16. Install 4th gear.
17. Install thrust washer 2 mm.
18. Install spacer 4 mm.

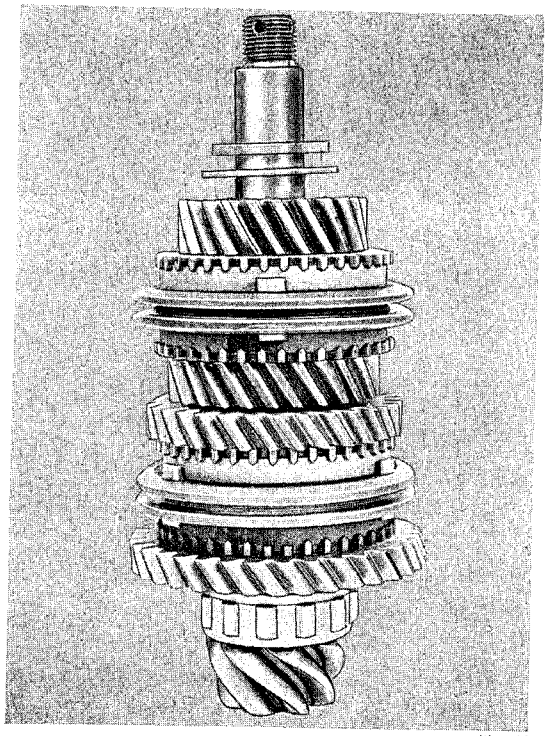

Fig. 66

19. Place assembled pinion shaft in stand P 31, using P 31a and P 40 tighten castle nut to 16 mkg (115 ft. lb.) torque. Loosen nut.

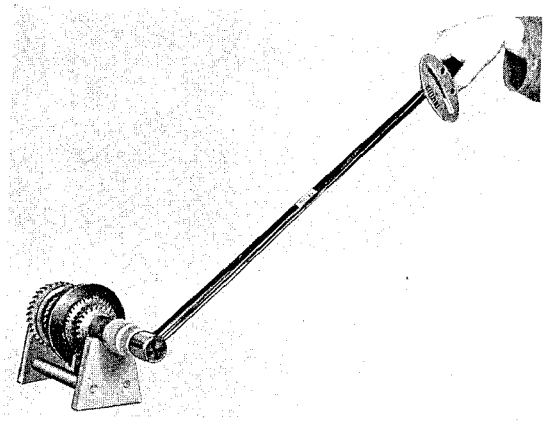

Fig. 67

20. Install sliding sleeve for 3rd and 4th gear.

Note

1st and 2nd gears each have double row caged roller bearings. The 3rd and 4th gears employ single row needle bearings. The 4th gear needle bearing is offset so that the needles are centered under the gear teeth while the 3rd gear needle bearing is symmetrical. Correct end play:

1st gear 0.25 to 0.35 mm (.0098 to .0138 in.). 2nd, 3rd, 4th gear 0.20 to 0.30 mm (.0079 to .0118 in.).

Arrangement of Reverse Gears

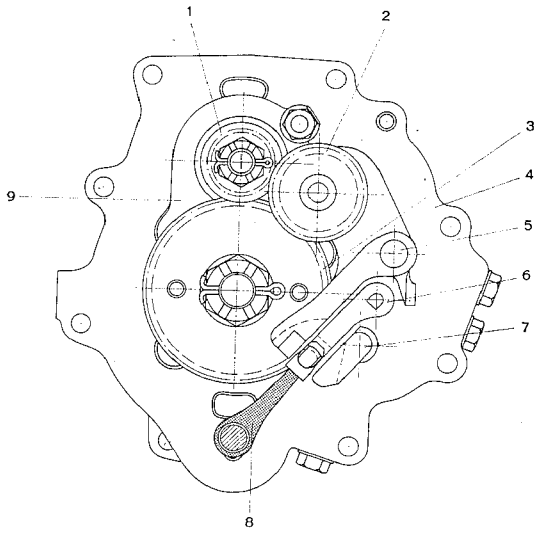

Fig. 68

① Gear I with 15 teeth, on the main shaft (one key)
② Gear II double gear with 10 and 20 teeth is on a seperate shaft
③ Gear III 40 teeth on the pinion shaft has two keys Ratio of reverse gear: 1:3.56
④ Intermediate plate
⑤ Selector rod for reverse gear
⑥ Selector rod for 1st and 2nd gear
⑦ Selector rod for 3rd and 4th gear
⑧ Selector finger
⑨ Bearing cover plate