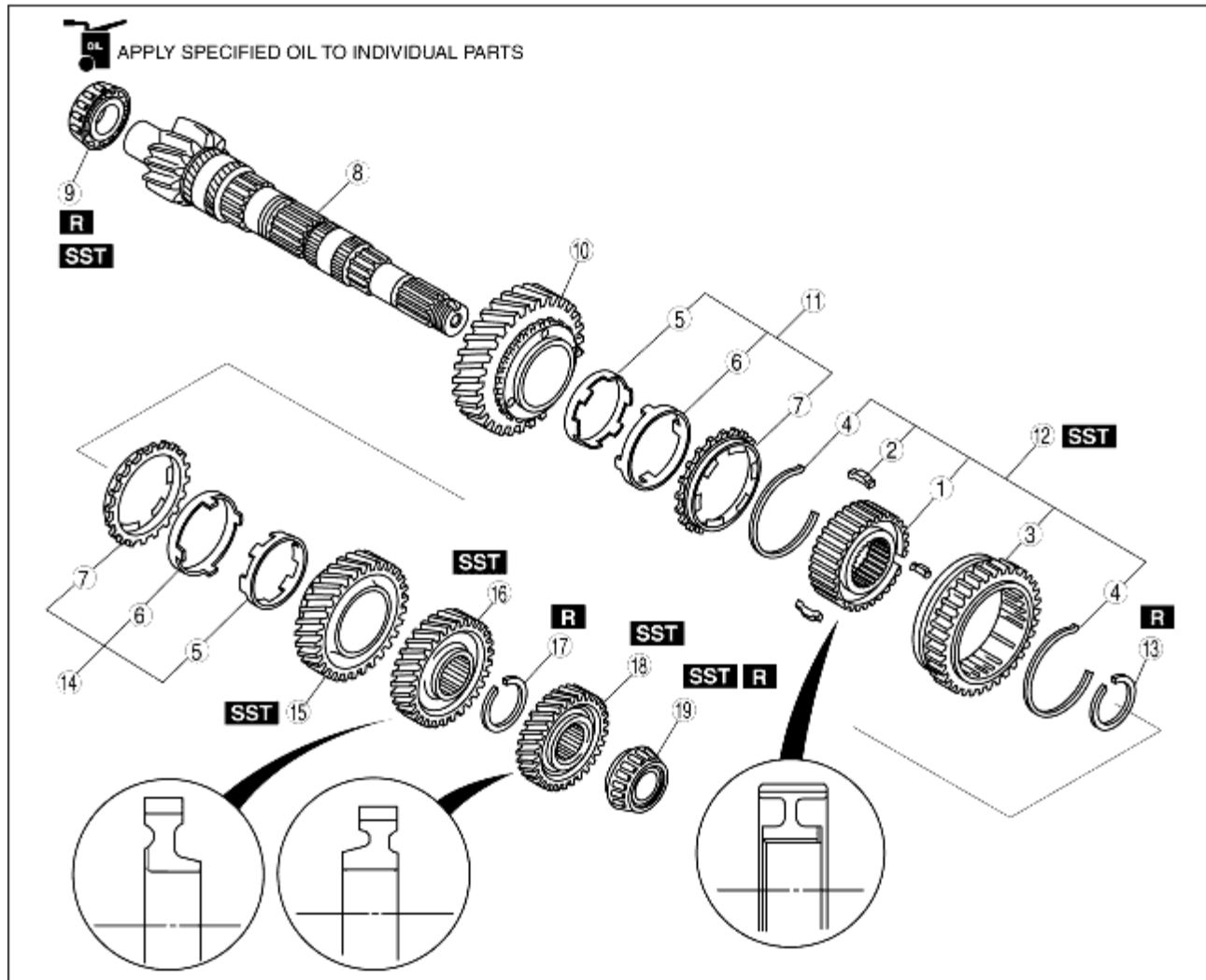


SECONDARY SHAFT COMPONENTS ASSEMBLY

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1. Assemble in the order shown in the figure.



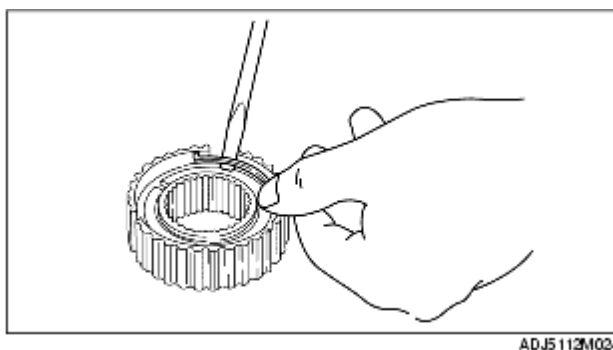
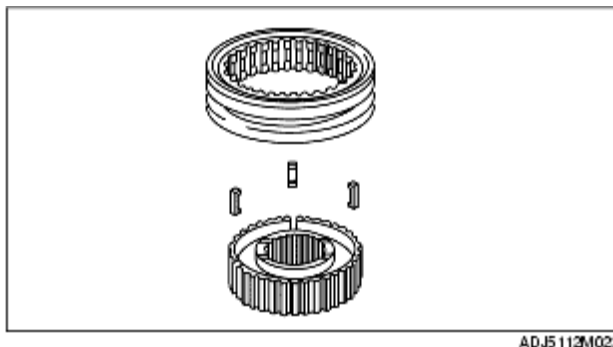
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| | |
|----|---|
| 1 | 1st/2nd clutch hub (See 1st/2nd Clutch Hub Assembly Note.) |
| 2 | Synchronizer key |
| 3 | Clutch hub sleeve (reverse gear) |
| 4 | Synchronizer key spring |
| 5 | Inner cone |
| 6 | Double cone |
| 7 | Synchronizer ring |
| 8 | Secondary shaft gear |
| 9 | Bearing (secondary shaft end) (See Bearing (Secondary Shaft End) Assembly Note.) |
| 10 | 1st gear (See 1st Gear, 1st Synchronizer Ring, and 1st/2nd Clutch Hub Component Assembly Note.) |

| | |
|----|---|
| 11 | Double cone component |
| 12 | 1st/2nd clutch hub component (See 1st/2nd Clutch Hub Assembly Note.) |
| 13 | Retaining ring |
| 14 | Double cone component |
| 15 | 2nd gear (See 2nd Synchronizer Ring, 2nd Gear, and Secondary 3rd Gear Assembly Note.) |
| 16 | Secondary 3rd gear (See 2nd Synchronizer Ring, 2nd Gear, and Secondary 3rd Gear Assembly Note.) |
| 17 | Retaining ring |
| 18 | Secondary 4th gear (See Secondary 4th Gear and Bearing Assembly Note.) |
| 19 | Bearing (See Secondary 4th Gear and Bearing Assembly Note.) |

1st/2nd 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 keys in place.



Synchronizer key

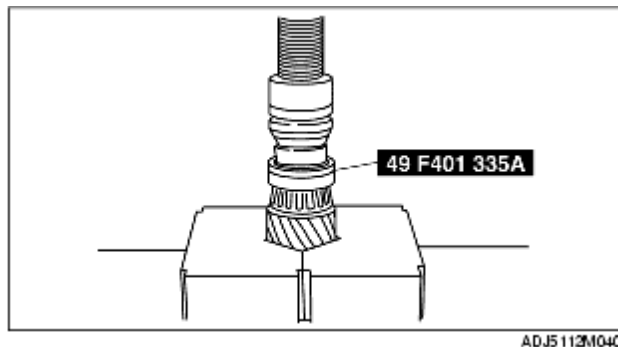
A: 19.00 mm {0.748 in}

B: 4.25 mm {0.167 in}

C: 5.00 mm {0.197 in}

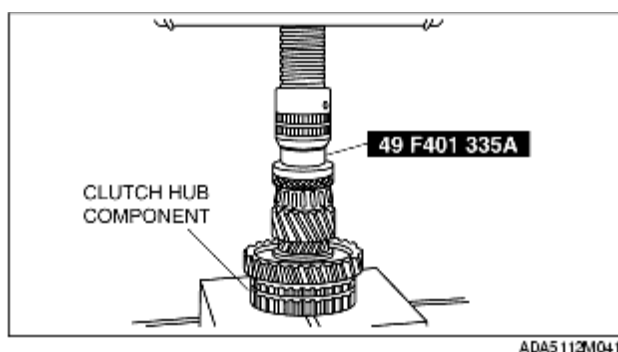
Bearing (Secondary Shaft End) Assembly Note

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



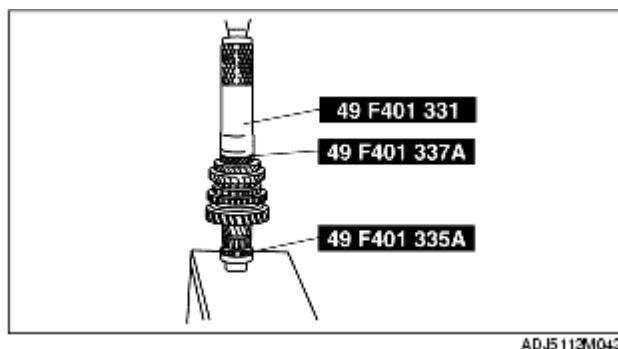
1st Gear, 1st Synchronizer Ring, and 1st/2nd Clutch Hub Component Assembly Note

1. Assemble the 1st gear, 1st synchronizer ring, inner cone, double cone and 1st/2nd clutch hub component, as shown in the figure.
2. Press the 1st/2nd clutch hub component on using the **SST**.



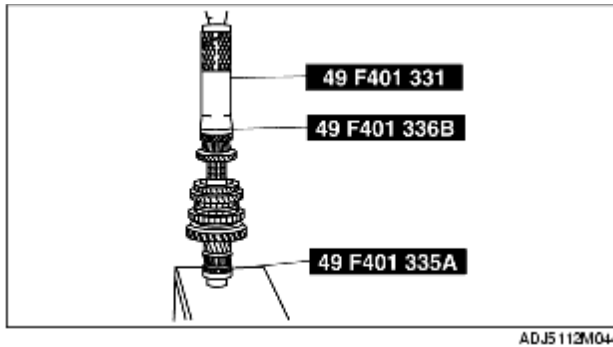
2nd Synchronizer Ring, 2nd Gear, and Secondary 3rd Gear Assembly Note

1. Install the 2nd synchronizer ring and 2nd gear.
2. Install the secondary 3rd gear using the **SSTs**.

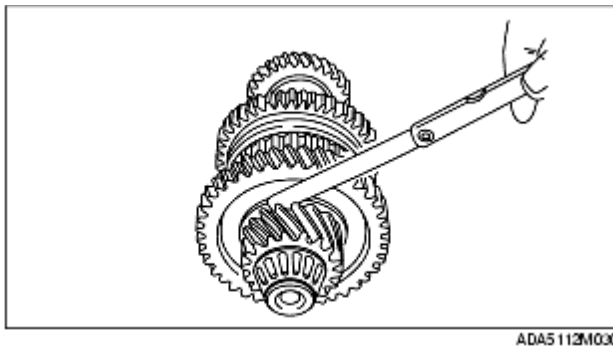


Secondary 4th Gear and Bearing Assembly Note

1. Install the secondary 4th gear and the bearing using the **SSTs**.

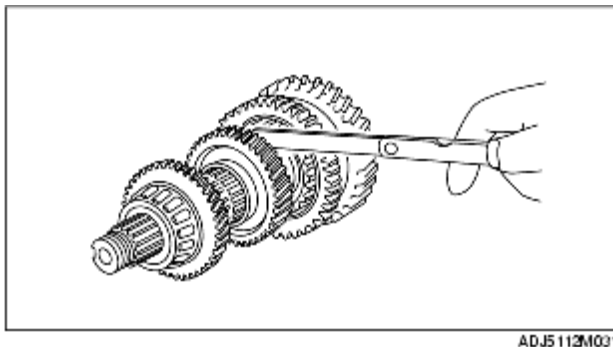


2. Measure the clearance between the 1st gear and the differential drive gear.



Standard clearance
0.05-0.28 mm {0.002-0.011 in}
Maximum clearance
0.33 mm {0.013 in}

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



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

Standard clearance
0.18-0.51 mm {0.007-0.020 in}
Maximum clearance
0.56 mm {0.022 in}