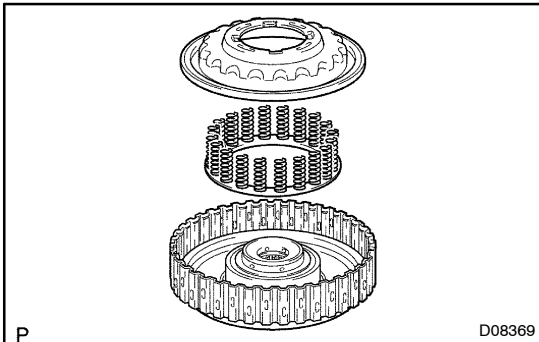


REASSEMBLY

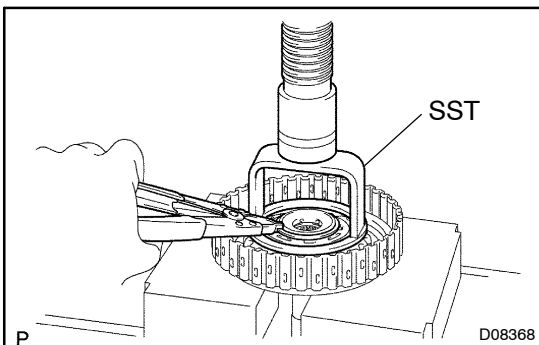
1. INSTALL FORWARD CLUTCH PISTON

- (a) Coat the forward clutch piston with ATF.
- (b) Install the forward clutch piston to the input shaft.



2. INSTALL PISTON RETURN SPRING

- (a) Place the piston return spring and clutch balancer onto the piston.



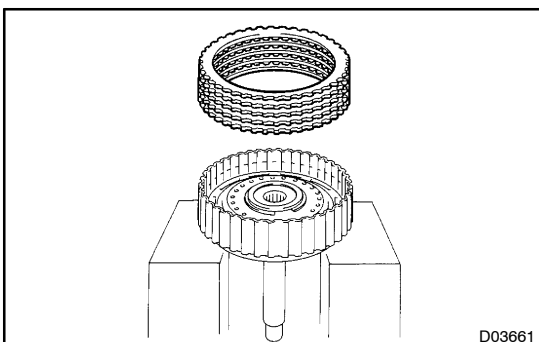
- (b) Place SST on the clutch balancer, and compress the return spring with a press.

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- (c) Install the snap ring with a snap ring expander. Be sure the end gap of the snap ring is not aligned with the spring retainer claw.

NOTICE:

- Stop the press when the spring sheet is lowered to the place 1 – 2 mm (0.039 – 0.078 in.) from the snap ring groove, preventing the snap sheet from the deforming.
- Do not expand the snap ring excessively.

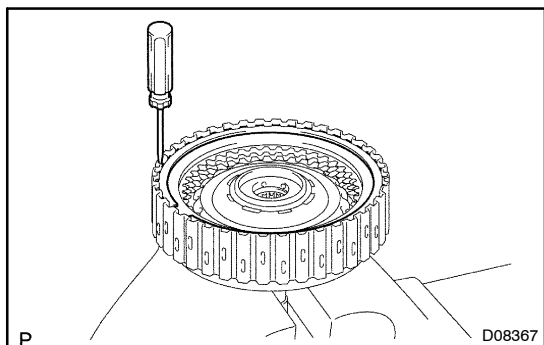


3. INSTALL PLATE, DISC AND FLANGE

Install the 4 plates, 4 discs and flange.

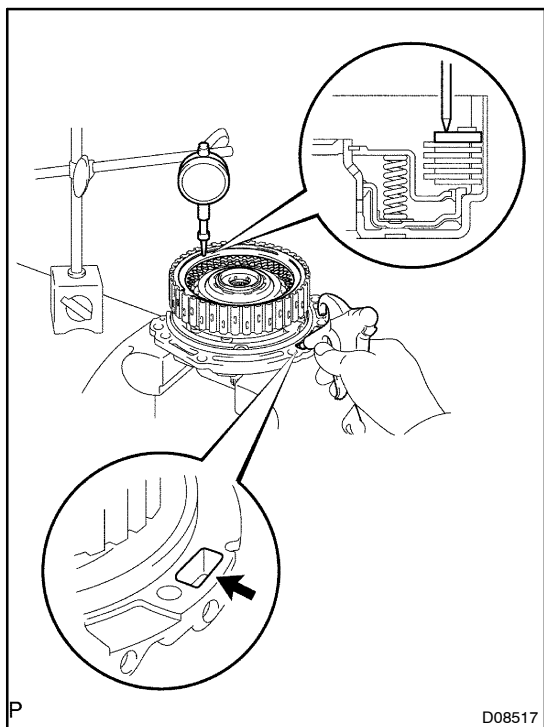
Install in order: P = Plate, D = Disc, F = Flange

P – D – P – D – P – D – P – D – F



4. INSTALL SNAP RING

Using a screwdriver, install the snap ring.



5. CHECK PACK CLEARANCE OF FORWARD CLUTCH

Using a dial indicator, measure the pack clearance while applying and releasing compressed air (392 kPa, 4.0 kgf/cm², 57 psi).

Pack clearance:

0.628 – 1.042 mm (0.02472 – 0.04102 in.)

If the piston stroke is less than the limit, parts may have been assembled incorrectly, check and reassemble again.

If the clearance is non-standard, select another flange.

HINT:

There are 5 different flanges in thickness.

Flange thickness: mm (in.)

No.	Thickness	No.	Thickness
1	3.00 (0.1181)	4	3.45 (0.1358)
2	3.15 (0.1240)	5	3.60 (0.1417)
3	3.30 (0.1300)	–	–