

## Section E (Transaxle)

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**TO RE-ASSEMBLE GEARBOX**

Use only Hylomar jointing compound and clean faces with carbon tetrachloride. **DO NOT SCRAPE.**

Assemble pinion shaft to hypoid casing and support pinion on 2 in. (5 cm) packing block.

Fit 1st (selective) washer (60, Fig. 2).

Fit 1st speed gear and bush (61/63).

Fit 1st speed baulk ring (62).

Fit 2nd (non-selective) washer (64).

The reverse selector shaft (79), 1st/2nd selector shaft (80) and the 1st/2nd synchro hub assembly (65) are fitted as a complete assembly. (See Fig. 19.) For units fitted with short selector shafts see page 29.

Guide the two selector shafts into the holes in the hypoid casing as the synchro hub is fitted to the shaft. (See Fig. 19.) Make sure the lugs on the baulk ring engage with the slots in the hub.

Fit the 2nd gear, baulk ring and bush (68/67/66). The two small slots in the bush face upwards with one slot in line with the keyway in the shaft.

Fit the 3rd (selective) washer (69). Fit the two bush pegs through the washer and into the slots in the 2nd gear bush.

Fit the 3rd speed bush (72). The two small slots in the bush engage the two bush pegs. The large slot must be in line with the keyway.

Fit the key to the keyway in the shaft (59).

Fit the 3rd speed gear and baulk ring (70/71).

The 3rd/4th synchro hub (73) and the 3rd/4th selector shaft and fork (77) are fitted as an assembly.

Guide the selector shaft into the hole in the hypoid casing as the synchro hub is fitted to the shaft. (See Fig. 18.)

Make sure the lugs on the baulk rings engage with the slots in the hubs. Fit 4th speed baulk ring (75).

Fit the 4th speed bush (74). The slot in the bush engages with the key. If the pinion bearing, synchro hub, or gearwheel bushes have been renewed, it will be necessary at this stage to re-select the 4th (selective) washer (57), as follows:—

Fit the dummy 4th speed washer (part of Tool No. RG365) onto the shaft, place the previously selected pre-load washer on top, and then the bearing.

Keeping the pre-load washer pressed against the shoulder on the shaft, measure with feeler gauges, the clearance between the dummy washer and the pre-load washer (See Fig. 32).



**Fig. 32.** Re-select 4th speed washer

Used bushes must be rebuilt with .002 in.-.006 in. (.0508-.1524 mm) compression allowance (crush).

NEW bushes are fitted with .006 in.-.010 in. (.1524-.2540 mm) compression allowance (crush).

The thickness of the washer required is equal to the size of the feeler, plus the thickness of the dummy washer (Part of Tool RG365), plus the crush amount.

**NOTE.** The size of the dummy washer must be checked before use, as the dimension can vary from .198 in.-.202 in. (5-5.13 mm).

Select the correct washer from the table.