

**PRECAUTION**

- a.** Before disassembling the transfer assembly, thoroughly clean it to remove any foreign matter. This will help prevent contamination during disassembly and reassembly.
- b.** When removing the transfer cover or any other light alloy parts, do not pry them off with a screwdriver or other tool that may cause damage. Instead, tap the parts with a plastic-faced hammer.
- c.** Always arrange removed parts in the order they were removed and protect them from foreign matter.
- d.** Before installation of each part, thoroughly clean and dry it. Then apply transfer oil to it. Do not use alkaline chemicals to clean aluminum parts, rubber parts or ring gear set bolts. Also, do not use non-residue solvent or other cleaning oils to clean O-rings, oil seals or rubber parts.
- e.** Coat sliding surfaces and rotating parts with transfer oil.
- f.** Do not fix a part directly in a vise. Place aluminum plates between the part and vise.
- g.** Replace any damaged or deformed snap rings with new ones.
- h.** Do not allow the case mating surfaces to be scratched. Scratches may lead to oil leakage.
- i.** Using a razor blade and gasket scraper, remove old FIPG from the sealing surface.
- j.** Clean all parts to remove excess FIPG completely.
- k.** Clean the sealing surface with solvent so that no residue remains on the sealing surface.
- l.** Apply FIPG in a continuous line of approximately 1.2 mm (0.0472 in.) in diameter along the sealing surface.
- m.** Be sure to assemble parts within 10 minutes of FIPG application. Otherwise, the FIPG must be removed and reapplied.
- n.** After sealing parts, do not allow oil to come into contact with the seal for at least 1 hour.
- o.** Do not allow scratches on surfaces which contact oil seals or gaskets. Scratches may lead to oil leakage.
- p.** When press-fitting an oil seal, be careful not to damage the lip of the oil seal or its periphery.