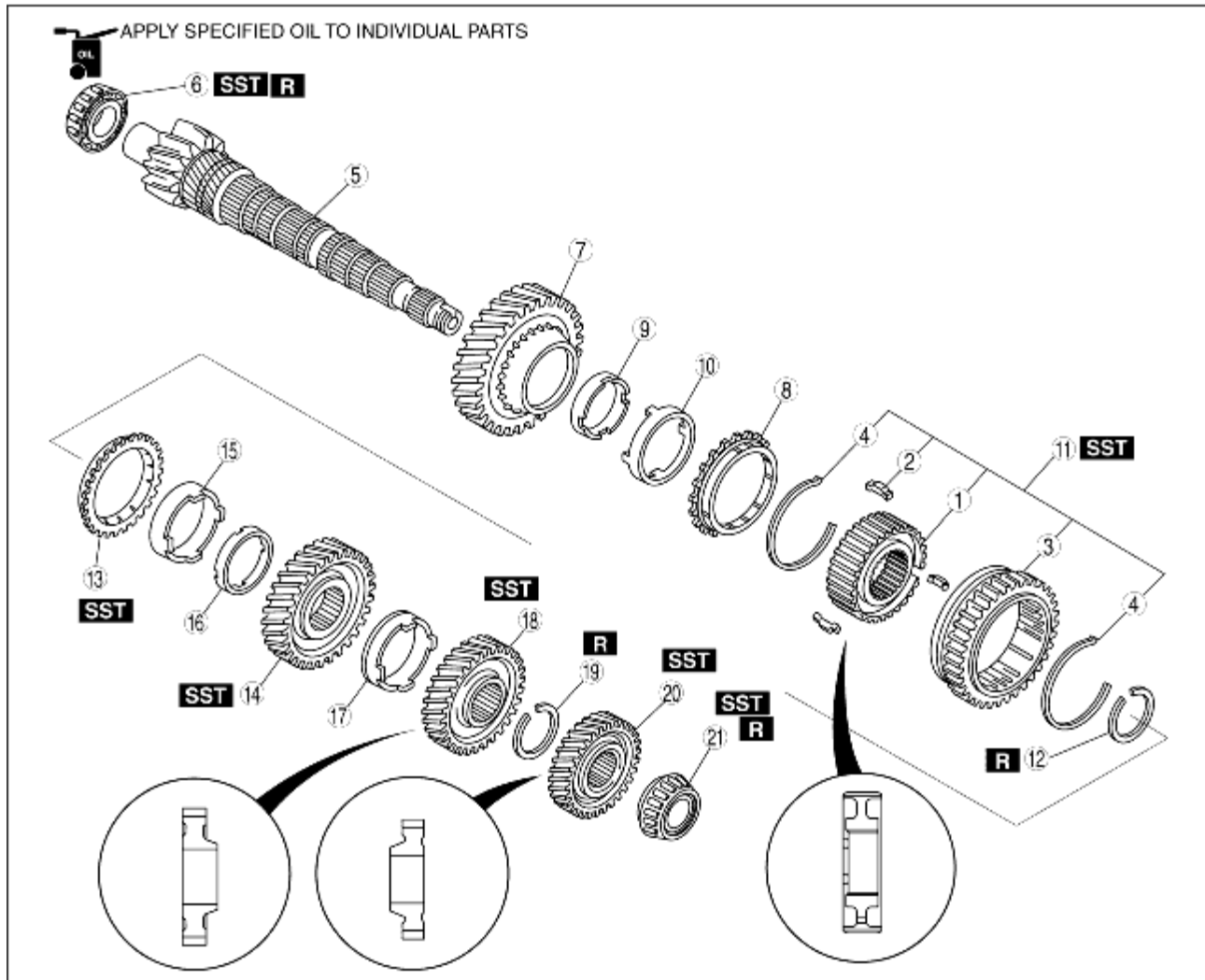


SECONDARY SHAFT COMPONENTS ASSEMBLY

B3E051517301M04

1. Assemble in the order indicated in the table.



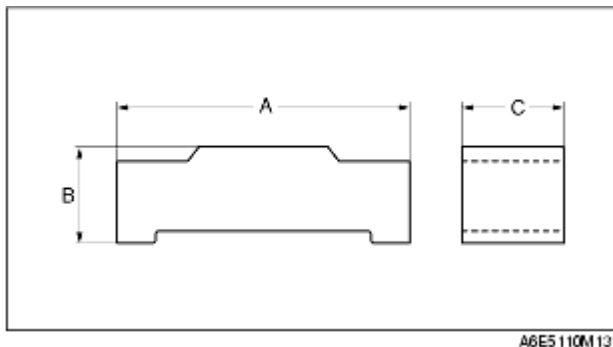
A6E5112M110

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	Secondary shaft gear
6	Bearing (secondary shaft end) (See Bearing (Secondary Shaft End) Assembly Note.)
7	1st gear (See 1st Gear, 1st Synchronizer Ring, and 1st/2nd Clutch Hub Component Assembly Note.)
8	Synchronizer ring
9	Inner cone
10	Double cone

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

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

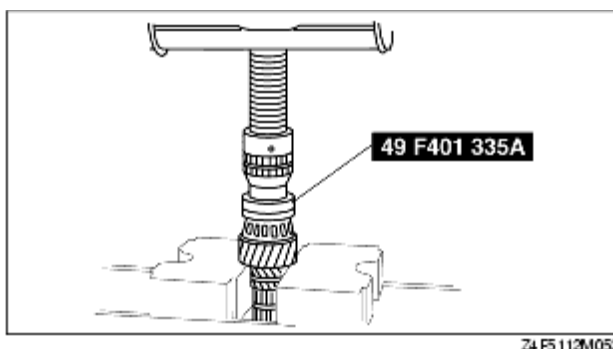
A: 19.0 mm {0.748 in}

B: 4.25 mm {0.167 in}

C: 5.0 mm {0.20 in}

Bearing (Secondary Shaft End) Assembly Note

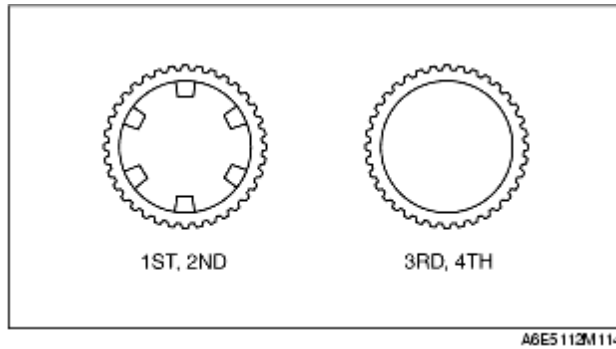
1. Install the new bearing using the SST.



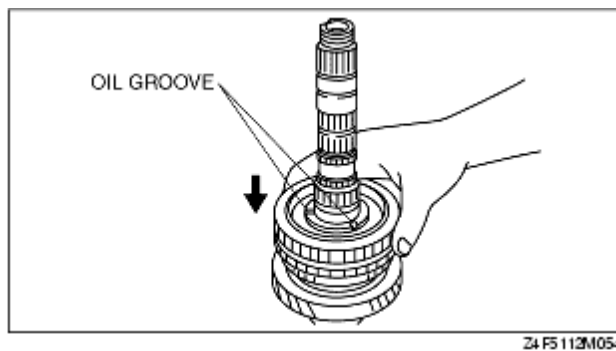
1st Gear, 1st Synchronizer Ring, and 1st/2nd Clutch Hub Component Assembly Note

Note

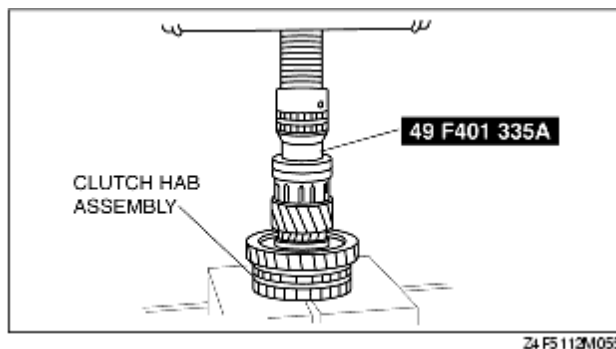
- The size of the 1st, 2nd, 3rd, and 4th synchronizer rings are the same.



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



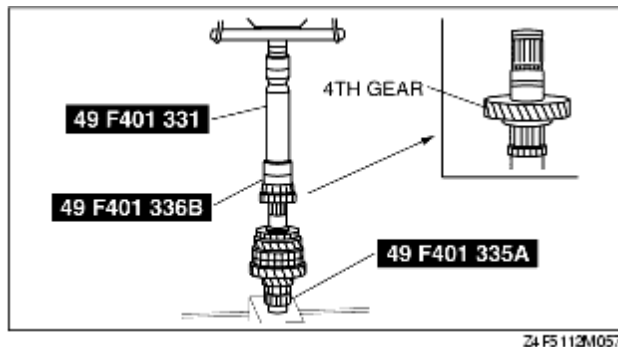
2. Press the 1st/2nd clutch hub component on using the **SST**.

**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 **SST**.

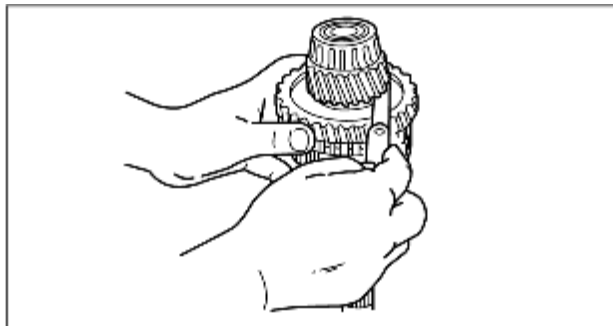
Secondary 4th Gear and Bearing Assembly Note

1. Install the secondary 4th gear and the bearing using the SST.



Z4 F5113M057

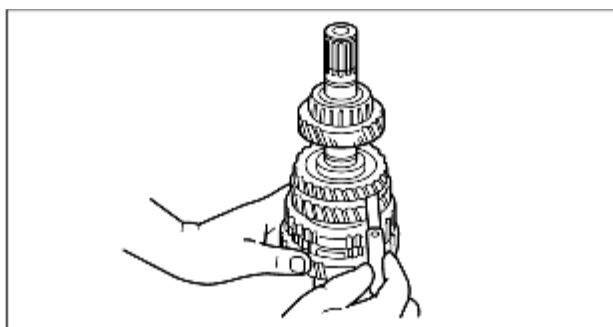
2. Measure the clearance between the 1st gear and the differential drive gear.



A6E5113M058

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.



A6E5113M059

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

Standard clearance
0.18-0.46 mm {0.007-0.018 in}
Maximum clearance
0.51 mm {0.020 in}