

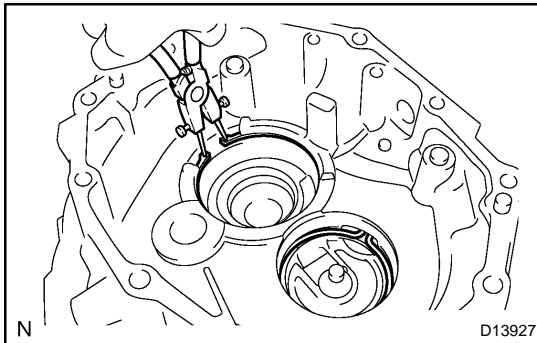
REASSEMBLY

1. REASSEMBLE FRONT CASE

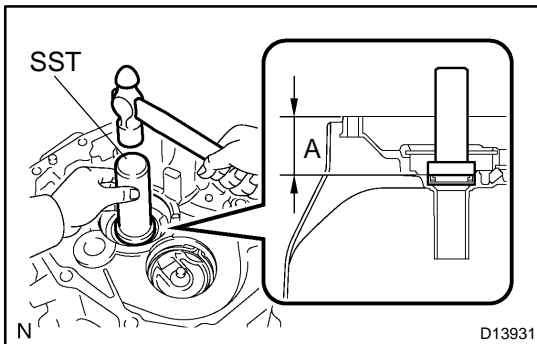
- (a) Install the oil receiver pipe to the front case.

HINT:

Make sure that the protruding part on the oil receiver pipe is fitted into the notch on the front case.



- (b) Using snap ring pliers, install the 2 snap rings.

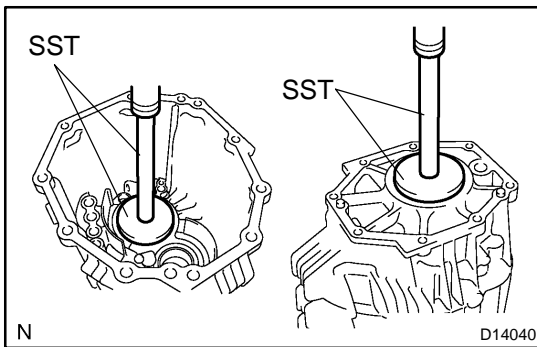


- (c) Using SST and a hammer, tap in a new oil seal to the clutch housing until dimension A falls within the specified range.

SST 09388-40010

Dimension A: 60.0 to 60.8 mm (2.362 to 2.394 in.)

- (d) Apply gear oil to the lip of the oil seal.

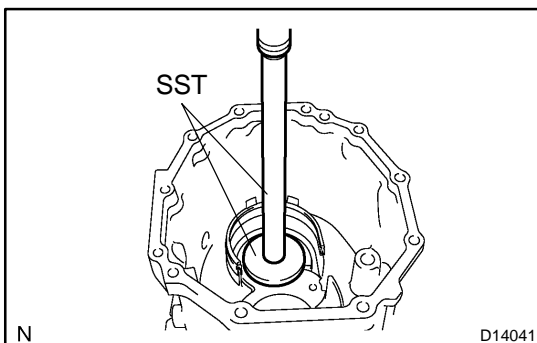


2. REASSEMBLE REAR CASE

- (a) Using SST and a press, press in 2 new bearing outer races.

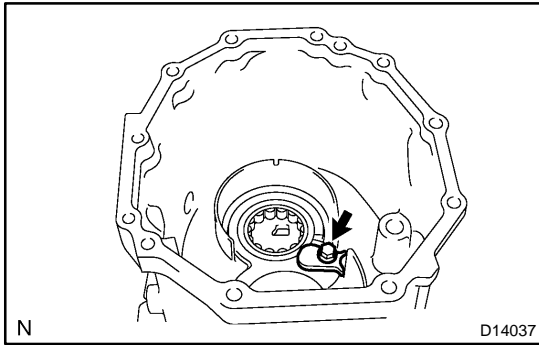
SST 09950-60020 (09951-00790, 09951-00850)

09950-70010 (09951-07100, 09951-07360)

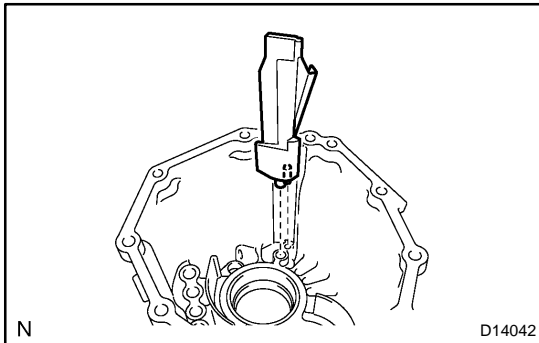


- (b) Using SST and a press, press in a new counter gear rear bearing.

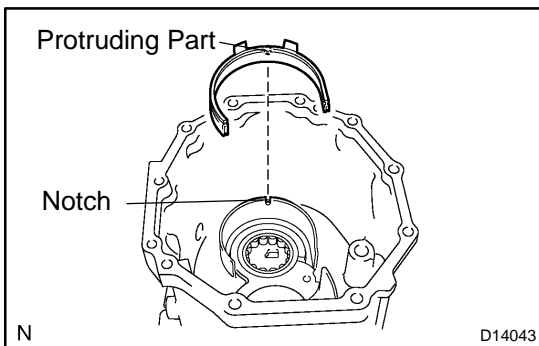
SST 09950-60010 (09951-00650), 09950-70010 (09951-07360)



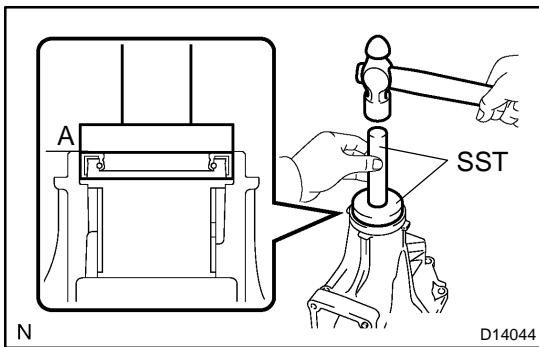
- (c) Install the bearing lock plate with the bolt.
Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)



- (d) Install the oil receiver pipe to the rear case.
HINT:
 Make sure that the protruding part on the oil receiver pipe is fitted into the hole on the rear case.

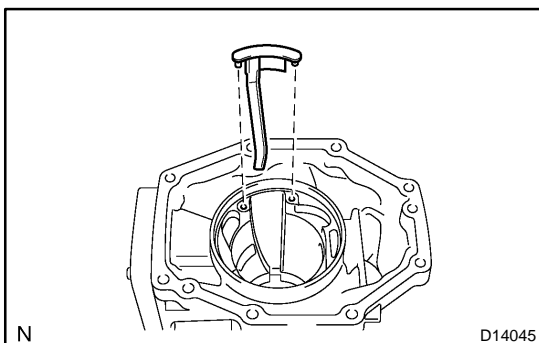


- (e) Install the transmission oil separator seal to the rear case.
HINT:
 Make sure that the protruding part on the transmission oil separator seal is fitted into the notch on the rear case.

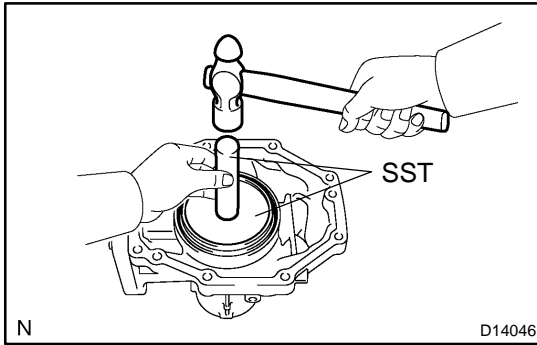


3. REASSEMBLE EXTENSION HOUSING

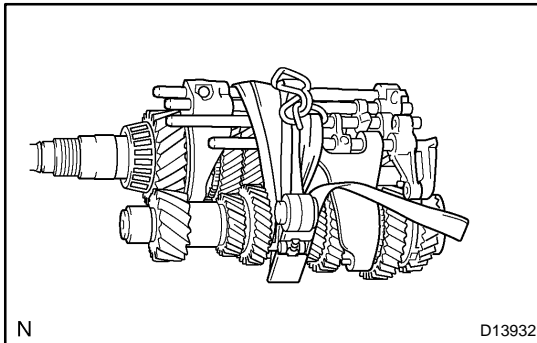
- (a) Using SST and a hammer, tap in a new oil seal to the extension housing until dimension A falls within the specified range.
 SST 09950-60020 (09951-00640), 09950-70010 (09951-07100)
Dimension A: -0.5 to 0.5 mm (-0.0197 to 0.0197 in.)
- (b) Apply gear oil to the lip of the oil seal.



- (c) Install the oil receiver pipe to the extension housing.
HINT:
 Make sure that the protruding parts on the oil receiver pipe is fitted into the holes on the extension housing.

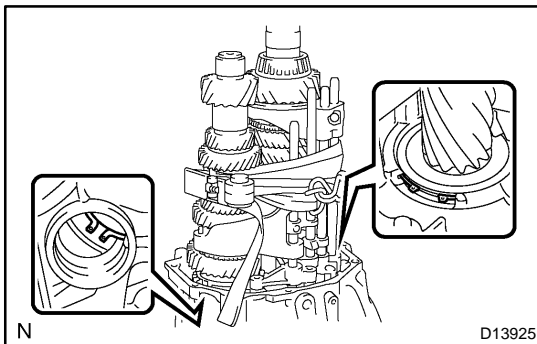


- (d) Using SST and a hammer, install a new oil separator.
SST 09255-10012, 09950-70010 (09951-07100)



4. INSTALL OUTPUT SHAFT, INPUT SHAFT, COUNTER GEAR SHAFT AND CONTROL SUB ASSEMBLY

- (a) Apply gear oil to the sliding surfaces and gear teeth.
(b) Temporarily assembly the output shaft, input shaft, counter gear shaft and control sub assembly, and bind them together with a belt, etc.

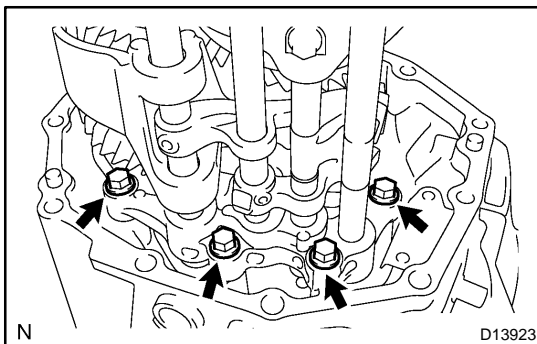


- (c) While expanding the 2 snap rings with snap ring pliers, install the output shaft, input shaft, counter gear shaft and control sub assembly.

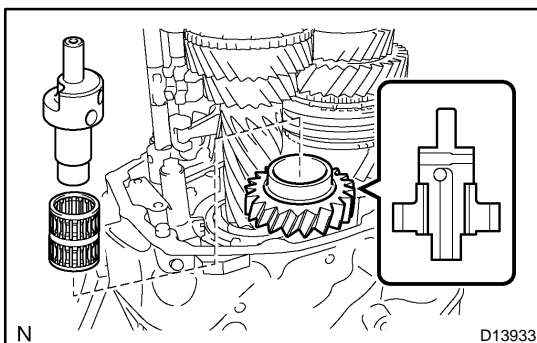
HINT:

Make sure that the snap rings are securely fitted into the grooves on the front bearings of the input shaft and counter gear shaft.

- (d) Remove the device binding the output shaft, input shaft, counter gear shaft and control sub assembly.



- (e) Install the 4 bolts to the control sub assembly.
Torque: 21 N·m (214 kgf·cm, 15 ft·lbf)

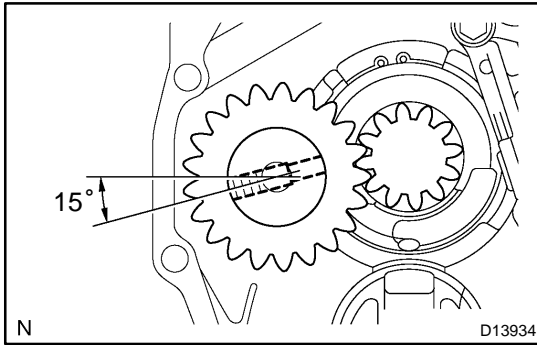


5. INSTALL REVERSE IDLER GEAR

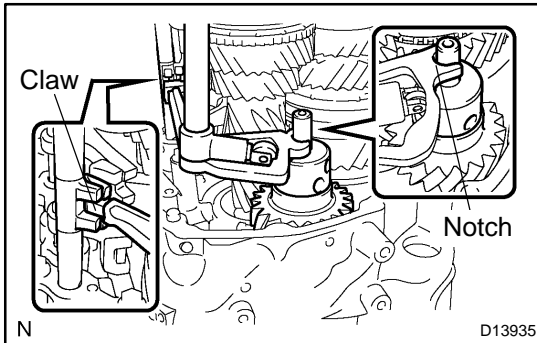
- (a) Install the reverse idler gear, needle roller bearing and reverse idler gear shaft.

HINT:

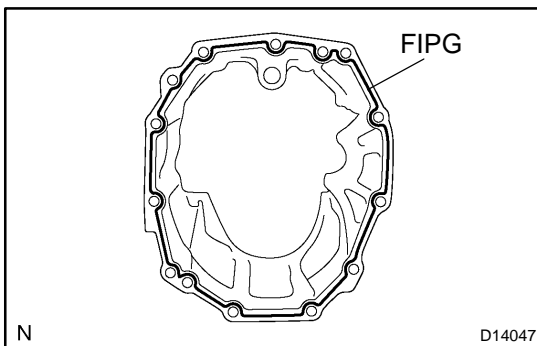
Make sure that the reverse idler gear is installed in the direction shown in the illustration.

**NOTICE:**

Make sure that the screw hole of the reverse idler shaft is positioned as shown in the illustration.

**6. INSTALL SHIFT & SELECT LEVER SHAFT**

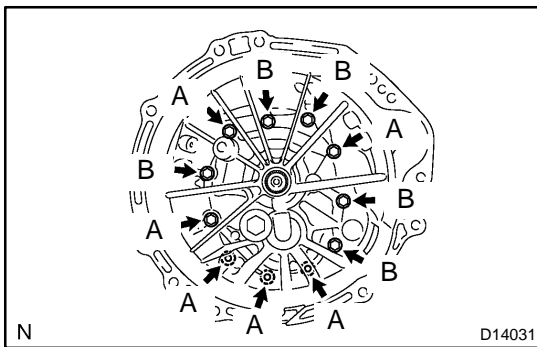
Fit the notch of the shift & select cam to the reverse idler gear shaft, and the claw to the gap on the control shaft assembly to install the shift & select lever shaft.

**7. INSTALL MIDDLE CASE**

- (a) Apply FIPG to the middle case as shown in the illustration.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent



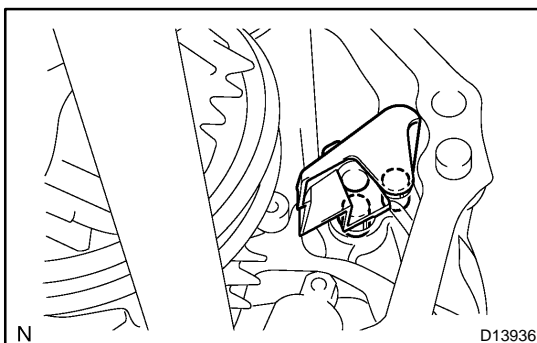
- (b) Install the middle case to the front case with the 11 bolts.

Torque: 40 N·m (408 kgf-cm, 30 ft-lbf)

Bolt length:

Bolt A: 40 mm (1.57 in.)

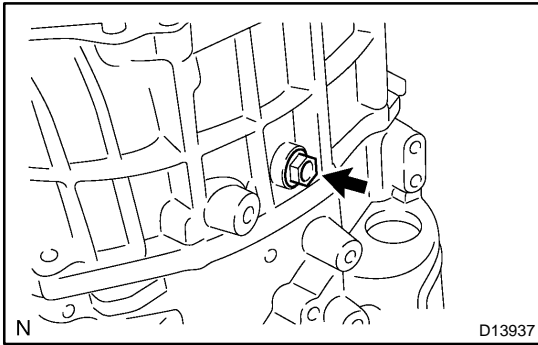
Bolt B: 80 mm (3.15 in.)



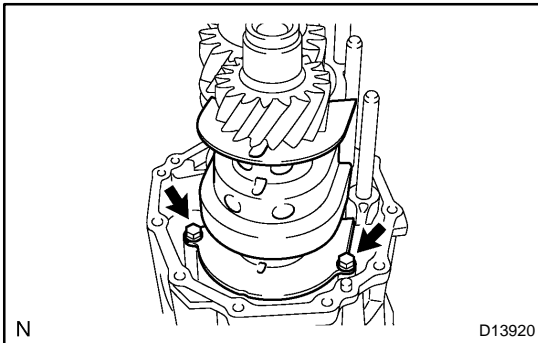
- (c) Install the oil receiver pipe to the middle case.

HINT:

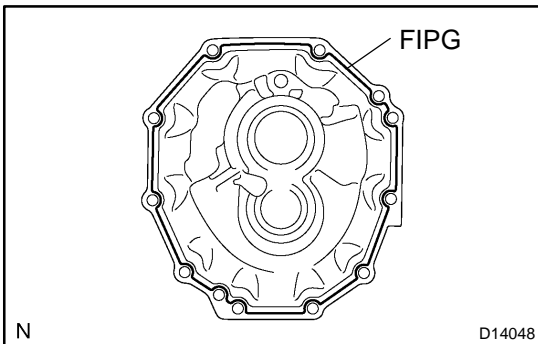
Make sure that the protruding parts on the receiver pipe are fitted into the holes on the middle case.



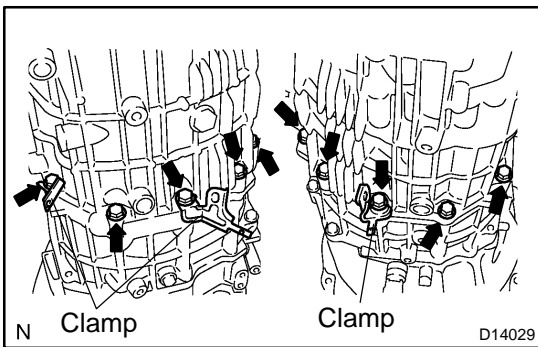
- 8. INSTALL REVERSE IDLER GEAR SHAFT BOLT**
 Install a new gasket and the reverse idler gear shaft bolt.
Torque: 28 N·m (286 kgf·cm, 21 ft·lbf)



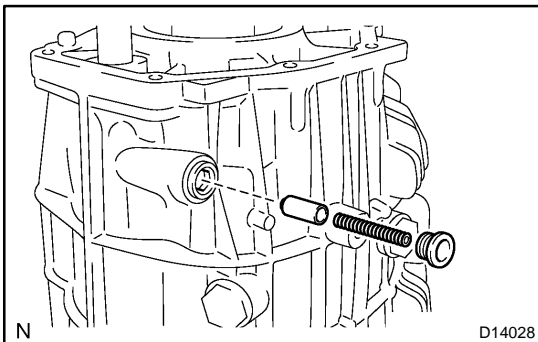
- 9. INSTALL TRANSMISSION OIL SEPARATOR**
 Install the transmission oil separator with the 2 bolts.
Torque: 8.5 N·m (87 kgf·cm, 75 in·lbf)



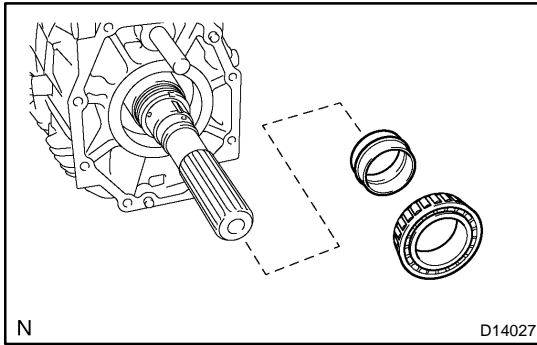
- 10. INSTALL REAR CASE**
 (a) Apply FIPG to the rear case as shown in the illustration.
FIPG:
Part No. 08826-00090, THREE BOND 1281 or equivalent



- (b) Install the rear case to the middle case with the 10 bolts and 3 clamps.
Torque: 40 N·m (408 kgf·cm, 30 ft·lbf)

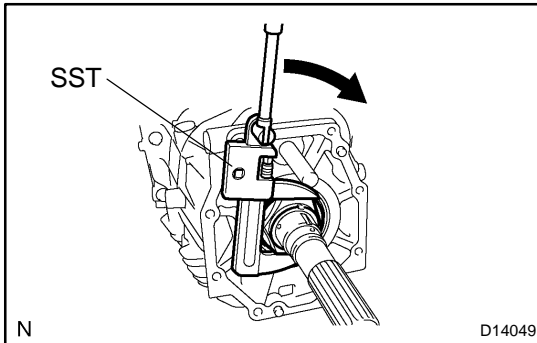


- (c) Install the lock ball pin, spring and a new plug.
Torque: 24.5 N·m (250 kgf·cm, 18 ft·lbf)



11. INSTALL OUTPUT SHAFT ADJUST NUT

- (a) Using a belt and wooden block, fasten the transmission to the work bench.
- (b) Install a new spacer and the output shaft taper roller bearing No.2.



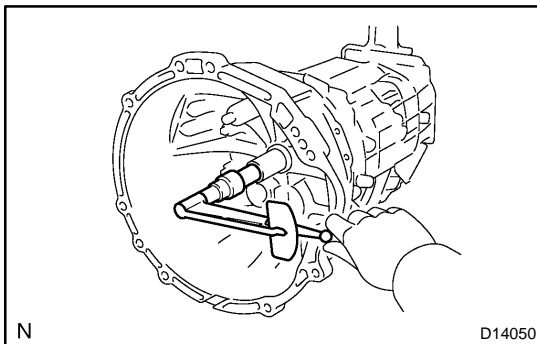
- (c) Using SST, temporarily tighten a new nut until the looseness in the output shaft is eliminated.

HINT:

Do not apply preload.

SST 09922-10010

- (d) Turn the output shaft 15 times to settle the bearing.



- (e) Shift to fifth gear, measure the starting torque and note it down.

- (f) Using SST, tighten the nut.

Torque:(Reference)

220 N·m (2,240 kgf·cm, 162 ft·lbf)

SST 09922-10010

- (g) Shift to fifth gear, measure the starting torque and note it down.

- (h) Make sure that the difference between the values measured at steps (e) and (g) is within the specified range.

Preload (at starting):

0.45 to 1.35 N·m

(4.59 to 13.77 kgf·cm, 3.98 to 11.95 in·lbf)

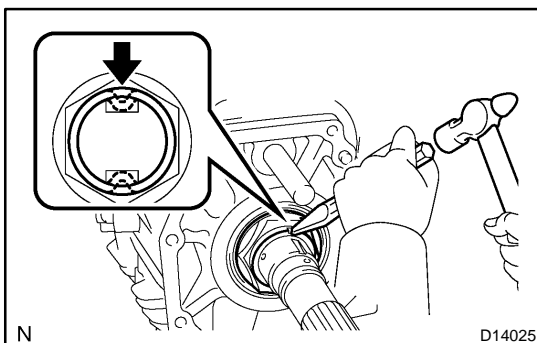
If the result is not as specified, tighten and adjust the output shaft adjust nut.

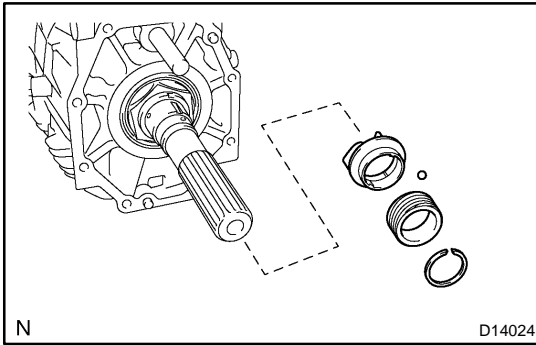
NOTICE:

Do not loosen or remove the output shaft adjust nut to adjust preload.

If the nut is loosened or removed, or if the preload exceeds the specified range, replace the spacer with a new one.

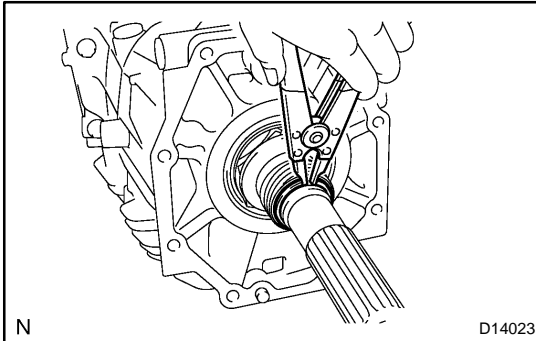
- (i) Using a chisel and hammer, stake the output shaft adjust nut.



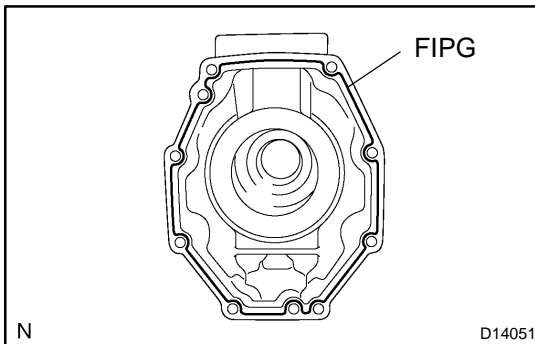


12. INSTALL SPEEDOMETER DRIVE GEAR

- (a) Install the oil receiver pipe, ball and speedometer drive gear.



- (b) Using a snap ring expander, install the snap ring.

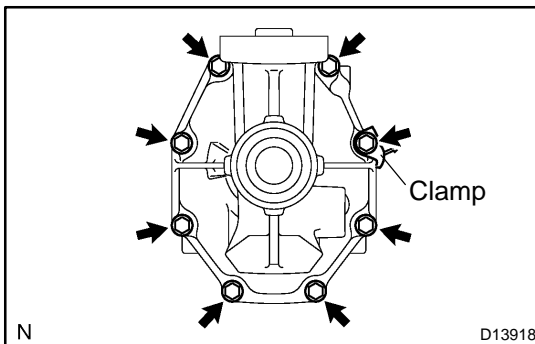


13. INSTALL EXTENSION HOUSING

- (a) Apply FIPG to the extension housing as shown in the illustration.

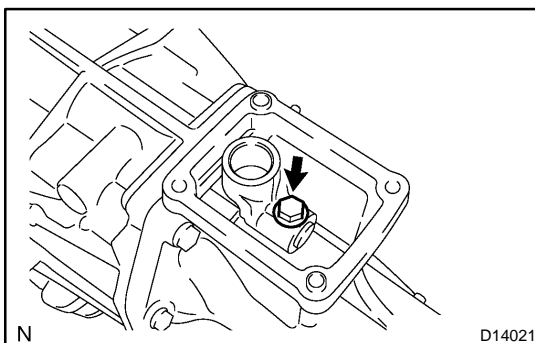
FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent



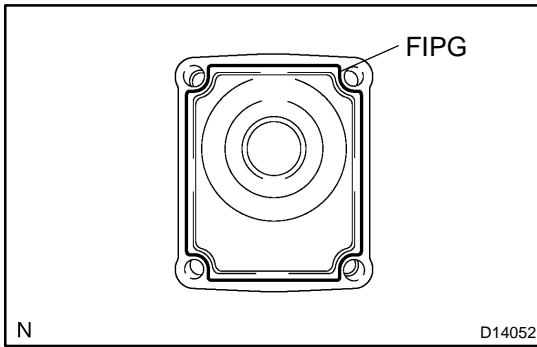
- (b) Install the extension housing and shift lever housing to the rear case with the 8 bolts and clamp.

Torque: 29 N·m (296 kgf-cm, 21 ft-lbf)



- (c) Install the bolt to the shift lever housing.

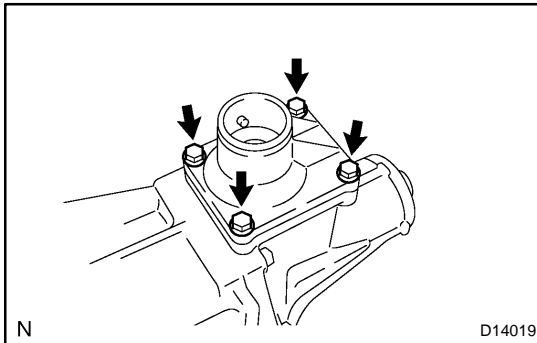
Torque: 33 N·m (340 kgf-cm, 25 ft-lbf)

**14. INSTALL CONTROL RETAINER**

- (a) Apply FIPG to the control retainer as shown in the illustration.

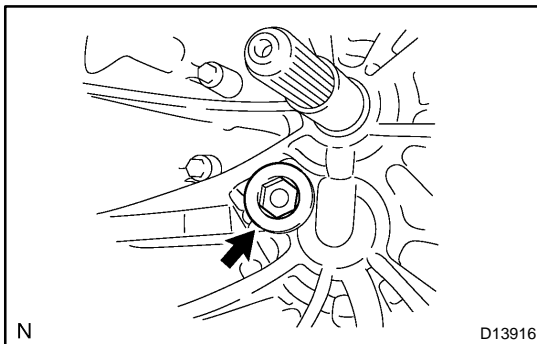
FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent



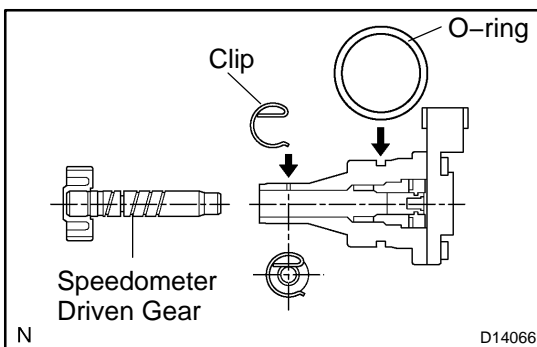
- (b) Install the control retainer to the extension housing with the 4 bolts.

Torque: 20 N·m (204 kgf-cm, 15 ft-lbf)

**15. INSTALL PLUG**

Install the plug to the clutch housing.

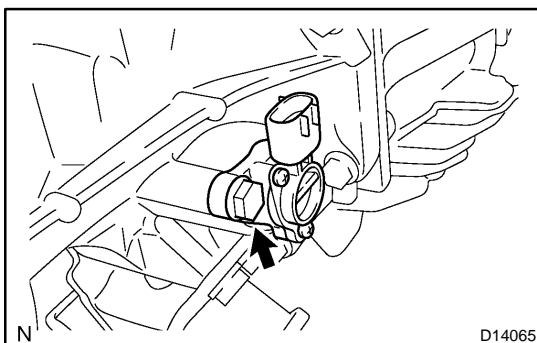
Torque: 39 N·m (397 kgf-cm, 29 ft-lbf)

**16. INSTALL SPEEDOMETER DRIVEN GEAR**

- (a) Install a new O-ring to the speedometer shaft sleeve.
(b) Install the speedometer driven gear to the speedometer sensor with the clip.

NOTICE:

Make sure to install the clip in the direction shown in the illustration.

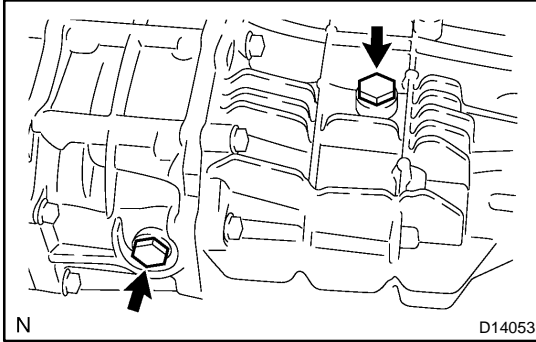


- (c) Install the speedometer sensor with the bolt.

Torque: 13 N·m (133 kgf-cm, 10 ft-lbf)

17. INSTALL EXTENSION HOUSING DEFLECTOR

Using a plastic hammer, install the deflector.

**18. INSTALL DRAIN PLUG**

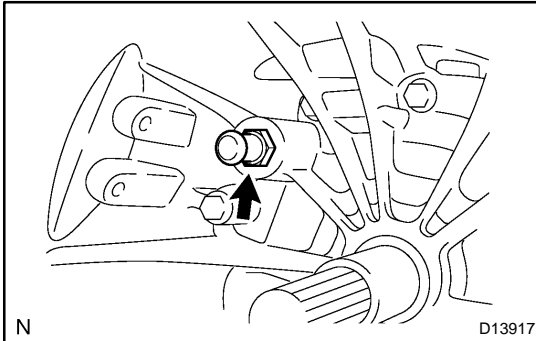
Install a new gasket and the drain plug.

Torque: 37 N·m (377 kgf-cm, 27 ft-lbf)

19. INSTALL FILLER PLUG

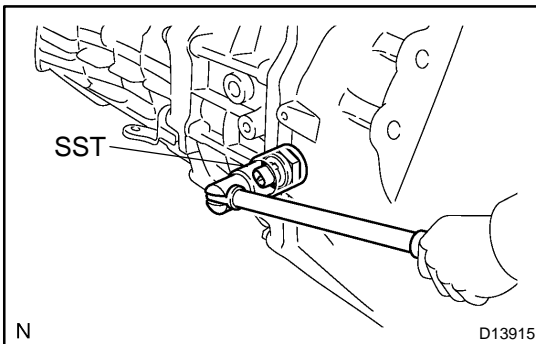
Install a new gasket and the filler plug.

Torque: 37 N·m (377 kgf-cm, 27 ft-lbf)

**20. INSTALL RELEASE FORK SUPPORT**

Install the release fork support to the clutch housing.

Torque: 47 N·m (480 kgf-cm, 35 ft-lbf)

**21. INSTALL BACK-UP LAMP SWITCH**

Using SST, install the back-up lamp switch.

SST 09817-16011

Torque: 44 N·m (449 kgf-cm, 32 ft-lbf)