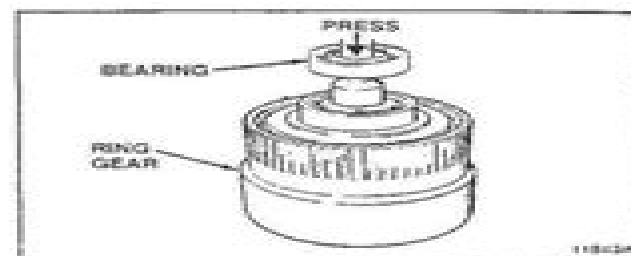


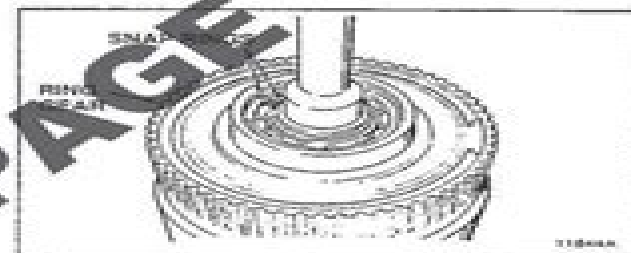
STEP 19. Install drive gear assembly (82) in clutch assembly. Slide bearing (63) down drive gear assembly (82).

Place complete assembly in press. Press bearing (63) into drive gear assembly (82) until seated against shoulder.



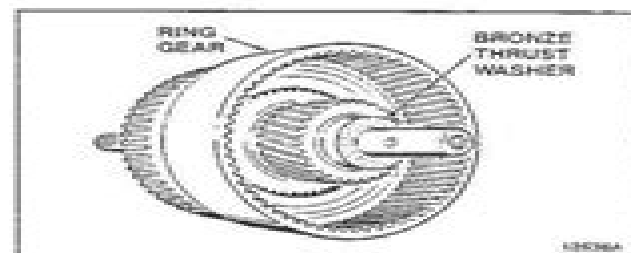
Bearing Installation

STEP 20. Install snap rings (61 and 62) in grooves of drive gear assembly (82) and forward clutch cylinder (64).



Snap Ring Installation

STEP 21. Apply vasoline to bronze thrustwasher (77). Install over end of shaft and against face of gear.



Thrustwasher Assembly

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Karin Nielsen-Saines



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