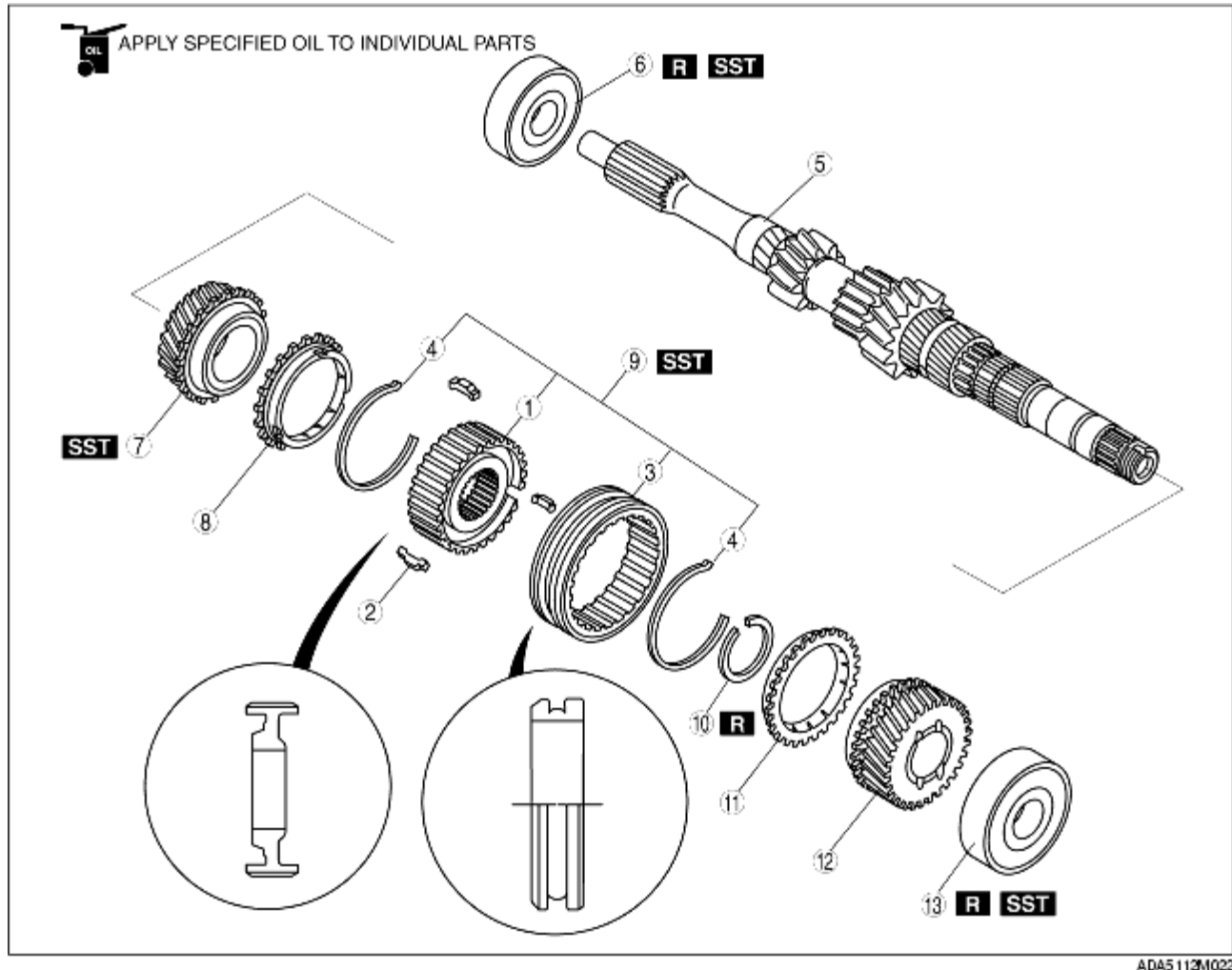


PRIMARY SHAFT COMPONENTS ASSEMBLY

B3E051517201104

1. Assemble in the order indicated in the table.

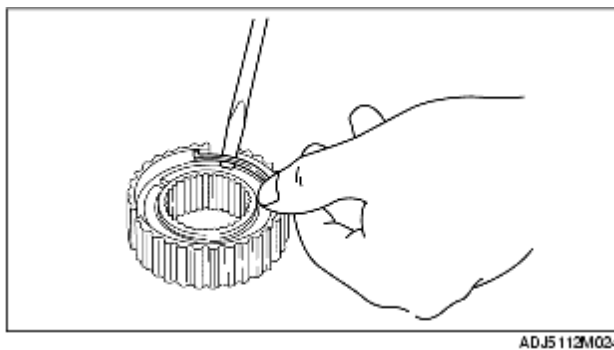
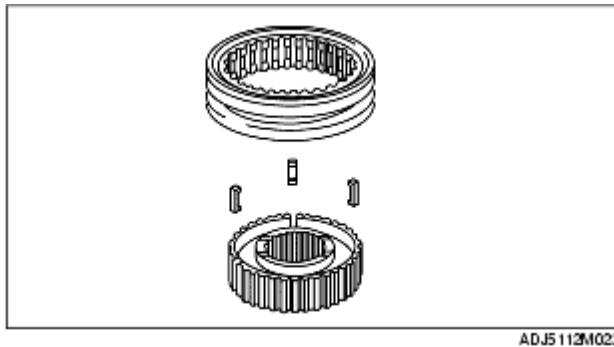


1	3rd/4th clutch hub (See 3rd/4th Clutch Hub Assembly Note.)
2	Synchronizer key
3	3rd/4th clutch hub sleeve
4	Synchronizer key spring
5	Primary shaft gear
6	Bearing (primary shaft end) (See Bearing (Primary Shaft End) Assembly Note.)
7	3rd gear (See 3rd Gear, 3rd Synchronizer Ring, and 3rd/4th Clutch Hub Component Assembly Note.)
8	3rd synchronizer ring (See 3rd Gear, 3rd Synchronizer Ring, and 3rd/4th Clutch Hub Component Assembly Note.)
9	3rd/4th clutch hub component (See 3rd Gear, 3rd Synchronizer Ring, and 3rd/4th Clutch Hub Component Assembly Note.)
10	Retaining ring

11	4th synchronizer ring (See 4th Synchronizer Ring, 4th Gear, and Bearing (4th Gear End) Assembly Note.)
12	4th gear (See 4th Synchronizer Ring, 4th Gear, and Bearing (4th Gear End) Assembly Note.)
13	Bearing (4th gear end) (See 4th Synchronizer Ring, 4th Gear, and Bearing (4th Gear End) Assembly Note.)

3rd/4th Clutch Hub Assembly Note

1. Install the synchronizer key springs in the clutch hub with the hooks in the grooves to hold the three synchronizer key in place.

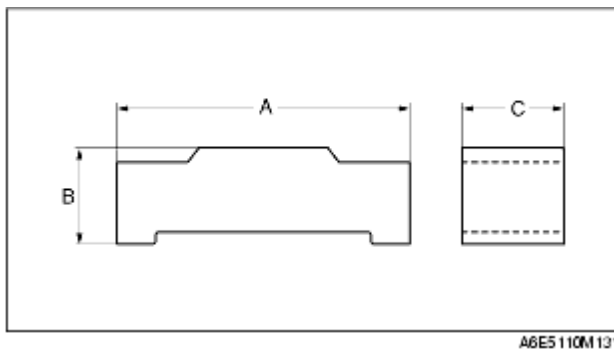


Synchronizer key size

A: 17.00 mm {0.669 in}

B: 4.25 mm {0.167 in}

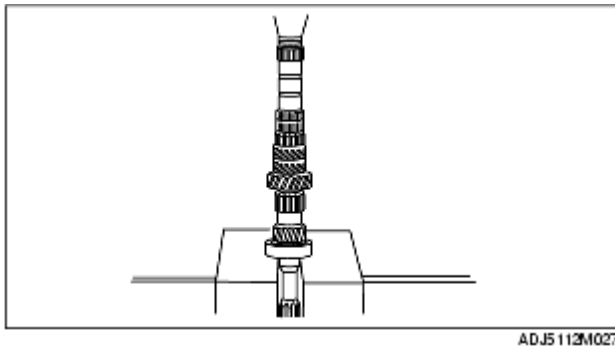
C: 5.00 mm {0.197 in}



2. Align the synchronizer ring grooves with the synchronizer key during assembly.

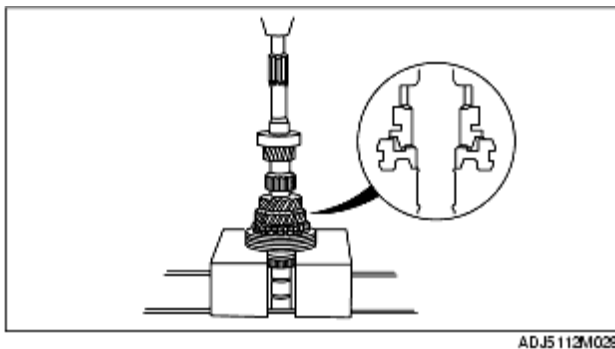
Bearing (Primary Shaft End) Assembly Note

1. Install the new bearing using the **SST**.



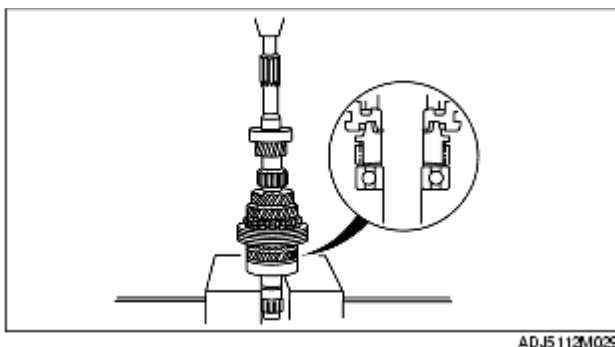
3rd Gear, 3rd Synchronizer Ring, and 3rd/4th Clutch Hub Component Assembly Note

1. Install the 3rd gear, 3rd synchronizer ring, and 3rd/4th clutch hub component using a press.



4th Synchronizer Ring, 4th Gear, and Bearing (4th Gear End) Assembly Note

1. Install the 4th synchronizer ring, 4th gear, and a new bearing using the **SST**.

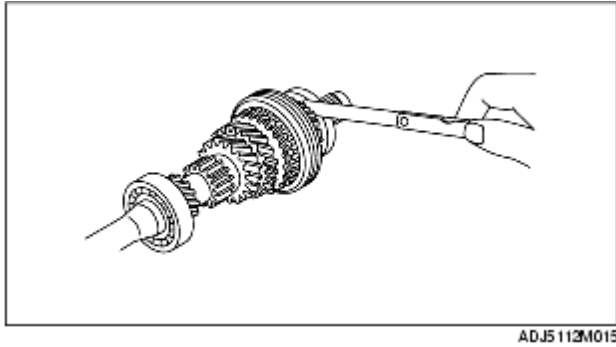


2. Measure the clearance between the 3rd gear and 2nd gear.

- If it exceeds the maximum specification, reassemble the primary shaft component.

Standard clearance
0.06-0.21 mm {0.002-0.008 in}
Maximum clearance
0.26 mm {0.010 in}

3. Measure the clearance between the 4th gear and bearing.



- If it exceeds the maximum specification, reassemble the primary shaft component.

Standard clearance
0.21-0.61 mm {0.008-0.024 in}
Maximum clearance
0.66 mm {0.026 in}