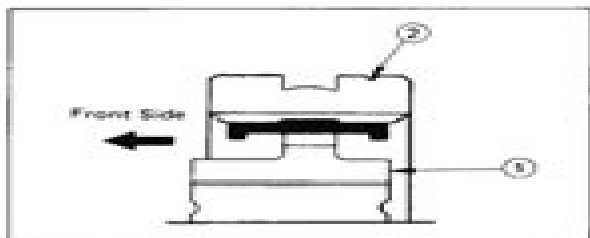


### Important Operations

#### 2. Needle Bearing

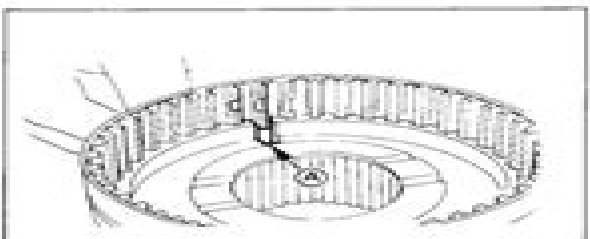
#### 3. 2nd Gear

- 1) Apply engine oil to the needle bearing and the 2nd gear thrust surfaces.
- 2) Install the needle bearing and the 2nd gear to the mainshaft.  
The dog teeth of the 2nd gear must be facing the rear side of the transmission.



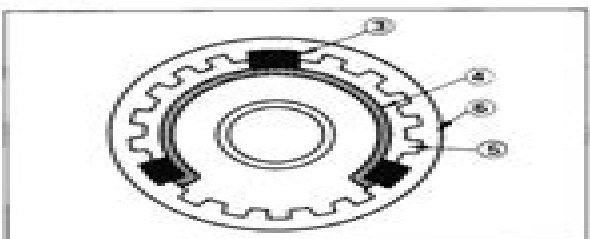
#### 5. 1st—2nd Synchronizer Assembly

- 1) Turn the shallow clutch hub face ① toward the side of the sleeve with small groove ② on the outer circumference.

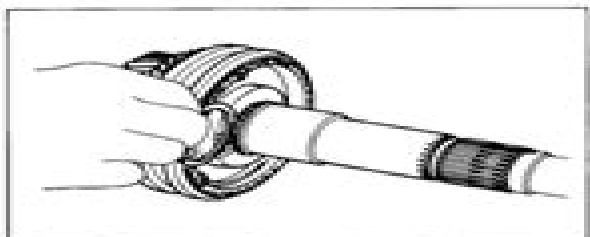


#### Note:

The clutch hub groove ③ must be aligned with the key groove of sleeve.



- 2) Check that the inserts ③ fit snugly into the block ring insert grooves.
- 3) Check that the insert springs ④ are fitted to the inserts as shown in the illustration.
- 4) Check that the clutch hub ⑤ and the sleeve ⑥ slide smoothly.
- 5) Install the synchronizer assembly to the mainshaft.  
The clutch hub face (with the heavy boss) must be facing the 2nd gear side.



#### 6. Clutch Hub Snap Ring

- 1) Select the snap ring which will provide the minimum clearance between the 1st/2nd clutch hub and the snap ring.  
There are three snap ring sizes available.  
The snap rings are color-coded to indicate their thickness.

Clutch Hub and Snap Ring Clearance	mm(in)
Standard	
0 - 0.1 (0.0039)	

# Isuzu Trooper Full Service Repair Manual 1993 1998

**Anthony S. Fauci**



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