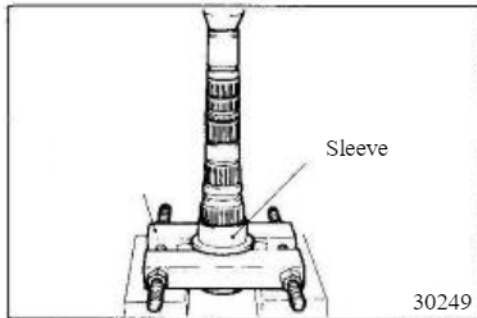
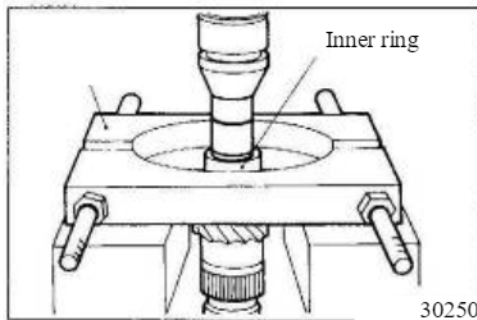
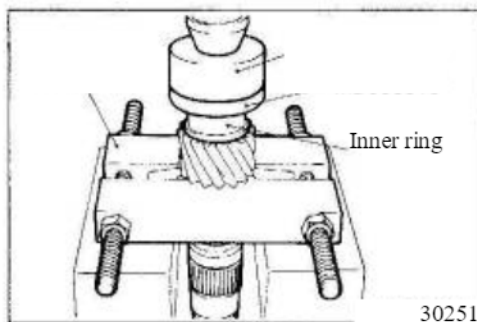




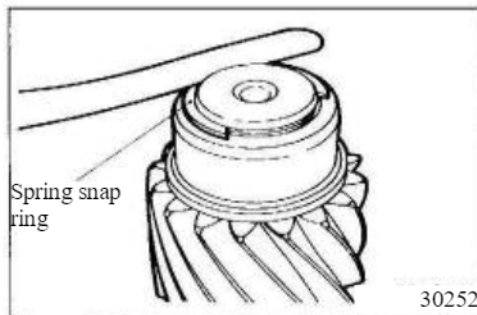
Unfixing the first-speed gear sleeve



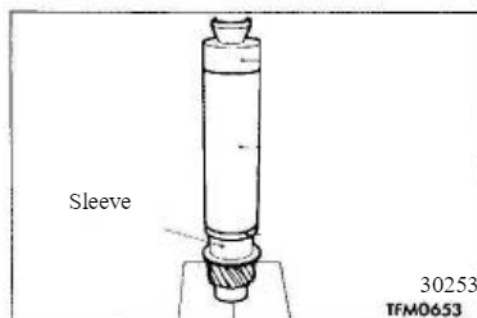
Unfixing the inner ring of the roller bearing



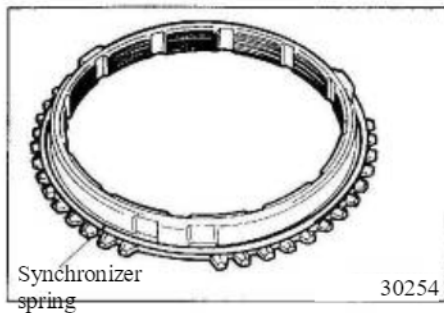
Notice for disassembly
Fixing the inner ring of the roller bearing



Fixing the spring snap ring
Select and fix the spring snap ring so that the axial clearance of the front bearing of the output shaft complies with the standard value.
Standard value: -0.01-0.12mm

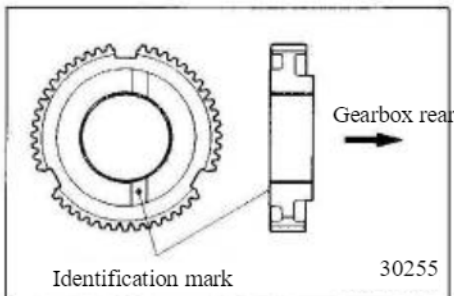


Fixing the first-speed gear sleeve



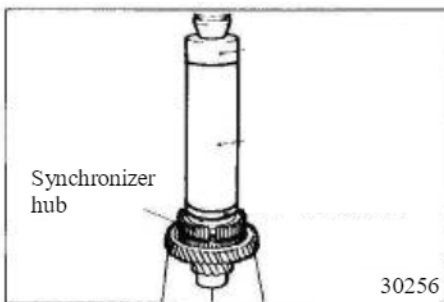
Fixing the synchronizer spring

Fix the synchronizer spring onto the synchronizer ring as the figure shows.



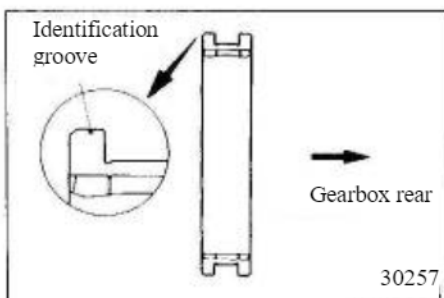
Fixing the first-gear and second-gear synchronizer hub

Fix the first-gear and second-gear synchronizer hub as the figure shows.



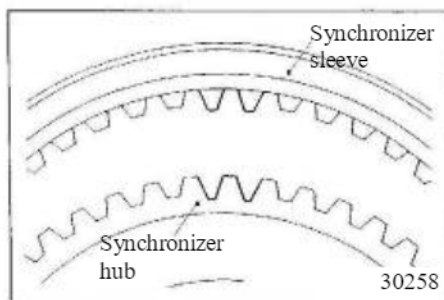
Note:

Please make sure that the synchronizer ring is not locked during fixing of the synchronizer hub.

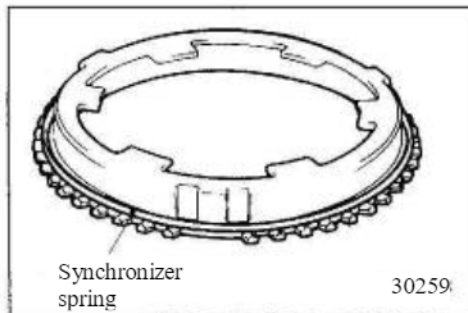


Fixing the synchronizer sleeve

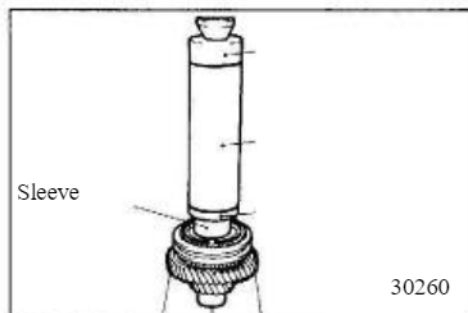
(1) Fix the synchronizer sleeve as the figure shows



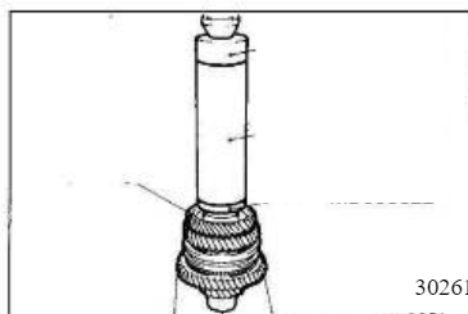
(2) Please make sure that the two deep tooth grooves of the synchronizer hub are aligned with the two high racks of the sleeve.



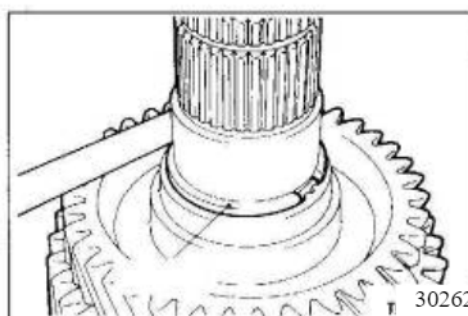
Fixing the synchronizer spring



Fixing the second-speed gear sleeve



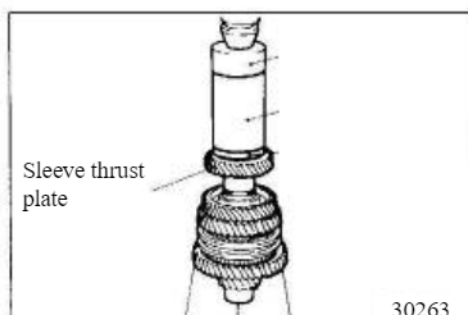
Fixing the third-speed gear sleeve



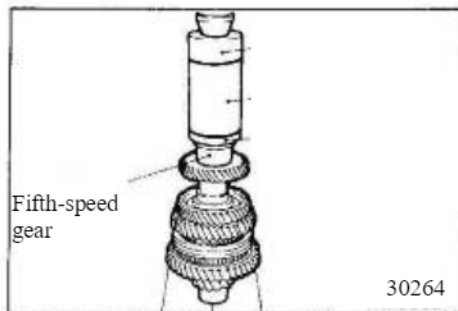
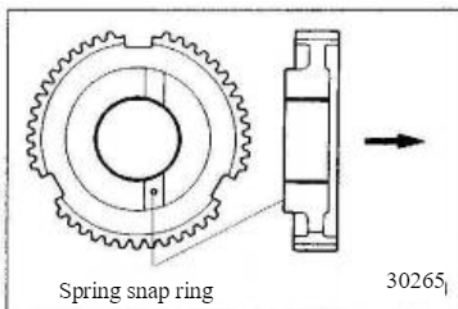
Fixing the spring snap ring

Fix the spring snap ring so that the axial clearance of the third-speed gear of the output shaft complies with the standard value.

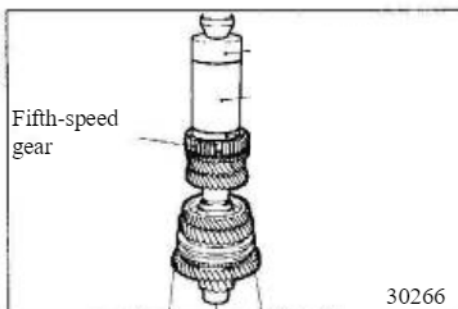
Standard value: -0.01-0.09mm



Fixing the fourth-speed gear

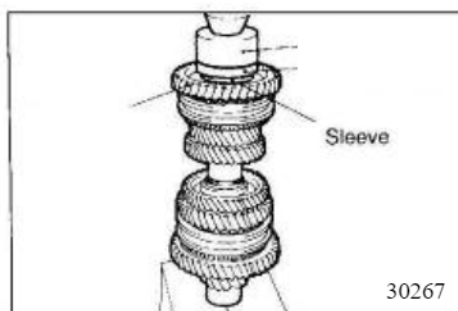
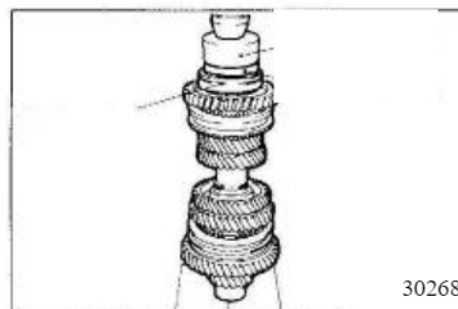

Fixing the fifth-speed gear sleeve

Fixing the fifth-gear and reverse-gear synchronizer hub

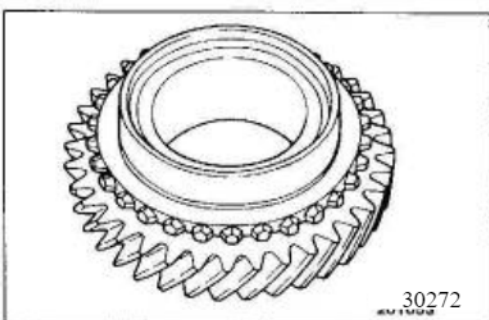
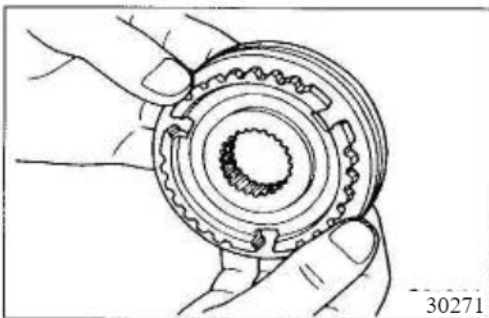
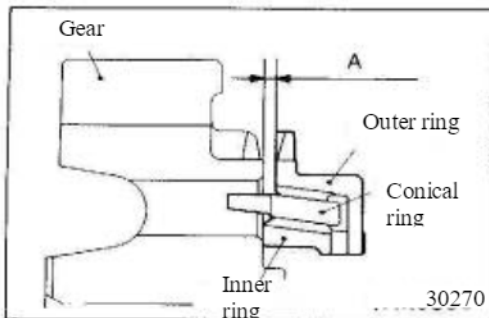
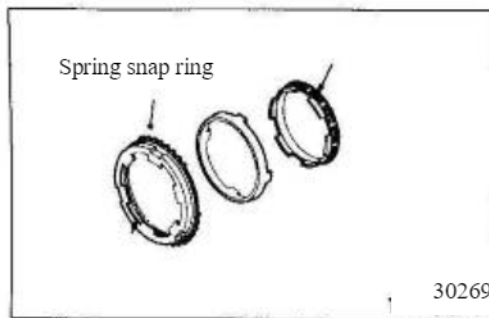
Fix the fifth-gear and reverse-gear synchronizer hub as the figure show.



Note:

Please make sure that the synchronizer ring is not locked during fixing of the fifth-gear and reverse-gear synchronizer hub.


Fixing the reverse gear/needle bearing/reverse-gear bearing sleeve

Fixing the ball bearing



Outer synchronizer ring/inner synchronizer ring/conical ring of synchronizer

(1) Check if there is any damage on the tooth surface and conical surface of the clutch gear.

(2) Fix the outer ring and inner ring and then measure Clearance "A" while pressing them against the gear. In case "A" is smaller than the limit, the ring shall be replaced.

Limit value: 0.5mm

Note: the whole set of inner ring, outer ring or conical ring shall be replaced if any of them needs replacement.

Synchronizer sleeve and hub

(1) Assemble the synchronizer sleeve and hub together and check if they are running smoothly together.

(2) Check if there is any damage to the front and rear ends of the sleeve's inner surface.

Note: the whole set of synchronizer sleeve and hub needs to be replaced if either of them needs replacement.

Synchronizer spring

Check if the spring is relaxed, deformed or worn out.

Transmission gear

(1) Check if there is any damage or wear on the tooth surface of bevel gear and clutch bearing

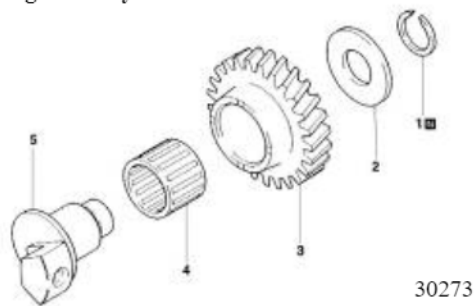
(2) Check if there is any abrasion, damage or wear on the surface of the synchronizer conical ring.

(3) Check if there is any damage or wear on the inner surface and front and rear ends of the gear.

Reverse Idle Gear Assembly and Disassembly

Apply all inner parts with lubricating oil
during assembly

Lubricate all inner components with
gear oil during assembly



30273

TFM0590

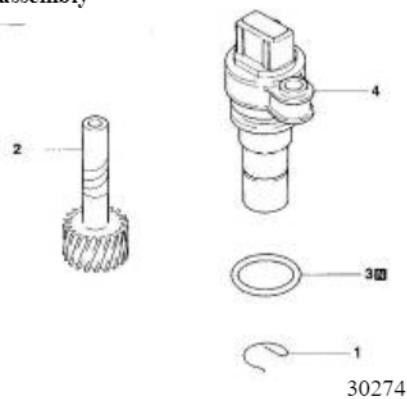
Disassembly steps:

1. Spring snap ring
2. Thrust washer
3. Reverse idle gear
4. Needle bearing
5. Reverse idle gear shaft

Checking**Needle bearing**

- (1) Assemble the bearing and shaft together and check if they are running smoothly together and if there is any loosening or noise.
- (2) Check if the bearing bracket is deformed or not.

Lubricate all inner components with gear oil during assembly



TFM0953

Speedometer gear**Assembly and disassembly**

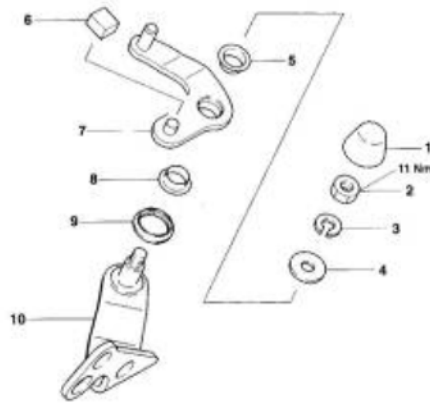
Apply all the inner parts with lubricating oil during assembly.

Disassembly steps:

1. E-shape steel clamp
2. Speedometer drive gear
3. O-ring
4. Sleeve

Gear lever

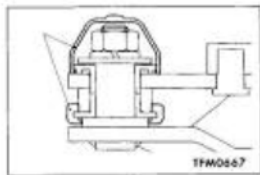
Assembly and disassembly



30275

Disassembly steps:

1. Dust cover
2. Nut
3. Spring washer
4. Washer
5. Gear lever lining
6. Gear lever sliding block
7. Gear lever
8. Gear lever lining
9. Dust cover
10. Gear lever shaft

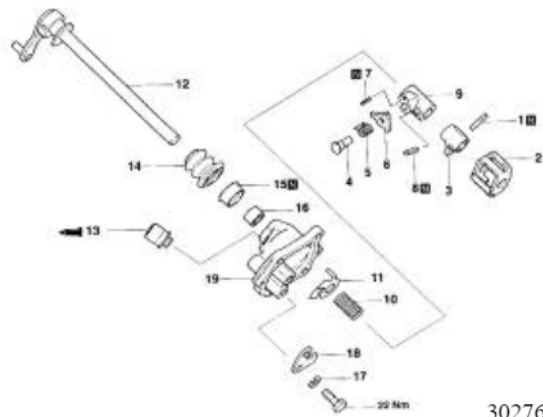


▶▶

Notice for assembly

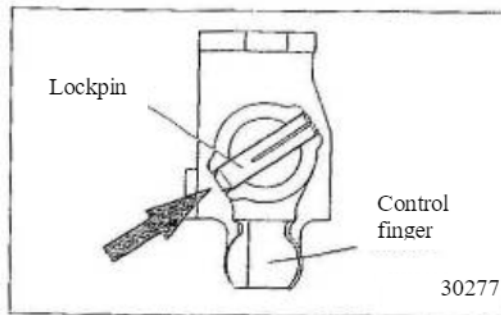
Fixing of dust cover

Controller Cover Assembly and Disassembly



Disassembly steps:

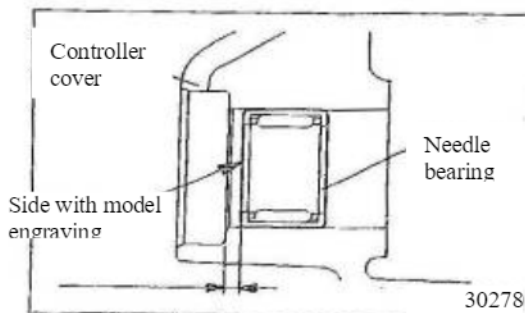
1. Lock pin
2. Interlocking plate
3. Control finger
4. Pin
5. Return spring
6. Retainer plate
7. Spring pin
8. Spring pin
9. Localizer
10. Middle return spring
11. Spacer
12. Control shaft
13. Air vent
14. Control shaft rubber sheath
15. Oil seal
16. Needle bearing
17. Spring washer
18. Localizer bracket
19. Controller cover



Notice for disassembly

Unfixing the lockpin

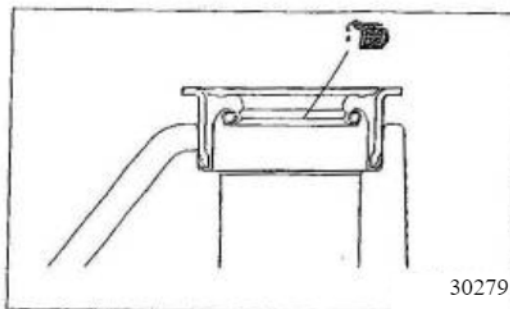
Strike out the lockpin in the direction as the figure shows



Notice for assembly

Fixing the needle bearing

Press the needle bearing in as the figure shows. The side with model engraving shall be on the side of the controller cover.

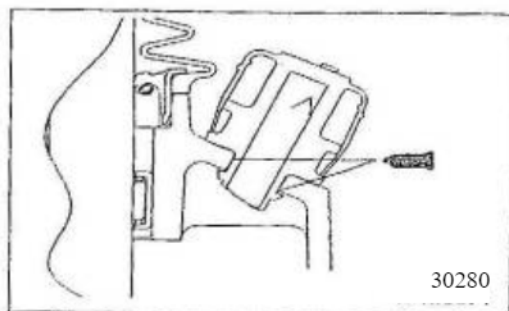


Fixing the oil seal

Apply gearbox oil onto oil seal lip.

Gearbox oil:

Hypoid gearbox oil SAE75W-85W that complies API categorization GL-4 or above

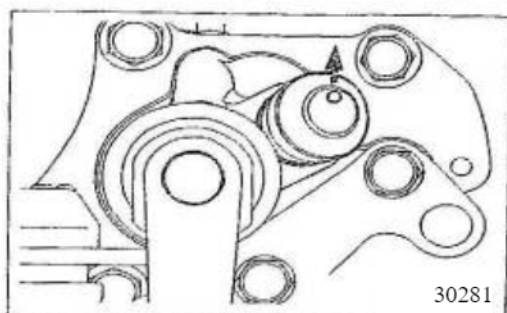


Fixing the air vent

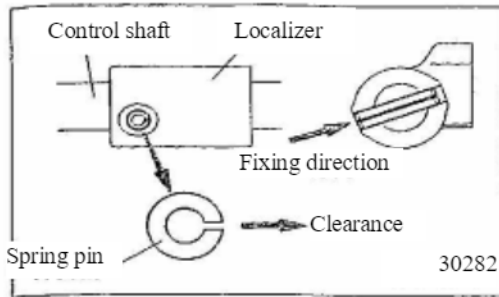
(1) Apply sealant onto the insertion surface.

Required sealant:

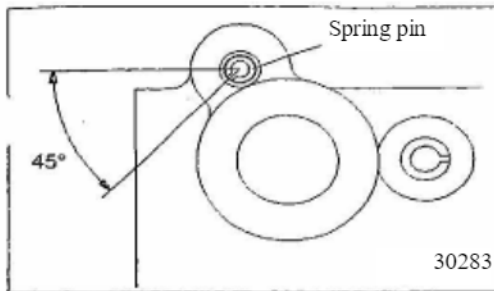
3M SUPER WEATHERSTRIP No. 8001 or equivalent



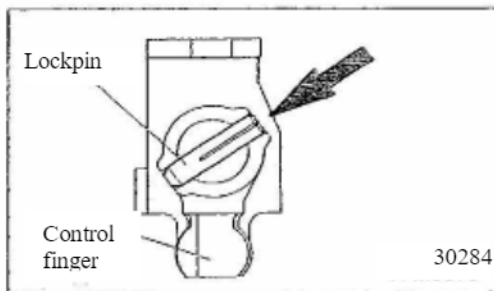
(2) Ensure that the protruding part is in the direction as the arrow shows.



►D◄ 弹簧销的安装
Fixing the spring pin



►E◄ 弹簧销的安装
Fixing the spring pin



►F◄ 锁销的安装
将锁销向图示方向冲出。
Fixing the lockpin
Strike out the lockpin in the direction as the figure shows.