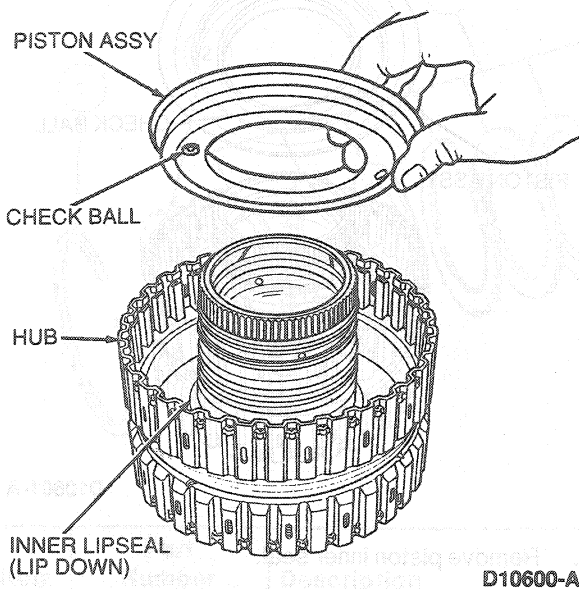


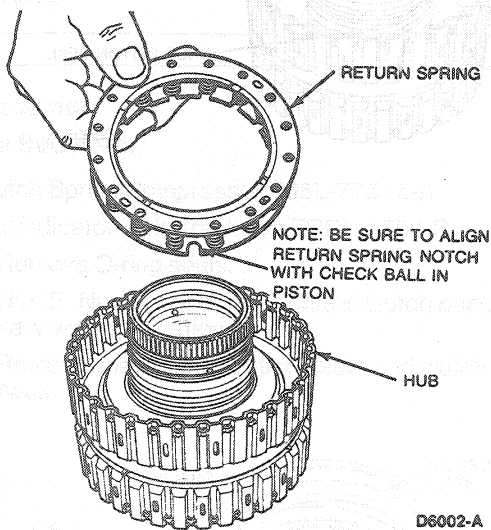
## DISASSEMBLY AND ASSEMBLY (Continued)

**Assembly**

1. Install inner seal (lip seal faces toward bottom of cylinder) and install piston into hub. Be sure piston is seated fully.

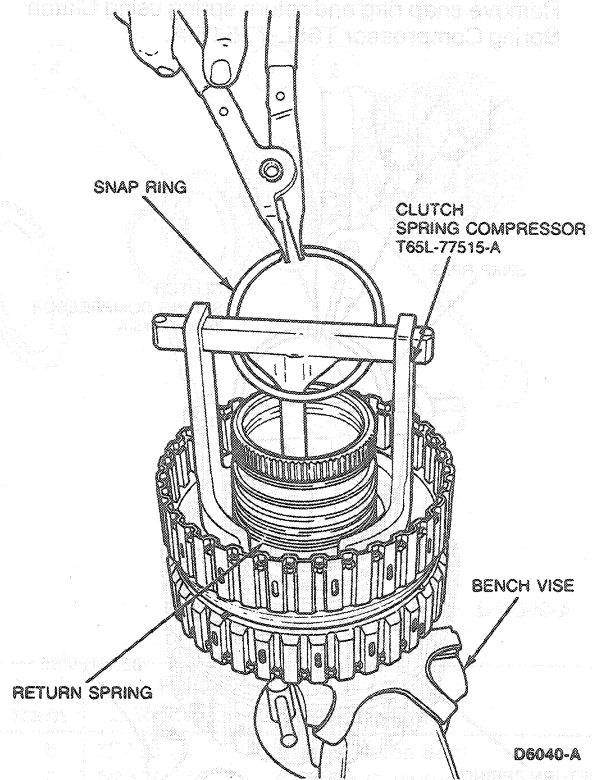


2. Verify free movement of check ball.
3. Install return spring in cylinder aligning return spring notch with check ball in piston.

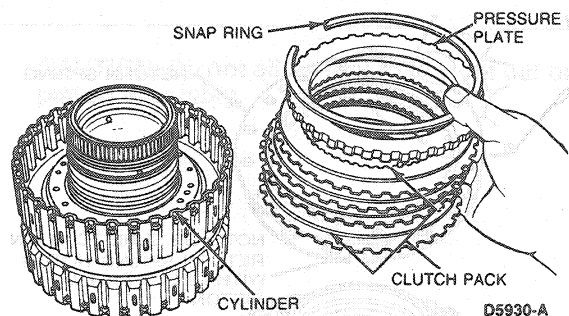


**CAUTION:** Do not allow tool to bottom out on piston assembly.

4. Install snap ring using Clutch Spring Compressor T65L-77515-A.



5. Install clutch pack, pressure plate and snap ring into cylinder.



6. Check clutch pack clearance using feeler gauge or Dial Indicator with Bracketry TOOL-4201-C or equivalent. Push firmly downward on the clutch pack. Release pressure and zero dial indicator. Lift pressure plate to the bottom of the snap ring. Note dial indicator reading. Take two readings, 180 degrees apart, and determine the average of the two readings. The clearance should be: 0.78-1.29mm (0.031-0.051 inch). If the clearance is not within specification, selective snap rings are available in the following thicknesses: