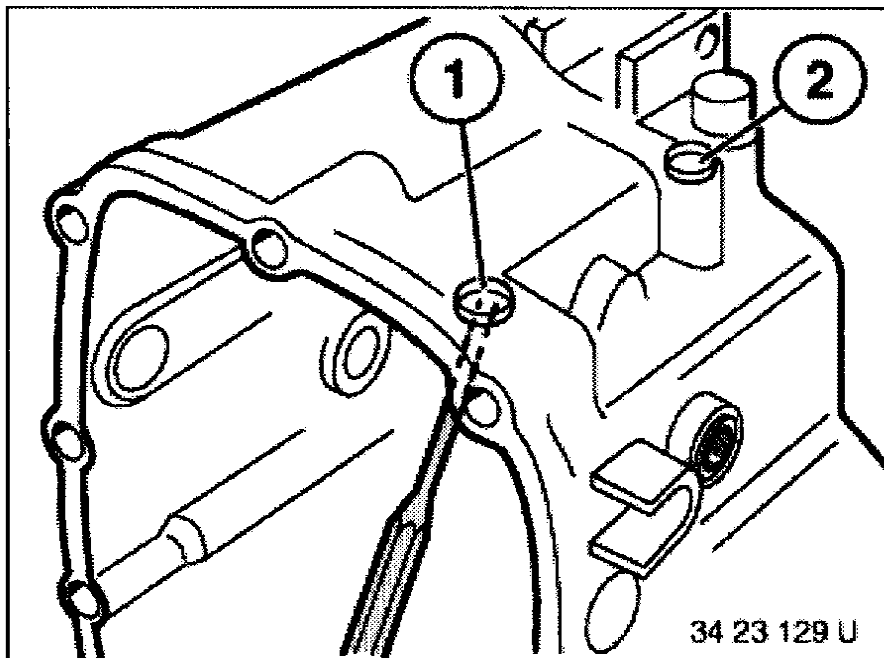


Remove the gear set with shift arms for 1st/2nd and 3rd/4th gear and layshaft.



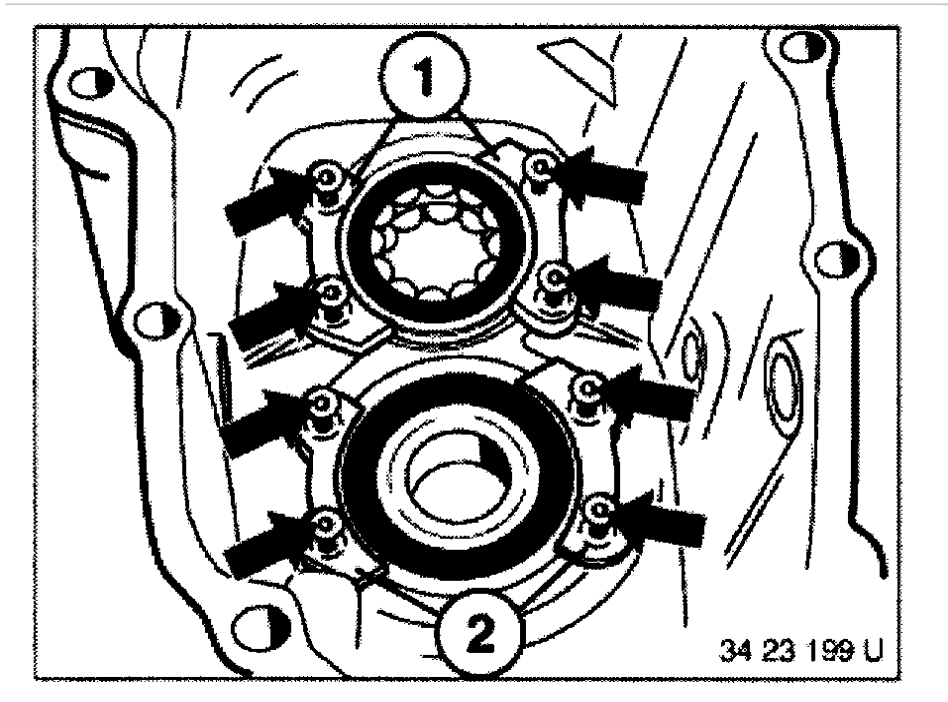
Installation:

Clean the case.

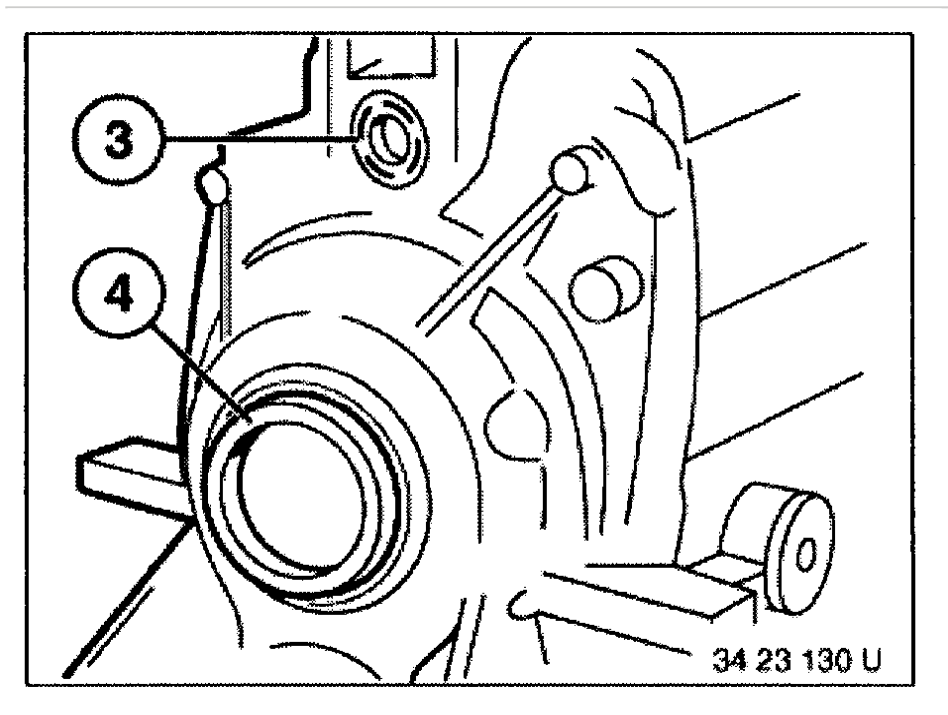
Drive sealing covers (11 and 2) on rear section of housing outwards from inside using a drift.

Installation:

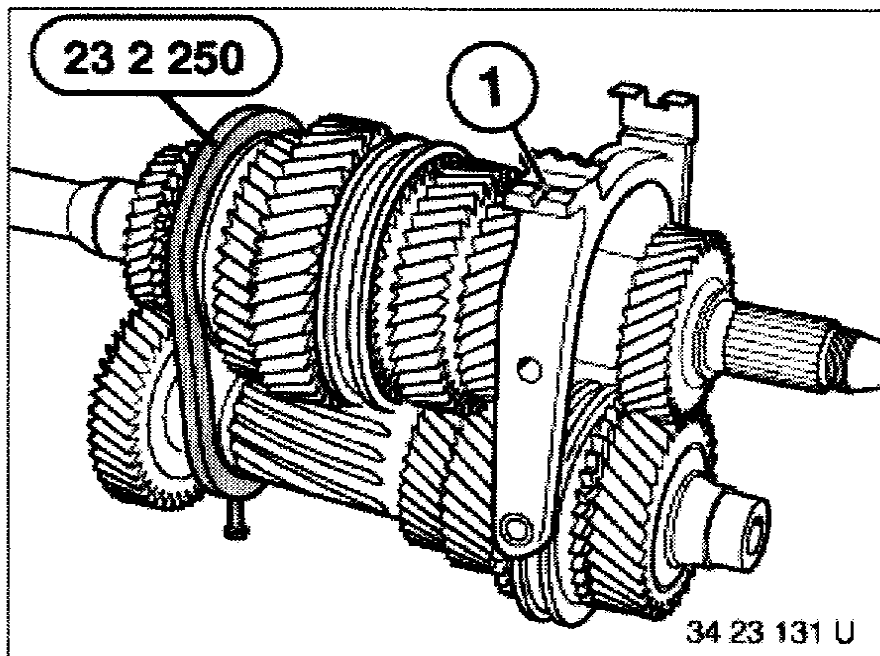
Replace sealing caps.



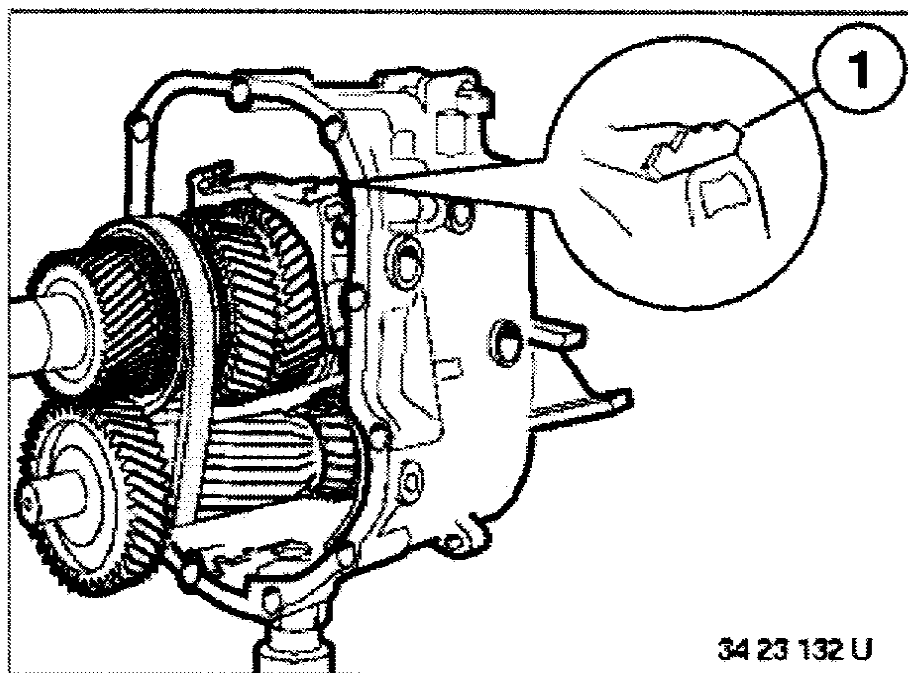
Replace the bearings of the output shaft, layshaft and retaining plates (1 - 2).



Lever out radial sealing rings (3 and 4) for the output shaft and shift shaft.

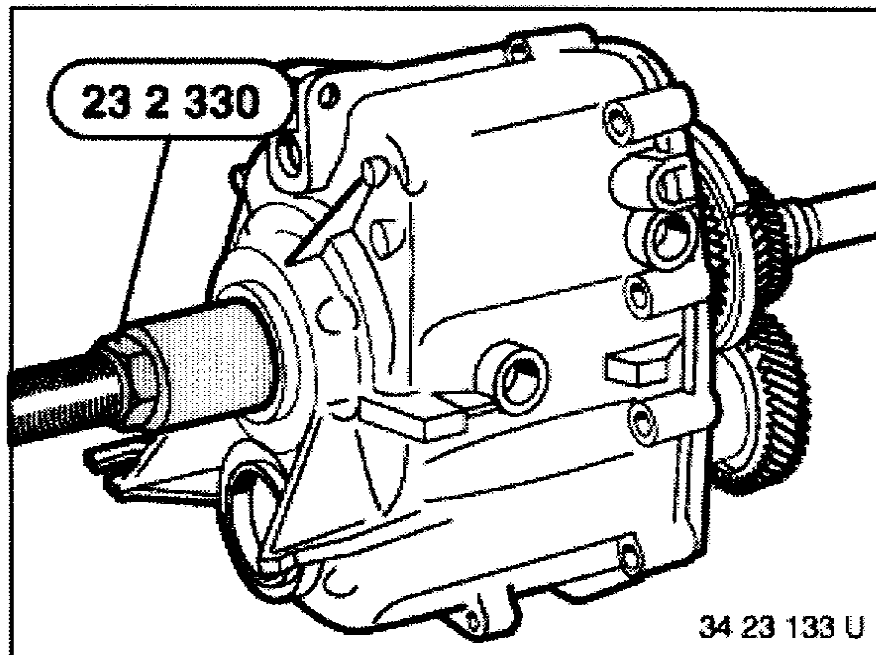


Compress gear set at 5th/reverse gear operating sleeve with layshaft. Use Special Tool 23 2 250. Place the shift arm for 3rd/4th gear with sliding blocks on the operating sleeve at 3rd/4th gear. Position the shift arm on the 3rd gear wheel of the output shaft. Install shift arm with lock (1) in direction of the left-hand side input shaft.

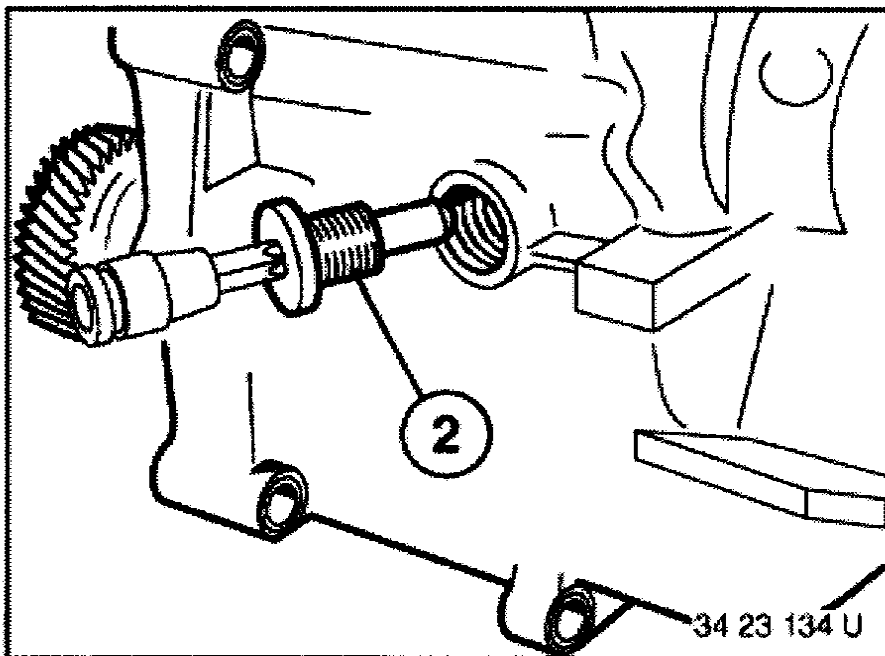


Place gear set with shift arm in the rear case section.
Place the shift arm for 1st/2nd gear and sliding blocks in the operating sleeve 1st/2nd gear.

Caution: Install shift arm with lock (1) in direction of the left-hand side input shaft.



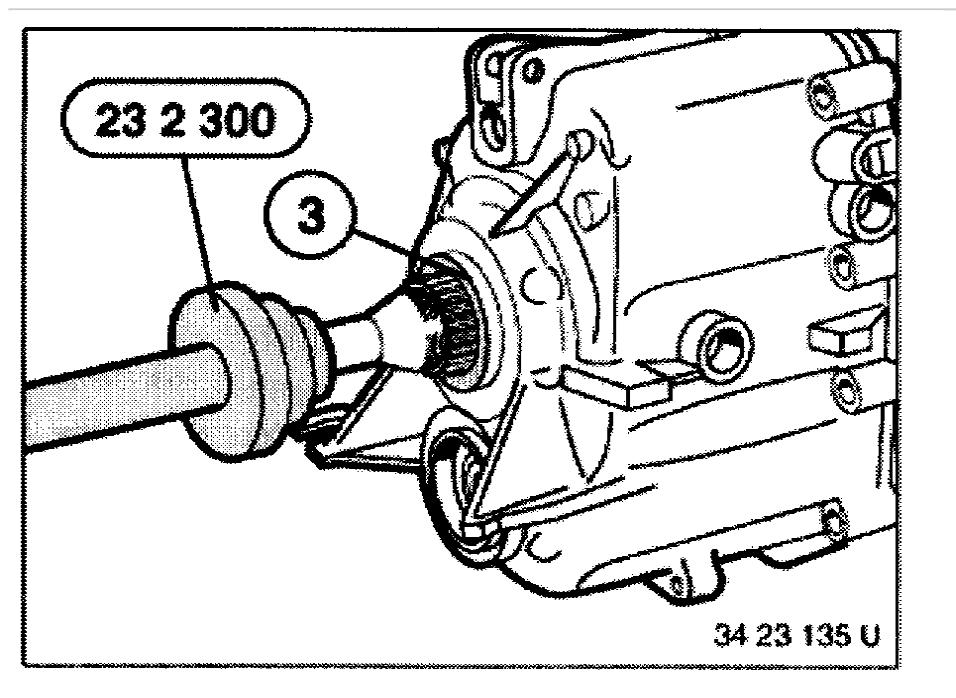
Apply Special Tool 23 2 330 on the output shaft journal. Pull output shaft in to fit tight with Special Tool 23 2 330. Make sure that shift arms and layshaft are not jammed while pulling in; align if necessary. Remove Special Tool 23 2 330.



By hand, align the shift arm for 3rd/4th gear with the bore on the case. In this position, turn the bearing pins (2) one

after another on the left and right, then secure.

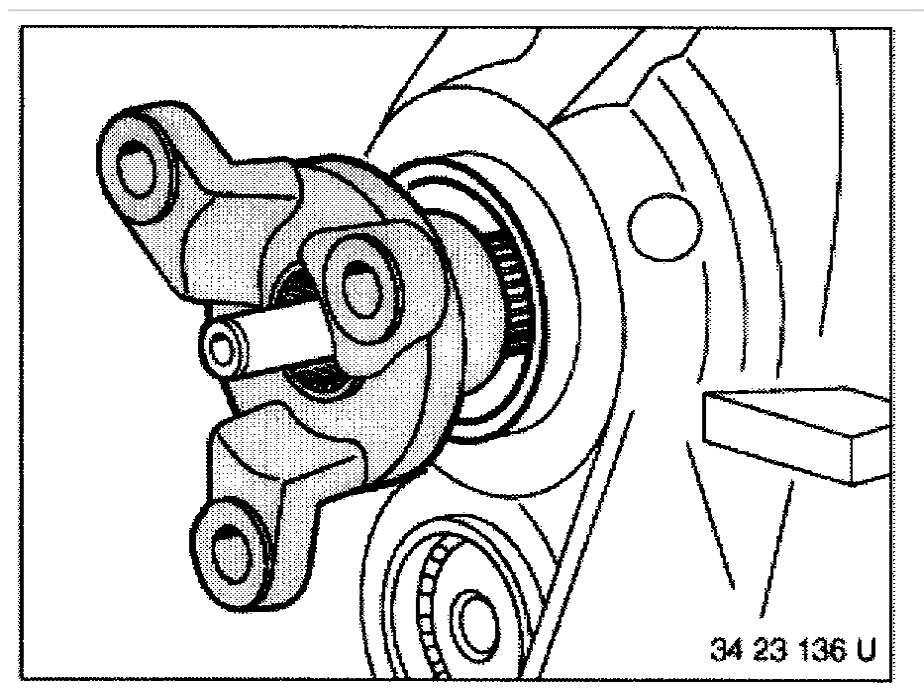
Tightening torque, refer to Manual Transmission/Transaxle, Specifications.



Lubricate sealing lip of radial sealing ring with oil.

Drive in radial sealing ring (3) for the output flange with Special Tool 23 2 300.

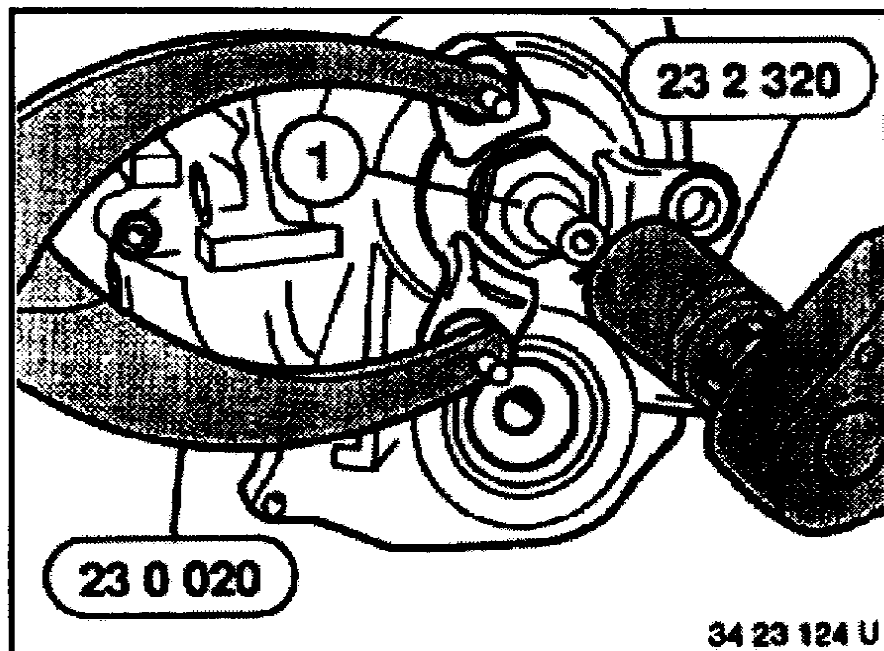
Caution: Use a plastic hammer to knock in.



Heat output flange to about 80°C with a hot air blower.

Slide output flange on to the output shaft.

If necessary, drive on to fit tight with Special Tool 23 1 160.

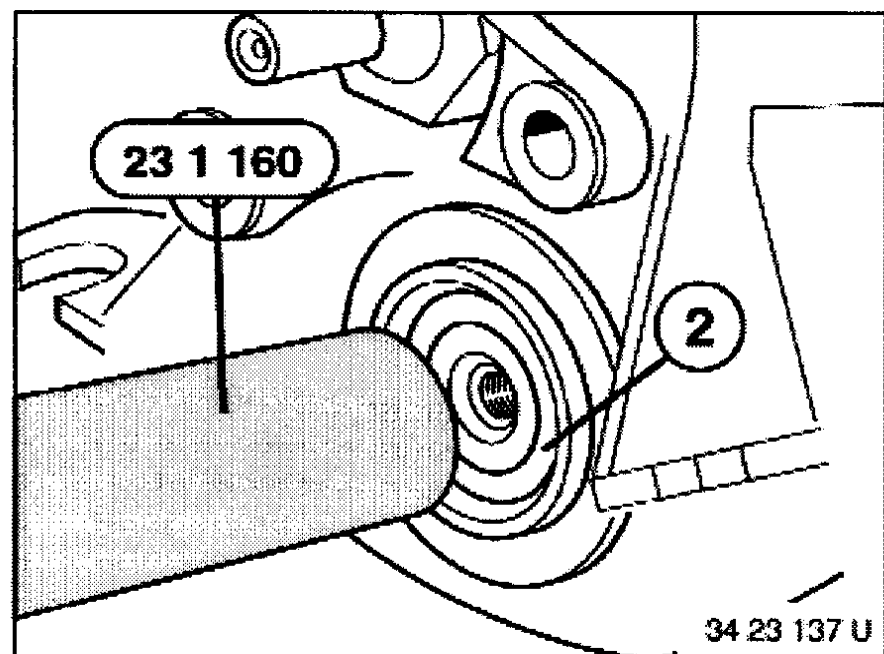


Install collar nut (1) with suitable bolt cement so that its flat side faces the output flange.

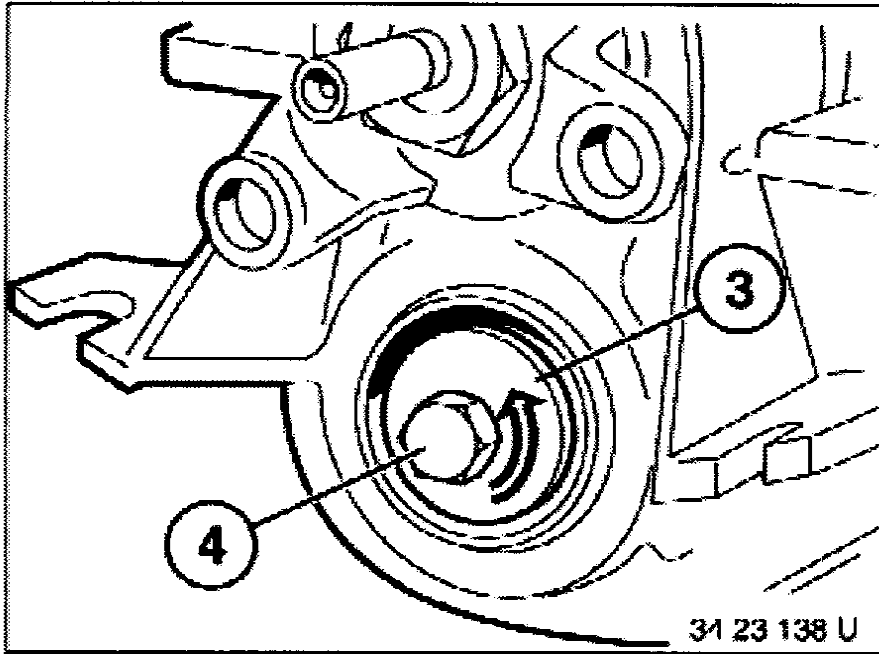
Block output flange using Special Tool 23 0 020.

Secure collar nut with drive socket 23 2 320.

Tightening torque, refer to Manual Transmission/Transaxle, Specifications.

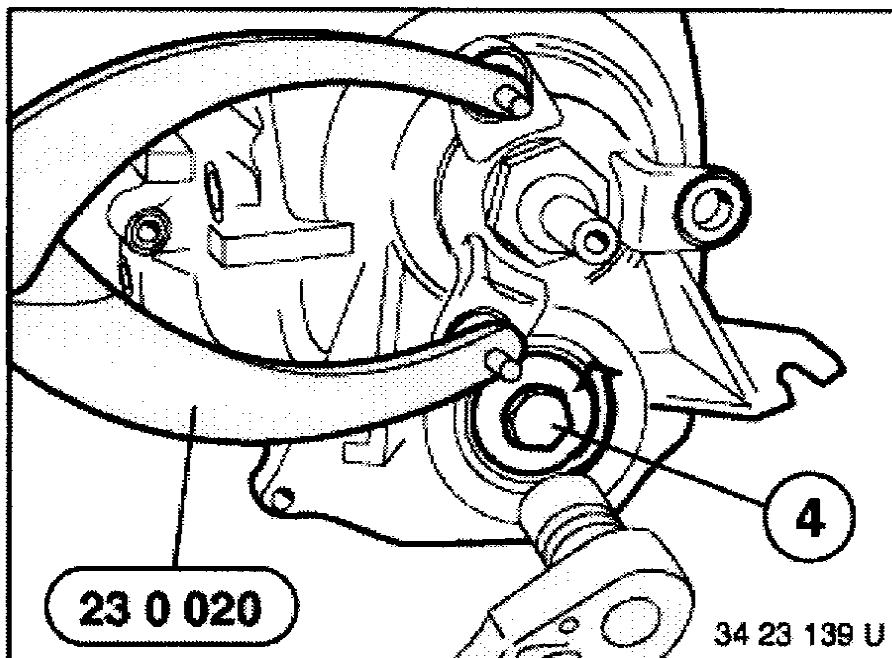


Heat ball bearing inner race (2) for layshaft to about 80°C with a hot air blower.
Press on ball bearing inner race (2) to fit tight with Special Tool 23 1 160; drive on with light knocks if necessary.



Install washer (3) and bolt (4) with suitable bolt cement.

Caution: Bolt (4) has left-hand threads.



Remove Special Tool 23 2 250 from the gear set.

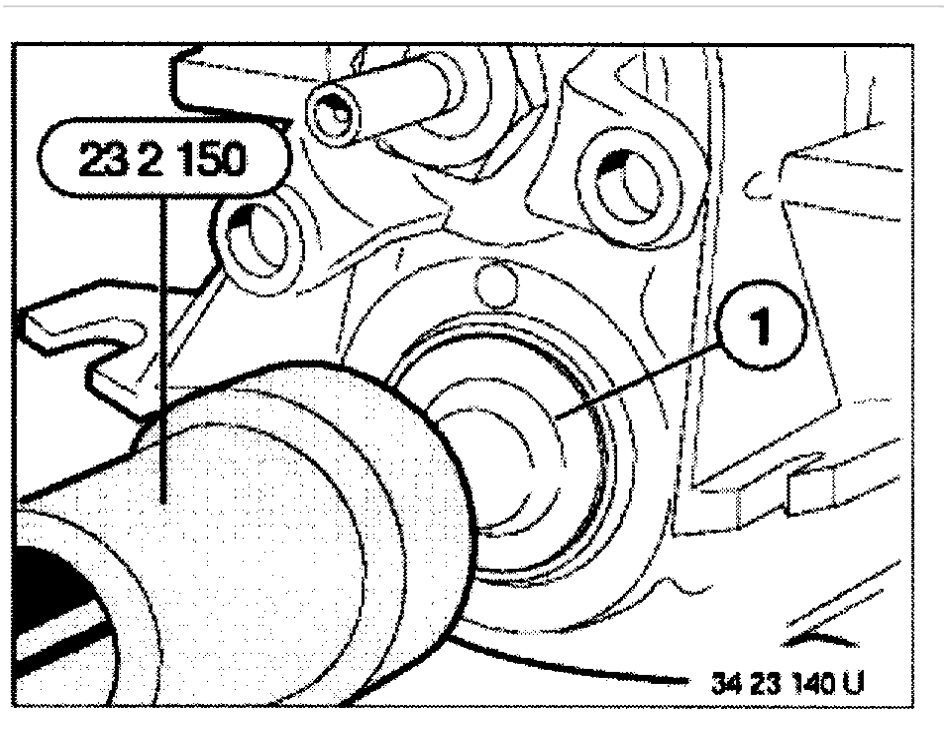
Engage a gear.

Block output flange using Special Tool 23 0 020.

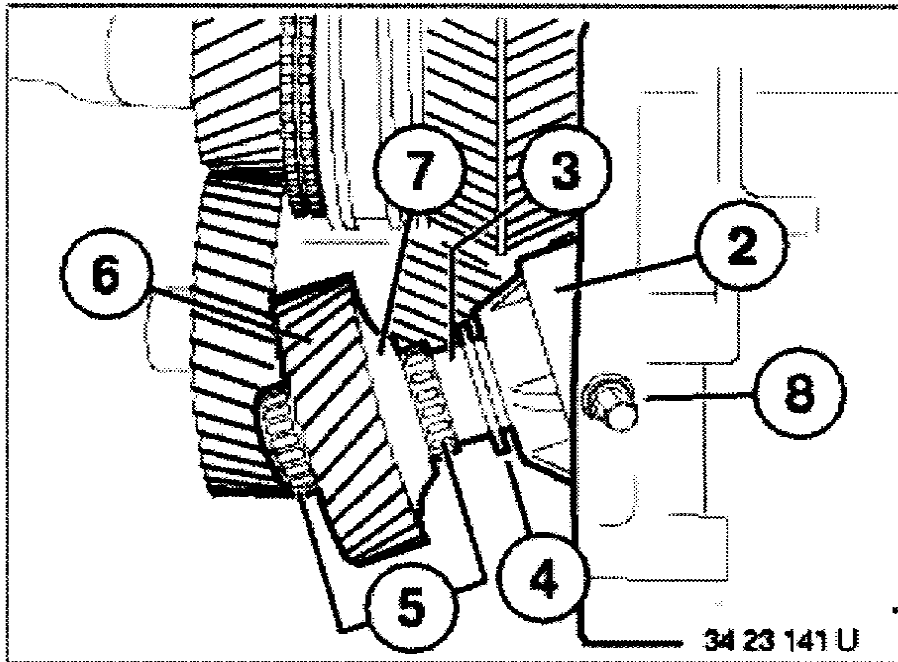
Tighten the screw (4).

Tightening torque, refer to Manual Transmission/Transaxle, Specifications.

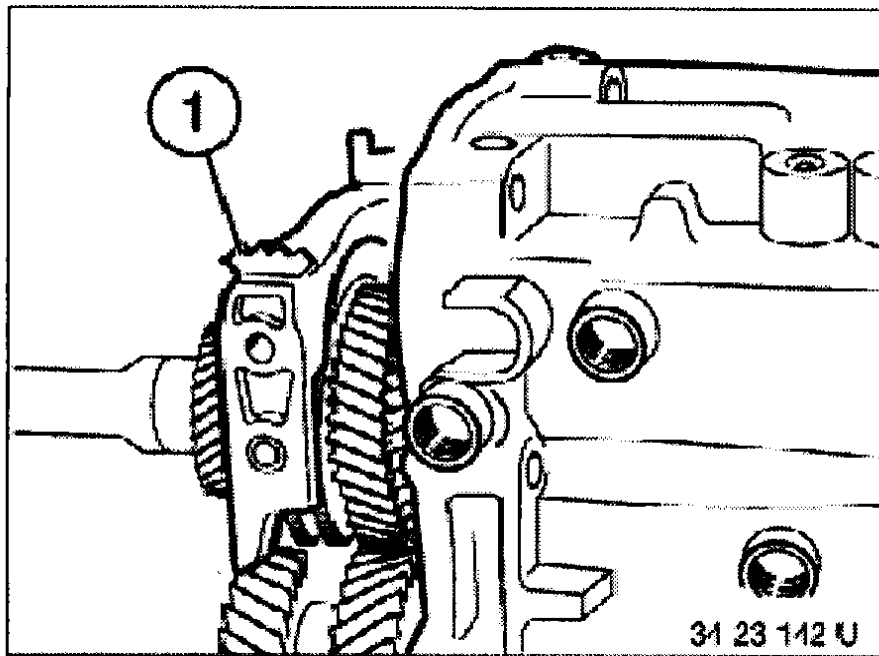
Disengage the gear.



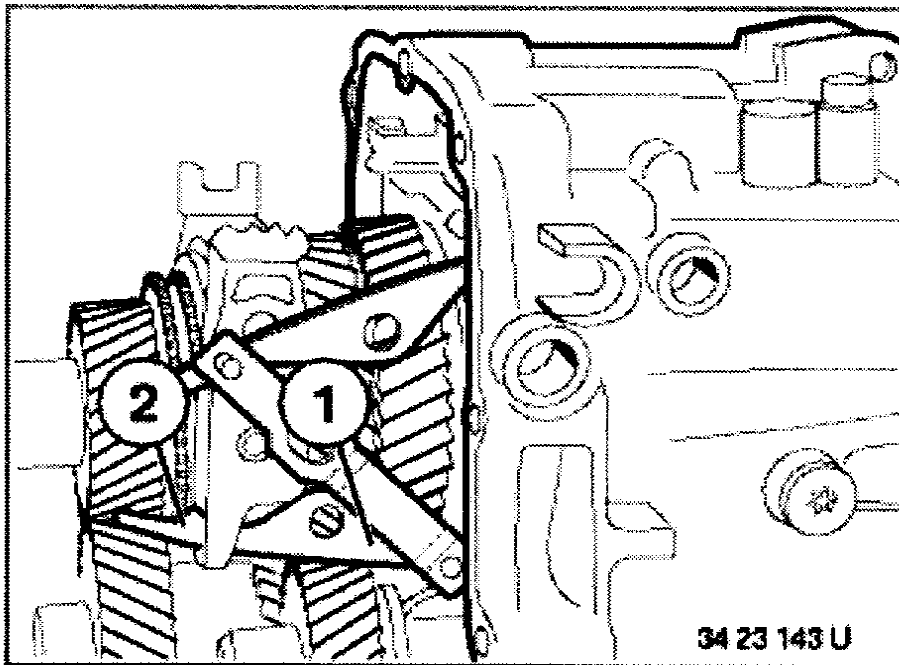
Insert and drive in sealing cap (1) flush with Special Tool 23 2 150.



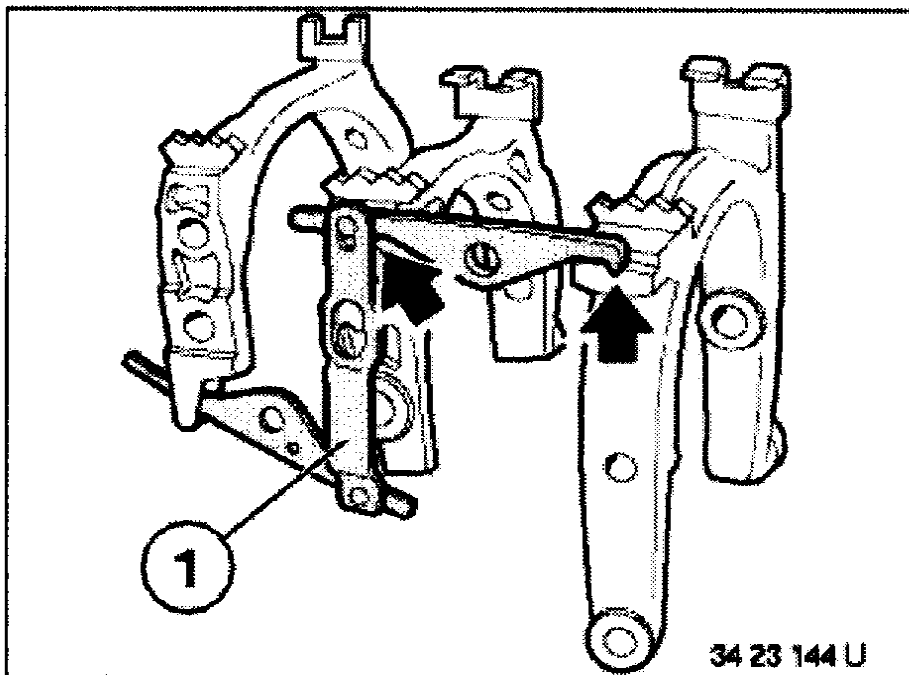
Coat half-shell (2) in area of the bolt bore with suitable sealing compound and install.
 Install pin (3), thrust washer (4), needle bearing (5) and reverse gear (6) with collar (7) facing the case.
 Coat shoulder of the bolt head with suitable sealing compound.
 Install bolt (8) with suitable bolt cement, but do not tighten.



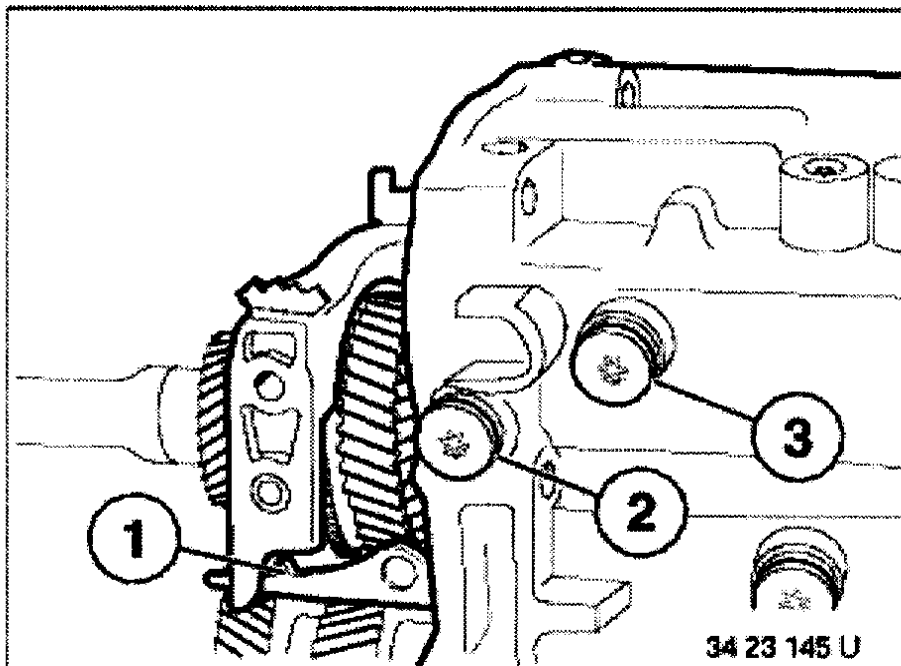
Install 5th/reverse gear shift arm and slide with catch (1) facing to the left in the 5th/reverse gear operating sleeve.



Guide in locking lever (1) with long tongue (2) in the slot of the 5th reverse gear shift arm.



Swing the locking lever (1) inwards and, at the same time, couple it into the recesses of 1st/2nd and 3rd/4th gear shift arms.

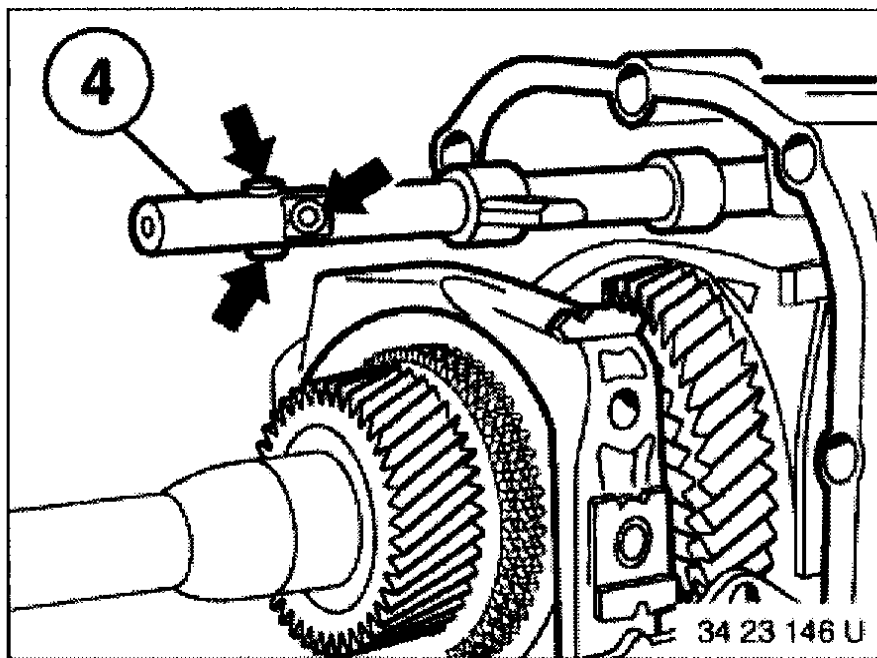


Center locking lever (1) with the bores by hand.

Fit and secure the bearing pins (2) and (3) on the left and right.

Tightening torque. refer to Manual Transmission/Transaxle, Specifications.

Check movement of the locking lever.



Guide in selector shaft (4) horizontally.

Attach 4 rollers with grease.