

3. Remove 4th gear using press VW 400 with VW 401 and tools P 65, VW 401, and VW 412.

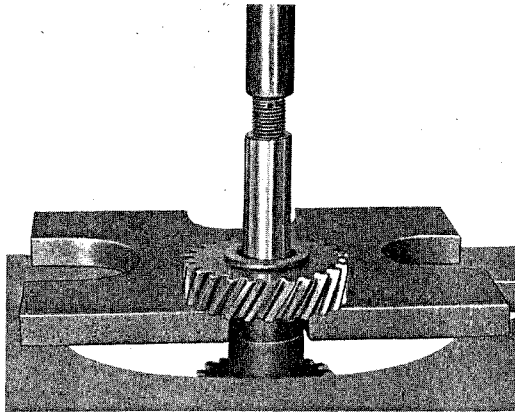


Fig. 73

4. Remove 2nd and 3rd gear.

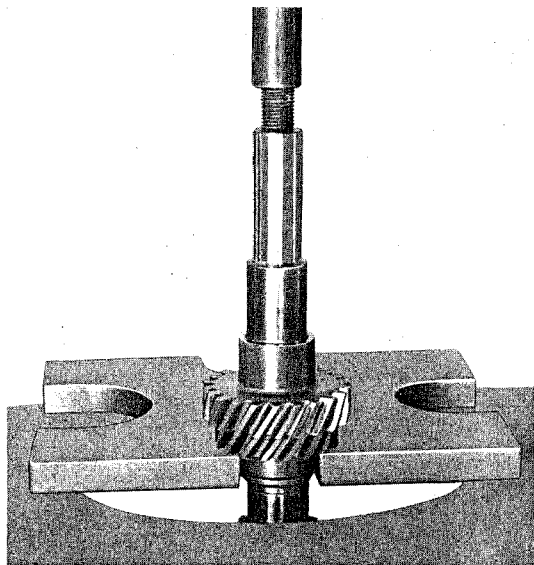


Fig. 74

#### Note

Gears for 2nd, 3rd, and 4th speed can only be exchanged in pairs.

#### Assembly

The assembly is accomplished in the reverse order of disassembly observing the following points:

#### Note

Heat gears in oil bath to 150° C (300° F). Ball bearings and gears must have a press fit.

1. Install key for gears.
2. Install heated gears in the following order: 2nd, 3rd, and 4th, and press tight using P 45 and VW 400.
3. Install inner ball bearing race using press VW 400 with VW 401 and VW 409.

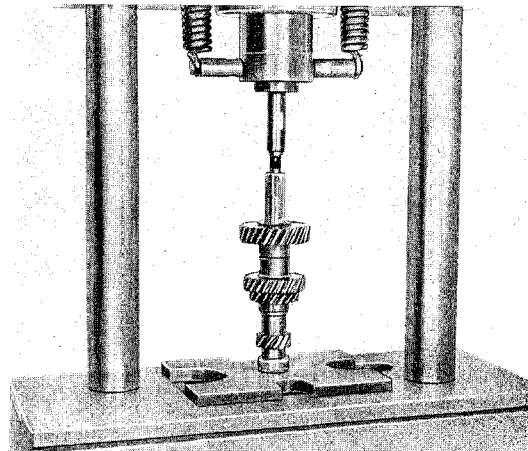


Fig. 75

4. Install lock ring.