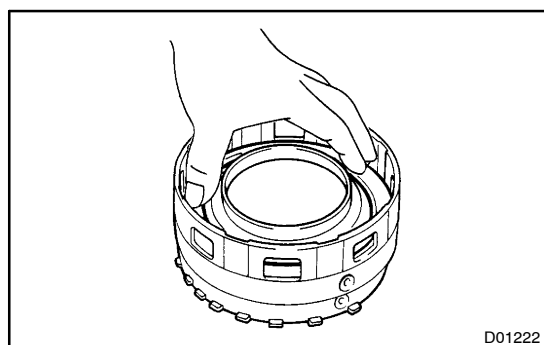


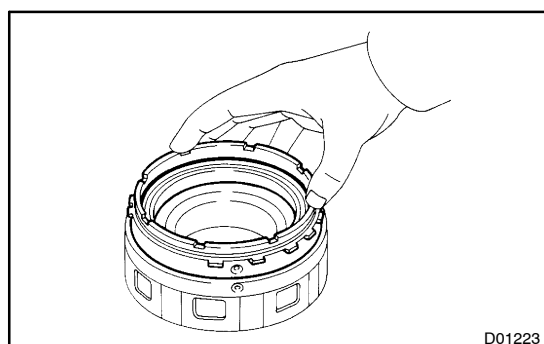
## REASSEMBLY

### 1. INSTALL 3RD & 2ND PISTON

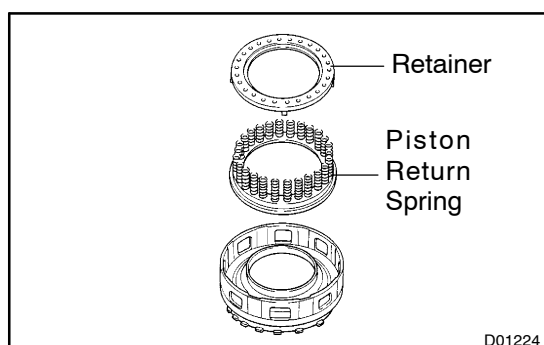
- (a) Coat 4 new O-rings with ATF and install them on 3rd and 2nd brake pistons.



- (b) Being careful not to damage the O-rings, press the 3rd brake piston into the brake drum with both hands.

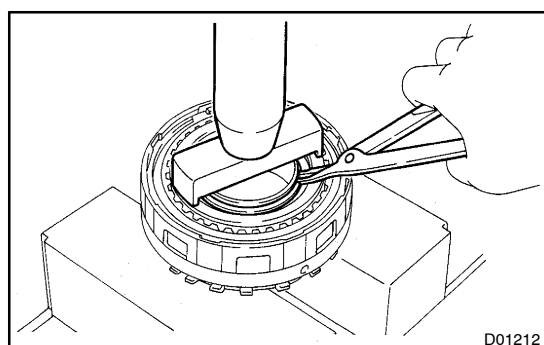


- (c) Being careful not to damage the O-rings, press the 2nd brake piston into the brake drum with both hands.



### 2. INSTALL PISTON RETURN SPRING

- (a) Install the piston return spring.
- (b) Install the piston retainer.



- (c) Place SST on the spring retainer, and compress the return spring with a press.

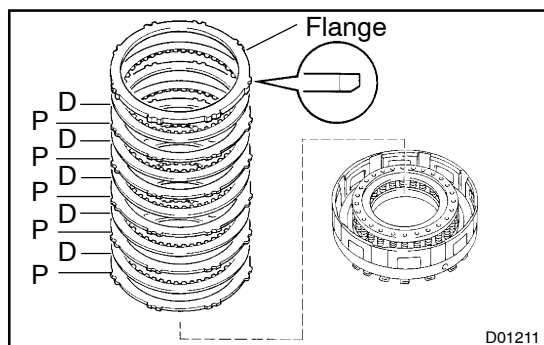
SST 09350-32014 (09350-32040)

- (d) Using SST, install the snap ring.

SST 09350-30020 (09350-07070)

#### NOTICE:

Be sure the end gap of the snap ring is not aligned with the spring retainer claw.



### 3. INSTALL PLATE, DISC AND FLANGE

- (a) Install the 5 plates and 5 discs.

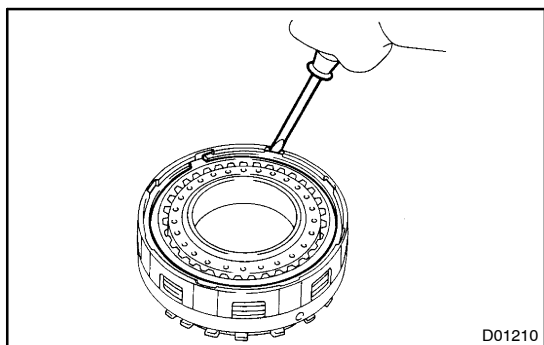
**Install in order: P = Plate, D = Disc**

**P – D – P – D – P – D – P – D – P – D**

- (b) Install the flange, with the Facing its bevelled part downward.

**HINT:**

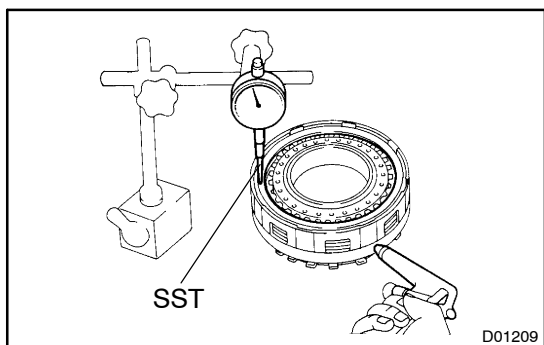
Assemble the flange to the brake drum with facing a carved mark on the flange upward.



- (c) Using a screwdriver, install the snap ring.

**NOTICE:**

Be sure the end gap of the snap ring is not aligned with cutout portion of the brake drum.



### 4. CHECK PISTON STROKE OF 3RD BRAKE PISTON

Using SST and a dial indicator, measure the 3rd piston stroke while applying and releasing compressed air (392 kPa, 4 kgf/cm<sup>2</sup>, 57 psi).

SST 09350-30020 (09350-06120)

**Piston stroke:**

**0.70 – 1.00 mm (0.028 – 0.039 in.)**

**NOTICE:**

**Do not applying compressed air into the 2nd brake piston hole.**

If the piston stroke is less than the limit of piston stroke, parts may have been assembled incorrectly, so check and reassemble again.

If the clearance is non-standard, select another flange.

**HINT:**

There are 6 different flanges in thickness.

**Flange thickness: mm (in.)**

No.	Thickness	No.	Thickness
36	3.6 (0.142)	39	3.9 (0.154)
37	3.7 (0.146)	40	4.0 (0.157)
38	3.8 (0.150)	41	4.1 (0.161)