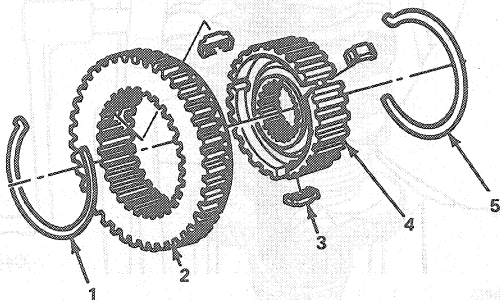


DISASSEMBLY AND ASSEMBLY (Continued)

Item	Part Number	Description
1	7109	Synchro Retainer Spring (2 Req'd)
2	7106	Synchronizer Sleeve
3	7K198	Synchro Hub Inserts (3 Req'd)
4	7L172	Synchronizer Hub
5	7L049	Synchro Insert Retaining Spacer
6	7G042	5th Synchro Insert Retainer

**SYNCHRONIZER ASSEMBLY
1ST/2ND AND 3RD/4TH (TYPICAL)**



LEGEND:

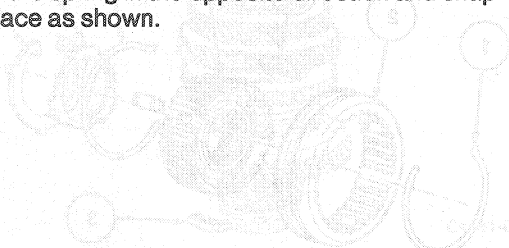
- 1. SPRING — SYNCHRONIZER RETAINER
- 2. GEAR AND SYNCHRONIZER SLEEVE
- 3. INSERTS — SYNCHRONIZER HUB
- 4. HUB — SYNCHRONIZER
- 5. SPRING — SYNCHRONIZER RETAINER

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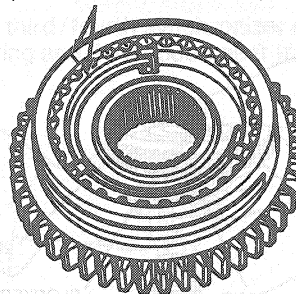
In assembling the synchronizers, some points must be noted:

1. Slide the sleeve over the hub. The index marks must be aligned.
2. Place the three inserts into their slots. Place the tab on the synchronizer spring into the groove of one of the inserts and snap the spring into place.

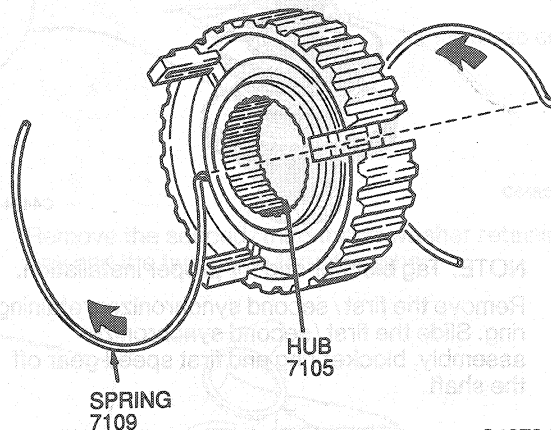
Place the tab of the other spring into the same insert (on the other side of the synchronizer assembly) and rotate the spring in the opposite direction and snap into place as shown.



**ALIGNMENT MARKS
(SINGLE SET OF MARKS)**



**NOTE THE SPRINGS
ROTATING AWAY
FROM THE SAME
INSERT BUT IN
OPPOSITE DIRECTIONS**



C4073-D

NOTE: When assembling synchronizers, notice that the sleeve and the hub have an extremely close fit and must be held square to prevent jamming. (Do not force the sleeve onto the hub).

Main Shaft Assembly

Tools Required:

- Pinion Bearing Cone Remover D79L-4621-A

Assembly

NOTE: Prior to assembly of the main shaft, thoroughly clean all parts and inspect their condition. Lightly oil the gear bores and other parts with Synthetic MERCON® Multi-Purpose Automatic Transmission Fluid E6AZ-19582-B (ESR-M2C 163-A2) or equivalent.