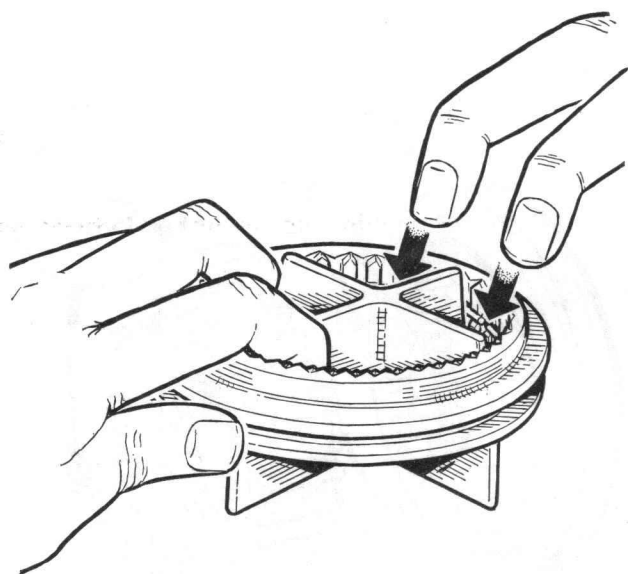




9471

Fig. 65. Engaging spring ring into sliding sleeve

To assemble spring ring synchro hubs

Care will be required in locating the spring ring in the groove of the sliding sleeve.

In order to perform this operation it will be necessary to make up an assembly fixture to the dimensions given. The two plates are slotted and tacked together with braze or weld as illustrated at "G" Fig. 67.

When the assembly of the fixture is complete, slightly round off the vertical edges to locate easily in the root of the teeth in the sliding sleeve. This should then be a reasonable push fit.

Using the first and second fingers of each hand to hold the ring in the sliding sleeve groove, lower the two over the taper of the fixture, so that the gap in the ring falls in one of the small quarters of the fixture, see Fig. 65, and the fixture locates in the teeth of the sleeve.

Press the sliding sleeve down to the surface on which the fixture is standing and this will now retain the spring ring.

Place the sleeve and fixture over the synchro hub, line up the teeth and, keeping an even pressure on the sleeve and fixture, slide the sleeve off the fixture and on to the hub. It may be necessary to use a small screwdriver to ease the ends of the spring ring into the groove.

Insert the shifting plates into the slots in the hub and refit both circlips with one on each side of the hub, with the hook end of each being located in a different shifting plate and wrapped in opposite directions. See Fig. 64.

When the reassembly is complete, test that the sliding sleeve will slide across the hub and that the spring ring makes a positive engagement in the detent.

To REASSEMBLE GEARBOX

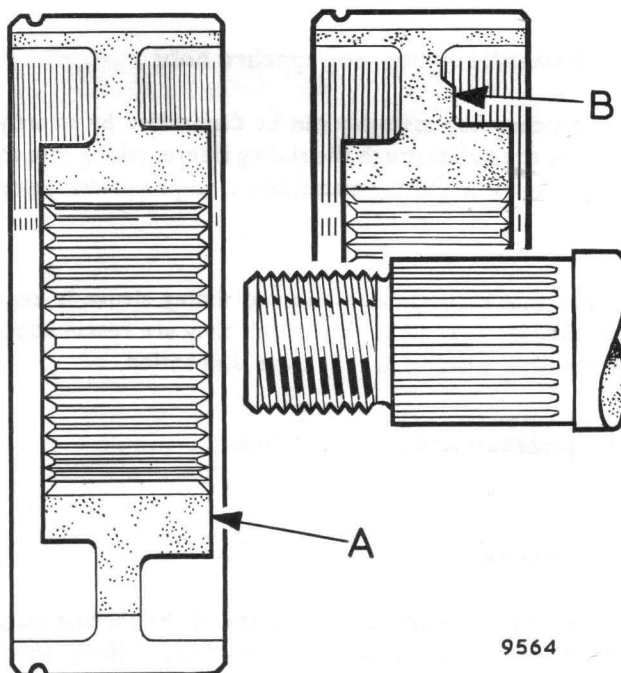
IT IS IMPORTANT TO NOTE ON REASSEMBLY OF THE GEAR BOX THAT THE 1st/2nd SPRING RING TYPE SYNCHRO HUB CAN BE INCORRECTLY ASSEMBLED ON THE PINION SHAFT.

CORRECT ASSEMBLY IS WHEN THE WIDER FACE OF THE SPLINED HUB CENTRE IS FITTED TOWARDS THE PINION HEAD, SEE "A" Fig. 66.

SOME MODELS INCORPORATE AN IDENTIFICATION STEP IN THE ROOT OF THE RECESS ON THE 1ST SPEED SIDE TO ASSIST REASSEMBLY, SEE "B" Fig. 66.

The 3rd/4th synchro assembly can be fitted either way round.

With the introduction of the spring ring synchro-mesh, the 1st selective washer has been changed in thickness and the quantity reduced to five.



9564

Fig. 66. Position of 1st/2nd hub, wider face 'A', to pinion head or, identification step 'B' to pinion head