

GROUP 22B

MANUAL TRANSAXLE OVERHAUL

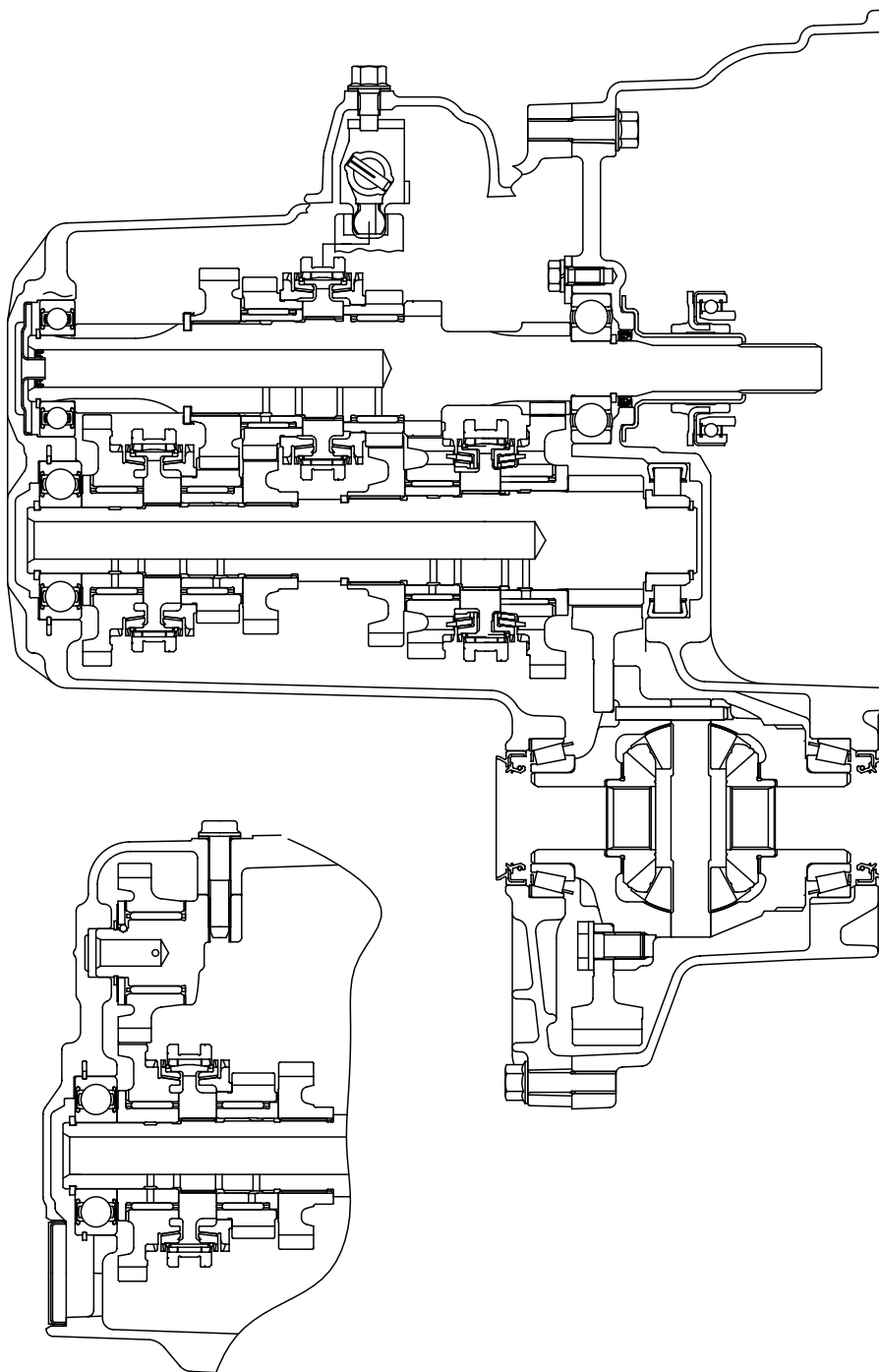
CONTENTS

GENERAL INFORMATION	22B-2	DISASSEMBLY AND ASSEMBLY	22B-38
SPECIAL TOOLS	22B-4	CONTROL HOUSING	22B-40
TRANSAXLE	22B-7	DISASSEMBLY AND ASSEMBLY	22B-40
DISASSEMBLY AND ASSEMBLY	22B-7	CLUTCH HOUSING	22B-43
INSPECTION	22B-16	DISASSEMBLY AND ASSEMBLY	22B-43
INPUT SHAFT	22B-17	TRANSMISSION CASE	22B-47
DISASSEMBLY AND ASSEMBLY	22B-17	DISASSEMBLY AND ASSEMBLY	22B-47
INSPECTION	22B-23	DIFFERENTIAL	22B-50
OUTPUT SHAFT	22B-25	DISASSEMBLY AND ASSEMBLY	22B-50
DISASSEMBLY AND ASSEMBLY	22B-25	SPECIFICATIONS	22B-53
INSPECTION	22B-33	FASTENER TIGHTENING	
REVERSE IDLER GEAR	22B-36	SPECIFICATIONS	22B-53
DISASSEMBLY AND ASSEMBLY	22B-36	GENERAL SPECIFICATIONS	22B-53
SPEEDOMETER GEAR	22B-37	SERVICE SPECIFICATIONS	22B-54
DISASSEMBLY AND ASSEMBLY	22B-37	SEALANTS AND ADHESIVES	22B-54
SELECT LEVER	22B-38	LUBRICANTS	22B-54
		SNAP RINGS, SPACERS AND THRUST	
		PLATE FOR ADJUSTMENT	22B-55

GENERAL INFORMATION

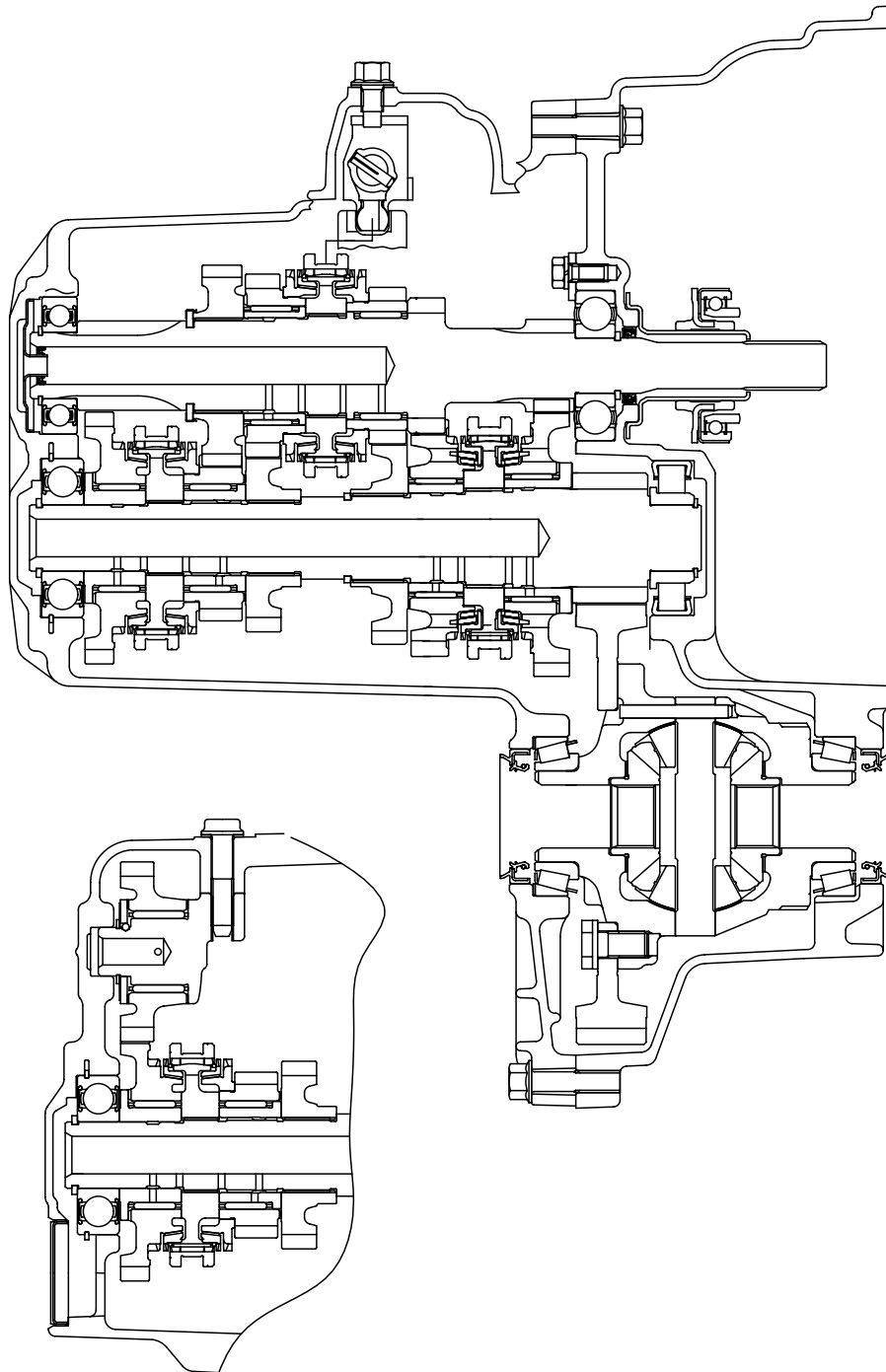
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SECTIONAL VIEW <F5M42-1>



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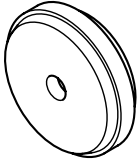
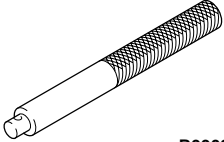

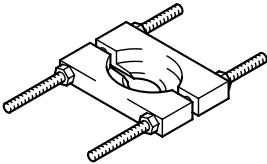
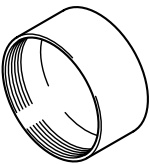
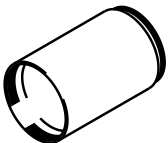
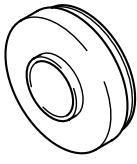
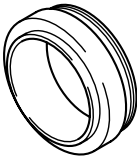
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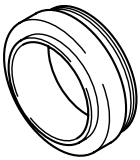
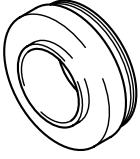
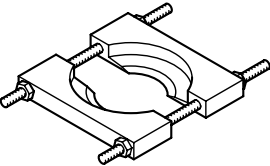
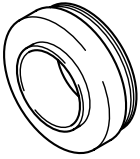
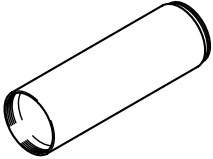
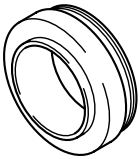
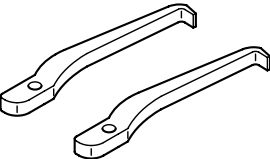
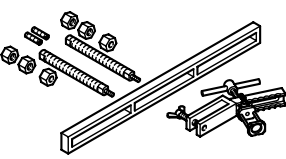


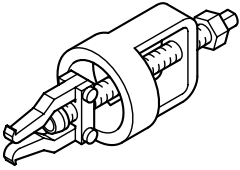

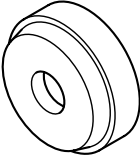
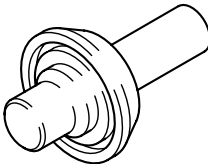
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SPECIAL TOOLS

M1222000600169

TOOL	TOOL NUMBER AND NAME	SUPERSESSION	APPLICATION
	MB990935 Installer adapter	MB990935-01 or General service tool	Installation of differential case taper roller bearing outer race
 B990938	MB990938 Handle	MB990938-01	Use with Installer adapter
	MB990927 Installer adapter	MB990927-01 or General service tool	Installation of sealing cap
	MD998801 Bearing remover	MD998348-01 or General service tool	Installation and removal of gears, bearings and sleeves
	MD998812 Installer cap	General service tool	Use with Installer and Installer adapter
	MD998813 Installer-100	General service tool	Use with Installer cap and Installer adapter
	MD998816 Installer adapter (30)	General service tool	Installation of input shaft front bearing
	MD998825 Installer adapter (52)	General service tool	Installation of 1st-2nd speed synchronizer hub, 3rd-4th speed synchronizer hub and 1st speed gear sleeve

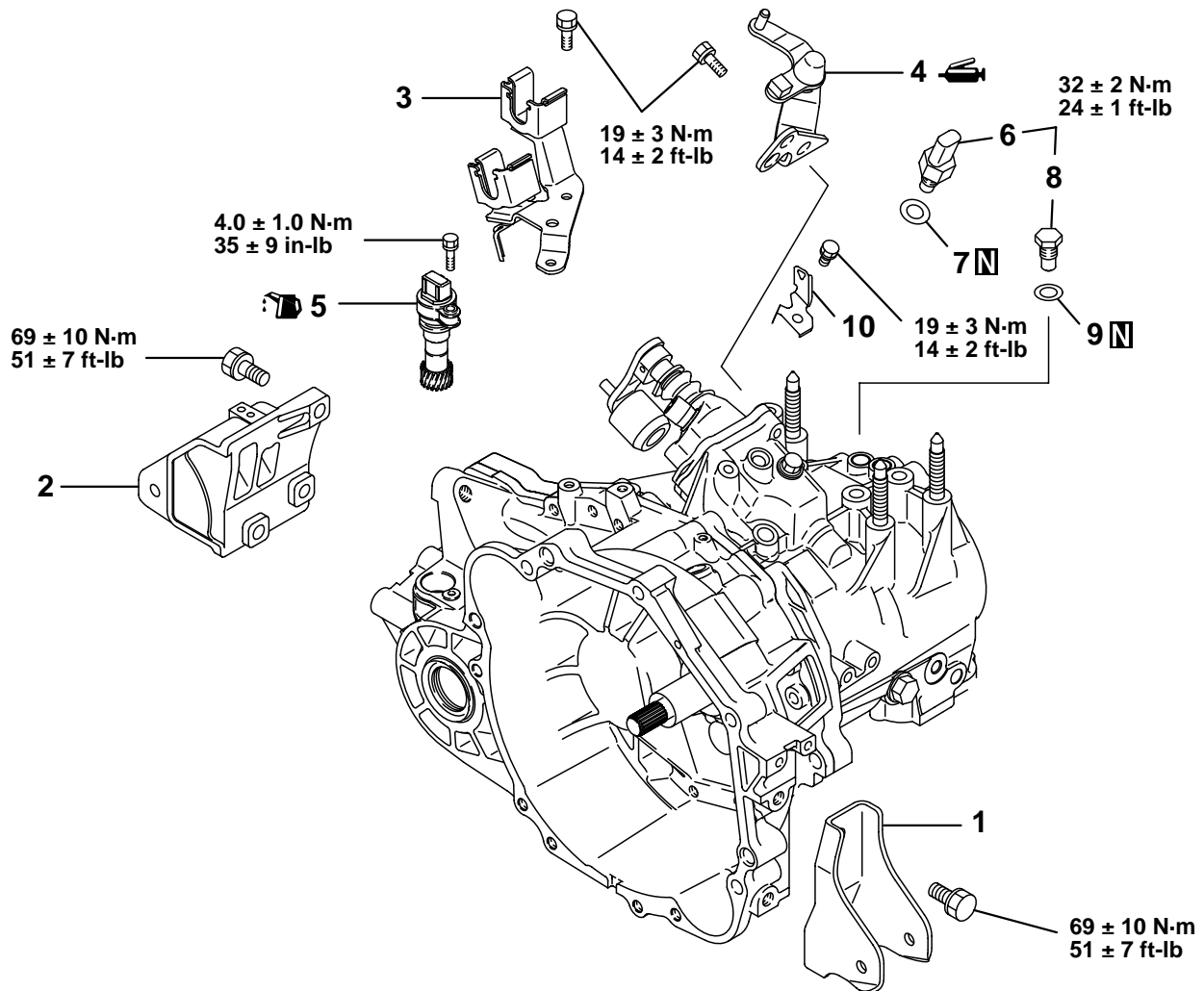
TOOL	TOOL NUMBER AND NAME	SUPERSESSION	APPLICATION
	MD998824 Installer adapter (50)	General service tool	Installation of 4th speed gear sleeve and 5th speed gear
	MD998818 Installer adapter (38)	MD998818	Installation of input shaft rear bearing, roller bearing inner race, reverse gear sleeve and output shaft rear ball bearing
	MD998917 Bearing remover	General service tool	Installation and removal of gears, bearing and sleeves
	MD998819 Installer adapter (40)	General service tool	Installation of 5th-reverse speed synchronizer hub, differential case bearing, 4th speed gear and 5th speed gear sleeve
	MD998814 Installer-200	MIT304180	Use with Installer cap and Installer adapter
	MD998822 Installer adapter (46)	General service tool	Installation of 2nd speed gear sleeve and 3rd speed gear
	MD999566 Claw	General service tool	Removal of taper roller bearing outer race
	MD998772 Valve spring compressor	General service tool	Removal of output shaft front roller bearing outer race

TOOL	TOOL NUMBER AND NAME	SUPERSESSON	APPLICATION
	MD998346 Bearing outer race remover	MD998346-01 or General service tool	Removal of output shaft front roller bearing outer race
	MB990934 Installer adapter	MB990934-01 or General service tool	Installation of output shaft front roller bearing outer race
	MB990926 Installer adapter	MB990926-01 or General service tool	Installation of clutch housing input shaft oil seal
	MD998325 Differential oil seal installer	MD998325-01	Installation of differential oil seal

TRANSAXLE

DISASSEMBLY AND ASSEMBLY

M1222001000171



AK302324 AB

DISASSEMBLY STEPS

- >>J<<
1. ROLL STOPPER BRACKET, FRONT
 2. ROLL STOPPER BRACKET, REAR
 3. SHIFT CABLE BRACKET
 4. SELECT LEVER

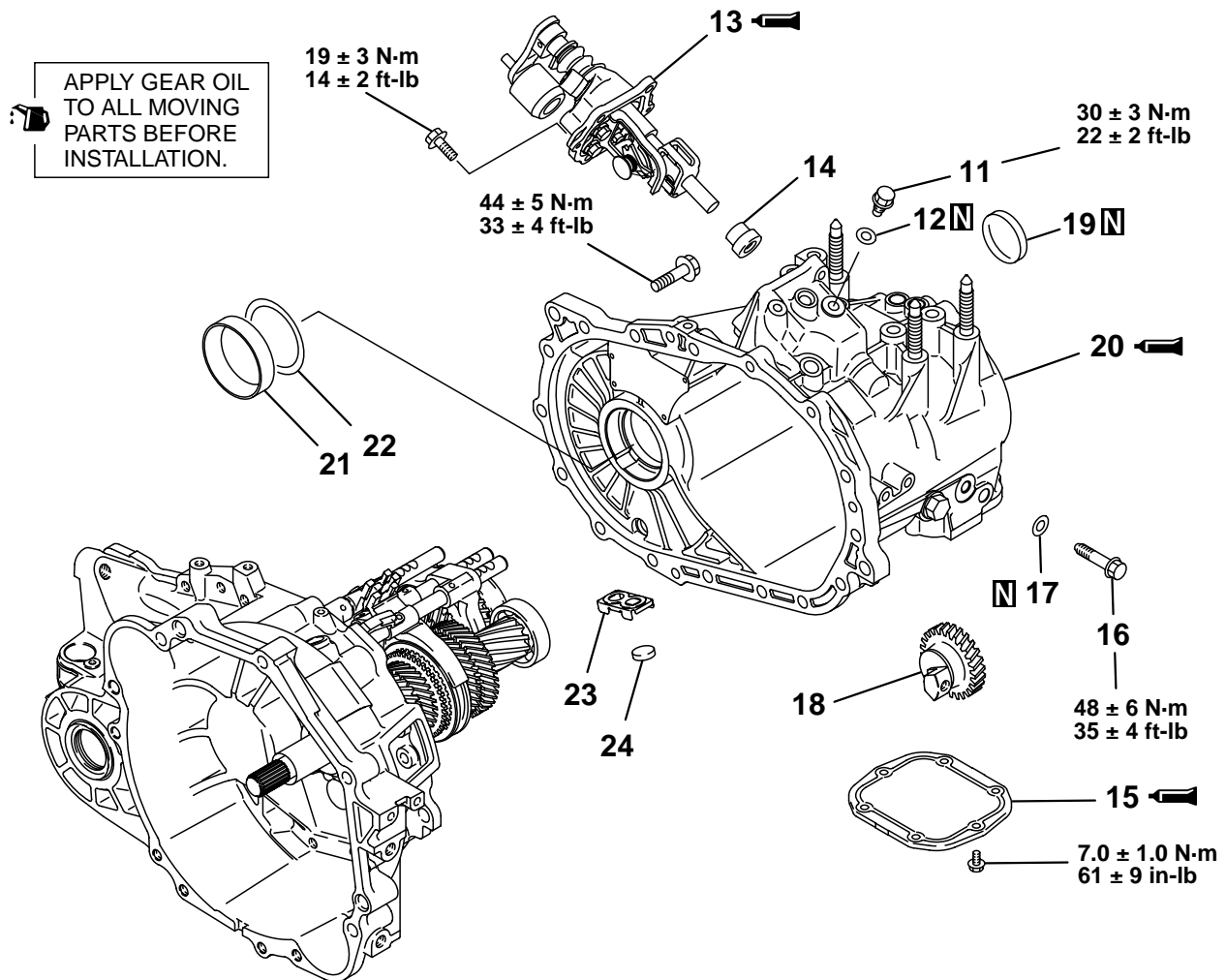
>>K<<

DISASSEMBLY STEPS

5. SPEEDOMETER GEAR
6. BACKUP LIGHT SWITCH
7. GASKET
8. POPPET SPRING
9. GASKET
10. HARNESS BRACKET

Required Special Tools:

- MB990927: Installer Adapter
- MB990935: Installer Adapter
- MB990938: Handle



AK302345AB

DISASSEMBLY STEPS

11. INTERLOCK PLATE BOLT
 12. GASKET
 >>H<< 13. CONTROL HOUSING
 14. NEUTRAL RETURN SPRING
 >>G<< 15. UNDER COVER
 16. REVERSE IDLER GEAR SHAFT BOLT
 17. GASKET

<<A>>

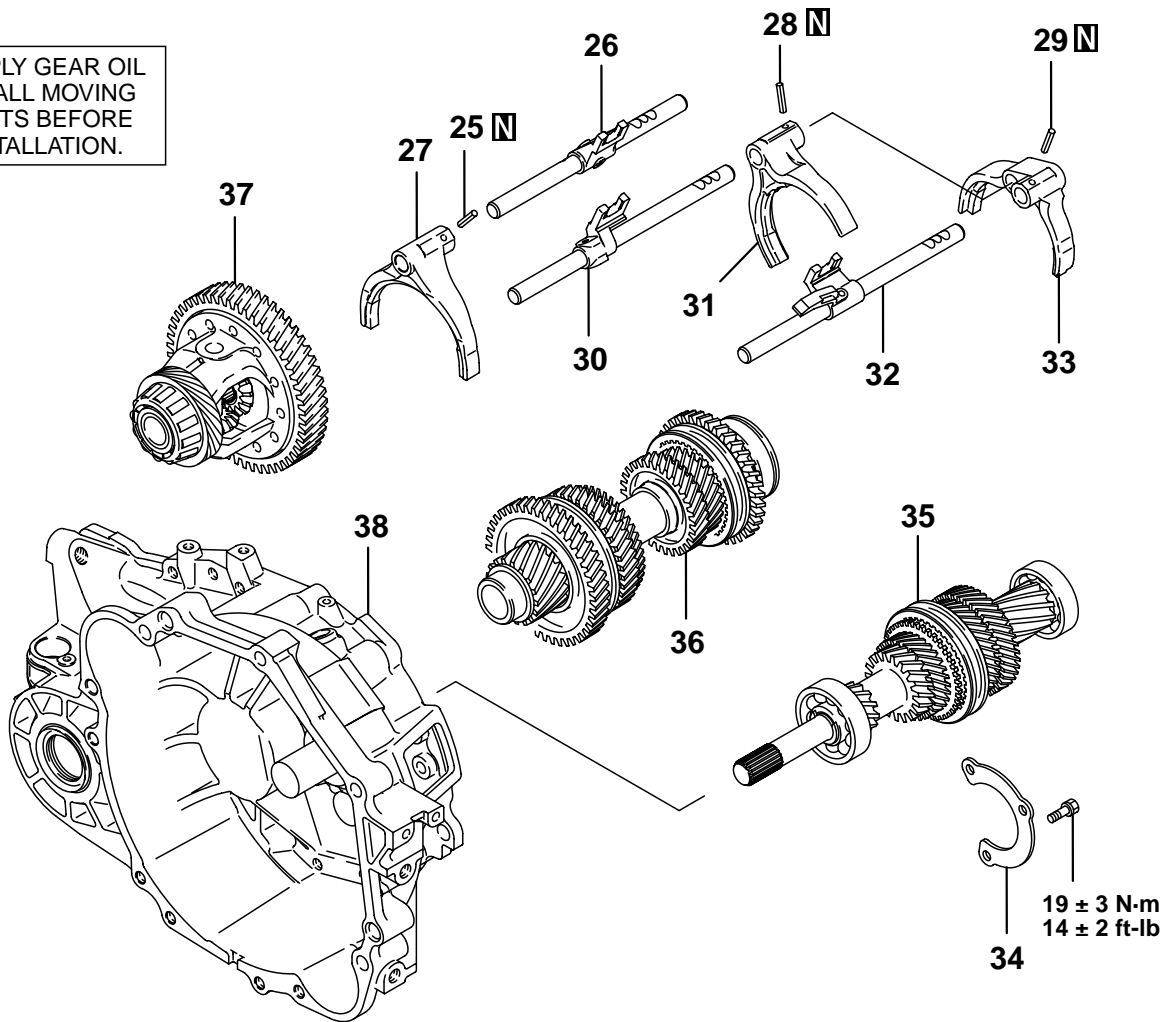
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DISASSEMBLY STEPS

18. REVERSE IDLER GEAR ASSEMBLY
 >>F<< 19. SEALING CAP
 >>E<< 20. TRANSAXLE CASE
 >>D<< 21. OUTER RACE
 >>D<< 22. SPACER
 23. MAGNET HOLDER
 24. MAGNET



APPLY GEAR OIL
TO ALL MOVING
PARTS BEFORE
INSTALLATION.



AK302346 AB

DISASSEMBLY STEPS

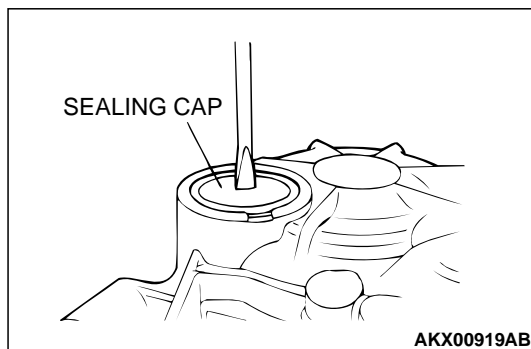
- >>C<< 25. SPRING PIN
>>C<< 26. 1ST-2ND SPEED SHIFT RAIL
>>C<< 27. 1ST-2ND SPEED SHIFT FORK
>>C<< 28. SPRING PIN
>>C<< 29. SPRING PIN
<<C>> >>B<< 30. 3RD-4TH SPEED SHIFT RAIL
<<C>> >>B<< 31. 3RD-4TH SPEED SHIFT FORK
<<C>> >>B<< 32. 5TH SPEED-REVERSE SHIFT RAIL

DISASSEMBLY STEPS

- <<C>> >>B<< 33. 5TH SPEED-REVERSE SHIFT FORK
<<D>> >>A<< 34. FRONT BEARING RETAINER
<<D>> >>A<< 35. INPUT SHAFT
<<D>> >>A<< 36. OUTPUT SHAFT
<<D>> >>A<< 37. DIFFERENTIAL
<<D>> >>A<< 38. CLUTCH HOUSING

DISASSEMBLY SERVICE POINTS**<<A>> SEALING CAP REMOVAL**

1. Drive a screwdriver into the center of the sealing cap.
2. Bend the screwdriver back to remove the sealing cap.

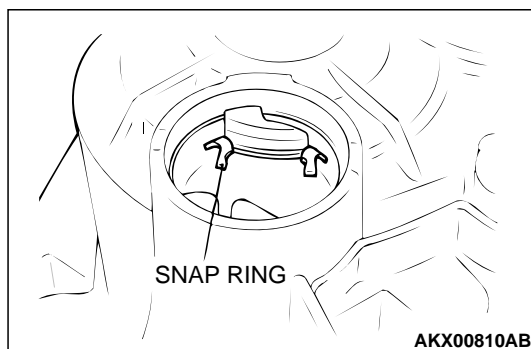
**<> TRANSAXLE CASE REMOVAL**

1. Remove all sixteen bolts securing the transaxle case to the clutch housing.
2. Use snap ring pliers to expand the indicated snap ring. The snap ring will release the grooved ball bearing, and the output shaft assembly will fall under its own weight.

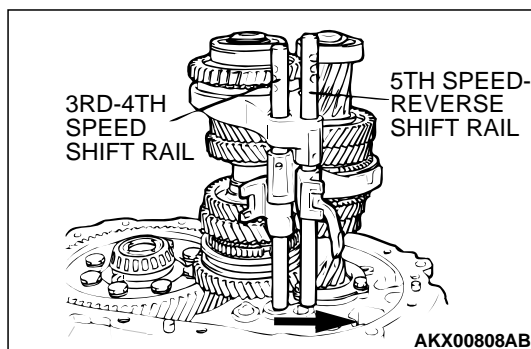
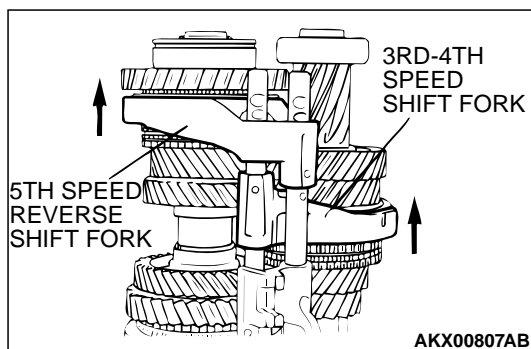
⚠ CAUTION

Do not use a scraper or chisel to remove the transaxle case.

3. Remove the transaxle case from the clutch housing by gently prying on opposite sides at the same time.

**<<C>> 3RD-4TH SPEED SHIFT RAIL/3RD-4TH SPEED SHIFT FORK/5TH SPEED-REVERSE SHIFT RAIL/5TH SPEED-REVERSE SHIFT FORK REMOVAL**

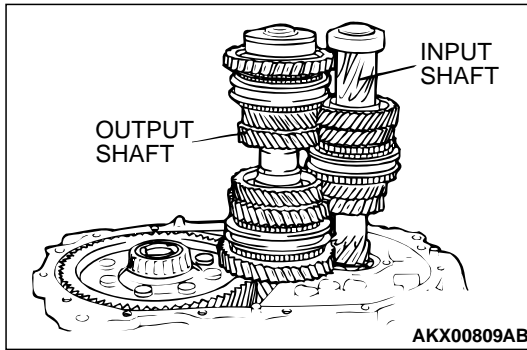
1. Shift the 3rd-4th speed shift fork and 5th speed-reverse shift fork in the direction shown.



2. Pull up on the 3rd-4th speed shift rail and 5th speed-reverse shift rail and take them out of the hole in the clutch housing.
3. Slide the 3rd-4th speed shift rail and 5th speed-reverse shift rail in the direction shown and remove them together with the shift forks.

<<D>> INPUT SHAFT AND OUTPUT SHAFT REMOVAL

Remove the input and output shafts together.



ADJUSTMENT BEFORE ASSEMBLY

SPACER SELECTION FOR DIFFERENTIAL CASE PRE-LOAD ADJUSTMENT

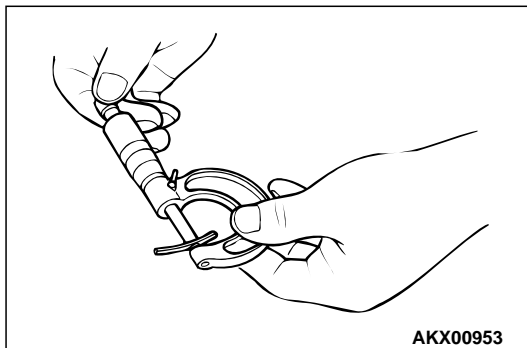
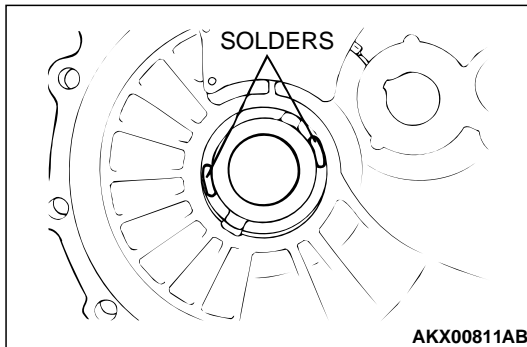
1. Put solders [1.6 mm (0.063 inch) diameter, about 10 mm (0.39 inch) long] in the illustrated positions of the transaxle case.
 2. Install the taper bearing outer race and differential assembly into the transaxle case.
- NOTE: If necessary, replace the differential case and taper bearing before carrying out these adjustments.*
3. Install the clutch housing and tighten the bolts to the specified torque.

Tightening torque: 44 ± 5 N·m (33 ± 4 ft-lb)

4. Remove the clutch housing, and then remove the differential assembly.
5. Remove the outer race and take out crushed solders.
6. Measure the thickness of the crushed solder with a micrometer and select a spacer that will provide the standard preload value.

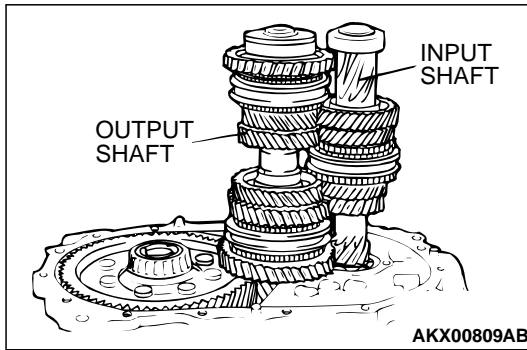
Standard value:

0.05 – 0.11 mm (0.0020 – 0.0043 inch) preload

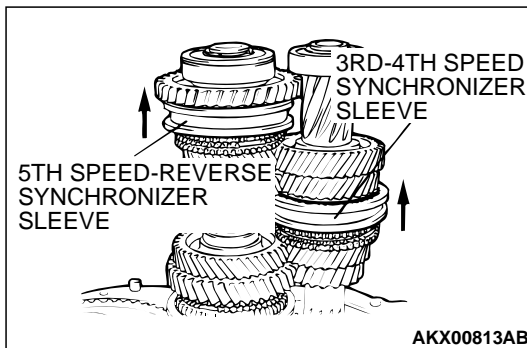


ASSEMBLY SERVICE POINTS**>>A<< OUTPUT SHAFT/INPUT SHAFT INSTALLATION**

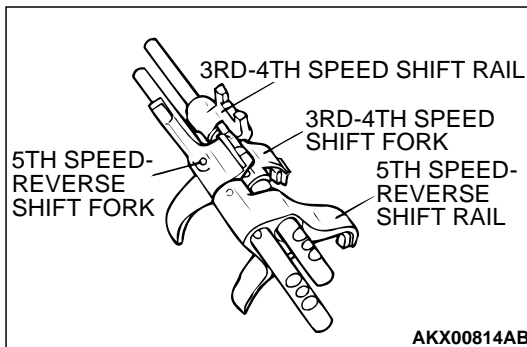
Install the input and output shafts together.

**>>B<< 5TH SPEED-REVERSE SHIFT FORK/5TH SPEED-REVERSE SHIFT RAIL/3RD-4TH SPEED SHIFT FORK/3RD-4TH SPEED SHIFT RAIL INSTALLATION**

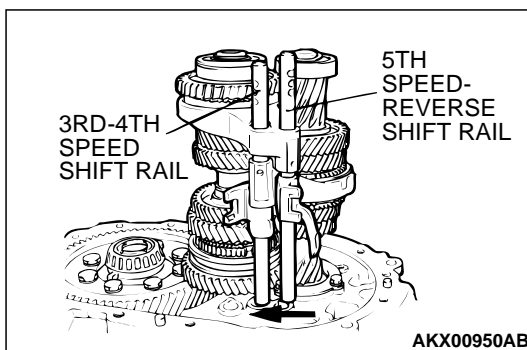
1. Shift the 3rd-4th speed synchronizer sleeve and 5th speed-reverse synchronizer sleeve in the direction shown.

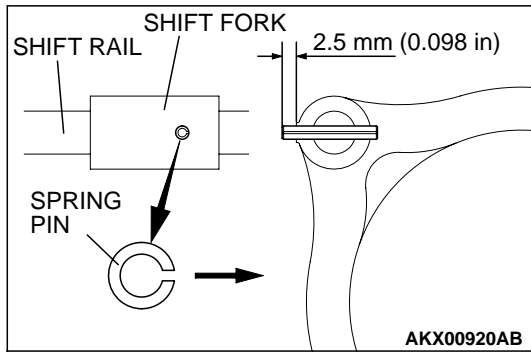


2. Assemble the 3rd-4th speed shift rail and fork, and the 5th speed-reverse shift rail and fork.



3. While fitting each shift fork in the groove of synchronizer sleeve, slide the shift rails in the direction shown and install.
4. Insert the 3rd-4th speed shift rail and 5th speed-reverse shift rail into the rail hole in the clutch housing.



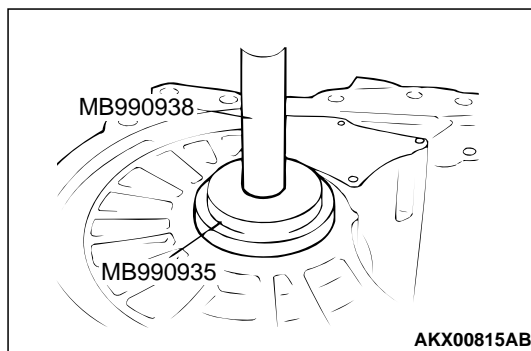


>>C<< SPRING PIN INSTALLATION

1. Align the pin holes in the shift rail and shift fork.
2. Insert the new spring pin. Push it in as shown so that the slit and center axis of the rail are aligned.

>>D<< SPACER AND OUTER RACE INSTALLATION

1. Install the spacer selected in the section "ADJUSTMENT BEFORE ASSEMBLY."
2. Using special tools MB990935 and MB990938, press the outer race into the transaxle case.



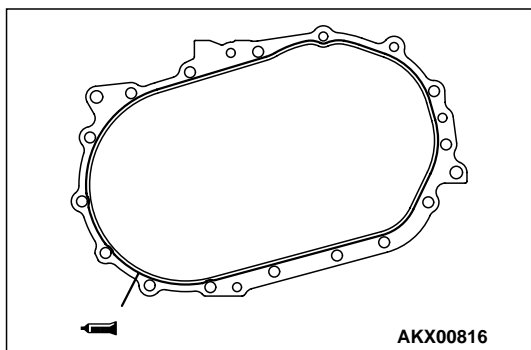
>>E<< TRANSAXLE CASE INSTALLATION

⚠ CAUTION

Squeeze sealant evenly onto the transaxle housing. Do not leave gaps or excess amounts, otherwise oil leaks are likely.

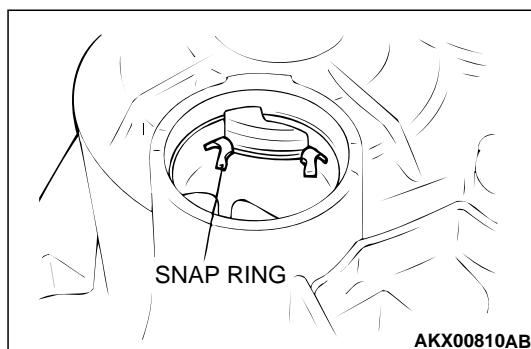
1. Apply a 2 mm (0.08 inch) diameter bead of sealant (Mitsubishi Genuine Part number MD997740 or equivalent) as illustrated onto the transaxle case.

NOTE: Be sure to install the transaxle case onto the transaxle housing while the sealant is still wet (within 15 minutes).



2. Align the transaxle case and expand the snap ring. After the case is on far enough for the snap ring to ride on the bearing, release the snap ring. Push down on the transaxle case, twisting it from side to side until the case contacts the housing.
3. Tighten the transaxle case mounting bolts to the specified torque.

Tightening torque: 44 ± 5 N·m (33 ± 4 ft-lb)

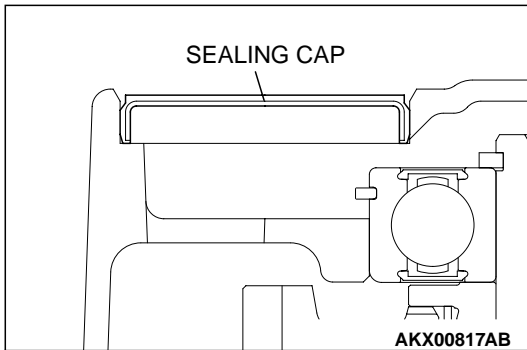
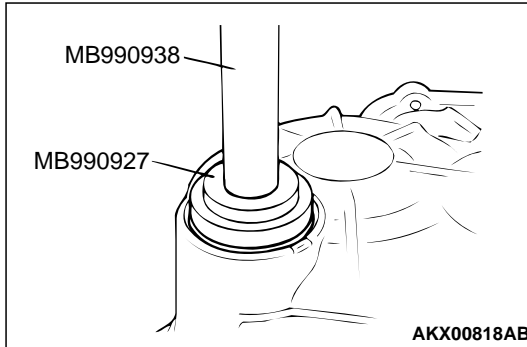


- Place the transaxle upside down and let the snap ring fit in the groove by the output shaft's own weight.

NOTE: After installation, keep the sealed area away from oil for approximately one hour.

>>F<< SEALING CAP INSTALLATION

- Using special tools MB990927 and MB990938, press install the sealing cap onto the case.



- Evenly press the sealing cap so it is fully seated and not at an angle.

>>G<< UNDER COVER INSTALLATION

CAUTION

Squeeze sealant onto the case. Do not leave gaps or excess amounts, otherwise oil leaks are likely.

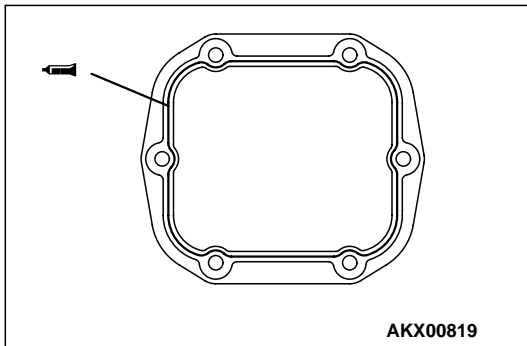
- Apply a 2 mm (0.08 inch) diameter bead of sealant (Mitsubishi Genuine Part number MD997740 or equivalent) as illustrated onto the under cover.

NOTE: Be sure to install the under cover to the case quickly while the sealant is still wet (within 15 minutes).

- Install the under cover to the transaxle case and tighten the bolts to specified torque.

Tightening torque: 7.0 ± 1.0 N·m (61 ± 9 in-lb)

NOTE: After installation, keep the sealed area away from oil for approximately one hour.



>>H<< CONTROL HOUSING INSTALLATION

CAUTION

Squeeze sealant onto the case. Do not leave gaps or excess amounts, otherwise oil leaks are likely.

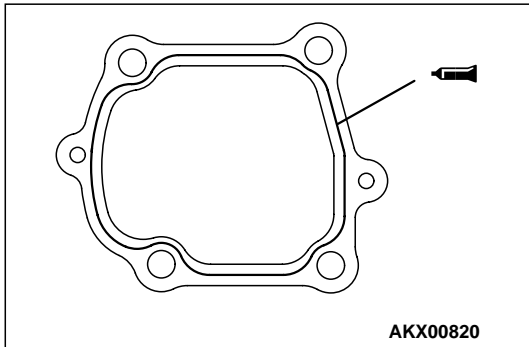
1. Apply a 0.2 mm (0.08 inch) diameter bead of sealant (Mitsubishi Genuine Part number MD997740 or equivalent) as illustrated onto the control housing.

NOTE: Be sure to install the housing to the case quickly while the sealant is still wet (within 15 minutes).

2. Install the control housing to the transaxle case and tighten the bolts to specified torque.

Tightening torque: 19 ± 3 N·m (14 ± 2 ft-lb)

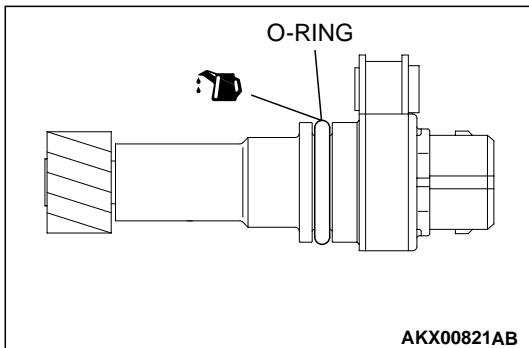
NOTE: After installation, keep the sealed area away from the oil for approximately one hour.



>>I<< SPEEDOMETER GEAR INSTALLATION

1. Apply gear oil (Hypoid gear oil SAE 75W-90 or 75W-85W conforming to API classification GL-4) to the O-ring of the speedometer gear. Install into the transaxle housing.
2. Tighten the bolt to specified torque.

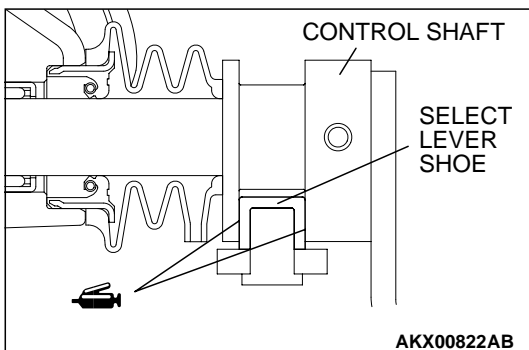
Tightening torque: 4.0 ± 1.0 N·m (35 ± 9 in-lb)



>>J<< SELECT LEVER INSTALLATION

1. Apply grease (Mitsubishi Genuine Part number 0101011 or equivalent) to the control shaft sliding portion of the select lever shoe.
2. Install the select lever and tighten the bolts to specified torque.

Tightening torque: 19 ± 3 N·m (14 ± 2 ft-lb)

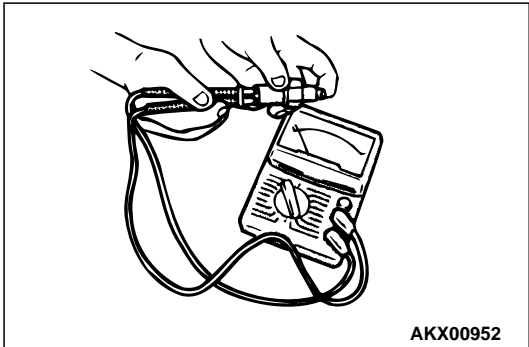


INSPECTION

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BACKUP LIGHT SWITCH

Check for continuity between terminals.

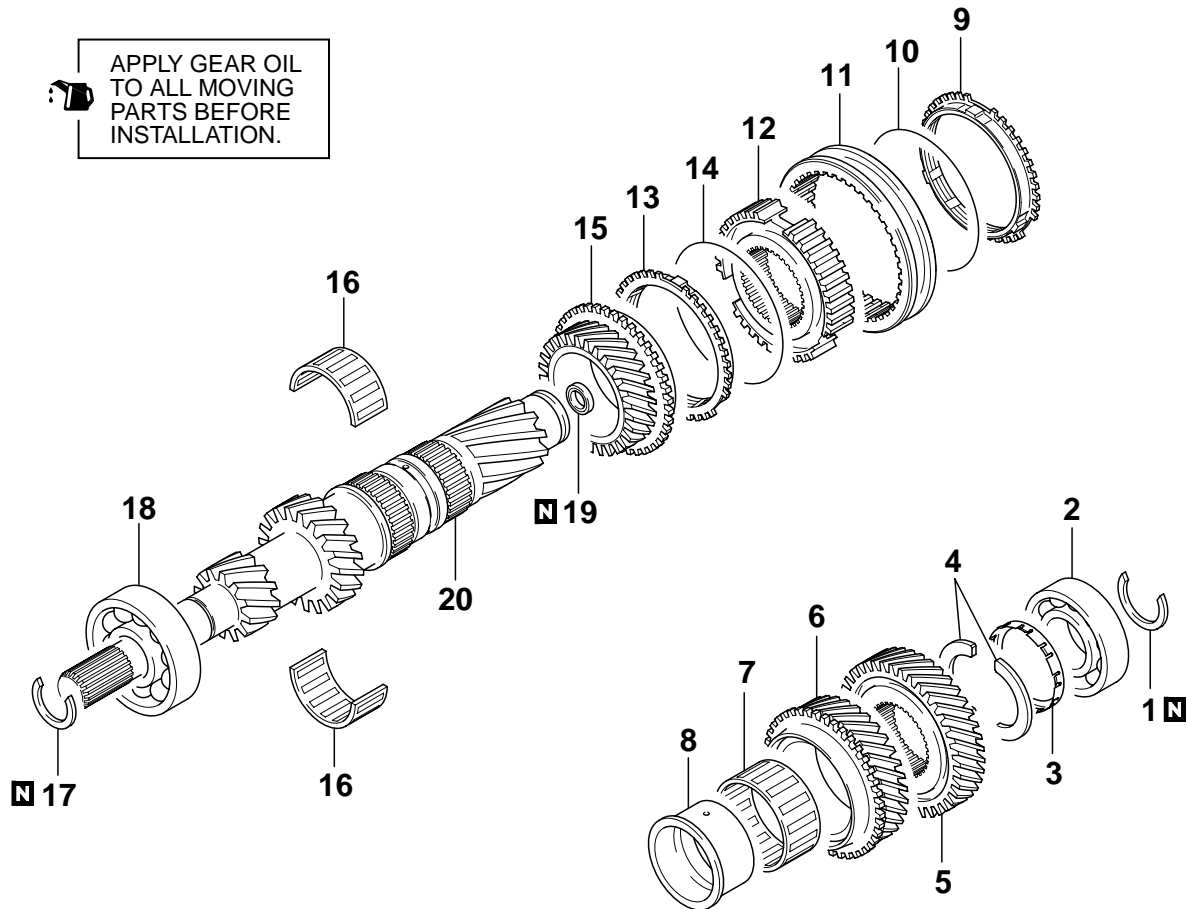


SWITCH CONDITION	CONTINUITY
Pressed	Open
Released	Conductive

INPUT SHAFT

DISASSEMBLY AND ASSEMBLY

M1222001600151



AKX00803AB

DISASSEMBLY STEPS

- | | | | |
|-------|-------|-----|-----------------------|
| <<A>> | >>M<< | 1. | SNAP RING |
| <> | >>L<< | 2. | BALL BEARING |
| <<C>> | >>K<< | 3. | THRUST PLATE STOPPER |
| | >>J<< | 4. | THRUST PLATE |
| | >>I<< | 5. | 5TH SPEED GEAR |
| | | 6. | 4TH SPEED GEAR |
| | | 7. | NEEDLE ROLLER BEARING |
| <<D>> | >>H<< | 8. | 4TH SPEED GEAR SLEEVE |
| | >>E<< | 9. | SYNCHRONIZER RING |
| | >>D<< | 10. | SYNCHRONIZER SPRING |
| | >>G<< | 11. | SYNCHRONIZER SLEEVE |

DISASSEMBLY STEPS

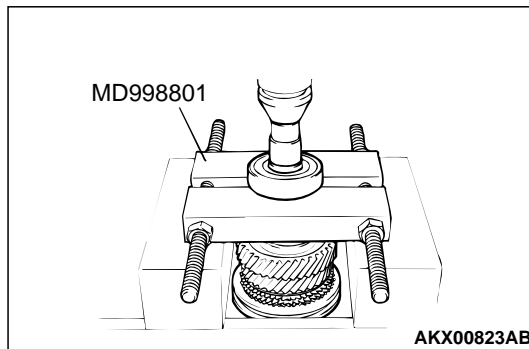
- | | | | |
|-------|-------|-----------------------------------|--------------|
| >>F<< | 12. | 3RD-4TH SPEED
SYNCHRONIZER HUB | |
| >>E<< | 13. | SYNCHRONIZER RING | |
| >>D<< | 14. | SYNCHRONIZER SPRING | |
| | 15. | 3RD SPEED GEAR | |
| | 16. | NEEDLE ROLLER BEARING | |
| >>C<< | 17. | SNAP RING | |
| <<E>> | >>B<< | 18. | BALL BEARING |
| | >>A<< | 19. | OIL SEAL |
| | | 20. | INPUT SHAFT |

Required Special Tools:

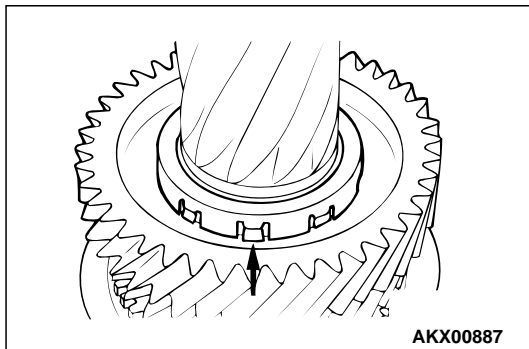
- MD998801: Bearing Remover
- MD998812: Installer Cap
- MD998813: Installer-100
- MD998816: Installer Adapter (30)
- MD998818: Installer Adapter (38)
- MD998824: Installer Adapter (50)
- MD998825: Installer Adapter (52)

DISASSEMBLY SERVICE POINTS**<<A>> BALL BEARING REMOVAL**

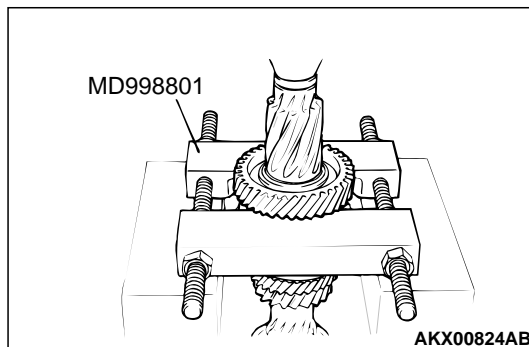
1. Using special tool MD998801, support the ball bearing, and then set them on the press.
2. Push down on the input shaft with the press and remove the ball bearing.

**<> THRUST PLATE STOPPER REMOVAL**

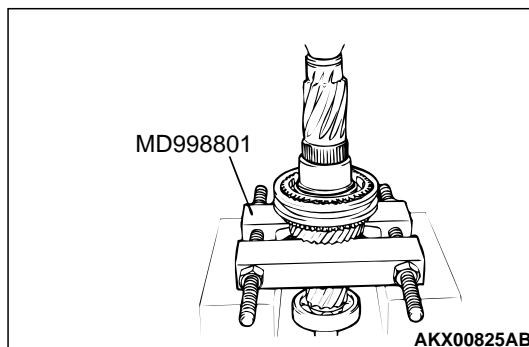
Using a screwdriver, pry up at the position shown in the illustration and remove the thrust plate stopper.

**<<C>>5TH SPEED GEAR REMOVAL**

1. Using special tool MD998801, support the 5th speed gear, and then set them on the press.
2. Push down on the input shaft with the press and remove the 5th speed gear.

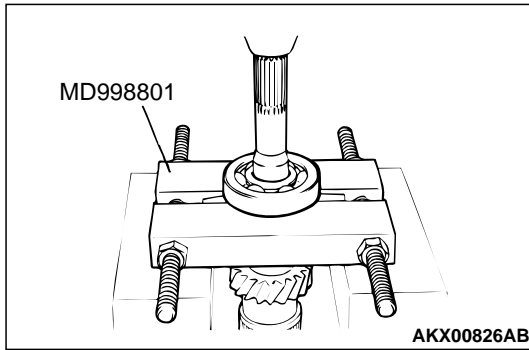
**<<D>>4TH SPEED GEAR SLEEVE REMOVAL**

1. Using special tool MD998801, support the 3rd speed gear, and then set them on the press.
2. Push down on the input shaft with the press and remove the 4th speed gear sleeve.



<<E>> BALL BEARING REMOVAL

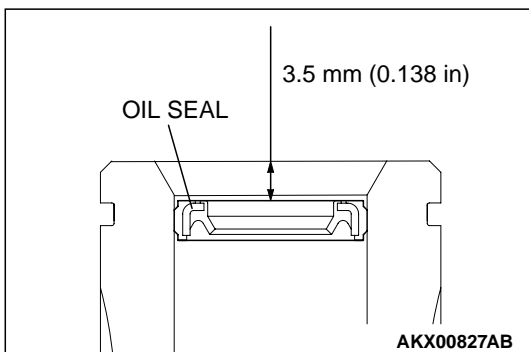
1. Using special tool MD998801, support the ball bearing, and then set them on the press.
2. Push down on the input shaft with the press and remove the ball bearing.



ASSEMBLY SERVICE POINTS

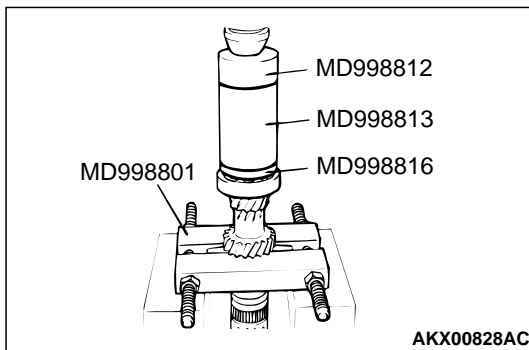
>>A<< OIL SEAL INSTALLATION

Install the oil seal into the end of the input shaft as shown.



>>B<< BALL BEARING INSTALLATION

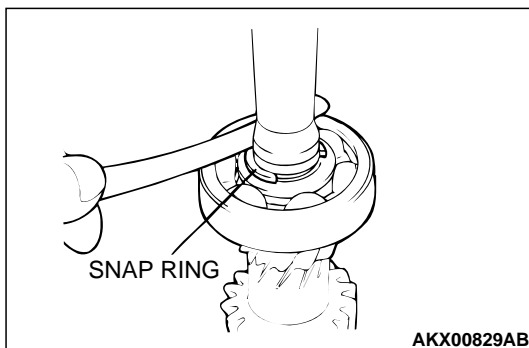
1. Using special tool MD998801, support the 2nd speed gear portion of the input shaft, and then set them on the press.
2. Using special tools MD998812, MD998813 and MD998816, press install the bearing with the press.

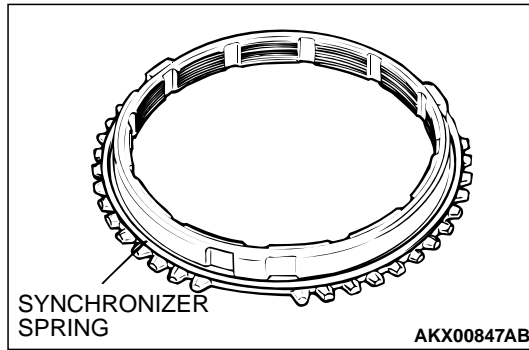


>>C<< SNAP RING INSTALLATION

1. Install the thickest snap ring that can be fitted in the snap ring groove of input shaft.
2. Make sure that the ball bearing end play meets the standard value.

Standard value: 0 – 0.12 mm (0 – 0.0047 inch)



**>>D<< SYNCHRONIZER SPRING INSTALLATION**

Install the synchronizer spring onto the synchronizer ring as shown.

>>E<< SYNCHRONIZER RING INSTALLATION**⚠ CAUTION**

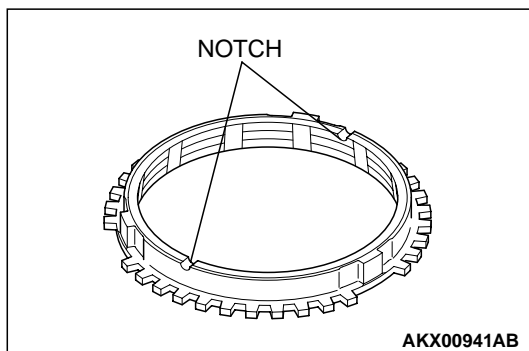
There are 3rd speed and 4th speed synchronizer rings, if the wrong one is installed it will effect the shift feeling.

1. Ascertain whether or not there are identification notches on the synchronizer ring.

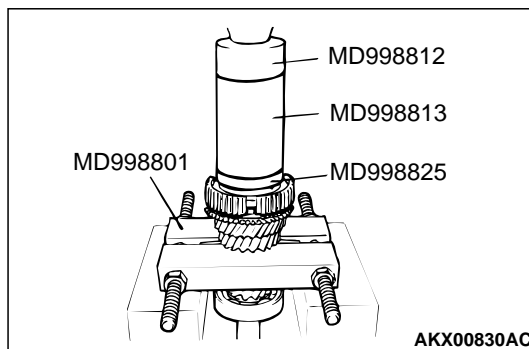
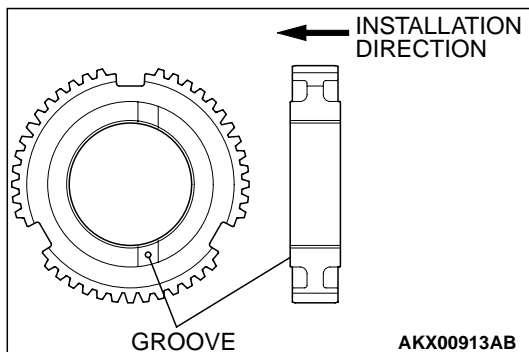
Two notches: 3rd speed synchronizer ring

No notches: 4th speed synchronizer ring

2. Install the synchronizer ring so that it completely fits over the machined cone of the gear.

**>>F<< 3RD-4TH SPEED SYNCHRONIZER HUB INSTALLATION**

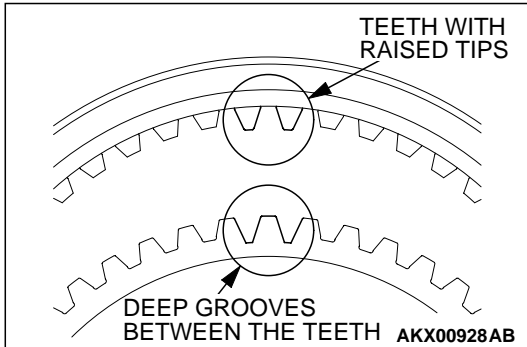
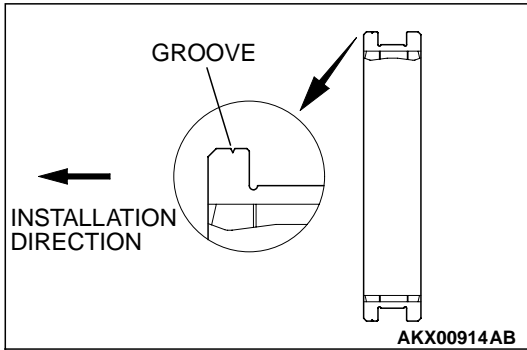
1. Using special tool MD998801, support the 2nd speed gear portion of the input shaft, and then set them on the press.
2. Make sure that the synchronizer ring has been perfectly matched to the 3rd speed gear cone.
3. Check the installation direction of the 3rd-4th speed synchronizer hub, and put it on the input shaft.



4. Using special tools MD998812, MD998813 and MD998825, press install the 3rd-4th speed synchronizer hub with the press.
5. Make sure that the synchronizer ring can rotate freely.

>>G<< SYNCHRONIZER SLEEVE INSTALLATION

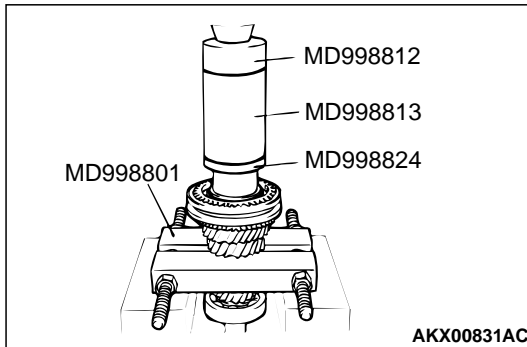
1. Check the installation direction of the synchronizer sleeve, and install it onto the 3rd-4th speed synchronizer hub.



2. Install the synchronizer sleeve so that the areas with teeth that have raised tips (three areas total) are aligned with the areas on the synchronizer hub that have deep grooves between the teeth (three areas total).

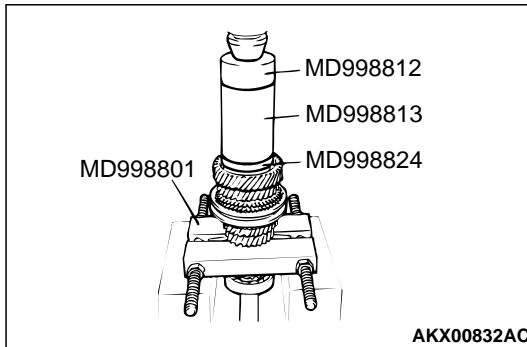
>>H<< 4TH SPEED GEAR SLEEVE INSTALLATION

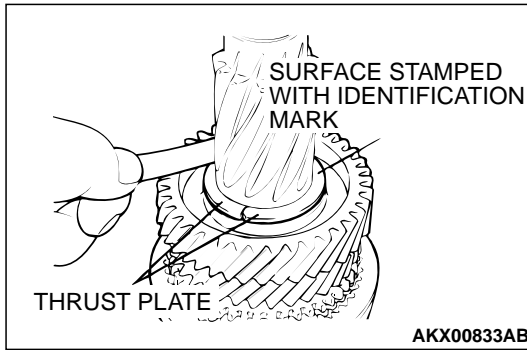
1. Using special tool MD998801, support the 2nd speed gear portion of the input shaft, and then set them on the press.
2. Using special tools MD998812, MD998813 and MD998824, install the 4th speed gear sleeve with the press.



>>I<< 5TH SPEED GEAR INSTALLATION

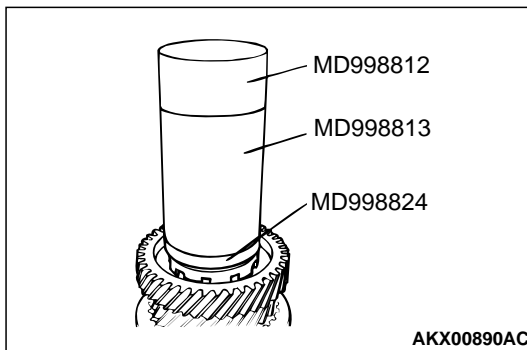
1. Using special tool MD998801, support the 2nd speed gear portion of the input shaft, and then set them on the press.
2. Using special tools MD998812, MD998813 and MD998824, install the 5th speed gear onto the input shaft with the press.



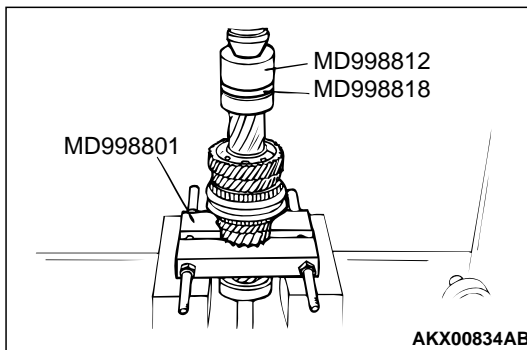
**>>J<< THRUST PLATE INSTALLATION**

1. Install the thickest thrust plates that can be fitted in the groove of the input shaft. Install the thrust plate so the surface stamped with the identification mark is facing up.
2. Make sure that the 5th speed gear end play meets the standard value.

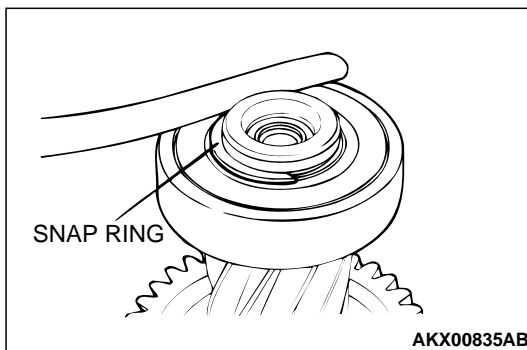
Standard value: 0 – 0.09 mm (0 – 0.0035 inch)

**>>K<< THRUST PLATE STOPPER INSTALLATION**

Install the thrust plate stopper by pressing special tools MD998812, MD998813 and MD998824 by hand. Make sure that it is not tilted.

**>>L<< BALL BEARING INSTALLATION**

1. Using special tool MD998801, support the 2nd speed gear portion of the input shaft, and then set them on the press.
2. Using special tools MD998812 and MD998818, install the ball bearing onto the input shaft with the press.

**>>M<< SNAP RING INSTALLATION**

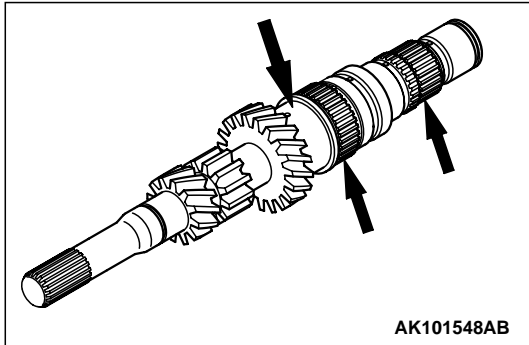
1. Install the thickest snap ring that can be fitted in the groove of the input shaft.
2. Make sure that the ball bearing end play meets the standard value.

Standard value: 0 – 0.12 mm (0 – 0.0047 inch)

INSPECTION

INPUT SHAFT

1. Check the outside diameter of the needle bearing mounting portion for damage, abnormal wear and seizure.
2. Check the splines for damage and wear.
3. Check that the helical gear teeth surfaces are not damaged or worn.

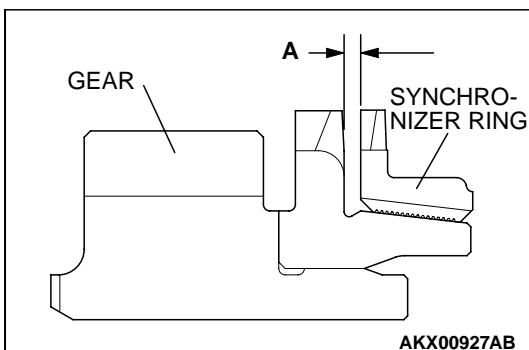
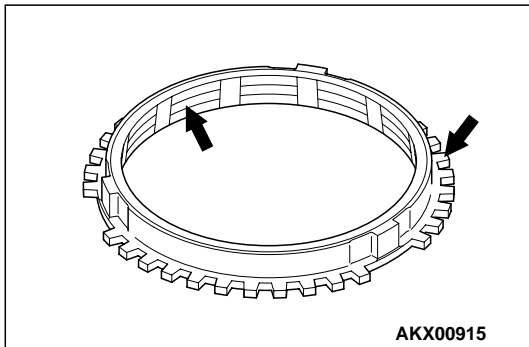


NEEDLE ROLLER BEARING

1. Combine the needle roller bearing with the input shaft or bearing sleeve and gear, and check that it rotates smoothly without noise or play.
2. Check the needle roller bearing cage for deformation.

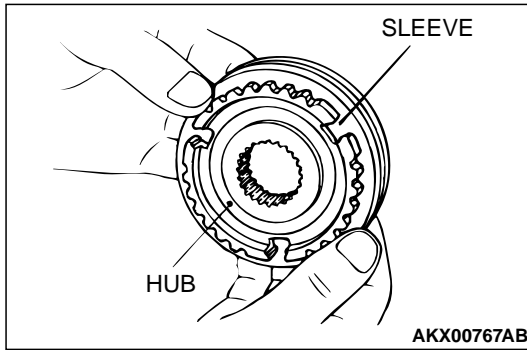
SYNCHRONIZER RING

1. Check the clutch gear teeth for damage and broken.
2. Check internal surface for damage, wear and broken threads.



3. Force the synchronizer ring toward the clutch gear and check clearance "A." If "A" is less than the limit, replace the synchronizer ring.

Minimum limit: 0.5 mm (0.020 inch)

**SYNCHRONIZER SLEEVE AND HUB**

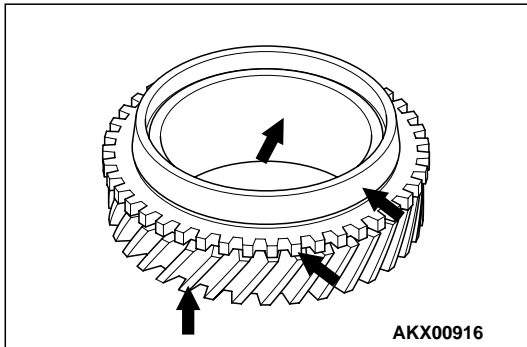
1. Combine the synchronizer sleeve and hub, and check that they slide smoothly.
2. Check that the sleeve is free from damage at its inside splines ends.

SYNCHRONIZER SPRING

Check that the spring is not sagging, deformed or broken.

SPEED GEARS

1. Check that the helical and clutch gear tooth surfaces are not damaged or worn.
2. Check that the synchronizer cone surfaces are not roughened, damaged or worn.
3. Check that the gear inside diameter and front and rear surfaces are not damaged and worn.

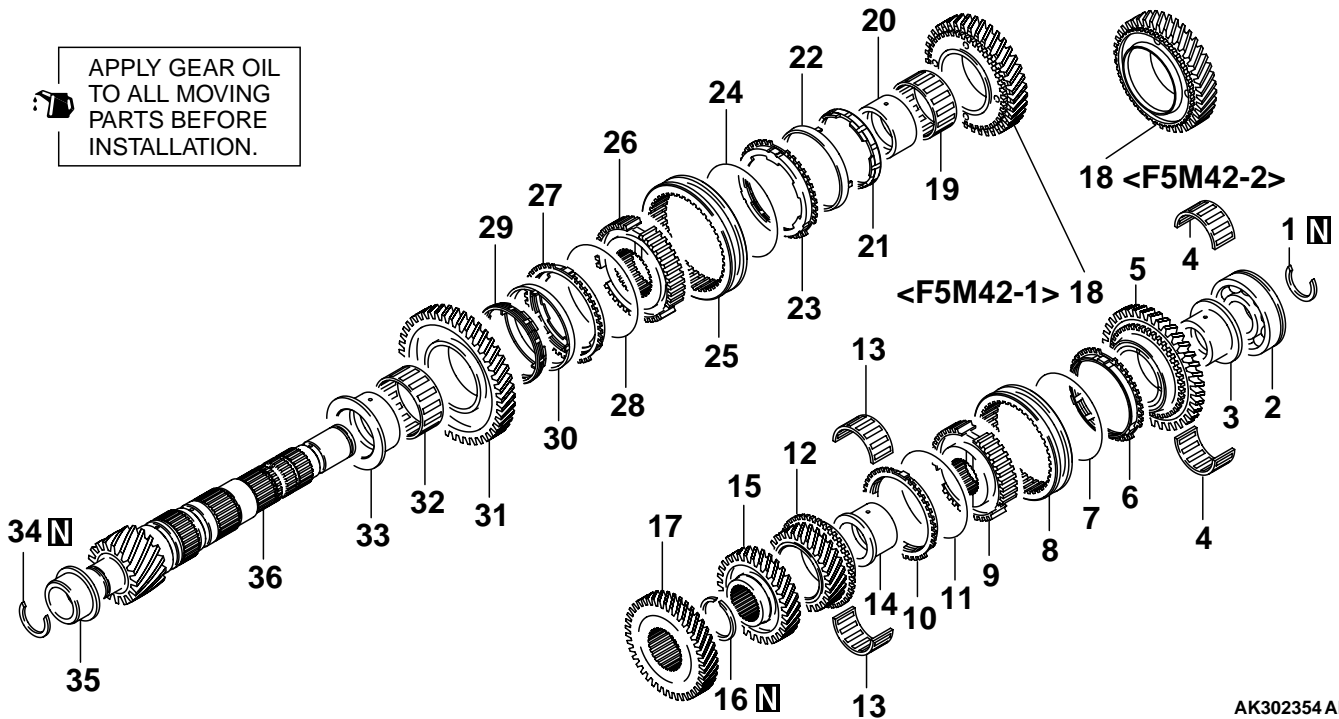


OUTPUT SHAFT

DISASSEMBLY AND ASSEMBLY

M1222002200145

APPLY GEAR OIL
TO ALL MOVING
PARTS BEFORE
INSTALLATION.



DISASSEMBLY STEPS

- | | | | |
|-------|-------|-----|------------------------------------|
| <<A>> | >>Q<< | 1. | SNAP RING |
| <> | >>P<< | 2. | BALL BEARING |
| | >>O<< | 3. | REVERSE GEAR SLEEVE |
| | | 4. | NEEDLE ROLLER BEARING |
| | | 5. | REVERSE GEAR |
| | >>M<< | 6. | SYNCHRONIZER RING |
| | >>L<< | 7. | SYNCHRONIZER SPRING |
| | >>F<< | 8. | SYNCHRONIZER SLEEVE |
| <<C>> | >>N<< | 9. | 5TH SPEED-REVERSE SYNCHRONIZER HUB |
| | >>M<< | 10. | SYNCHRONIZER RING |
| | >>L<< | 11. | SYNCHRONIZER SPRING |
| | | 12. | 5TH SPEED GEAR |
| | | 13. | NEEDLE ROLLER BEARING |
| | >>K<< | 14. | 5TH SPEED GEAR SLEEVE |
| | >>J<< | 15. | 4TH SPEED GEAR |
| | >>I<< | 16. | SNAP RING |
| <<D>> | >>H<< | 17. | 3RD SPEED GEAR |
| | | 18. | 2ND SPEED GEAR |

DISASSEMBLY STEPS

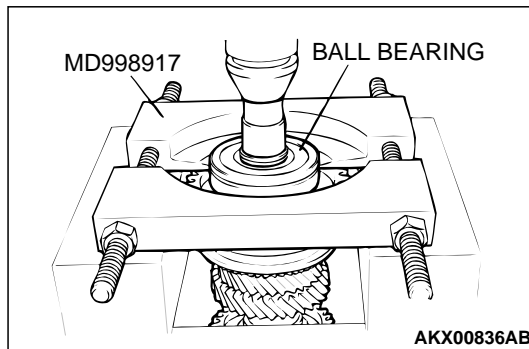
- | | | | |
|-------|-------|-----|--------------------------------|
| <<E>> | >>G<< | 19. | NEEDLE ROLLER BEARING |
| | | 20. | 2ND SPEED GEAR SLEEVE |
| | | 21. | INNER SYNCHRONIZER RING |
| | | 22. | SYNCHRONIZER CONE |
| | | 23. | OUTER SYNCHRONIZER RING |
| | >>D<< | 24. | SYNCHRONIZER SPRING |
| | >>F<< | 25. | SYNCHRONIZER SLEEVE |
| | >>E<< | 26. | 1ST-2ND SPEED SYNCHRONIZER HUB |
| | >>D<< | 27. | OUTER SYNCHRONIZER RING |
| | | 28. | SYNCHRONIZER SPRING |
| | | 29. | INNER SYNCHRONIZER RING |
| | | 30. | SYNCHRONIZER CONE |
| | | 31. | 1ST SPEED GEAR |
| | | 32. | NEEDLE ROLLER BEARING |
| <<F>> | >>C<< | 33. | 1ST SPEED GEAR SLEEVE |
| | >>B<< | 34. | SNAP RING |
| <<G>> | >>A<< | 35. | ROLLER BEARING INNER RACE |
| | | 36. | OUTPUT SHAFT |

Required Special Tools:

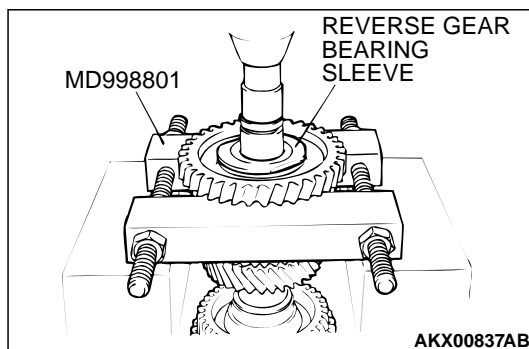
- MD998801: Bearing Remover
- MD998812: Installer Cap
- MD998813: Installer-100
- MD998814: Installer-200
- MD998818: Installer Adapter (38)
- MD998819: Installer Adapter (40)
- MD998822: Installer Adapter (46)
- MD998825: Installer Adapter (52)
- MD998917: Bearing Remover

DISASSEMBLY SERVICE POINTS**<<A>> BALL BEARING REMOVAL**

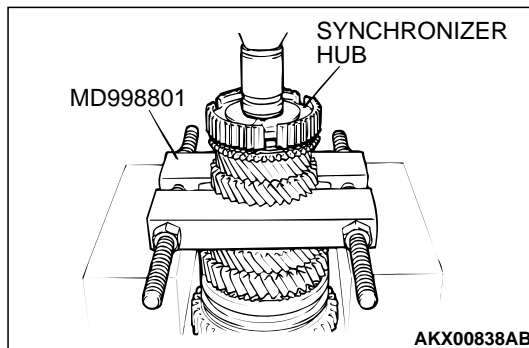
1. Using special tool MD998917, support the ball bearing, and then set them on the press.
2. Push down on the output shaft with the press, and remove the ball bearing.

**<> REVERSE GEAR BEARING SLEEVE REMOVAL**

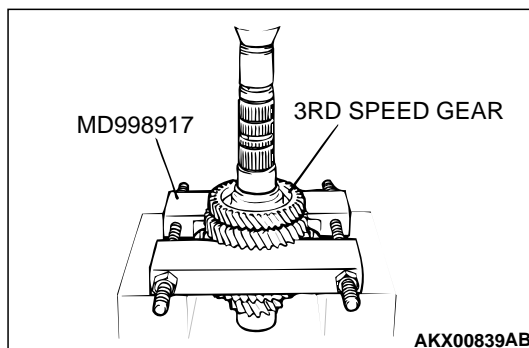
1. Using special tool MD998801, support the reverse gear, and then set them on the press.
2. Push down on the output shaft with the press and remove the reverse gear bearing sleeve.

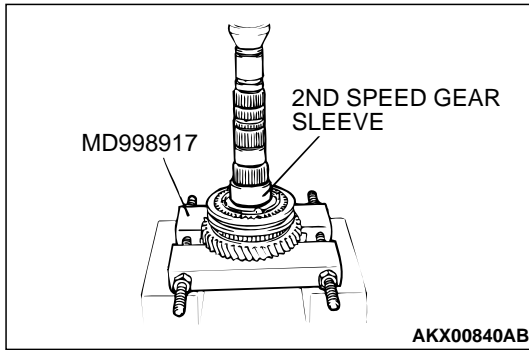
**<<C>> 5TH SPEED-REVERSE SYNCHRONIZER HUB REMOVAL**

1. Using special tool MD998801, support the 4th speed gear, and then set them on the press.
2. Push down on the output shaft with the press and remove the 5th speed-reverse synchronizer hub.

**<<D>> 3RD SPEED GEAR REMOVAL**

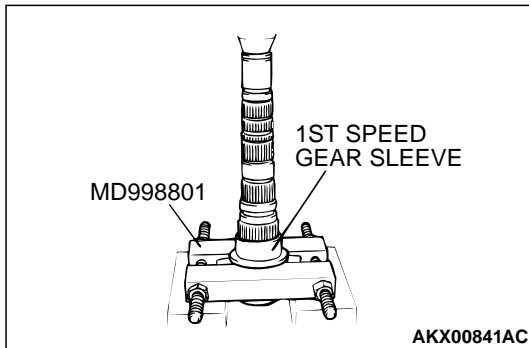
1. Using special tool MD998917, support the 2nd speed gear, and then set them on the press.
2. Push down on the output shaft with the press and remove the 3rd speed gear.





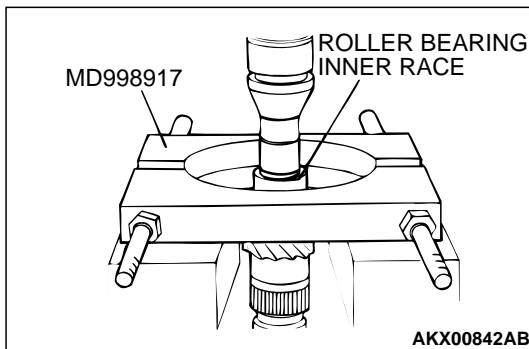
<<E>> 2ND SPEED GEAR SLEEVE REMOVAL

1. Using special tool MD998917, support the 1st speed gear, and then set them on the press.
2. Push down on the output shaft with the press and remove the 2nd speed gear sleeve.



<<F>> 1ST SPEED GEAR SLEEVE REMOVAL

1. Using special tool MD998801, support the 1st speed gear sleeve, and then set them on the press.
2. Push down on the output shaft with the press and remove the 1st speed gear sleeve.



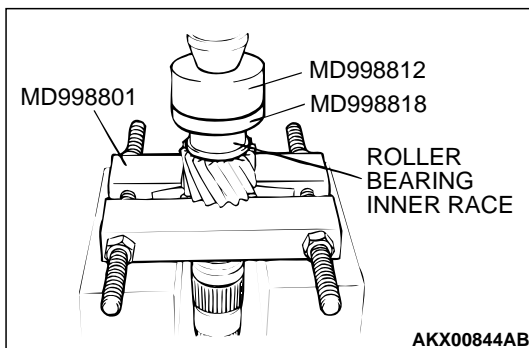
<<G>> ROLLER BEARING INNER RACE REMOVAL

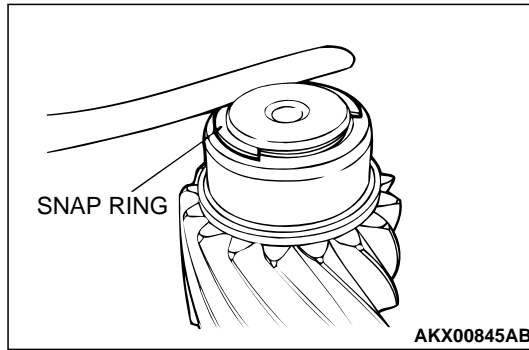
1. Using special tool MD998917, support the roller bearing inner race, and then set them on the press.
2. Push down on the output shaft with the press and remove the roller bearing inner race.

ASSEMBLY SERVICE POINTS

>>A<< ROLLER BEARING INNER RACE INSTALLATION

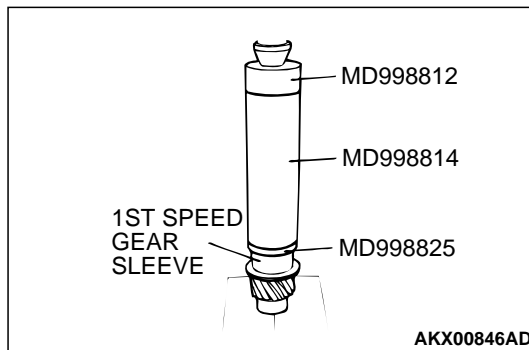
1. Using special tool MD998801, support the output shaft gear, and then set them on the press.
2. Using special tools MD998812 and MD998818, install the roller bearing inner race with the press.



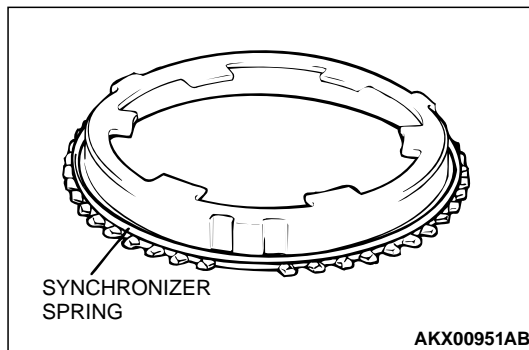
**>>B<< SNAP RING INSTALLATION**

1. Install the thickest snap ring that can be fitted in the groove of output shaft.
2. Make sure that the roller bearing inner race end play meets the standard value.

Standard value: 0 – 0.12 mm (0 – 0.0047 inch)

**>>C<<1ST SPEED GEAR SLEEVE INSTALLATION**

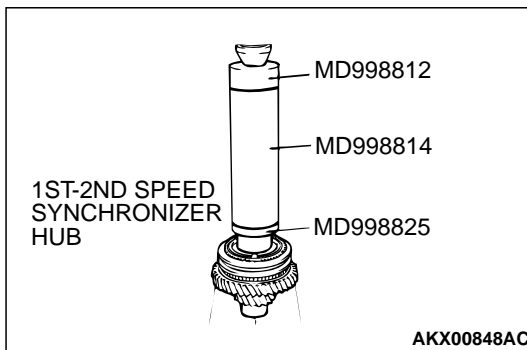
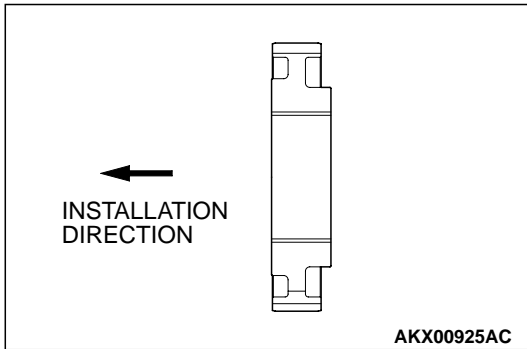
1. Set the output shaft on the press support stand.
2. Using special tools MD998812, MD998814 and MD998825, install the 1st speed gear sleeve with the press.

**>>D<< SYNCHRONIZER SPRING INSTALLATION**

Install the synchronizer spring onto the outer synchronizer ring as shown.

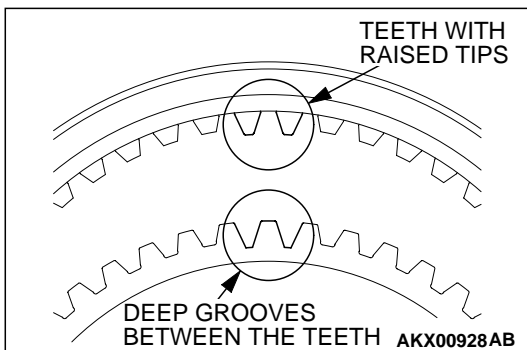
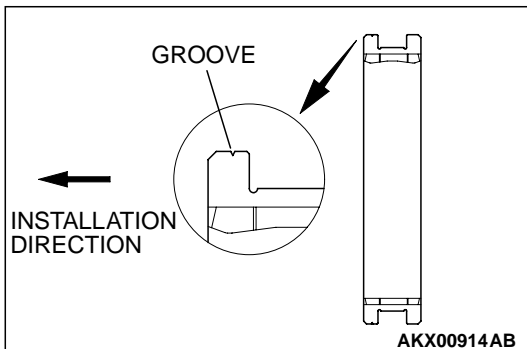
**>>E<< 1ST-2ND SPEED SYNCHRONIZER HUB
INSTALLATION**

1. Set the output shaft on the press support stand.
2. Check that the 1st-2nd speed synchronizer hub is in the correct installation direction, and put it on the output shaft.
3. Using special tools MD998812, MD998814 and MD998825, install the 1st-2nd speed synchronizer hub with the press.
4. Make sure that the outer synchronizer ring on the 1st speed gear side can rotate freely.

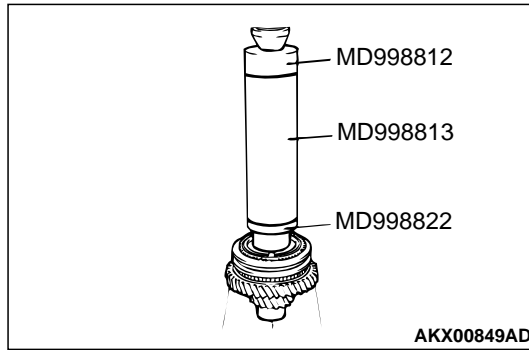


>>F<< SYNCHRONIZER SLEEVE INSTALLATION

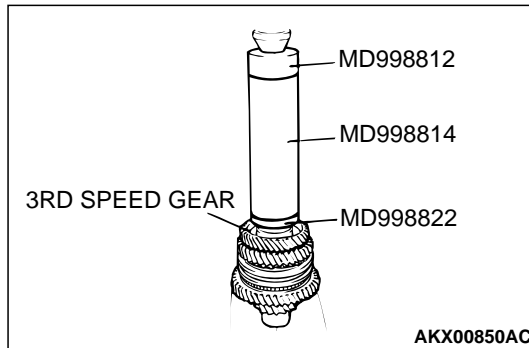
1. Check that the synchronizer sleeve is in the correct direction for installation, and install it on the 1st-2nd speed synchronizer hub.



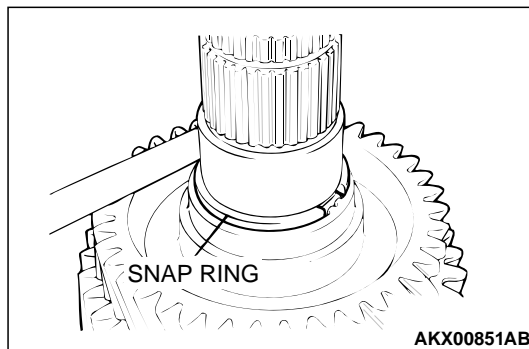
2. Install the synchronizer sleeve so that the areas with teeth that have raised tips (three areas total) are aligned with the areas on the synchronizer hub that have deep grooves between the teeth (three areas total).

**>>G<< 2ND SPEED GEAR SLEEVE INSTALLATION**

1. Set the output shaft on the press support stand.
2. Using special tools MD998812, MD998813 and MD998822, install the 2nd speed sleeve onto the output shaft with the press.

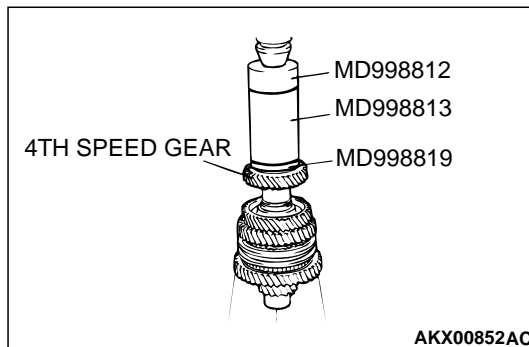
**>>H<< 3RD SPEED GEAR INSTALLATION**

1. Check that the 2nd speed gear and the outer synchronizer ring have been properly installed. Also, make sure the claws on the synchronizer cone (four places) are correctly fitted into the holes in the 2nd speed gear (four places).
2. Using special tools MD998812, MD998814 and MD998822, install the 3rd speed gear onto the output shaft with the press.
3. Make sure that the 2nd speed gear and the outer synchronizer ring can rotate freely.

**>>I<< SNAP RING INSTALLATION**

1. Install the thickest snap ring that can be fitted in the groove of output shaft.
2. Make sure that the 3rd speed gear end play meets the standard value.

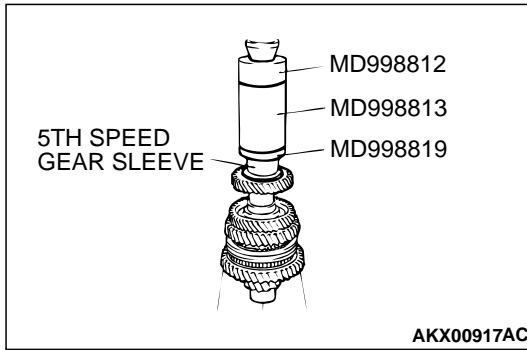
Standard value: 0 – 0.09 mm (0 – 0.0035 inch)

>>J<< 4TH SPEED GEAR INSTALLATION

1. Set the output shaft on the press support stand.
2. Using special tools MD998812, MD998813 and MD998819, install the 4th speed gear onto the output shaft with the press.

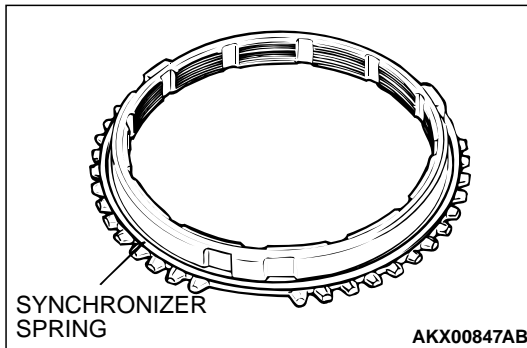
>>K<< 5TH SPEED GEAR SLEEVE INSTALLATION

Using special tools MD998812, MD998813 and MD998819, install the 5th speed gear sleeve onto the output shaft with the press.



>>L<< SYNCHRONIZER SPRING INSTALLATION

Install the synchronizer spring onto the synchronizer ring as shown.



>>M<< SYNCHRONIZER RING INSTALLATION

⚠ CAUTION

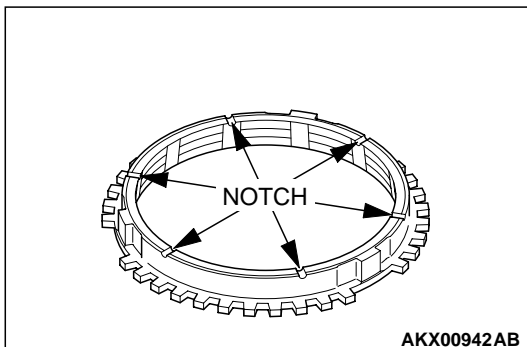
There is a 5th speed synchronizer ring and a reverse synchronizer ring. Be careful not to confuse the two when installing, as a mistake can effect the shift feeling.

1. Check for the presence of identification notches on the synchronizer ring.

No notches: 5th speed synchronizer ring

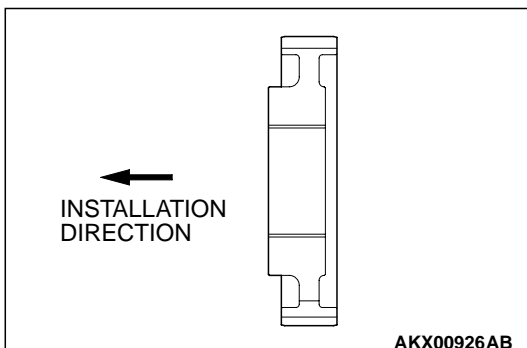
Six notches: Reverse synchronizer ring

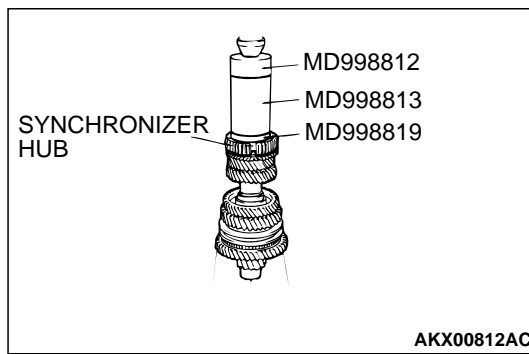
2. Install the synchronizer ring so that it fits completely over the machined cone of the gear.



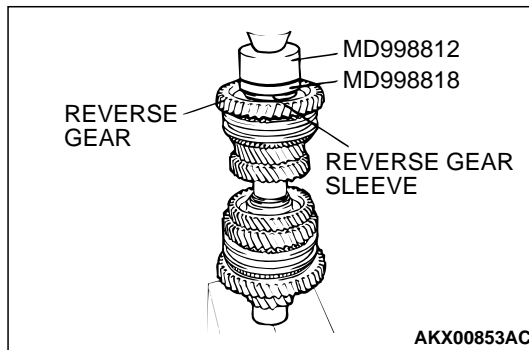
>>N<< 5TH SPEED-REVERSE SYNCHRONIZER HUB INSTALLATION

1. Set the output shaft on the press support stand.
2. Make sure that the synchronizer ring is fitted correctly on the cone of the 5th speed gear.
3. Check that the 5th speed-reverse synchronizer hub is oriented correctly for installation, and fit it on the output shaft.



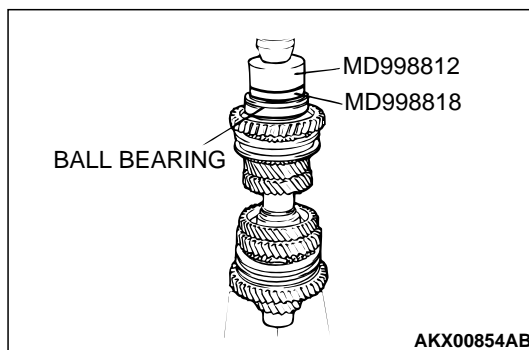


- Using special tools MD98812, MD998813 and MD998819, press install the 5th speed-reverse synchronizer hub with the press.
- Make sure that the synchronizer ring on the 5th speed gear side can rotate freely.



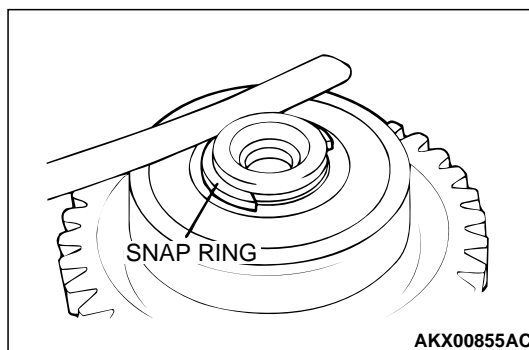
>>O<< REVERSE GEAR SLEEVE INSTALLATION

- Make sure the synchronizer ring, reverse gear and needle roller bearing have been correctly installed.
- Using special tools MD998812 and MD998818, press fit the reverse gear sleeve. Make sure that the reverse gear and the synchronizer ring can rotate freely during the pressing process.



>>P<< BALL BEARING INSTALLATION

- Check the installation direction of the ball bearing.
- Using special tools MD998812 and MD998818, install the ball bearing with the press.



>>Q<< SNAP RING INSTALLATION

- Install the thickest snap ring that can be fitted in the groove of output shaft.
- Make sure that the ball bearing end play meets the standard value.

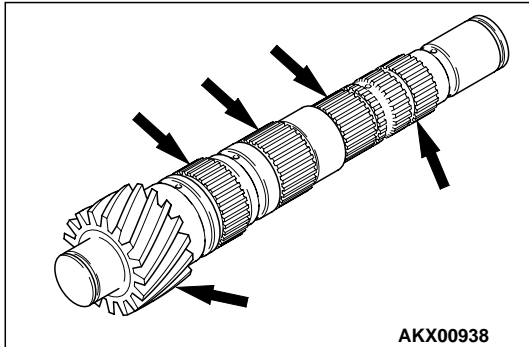
Standard value: 0 – 0.09 mm (0 – 0.0035 inch)

INSPECTION

M1222002300120

OUTPUT SHAFT

1. Check the splines for damage and wear.
2. Check that the helical gear teeth surfaces are not damaged or worn.

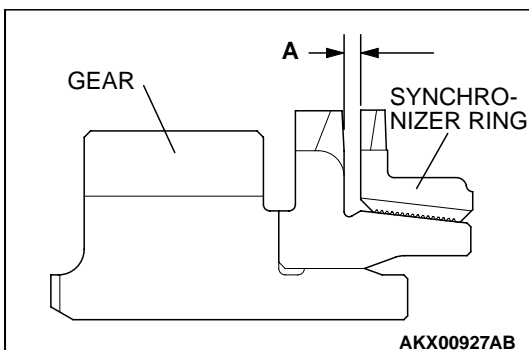
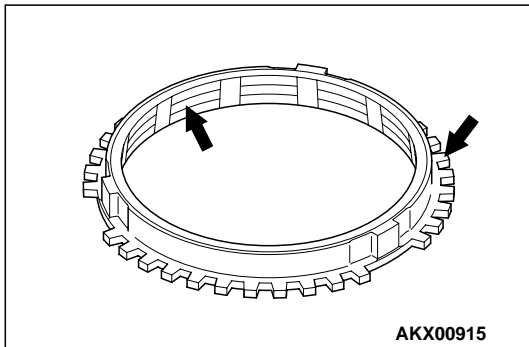


NEEDLE ROLLER BEARING

1. Combine the needle roller bearing with the bearing sleeve and gear, and check that it rotates smoothly without noise or play.
2. Check the needle roller bearing cage for deformation.

SYNCHRONIZER RING

1. Check if the clutch gear teeth are damaged or broken.
2. Check internal surface for damage, wear and broken threads.



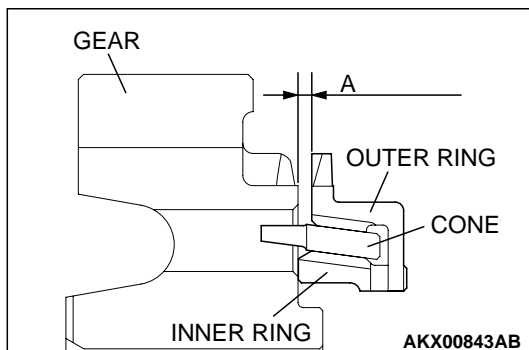
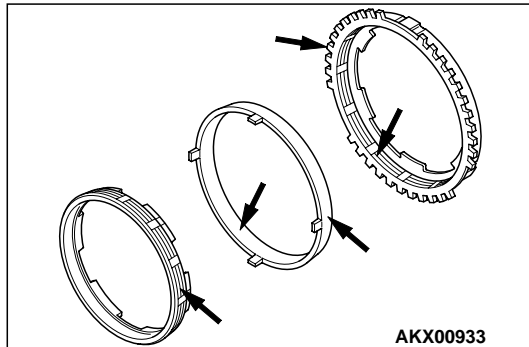
3. Force the synchronizer ring toward the clutch gear and check clearance "A." If "A" is less than the limit, replace the synchronizer ring.

Minimum limit: 0.5 mm (0.020 inch)

OUTER SYNCHRONIZER RING/INNER SYNCHRONIZER RING/SYNCHRONIZER CONE <FOR F5M42-1 2ND SPEED>**⚠ CAUTION**

When replacing, replace the outer ring, inner ring and cone as a set.

1. Check that the clutch gear tooth surfaces and cone surfaces are not damaged or broken.



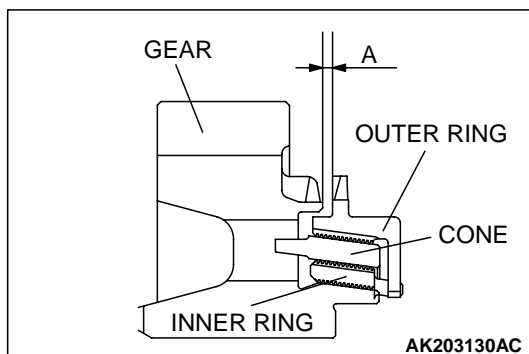
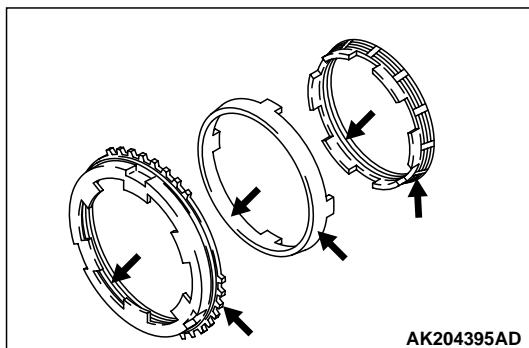
2. Install the outer ring, inner ring and cone, force them toward the gear, and check clearance "A." If "A" is less than the limit, replace them as a set.

Minimum limit: 0.5 mm (0.020 inch)

OUTER SYNCHRONIZER RING/INNER SYNCHRONIZER RING/SYNCHRONIZER CONE**⚠ CAUTION**

When replacing, replace the outer ring, inner ring and cone as a set.

1. Check that the clutch gear tooth surfaces and cone surfaces are not damaged or broken.

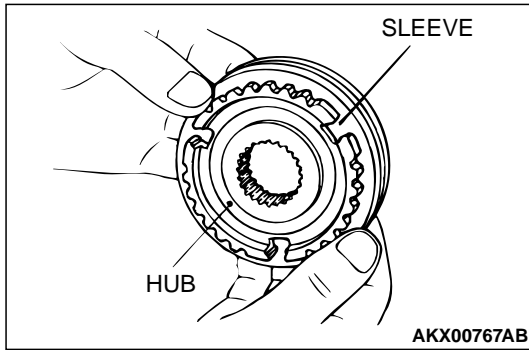


2. Install the outer ring, inner ring and cone, force them toward the gear, and check clearance "A." If "A" is less than the limit, replace them as a set.

Minimum limit: 0.5 mm (0.020 inch)

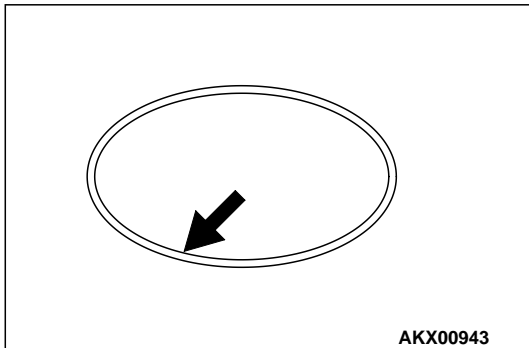
SYNCHRONIZER SLEEVE AND HUB

1. Combine the synchronizer sleeve and hub, and check that they slide smoothly.
2. Check that the sleeve is free from damage at its inside splines ends.



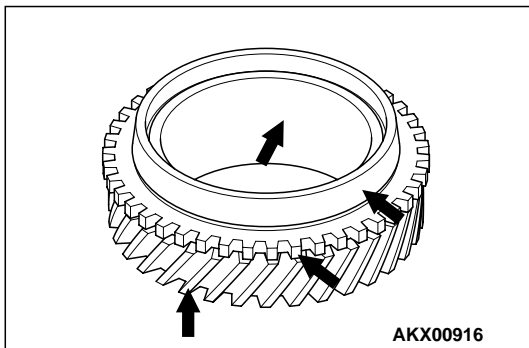
SYNCHRONIZER SPRING

Check that the spring is not sagging, deformed or broken.



SPEED GEARS

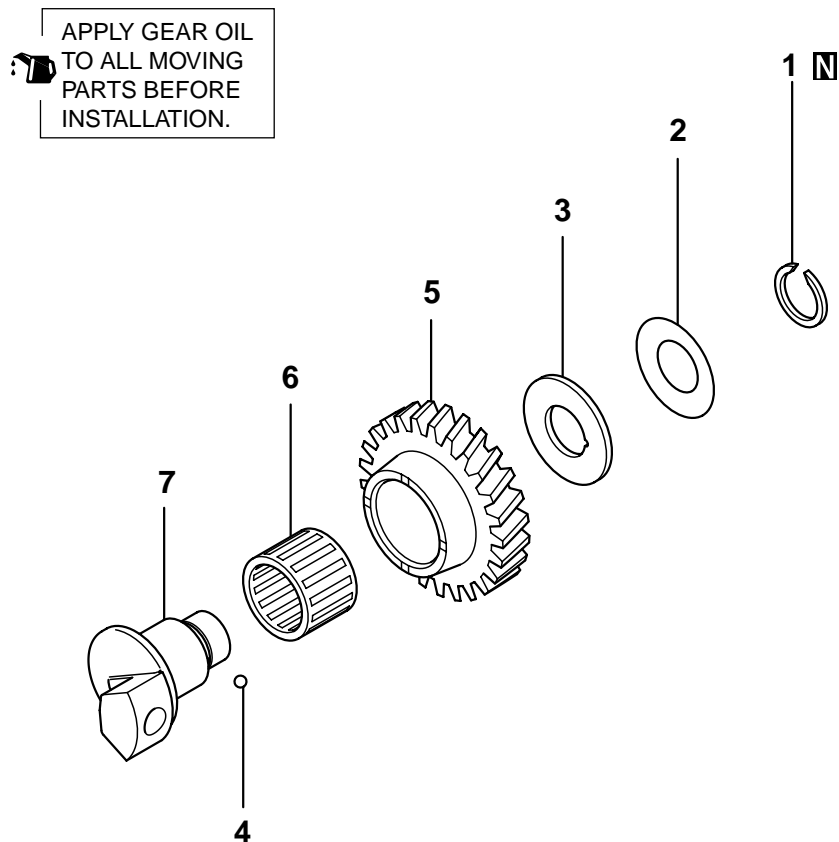
1. Check that the helical and clutch gear tooth surfaces are not damaged or worn.
2. Check that the synchronizer cone surfaces are not roughened, damaged or worn.
3. Check that the gear inside diameter and front and rear surfaces are not damaged and worn.



REVERSE IDLER GEAR

DISASSEMBLY AND ASSEMBLY

M1222012500114



AK000202AB

DISASSEMBLY STEPS

1. SNAP RING
2. CONE SPRING
3. THRUST WASHER
4. STEEL BALL

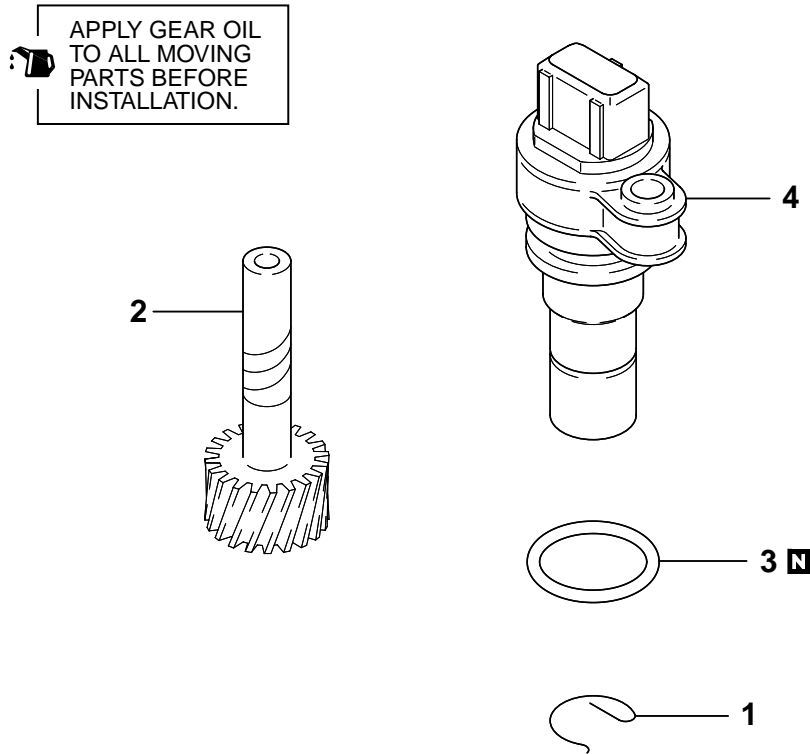
DISASSEMBLY STEPS

5. REVERSE IDLER GEAR
6. NEEDLE ROLLER BEARING
7. REVERSE IDLER GEAR SHAFT

SPEEDOMETER GEAR

DISASSEMBLY AND ASSEMBLY

M1222003400119



AKX00804AB

DISASSEMBLY STEPS

1. E-CLIP
2. SPEEDOMETER DRIVEN GEAR

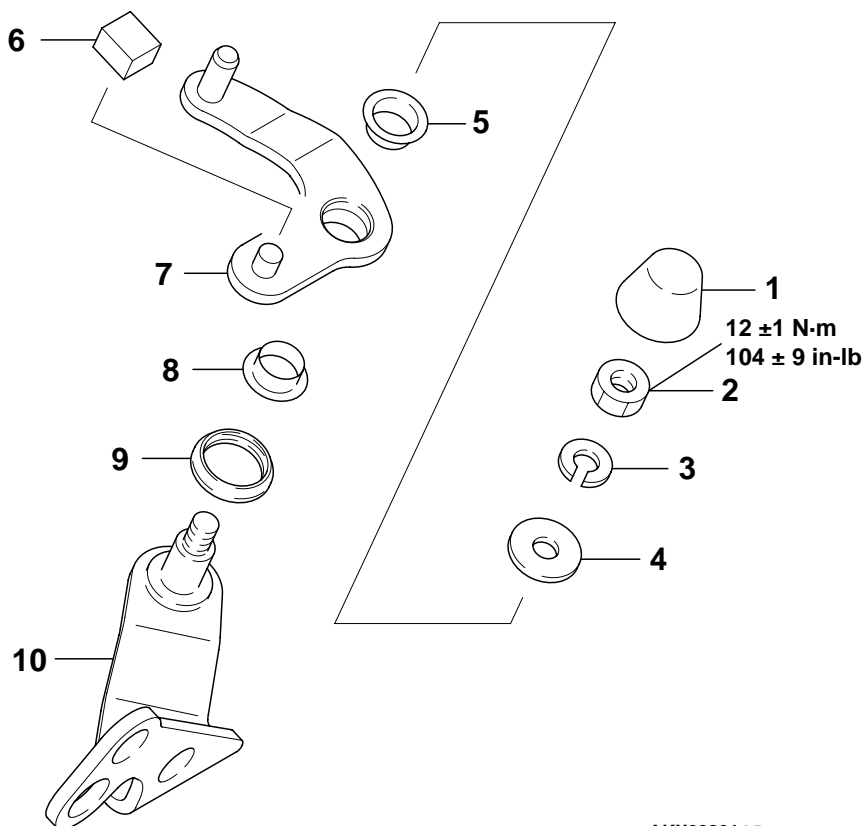
DISASSEMBLY STEPS

3. O-RING
4. SLEEVE

SELECT LEVER

DISASSEMBLY AND ASSEMBLY

M1222012800104



AKX00801AB

DISASSEMBLY STEPS

1. DUST COVER
 2. NUT
 3. SPRING WASHER
 4. WASHER
 5. SELECT LEVER BUSHING
- >>A<<

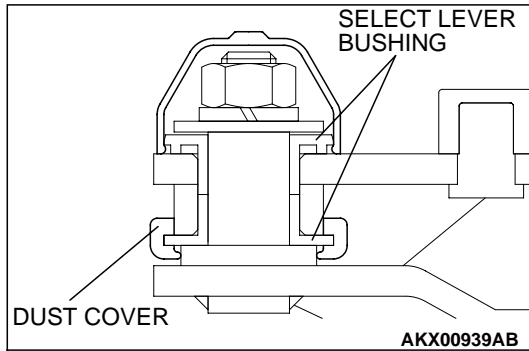
DISASSEMBLY STEPS

6. SELECT LEVER SHOE
 7. SELECT LEVER
 8. SELECT LEVER BUSHING
 9. DUST COVER
 10. SELECT LEVER SHAFT
- >>A<<

ASSEMBLY SERVICE POINT

>>A<< DUST COVER AND SELECT LEVER BUSHING INSTALLATION

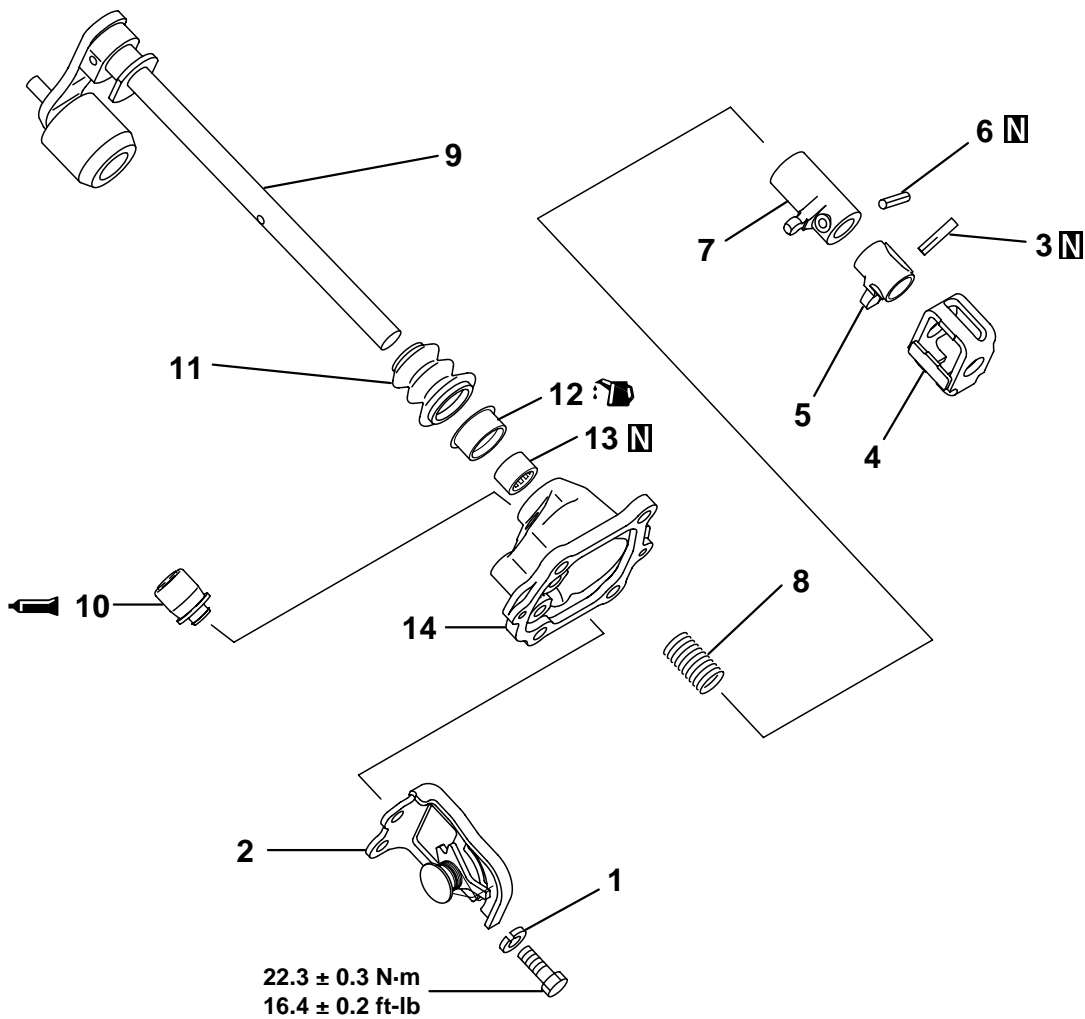
Make sure the dust cover and select lever bushing installation direction is correct, and the distinguished parts are correctly assembled as shown.



CONTROL HOUSING

DISASSEMBLY AND ASSEMBLY

M1222013100142



AK302355AB

DISASSEMBLY STEPS

DISASSEMBLY STEPS

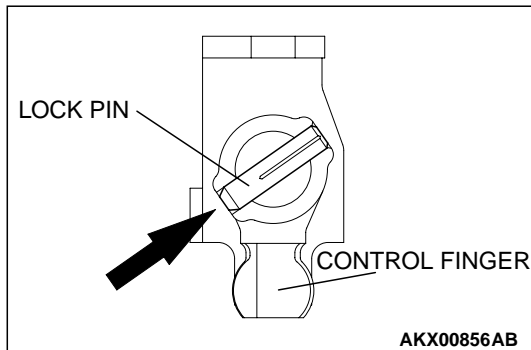
- <<A>> >>E<<
>>D<<
1. SPRING WASHER
2. STOPPER BRACKET
3. LOCK PIN
4. INTERLOCK PLATE
5. CONTROL FINGER
6. SPRING PIN
7. STOPPE BODY

- >>C<<
>>B<<
>>A<<
8. SPRING
9. CONTROL SHAFT
10. AIR BREATHER
11. CONTROL SHAFT BOOT
12. OIL SEAL
13. NEEDLE BEARING
14. CONTROL HOUSING

DISASSEMBLY SERVICE POINT

<<A>> LOCK PIN REMOVAL

Drive out the lock pin from the direction shown.

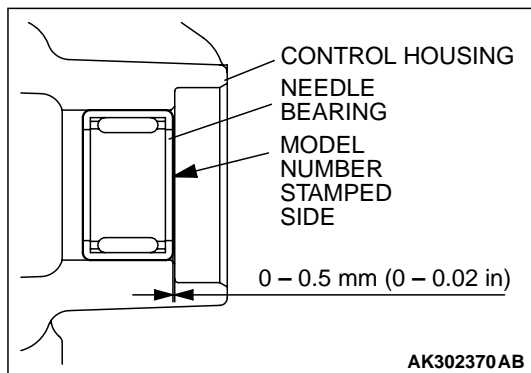


ASSEMBLY SERVICE POINTS

>>A<< NEEDLE BEARING INSTALLATION

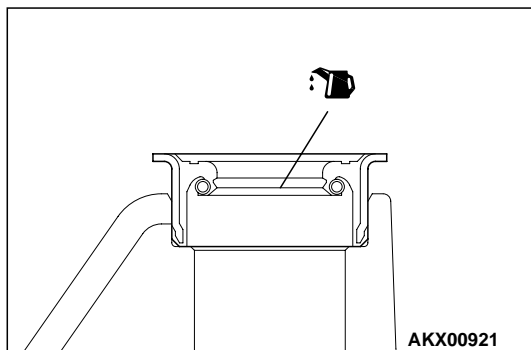
Press fit the needle bearing into the control housing side as shown.

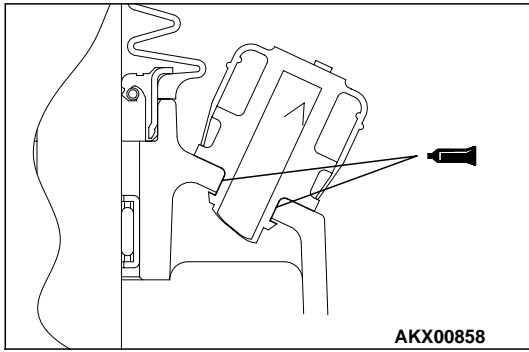
Make sure that the side with the model number stamped on it faces the end of the control housing as shown.



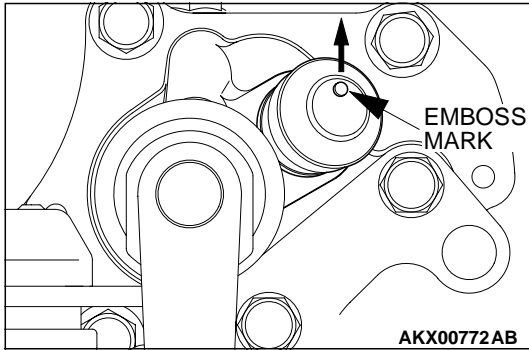
>>B<< OIL SEAL INSTALLATION

Apply gear oil (Hypoid gear oil SAE 75W-90 or 75W-85W conforming to API classification GL-4) to the oil seal lip area.

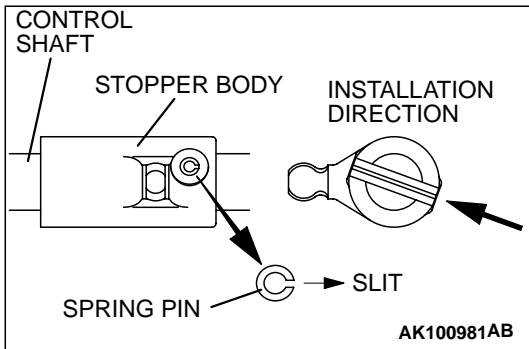


**>>C<< AIR BREATHER INSTALLATION**

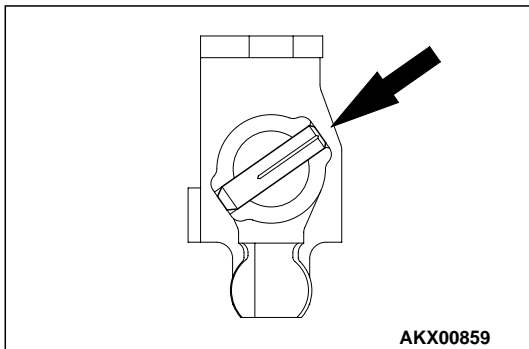
1. Apply sealant (3M™ AAD Part Number 8001 or equivalent) to the inserting portion of air breather.



2. Install the air breather so that the embossed mark is in the direction shown in the figure.

**>>D<< SPRING PIN INSTALLATION**

Drive in the spring pin so that the slit is in the direction shown in the figure.

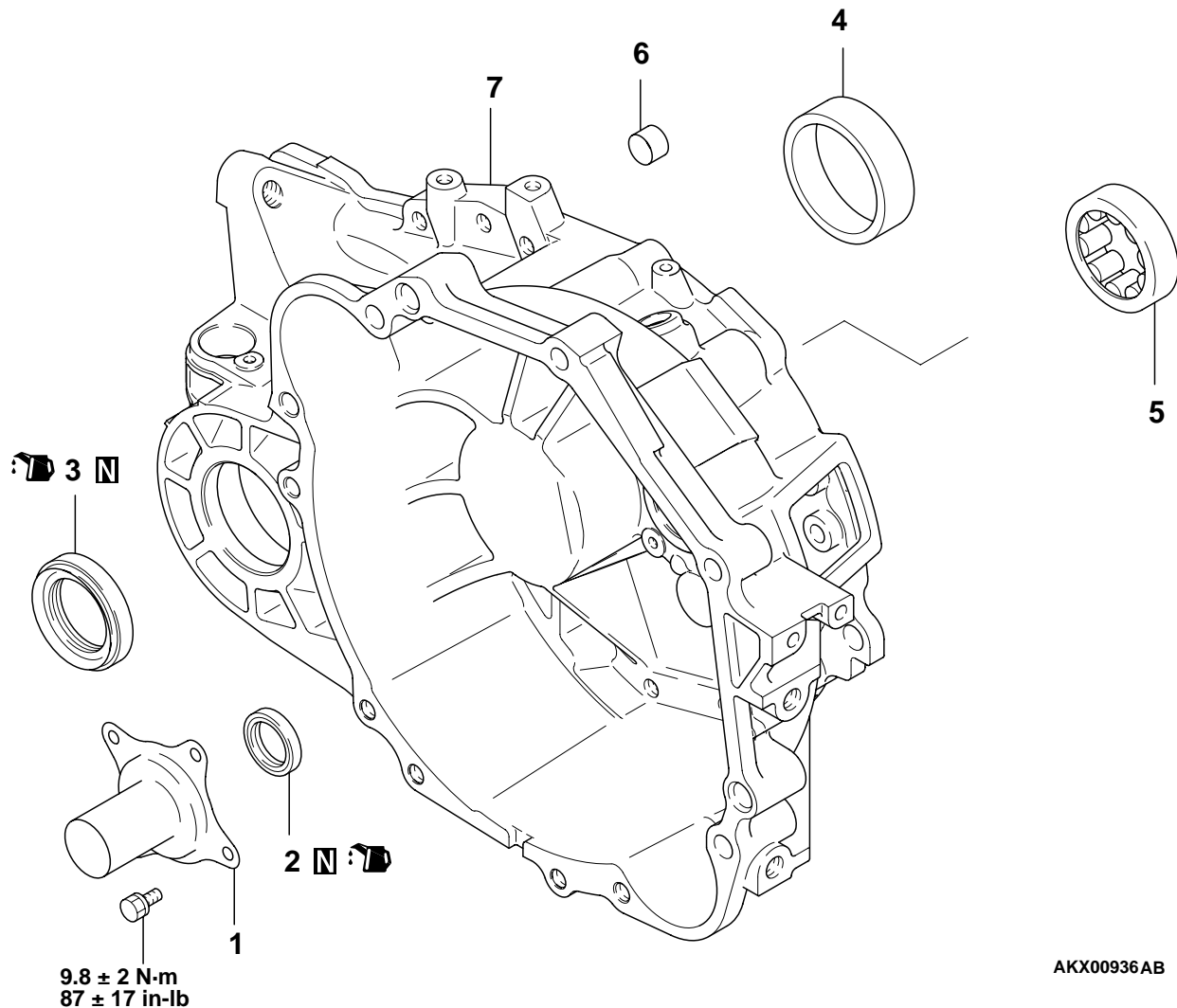
**>>E<< LOCK PIN INSTALLATION**

Drive the lock pin in from the direction shown in the figure.

CLUTCH HOUSING

DISASSEMBLY AND ASSEMBLY

M1222003700143



- DISASSEMBLY STEPS**
1. CLUTCH RELEASE BEARING RETAINER
 2. OIL SEAL
 3. OIL SEAL

<<A>>
<>

>>C<<
>>B<<
>>A<<

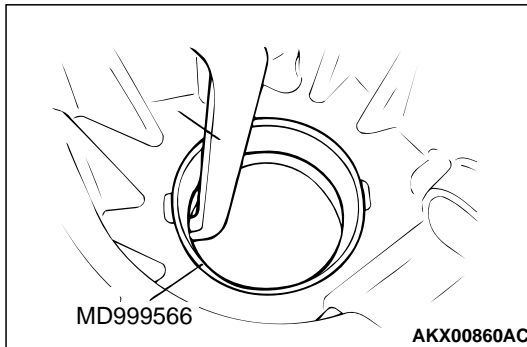
- DISASSEMBLY STEPS**
4. OUTER RACE
 5. OUTER RACE
 6. BUSHING
 7. CLUTCH HOUSING

Required Special Tools:

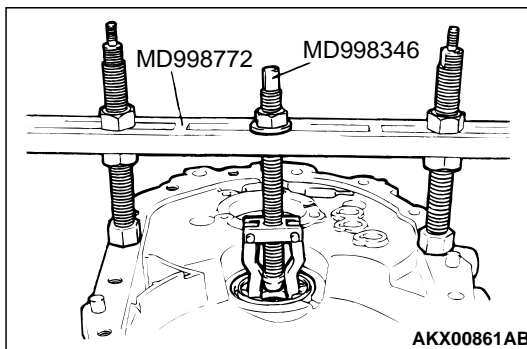
- MB990926: Installer Adapter
- MB990934: Installer Adapter
- MB990935: Installer Adapter
- MB990938: Handle
- MD998325: Differential Oil Seal Installer
- MD998346: Bearing Outer Race Remover
- MD998772: Valve Spring Compressor
- MD999566: Claw

DISASSEMBLY SERVICE POINT**<<A>> OUTER RACE REMOVAL**

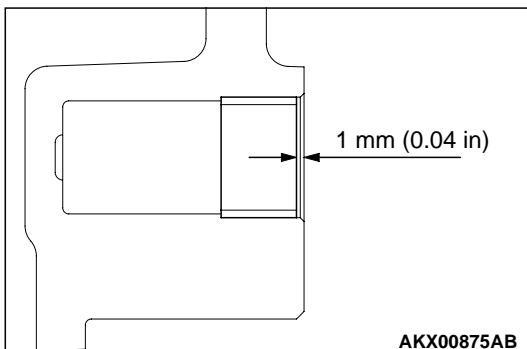
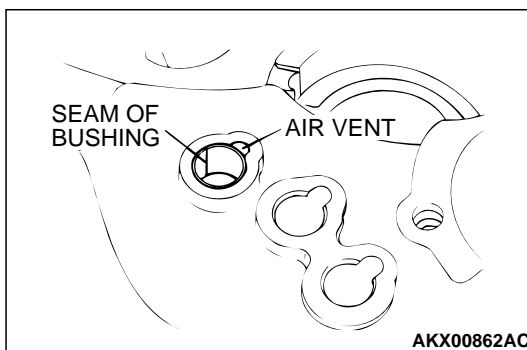
Using special tool MD999566, remove the outer race from the clutch housing.

**<> OUTER RACE REMOVAL**

1. Set special tools MD998772 and MD998346 as indicated in the figure.
2. Turn the nut on special tool MD998346 to pull up on the tool and take out the outer race.

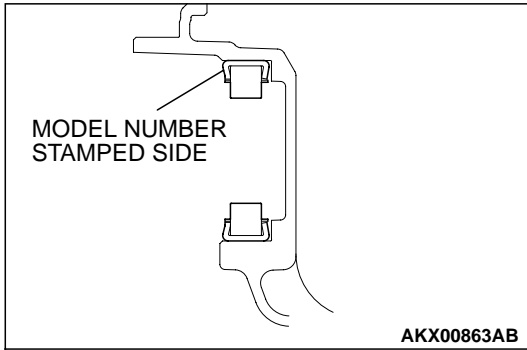
**ASSEMBLY SERVICE POINTS****>>A<< BUSHING INSTALLATION**

1. Press fit the bushing so the seam is away from the air vent.
2. Be sure the bushing is fully seated as shown. It must be 1 mm (0.04 inch) below the housing surface.

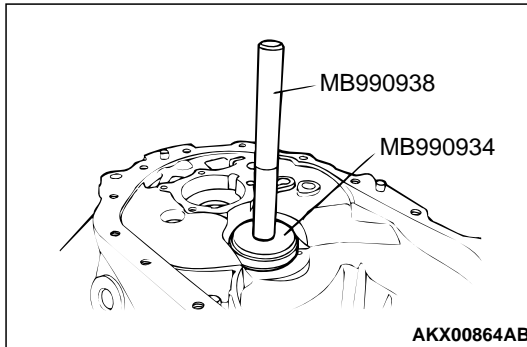


>>B<< OUTER RACE INSTALLATION

1. Check the installation direction of the outer race.
Install the outer race so the side with the model number stamping can be seen.

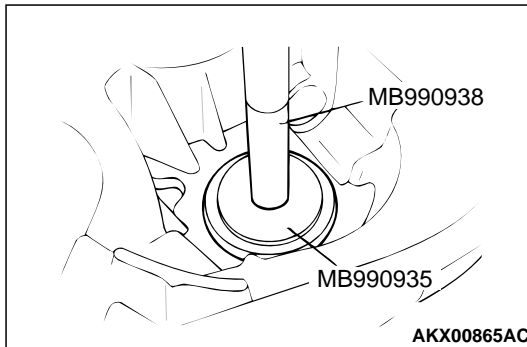


2. Using special tools MB990938 and MB990934, press fit the outer race into the clutch housing.



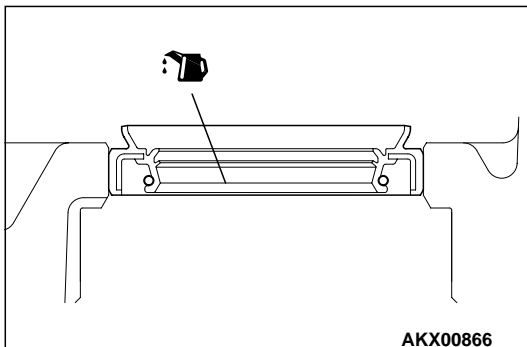
>>C<< OUTER RACE INSTALLATION

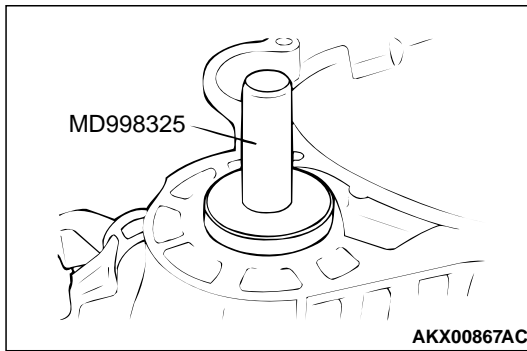
1. Check the installation direction of the outer race.
2. Using special tools MB990938 and MB990935, press fit the outer race into the clutch housing.



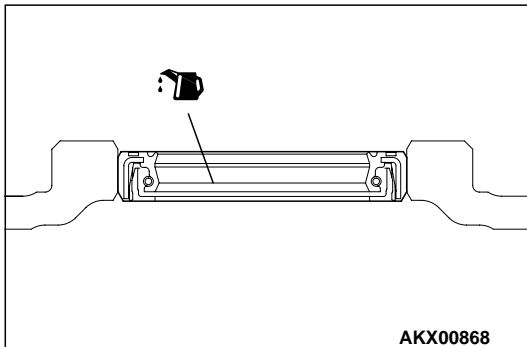
>>D<<OIL SEAL INSTALLATION

1. Apply gear oil (Hypoid gear oil SAE 75W-90 or 75W-85W conforming to API classification GL-4) to the oil seal lip.



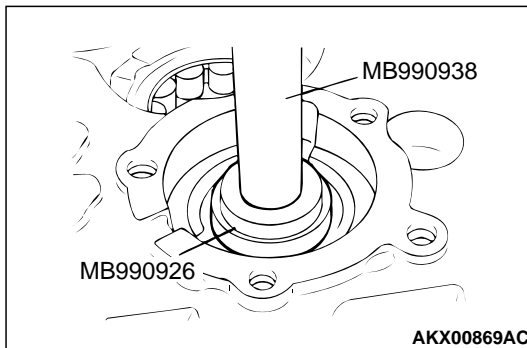


2. Using special tool MD998325, press fit the oil seal into the clutch housing.



>>E<< OIL SEAL INSTALLATION

1. Apply transmission oil (Hypoid gear oil SAE 75W-90 or 75W-85W conforming to API classification GL-4) to the oil seal lip.

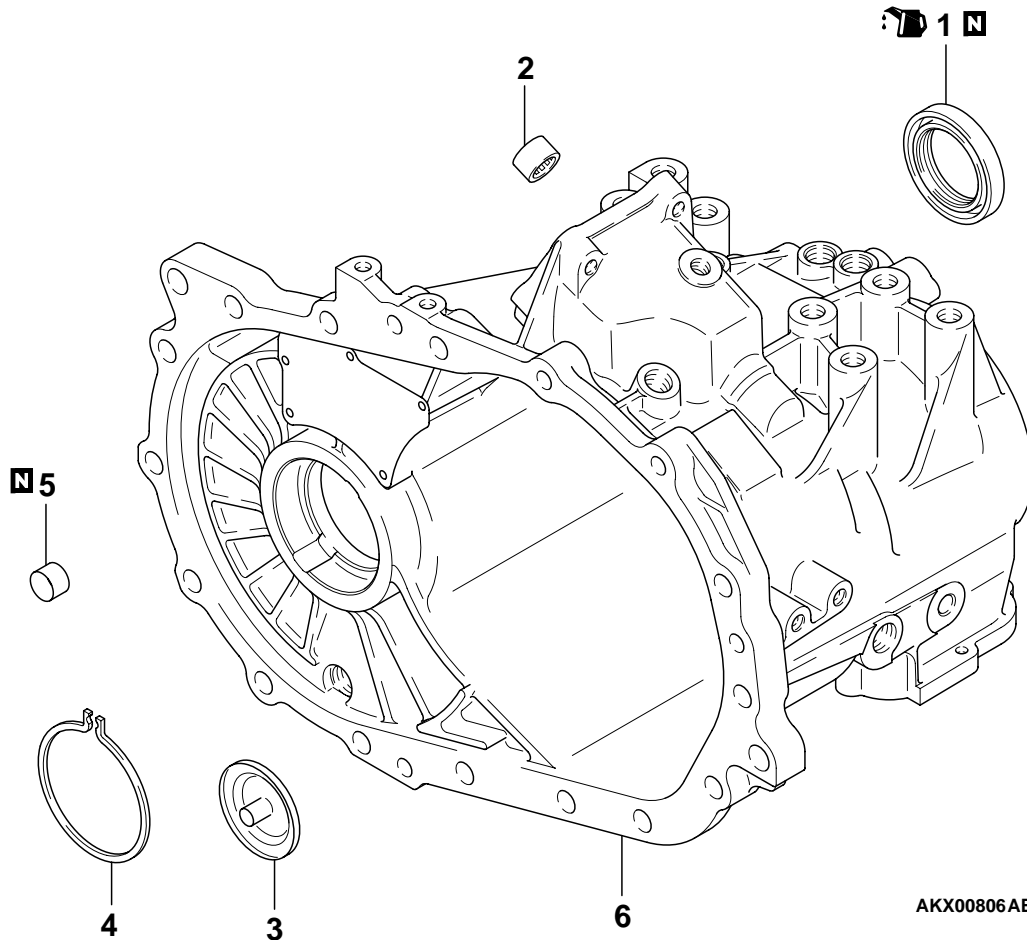


2. Using special tools MB990938 and MB990926, press fit the oil seal into the clutch housing.

TRANSMISSION CASE

DISASSEMBLY AND ASSEMBLY

M1222013400110



AKX00806 AB

DISASSEMBLY STEPS

- >>C<< 1. OIL SEAL
>>B<< 2. NEEDLE BEARING
3. OIL GUIDE

DISASSEMBLY STEPS

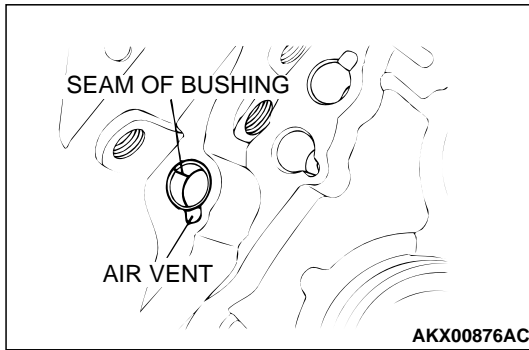
- >>A<< 4. SNAP RING
5. BUSHING
6. TRANSAXLE

Required Special Tool:

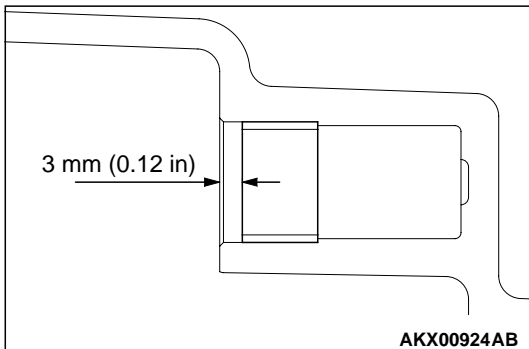
- MD998325: Differential Oil Seal Installer

ASSEMBLY SERVICE POINTS**>>A<< BUSHING INSTALLATION**

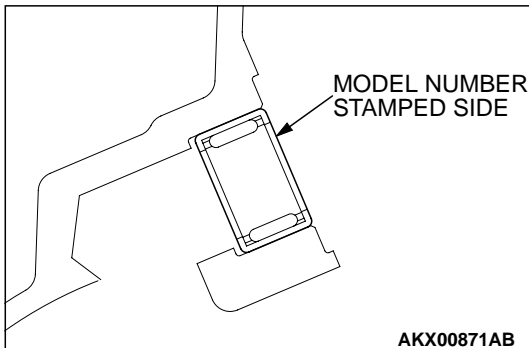
1. Press fit the bushing so the seam is away from the air vent.



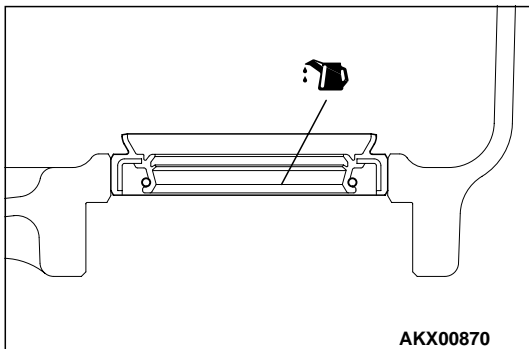
2. Be sure the bushing is fully seated as shown. It must be 3 mm (0.12 inch) below the housing surface.

**>>B<< NEEDLE BEARING INSTALLATION**

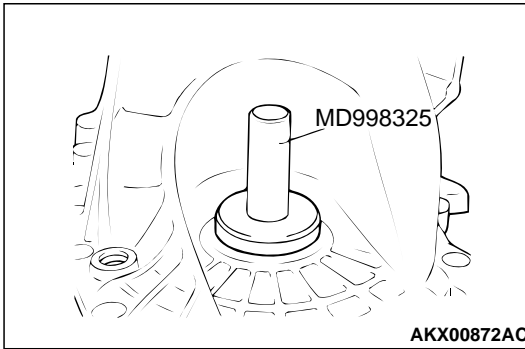
1. Check the installation direction of the needle bearing.
2. Press fit the needle bearing until it is flush with the case.

**>>C<< OIL SEAL INSTALLATION**

1. Apply gear oil (Hypoid gear oil SAE 75W-90 or 75W-85W conforming to API classification GL-4).



2. Using special tool MD998325, press fit the oil seal into the transaxle case.

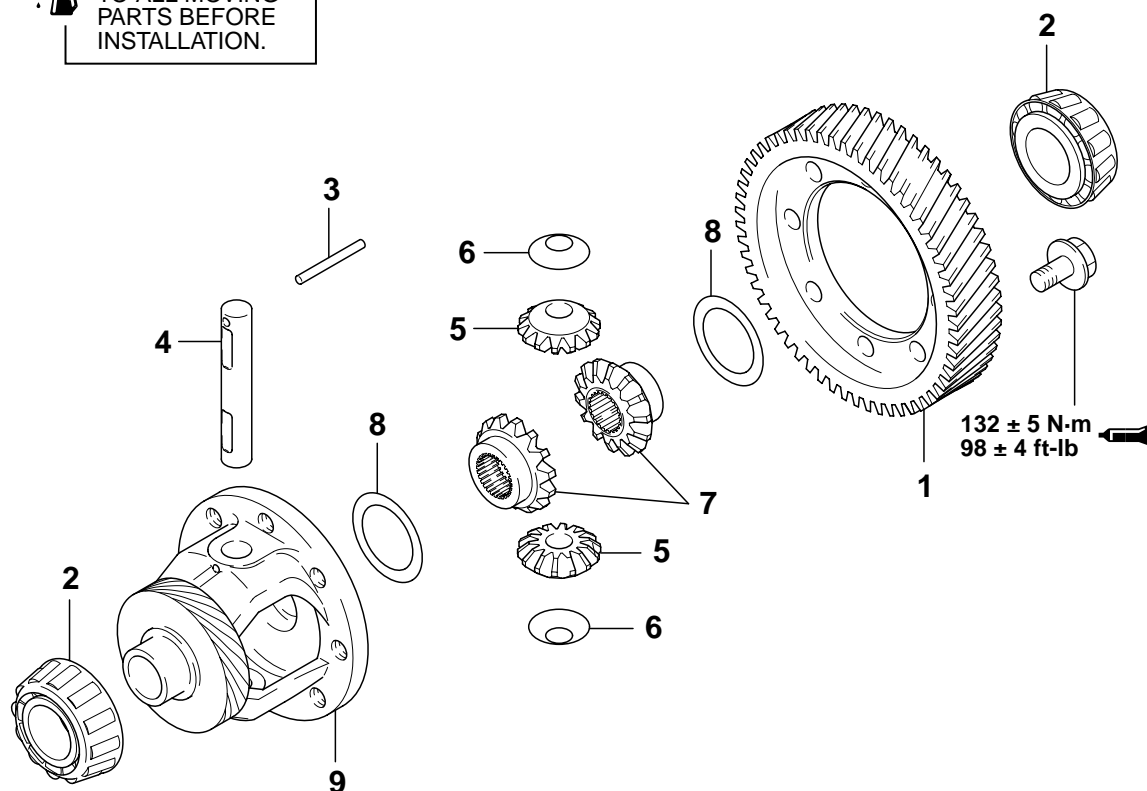


DIFFERENTIAL

DISASSEMBLY AND ASSEMBLY

M1222002500135

APPLY GEAR OIL
TO ALL MOVING
PARTS BEFORE
INSTALLATION.



AKX00771AB

DISASSEMBLY STEPS	
<<A>>	>>D<< 1. DIFFERENTIAL DRIVE GEAR
	>>C<< 2. TAPER ROLLER BEARING
	>>B<< 3. LOCK PIN
	>>A<< 4. PINION SHAFT
	>>A<< 5. PINION

DISASSEMBLY STEPS	
>>A<<	6. WASHER
>>A<<	7. SIDE GEAR
>>A<<	8. SPACER
	9. DIFFERENTIAL CASE

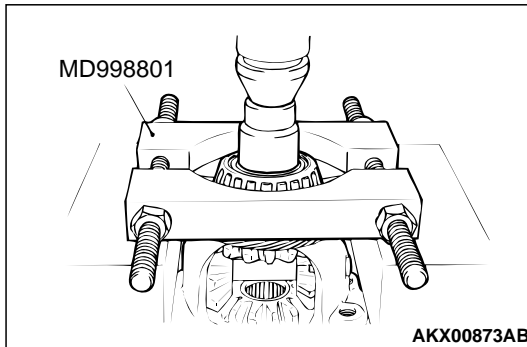
Required Special Tools:

- MD998801: Bearing Remover
- MD998812: Installer Cap
- MD998819: Installer Adapter (40)

DISASSEMBLY SERVICE POINT

<<A>> TAPER ROLLER BEARING REMOVAL

1. Using special tool MD998801, support the taper roller bearing, and then set them on the press.
2. Push down on the differential case with the press and remove the bearing.



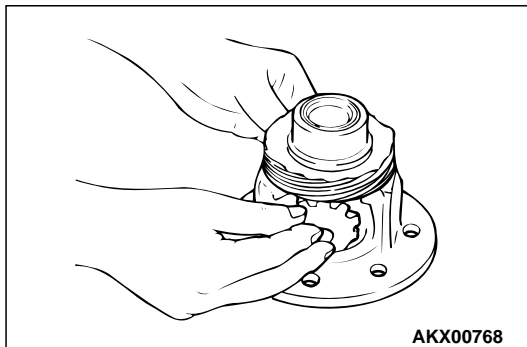
ASSEMBLY SERVICE POINTS

>>A<< SPACER/SIDE GEAR/WASHER/PINION/PINION SHAFT INSTALLATION

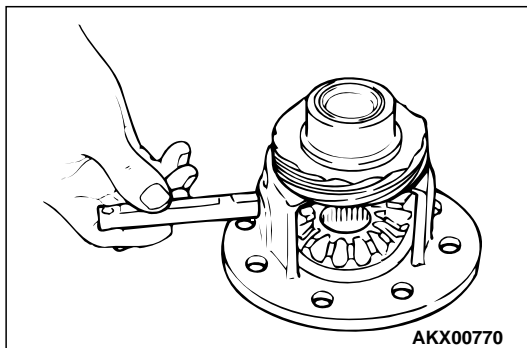
1. After a spacer has been mounted on the back surface of the side gear, install the side gear in the differential case.

NOTE: When a new side gear is to be installed, mount a medium thickness spacer [0.93 – 1.00 mm (0.0366 – 0.0395 inch)].

2. Set the washer on the back of each pinion, and put both pinions simultaneously in mesh with the side gears. While rotating them, install them in position.



3. Insert the pinion shaft.



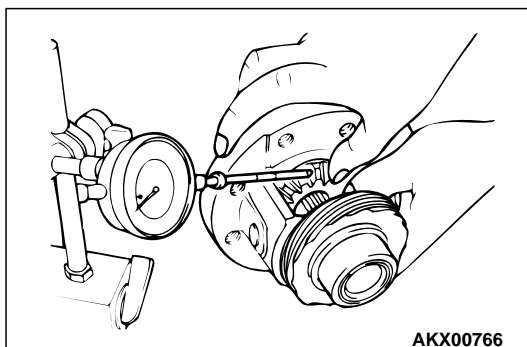
4. Measure the backlash between the side gear and pinion.

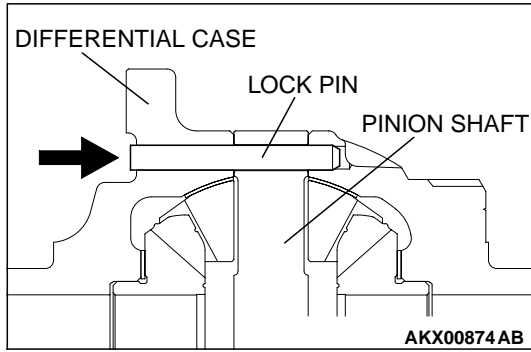
Standard value:

0 – 0.150 mm (0 – 0.0059 inch)

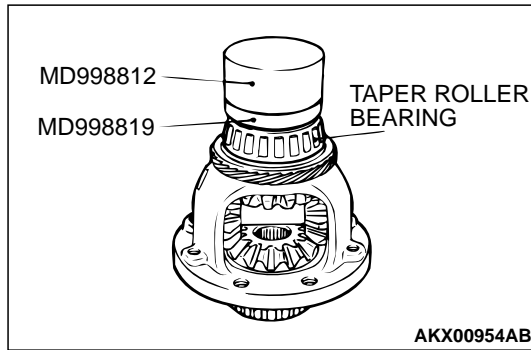
5. If the backlash is out of specification, select a spacer that should get the back lash with in the standard value and re-measure the backlash.

NOTE: Repeat until the backlash on both sides are equal.

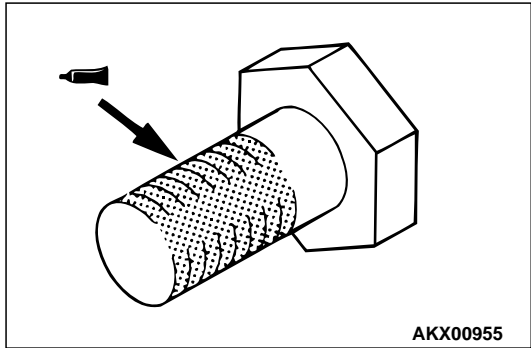


**>>B<< LOCK PIN INSTALLATION**

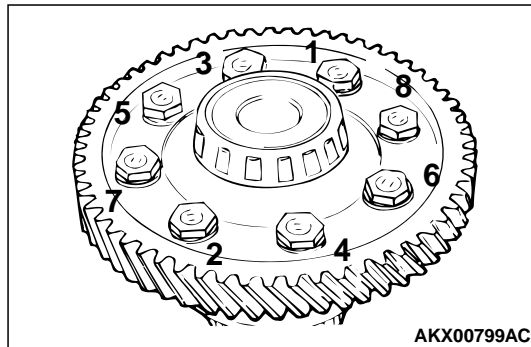
Install the lock pin so that it will be oriented in the direction shown.

**>>C<< TAPER ROLLER BEARING INSTALLATION**

Using special tools MD998812 and MD998819, install the taper roller bearing with the press.

**>>D<< DIFFERENTIAL DRIVE GEAR INSTALLATION**

1. Apply sealant (3M™ AAD Part Number 8730 or 8731 or equivalent) to the entire threaded portion of the bolt.



2. Tighten to the specified torque in the illustrated sequence.

Tightening torque: 132 ± 5 N·m (98 ± 4 ft-lb)

SPECIFICATIONS

FASTENER TIGHTENING SPECIFICATIONS

M1222012100127

ITEMS	SPECIFICATIONS
Roll stopper bracket mounting bolt	$69 \pm 10 \text{ N}\cdot\text{m}$ ($51 \pm 7 \text{ ft}\cdot\text{lb}$)
Shift cable bracket mounting bolt	$19 \pm 3 \text{ N}\cdot\text{m}$ ($14 \pm 2 \text{ ft}\cdot\text{lb}$)
Select lever mounting bolt	$19 \pm 3 \text{ N}\cdot\text{m}$ ($14 \pm 2 \text{ ft}\cdot\text{lb}$)
Speedometer gear mounting bolt	$4.0 \pm 1.0 \text{ N}\cdot\text{m}$ ($35 \pm 9 \text{ in}\cdot\text{lb}$)
Backup light switch	$32 \pm 2 \text{ N}\cdot\text{m}$ ($24 \pm 1 \text{ ft}\cdot\text{lb}$)
Interlock plate bolt	$30 \pm 3 \text{ N}\cdot\text{m}$ ($22 \pm 2 \text{ ft}\cdot\text{lb}$)
Poppet spring	$32 \pm 2 \text{ N}\cdot\text{m}$ ($24 \pm 1 \text{ ft}\cdot\text{lb}$)
Control housing mounting bolt	$19 \pm 3 \text{ N}\cdot\text{m}$ ($14 \pm 2 \text{ ft}\cdot\text{lb}$)
Under cover mounting bolt	$7.0 \pm 1.0 \text{ N}\cdot\text{m}$ ($61 \pm 9 \text{ in}\cdot\text{lb}$)
Reverse idler gear shaft mounting bolt	$48 \pm 6 \text{ N}\cdot\text{m}$ ($35 \pm 4 \text{ ft}\cdot\text{lb}$)
Clutch housing-transaxle case mounting bolt	$44 \pm 5 \text{ N}\cdot\text{m}$ ($33 \pm 4 \text{ ft}\cdot\text{lb}$)
Front bearing retainer mounting bolt	$19 \pm 3 \text{ N}\cdot\text{m}$ ($14 \pm 2 \text{ ft}\cdot\text{lb}$)
Select lever mounting nut	$12 \pm 1 \text{ N}\cdot\text{m}$ ($104 \pm 9 \text{ in}\cdot\text{lb}$)
Stopper bracket mounting bolt	$22.3 \pm 0.3 \text{ N}\cdot\text{m}$ ($16.1 \pm 0.2 \text{ ft}\cdot\text{lb}$)
Clutch release bearing retainer mounting bolt	$9.8 \pm 2 \text{ N}\cdot\text{m}$ ($87 \pm 17 \text{ in}\cdot\text{lb}$)
Differential drive gear mounting bolt	$132 \pm 5 \text{ N}\cdot\text{m}$ ($98 \pm 4 \text{ ft}\cdot\text{lb}$)

GENERAL SPECIFICATIONS

M1222000200183

ITEMS		SPECIFICATIONS		
Model		F5M42-1-F7B3	F5M42-1-F8B4	F5M42-2-R7B5
Applicable engine		4G94		4G69
Type		5-speed transaxle floor shift		
Gear ratio	1st	3.583		
	2nd	1.947		
	3rd	1.379		
	4th	1.030		
	5th	0.767		0.820
	Reverse	3.363		
Final reduction ratio		3.722		4.058
Speedometer gear ratio (driven/drive)		30/36	31/36	30/36

SERVICE SPECIFICATIONS

M1222000300157

ITEMS	STANDARD VALUE	MINIMUM LIMIT
Input shaft front bearing end play mm (in)	0 – 0.12 (0 – 0.0047)	–
Input shaft rear bearing end play mm (in)	0 – 0.12 (0 – 0.0047)	–
Input shaft 5th speed gear end play mm (in)	0 – 0.09 (0 – 0.0035)	–
Output shaft roller bearing inner race end play mm (in)	0 – 0.12 (0 – 0.0047)	–
Output shaft ball bearing end play mm (in)	0 – 0.09 (0 – 0.0035)	–
Output shaft 3rd speed gear end play mm (in)	0 – 0.09 (0 – 0.0035)	–
Differential pinion backlash mm (in)	0 – 0.150 (0 – 0.0059)	–
Differential case preload mm (in)	0.05 – 0.11 (0.0020 – 0.0043)	–
Synchronizer ring back surface to gear clearance mm (in)	–	0.5 (0.020)

SEALANTS AND ADHESIVES

M1222000500140

ITEM	SPECIFIED SEALANT
Clutch housing-transaxle case mating surface	MITSUBISHI Genuine sealant part No. MD997740 or equivalent
Control housing-transaxle case mating surface	
Under cover-transaxle case mating surface	
Air breather	3M™ AAD Part No.8001 or equivalent
Differential drive gear bolt	3M™ AAD Part No.8730 or 8731 or equivalent

LUBRICANTS

M1222000400110

ITEMS	SPECIFIED SEALANTS
Driveshaft oil seal lip gear oil	Hypoid gear oil SAE 75W-90 or 75W-85W conforming to API classification GL-4
Input shaft oil seal lip gear oil	
Control shaft oil seal lip gear oil	
Select lever shoe	MITSUBISHI genuine grease part No.0101011 or equivalent

SNAP RINGS, SPACERS AND THRUST PLATE FOR ADJUSTMENT

M1222012000164

Snap ring

(For adjustment of input shaft front bearing end play)

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
2.24 (0.0882)	None	2.38 (0.0937)	Brown
2.31 (0.0909)	Blue		

Snap ring

(For adjustment of input shaft rear bearing end play)

(For adjustment of output shaft front bearing end play)

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
1.43 (0.0563)	Green (2)	1.59 (0.0626)	Yellow (2)
1.51 (0.0594)	White (2)		

Thrust plate

(For adjustment of input shaft 5th speed gear end play)

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
2.82 (0.1110)	0	2.98 (0.1173)	6
2.86 (0.1126)	2	3.02 (0.1189)	7
2.90 (0.1142)	3	3.06 (0.1205)	8
2.94 (0.1157)	5	3.10 (0.1220)	9

Snap ring

(For adjustment of output shaft 3rd speed gear end play)

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
2.81 (0.1106)	Green	2.97 (0.1169)	Orange
2.85 (0.1122)	White	3.01 (0.1185)	Red
2.89 (0.1138)	Yellow	3.05 (0.1201)	Pink
2.93 (0.1154)	Black	3.09 (0.1217)	Blue

Snap ring

(For adjustment of output shaft rear bearing end play)

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
2.31 (0.0909)	Black (2)	2.55 (0.1004)	Yellow
2.35 (0.0925)	None	2.59 (0.1020)	Black
2.39 (0.0941)	Blue	2.63 (0.1035)	Orange
2.43 (0.0957)	Brown	2.67 (0.1051)	Blue
2.47 (0.0972)	Green	2.71 (0.1067)	Brown
2.51 (0.0988)	White		

Spacer**(For adjustment of differential case preload)**

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
0.71 (0.0279)	71	1.01 (0.0398)	01
0.74 (0.0292)	74	1.04 (0.0409)	04
0.77 (0.0303)	77	1.07 (0.0421)	07
0.80 (0.0315)	80	1.10 (0.0433)	J
0.83 (0.0327)	83	1.13 (0.0445)	D
0.86 (0.0339)	86	1.16 (0.0457)	K
0.89 (0.0350)	89	1.19 (0.0469)	L
0.92 (0.0362)	92	1.22 (0.0480)	G
0.95 (0.0374)	95	1.25 (0.0492)	M
0.98 (0.0386)	98		

Spacer**(For adjustment of differential case backlash) <F5M42-1>**

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
0.72 – 0.79 (0.0283 – 0.0311)	–	0.98 – 1.02 (0.0386 – 0.0402)	–
0.80 – 0.84 (0.0315 – 0.0331)	–	1.02 – 1.06 (0.0402 – 0.0417)	–
0.85 – 0.90 (0.0335 – 0.0354)	–	1.07 – 1.11 (0.0421 – 0.0437)	–
0.90 – 0.94 (0.0354 – 0.0370)	–	1.12 – 1.16 (0.0441 – 0.0457)	–
0.94 – 0.98 (0.0370 – 0.0386)	–	1.16 – 1.20 (0.0457 – 0.0472)	–

Spacer**(For adjustment of differential case backlash) <F5M42-2>**

THICKNESS mm (in)	IDENTIFICATION SYMBOL	THICKNESS mm (in)	IDENTIFICATION SYMBOL
0.75 – 0.82 (0.0295 – 0.0322)	–	1.05 – 1.12 (0.0412 – 0.0441)	–
0.83 – 0.92 (0.0327 – 0.0362)	–	1.09 – 1.16 (0.0429 – 0.0457)	–
0.93 – 1.00 (0.0366 – 0.0394)	–	1.15 – 1.22 (0.0453 – 0.0480)	–
1.01 – 1.08 (0.0398 – 0.0425)	–		