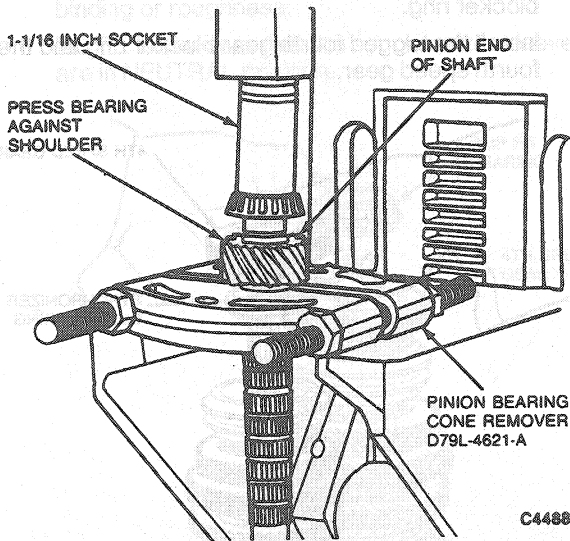


**DISASSEMBLY AND ASSEMBLY (Continued)**

1. Install the bearing on the pinion end of the shaft using a 1-1/16 inch socket and an arbor press.



**NOTE:** When installing the synchronizer, align the three grooves in the first gear blocker ring with the synchronizer inserts. This allows the synchronizer assembly to seat properly in the blocker ring.

2. Slide the first speed gear and tagged blocker ring onto the main shaft. Slide the first / second synchronizer assembly into place, making sure the shift fork groove on the reverse sliding gear faces the first speed gear.

**NOTE:** When installing the synchronizer, align the three grooves in the second gear blocker ring with the synchronizer inserts. This allows the synchronizer assembly to seat properly in the blocker ring.

Install the synchronizer retaining ring.

**1ST/2ND GEAR SYNCHRONIZER ASSY**

MAKE SURE GROOVE FACES 1ST SPEED GEAR

BLOCKER RING

CONE UP

1ST SPEED GEAR

C4486-C

3. Install the tagged second speed blocker ring and the second speed gear.

