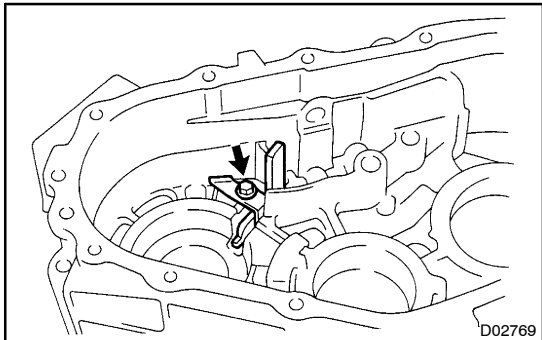


## REASSEMBLY

### HINT:

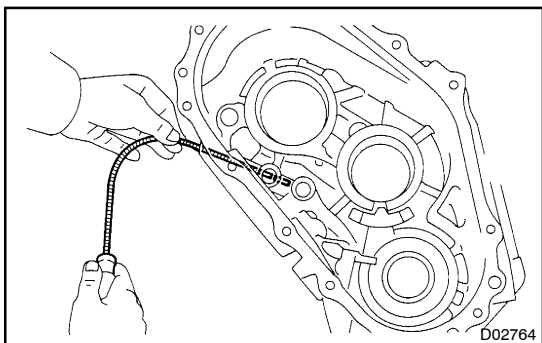
Coat all of the sliding and rotating surfaces with gear oil before reassembly.



### 1. INSTALL OIL RECEIVER

Install the oil receiver to the front case with the bolt.

**Torque: 12 N·m ( 120 kgf·cm, 9 ft·lbf)**



### 2. INSTALL STARTING PIN

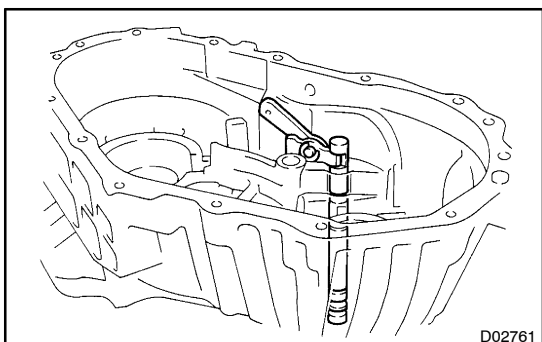
Using a magnetic finger, install the straight pin to the front case.

### 3. INSTALL SHIFT INNER LEVER AND SHIFT INNER LEVER SHAFT

- (a) Assemble the shift inner lever and the shift inner lever shaft with the E -ring.
- (b) Install the shift inner lever and shift inner lever shaft to the front case.

### 4. INSTALL FRONT DRIVE SHIFT FORK SHAFT

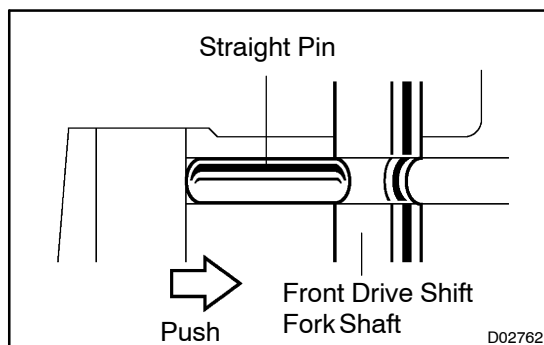
- (a) Using pliers, install the snap ring to the front drive shift fork shaft.



- (b) Install the front drive shift fork shaft to the front case.

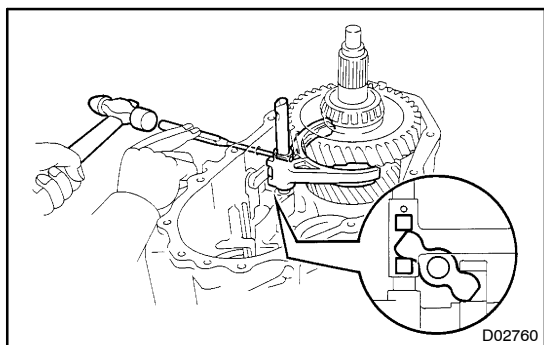
### NOTICE:

- **Set the shift inner lever into the fork head part of the front drive shift fork shaft securely.**



- After installing the front drive shift fork shaft, push the straight pin in the groove of the front drive shift fork shaft, as shown in the illustration.

## 5. INSTALL OUTPUT SHAFT ASSEMBLY TO FRONT CASE



## 6. INSTALL NO. 1 SHIFT FORK AND HIGH AND LOW SHIFT FORK SHAFT

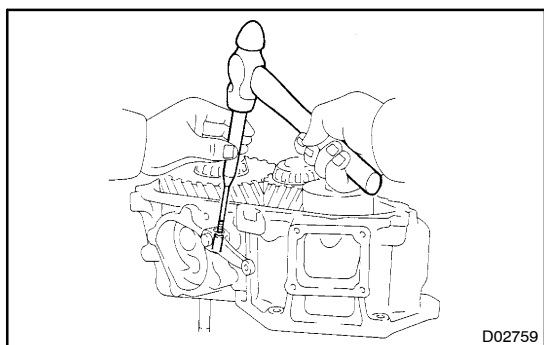
- (a) Install the No. 1 shift fork and the high and low shift fork shaft.

### NOTICE:

Set the shift inner lever into the fork head part of the No. 1 shift fork securely.

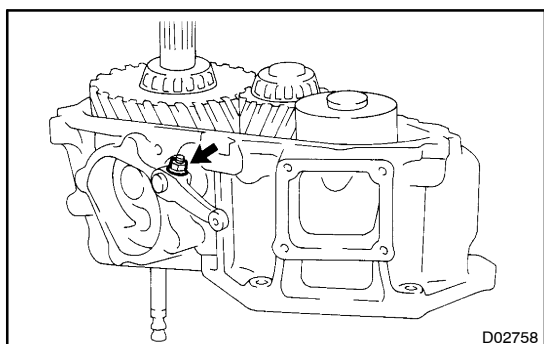
1

- (b) Using a pin punch and hammer, drive in the slotted spring pin to the No. 1 shift fork.



## 7. INSTALL SHIFT OUTER LEVER

- (a) Install the shift outer lever to the shift inner lever.  
(b) Using a pin punch and hammer, drive in the lever lock pin.



- (c) Install the washer and nut.

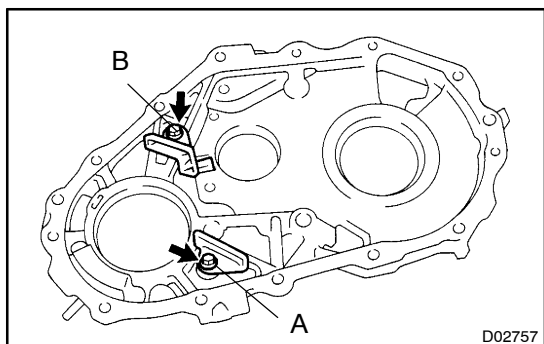
**Torque: 12 N·m ( 120 kgf·cm, 9 ft·lbf)**

## 8. INSTALL IDLER GEAR ASSEMBLY TO FRONT CASE

### HINT:

If it is difficult to install the idler gear assembly, pull up the output shaft assembly.

## 9. INSTALL INPUT SHAFT ASSEMBLY TO FRONT CASE



## 10. INSTALL OIL RECEIVER PIPE

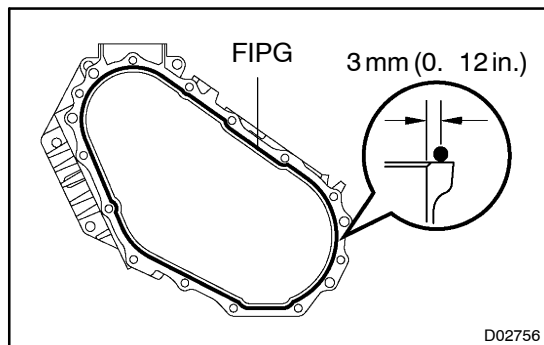
Install the 2 oil receiver pipes to the rear case with the 2 bolts.

### Torque:

**Bolt A: 12 N·m ( 120 kgf·cm, 9 ft·lbf)**

**Bolt B: 18 N·m ( 185 kgf·cm, 13 ft·lbf)**

## 11. INSTALL 2 BEARING OUTER RACES TO REAR CASE

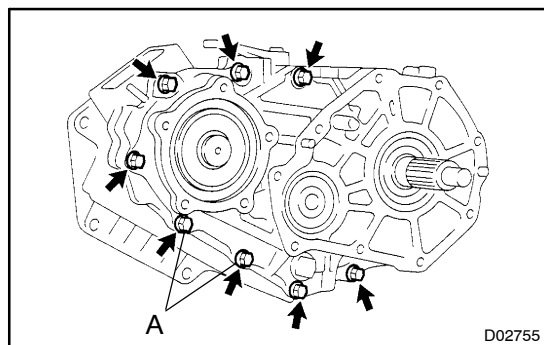


## 12. ASSEMBLE FRONT CASE AND REAR CASE

- (a) Apply FIPG to the front case.

**FIPG:**

**Part No. 08826 -00090, THREE BOND 1280 or equivalent**

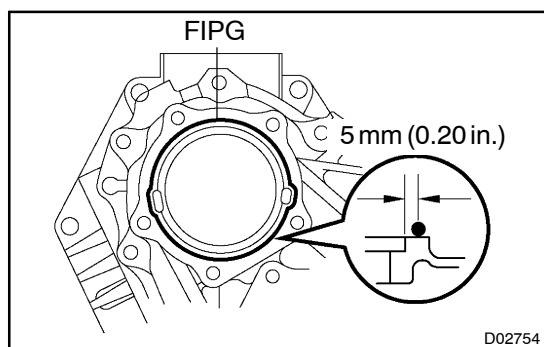


- (b) Apply sealant to the "A" bolt threads.

**Sealant:**

**Part No. 08833 -00080, THREE BOND 1344, LOCTITE 242 or equivalent**

- (c) Install the rear case to the front case with the 8 bolts.  
**Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)**
- (d) Using a snap ring expander, install the snap ring to the input shaft.

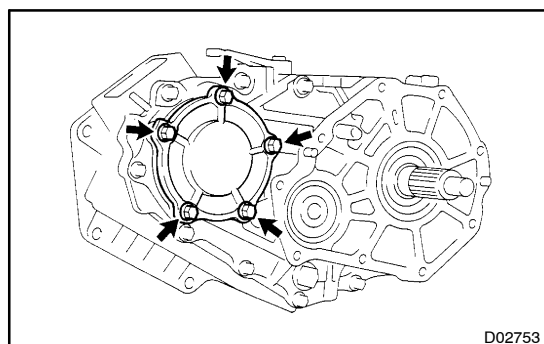


## 13. INSTALL CASE COVER

- (a) Apply FIPG to the rear case.

**FIPG:**

**Part No. 08826 -00090, THREE BOND 1281 or equivalent**

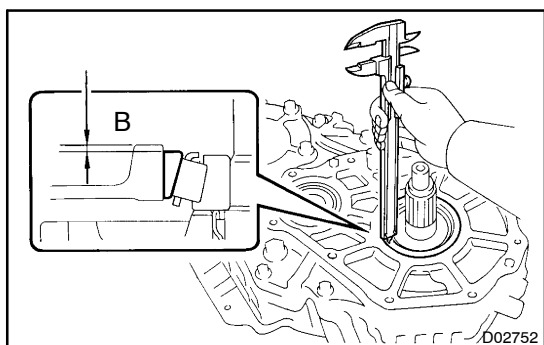


- (b) Apply sealant to the bolt threads.

**Sealant:**

**Part No. 08833 -00080, THREE BOND 1344, LOCTITE 242 or equivalent**

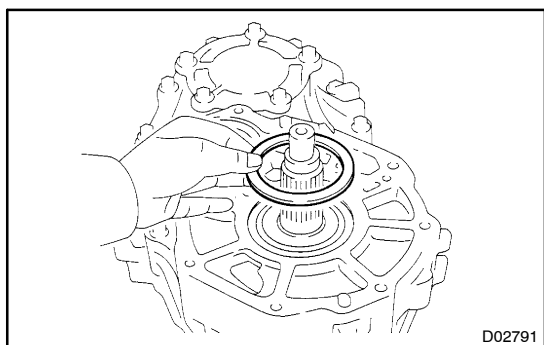
- (c) Install the case cover to the rear case with the 5 bolts.  
**Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)**



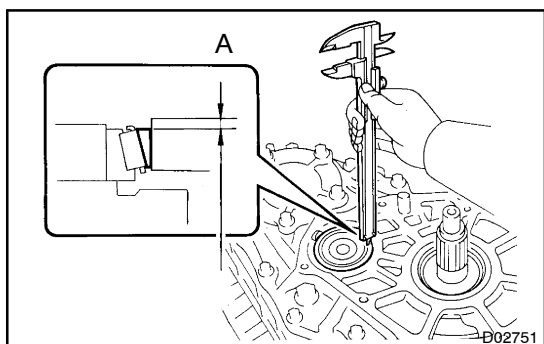
#### 14. SELECT ADJUSTING SHIM FOR OUTPUT SHAFT TAPER ROLLER BEARING

- Using vernier calipers, measure the clearance of the dimension "B".
- Lightly hold down the bearing outer race in the thrust direction to eliminate any looseness before making the measurement.
- Calculate the required thickness of the adjusting shim.  
**Thickness: Dimension "B" + [0.070 - 0.034 mm (0.0028 - 0.0013 in.)]**
- From the following table, select a shim so that its thickness is within the range of the calculation.

| Mark | Thickness mm (in.) | Mark | Thickness mm (in.) |
|------|--------------------|------|--------------------|
| 2    | 0.30 (0.0 118)     | 8    | 1.80 (0.0709)      |
| 3    | 0.45 (0.0 177)     | 9    | 2.00 (0.0787)      |
| 4    | 1.00 (0.0394)      | 10   | 2.20 (0.0866)      |
| 5    | 1.20 (0.0472)      | 11   | 2.40 (0.0945)      |
| 6    | 1.40 (0.055 1)     | 12   | 2.60 (0. 1024)     |
| 7    | 1.60 (0.0630)      | 13   | 0.55 (0.02 16)     |



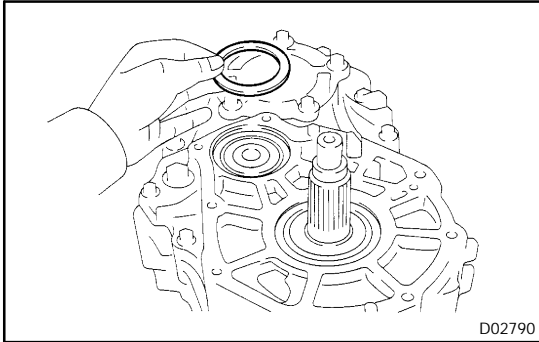
#### 15. INSTALL ADJUSTING SHIM FOR OUTPUT SHAFT TAPER ROLLER BEARING



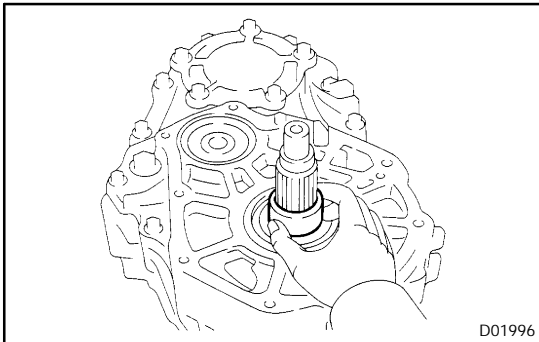
#### 16. SELECT ADJUSTING SHIM FOR IDLER GEAR TAPER ROLLER BEARING

- Using vernier calipers, measure the clearance of the dimension "A".
- Lightly hold down the bearing outer race in the thrust direction to eliminate any looseness before making the measurement.
- Calculate the required thickness of the adjusting shim.  
**Thickness: Dimension "A" + [0.0 14 - 0.042 mm (0.0006 - 0.0017 in.)]**
- From the following table, select a shim so that its thickness is within the range of the calculation.

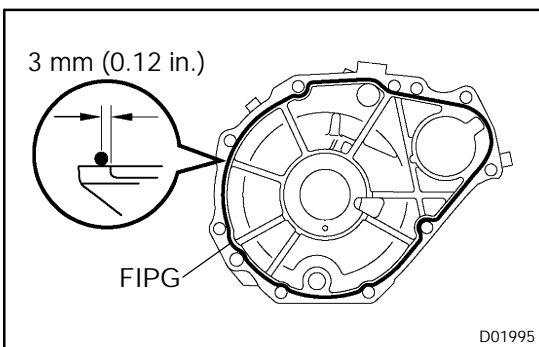
| Mark | Thickness mm (in.) | Mark | Thickness mm (in.) |
|------|--------------------|------|--------------------|
| 2    | 0.30 (0.0 118)     | 8    | 3.20 (0. 1260)     |
| 3    | 0.45 (0.0 177)     | 9    | 3.40 (0. 1339)     |
| 4    | 2.40 (0.0945)      | 10   | 3.60 (0. 1417)     |
| 5    | 2.60 (0. 1024)     | 11   | 3.80 (0. 1496)     |
| 6    | 2.80 (0. 1102)     | 12   | 4.00 (0. 1575)     |
| 7    | 3.00 (0. 1181)     | 13   | 0.55 (0.02 16)     |



**17. INSTALL ADJUSTING SHIM FOR IDLER GEAR TAPER ROLLER BEARING**



**18. INSTALL SPACER TO OUTPUT SHAFT**

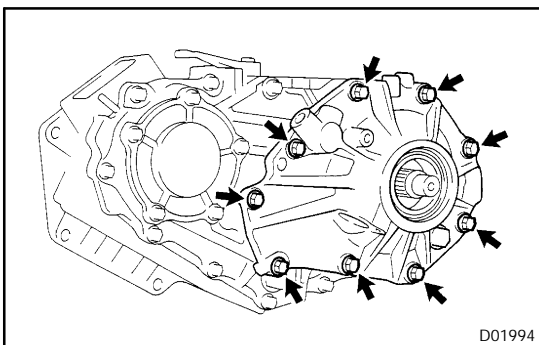


**19. INSTALL REAR EXTENSION HOUSING**

(a) Apply FIPG to the rear extension housing.

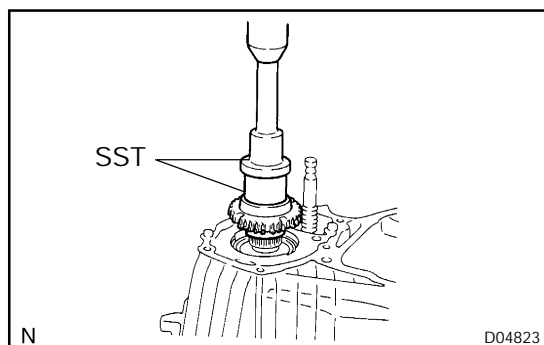
**FIPG:**

**Part No. 08826-00090, THREE BOND 1281 or equivalent**



(b) Install the rear extension housing with the 9 bolts.

**Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)**



## 20. INSTALL FRONT DRIVE GEAR PIECE

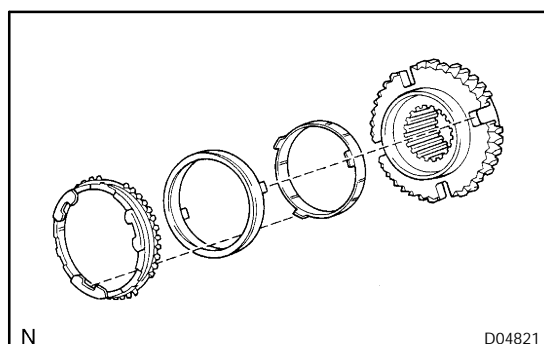
- (a) Using SST and a press, install the front drive gear piece to the output shaft.

SST 09517-12010, 09631-20081

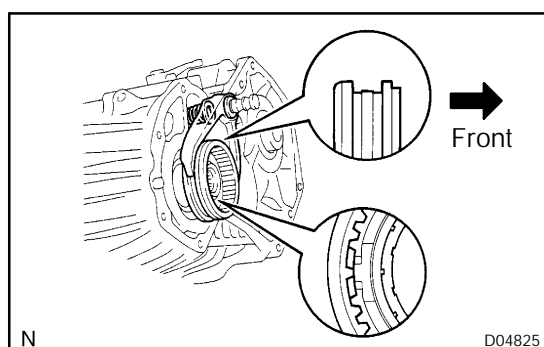
- (b) Select a snap ring that allows the minimum axial play.

| Mark | Thickness mm (in.) | Mark | Thickness mm (in.) |
|------|--------------------|------|--------------------|
| A    | 2.00 (0.0787)      | D    | 2.30 (0.0906)      |
| B    | 2.10 (0.0827)      | E    | 2.40 (0.0945)      |
| C    | 2.20 (0.0866)      | –    | –                  |

- (c) Using a snap ring expander, install a new snap ring.



## 21. INSTALL NO. 2 SYNCHRONIZER INNER RING, NO. 2 SYNCHRONIZER MIDDLE RING AND NO. 2 SYNCHRONIZER OUTER RING



## 22. INSTALL FRONT DRIVE CLUTCH SLEEVE AND NO. 2 SHIFT FORK

- (a) Install the front drive clutch sleeve, compression spring, 2 plate washers and No. 2 shift fork.

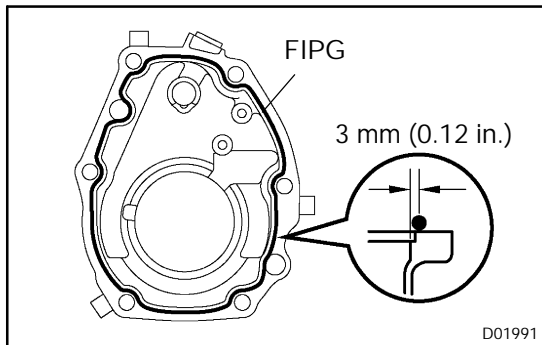
**HINT:**

Make sure to install the front drive clutch sleeve in the correct direction.

**NOTICE:**

**Assemble the front drive clutch sleeve and No. 2 synchronizer outer ring securely to ensure they are in the position as shown in the illustration.**

- (b) Using pliers, install the snap ring to the front drive shift fork shaft.

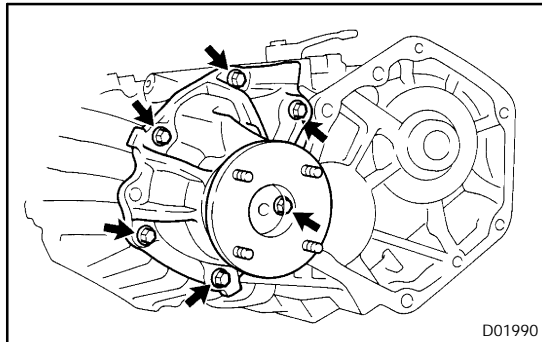


### 23. INSTALL FRONT EXTENSION HOUSING

- (a) Apply FIPG to the front extension housing.

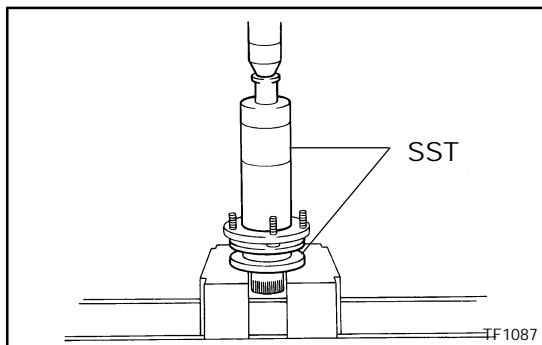
**FIPG:**

**Part No. 08826-00090, THREE BOND 1281 or equivalent**



- (b) Install the front extension housing with the 6 bolts.

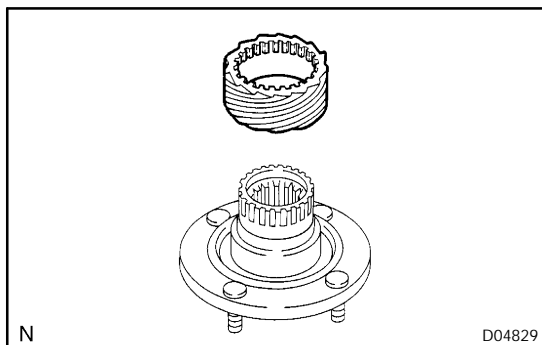
**Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)**



### 24. INSTALL OUTPUT SHAFT COMPANION FLANGE

- (a) Using SST and a press, install the dust deflector to the companion flange.

SST 09316-20011, 09316-60011 (09316-00011)

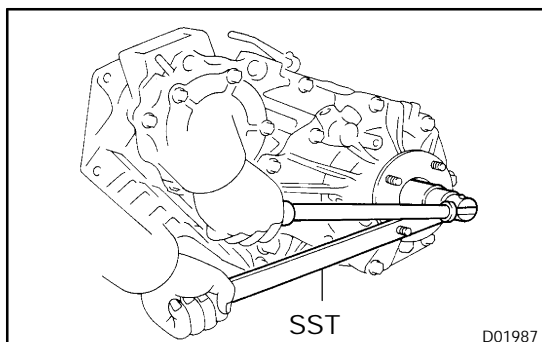


- (b) Install the speed sensor drive gear to the companion flange.

**HINT:**

Align the companion flange grooves with the projections on the speed sensor drive gear.

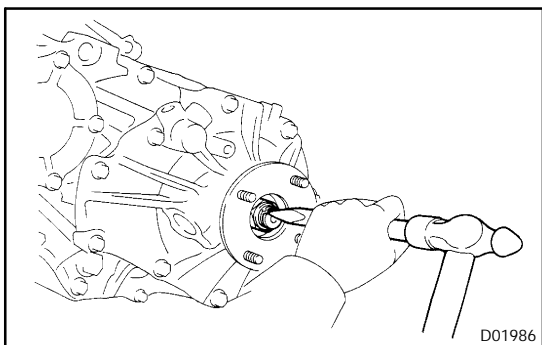
- (c) Install the companion flange.



- (d) Using SST to hold the flange, install a new O-ring and nut.

SST 09330-00021

**Torque: 127 N·m (1,300 kgf·cm, 94 ft·lbf)**

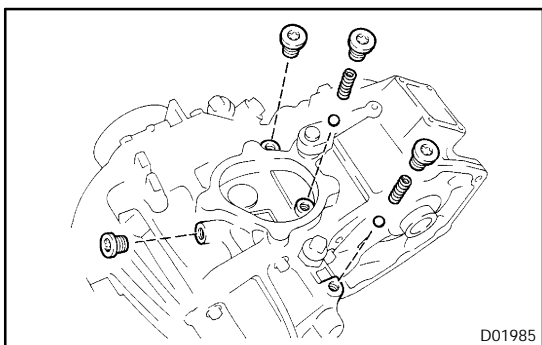


(e) Using a chisel and hammer, stake the nut.

## 25. INSTALL TRANSFER INDICATOR SWITCH

Install 3 new gaskets, transfer 4WD position switch, L4 position switch and neutral position switch.

**Torque: 37 N·m (380 kgf·cm, 27 ft·lbf)**



## 26. INSTALL SCREW PLUG, SPRING AND BALL

(a) Install the 2 balls and springs.

(b) Apply sealant to the screw plug threads.

**Sealant:**

**Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent**

(c) Using a torx socket wrench (T40), install the 4 screw plugs.

**Torque: 19 N·m (190 kgf·cm, 14 ft·lbf)**

## 27. INSTALL SPEED SENSOR DRIVEN GEAR

Install the speed sensor driven gear with the bolt.

**Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)**

## 28. INSTALL BREATHER HOSE