

# PRIMARY SHAFT COMPONENTS INSPECTION

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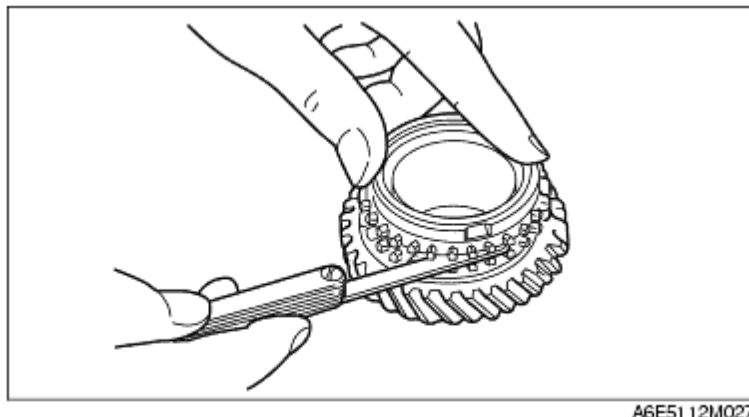
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## 4th Gear, 3rd Gear Inspection

1. Inspect the synchronizer cones for wear.
  - If there is malfunction, replace parts as necessary.
2. Inspect the gear teeth for damage, wear, and cracks.
  - If there is malfunction, replace parts as necessary.
3. Inspect the synchronizer ring matching teeth for damage and wear.
  - If there is malfunction, replace the synchronizer ring.

## 4th Synchronizer Ring, 3rd Synchronizer Ring Inspection

1. Inspect the synchronizer ring teeth for damage, wear, and cracks.
  - If there is malfunction, replace parts as necessary.
2. Inspect the tapered surface for wear and cracks.
  - If there is malfunction, replace parts as necessary.
3. Measure the clearance between the synchronizer ring and the flank surface of the gear.



- If not as specified, replace the synchronizer ring.

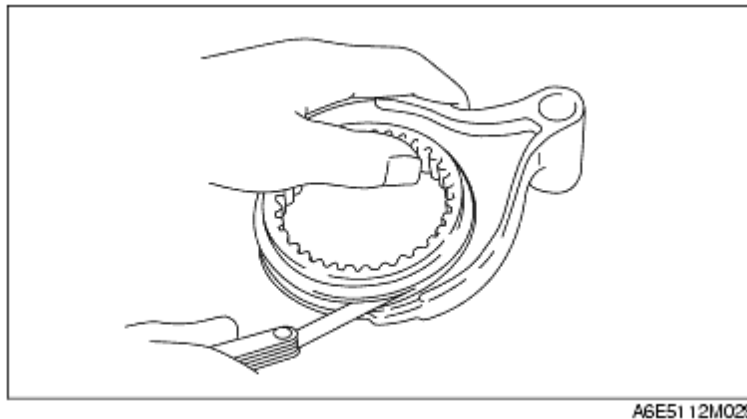
### Note

- Set the synchronizer ring squarely in the gear; then measure around the circumference.

Standard clearance  
1.50 mm {0.059 in}  
Minimum  
0.80 mm {0.031 in}

### 3rd/4th Clutch Hub Component Inspection

1. Inspect the clutch hub sleeve and hub operation.
  - If there is malfunction, replace parts as necessary.
2. Inspect the gear teeth for damage, wear, and cracks.
  - If there is malfunction, replace parts as necessary.
3. Inspect the synchronizer keys for damage, wear, and cracks.
  - If there is malfunction, replace parts as necessary.
4. Measure the clearance between the hub sleeve and shift forks.



- If the clearance exceeds the maximum, replace the hub sleeve and shift fork as a set.

Standard  
0.10-0.40 mm {0.004-0.015 in}  
Maximum  
0.90 mm {0.035 in}

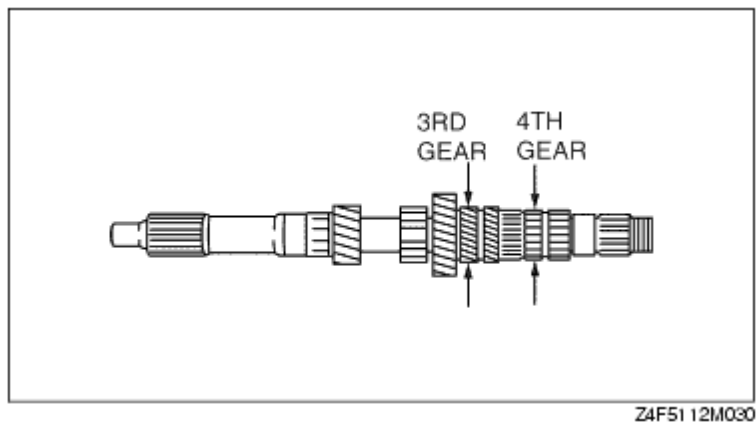
### Primary Shaft Gear Inspection

1. Inspect the gear contact surface for damage and wear.
  - If there is malfunction, replace the primary shaft.
2. Inspect the splines for damage and wear.
  - If there is malfunction, replace the primary shaft.
3. Inspect the gear teeth for damage, wear, and cracks.
  - If there is malfunction, replace the primary shaft.
4. Inspect the oil passage for clogging.
  - If there is malfunction, replace the primary shaft.
5. Measure the shaft gear runout.

- If not as specified, replace the primary shaft.

Primary shaft runout  
0.050 mm {0.0020 in} max.

6. Measure the clearance between the shaft gears and the gears.



- If not as specified, replace parts as necessary.

<b>Gear</b>	<b>Shaft (Outer dia.)</b>	<b>Gear (Inner dia.)</b>	<b>Clearance</b>
3rd	35.945-35.970 {1.415-1.416}	36.000-36.025 {1.417-1.418}	0.030-0.080 {0.001-0.003}
4th	30.945-30.970 {1.218-1.219}	31.000-31.025 {1.220-1.221}	