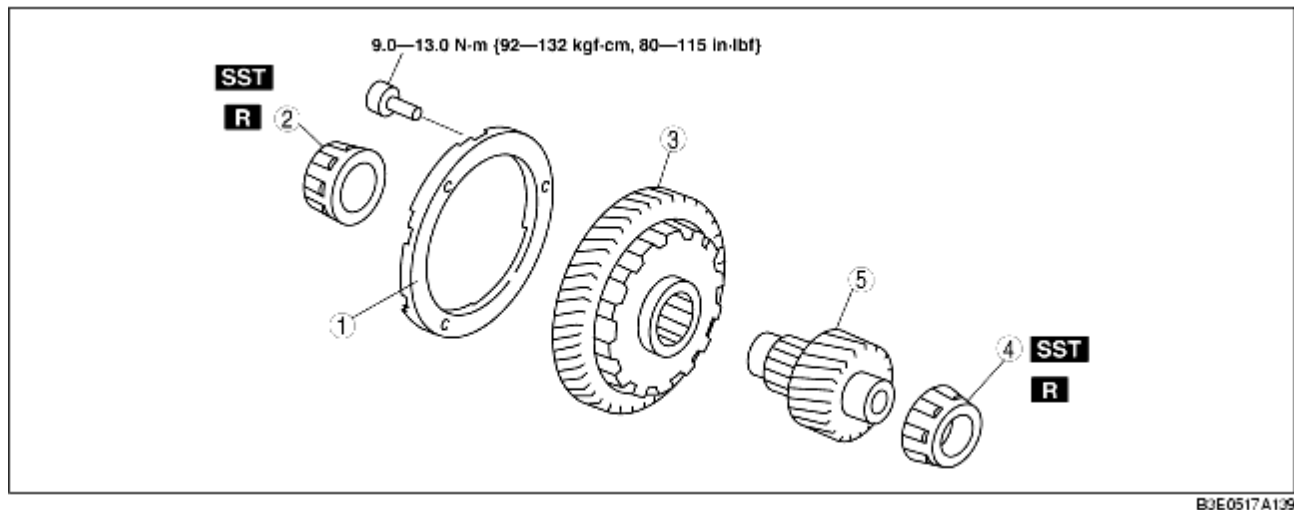


SECONDARY GEAR AND OUTPUT GEAR DISASSEMBLY/ASSEMBLY

B3E051719204A01

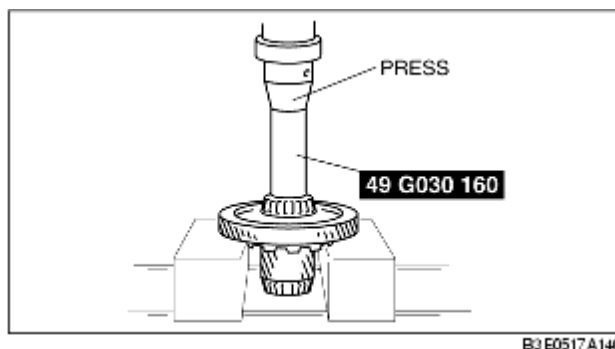
1. Disassemble in the order indicated in the table.
2. Assemble in the reverse order of disassembly.



1	Ring
2	Bearing (See Bearing Disassembly Note.)
3	Secondary gear
4	Bearing (See Bearing Disassembly Note.)
5	Output gear

Bearing Disassembly Note

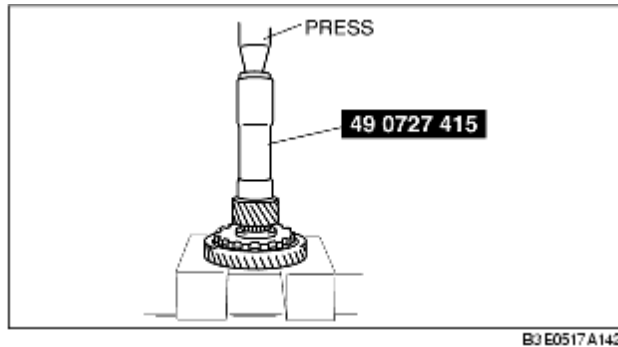
1. Remove the bearing (secondary gear side) from the output gear using the **SST**.



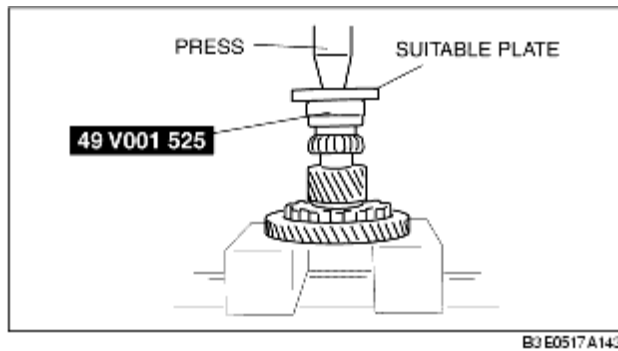
2. Remove the bearing (output gear side) from the output gear using the **SST**.

Assembly Procedure

1. Install the output gear to the secondary gear using the **SST**.



2. Install the bearing (output gear side) to the output gear using the **SST** and suitable plate.



3. Install the bearing (secondary gear side) to the output gear using **the SST** and suitable plate.

