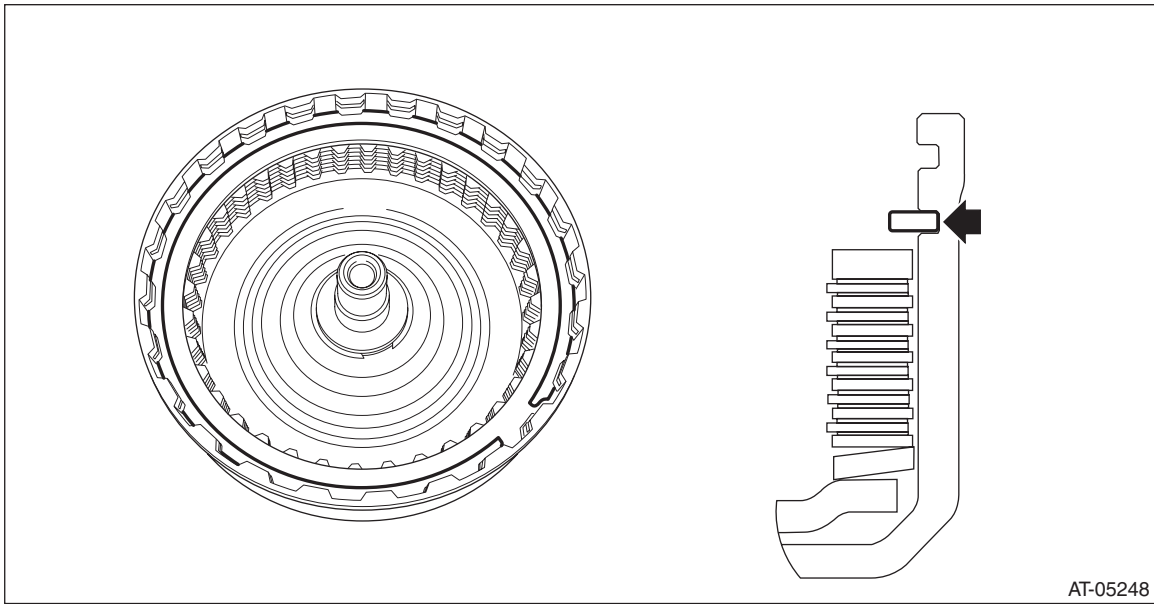


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## Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

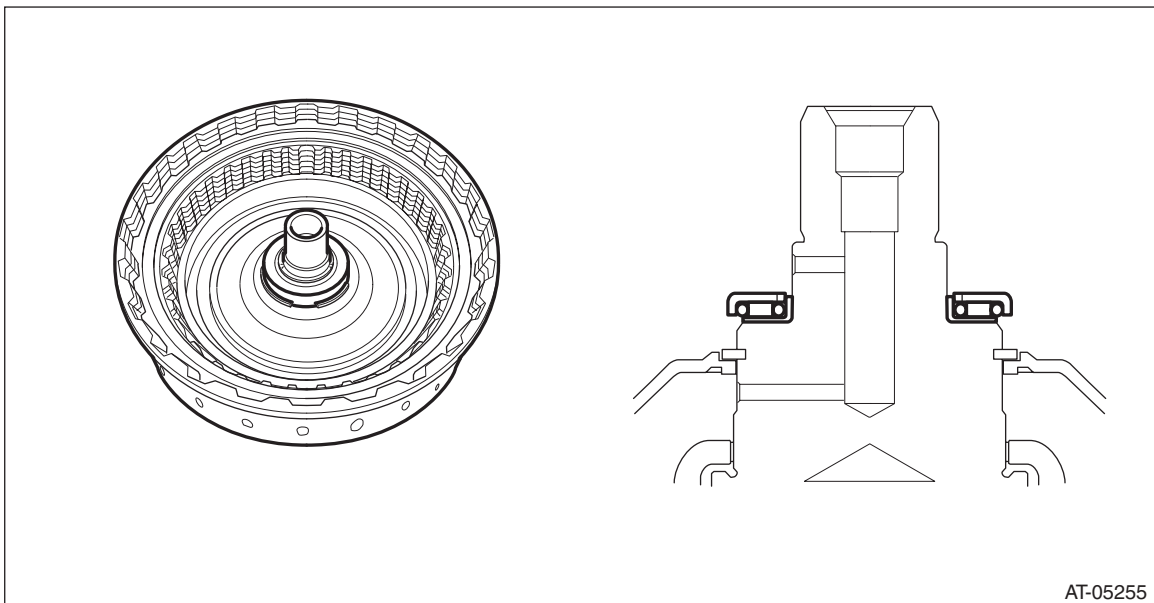
- 14) Replace with the selected retaining plate to install.
- 15) Install the snap ring to the lower groove.



- 16) Install the thrust needle bearing.

**NOTE:**

Install the thrust needle bearing in the correct direction.



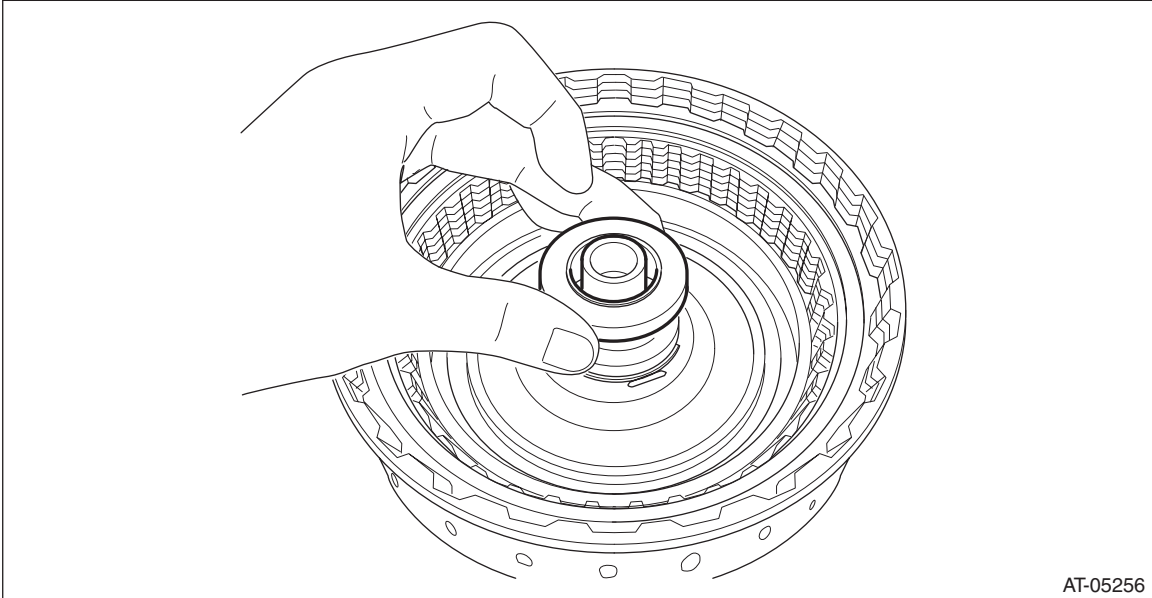


## Forward Clutch Assembly

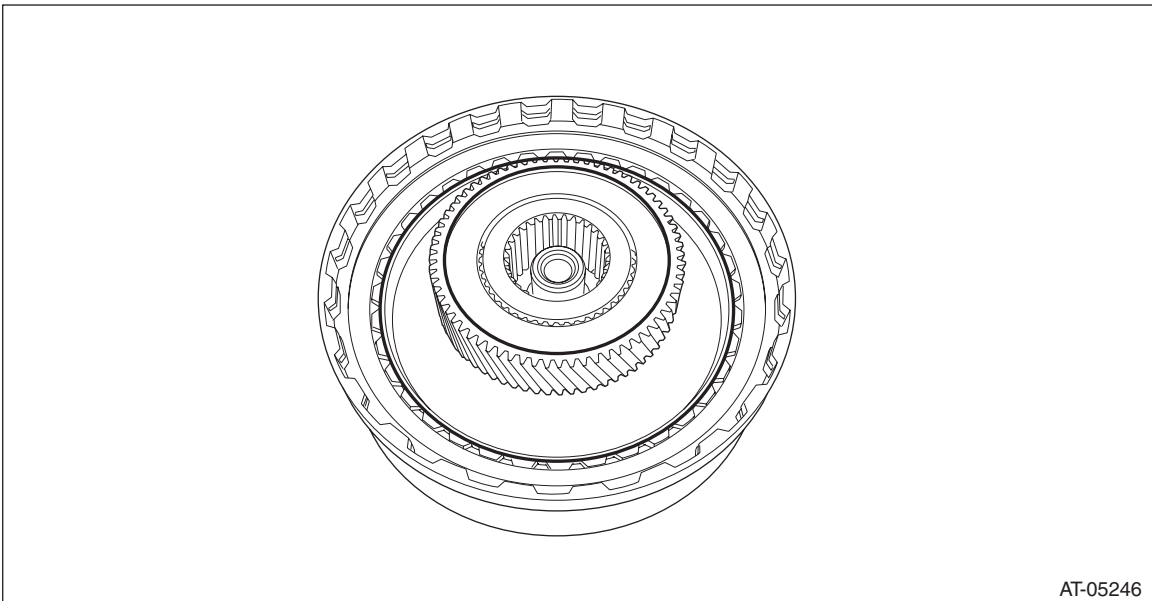
### CONTINUOUSLY VARIABLE TRANSMISSION

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17) Install the washer.



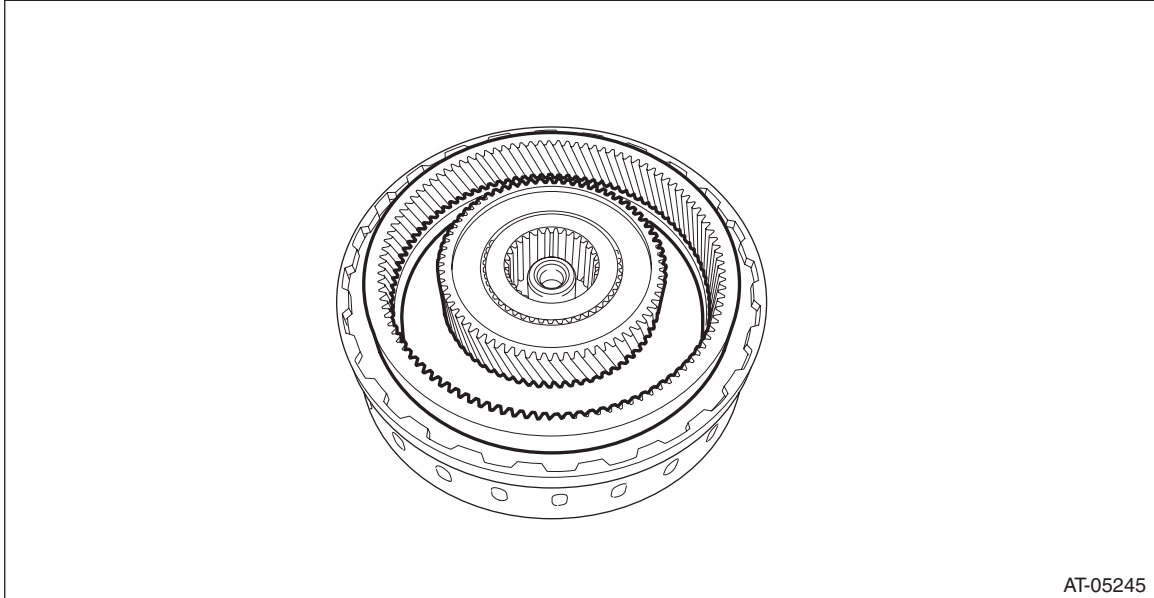
18) Install the sun gear.



# Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

19) Install the internal gear.

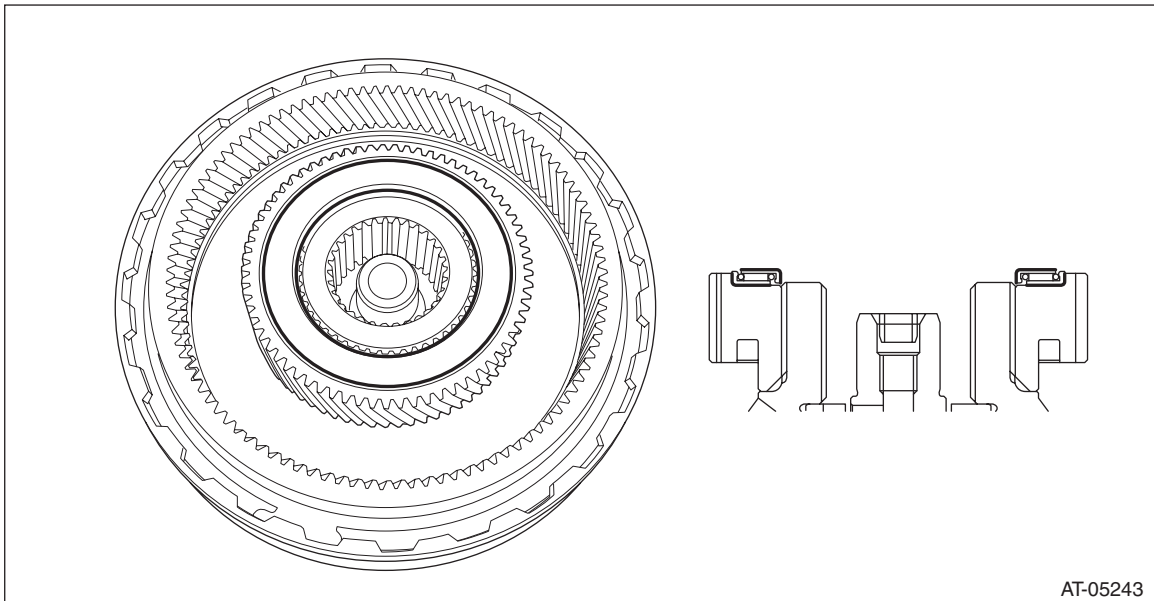


20) Install the snap ring.

21) Install the thrust needle bearing.

NOTE:

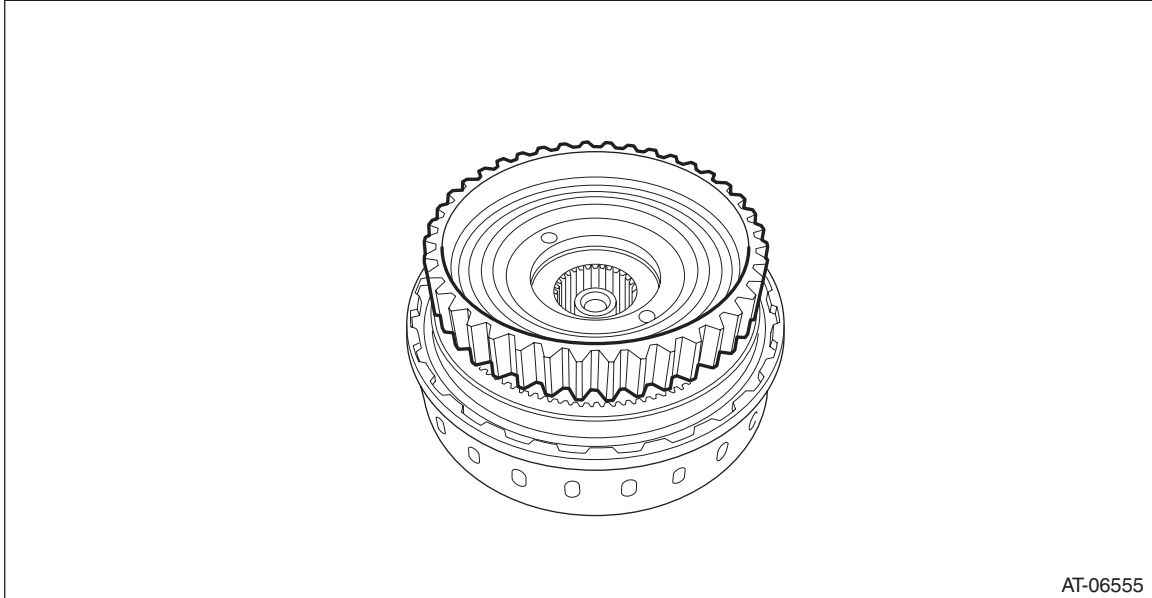
Make sure to install in the right direction.



# Forward Clutch Assembly

## CONTINUOUSLY VARIABLE TRANSMISSION

22) Install the planetary carrier assembly.



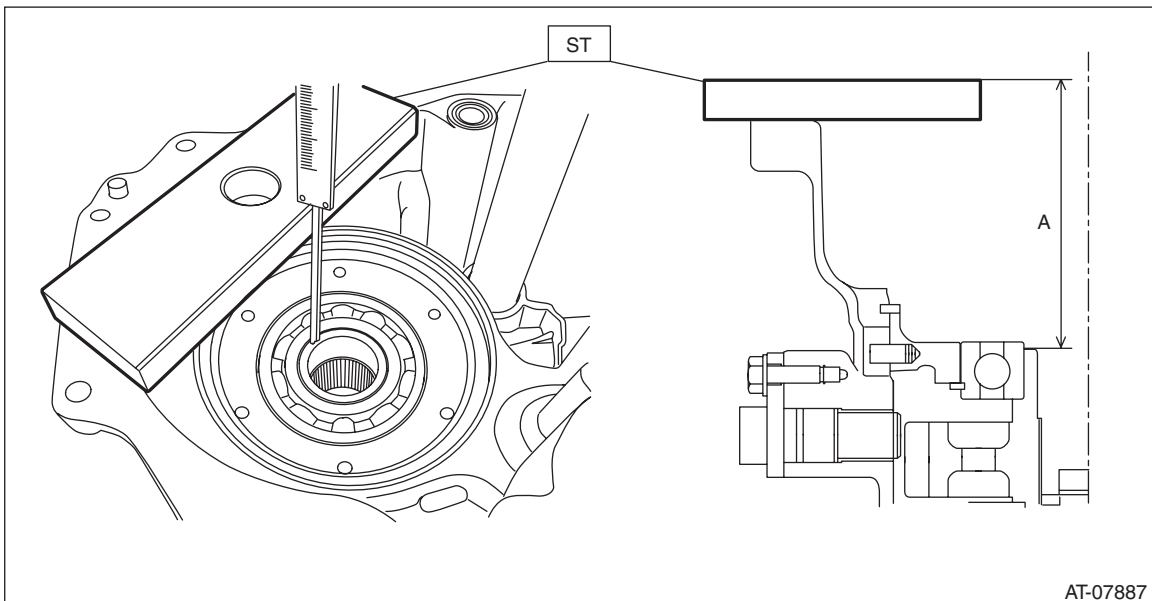
### E: INSPECTION

- Check the forward clutch drum, internal gear, sun gear and forward clutch piston lip for wear or damage.
- Inspect the drive plate facing for wear and damage.
- Check the driven plate for discoloration (burnt color).
- Check for worn snap ring, fatigue or damaged return spring or deformed spring retainer.
- Make sure the clearance between retaining plate and internal gear of forward clutch is within the limit. If it exceeds the standard, replace the forward clutch assembly. <Ref. to CVT(TR690)-191, ASSEMBLY, Forward Clutch Assembly.>

### F: ADJUSTMENT

1) Measure depth "A" from the ST upper face to the washer catch surface.

ST 398643600 GAUGE

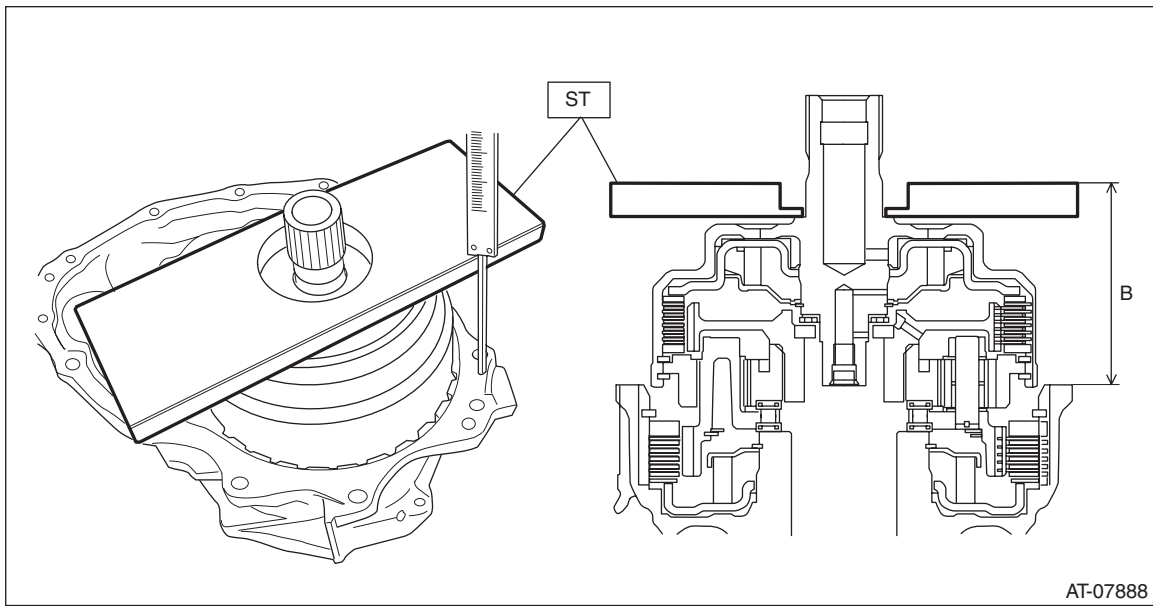


2) Install the forward clutch assembly to intermediate case.

# Forward Clutch Assembly

CONTINUOUSLY VARIABLE TRANSMISSION

- 3) Setting the ST, measure height “B” from the ST upper side to the intermediate case mating surface.  
ST 499575600 GAUGE



- 4) Obtain the thickness of washer using the following formula.

Calculation formula:

$$T \text{ (mm)} = (A - 15) - (B - 15) - (0.35 - 0.70)$$

$$[T \text{ (in)} = (A - 0.591) - (B - 0.591) - (0.014 - 0.028)]$$

T: Washer thickness

A: Depth from the ST upper face to the washer catch surface

B: Height from the upper surface of the ST to the mating surface of the intermediate case

15 mm (0.591 in): Thickness of ST

0.35 — 0.70 mm (0.014 — 0.028 in): Clearance

- 5) Select the washer to meet the value “T” obtained from step 4).

Washer	
Part No.	Washer thickness mm (in)
803034040	1.0 (0.039)
803034041	1.2 (0.047)
803034042	1.4 (0.055)
803034043	1.6 (0.063)