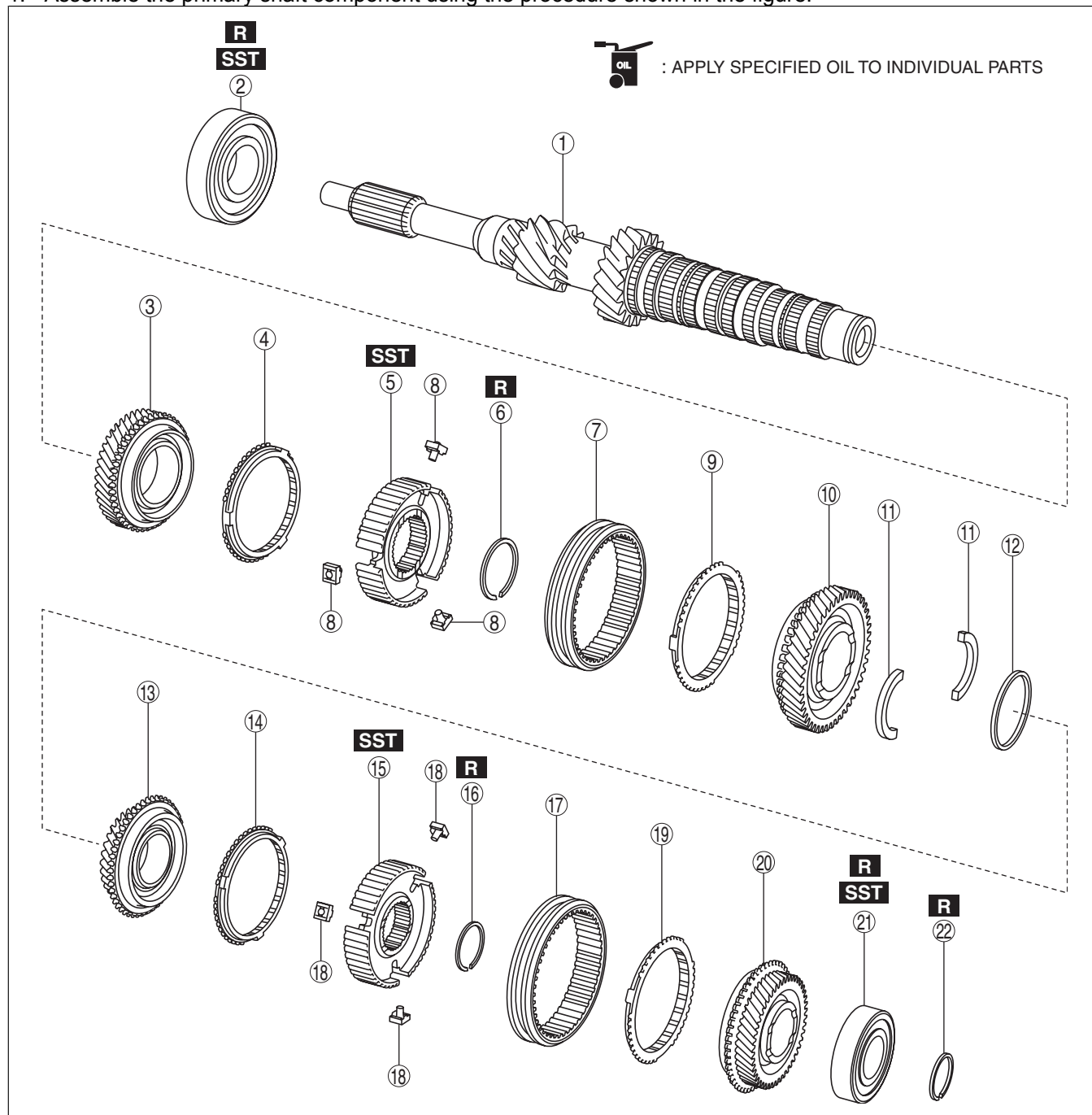


PRIMARY SHAFT COMPONENT ASSEMBLY

id051500168900

1. Assemble the primary shaft component using the procedure shown in the figure.



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1	Primary shaft
2	Ball bearing (See Ball Bearing (Clutch Housing Side) Assembly Note.)
3	5th gear
4	Synchronizer ring
5	Clutch hub (5GR/6GR) (See Clutch Hub (5GR/6GR) Assembly Note.)
6	Clip
7	Clutch hub sleeve (See Clutch Hub Sleeve Assembly Note.)
8	Synchronizer key (See Synchronizer Key Assembly Note.)

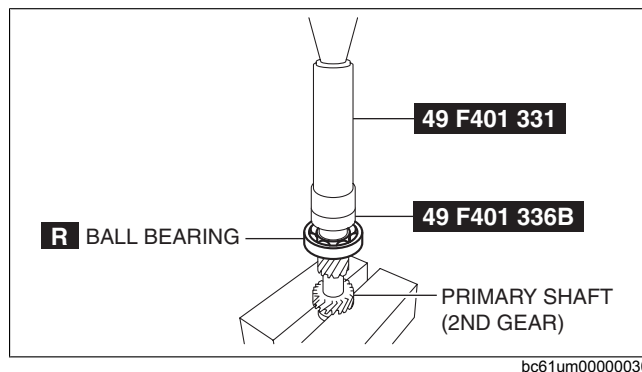
9	Synchronizer ring (See Synchronizer Ring Assembly Note.)
10	6th gear
11	Retaining ring
12	Holder
13	3rd gear
14	Synchronizer ring
15	Clutch hub (3GR/4GR) (See Clutch Hub (3GR/4GR) Assembly Note.)
16	Clip
17	Clutch hub sleeve (See Clutch Hub Sleeve Assembly Note.)
18	Synchronizer key (See Synchronizer Key Assembly Note.)

19	Synchronizer ring (See Synchronizer Ring Assembly Note.)
20	4th gear
21	Ball bearing (See Ball Bearing (Transaxle Case Side) Assembly Note.)

22	Clip
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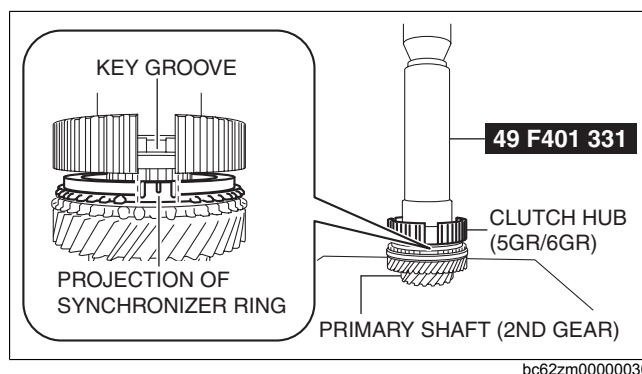
Ball Bearing (Clutch Housing Side) Assembly Note

1. Set the primary shaft and new ball bearing, and the **SST**s in a press as shown in the figure.
2. Assemble the ball bearing using the press.



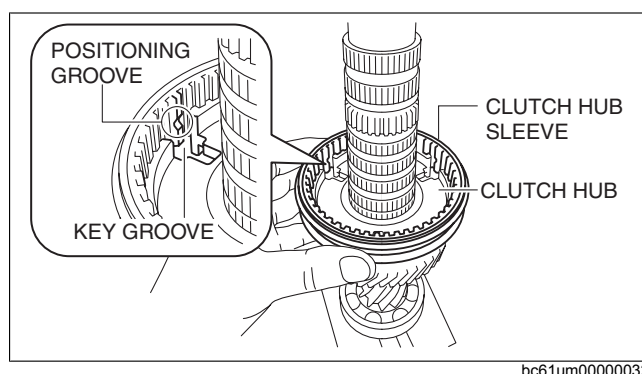
Clutch Hub (5GR/6GR) Assembly Note

1. Set the primary shaft component and **SST** in a press as shown in the figure.
2. Align the projection of the synchronizer ring with the key groove of the clutch hub (5GR/6GR).
3. Assemble the clutch hub (5GR/6GR) using the press.



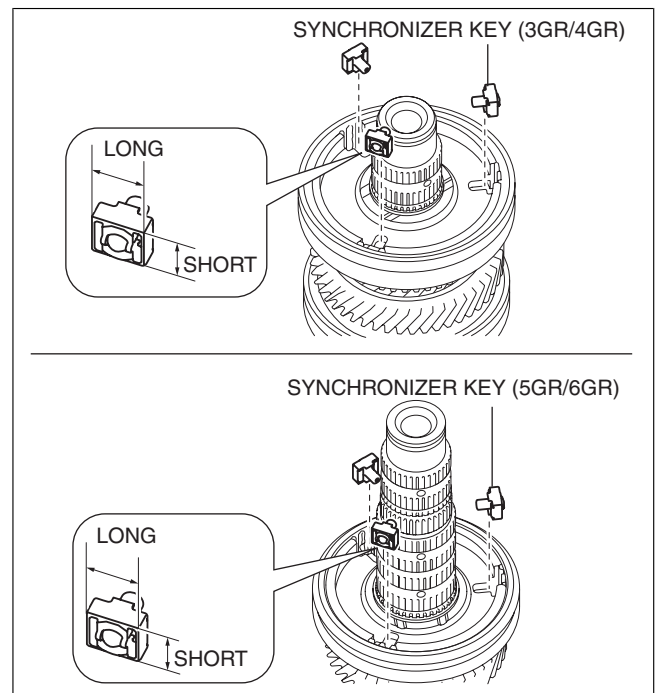
Clutch Hub Sleeve Assembly Note

1. Align the positioning groove of the clutch hub sleeve so that it is lined up with the center of the key groove of the clutch hub, and assemble the clutch hub sleeve.



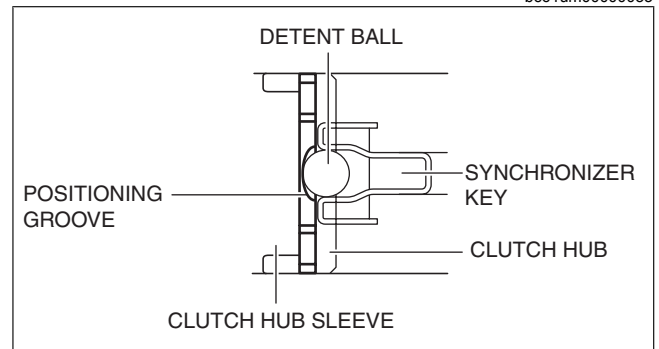
Synchronizer Key Assembly Note

1. Align with the direction of the synchronizer key as shown in the figure, and assemble the clutch hub.



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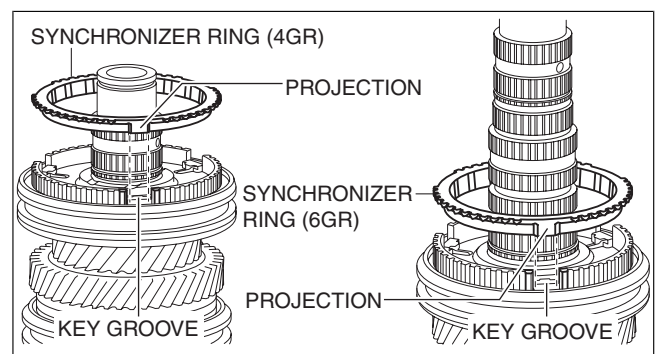
2. After the synchronizer key is assembled, verify that the detent ball of the synchronizer key is engaged with the positioning groove of the clutch hub sleeve.



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Synchronizer Ring Assembly Note

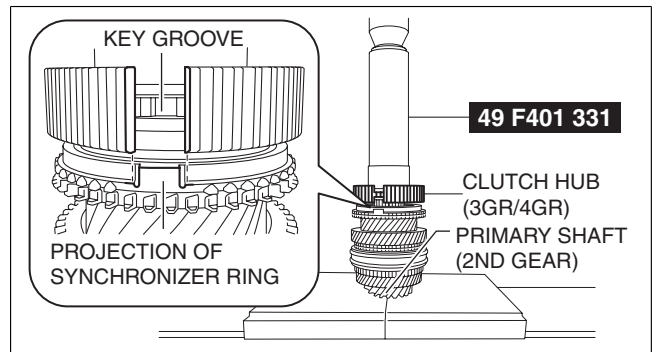
1. Align the projection of the synchronizer ring with the key groove of the clutch hub as shown in the figure, and assemble the synchronizer ring.



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Clutch Hub (3GR/4GR) Assembly Note

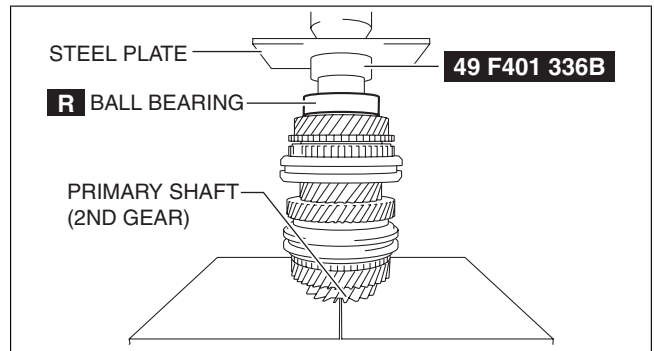
1. Set the primary shaft component and **SST** in a press as shown in the figure.
2. Align the projection of the synchronizer ring with the key groove of the clutch hub (3GR/4GR).
3. Assemble the clutch hub (3GR/4GR) using the press.



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Ball Bearing (Transaxle Case Side) Assembly Note

1. Set the primary shaft component, new ball bearing, **SST**, and an appropriate steel plate in a press as shown in the figure.
2. Assemble the ball bearing using the press.



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