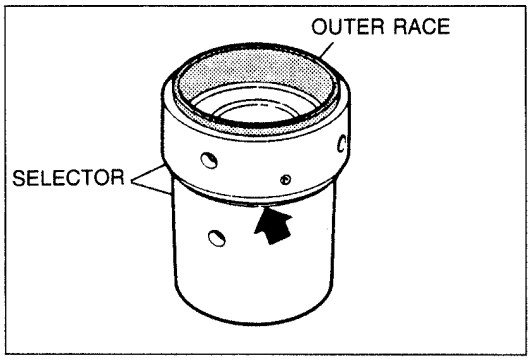
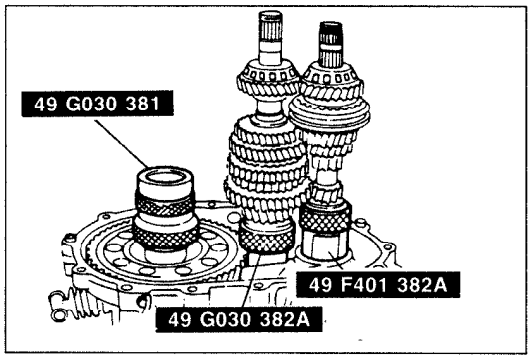


03U0J2-069

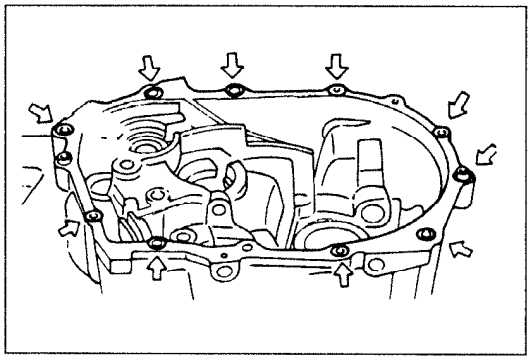
1. Install the primary and secondary shaft bearing outer races into the transaxle case (diaphragm springs and shims removed).
2. Mount the clutch housing onto the transaxle hanger, and set the differential bearing outer race into the clutch housing. Position a piece of pipe against the outer race and tap in with a hammer until it contacts the clutch housing.
3. Set the outer races into the **SST** (selector) as shown in the figure.

Note
- **Turn the selector to eliminate the gap indicated by the arrow in the figure.**



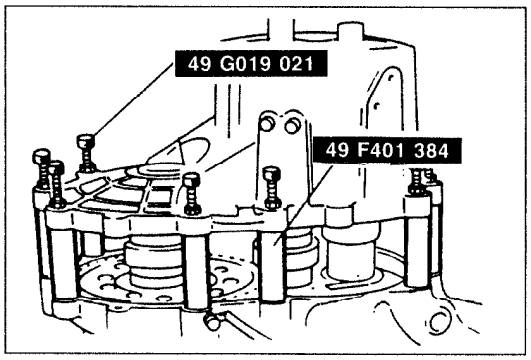
03U0J2-070

4. Set the differential assembly into the clutch housing; then set the bearing outer race and the **SST** (selector) on the differential. Set the assembled selectors for the primary and secondary shaft in the clutch housing.
   Mount the shaft gear assemblies as shown in the figure.



86U07A-253

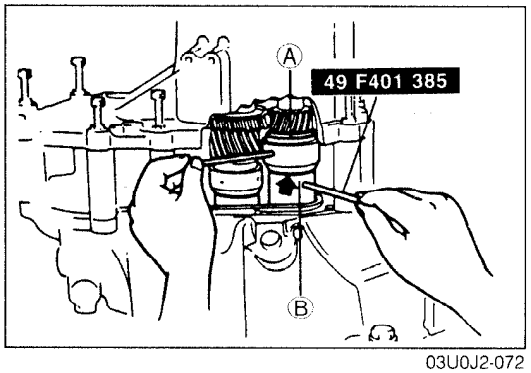
5. Set the **SST** (collars) in the positions shown in the figure.



03U0J2-071

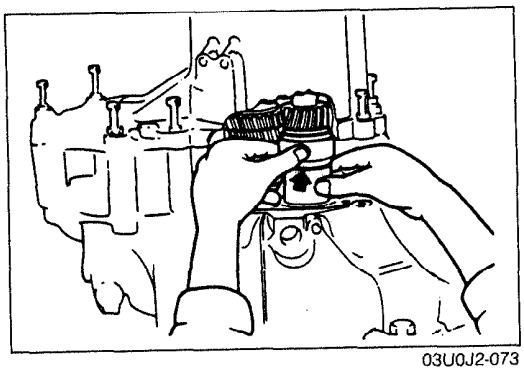
6. Install the transaxle case and tighten the **SST** (bolts) to the specified torque.

Tightening torque:
37—52 N·m (3.8—5.3 m-kg, 27—38 ft-lb)

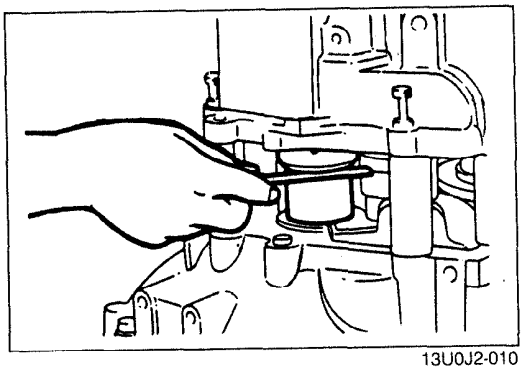


03U0J2-072

7. To seat the bearings, mount the **SST** (bars) on parts Ⓐ and Ⓑ of the selector, and turn the selector so the gaps are widened.
   Then turn the **SST** in the reverse direction until the gaps are eliminated.



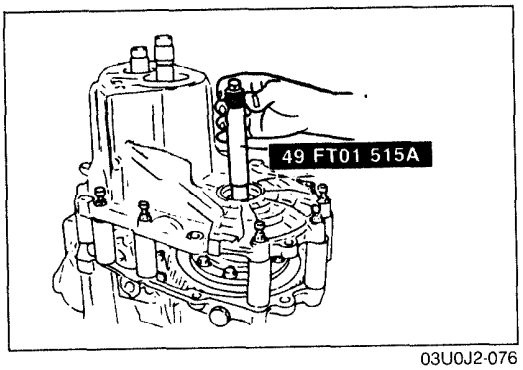
03U0J2-073



13U0J2-010

Thickness (Shaft gears)	mm (in)
0.20 (0.008)	0.50 (0.020)
0.25 (0.010)	0.55 (0.022)
0.30 (0.012)	0.60 (0.024)
0.35 (0.014)	0.65 (0.026)
0.40 (0.016)	0.70 (0.028)
0.45 (0.018)	

13U0J2-011



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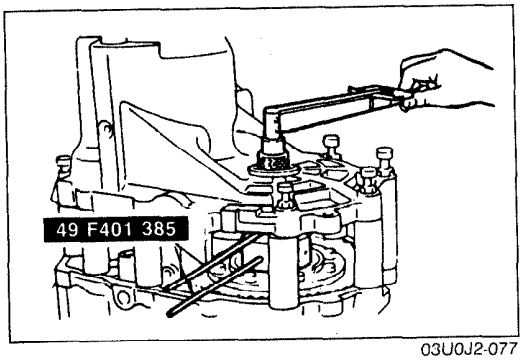


03U0J2-077

Note
- **Check that each shaft turns smoothly.**

8. Manually expand the selector until it no longer turns by hand.

Caution
- **Measure the gap around the entire circumference of the selector.**

9. Use a feeler gauge and measure the gap in the selector.

10. Take the maximum reading and determine the shim to be used as follows:

Note
- **Use a maximum of two shims.**

< Primary shaft adjust shim >
- Subtract the diaphragm spring thickness (0.70mm, 0.0276 in) from the gap determined in Step 9.
- Select the closest thinner shim from the table.

Example
1.22mm (0.0480 in) - 0.70mm (0.0276 in)
= 0.52mm (0.0205 in)
Shim: 0.50mm (0.020 in)

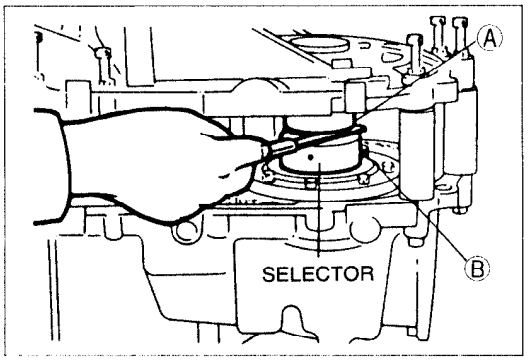
< Secondary shaft adjust shim >
- Subtract the diaphragm spring thickness (0.70mm, 0.0276 in) from the gap determined in Step 9.
- Select the closest thicker shim from the table.

Example
1.22mm (0.0480 in) - 0.70mm (0.0276 in)
= 0.52mm (0.0205 in)
Shim: 0.55mm (0.022 in)

11. Install the **SST**.

12. Adjust the selector with the **SST** until the specified preload is obtained.

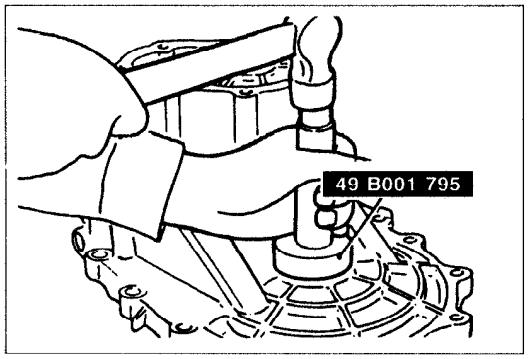
Preload: 0.5 N·m (5 cm-kg, 4.3 in-lb)



03U0J2-078

Thickness	mm (in)
0.10 (0.004)	0.70 (0.028)
0.20 (0.008)	0.75 (0.030)
0.25 (0.010)	0.80 (0.031)
0.30 (0.012)	0.85 (0.033)
0.35 (0.014)	0.90 (0.035)
0.40 (0.016)	0.95 (0.037)
0.45 (0.018)	1.00 (0.039)
0.50 (0.020)	1.05 (0.041)
0.55 (0.022)	1.10 (0.043)
0.60 (0.024)	1.15 (0.045)
0.65 (0.026)	1.20 (0.047)

03U0J2-079



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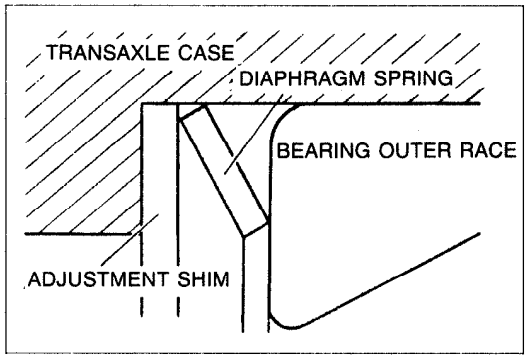

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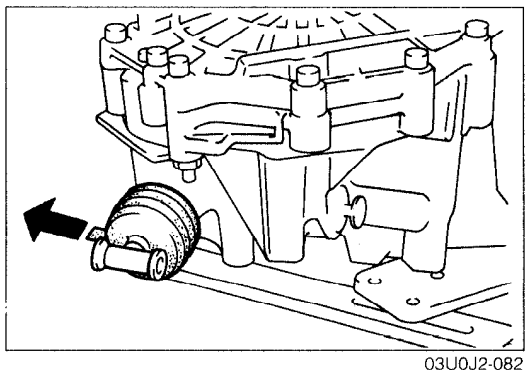


03U0J2-082

Caution
- **Measure the gap around the entire circumference of the selector**

13. Use a feeler gauge to measure the gap in the selector for the differential.

14. Add **0.15mm (0.0059 in)** to the measured clearance and select the combination of shims closest in value to that measurement.

Note
- **Use a maximum of two shims.**

See the table below for available shim sizes.

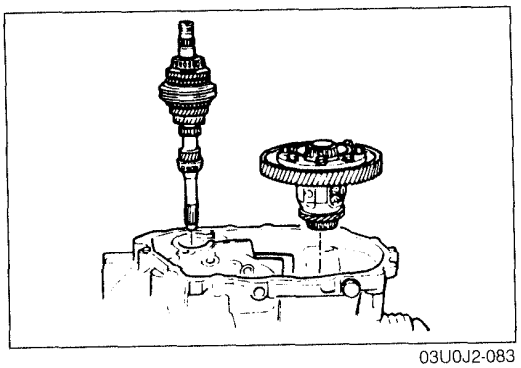
Example: 0.32mm (0.013 in)
0.32mm (0.013 in) + 0.15mm (0.006 in) = 0.47mm (0.019 in).
So the nearest shim (on the thick side) to 0.47mm (0.019 in) is 0.50mm (0.020 in).

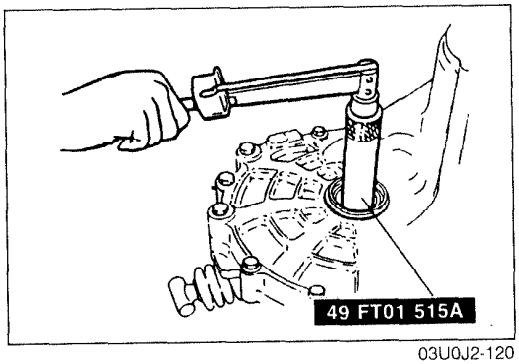
15. Remove the **SST** and the transaxle case.
16. Remove the selectors, the primary shaft assembly and the differential.
17. Remove the bearing outer races.

Assembly note
Oil seals
1. Apply transaxle oil to outer periphery.
2. Install the new oil seals with the **SST**.

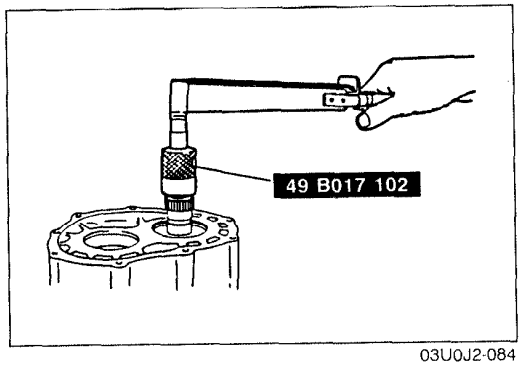
Diaphragm spring
1. Install the diaphragm spring as shown in the figure.

Boot
1. Install the boot with the drain hole facing downward.


03U0J2-083



03U0J2-120



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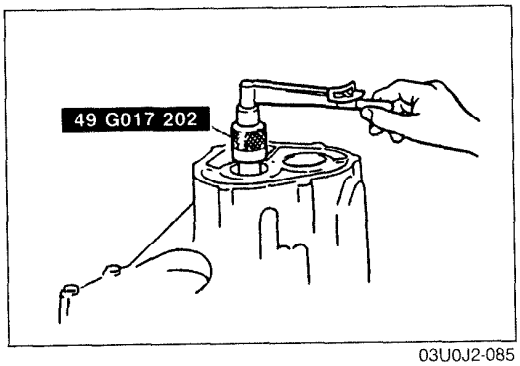

03U0J2-085

Bearing preload

Verify the shaft gears and the differential bearing preload.

Note
- **Verify that the correct adjust shims were selected.**
- **If the bearing preload is not within specification, adjust again.**

1. Set the primary shaft gear and the differential into the clutch housing.
2. Install the transaxle case, and tighten to the specified torque.

Tightening torque:
37—52 N·m (3.8—5.3 m-kg, 27—38 ft-lb)

3. Connect the **SST** and install it through the driveshaft hole.
4. Hook a spring scale to the attachment and measure the preload.

Preload:
1.4—2.0 N·m (14—20 cm-kg, 12—17 in-lb)

5. Remove the **SST**.
6. With the transaxle facing in the direction shown in the figure, install the **SST** to the primary shaft gear.
7. Measure the preload.

Preload:
0.1—0.25 N·m (1.0—2.5 cm-kg, 0.87—2.18 in-lb)

8. Remove the **SST**, transaxle case, primary shaft gear and differential.
9. Install the secondary shaft gear and transaxle case then tighten to the specified torque.

Tightening torque:
37—52 N·m (3.8—5.3 m-kg, 27—38 ft-lb)

10. Measure the secondary shaft preload with the **SST**.

Preload:
0.2—0.4 N·m (2.0—4.0 cm-kg, 1.7—3.5 in-lb)