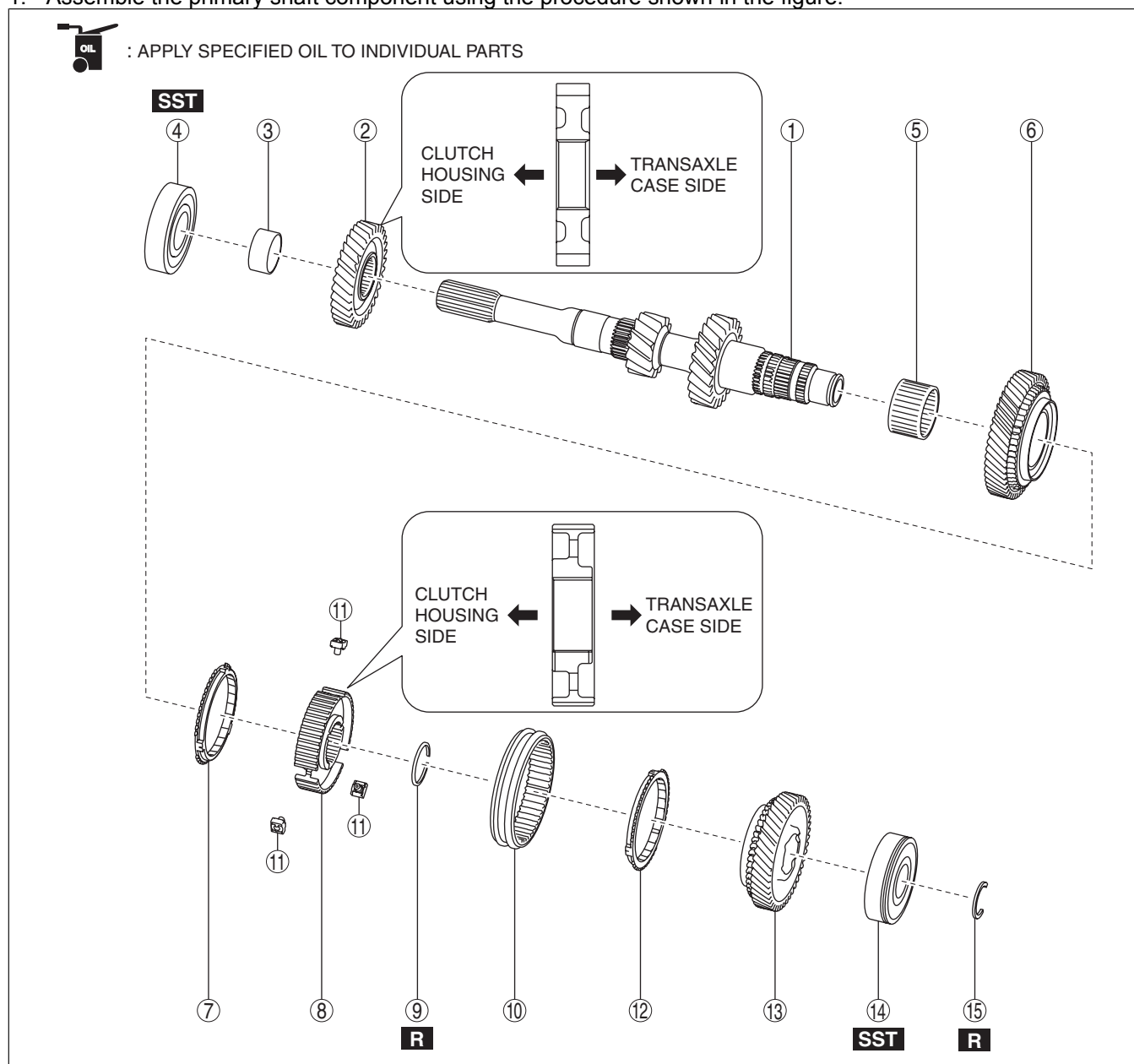


PRIMARY SHAFT COMPONENT ASSEMBLY

id051500175900

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



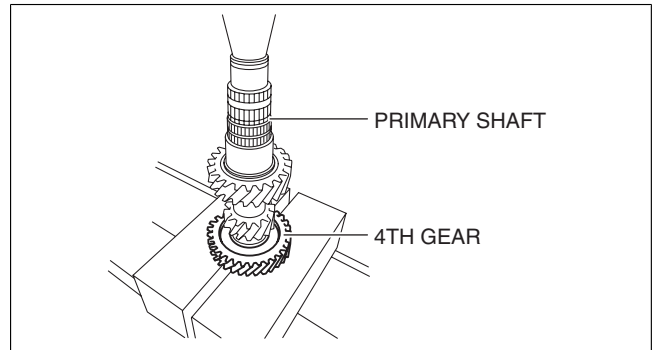
bd62zm00000045

1	Primary shaft
2	4th gear (See 4th Gear Assembly Note.)
3	Spacer
4	Ball bearing (clutch housing side) (See Ball Bearing (Clutch Housing Side) Assembly Note.)
5	Needle bearing
6	6th gear
7	Synchronizer ring (6GR)
8	Clutch hub (See Clutch Hub Assembly Note.)
9	Clip

10	Clutch hub sleeve (See Clutch Hub Sleeve Assembly Note.)
11	Synchronizer key (See Synchronizer Key Assembly Note.)
12	Synchronizer ring (5GR) (See Synchronizer Ring (5GR) Assembly Note.)
13	5th gear
14	Ball bearing (transaxle case side) (See Ball Bearing (Transaxle Case Side) Assembly Note.)
15	Clip

4th Gear Assembly Note

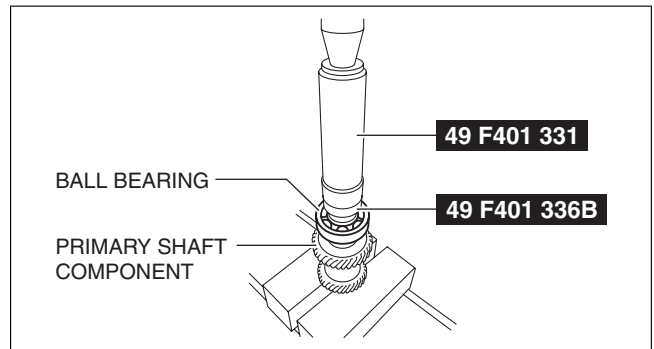
1. Set the primary shaft and 4th gear in a press as shown in the figure.
2. Assemble the 4th gear using the press.



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Ball Bearing (Clutch Housing Side) Assembly Note

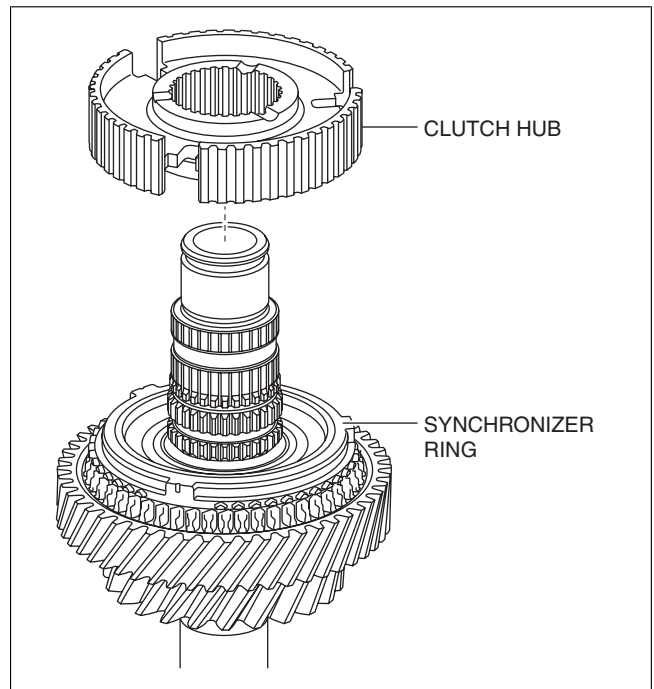
1. Set the primary shaft component and the ball bearing, and the **SSTs** in a press as shown in the figure.
2. Assemble the ball bearing using the press.



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Clutch Hub Assembly Note

1. Put the clutch hub on the synchronizer ring.

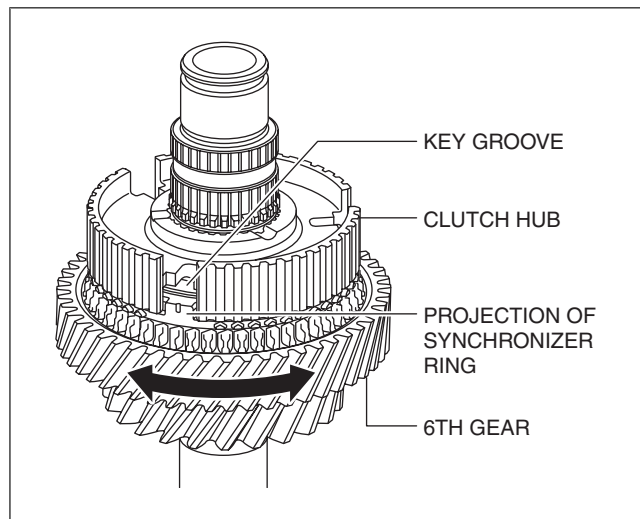


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2. By rotating the 6th gear in the drive direction, align the key groove of the clutch hub with the projection of the synchronizer ring and assemble the clutch hub.

Note

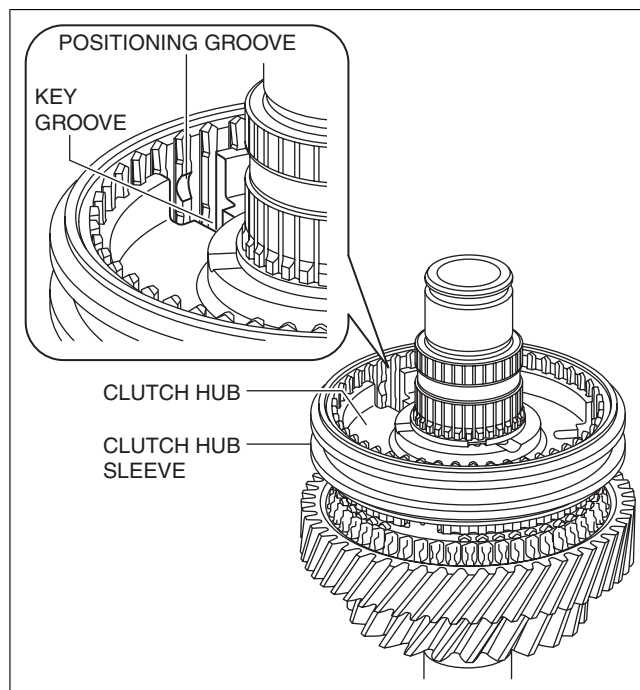
- When the 6th gear is rotated, the synchronizer ring is rotated by the friction force.
- When the key groove of the clutch hub and the projection of the synchronizer ring are aligned, the clutch hub drops by its own weight and engages with the synchronizer ring.



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Clutch Hub Sleeve Assembly Note

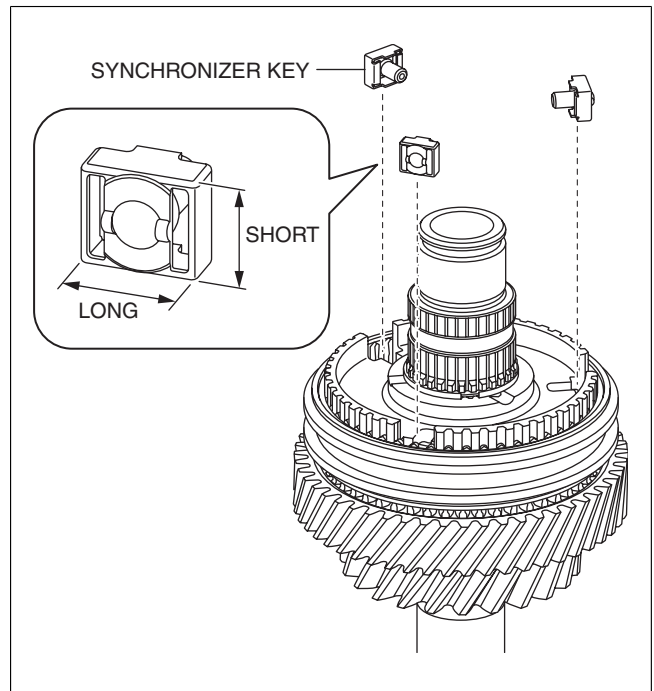
1. Align the positioning groove of the clutch hub sleeve so that it is lined up with the center of the key groove of the clutch hub, and assemble the clutch hub sleeve.



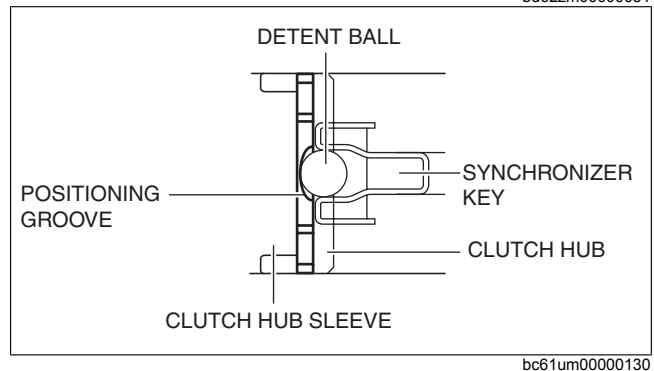
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Synchronizer Key Assembly Note

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

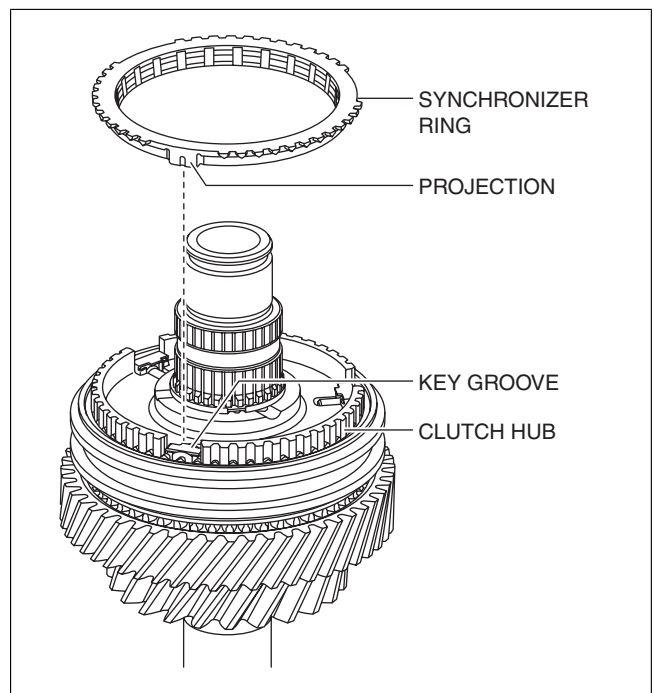


2. After the synchronizer key is assembled, verify that the detent ball of the synchronizer key is engaged with the positioning groove of the clutch hub sleeve.



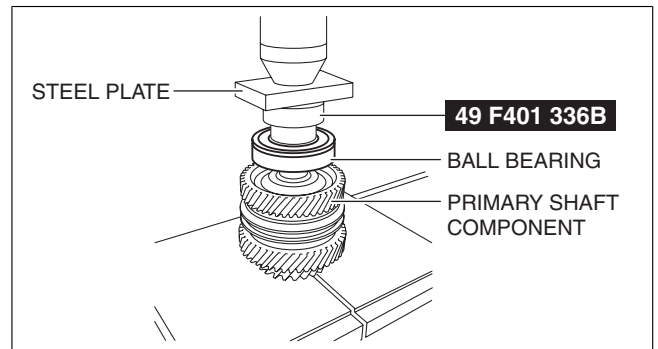
Synchronizer Ring (5GR) Assembly Note

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.

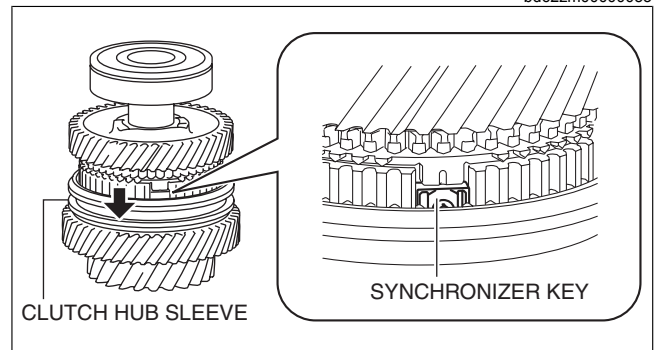


Ball Bearing (Transaxle Case Side) Assembly Note

1. Set the primary shaft component, ball bearing, **SST**, and an appropriate steel plate in a press as shown in the figure.
2. Move the clutch hub sleeve in the axial direction while pressing the 5th gear by hand so that it does not move, and verify that the synchronizer key is assembled correctly.
3. Assemble the ball bearing using the press.



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