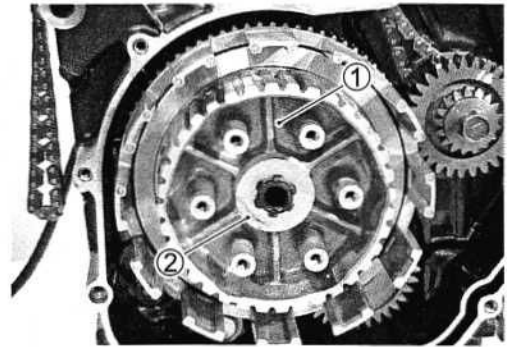


- Install the clutch sleeve hub ① and lock washer ②.

**NOTE**

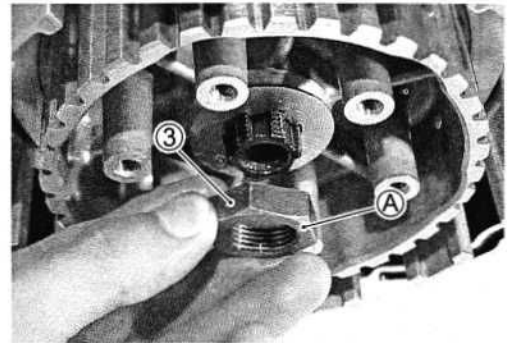
Replace the lock washer ② with a new one.



- Install the clutch sleeve hub nut ③.

**NOTE**

The chamfer side ① of the clutch sleeve hub nut faces out.

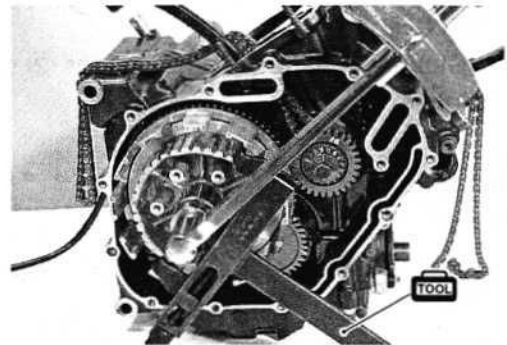


- Hold the clutch sleeve hub using the special tool.

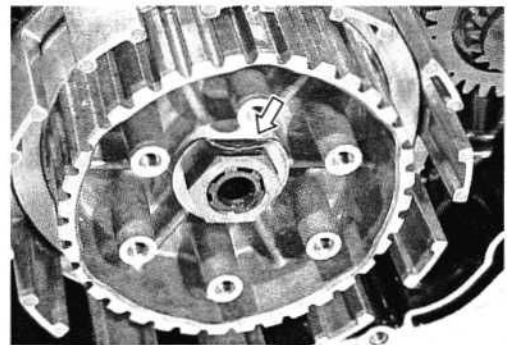
**TOOL** 09920-53740: Clutch sleeve hub holder

- Tighten the clutch sleeve hub nut to the specified torque.

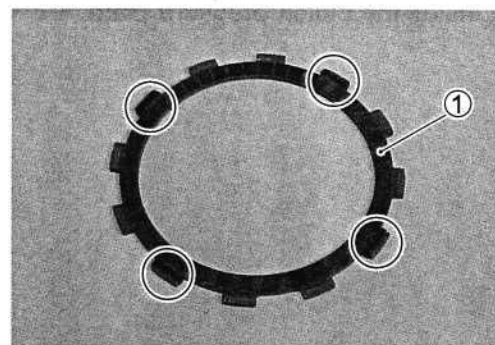
**TOOL** Clutch sleeve hub nut: 50 N·m (5.0 kgf·m, 36 lb-ft)



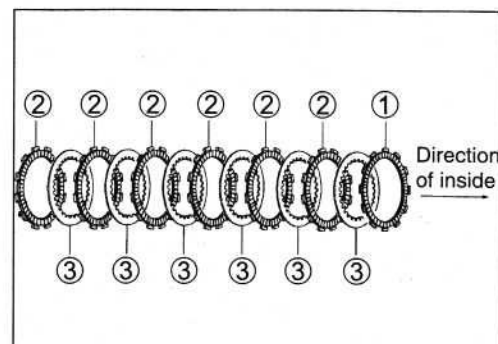
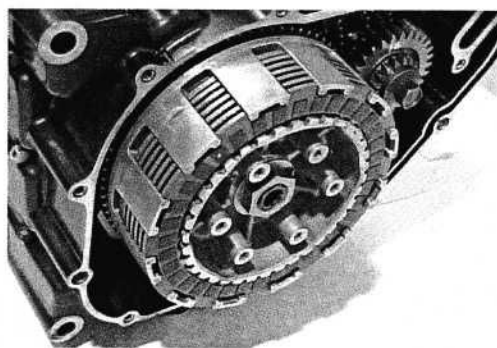
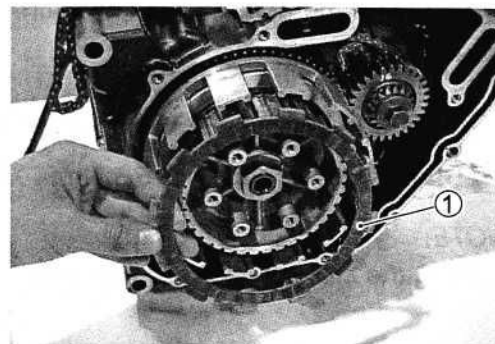
- Bend the lock washer to lock the nut.



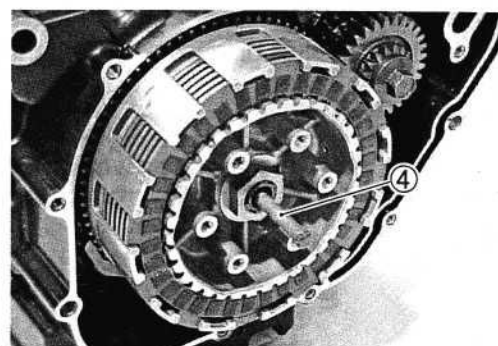
- Insert the clutch drive plates ①, ② and driven plates ③ one by one into the clutch sleeve hub in the prescribed order, No.2 drive plate ① being inserted first.



- ① No.2 Clutch drive plate (installed the dampers)
- ② No.1 clutch drive plate
- ③ Clutch driven plate (thickness: 1.6 mm)



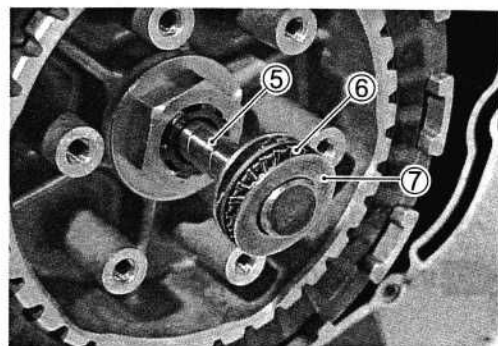
- Install the clutch push rod ④ into the countershaft.



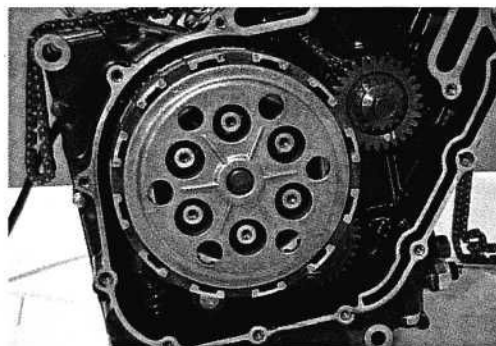
- Install the clutch push piece ⑤, the bearing ⑥ and the thrust washer ⑦ to the countershaft.

**NOTE:**

Thrust washer ⑦ is located between the pressure plate and the bearing ⑥.



- Install the clutch pressure plate.



- Hold the generator rotor (crankshaft) using the special tool.

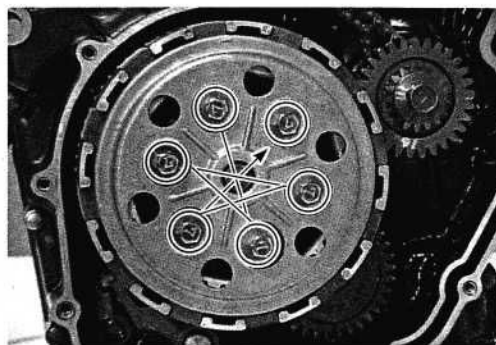
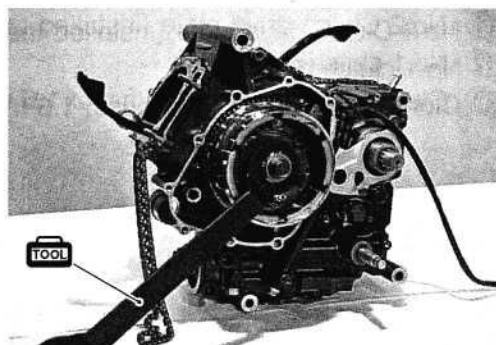
**TOOL 09930-44530: Rotor holder**

- Tighten the clutch spring set bolts to the specified torque.

**Clutch spring set bolt: 5.5 N·m (0.55 kgf·m, 4.0 lb-ft)**

**NOTE:**

*Tighten the clutch spring set bolt diagonally.*

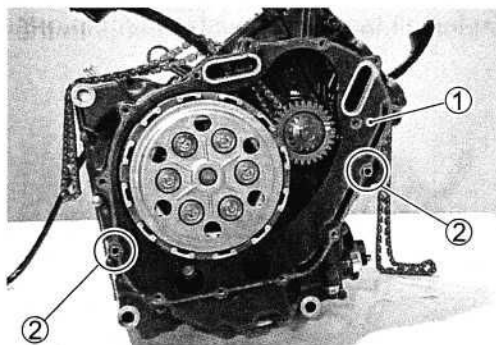


**CLUTCH COVER**

- Install the gasket ① and the dowel pins ②.

**CAUTION**

**Use the new gasket to prevent oil leakage.**



- Install the clutch inner cover ③ and tighten its bolts temporarily.

**NOTE:**

- \* Be sure to install the water pump and its driven gear.  
(5-19)
- \* Apply **THREAD LOCK "1342"** to the clutch cover bolts.

**1342 99000-32050: THREAD LOCK "1342"**

