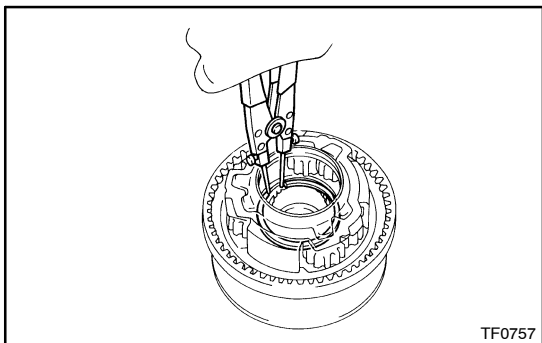


REASSEMBLY

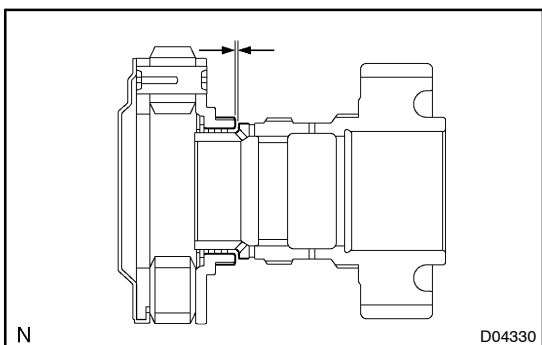
HINT:

Coat all of the sliding and rotating surfaces with gear oil before reassemble.



1. ASSEMBLE DRIVE SPROCKET, CONTROL COUPLING AND PLANETARY RING GEAR

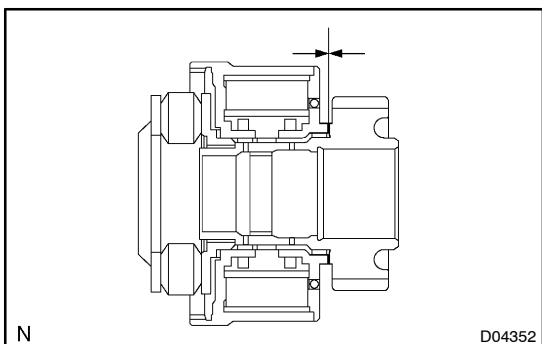
- (a) Temporarily assemble the planetary ring gear to the drive sprocket.
- (b) Using a snap ring expander, install the snap ring.



- (c) Select a snap ring so that the planetary ring gear thrust clearance will be less than 0.10 mm (0.0039 in.). Measure the clearance with a feeler gauge.

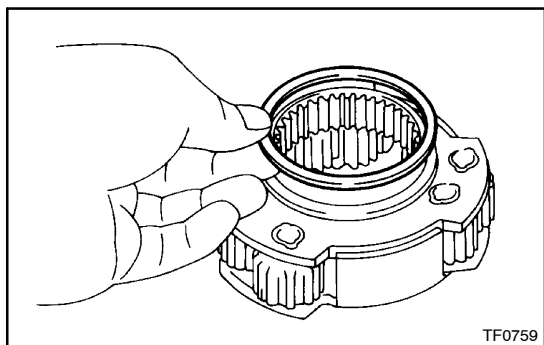
Mark	Thickness mm (in.)
A	1.55 (0.0610)
B	1.60 (0.0630)
C	1.65 (0.0650)
D	1.70 (0.0669)
E	1.75 (0.0689)

- (d) Using a snap ring expander, remove the snap ring.
- (e) Separate the planetary ring gear and drive sprocket.
- (f) Assemble the drive sprocket, control coupling and planetary ring gear.
- (g) Using a snap ring expander, install the selected snap ring.



- (h) Using a feeler gauge, measure the control coupling thrust clearance.

Clearance: 0.30 – 0.45 mm (0.0118 – 0.0177 in.)



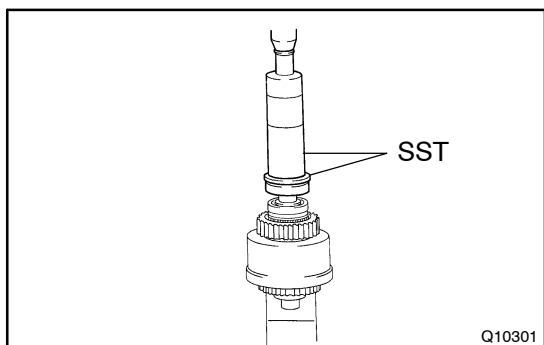
If the clearance is not within the specification, disassemble the drive sprocket, control coupling and planetary ring gear once more, install the planetary carrier washer of a different thickness so that the clearance is within the specification.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	1.30 (0.0511)	D	1.60 (0.0630)
B	1.40 (0.0551)	E	1.70 (0.0669)
C	1.50 (0.0590)	F	1.80 (0.0707)

2. INSTALL NEEDLE ROLLER BEARING AND REAR OUTPUT SHAFT

- (a) Install the needle roller bearing in the drive sprocket.
- (b) Install the rear output shaft.

3. INSTALL SPACER



4. INSTALL BALL BEARING

Using SST and a press, install a new ball bearing.

SST 09316-60011 (09613-00011, 09316-00031)