



3. Before installing the cover make sure the sealing surfaces are clean and dry, and shafts are fully seated in the transmission case. Apply Crankcase Sealant (PN 2871557) to the mating surfaces.



Apply Crankcase Sealant to mating surfaces.

4. Reinstall the thrust button shim, thrust button, and other shims into the cover. Reinstall cover and torque bolts in a criss-cross pattern in 3 steps to 27-34 ft. lbs. (36.50-46 Nm).



Cover Bolt Torque: 27-34 ft.lbs. (36.5-46 Nm)

NOTE: Make sure that the case locating pins (knock pipes) are in place.

5. Install new front and rear output shaft seals. Apply grease to the seal lips. Cover the splines of the shaft to protect the seal lips during installation.
6. Install pinion shaft with bearing.
7. Install retainer plate with flat side toward bearing.

8. Apply Loctite™ 262 (Red) (PN 2871951) to screw threads and torque screws to 6-12 ft. lbs. (8-16 Nm).



Pinion Retainer Plate Bolt
Torque: 6-12 ft.lbs. (8-16 Nm)

9. Install the a new needle bearing, the 24T reverse sprocket, washer, and a new snap ring. Install the shift dogs and wave spring. Install the washer, a new needle bearing and the high gear. Install the press fit gear and ball bearing.



NOTE: Install a new snap ring at this time. When installing the new snap ring, open the the snap ring just far enough to go over the shaft, to avoid stressing the snap ring. If the snap ring is overstressed, it could come off the shaft and cause internal damage to the transmission.

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JE Gale



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