

SECONDARY SHAFT COMPONENTS INSPECTION

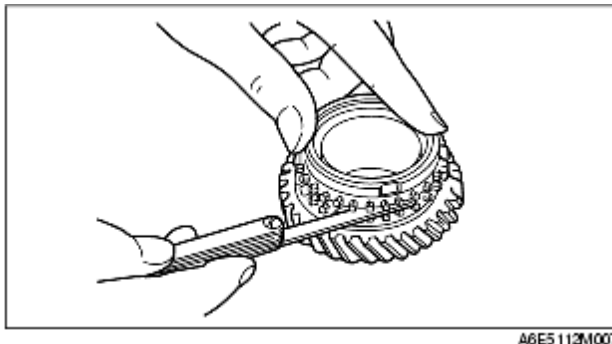
B3E051517301103

Gears Inspection

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

Synchronizer Ring Inspection

1. Inspect the synchronizer ring teeth for damage, wear, and cracks.
 - If there is any malfunction, replace parts as necessary.
2. Inspect the tapered surface for wear and cracks.
 - If there is any malfunction, replace parts as necessary.
3. Measure the clearance between the synchronizer ring and the side of gear circumferentially using a feeler gauge.



- If it is less than the minimum specification, replace the synchronizer ring.

Standard clearance
1.30-1.70 mm {0.052-0.066 in}
Minimum clearance
1.00 mm {0.039 in}

Clutch Hub Component Inspection

1. Inspect the clutch hub sleeve and hub operation.
 - If there is any malfunction, replace parts as necessary.

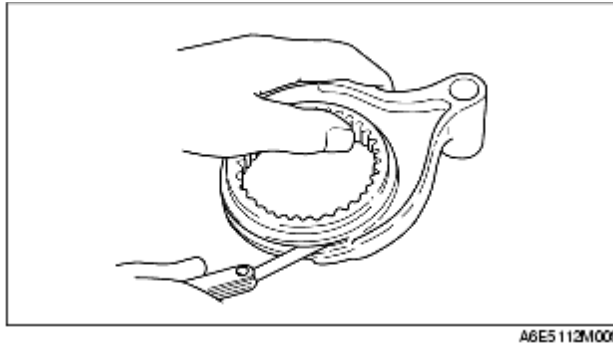
2. Inspect the gear teeth for damage, wear, and cracks.

- If there is any malfunction, replace parts as necessary.

3. Inspect the synchronizer keys for damage, wear, and cracks.

- If there is any malfunction, replace parts as necessary.

4. Measure the clearance between the hub sleeve and shift fork.



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

Standard clearance
0.10-0.36 mm {0.004-0.014 in}
Maximum clearance
0.86 mm {0.034 in}

Secondary Shaft Gear Inspection

1. Inspect the gear contact surface for damage and wear.

- If there is any malfunction, replace the secondary shaft.

2. Inspect the splines for damage and wear.

- If there is any malfunction, replace the secondary shaft.

3. Inspect the gear teeth for damage, wear, and cracks.

- If there is any malfunction, replace the secondary shaft.

4. Inspect the oil passage for clogging.

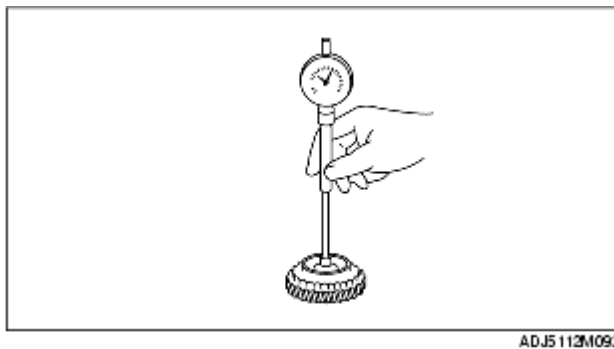
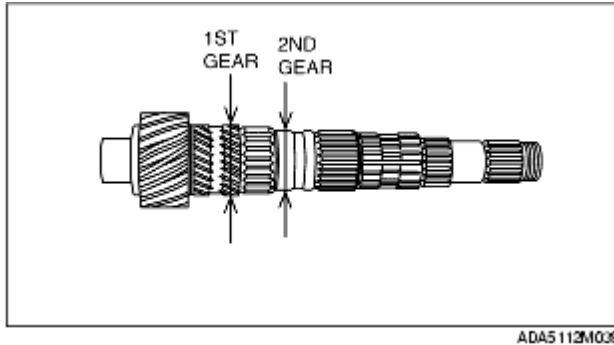
- If there is any malfunction, replace the secondary shaft.

5. Measure the shaft gear runout.

- If it exceeds the maximum specification, replace the secondary shaft.

Maximum runout
0.015 mm {0.0006 in}

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



- If not within the specification, replace parts as necessary.

Gear	Shaft (outer dia.)	Gear (inner dia.)	Clearance
1st	39.45-39.47 {1.553-1.554}	39.50-39.52 {1.555-1.556}	0.03-0.07 {0.002-0.003}
2nd	35.15-35.17 {1.384-1.385}	35.20-35.22 {1.386-1.387}	