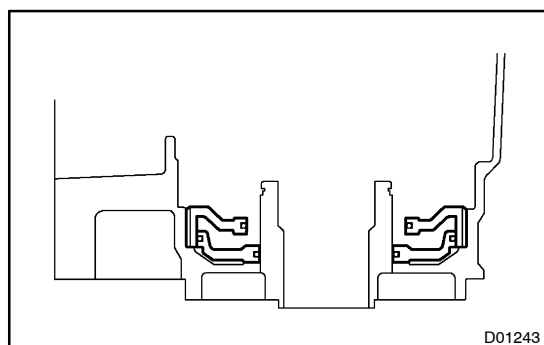


REASSEMBLY

1. INSTALL NO. 1 BRAKE PISTON

- Coat 3 new O-rings with ATF.
- Install the 2 O-rings on No. 1 brake piston.
- Install the O-ring on the reaction sleeve.
- Install the No. 1 brake piston to the reaction sleeve.

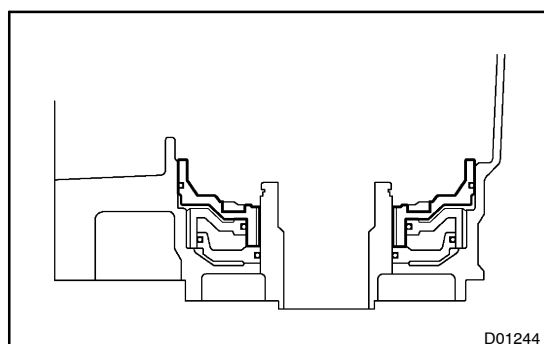


2. INSTALL REACTION SLEEVE AND NO. 1 BRAKE PISTON TO TRANSMISSION CASE

With the No. 1 brake piston underneath (the rear side), install the brake reaction sleeve and No. 1 brake piston to the transmission case.

NOTICE:

Be careful not to damage the O-rings.

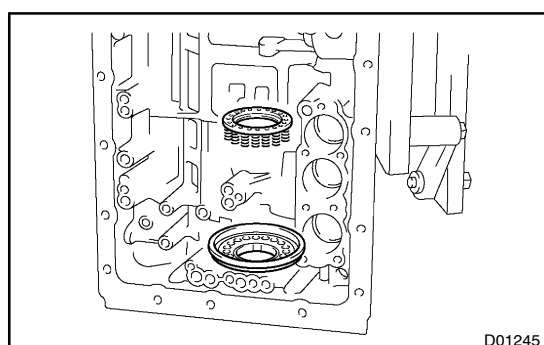


3. INSTALL NO. 2 BRAKE PISTON

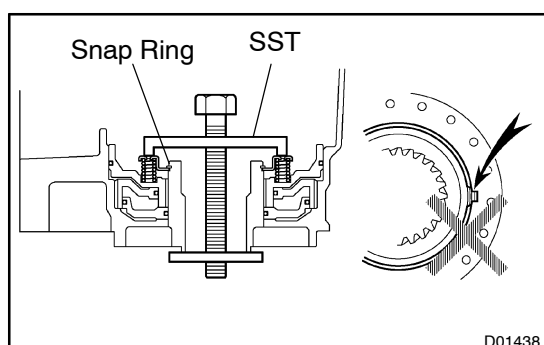
- Coat new O-ring with ATF.
- Install the O-ring on No. 2 brake piston.
- With the spring seat of the piston upwards (the front side), place the piston in the transmission case.

NOTICE:

Be careful not to damage the O-ring.



- Place the piston return spring onto the No. 2 brake piston.



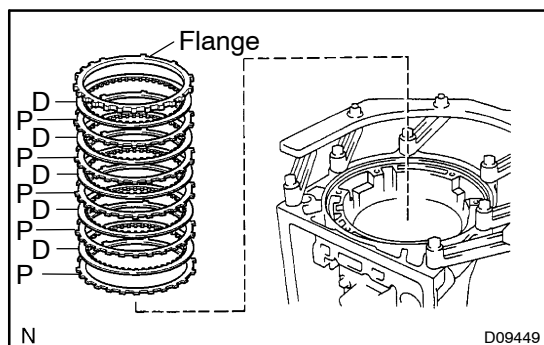
4. INSTALL PISTON RETURN SPRING

- Place SST on the spring retainer and compress the return spring.

SST 09350-30020 (09350-07050)

- Using SST, install the snap ring.

SST 09350-30020 (09350-07070)

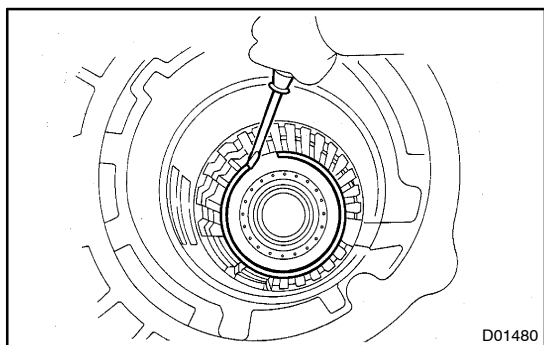


5. INSTALL PLATE, DISC AND FLANGE

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

Install in order: P = Plate, D = Disc

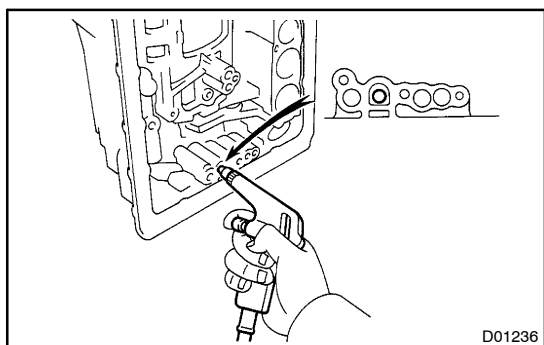
P – D – P – D – P – D – P – D – P – D



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

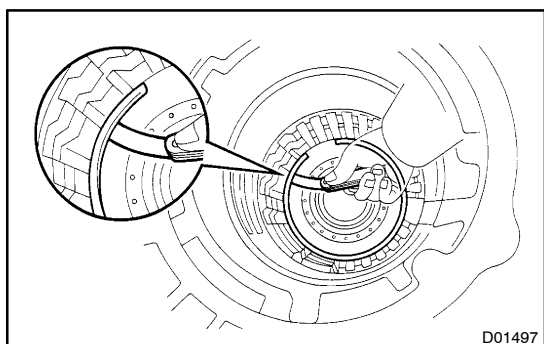
NOTICE:

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



6. CHECK PACK OPERATION OF 1ST & REVERSE BRAKE

- (a) Make sure the 1st & reverse brake pistons move smoothly when applying and releasing the compressed air (392 kPa, 4 kgf/cm², 57 psi) into the transmission case.



- (b) Using feeler gauge, measure 1st & reverse brake pack clearance between the snap ring and the flange.

Pack clearance: 0.50 – 0.80 mm (0.020 – 0.031 in.)

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

If the stroke is non-standard, select another plate.

HINT:

There are 13 different plates in thickness for the bottom plate. For the other plates, the thickness is 1.8 mm (0.071 in.).

Plate thickness: mm (in.)

No.	Thickness	No.	Thickness
01	1.8 (0.071)	08	2.5 (0.098)
02	1.9 (0.075)	09	2.6 (0.102)
03	2.0 (0.079)	10	2.7 (0.106)
04	2.1 (0.083)	11	2.8 (0.110)
05	2.2 (0.087)	12	2.9 (0.114)
06	2.3 (0.090)	13	3.0 (0.118)
07	2.4 (0.094)	–	–