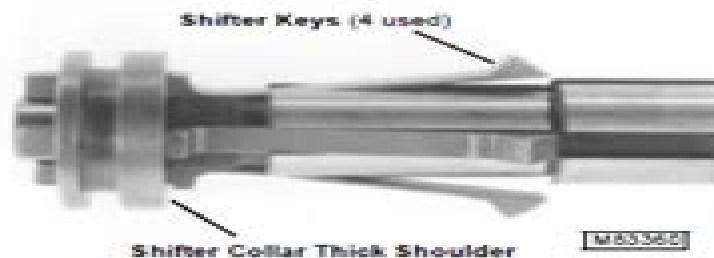


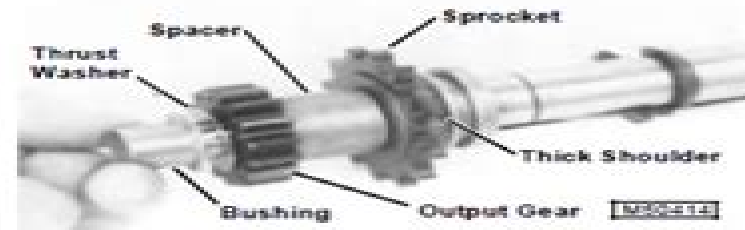
7. Insert thrust washers behind each pinion gear. Slide pinion shaft through differential carrier housing, thrust washers and pinion gears.
8. Install rolled pin to fasten pinion shaft to housing.



9. Install loose-fit outer bushings and ball bearings.



10. Position keys in keyways near end of shifter shaft and hold in place with heavy rubber band or plastic tie strap that can be cut when finished. Install shifter collar over key tabs with thicker shoulder of collar toward center of shaft. Slide collar and keys onto center of shaft.



11. Install reverse sprocket with thicker shoulder toward shifter collar.
12. Install spacer, output gear, thrust washer and bushing.



13. Install thrust washers and spur gears on shaft from brake splines end with raised side of thrust washers toward shoulder of shaft. Flat side of gears **MUST BE** toward shoulder.



14. Put protective tape over brake splines to protect new seal from being damaged. Install thrust washer, bushing and square cut seal.

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Victor M. Corman



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