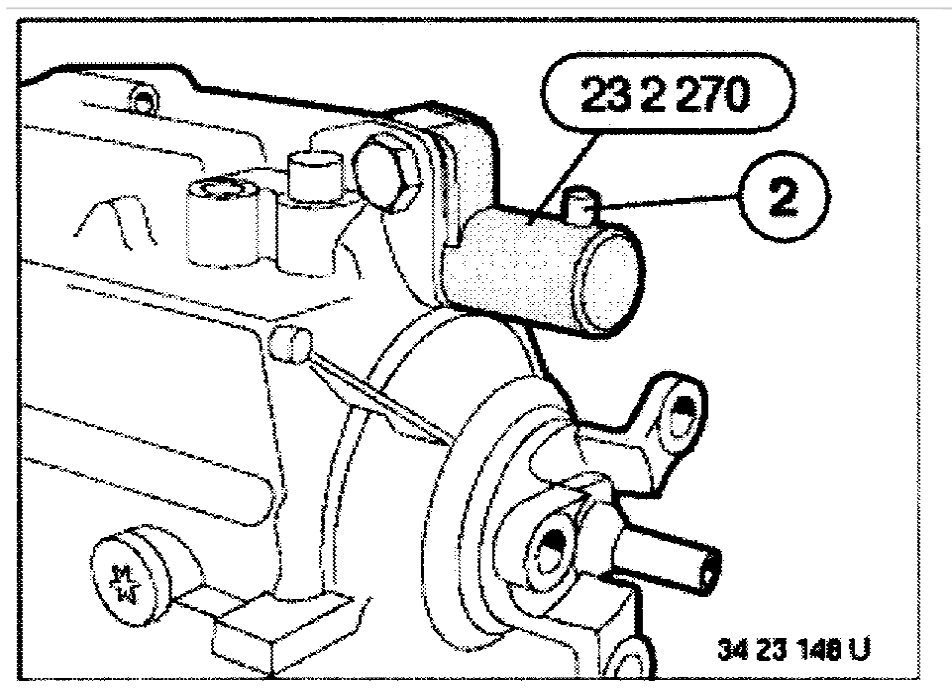
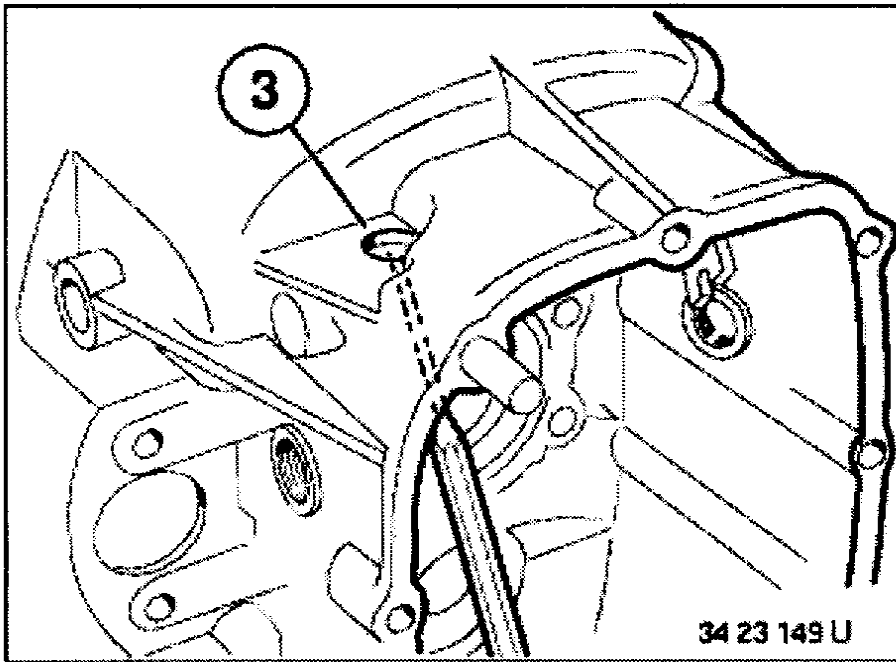


Drive in radial sealing ring (1) for the shift shaft with Special Tool 23 2 260.



Hold the shift shaft in neutral position with Special Tool 23 2 270.

Use a 8 mm bolt and cylindrical pin (2) from the shift joint or suitable mandrel for holding the shift shaft.

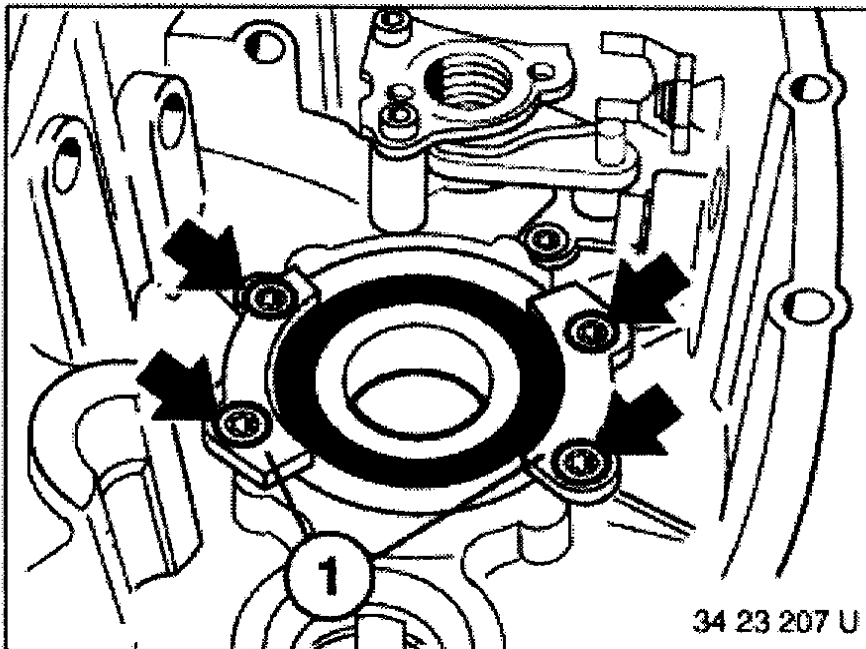


Clean the front case section.

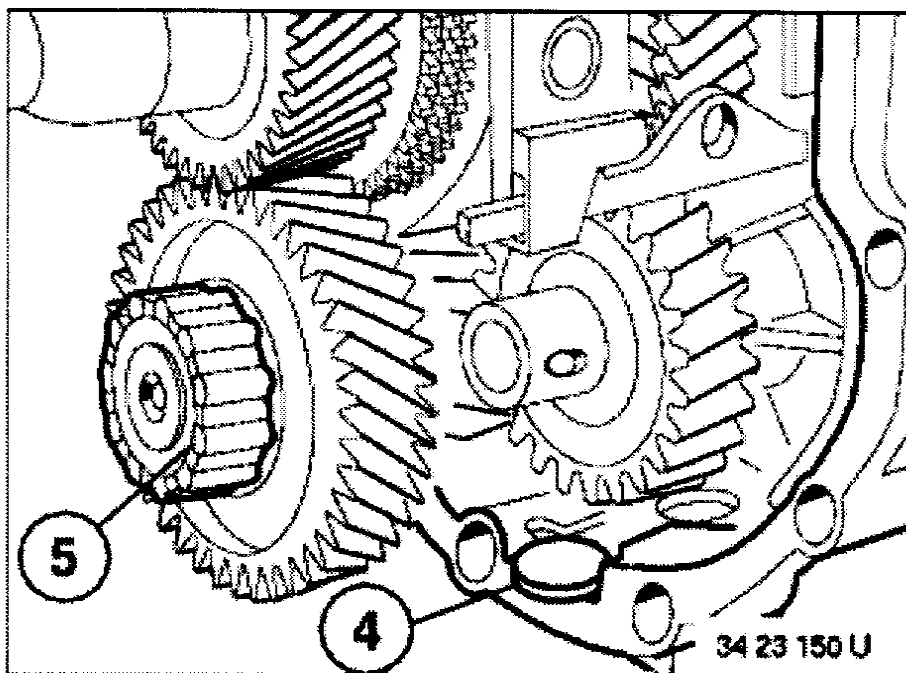
Drive out sealing cap (3) for the catch pin from inside to outside using a punch.

Installation:

Replace sealing caps.



Replace the bearings of the drive shaft and replace the retaining elements (1).
Remove the retaining plates (1).

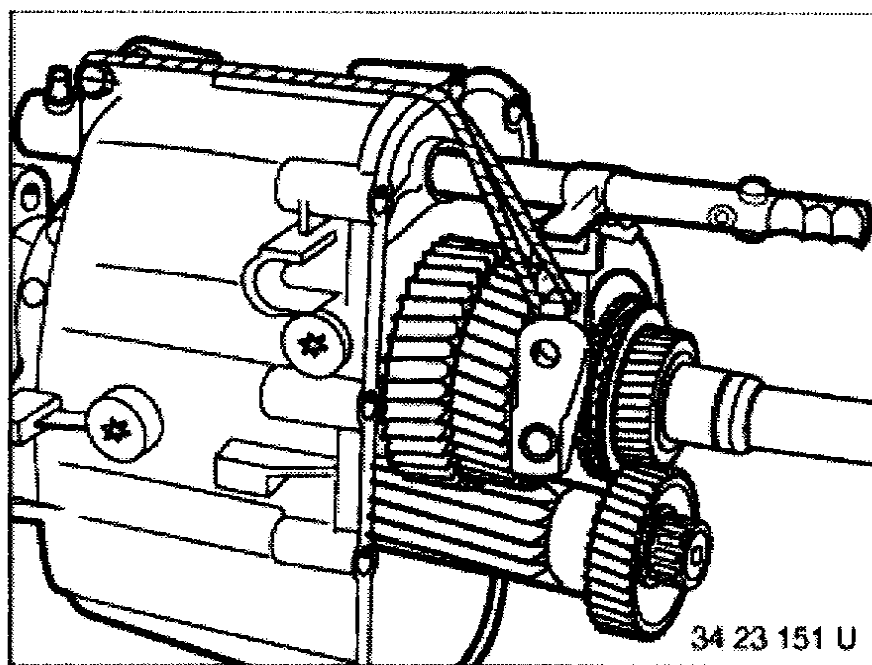


Place magnet (4) in the rear case section.

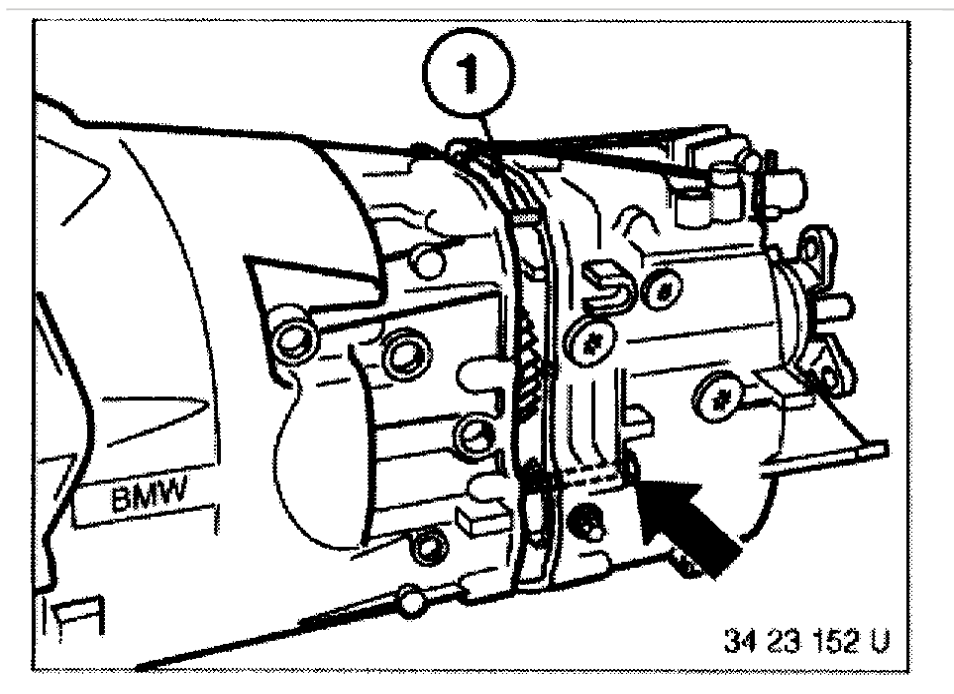
Install needle bearing (5) with the small diameter end on the outside.

Note: Coat needles with grease and press them in to avoid canting of the needles when mounting the front case section.

Clean and coat case sealing surfaces with a suitable sealing compound.

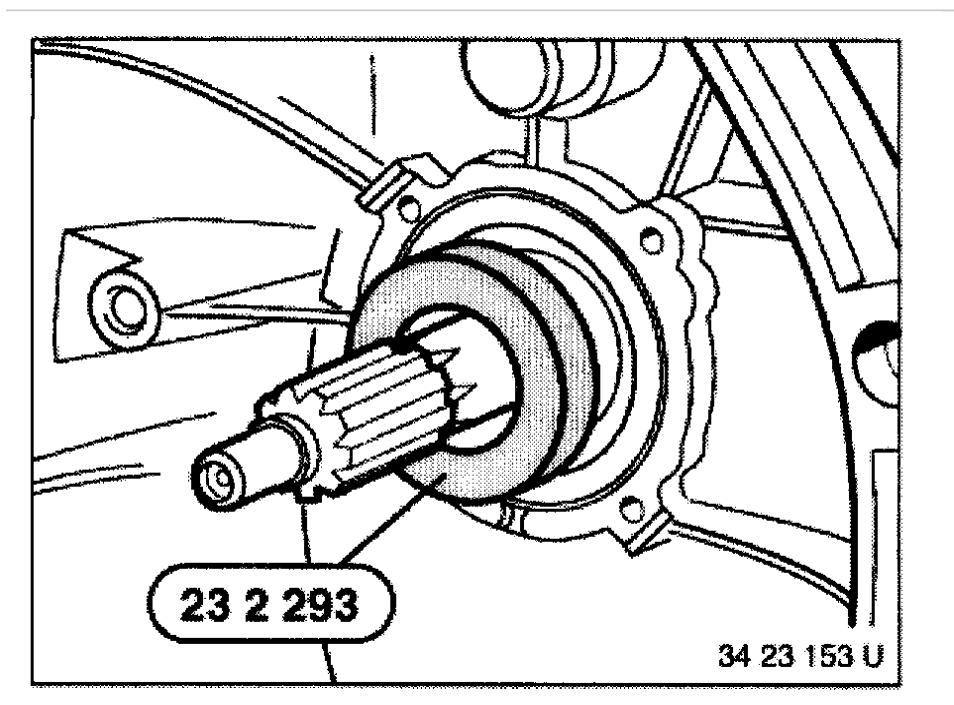


Hold the 5th/reverse gear shift arm in horizontal position with a piece of string to make installation easier.

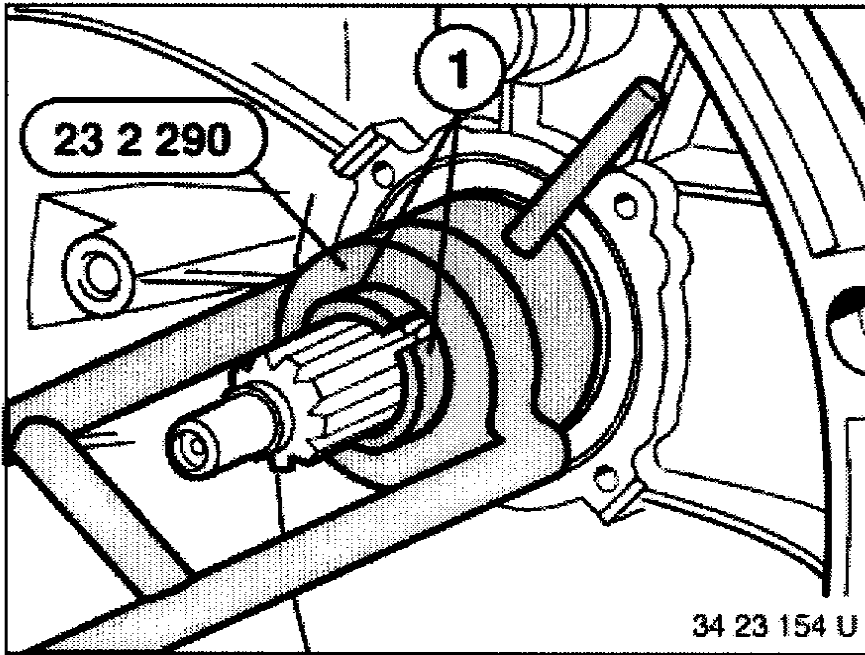


Mount the front case section as far as centering pins (1).

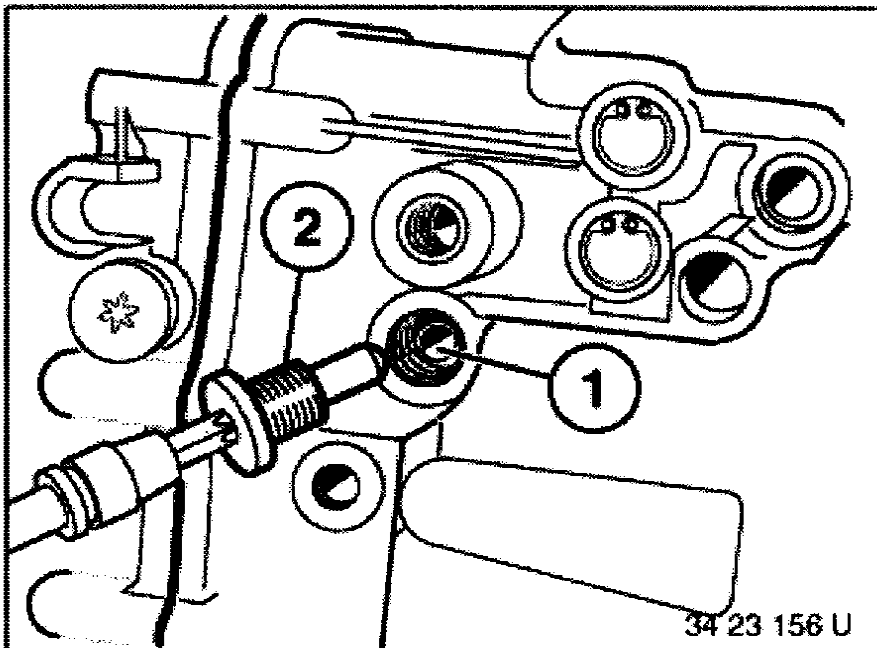
To center the case, screw 2 M8 x 75 mm auxiliary screws opposite one another on the left and right into the rear section of the case.



Place Special Tool 23 2 293 (thrust ring from Special Tool 23 2 290) in the front case section.



Apply Special Tool 23 2 290 on the drive shaft.
Place supporting shells (1) on the drive shaft that the tapered sides face in.
Unscrewing the spindle presses the front case section on to the input shaft.



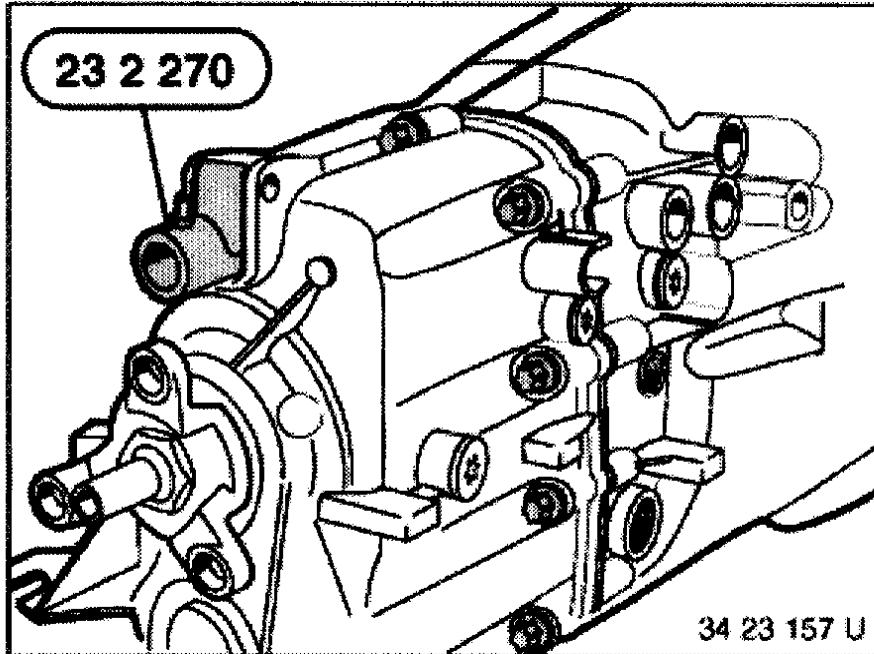
Press the front case section on only so far that the piece of string can still be removed after installation of the right bearing shaft.

Center 5th/reverse gear shift arm (1) with the bore and screw in the right bearing shaft (2) by hand, but do not tighten.

Note: Replace bearing pin (2). Clean thread in housing

Remove piece of string.

Press front section of housing firmly home.



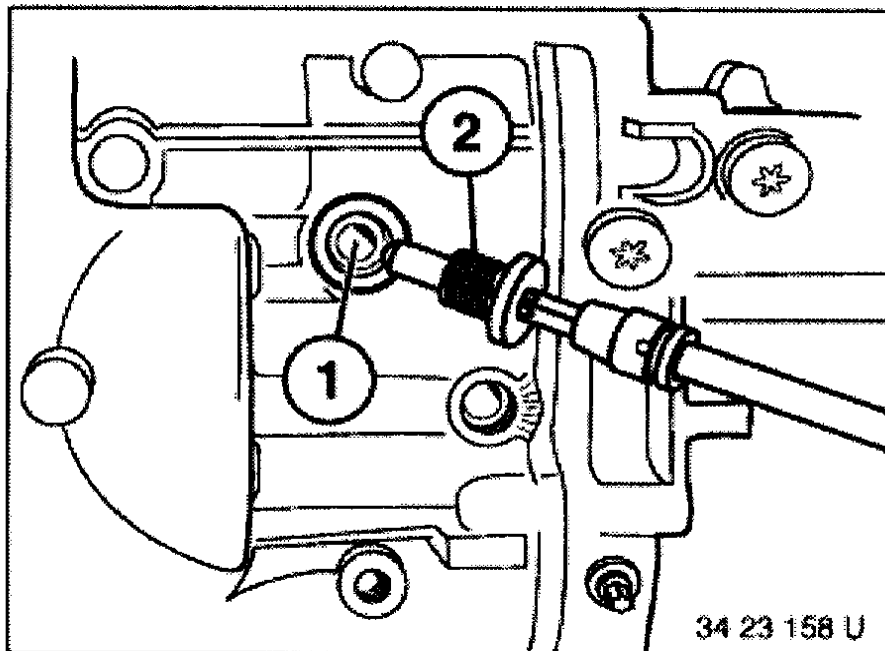
Remove complete Special Tool 23 2 290.

Remove centering bolts from case.

Secure the front section of the case to the rear section.

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

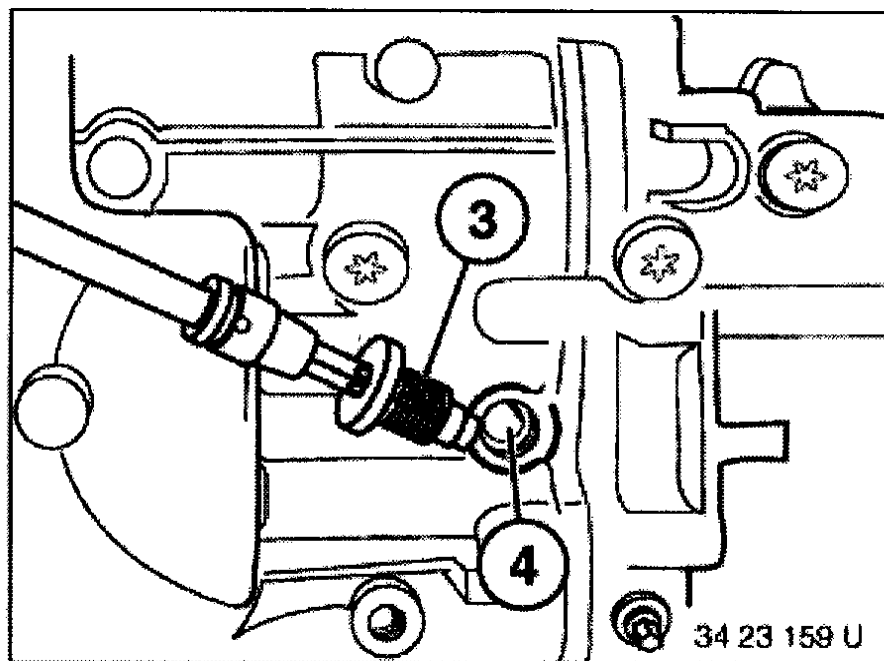
Remove Special Tool 23 2 270 from shift shaft.



Center 5th/reverse gear shift arm (1) with the bore and screw in the left bearing shaft (2) by hand.
Secure the bearing pins (2) on the left and right.

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

Note: Replace bearing pin (2). Clean thread in housing

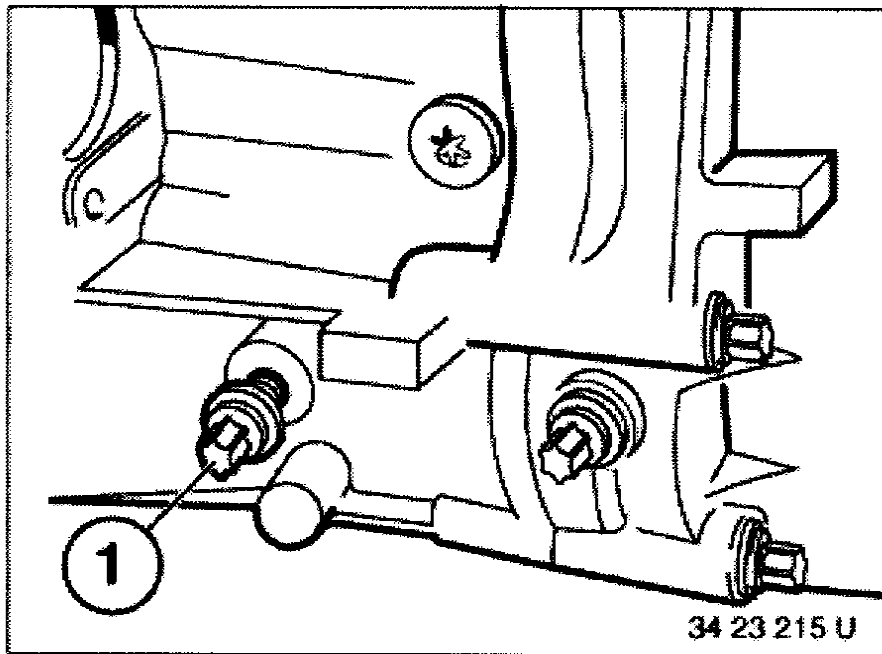


Install bearing pin (3) for the locking lever.

This requires turning the transmission until bore (4) in the locking lever is aligned with the bore in the case.

In this position, turn the bearing pins (3) by hand and secure.

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

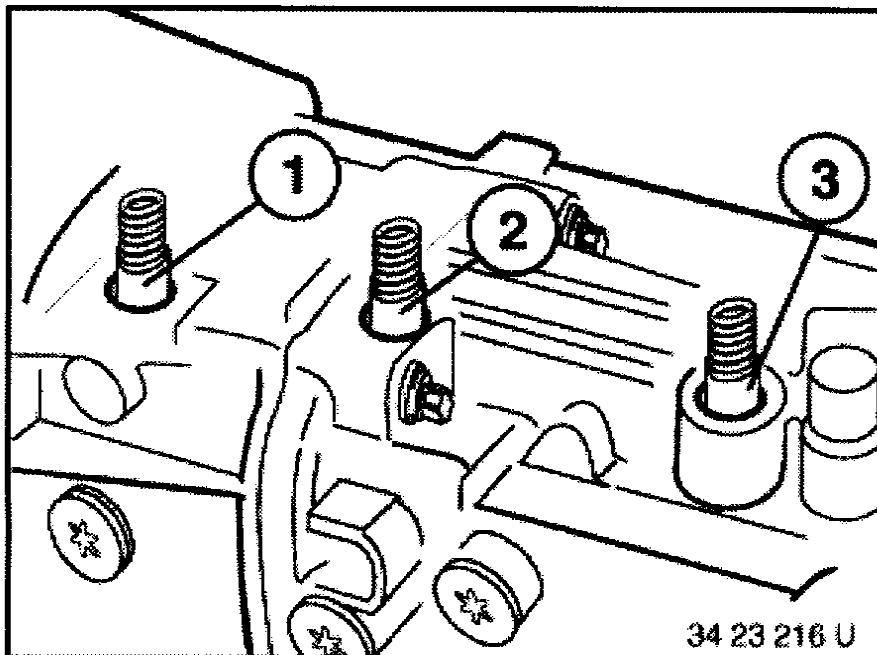


Coat shoulder of the bolt head with a suitable sealing compound.

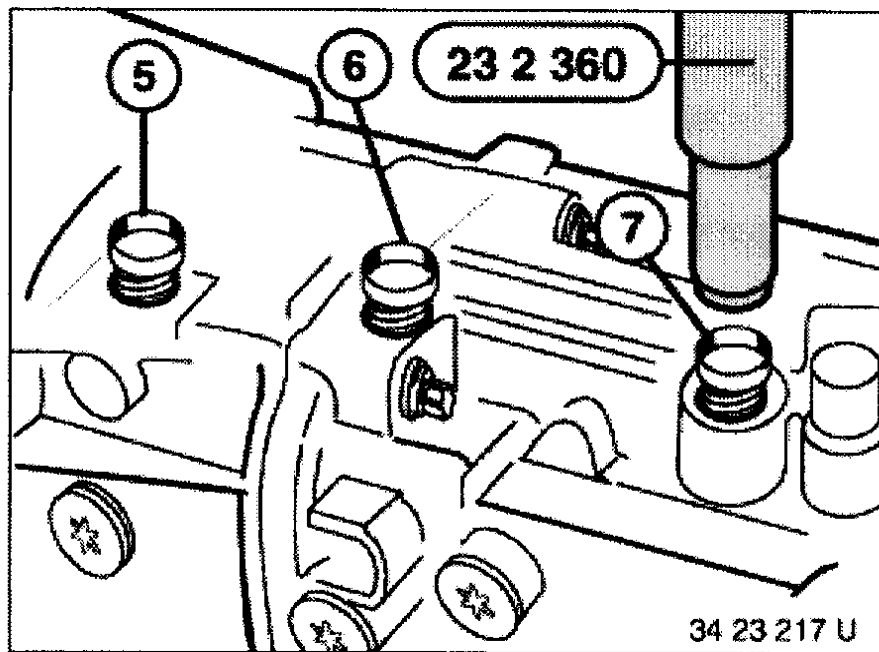
Insert the screw (1) for the reverse gear bolt with suitable screw retaining agent.

Tighten both screws.

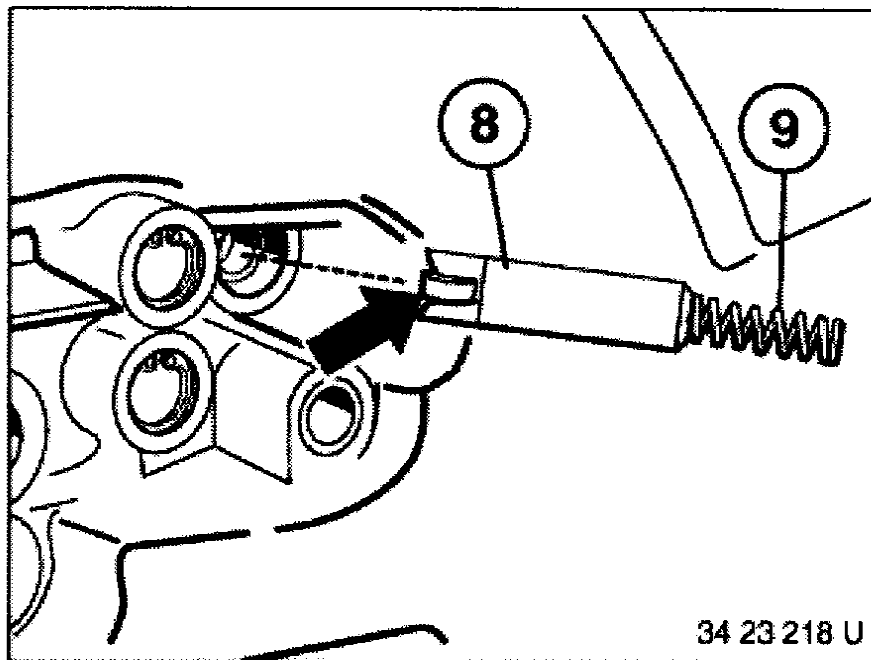
Tightening torque, refer to Manual Transmission/Transaxle, Specifications.



Place catch pins (1 - 3) with compression springs in the shift arms.

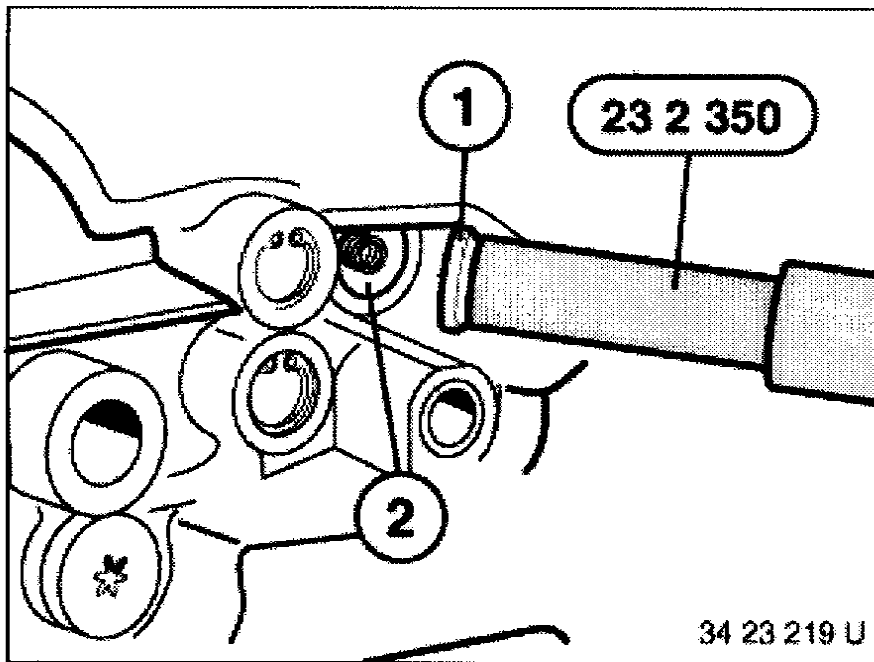


Knock in sealing caps (5 - 7) with Special Tool 23 2 360.

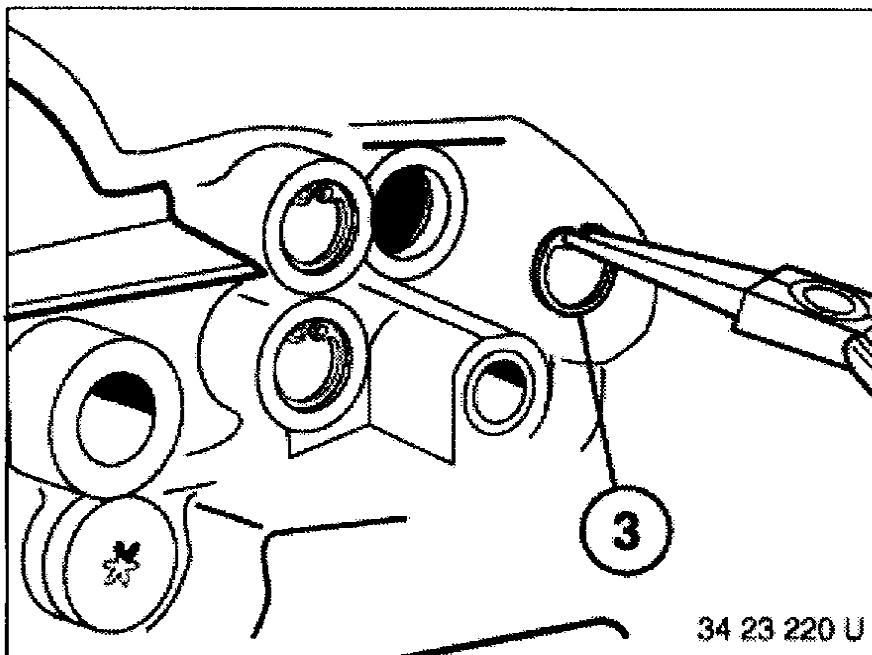


Catch pin (8) and spring (9)

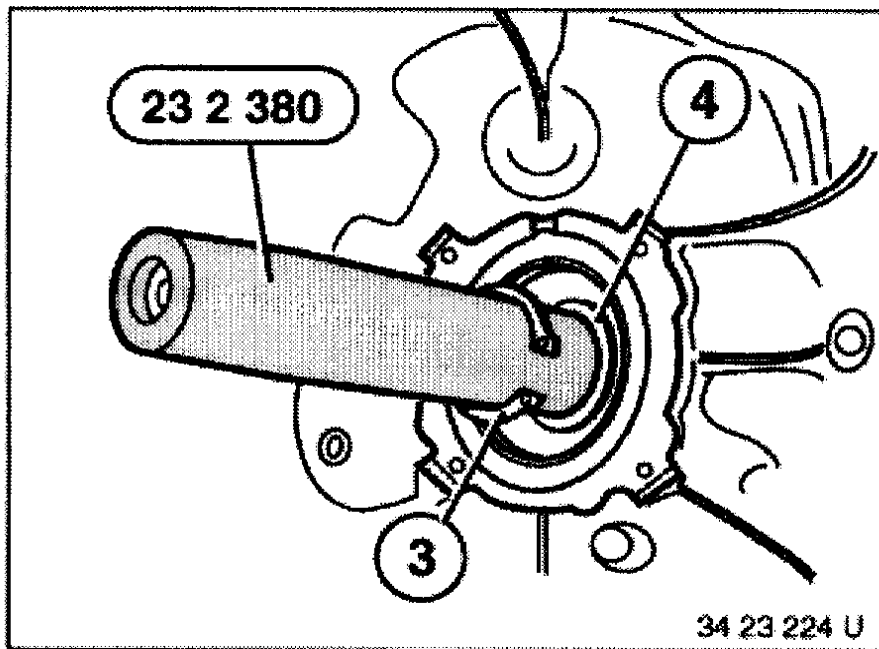
Caution: Check installed position of catch pin (8). Roller must be horizontal.



Install sealing cap (1) in bore (2) with Special Tool 23 2 350 and push in as far as possible.



Install circlip (3) and press in as far as groove with Special Tool 23 2 350.
Check for correct seating of the circlip (visual inspection).
Install the reverse gear switch.



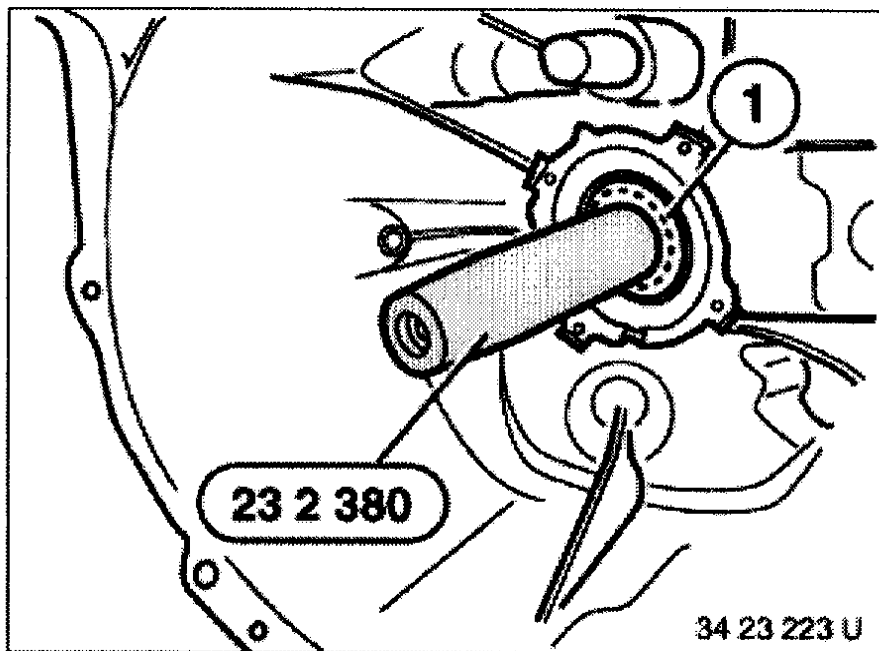
Install spacer (4).

Caution: Special Tool 23 2 380 must be used on the input shaft while installing circlip (3) to avoid damaging the input shaft.

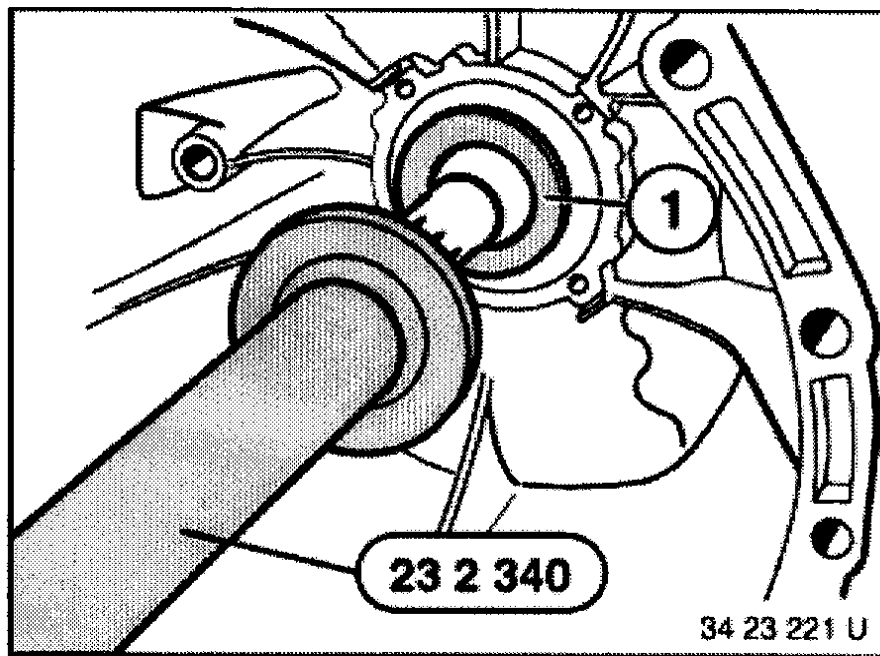
Slide circlip (3) over Special Tool 23 2 380 and install it in the groove.

The circlip must seat in the groove without play.

Replace circlip with a circlip of correct thickness. Circlips are available in different thicknesses in steps from 2.2 to 2.6 mm.

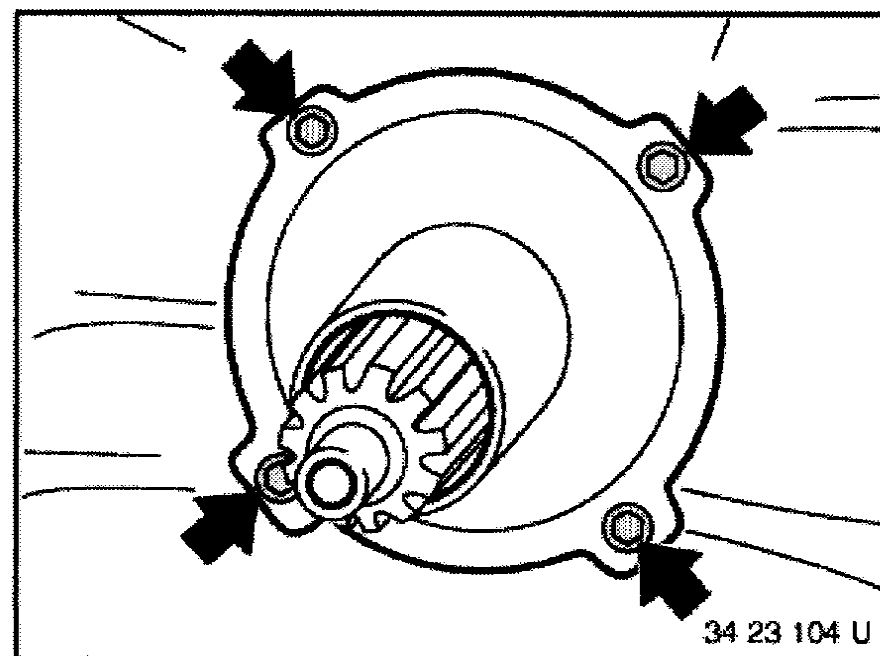


Lubricate sealing lip of radial sealing ring with ATF.
Apply Special Tool 23 2 380 on the input shaft.
Push on radial sealing ring (1) as far as case.



Remove Special Tool 23 2 380.
Drive radial sealing ring (1) in flush using Special Tool 23 2 340.

Caution: Use a plastic hammer to knock in.



Install guide tube.

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