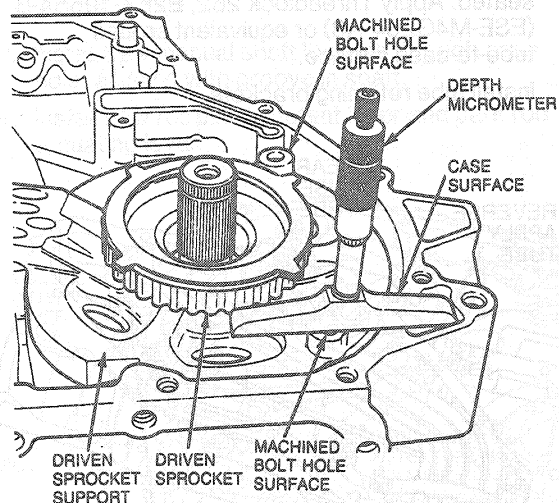


**DISASSEMBLY AND ASSEMBLY (Continued)**

40. If support machined bolt hole surfaces are below case machined surface, place depth micrometer on case-machined surface and measure down to machined surface of both bolt holes on support to get an average. Compare this reading to the No. 8 thrust washer reading in Step 34. The difference between the two readings is the No. 5 thrust washer clearance.

**NOTE:** The No. 5 thrust washer reading must always allow the driven sprocket support to be the same height or to set lower in the case than the No. 8 thrust washer reading did. If not, a thinner No. 5 thrust washer must be selected. If the support does set lower in the case, the difference must not be greater than 0.85mm (0.033 inch) or a thicker No. 5 thrust washer must be selected. Refer to No. 5 thrust washer selection chart following Step 41.



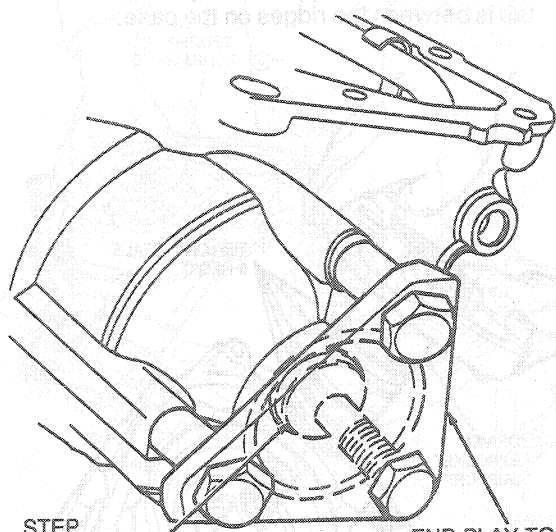
D6015-B

41. Recheck sprocket support clearance after changing selective thrust washers. The No. 5 thrust washer clearance must be between 0.00 and 0.85mm (0.00 and 0.033 inch).

**NO. 5 THRUST WASHER SELECTION**

Thrust Washer Thickness		Color
mm	Inches	
2.28-2.18	0.090-0.086	Green
2.53-2.43	0.099-0.095	Black
2.77-2.67	0.109-0.105	Natural
3.02-2.92	0.118-0.115	Red

42. Remove tool from bottom of case.

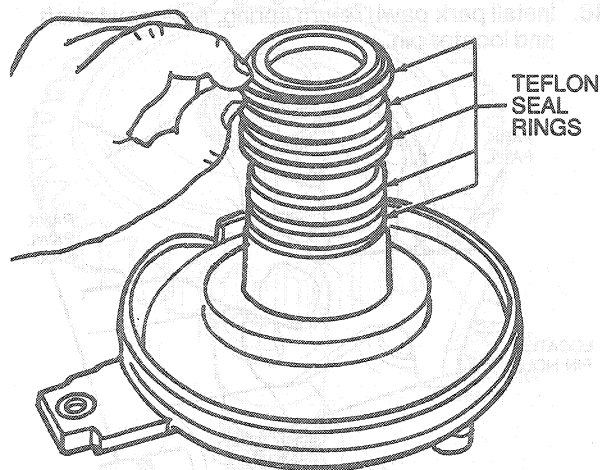


STEP PLATE ADAPTER D80L-630-3

END PLAY TOOL T87P-70014-AH D6200-E

43. Remove driven sprocket support and install No. 9 needle bearing and correct No. 8 and No. 5 thrust washers.

44. Install Teflon® seals on driven sprocket support. Make sure that seals are lapped correctly.



**CAUTION: SEAL RINGS MUST BE LAPPED CORRECTLY**

CORRECT

INCORRECT

D10617-A