

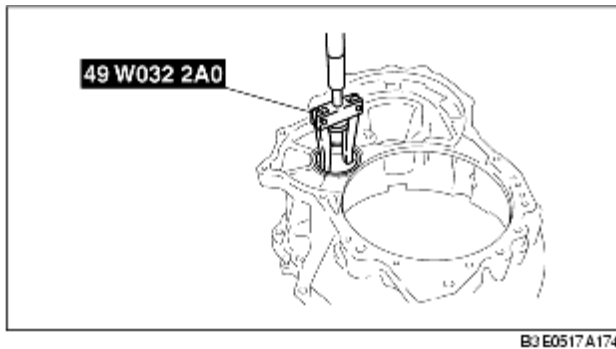
SECONDARY GEAR BEARING PRELOAD

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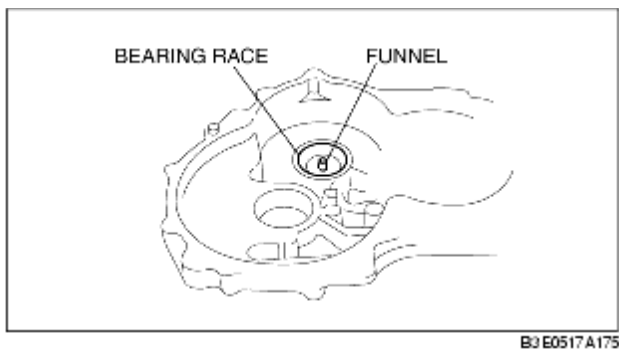
1. Set the primary gear into the transaxle case.

(See [AUTOMATIC TRANSAXLE ASSEMBLY](#).)

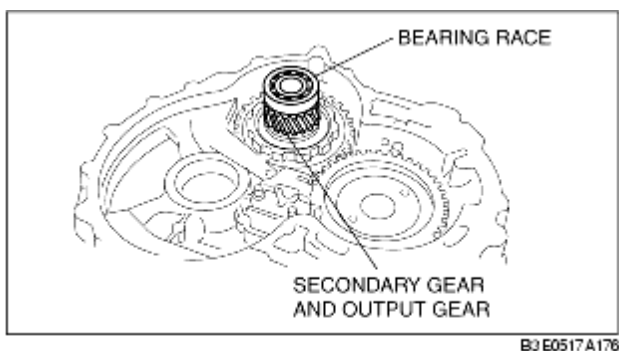
2. Remove the bearing race and adjustment shim from the converter housing using the **SST**.



3. Install the funnel and bearing race into the transaxle case.

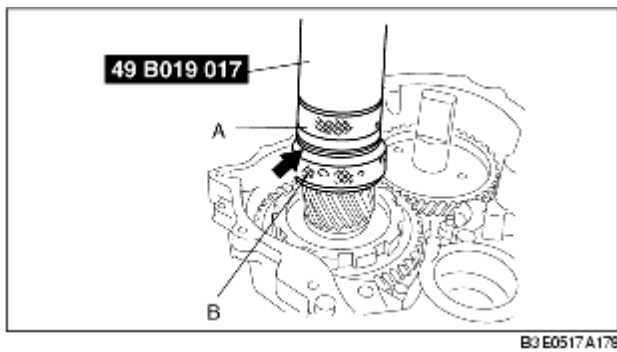


4. Set the secondary gear and output gear into the transaxle case.
5. Install the bearing race removed in Step 2 into the secondary gear and output gear.

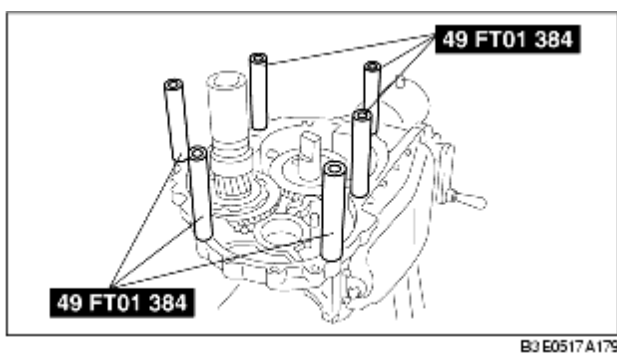


6. Set the **SSTs** onto the primary gear and secondary gear and output gear.

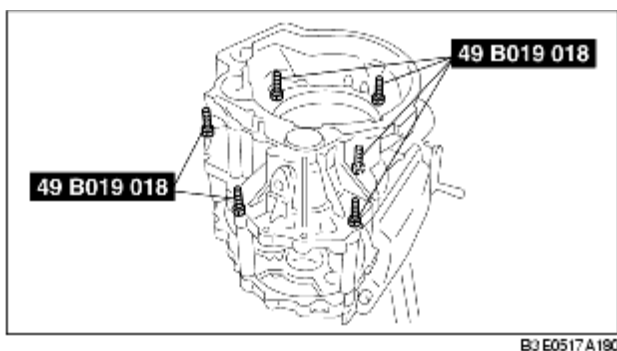
7. Turn the selector to eliminate the gap between its two halves.



8. Set the six **SSTs** (collars) on the transaxle case in the position shown.



9. Set the converter housing on the transaxle case and tighten the **SSTs** (bolts) to the specified torque.



Tightening torque

19-25 N·m {1.9-2.6 kgf·m, 14-18 ft·lbf}

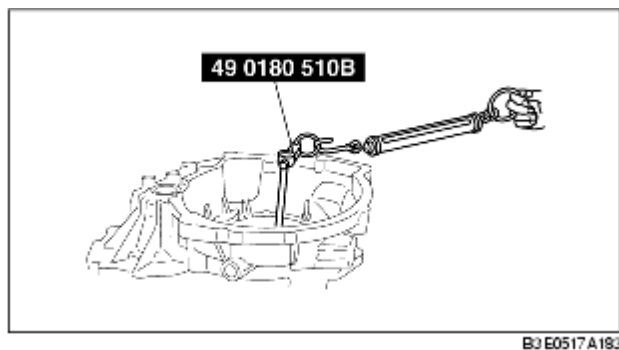
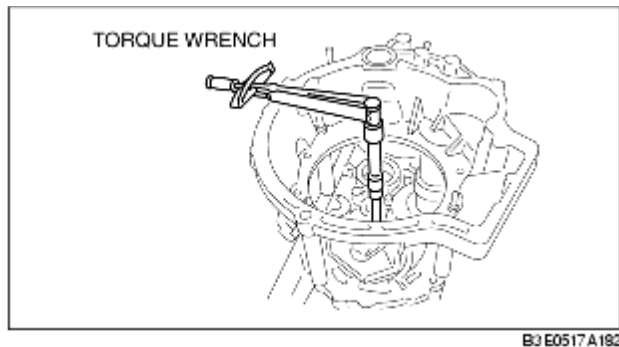
10. Turn the **SST** (selector) to increase the clearance (arrow) using the **SSTs** (bars), until it no longer turns. This is to seat the bearing race.
11. Turn the selector in the opposite direction until the preload is eliminated (gap is reduced).

12. Insert the joint through the converter housing and attach it the **SST** installed to the primary gear.

Note

- Read the preload when the primary gear starts to turn.
- Measure several times and calculate the average value.

13. Adjust the clearance of the **SST** (selector) to obtain the specified preload/pull scale reading.



Preload:

1.5-2.4 N·m {15-25 kgf·cm, 13-21 in·lbf}

Reading on pull scale:

15-24 N {1.5-2.5 kgf, 3.3-5.5 lbf}

Note

- Measure the clearance around the entire circumference, and select a shim based on the maximum clearance.
- The maximum allowable number of adjustment shim is one.

14. Measure the clearance as shown.

15. Take the maximum reading and determine the shim to be used.

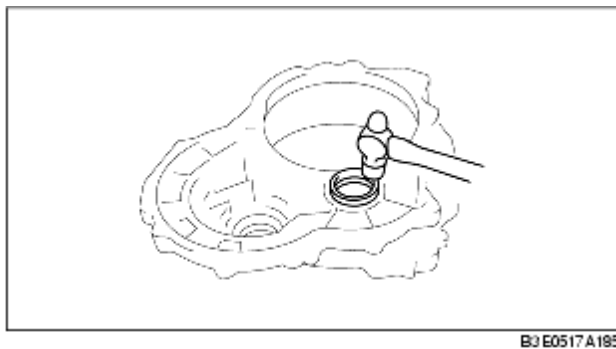
Adjustment shim sizes

mm {in}

0.50 {0.020}	0.55 {0.022}	0.60 {0.024}
0.65 {0.026}	0.70 {0.028}	0.75 {0.030}
0.80 {0.031}	0.85 {0.033}	0.90 {0.035}
0.95 {0.037}	1.00 {0.039}	1.05 {0.041}
1.10 {0.043}	1.15 {0.045}	1.20 {0.047}
1.25 {0.049}	1.30 {0.051}	-

16. Remove the converter housing and **SST** (selector).

17. Install the required adjustment shim and tap the bearing race into the converter housing.



18. Install the converter housing.

Tightening torque

19-25 N·m {1.9-2.6 kgf·m, 14-18 ft·lbf}

19. Insert the **SST** (preload adapter) through the converter housing and attach it to the **SST**.

20. Verify that the preload is within the specification. If not, return to Step 1.

Preload

1.5-2.4 N·m {15-25 kgf·cm, 13-21 in·lbf}

Reading on pull scale

15-24 N {1.5-2.5 kgf, 3.3-5.5 lbf}

21. Remove the converter housing.