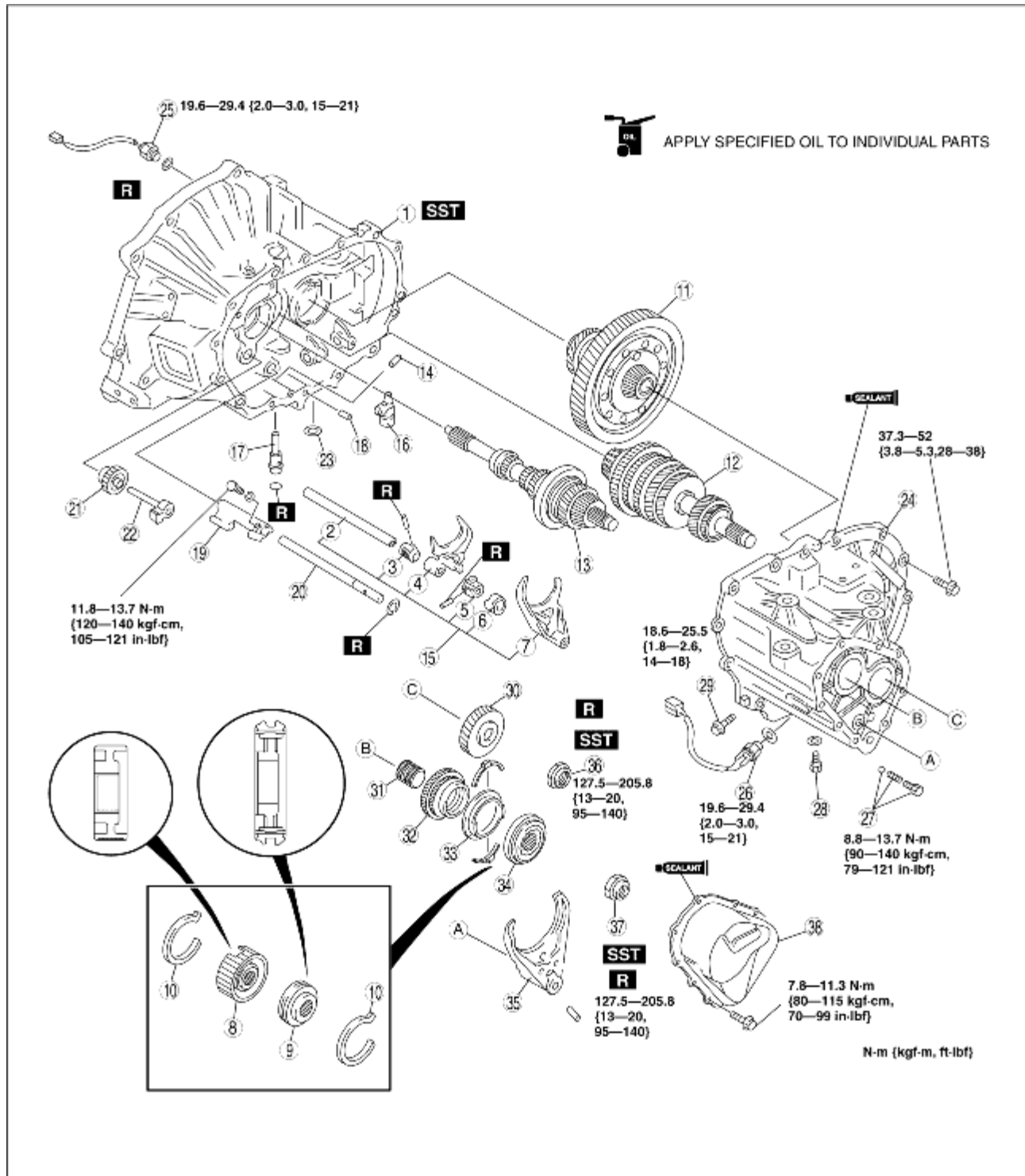


# 5TH/REVERSE GEAR AND HOUSING PARTS ASSEMBLY

B3E051501029M09

1. Assemble in the order indicated in the table.



A6E5113M119

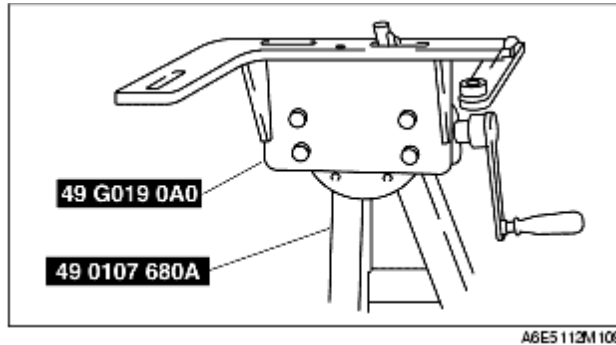
1	Clutch housing (See <a href="#">Clutch Housing Assembly Note.</a> )
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2	Control rod
3	Control end
4	1st/2nd shift fork
5	Control lever
6	Interlock lever
7	3rd/4th shift fork
8	Clutch hub
9	Clutch hub sleeve
10	Differential component
11	Secondary shaft gear component (See <a href="#">Primary Shaft Gear Component and Secondary Shaft Gear Component Assembly Note.</a> )
12	Primary shaft gear component (See <a href="#">Primary Shaft Gear Component and Secondary Shaft Gear Component Assembly Note.</a> )
13	Spring
14	Push pin
15	Shift fork and shift rod component (See <a href="#">Shift Fork and Shift Rod Component Assembly Note.</a> )
16	Crank lever component (See <a href="#">Crank Lever Component and Crank Lever Shaft Assembly Note.</a> )
17	Crank lever shaft (See <a href="#">Crank Lever Component and Crank Lever Shaft Assembly Note.</a> )
18	Pin
19	5th/reverse shift rod end (See <a href="#">5th/Reverse Shift Rod End and 5th/Reverse Shift Rod Assembly Note.</a> )
20	5th/reverse shift rod (See <a href="#">5th/Reverse Shift Rod End and 5th/Reverse Shift Rod Assembly Note.</a> )
21	Reverse idle gear (See <a href="#">Reverse Idle Gear and Reverse Idle Shaft Assembly Note.</a> )
22	Reverse idle shaft (See <a href="#">Reverse Idle Gear and Reverse Idle Shaft Assembly Note.</a> )
23	Magnet
24	Transaxle case component (See <a href="#">Transaxle Case Component Assembly Note.</a> )
25	Neutral switch
26	Back-up light switch
27	Lock bolt, ball and spring
28	Guide bolt
29	Lock bolt
30	Secondary 5th gear (See <a href="#">Secondary 5th Gear Assembly Note.</a> )
31	Gear sleeve
32	5th gear
33	5th synchronizer ring
34	5th/reverse clutch hub component (See <a href="#">5th/Reverse Clutch Hub Component and 5th/Reverse Shift Fork Assembly Note.</a> )
35	5th/reverse shift fork (See <a href="#">5th/Reverse Clutch Hub Component and 5th/Reverse Shift Fork Assembly Note.</a> )
36	Locknut (secondary shaft) (See <a href="#">Locknut Assembly Note.</a> )
37	Locknut (primary shaft)

	(See <a href="#">Locknut Assembly Note.</a> )
38	Rear cover

## Clutch Housing Assembly Note

1. Assemble the **SST**.



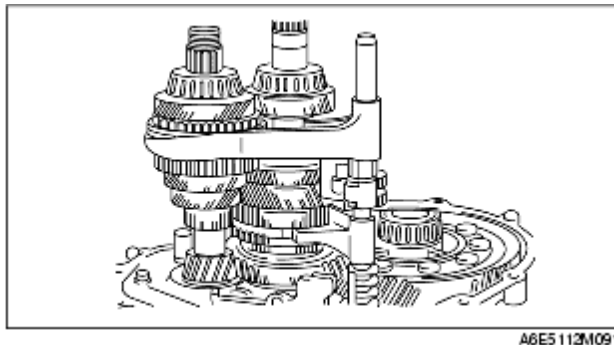
2. Assemble the clutch housing on the **SST**.

## Primary Shaft Gear Component and Secondary Shaft Gear Component Assembly Note

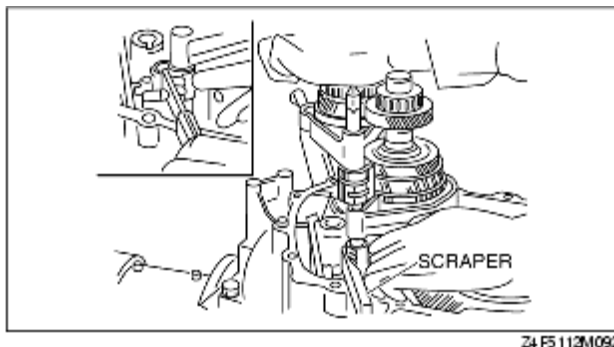
1. Install the primary shaft gear component and the secondary shaft gear component together.

## Shift Fork and Shift Rod Component Assembly Note

1. Shift to 2nd gear and position the shift fork and shift rod component as shown.

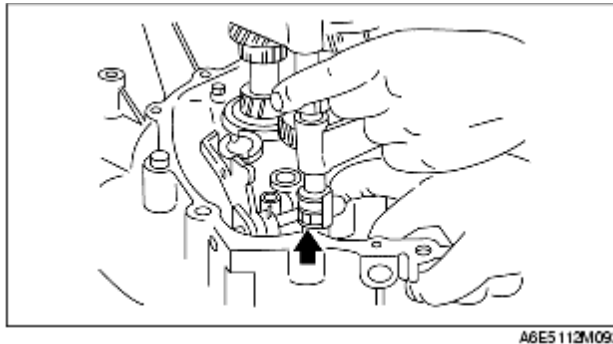


2. Insert the spring seat and spring into the reverse lever shaft, install the steel ball, and place a scraper so that it contacts the steel ball.



3. With the edge of the control end against the scraper, when the control end is pushed in the direction of the arrow in the figure so that the ball goes into the shaft, the rod will at the same time line up with the shift rod coupling hole in the clutch housing.

4. Set each clutch hub sleeve to the neutral position, and tap the shift rod from above so that the steel ball goes into the center groove (of the three grooves in the control end).

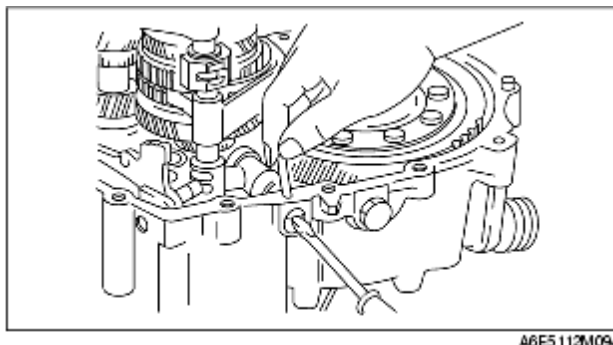


5. Pull the ball part of the control end forward so that the steel ball goes into the detent in the groove.

## Crank Lever Component and Crank Lever Shaft Assembly Note

1. Fit the crank lever between the change arm and the control end, and connect the crank lever shaft to the crank lever.

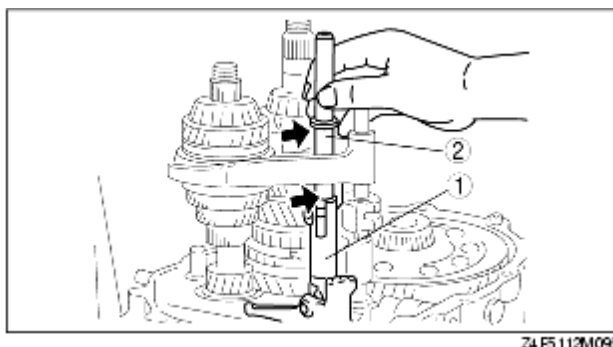
2. Align the pin holes of the crank lever shaft and the clutch housing, and insert a new pin.



## 5th/Reverse Shift Rod End and 5th/Reverse Shift Rod Assembly Note

### Note

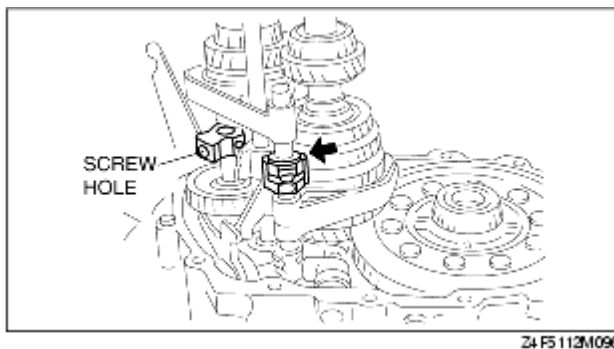
- The mark (indicated by the arrow in the figure) and the shift rod end mounting bolt hole must be aligned.



1. Install shift rod end 1 and the shift rod 2, and tighten the gate mounting bolt.

**Tightening torque****11.8-13.7 N·m {120-140 kgf·cm, 105-121 in·lbf}****Reverse Idle Gear and Reverse Idle Shaft Assembly Note**

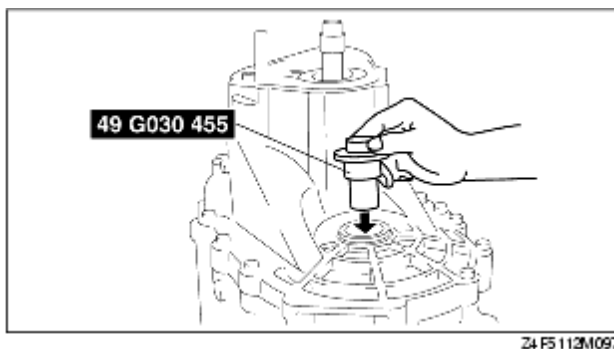
1. Install the reverse idle gear and the reverse idler shaft.
2. Attach the magnet to the clutch housing.
3. Align the end of the interlock sleeve with the control lever (arrow), and at the same time, face the reverse idle shaft screw hole in the direction shown in the figure.

**Transaxle Case Component Assembly Note**

1. Apply a thin coat of sealant to the contact surfaces of the clutch housing and transaxle case, and tighten the transaxle case installation bolts to the specified torque.

**Tightening torque****37.3-52.0 N·m {3.8-5.3 kgf·m, 28-38 ft·lbf}**

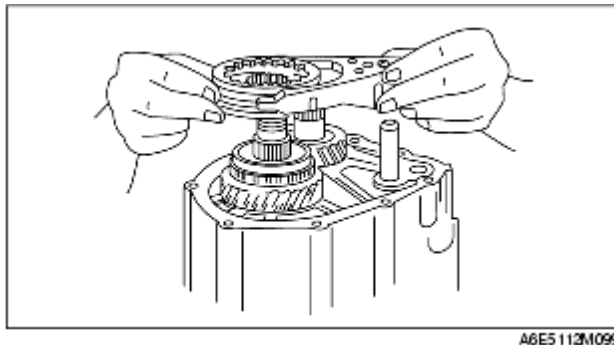
2. Install the **SSTs** through the drive shaft and joint shaft hole.

**Secondary 5th Gear Assembly Note**

1. Install the secondary 5th gear as shown.

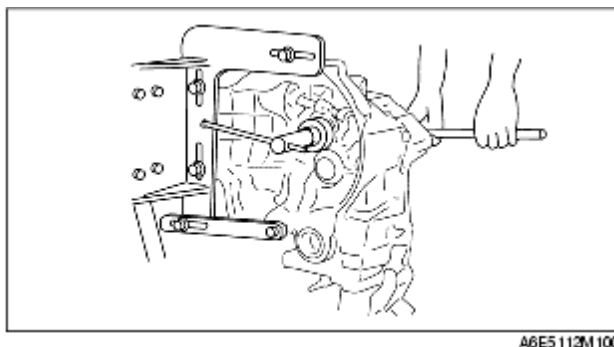
## 5th/Reverse Clutch Hub Component and 5th/Reverse Shift Fork Assembly Note

1. Install the 5th/reverse clutch hub component and the 5th/reverse shift fork together.



## Locknut Assembly Note

1. Shift to 1st gear.
2. Lock the primary shaft using the **SST**.

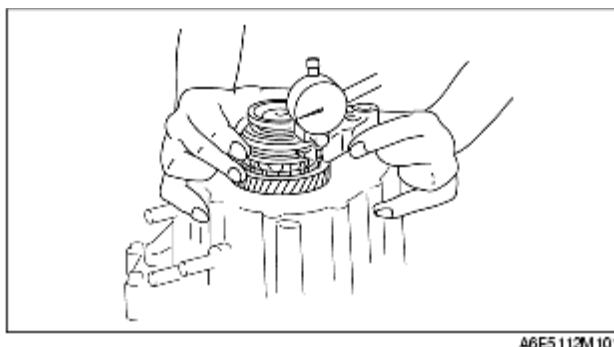


3. Tighten new lock nuts onto the primary and secondary shafts.

### Tightening torque

127.5-205.8 N·m {13.0-20.0 kgf·m, 95-144 ft·lbf}

4. Stake the locknuts.
5. Measure the 5th gear thrust clearance using a dial indicator.



- If it exceeds the maximum specification, reassemble the transaxle.

**Standard clearance****0.100-0.220 mm {0.0039-0.0087 in}****Maximum clearance****0.270 mm {0.0106 in}**