
MANUAL TRANSAXLE (C50, C250)

TROUBLESHOOTING	MX-1
MANUAL TRANSAXLE UNIT	MX-2
MANUAL TRANSAXLE ASSEMBLY	MX-8
INPUT SHAFT	MX-21
OUTPUT SHAFT	MX-28
SHIFT AND SELECT LEVER SHAFT	MX-35
DIFFERENTIAL CASE	MX-36
SHIFT LEVER AND CONTROL CABLE	MX-43

TROUBLESHOOTING

PROBLEM SYMPTOMS TABLE

MX002-02

Use the table below to help you find the cause of the problem. The numbers indicate the priority of the likely cause of the problem. Check each part in order. If necessary, replace parts.

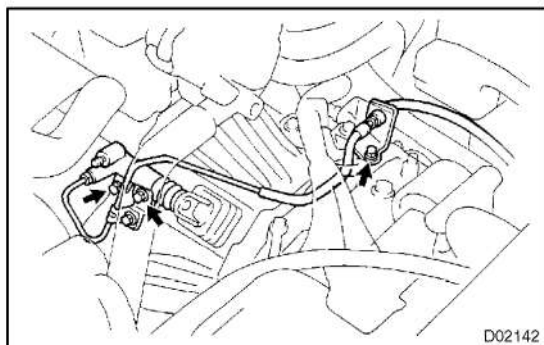
Symptom	Suspect Area	See page
Noise	1. Oil (Level low) 2. Oil (Wrong) 3. Gear (Worn or damaged) 4. Bearing (Worn or damaged)	MX-3 MX-3 MX-8 MX-8
Oil leakage	1. Oil (Level too high) 2. Gasket (Damaged) 3. Oil seal (Worn or damaged) 4. O-Ring (Worn or damaged)	MX-3 MX-8 MX-8 MX-8
Hard to shift or will not shift	1. Control cable (Faulty) 2. Synchronizer ring (Worn or damaged) 3. Shift key spring (Damaged)	MX-43 MX-8 MX-21 MX-28 MX-8 MX-21 MX-28
Jumps out of gear	1. Locking ball spring (Damaged) 2. Shift fork (Worn) 3. Gear (Worn or damaged) 4. Bearing (Worn or damaged)	MX-8 MX-8 MX-8 MX-8

MYDSE-01



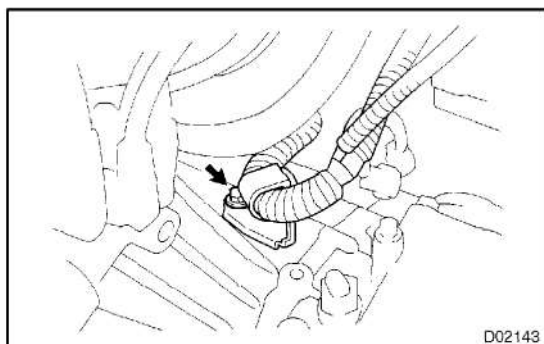
REMOVAL

1. REMOVE BATTERY AND AIR CLEANER CASE ASSEMBLY WITH AIR HOSE



2. DISCONNECT CLUTCH RELEASE CYLINDER AND LINE

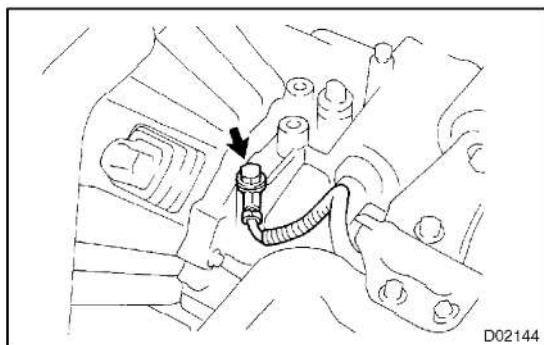
- (a) Remove the set bolt of the clutch line bracket.
Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)
- (b) Remove the 2 bolts and disconnect the clutch release cylinder and line.
Torque: 12 N·m (120 kgf·cm, 9 ft·lbf)



3. DISCONNECT ENGINE WIRE FROM CLAMP

Remove the bolt and engine wire clamp from the transaxle.

4. DISCONNECT BACK-UP LIGHT SWITCH AND SPEED SENSOR CONNECTORS

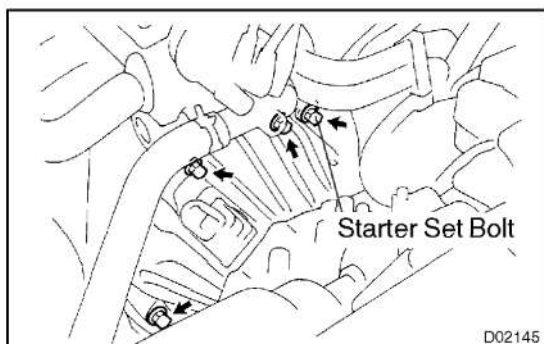


5. DISCONNECT GROUND CABLE

Remove the set bolt and disconnect the ground cable from the transaxle.

6. DISCONNECT CONTROL CABLE

- (a) Remove the 2 clips and washers.
- (b) Remove the 2 clips from the cables.
- (c) Disconnect the 2 control cables from the transaxle.

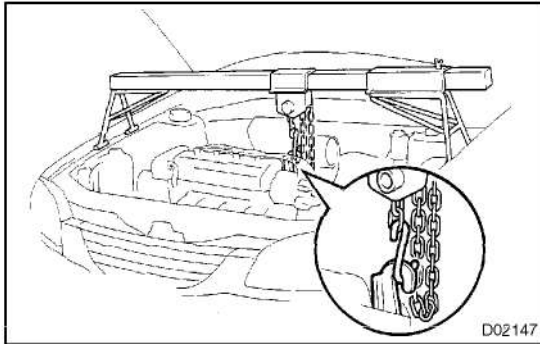


7. REMOVE STARTER SET BOLT

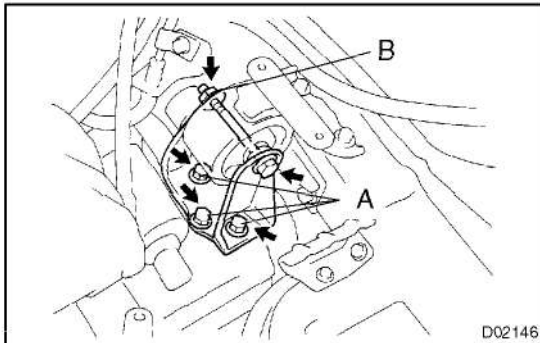
Remove the set bolt of the starter from the transaxle upper side.
Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)

8. REMOVE 3 TRANSAXLE UPPER SIDE MOUNTING BOLTS

Torque: 64 N·m (650 kgf·cm, 47 ft·lbf)



9. INSTALL ENGINE SUPPORT FIXTURE



10. REMOVE ENGINE LEFT MOUNTING BRACKET

Remove the 4 bolts, nut and bracket.

Torque:

Bolt A: 52 N·m (530 kgf·cm, 38 ft·lbf)

Nut B : 87 N·m (890 kgf·cm, 64 ft·lbf)

11. REMOVE FRONT WHEEL

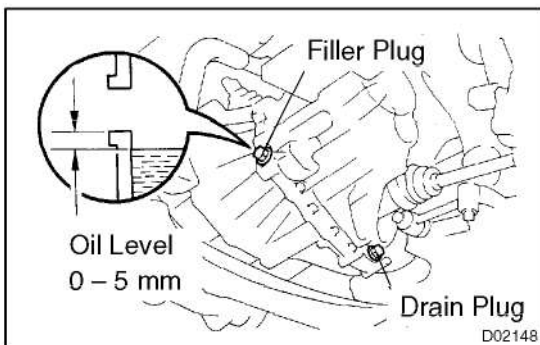
Torque: 216 N·m (2,200 kgf·cm, 159 ft·lbf)

12. RAISE VEHICLE

NOTICE:

Make sure that the vehicle is securely supported.

13. REMOVE LH AND RH ENGINE UNDER COVERS



14. DRAIN TRANSAXLE OIL

Oil grade: API GL-4 or GL-5

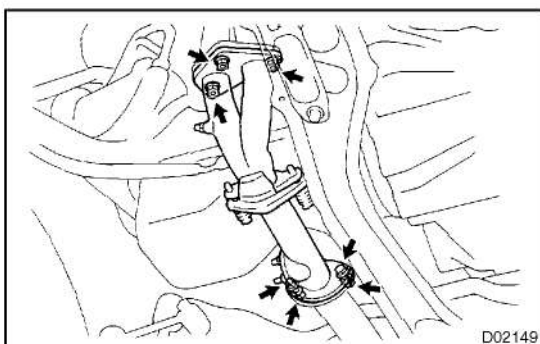
Viscosity: SAE 75W-90

Capacity: 1.9 liters (2.0 US qts, 1.7 Imp. qts)

Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)

15. REMOVE LH AND RH DRIVE SHAFTS

(See page SA-17)



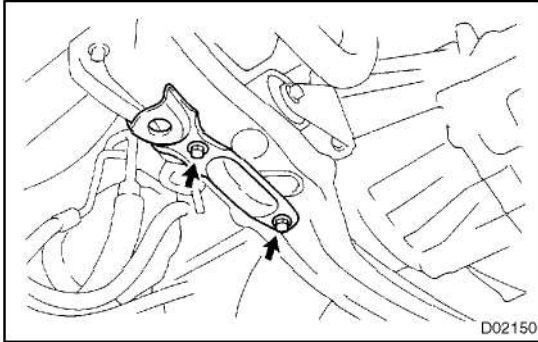
16. REMOVE FRONT AND CENTER EXHAUST PIPES

- (a) Remove the 3 nuts and 2 gaskets from the exhaust manifold.

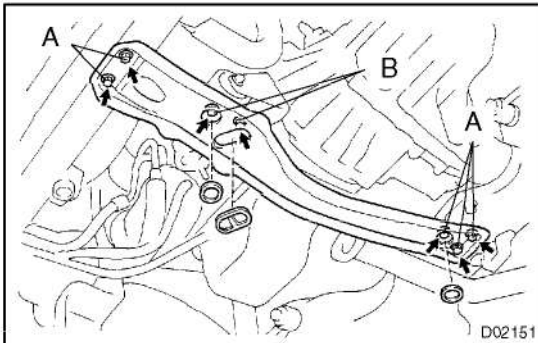
Torque: 62 N·m (630 kgf·cm, 46 ft·lbf)

- (b) Remove the 2 bolts, nuts, gasket and front and center exhaust pipes.

Torque: 43 N·m (430 kgf·cm, 32 ft·lbf)

**17. REMOVE ENGINE MOUNTING CENTER MEMBER**

- (a) Remove the 2 bolts and front transport hook.
Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)

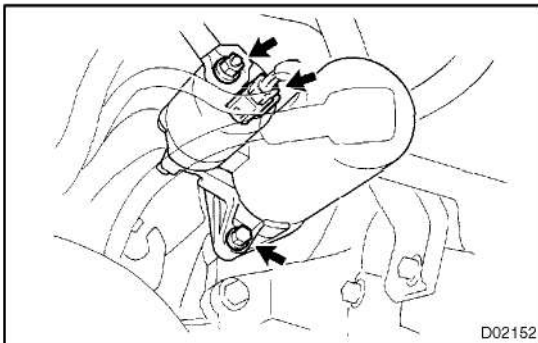


- (b) Remove the 2 hole plugs and hole cover.
(c) Remove the 7 bolts and center member.

Torque:

Bolt A: 73 N·m (740 kgf·cm, 54 ft·lbf)

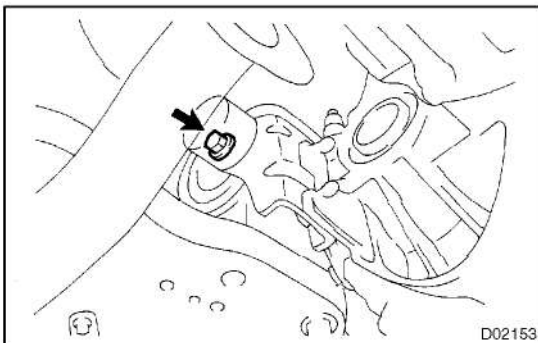
Bolt B: 72 N·m (730 kgf·cm, 53 ft·lbf)

**18. REMOVE STARTER**

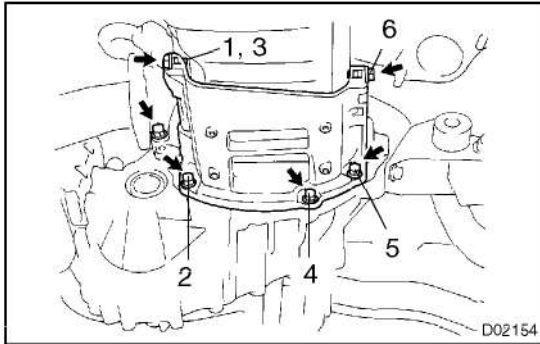
- (a) Disconnect the connector and wire from the starter.
(b) Remove the set bolt of the starter from the lower side.
Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)
(c) Remove the starter.

19. JACK UP TRANSAXLE SLIGHTLY

Using a transmission jack, support the transaxle.

**20. REMOVE ENGINE REAR MOUNTING BOLT**

Torque: 87 N·m (890 kgf·cm, 64 ft·lbf)

**21. 4A-FE Engine:****REMOVE STIFFENER PLATE AND TRANSAXLE LOWER SIDE MOUNTING BOLT**

- (a) Remove the 5 bolts and stiffener plate.

Torque: 43 N·m (440 kgf·cm, 32 ft·lbf)

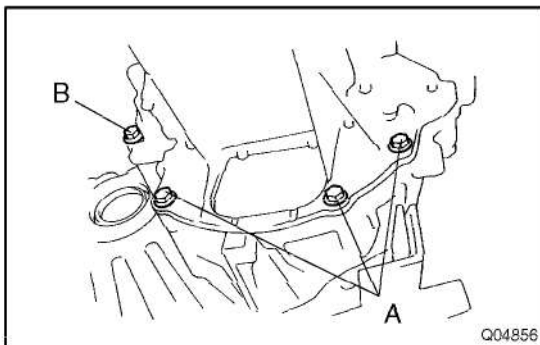
HINT:

At the time of installation, please refer to the following items.

- Install the stiffener plate and 5 bolts, temporarily tighten the No.1 bolt.
- Torque the 5 bolts in order shown.

- (b) Remove the bolt of transaxle lower side.

Torque: 46 N·m (470 kgf·cm, 34 ft·lbf)

**22. 7A-FE Engine:****REMOVE TRANSAXLE LOWER SIDE MOUNTING BOLT**

Remove the 4 bolts.

Torque:

Bolt A: 43 N·m (440 kgf·cm, 32 ft·lbf)

Bolt B: 46 N·m (470 kgf·cm, 34 ft·lbf)

23. REMOVE TRANSAXLE

Lower the engine left side and remove the transaxle from the engine.

HINT:

At the time of installation, please refer to the following items.

- Align the input shaft with the clutch disc and install the transaxle to the engine.
- Temporarily tighten the transaxle mounting bolts.

INSTALLATION

Installation is in the reverse order of removal (See page MX-3).

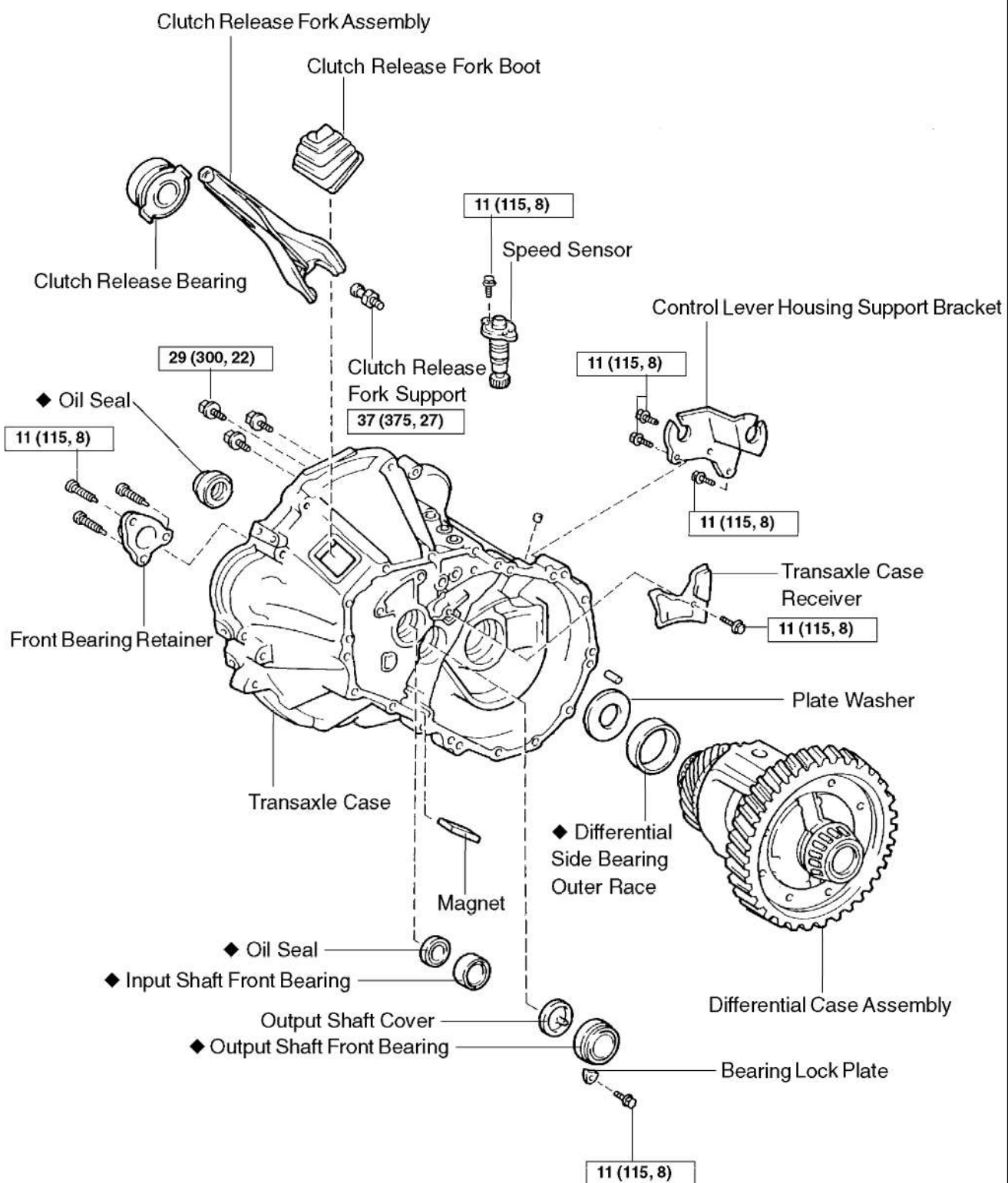
HINT:

After installation, check and inspect items as follows.

- Front wheel alignment (See page SA-4).
- Do the road test.

MANUAL TRANSAXLE ASSEMBLY COMPONENTS

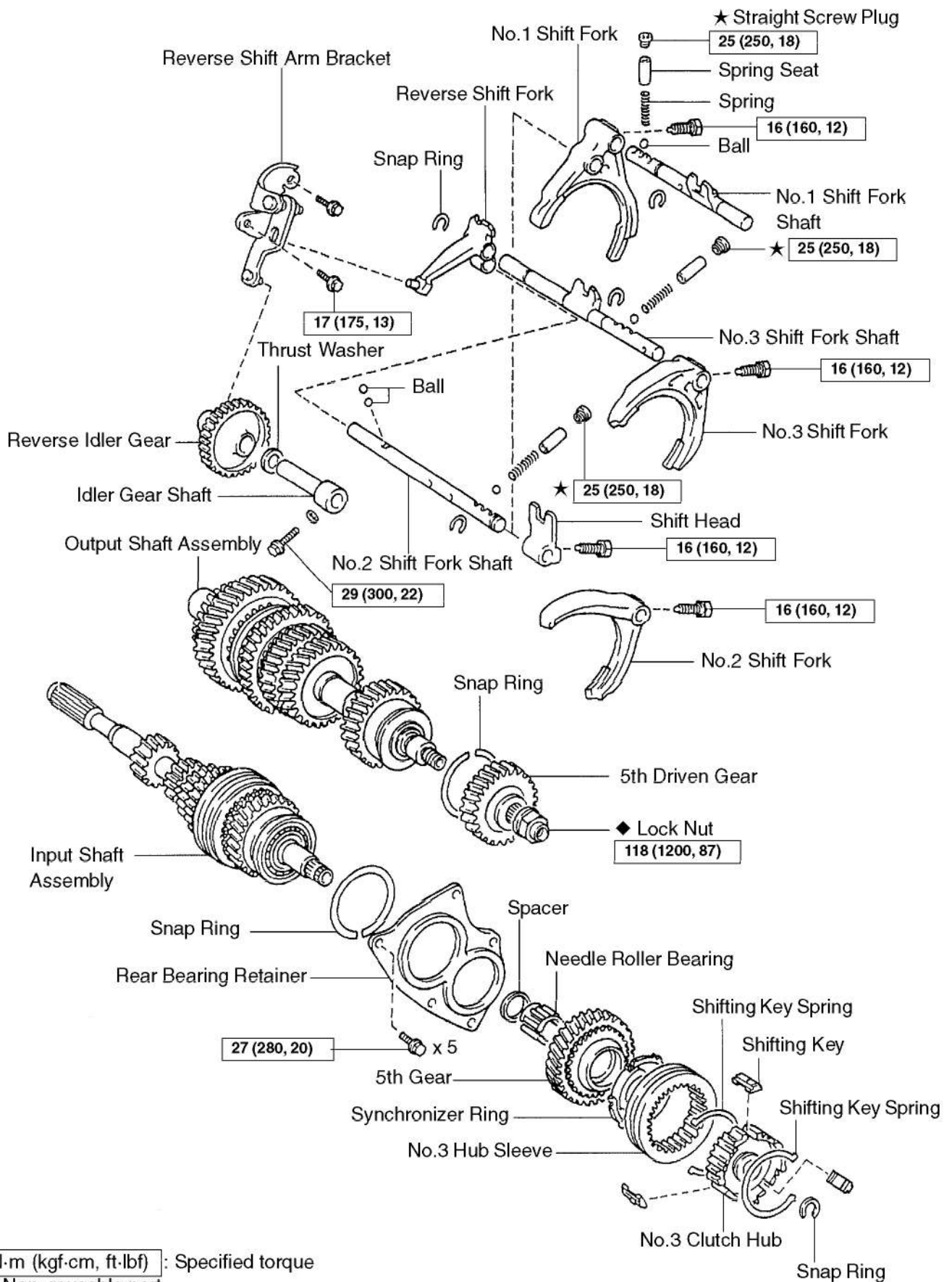
MX006-02

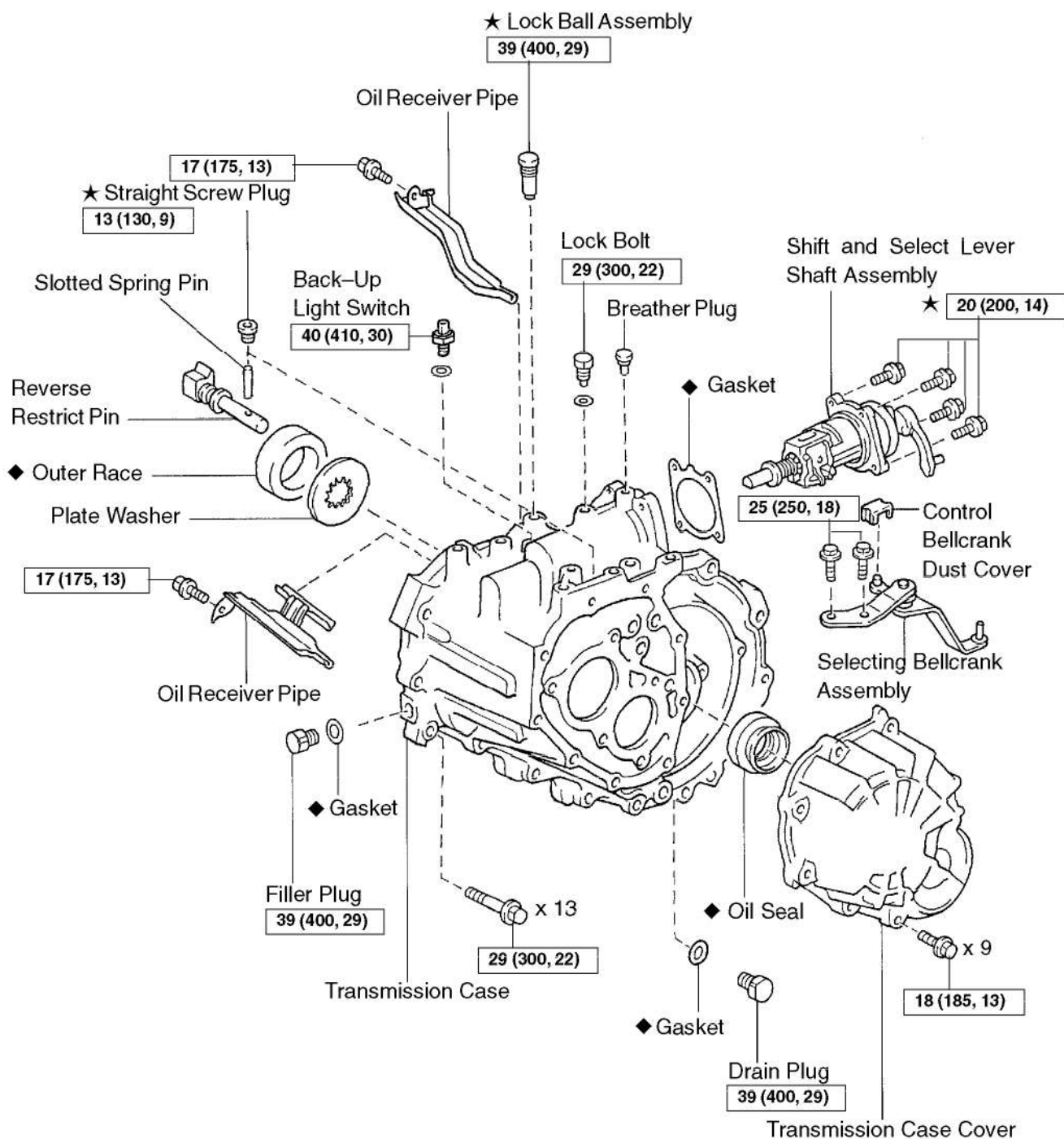


N·m (kgf·cm, ft·lbf) : Specified torque

◆ Non-reusable part

D02462





N·m (kgf·cm, ft·lbf) : Specified torque

◆ Non-reusable part

★ Precoated part

DISASSEMBLY

1. REMOVE RELEASE FORK AND BEARING

HINT:

At the time of reassembly, please refer to the following item.
Apply molybdenum disulphide lithium base grease.

(See page CL-18)

2. REMOVE BOLT AND SPEED SENSOR

Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)

3. REMOVE BACK-UP LIGHT SWITCH

Torque: 40 N·m (410 kgf·cm, 30 ft·lbf)

4. REMOVE SELECTING BELLCRANK ASSEMBLY

(a) Remove 2 bolts and selecting bellcrank assembly.

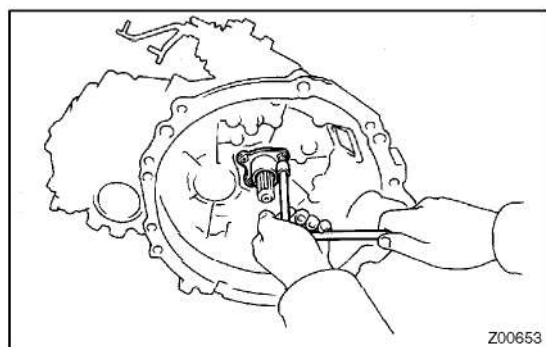
Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)

(b) Remove the control bellcrank dust cover from the selecting bellcrank assembly.

5. REMOVE CONTROL LEVER HOUSING SUPPORT BRACKET

Remove the 3 bolts and bracket.

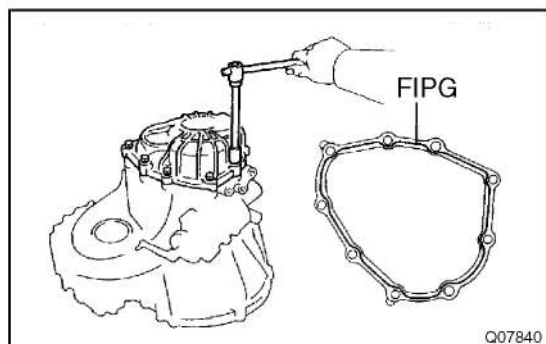
Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)



6. REMOVE FRONT BEARING RETAINER

Using a torx wrench (T30), remove the 3 torx screws and retainer.

Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)



7. REMOVE TRANSMISSION CASE COVER

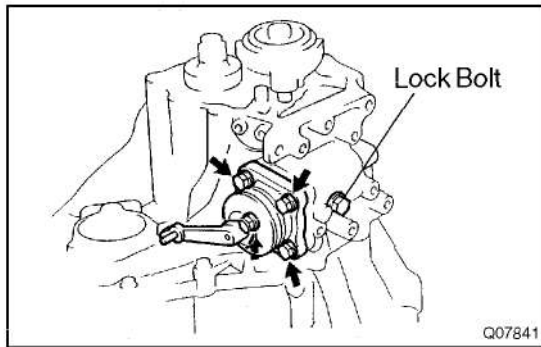
(a) Remove the 9 bolts.

Torque: 18 N·m (185 kgf·cm, 13 ft·lbf)

(b) Using a brass bar and hammer, carefully tap the projection of the transmission case cover to remove the transmission case cover from the transmission case.

FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent



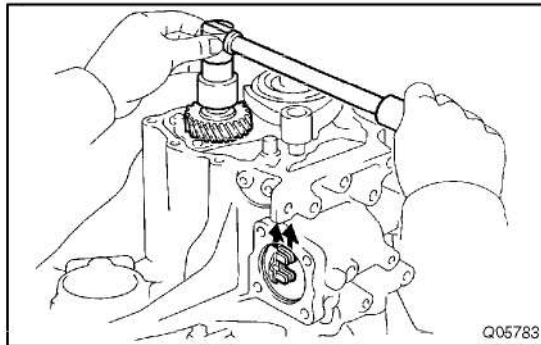
8. REMOVE SHIFT AND SELECT LEVER SHAFT ASSEMBLY

- (a) Remove the lock bolt.
- (b) Remove the 4 bolts and pull out the shift and select lever shaft assembly with the gasket.

Sealant:

Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

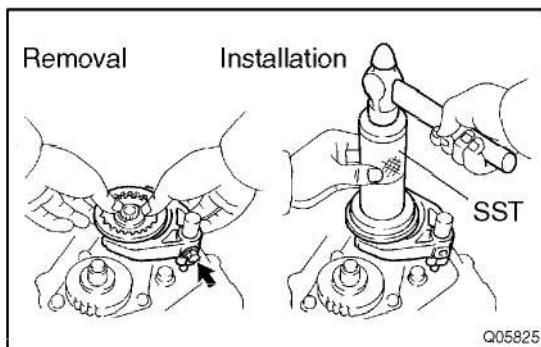
Torque: 20 N·m (200 kgf·cm, 14 ft·lbf)



9. REMOVE LOCK NUT

- (a) Engage the gear to the double meshing.
- (b) Using a chisel and hammer, loosen the staked part of the nut.
- (c) Remove the lock nut.
- (d) Disengage the gear double meshing.

Torque: 118 N·m (1,200 kgf·cm, 87 ft·lbf)



10. REMOVE NO.3 HUB SLEEVE AND NO.3 SHIFT FORK

- (a) Remove the bolt from the No.3 shift fork.
- (b) Remove the No.3 hub sleeve with the shift fork.

Torque: 16 N·m (160 kgf·cm, 12 ft·lbf)

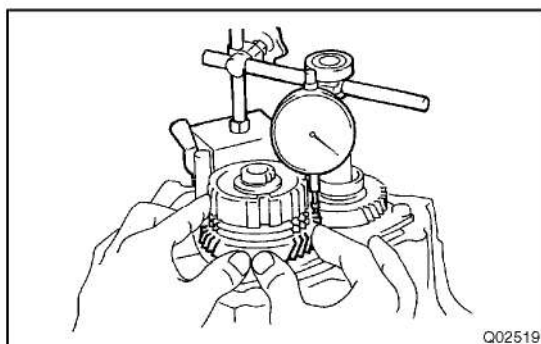
HINT:

At the time of reassembly, please refer to the following item.
Using SST and a hammer, drive in the No.3 hub sleeve with the shift fork.

SST 09636-20010

NOTICE:

At the time of installation, please refer to the following item.
Align the synchronizer ring slots with the shifting keys.



11. INSPECT 5TH GEAR THRUST CLEARANCE

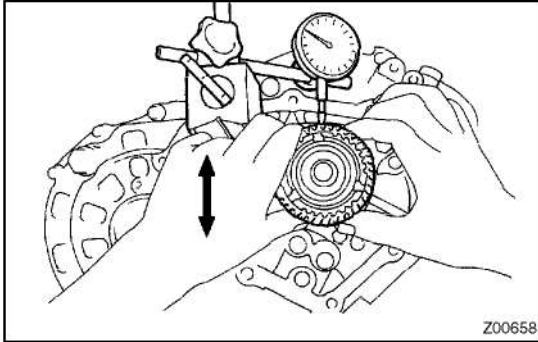
Using a dial indicator, measure the thrust clearance.

Standard clearance:

0.10–0.57 mm (0.0039–0.0024 in.)

Maximum clearance:

0.65 mm (0.0256 in.)



12. INSPECT 5TH GEAR RADIAL CLEARANCE

Using a dial indicator, measure the radial clearance.

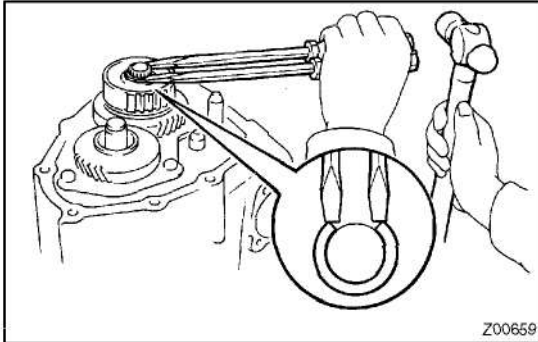
Standard clearance:

0.015–0.058 mm (0.0006–0.0023 in.)

Maximum clearance:

0.070 mm (0.0028 in.)

If the clearance exceeds the maximum, replace the gear, needle roller bearing or shaft.



13. REMOVE NO.3 CLUTCH HUB AND 5TH GEAR

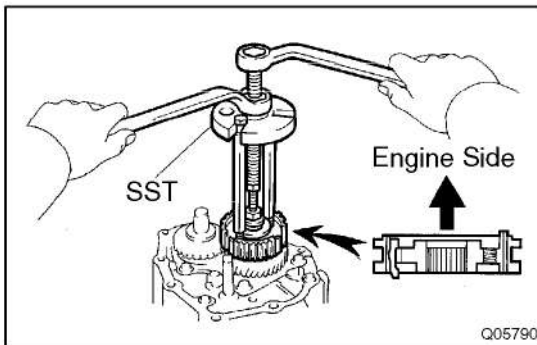
- (a) Using 2 screwdrivers and a hammer, tap out the snap ring.

HINT:

At the time of reassembly, please refer to the following item.
Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.25 (0.0886)	E	2.49 (0.0980)
B	2.31 (0.0909)	F	2.55 (0.1004)
C	2.37 (0.0933)	G	2.61 (0.1028)
D	2.43 (0.0957)	—	—

- (b) Using a screwdriver, remove the key spring.



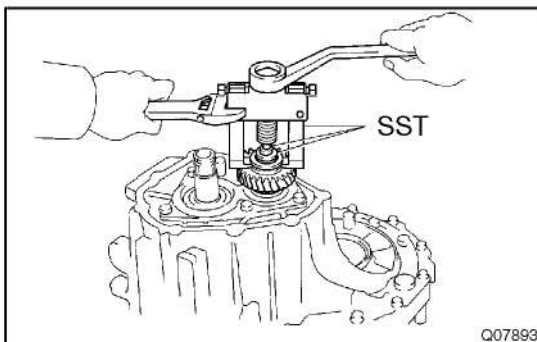
- (c) Install a bolt and washer to the tip of the input shaft and using SST, remove the No.3 clutch hub.

SST 09950-30010

NOTICE:

Select a bolt whose outer diameter is smaller than the screw hole of the input shaft so that it can be turned easily.

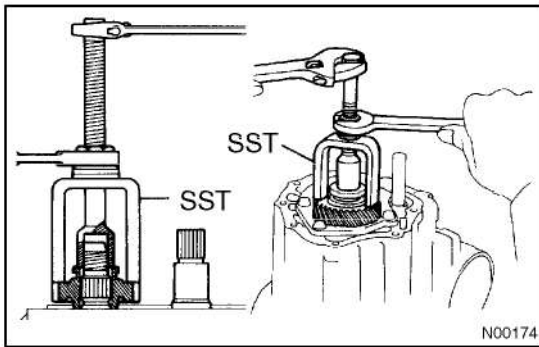
- (d) Remove the synchronizer ring, 5th gear and needle roller bearing.



14. REMOVE 5TH DRIVEN GEAR

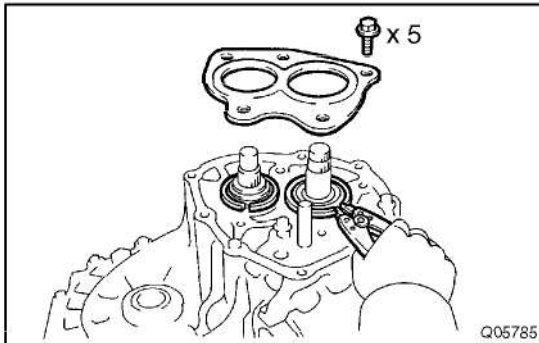
Using SST, remove the 5th driven gear.

SST 09628-62011, 09950-40011 (09957-04010),
09950-60010 (09951-00230)

**HINT:**

At the time of reassembly, please refer to the following item.
Using SST, install the 5th driven gear.

SST 09309-12020

**15. REMOVE REAR BEARING RETAINER**

Remove the 5 bolts and retainer.

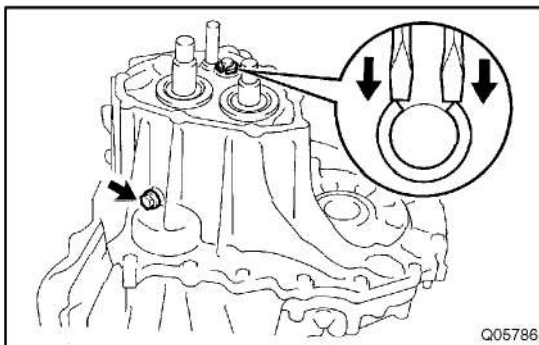
Torque: 27 N·m (280 kgf·cm, 20 ft·lbf)

16. REMOVE BEARING SNAP RING

Using a snap ring expander, remove the 2 snap rings.

HINT:

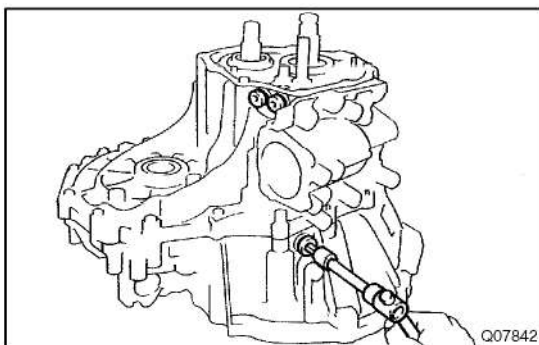
If it is difficult to remove and install the snap rings, pull up the shafts.

**17. REMOVE REVERSE IDLER GEAR SHAFT LOCK BOLT**

Torque: 29 N·m (300 kgf·cm, 22 ft·lbf)

18. REMOVE SNAP RING FROM NO.2 SHIFT FORK SHAFT

Using 2 screwdrivers and a hammer, tap out the snap ring.

**19. REMOVE PLUG, SEAT, SPRING AND BALL**

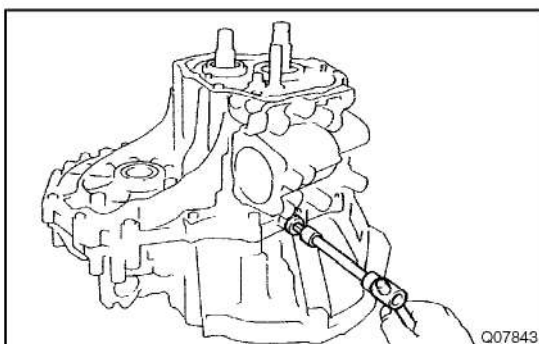
(a) Using a hexagon wrench, remove the 3 plugs.

Sealant:

Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)

(b) Using a magnetic finger, remove the 3 seats, springs and balls.

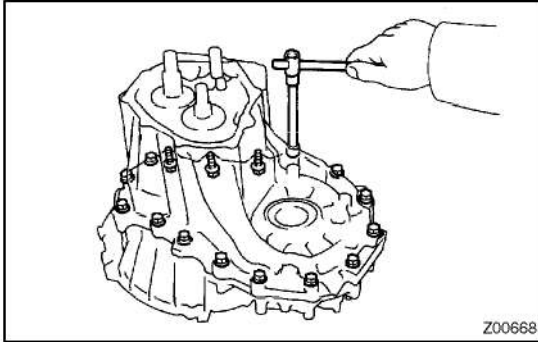
**20. REMOVE LOCK BALL ASSEMBLY**

Using a hexagon wrench, remove the lock ball assembly.

Sealant:

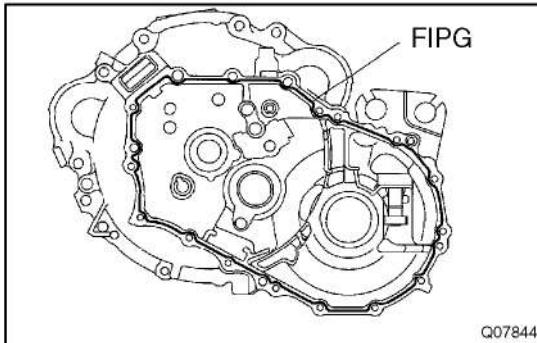
Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

Torque: 39 N·m (400 kgf·cm, 29 ft·lbf)



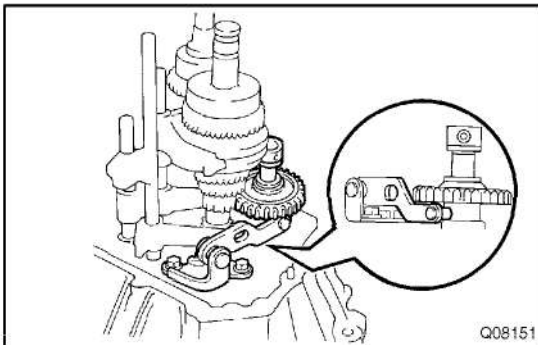
21. REMOVE TRANSMISSION CASE

- Remove the 16 bolts.
Torque: 29 N·m (300 kgf·cm, 22 ft·lbf)
- Using a plastic hammer, carefully tap the projection of the transmission case to remove the transmission case from the transaxle case.



FIPG:

Part No. 08826-00090, THREE BOND 1281 or equivalent

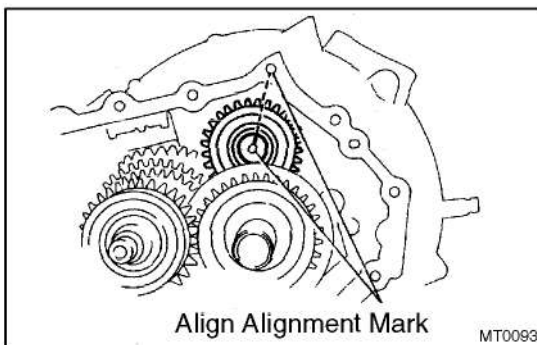


22. REMOVE REVERSE IDLER GEAR, THRUST WASHER AND SHAFT

23. REMOVE REVERSE SHIFT ARM BRACKET

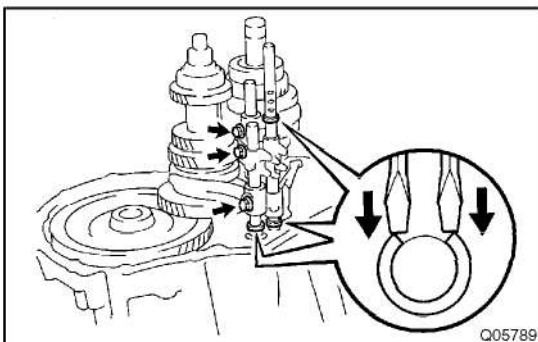
Remove the 2 bolts and bracket.

Torque: 17 N·m (175 kgf·cm, 13 ft·lbf)



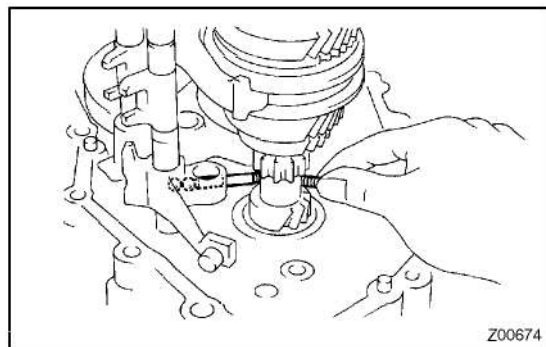
HINT:

At the time of reassembly, please refer to the following item.
Install the reverse idler gear, thrust washer and shaft, as shown in the illustration.



24. REMOVE SHIFT FORK AND SHIFT FORK SHAFT

- Using 2 screwdrivers and a hammer, tap out the 3 snap rings.
- Remove the 3 set bolts.
Torque: 16 N·m (160 kgf·cm, 12 ft·lbf)
- Pull up the No.3 shift fork shaft, remove the No.2 shift fork shaft and shift head.



- (d) Using a magnetic finger, remove the 2 balls from the reverse shift fork.
- (e) Remove the No.3 shift fork shaft and reverse shift fork.
- (f) Pull out the No.1 shift fork shaft.
- (g) Remove the No.1 and No.2 shift forks.

25. REMOVE INPUT AND OUTPUT SHAFTS TOGETHER FROM TRANSAXLE CASE

26. REMOVE DIFFERENTIAL CASE ASSEMBLY

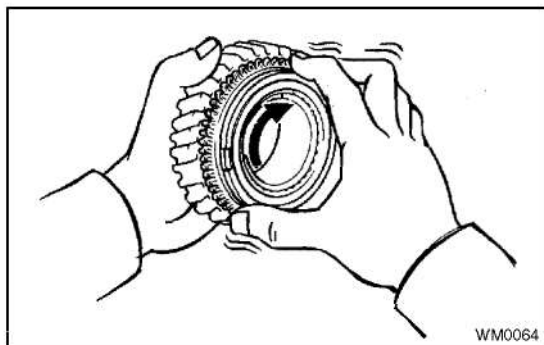
HINT:

At the time of reassembly, please refer to the following item.
Before reassembly, inspect the differential side bearing preload.

27. REMOVE MAGNET FROM TRANSAXLE CASE

28. REMOVE NO.3 HUB SLEEVE, SHIFTING KEY AND SPRING FROM NO.3 CLUTCH HUB

Using a screwdriver, remove the 3 shifting keys and 2 springs from the No.3 clutch hub.



INSPECTION

1. INSPECT 5TH GEAR SYNCHRONIZER RING

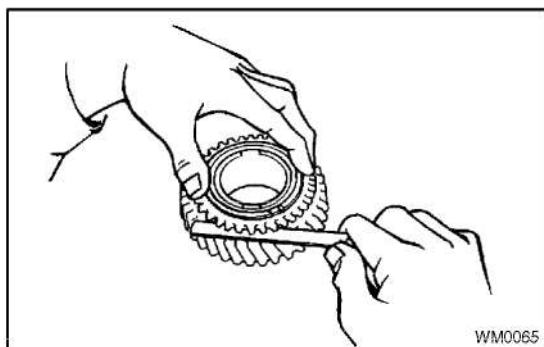
- (a) Check wear or damage.
- (b) Check the braking effect of the synchronizer ring.
Turn the synchronizer ring in one direction while pushing it to the gear cone. Check that the ring locks.

If the braking effect is insufficient, apply a small amount of the fine lapping compound between the synchronizer ring and gear cone. Lightly rub the synchronizer ring and gear cone together.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.

- (c) Check again the braking effect of the synchronizer ring.



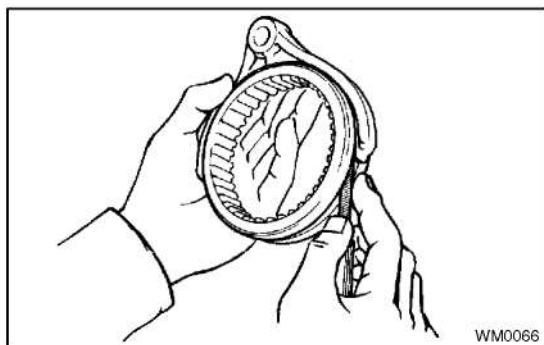
- (d) Using a feeler gauge, measure the clearance between the synchronizer ring back and gear spline end.

Minimum clearance: 0.6 mm (0.024 in.)

If the clearance is less than the minimum, replace the synchronizer ring, and apply a small amount of the fine lapping compound on gear cone.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.



2. INSPECT SHIFT FORK AND HUB SLEEVE CLEARANCE

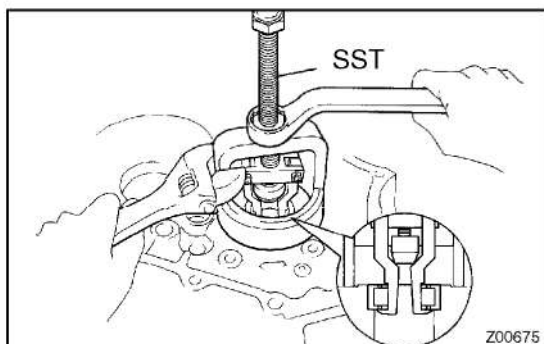
Using a feeler gauge, measure the clearance between the hub sleeve and shift fork.

Maximum clearance: 1.0 mm (0.039 in.)

If the clearance exceeds the maximum, replace the shift fork or hub sleeve.

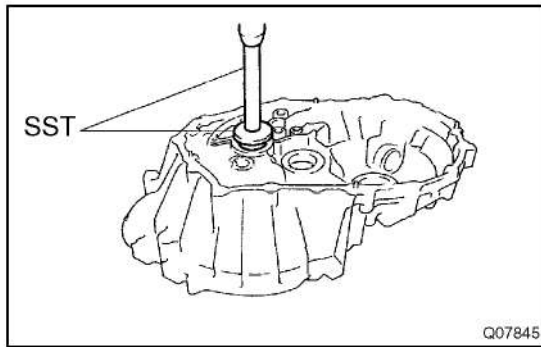
3. REMOVE TRANSAXLE CASE RECEIVER

Remove the bolt and transaxle case receiver.

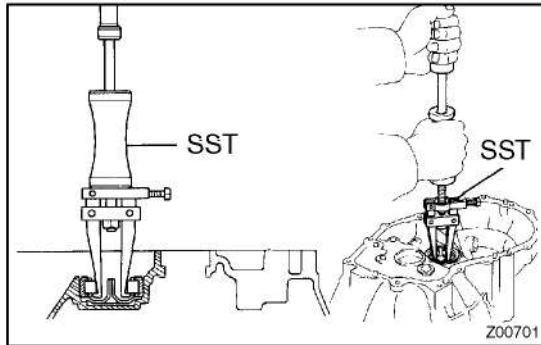


4. IF NECESSARY, REPLACE INPUT SHAFT FRONT BEARING

- (a) Using SST, pull out the bearing.
SST 09612-65014

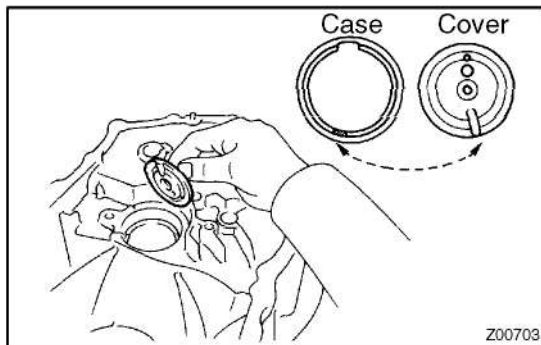


- (b) Using SST and a press, install a new bearing.
 SST 09950-60010 (09951-00460), 09950-70010 (09951-07150)



5. IF NECESSARY, REPLACE OUTPUT SHAFT FRONT BEARING

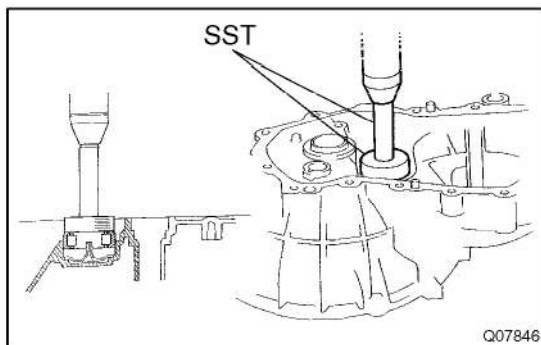
- (a) Remove the bolt and bearing lock plate.
 (b) Using SST, pull out the bearing.
 SST 09308-00010
 (c) Remove the output shaft front cover.



- (d) Install the output shaft front cover.

HINT:

Set the projection of the cover into the hollow in the case.



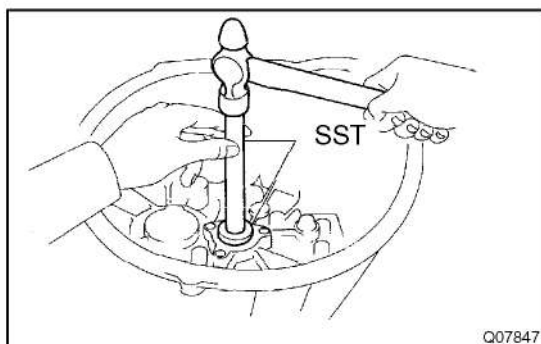
- (e) Using SST and a press, install a new bearing.
 SST 09950-60010 (09951-00620), 09950-70010 (09951-07150)

- (f) Install the bearing lock plate and torque the bolt.
Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)

6. INSTALL TRANSAXLE CASE RECEIVER

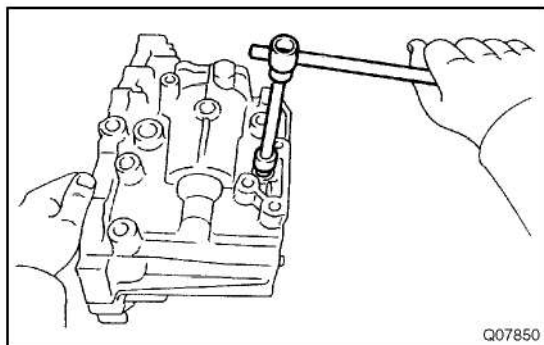
Install the transaxle case receiver and torque the bolt.

Torque: 11 N·m (115 kgf·cm, 8 ft·lbf)

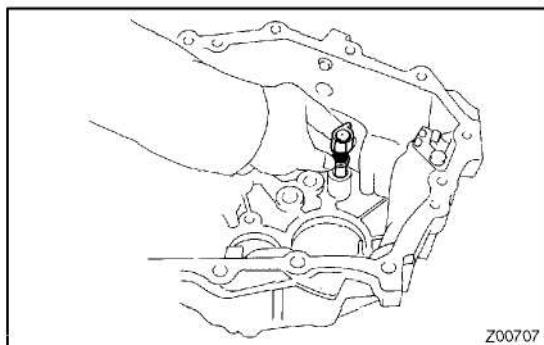


7. IF NECESSARY, REPLACE INPUT SHAFT FRONT OIL SEAL

- (a) Using a screwdriver, pry out the oil seal.
 (b) Using SST, drive in a new oil seal until its surface is flush with the transaxle case.
 SST 09950-60010 (09951-00400), 09950-70010 (09951-07150)
 (c) Coat the lip of the oil seal with MP grease.

**8. IF NECESSARY, REPLACE REVERSE RESTRICT PIN**

- (a) Using a hexagon wrench, remove the straight screw plug.
- (b) Using a pin punch and hammer, drive out the slotted spring pin.



- (c) Replace the reverse restrict pin.
- (d) Using a pin punch and hammer, drive in the slotted spring pin.
- (e) Apply sealant to the screw plug threads.

Sealant:

Part No. 08833-00080, THREE BOND 1344, LOCTITE 242 or equivalent

- (f) Using a hexagon wrench, install the straight screw plug.
Torque: 13 N·m (130 kgf·cm, 9 ft·lbf)

REASSEMBLY

Reassembly is in the reverse order of disassembly (See page MX-11).

HINT:

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

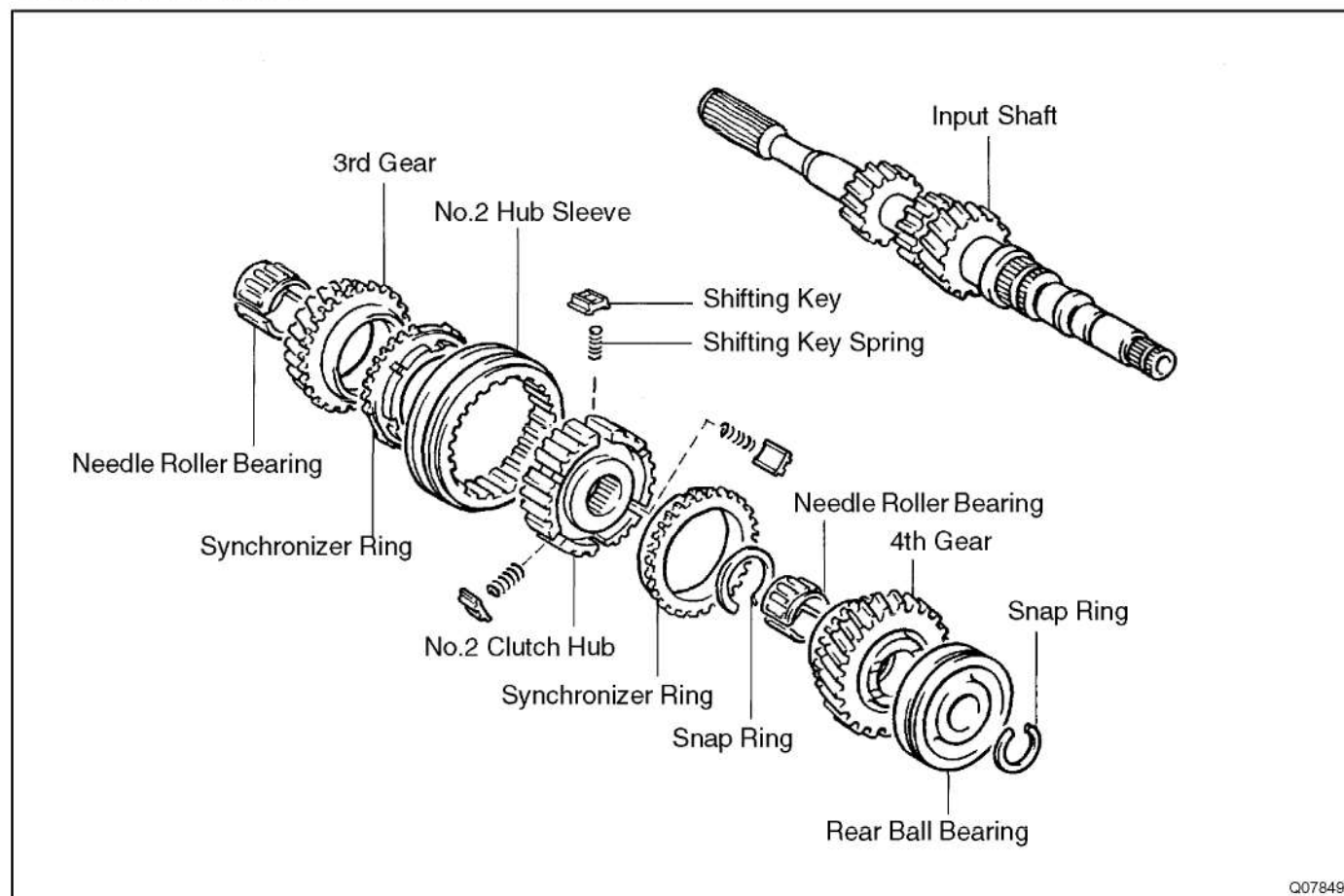
NOTICE:

When working with FIPG material, you must observe the following items.

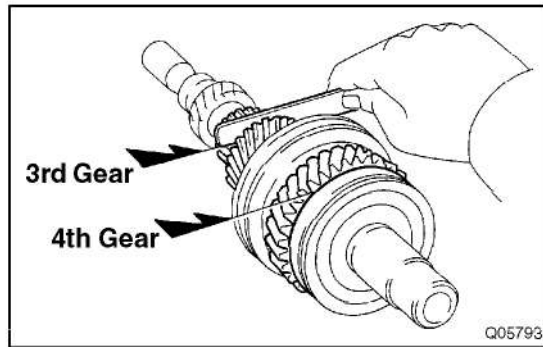
- Using a razor blade and gasket scraper, remove all the old FIPG material from the gasket surfaces.
- Thoroughly clean all components to remove all the loose material.
- Clean both sealing surfaces with a non-residue solvent.
- Apply FIPG in an approx. 1 mm (0.04 in.) wide bead along the sealing surface.
- Parts must be assembled within 10 minutes of application. Otherwise, the FIPG material must be removed and reapplied.

INPUT SHAFT COMPONENTS

MX00A-02



Q07849



DISASSEMBLY

1. INSPECT 3RD AND 4TH GEARS THRUST CLEARANCE

Using a feeler gauge, measure the thrust clearance.

Standard clearance:

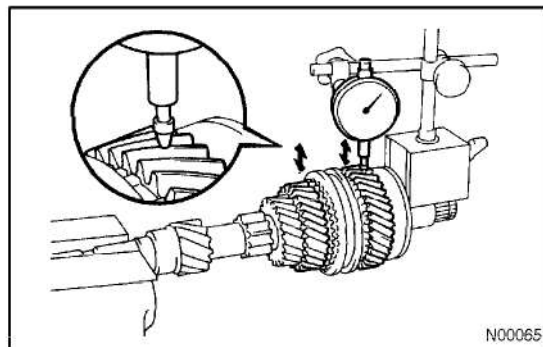
3rd gear: 0.10–0.35 mm (0.0039–0.0138 in.)

4th gear: 0.10–0.55 mm (0.0039–0.0217 in.)

Maximum clearance:

3rd gear: 0.40 mm (0.0157 in.)

4th gear: 0.60 mm (0.0236 in.)



2. INSPECT 3RD AND 4TH GEARS RADIAL CLEARANCE

Using a dial indicator, measure the radial clearance between the gear and shaft.

Standard clearance:

0.015–0.058 mm (0.0006–0.0023 in.)

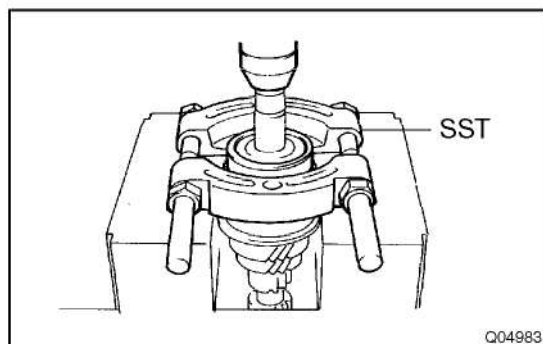
Maximum clearance:

0.070 mm (0.0028 in.)

If the clearance exceeds the maximum, replace the gear, needle roller bearing and shaft.

3. REMOVE SNAP RING

Using 2 screwdrivers and a hammer, tap out the snap ring.



4. REMOVE REAR BALL BEARING, 4TH GEAR, NEEDLE ROLLER BEARING, SPACER AND SYNCHRONIZER RING FROM INPUT SHAFT

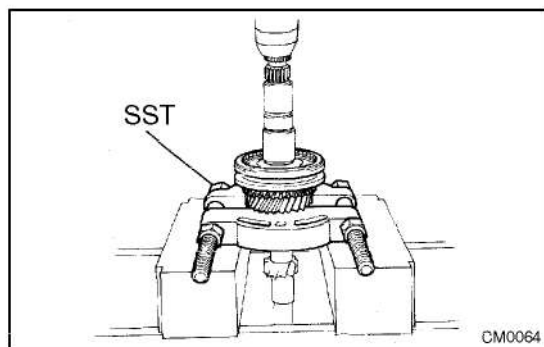
(a) Using SST and a press, remove the rear ball bearing.

SST 09950-00020

(b) Remove the 4th gear, needle roller bearings, spacer and synchronizer ring.

5. REMOVE SNAP RING

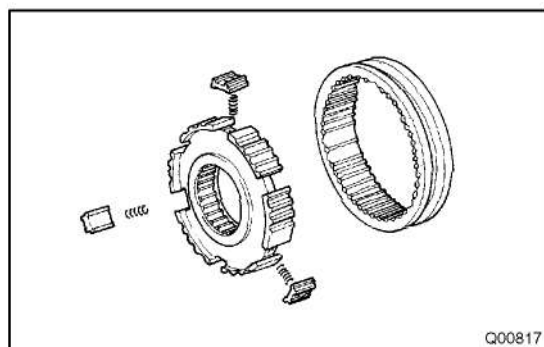
Using 2 screwdrivers and a hammer, tap out the snap ring.



6. REMOVE NO.2 HUB SLEEVE ASSEMBLY, 3RD GEAR, SYNCHRONIZER RING AND NEEDLE ROLLER BEARING

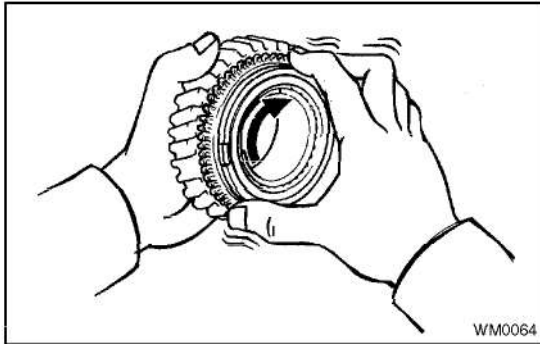
Using SST and a press, remove the No.2 hub sleeve assembly, 3rd gear, synchronizer ring and needle roller bearings.

SST 09950-00020



7. REMOVE NO.2 HUB SLEEVE, SHIFTING KEY AND SPRING FROM NO.2 CLUTCH HUB

Remove the 3 shifting keys, springs and No.2 hub sleeve from the No.2 clutch hub.



INSPECTION

1. INSPECT SYNCHRONIZER RING

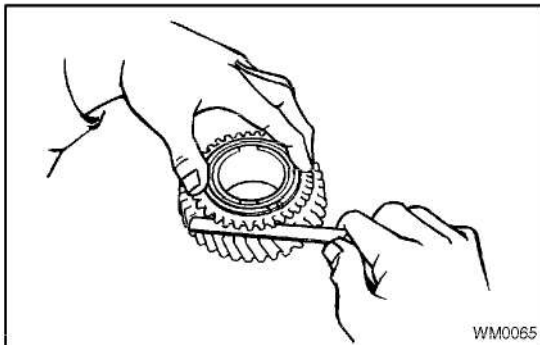
- (a) Check wear or damage.
- (b) Check the braking effect of the synchronizer ring.
Turn the synchronizer ring in one direction while pushing it to the gear cone. Check that the ring locks.

If the braking effect is insufficient, apply a small amount of the fine lapping compound between the synchronizer ring and gear cone. Lightly rub the synchronizer ring and gear cone together.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.

- (c) Check again the braking effect of the synchronizer ring.



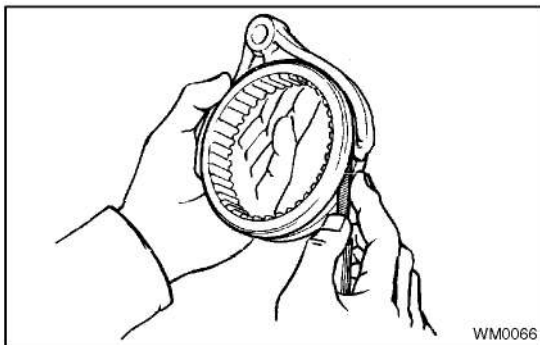
- (d) Using a feeler gauge, measure the clearance between the synchronizer ring back and gear spline end.

Minimum clearance: 0.6 mm (0.024 in.)

If the clearance is less than the minimum, replace the synchronizer ring, and apply a small amount of the fine lapping compound on gear cone.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.

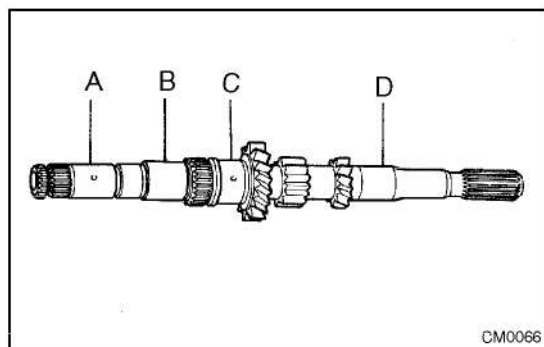


2. INSPECT SHIFT FORK AND HUB SLEEVE CLEARANCE

Using a feeler gauge, measure the clearance between the hub sleeve and shift fork.

Maximum clearance: 1.0 mm (0.039 in.)

If the clearance exceeds the maximum, replace the shift fork or hub sleeve.



3. INSPECT INPUT SHAFT

- (a) Check the input shaft for wear or damage.
- (b) Using a micrometer, measure the outer diameter of the input shaft journal surface.

Minimum outer diameter:

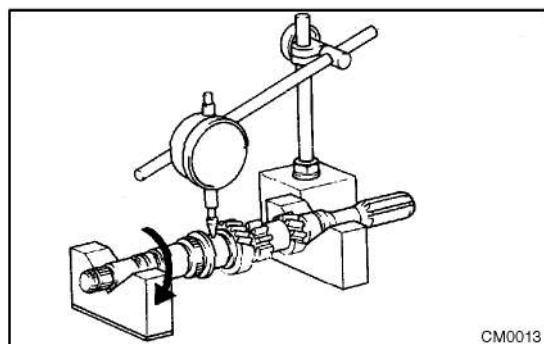
Part A: 24.870 mm (0.9791 in.)

Part B: 28.970 mm (1.1405 in.)

Part C: 30.970 mm (1.2193 in.)

Part D: 24.970 mm (0.9831 in.)

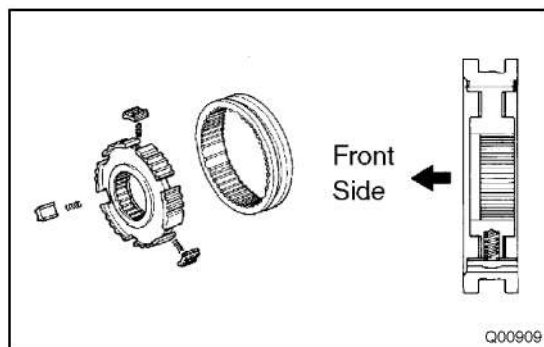
If the outer diameter is less than the minimum, replace the input shaft.



- (c) Using a dial indicator, check the shaft runout.

Maximum runout: 0.05 mm (0.0020 in.)

If the runout exceeds the maximum, replace the input shaft.



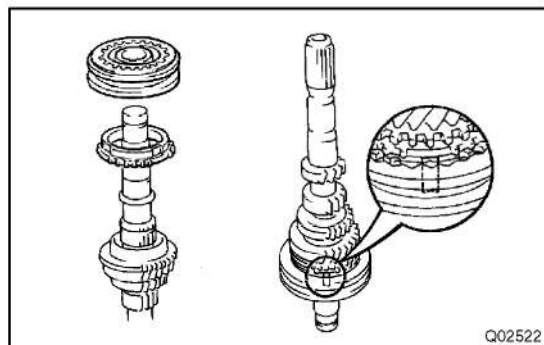
REASSEMBLY

HINT:

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

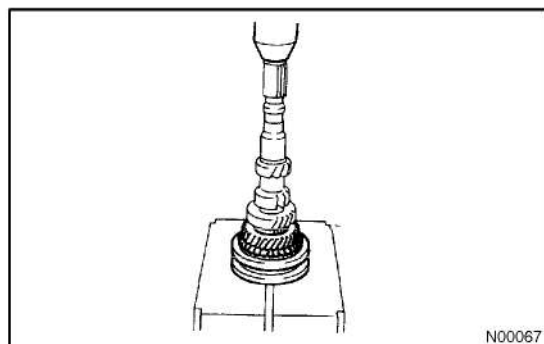
1. INSTALL NO.2 CLUTCH HUB INTO NO.2 HUB SLEEVE

- Install the 3 springs and shifting keys to the No.2 clutch hub.
- Install the No.2 hub sleeve to the No. 2 clutch hub.

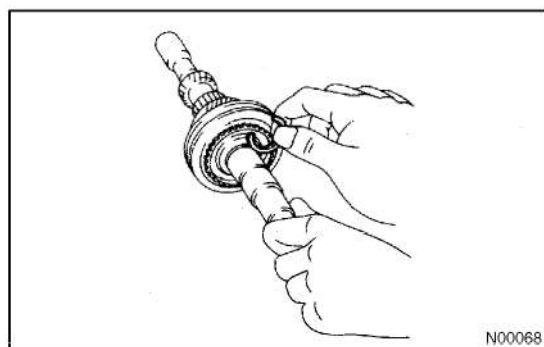


2. INSTALL 3RD GEAR, NEEDLE ROLLER BEARING, SYNCHRONIZER RING AND NO. 2 HUB SLEEVE ASSEMBLY TO INPUT SHAFT

- Apply gear oil to the needle roller bearings.
- Place the synchronizer ring on the gear and align the ring slots with shifting keys.



- Using a press, install the 3rd gear and No.2 hub sleeve assembly.



3. INSTALL SNAP RING

- Select a snap ring that allows the minimum axial play.

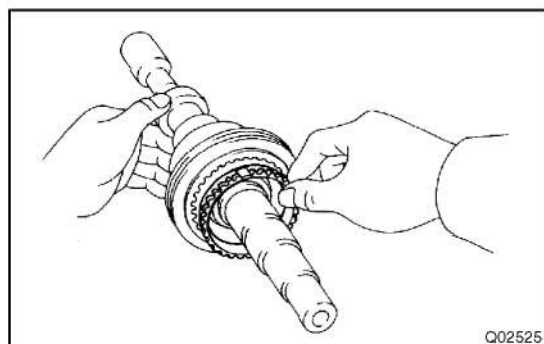
Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
0	2.30 (0.0906)	3	2.48 (0.0976)
1	2.36 (0.0929)	4	2.54 (0.1000)
2	2.42 (0.0953)	5	2.60 (0.1024)

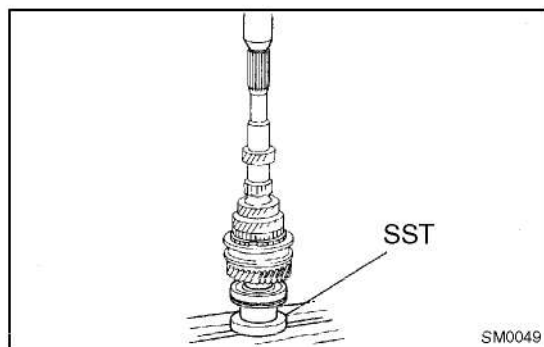
- Using a screwdriver and hammer, tap in the snap ring.

4. INSPECT 3RD GEAR THRUST CLEARANCE (See page MX-22)

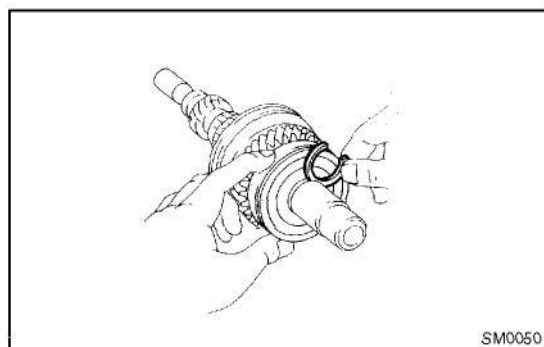
5. INSPECT SYNCHRONIZER RING, NEEDLE ROLLER BEARING, SPACER, 4TH GEAR AND REAR BALL BEARING

- Apply gear oil to the needle roller bearings.
- Place the synchronizer ring on the gear and align the ring slots with the shifting keys.





- (c) Using SST and a press, install the rear ball bearing.
SST 09608-03071



6. INSTALL SNAP RING

- (a) Select a snap ring that allows the minimum axial play.

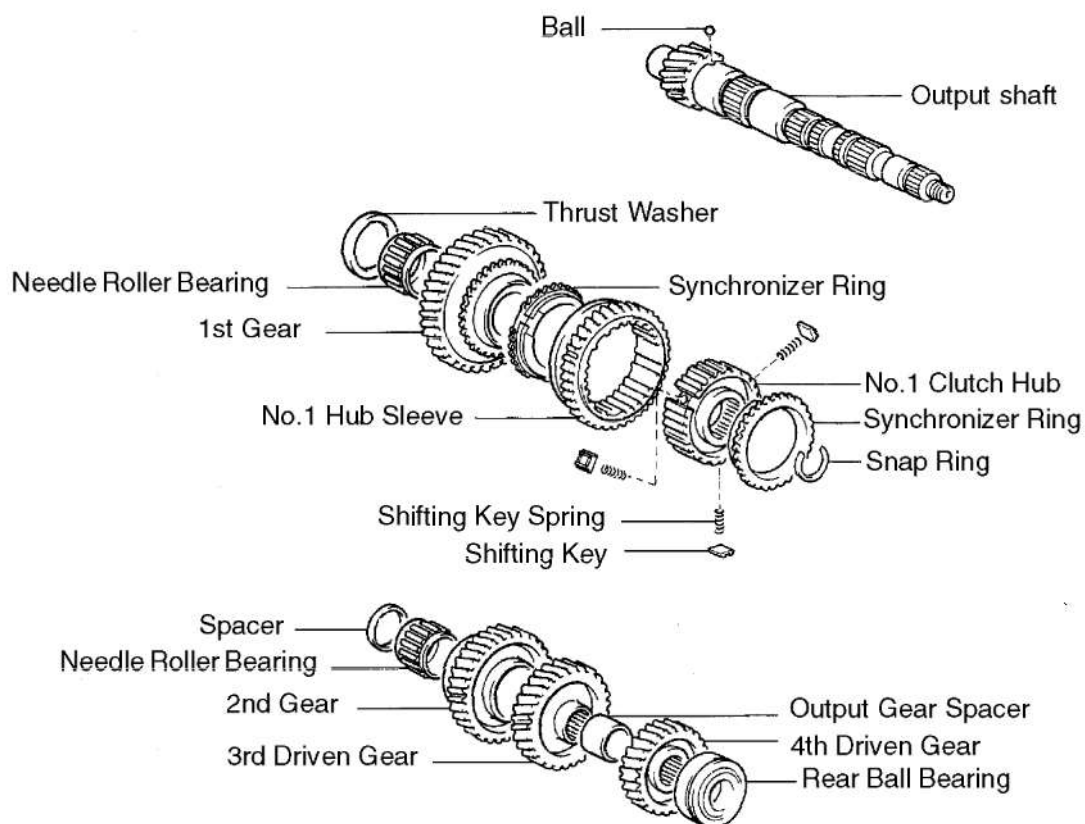
Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.29 (0.0902)	D	2.47 (0.0972)
B	2.35 (0.0925)	E	2.53 (0.0996)
C	2.41 (0.0949)	F	2.59 (0.1020)

- (b) Using a screwdriver and hammer, tap in the snap ring.

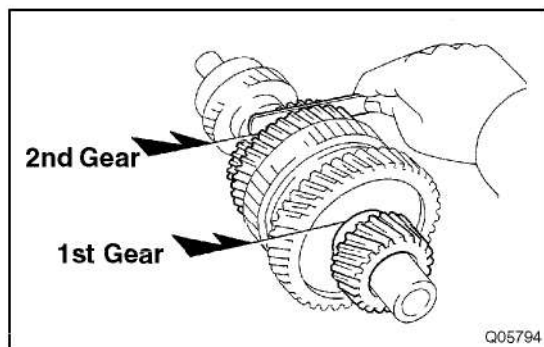
7. INSPECT 4TH GEAR THRUST CLEARANCE (See page MX-22)

OUTPUT SHAFT COMPONENTS

MX00E-02



Q07853



DISASSEMBLY

1. INSPECT 1ST AND 2ND GEARS THRUST CLEARANCES

Using a feeler gauge, measure each thrust clearance.

Standard clearance:

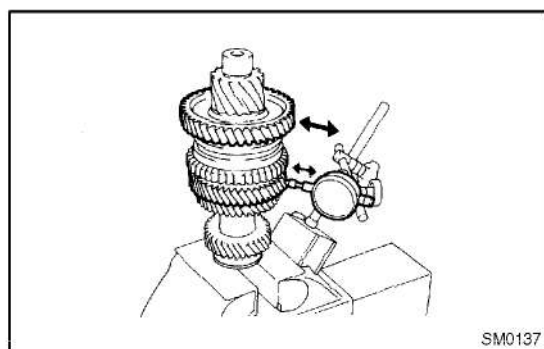
1st gear: 0.10–0.40 mm (0.0039–0.0157 in.)

2nd gear: 0.10–0.45 mm (0.0039–0.0177 in.)

Maximum clearance:

1st gear: 0.45 mm (0.0177 in.)

2nd gear: 0.50 mm (0.0197 in.)



2. INSPECT 1ST AND 2ND GEARS RADIAL CLEARANCE

Using a dial indicator, measure the radial clearance between the gear and shaft.

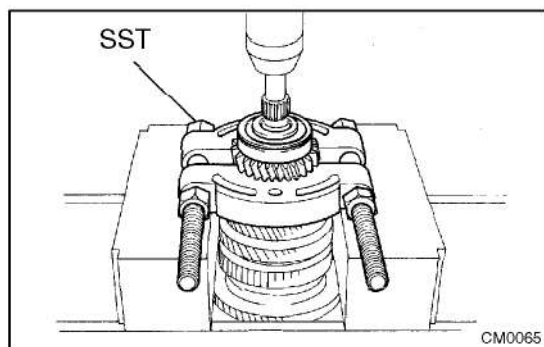
Standard clearance:

0.015–0.058 mm (0.0006–0.0023 in.)

Maximum clearance:

0.070 mm (0.0028 in.)

If the clearance exceeds the maximum, replace the gear, needle roller bearing or shaft.

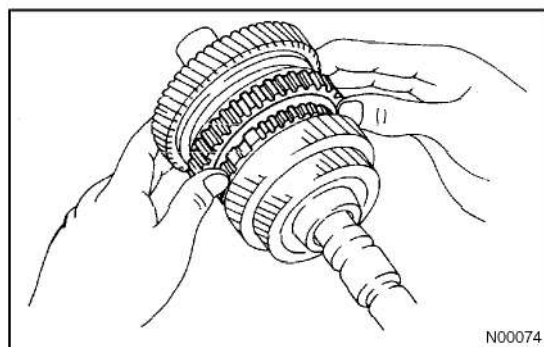


3. REMOVE REAR BALL BEARING, 4TH DRIVEN GEAR AND OUTPUT GEAR SPACER FROM OUTPUT SHAFT

- (a) Using SST and a press, remove the ball bearing and 4th driven gear.

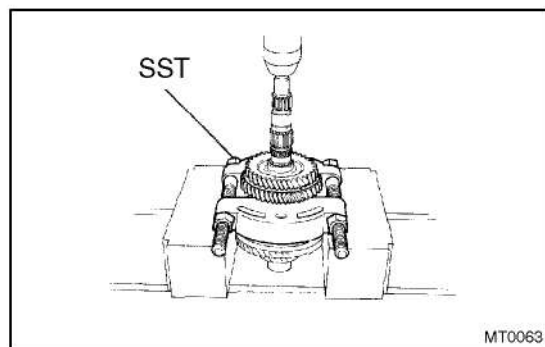
SST 09950-00020

- (b) Remove the output spacer.



4. REMOVE 3RD DRIVEN GEAR, 2ND GEAR, NEEDLE ROLLER BEARING, SYNCHRONIZER RING AND SPACER

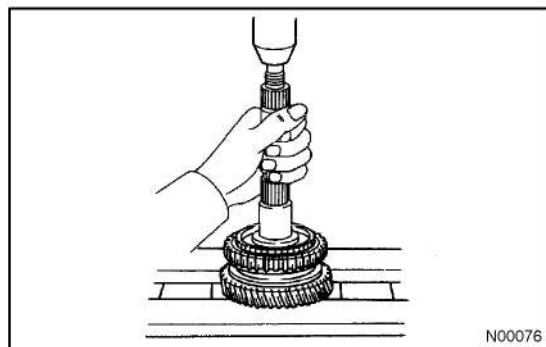
- (a) Shift the No.1 hub sleeve into the 1st gear.



- (b) Using SST and a press, remove the 3rd driven gear.
SST 09950-00020
- (c) Remove the 2nd gear, needle roller bearing, synchronizer ring and spacer.

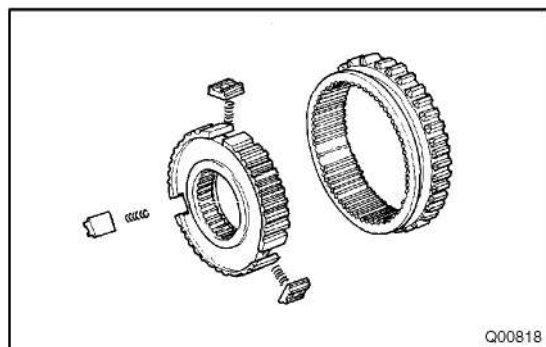
5. REMOVE SNAP RING

Using 2 screwdrivers and a hammer, tap out the snap ring.



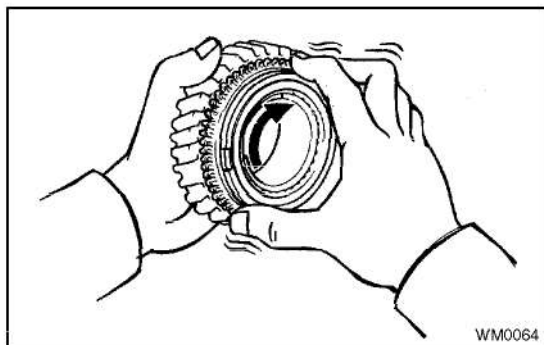
6. REMOVE NO.1 HUB SLEEVE ASSEMBLY 1ST GEAR, SYNCHRONIZER RING, NEEDLE ROLLER BEARING, THRUST WASHER AND BALL

- (a) Using a press, remove the No.1 hub sleeve assembly, 1st gear and synchronizer ring.
- (b) Remove the needle roller bearing, thrust washer and ball.



7. REMOVE NO.1 HUB SLEEVE, SHIFTING KEY AND SPRING FROM NO.1 CLUTCH HUB

Remove the 3 shifting keys, springs and No.1 hub sleeve from the No.1 clutch hub.



INSPECTION

1. INSPECT SYNCHRONIZER RING

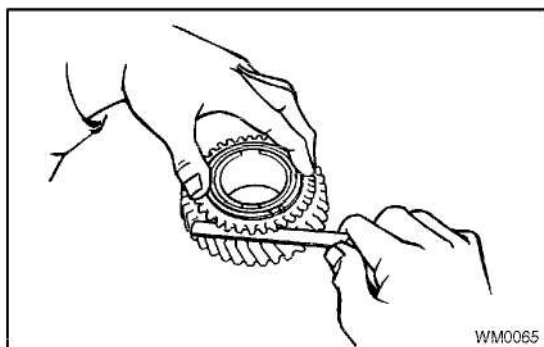
- (a) Check wear or damage.
- (b) Check the braking effect of the synchronizer ring.
Turn the synchronizer ring in one direction while pushing it to the gear cone. Check that the ring locks.

If the braking effect is insufficient, apply a small amount of the fine lapping compound between the synchronizer ring and gear cone. Lightly rub the synchronizer ring and gear cone together.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.

- (c) Check again the braking effect of the synchronizer ring.



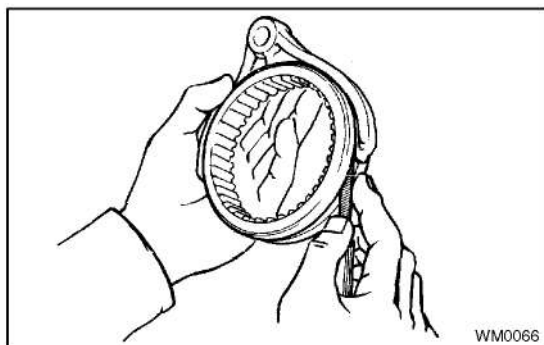
- (d) Using a feeler gauge, measure the clearance between the synchronizer ring back and gear spline end.

Minimum clearance: 0.6 mm (0.024 in.)

If the clearance is less than the minimum, replace the synchronizer ring, and apply a small amount of the fine lapping compound on gear cone.

NOTICE:

Ensure the fine lapping compound is completely washed off after rubbing.

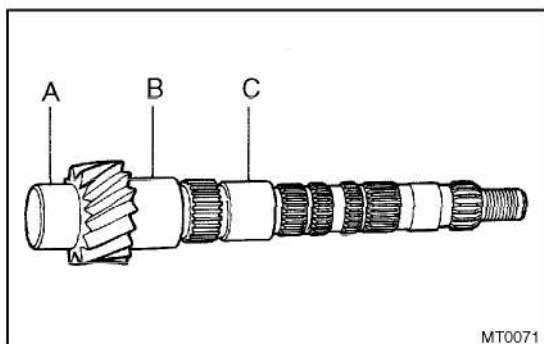


2. INSPECT SHIFT FORK AND HUB SLEEVE CLEARANCE

Using a feeler gauge, measure the clearance between the hub sleeve and shift fork.

Maximum clearance: 1.0 mm (0.039 in.)

If the clearance exceeds the maximum, replace the shift fork or hub sleeve.



3. INSPECT OUTPUT SHAFT

- (a) Check the output shaft for wear or damage.
- (b) Using a micrometer, measure the outer diameter of the output shaft journal surface.

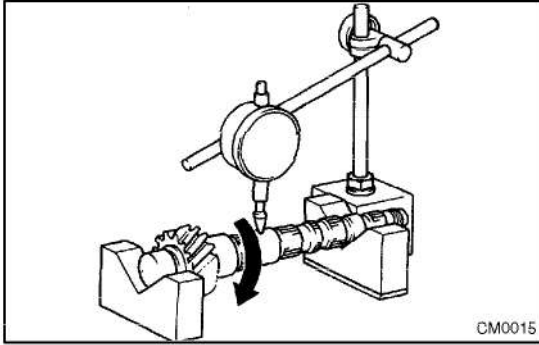
Minimum outer diameter:

Part A: 32.970 mm (1.2980 in.)

Part B: 37.970 mm (1.4949 in.)

Part C: 31.970 mm (1.2587 in.)

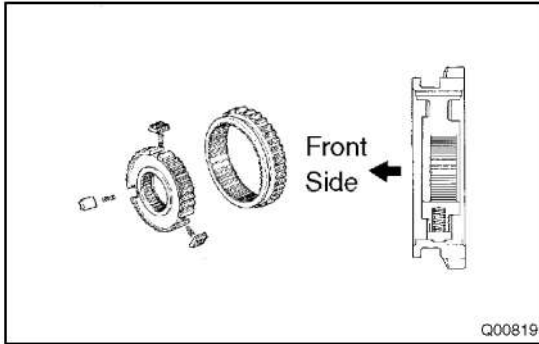
If the outer diameter is less than the minimum, replace the output shaft.



(c) Using a dial indicator, check the shaft runout.

Maximum runout: 0.05 mm (0.0020 in.)

If the runout exceeds the maximum, replace the output shaft.



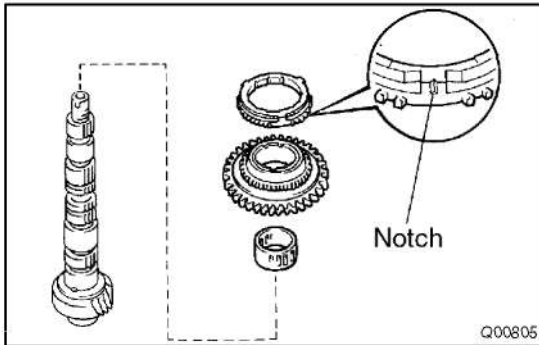
REASSEMBLY

HINT:

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

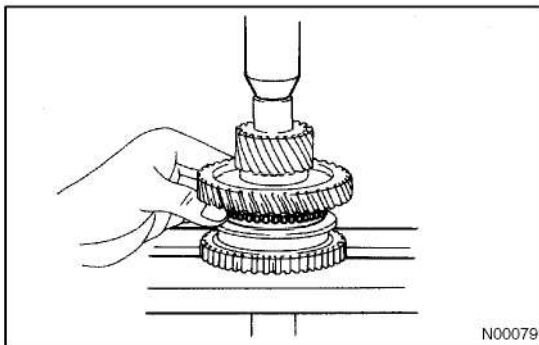
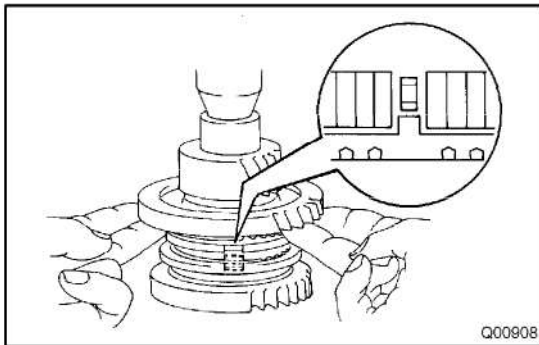
1. INSTALL NO.1 CLUTCH HUB INTO NO.1 HUB SLEEVE

- Install the 3 springs and shifting keys to the No.1 clutch hub.
- Install the No.1 clutch hub to the No.1 hub sleeve.

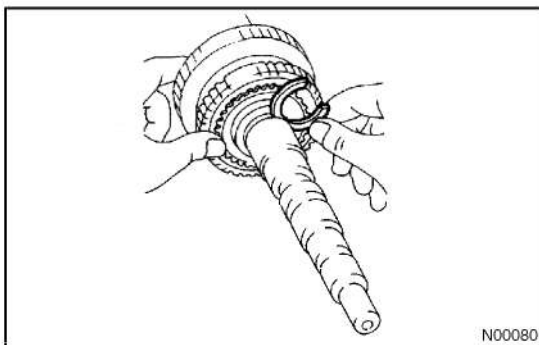


2. INSTALL BALL, THRUST WASHER, 1ST GEAR, NEEDLE ROLLER BEARING, SYNCHRONIZER RING AND NO.1 HUB SLEEVE ASSEMBLY TO OUTPUT SHAFT

- Install the ball to the shaft.
- Fit the thrust washer groove securely over the locking ball when installing the thrust on the shaft.
- Apply gear oil to the needle roller bearing.
- Install the needle roller bearing, 1st gear and synchronizer ring.
- Place the synchronizer ring on the gear and align the clutch hub grooves with the projections on the synchronizer ring.



- Using a press, install the 1st gear and No.1 hub sleeve.



3. INSTALL SNAP RING

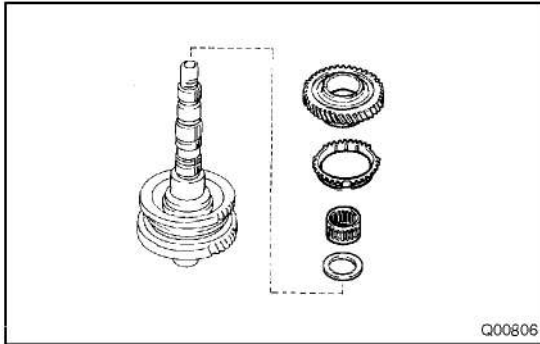
- Select a snap ring that allows the minimum axial play.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.50 (0.0984)	D	2.68 (0.1055)
B	2.56 (0.1008)	E	2.74 (0.1079)
C	2.62 (0.1031)	F	2.80 (0.1102)

- Using a screwdriver and hammer, tap in the snap ring.

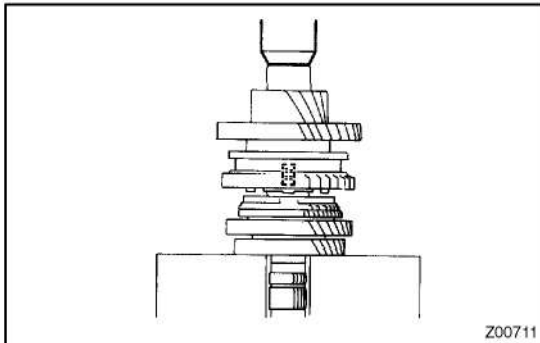
4. INSPECT 1ST GEAR THRUST CLEARANCE

(See page MX-29)



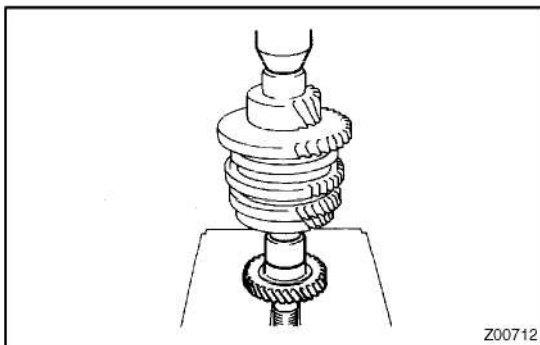
5. INSTALL SYNCHRONIZER RING, SPACER, NEEDLE ROLLER BEARING, 2ND GEAR AND 3RD DRIVEN GEAR

- (a) Place the synchronizer ring on the gear and align the clutch hub grooves with the projections on the synchronizer ring.
- (b) Install the spacer.
- (c) Apply gear oil to the needle roller bearing.
- (d) Install the 2nd gear.



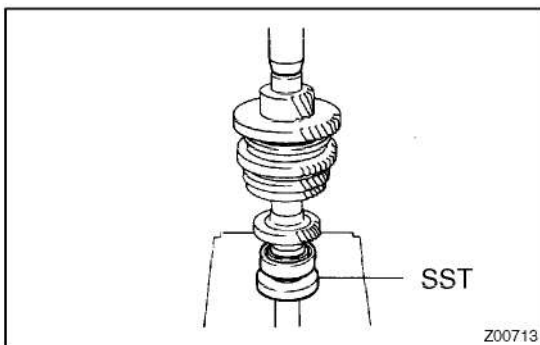
- (e) Using a press, install the 3rd driven gear.

6. INSPECT 2ND GEAR THRUST CLEARANCE
(See page MX-29)



7. INSTALL OUTPUT GEAR SPACER AND 4TH DRIVEN GEAR

- (a) Install the output gear spacer.
- (b) Using a press, install the 4th driven gear.

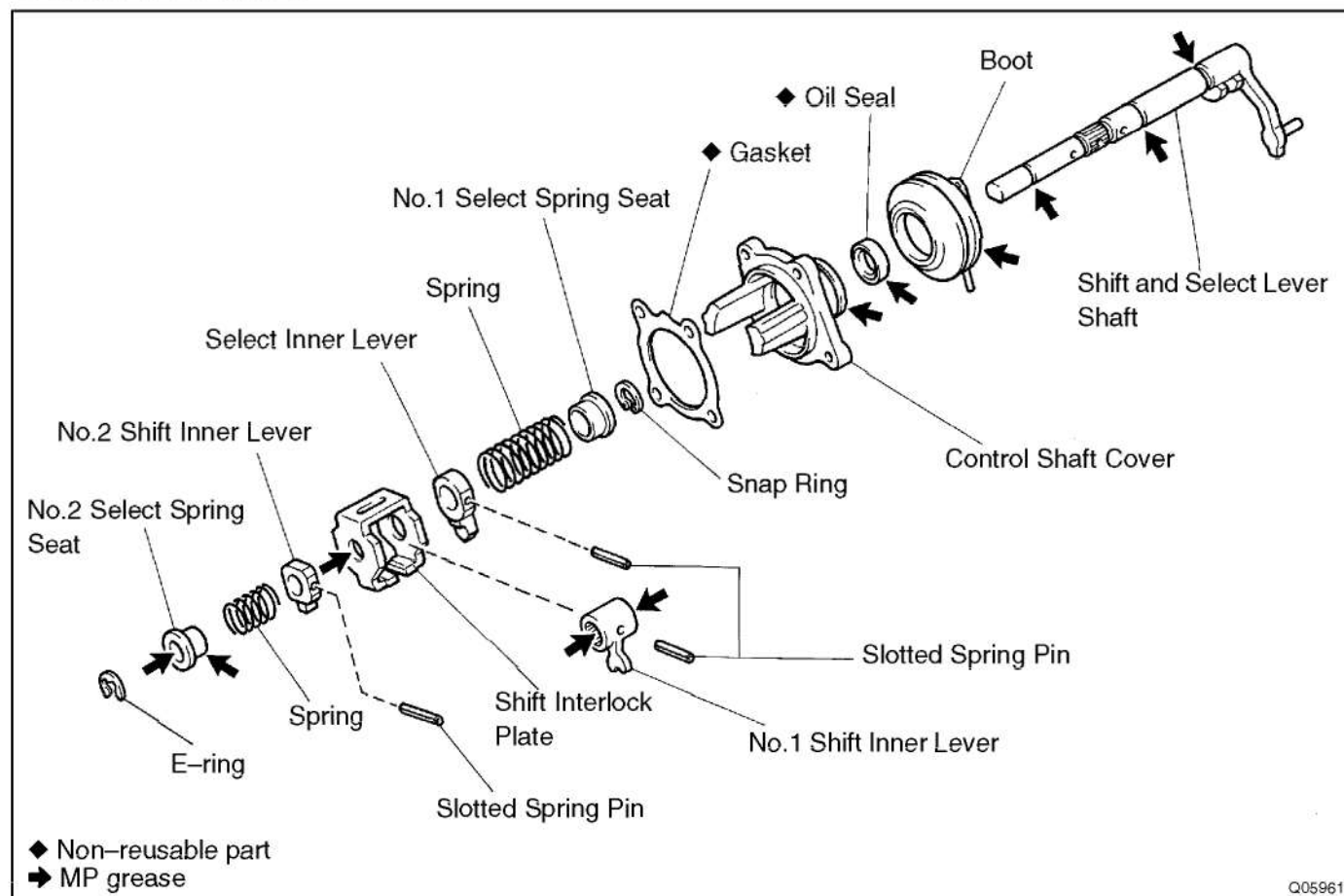


8. INSTALL REAR BALL BEARING

Using SST and a press, install the rear ball bearing.
SST 09316-60011 (09316-00021)

SHIFT AND SELECT LEVER SHAFT COMPONENTS

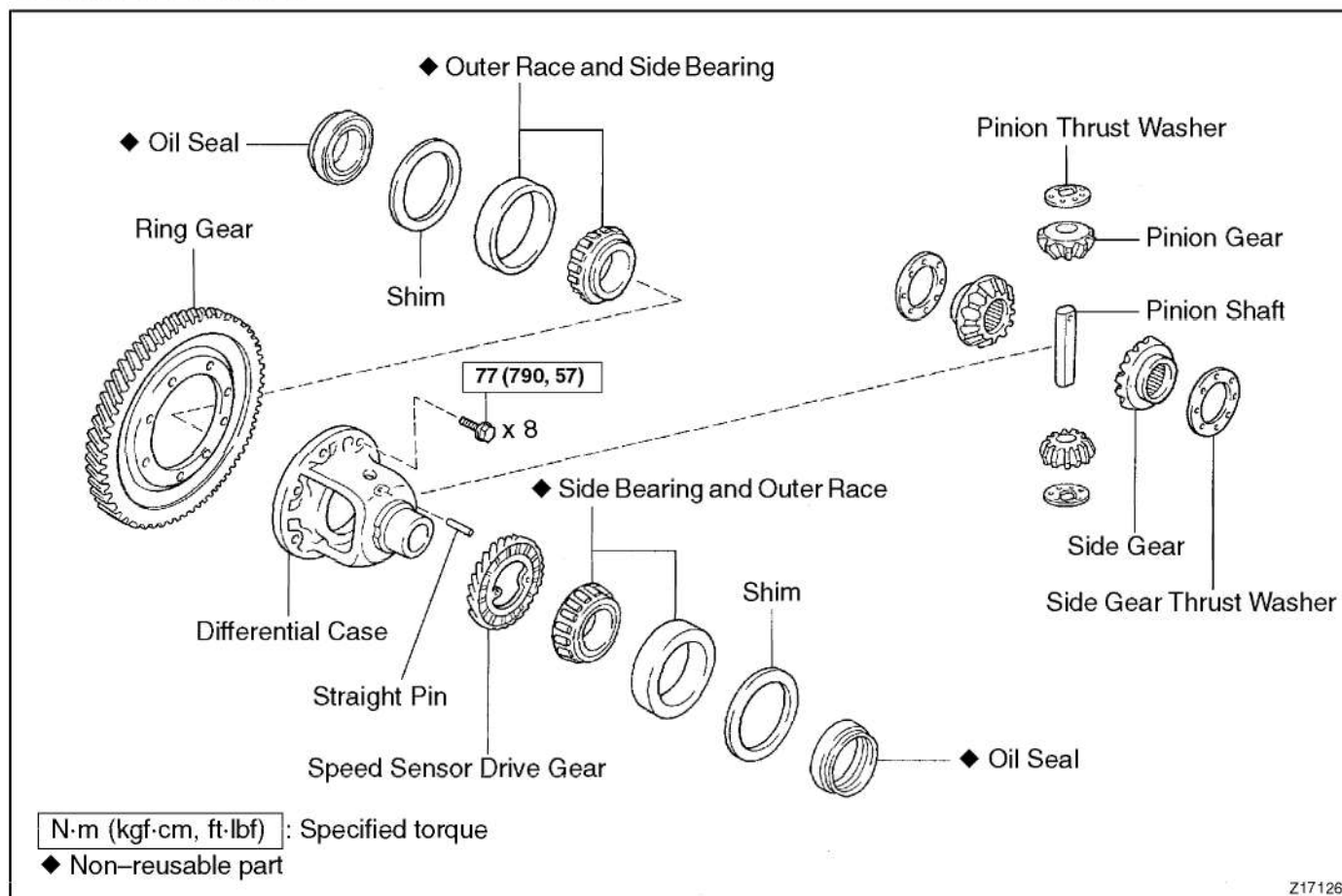
MX001-02



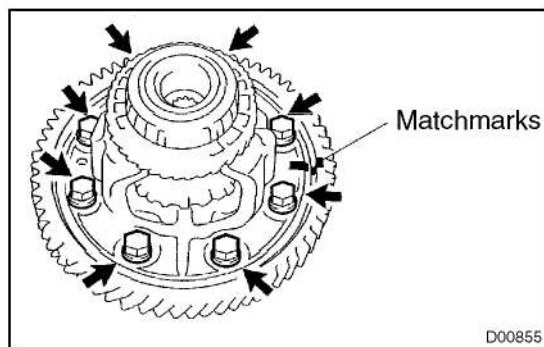
Q05961

DIFFERENTIAL CASE COMPONENTS

MX00J-02



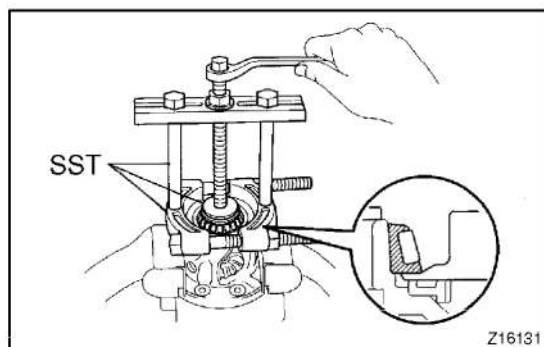
Z17126



DISASSEMBLY

1. REMOVE RING GEAR

- Place matchmarks on the ring gear and case.
- Remove the 8 bolts.
- Using a copper hammer, tap on the ring gear to remove it from the case.



2. Speed Sensor Drive Gear Side:

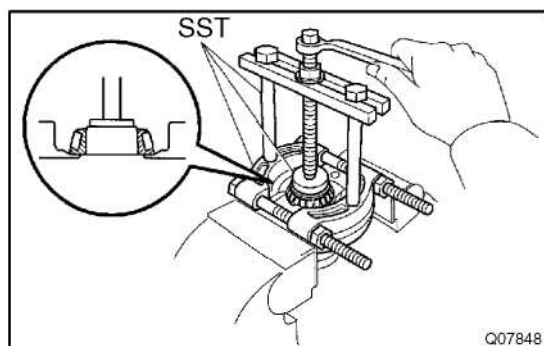
REMOVE SIDE BEARING FROM DIFFERENTIAL CASE

- Using SST, remove the side bearing.
SST 09950-00020, 09950-00030, 09950-60010 (09951-00360)

HINT:

Set the claw of SST to the bearing inner race at the position where the speed sensor drive gear is indented.

- Remove the speed sensor drive gear.



3. Ring Gear Side:

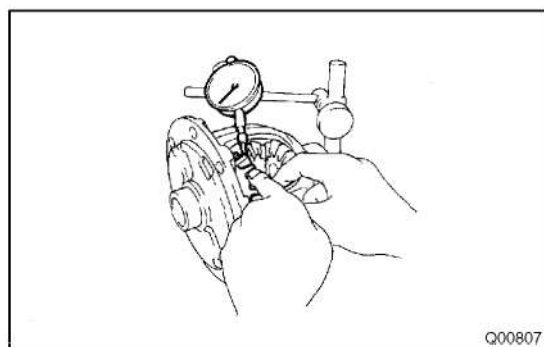
REMOVE SIDE BEARING FROM DIFFERENTIAL CASE

Using SST, remove the side bearing.

SST 09950-00020, 09950-00030, 09950-60010 (09951-00360)

HINT:

Set the claw of SST to the bearing inner race at the position where the differential case is indented.



4. INSPECT SIDE GEAR BACKLASH

Using a dial indicator, measure the backlash of one side gear while holding one pinion toward the case.

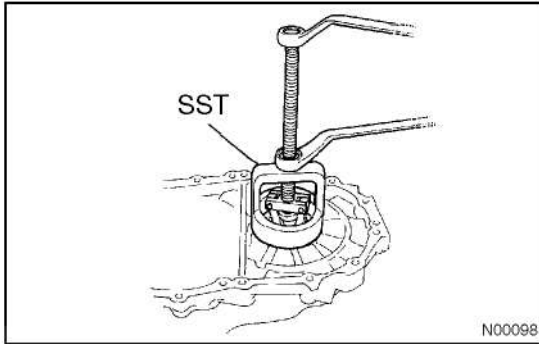
Standard backlash:

0.05 – 0.20 mm (0.0020 – 0.0079 in.)

If the backlash is not within the specification, install the correct thrust washer to the side gears.

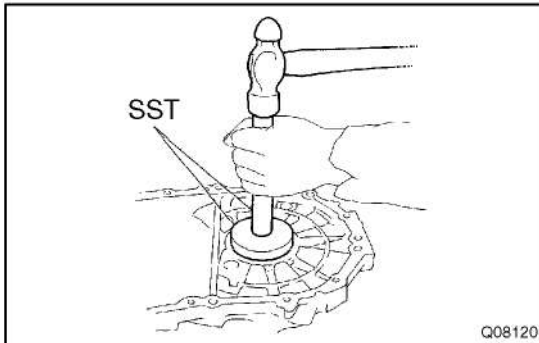
5. DISASSEMBLE DIFFERENTIAL CASE

- Using a pin punch and hammer, drive out the straight pin.
- Remove the pinion shaft from the case.
- Remove the 2 pinions and side gears with the 4 thrust washers from each gear.

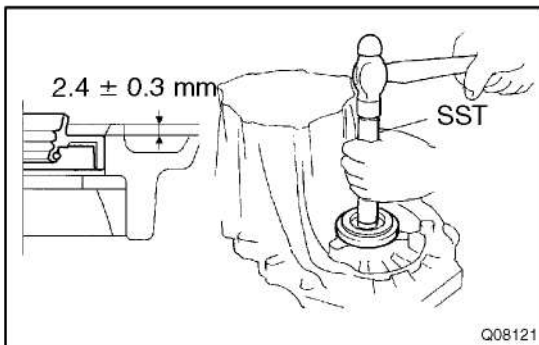


**6. Transmission Case Side:
IF NECESSARY, REPLACE OIL SEAL AND SIDE
BEARING OUTER RACE**

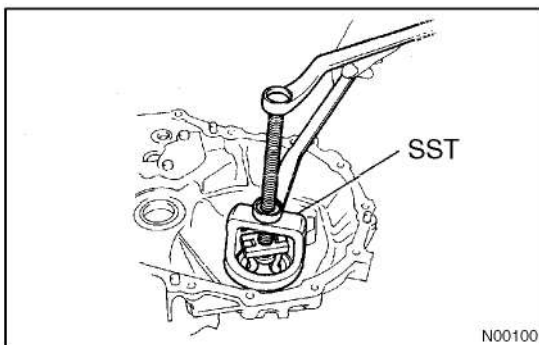
- (a) Using a screwdriver and hammer, drive out the oil seal.
- (b) Using SST, pull out the outer race and shim.
SST 09612-65014
- (c) Place the shim into the case.



- (d) Using SST and a hammer, drive in a new outer race.
SST 09950-60020 (09951-00710), 09950-70010
(09951-07150)

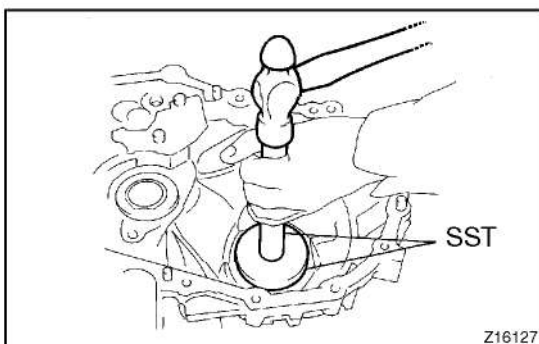


- (e) Using SST and a hammer, drive in a new oil seal.
SST 09350-32014 (09351-32111, 09351-32130)
Drive in depth: 2.4 ± 0.3 mm (0.094 ± 0.012 in.)
- (f) Coat the lip of the oil seal with MP grease.

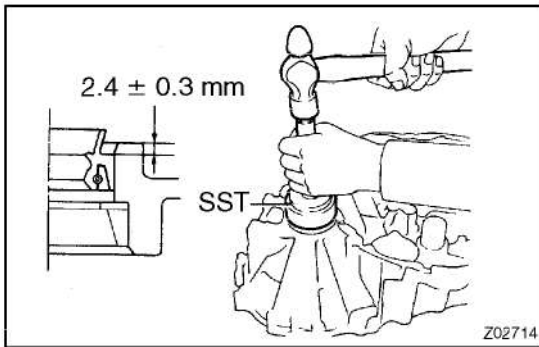


**7. Transaxle Case Side:
IF NECESSARY, REPLACE OIL SEAL AND SIDE
BEARING OUTER RACE**

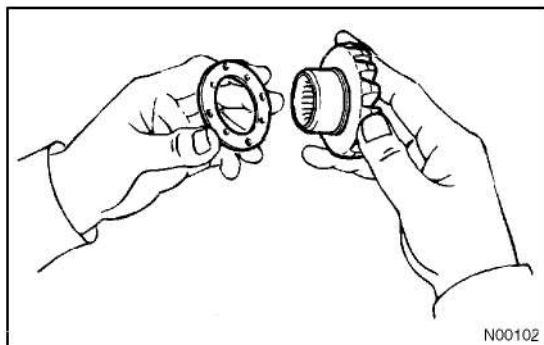
- (a) Using a screwdriver and hammer, drive out the oil seal.
- (b) Using SST, pull out the outer race and shim.
SST 09612-65014
- (c) Place the shim into the case.



- (d) Using SST and a hammer, drive in a new outer race.
SST 09950-60020 (09951-00680), 09950-70010
(09951-07150)



- (e) Using SST and a hammer, drive in a new oil seal.
SST 09350-32014 (09351-32130, 09351-32150)
Drive in depth: 2.4 ± 0.3 mm (0.075 ± 0.012 in.)
- (f) Coat the lip of the oil seal with MP grease.



REASSEMBLY

1. ASSEMBLE DIFFERENTIAL CASE

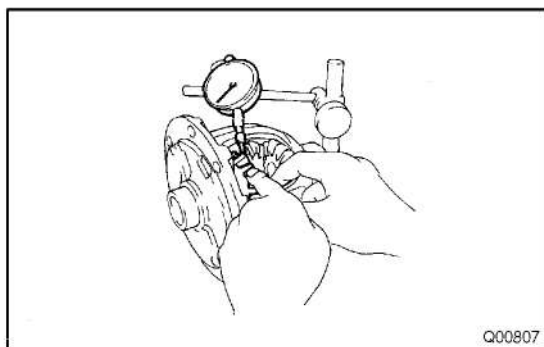
- (a) Install the correct thrust washers and side gears. Refer to the table below, select thrust washers which will allow that the backlash is within the specification.

Standard backlash:

0.05 – 0.20 mm (0.0020 – 0.0079 in.)

Thickness mm (in.)	Thickness mm (in.)
0.95 (0.0374)	1.10 (0.0433)
1.00 (0.0394)	1.15 (0.0453)
1.05 (0.0413)	1.20 (0.0472)

- (b) Install the thrust washers and side gears in the differential case.
(c) Install the pinion shaft.



- (d) Using a dial indicator, check the side gear backlash. Measure the side gear backlash while holding one pinion gear toward the case.

Standard backlash:

0.05 – 0.20 mm (0.0020 – 0.0079 in.)

If the backlash is not within the specification, install a thrust washer of different thickness.

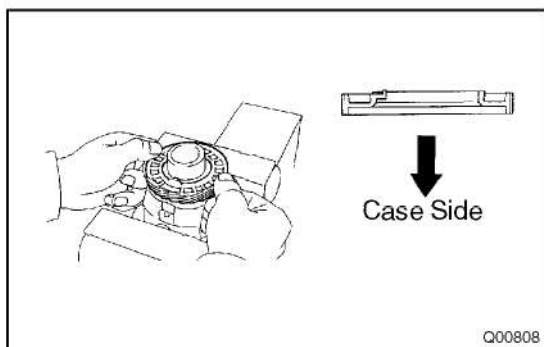
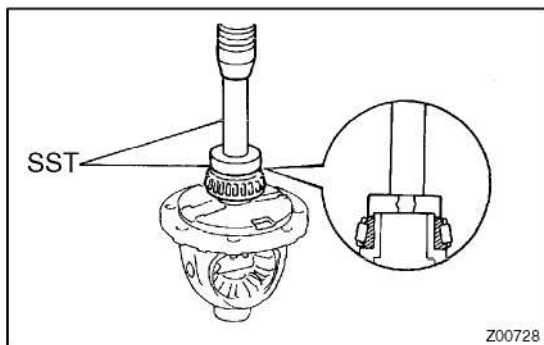
- (e) Using a pin punch and hammer, drive in the straight pin through the case and hole in the pinion shaft.
(f) Stake the differential case.

2. Ring Gear Side:

INSTALL SIDE BEARING

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

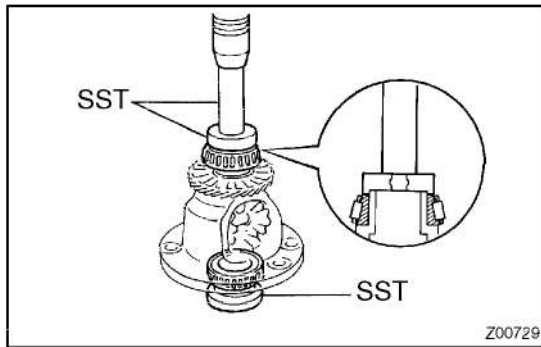
SST 09550-10012 (09252-10010, 09556-10010)



3. Speed Sensor Drive Side:

INSTALL SIDE BEARING

- (a) Install the speed sensor drive gear.



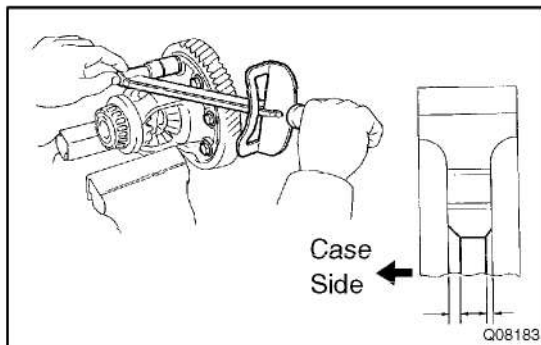
- (b) Using SST and a press, install a new side bearing.
 SST 09550-10012 (09556-10010), 09950-60010
 (09951-00460), 09950-70010 (09951-07150)

4. INSTALL RING GEAR ON DIFFERENTIAL CASE

- Clean the contact surface of the differential case.
- Heat the ring gear in boiling water.
- Carefully take the ring gear out of the water.
- After the moisture on the ring gear has completely evaporated, quickly install the ring gear to the differential case.

HINT:

Align the matchmarks on the differential case and contact the ring gear.



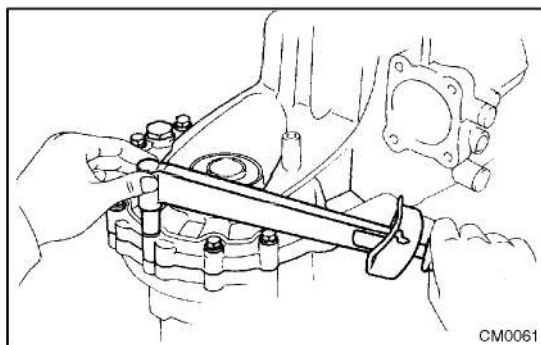
- (e) Temporarily install the 8 set bolts.

NOTICE:

The ring gear set bolts should not be tightened until the ring gear has cooled sufficiently.

- (f) After the ring gear has cooled sufficiently, torque the ring gear set bolts uniformly at a time.

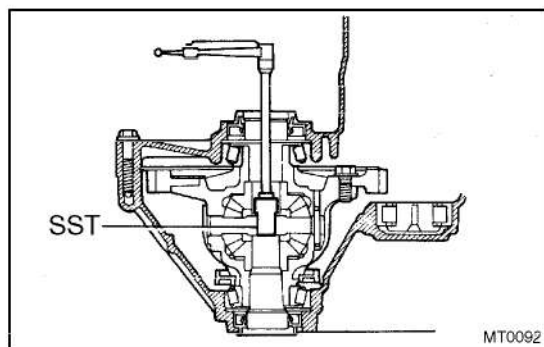
Torque: 77 N·m (790 kgf·cm, 57 ft·lbf)



5. INSPECT DIFFERENTIAL SIDE BEARING PRELOAD

- Install the differential case assembly to the transaxle case.
- Install the transmission case.
- Install and torque the case bolts.

Torque: 29 N·m (300 kgf·cm, 22 ft·lbf)



- (d) Using SST and a torque wrench, measure the preload.
SST 09564-32011

Preload (at starting):

New bearing

0.8 – 1.6 N·m (8 – 16 kgf·cm, 6.9 – 13.9 in.·lbf)

Reused bearing

0.5 – 1.0 N·m (5 – 10 kgf·cm, 4.3 – 8.7 in.·lbf)

If the preload is not within the specification, remove the transmission case side outer race of the side bearing with SST.

(See page MX-37)

Select another shim.

HINT:

The preload will change by about 0.3 – 0.4 N·m (3 – 4 kgf·cm, 2.6 – 3.5 in.·lbf) with each 0.05 mm change in shim thickness.

Mark	Thickness mm (in.)	Mark	Thickness mm (in.)
A	2.10 (0.0827)	L	2.60 (0.1024)
B	2.15 (0.0846)	M	2.65 (0.1043)
C	2.20 (0.0866)	N	2.70 (0.1063)
D	2.25 (0.0886)	P	2.75 (0.1083)
E	2.30 (0.0906)	Q	2.80 (0.1102)
F	2.35 (0.0925)	R	2.85 (0.1122)
G	2.40 (0.0945)	S	2.90 (0.1142)
H	2.45 (0.0965)	T	2.95 (0.1161)
J	2.50 (0.0984)	U	3.00 (0.1181)
K	2.55 (0.1004)	–	–

MXD6H-01



