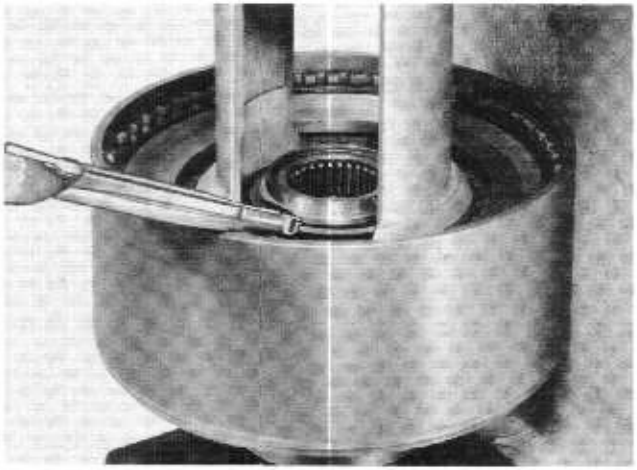
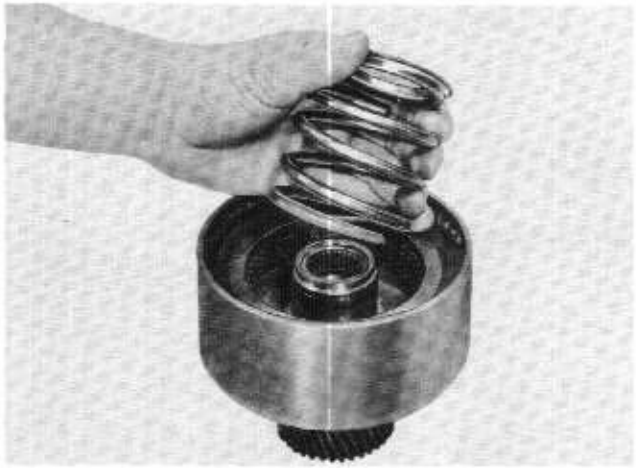
## A. Disassembly of Rear Clutch

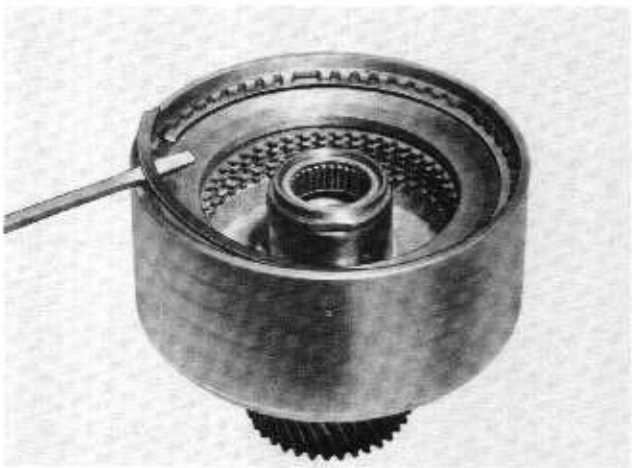


1. Using an arbor press and the tool shown, remove the clutch release spring snap ring.

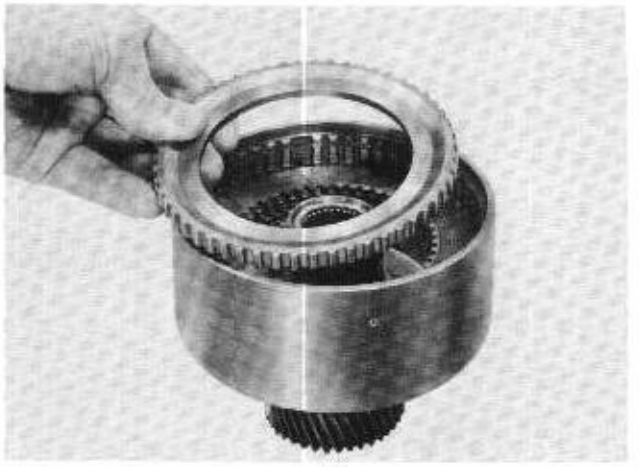
**CAUTION** Guide the spring retainer, while releasing the press, to prevent the retainer from "hanging up" in the snap ring groove.



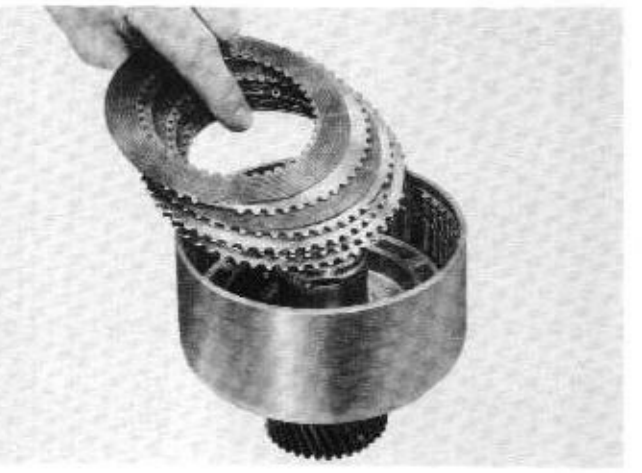
2. Remove the retainer and release spring.



3. Remove the pressure plate snap ring.

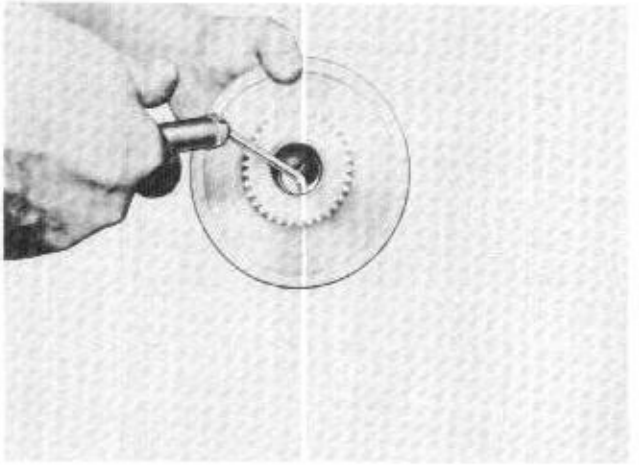


4. Remove the pressure plate from the drum.



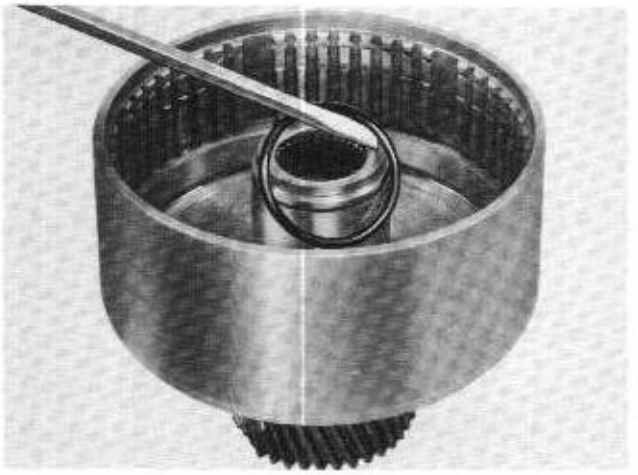
5. Remove the bronze and steel plates.

**NOTE** These steel plates are not interchangeable with front clutch steel plates.

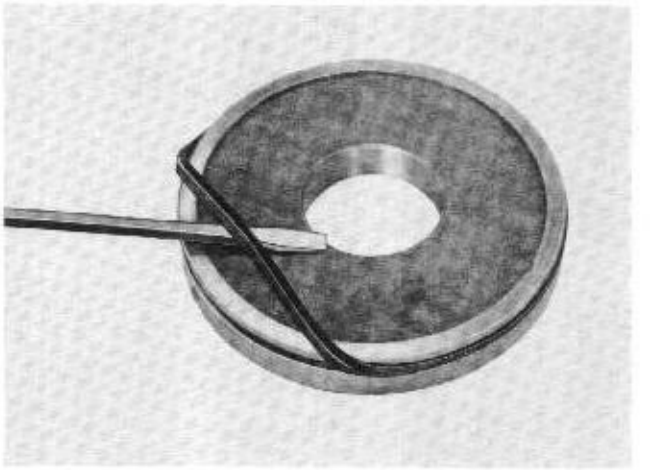


6. With air pressure and a piece of 3/16 inch tubing, force the piston out of the clutch bore.

**CAUTION** Hold your hand over the piston to keep it from flying out of the bore.



7. Remove the clutch piston inner seal ring.



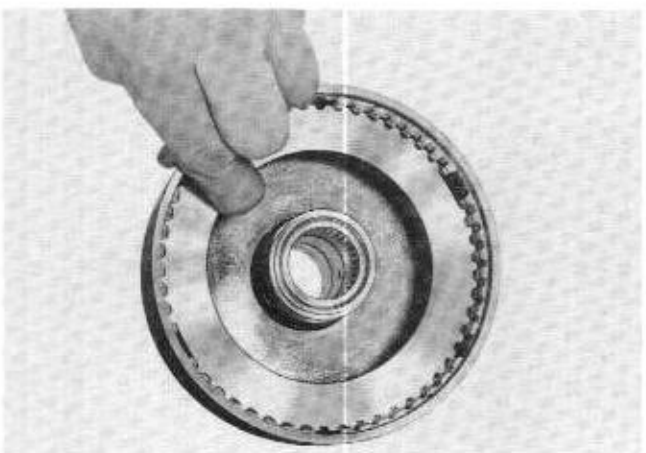
8. Remove the outer seal ring from the piston.

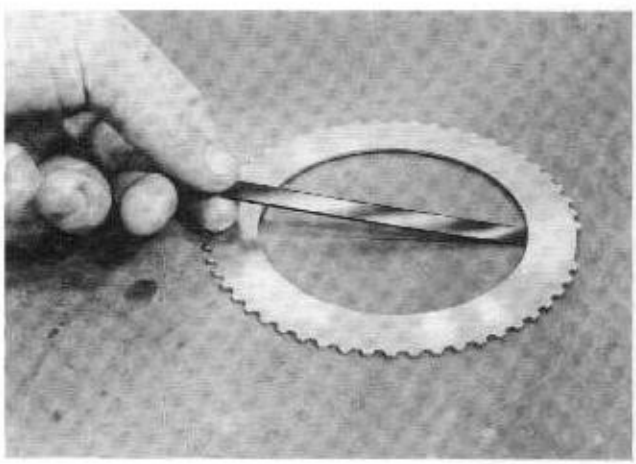
## B. Inspection of Rear Clutch

Wash all clutch parts in clean solvent, and blow them dry before inspection.

1. Inspect the drum band surface, bushing or needle bearing, and thrust surfaces for wear and scoring.
2. Inspect the piston bore, and the inner and piston bearing surfaces for scores.
3. Inspect gear teeth for burrs or scores.
4. Check all fluid passages for obstructions.
5. Inspect the steel and bronze clutch plates for scores.

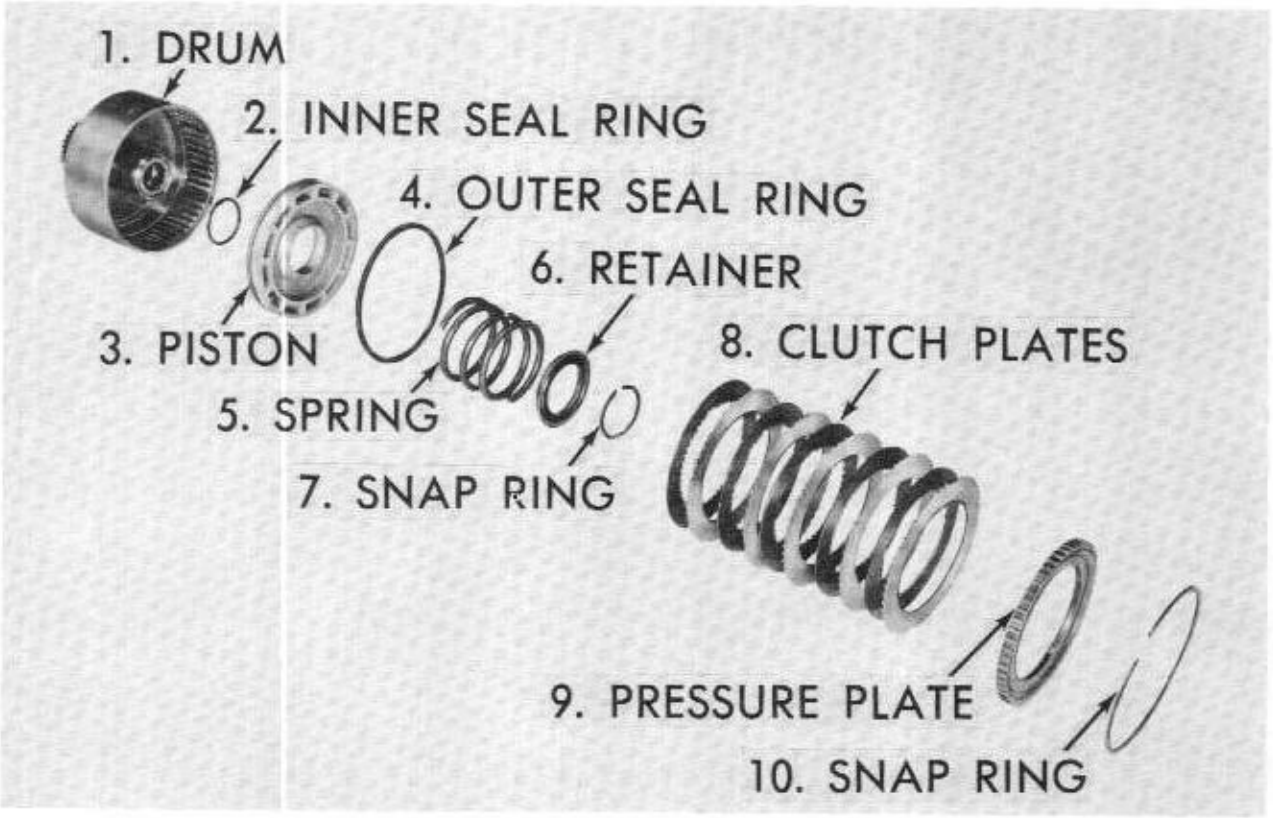
NOTE The steel plates are coned.





6. Check all the plates (steel and bronze) for free movement on the serrations in the drum.
7. Check the coning of the steel plates. Place each plate on a flat plate, and use a feeler gage to check the coning on the inside diameter. Coning on the inside diameter of the plates should be .010 inch.
8. Inspect the clutch pressure plate for scores on the clutch plate bearing surface.
9. Check the clutch release spring for distortion.
10. Inspect the rear band for wear, cracks or distortion.

NOTE If any of the rear clutch parts are damaged replace them.




## C. Assembly of the Rear Clutch

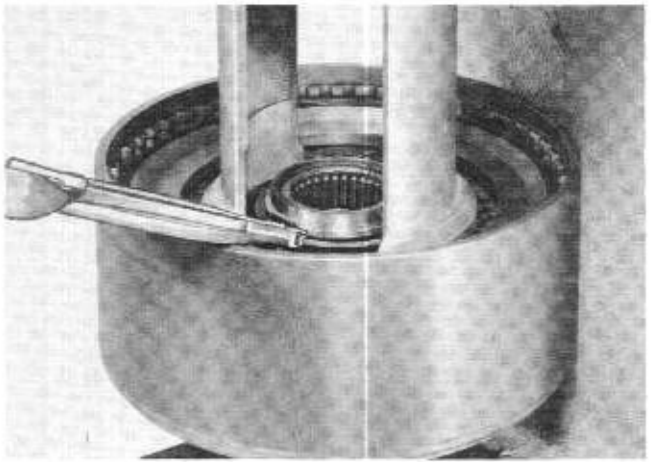
1. Install the inner seal ring (2) in the groove in the drum (1).
2. Install a new outer seal ring (4) on the piston (3).
3. Install the piston in the clutch drum.

NOTE Lubricate the parts to make piston installation easier.

4. Install the steel clutch plates and bronze clutch plates (8) alternately--starting with a steel plate.

NOTE The steel plates must be installed with the cones down. Lubricate the plates as they are installed.

5. Install the clutch pressure plate (9) with its bearing surface down.
6. Install the pressure plate snap ring (10)-- making certain it is fully seated in its groove.
7. Install the clutch release spring (5) and place the retainer (6) on the spring.



8. Using an arbor press and the special tool shown, compress the retainer and clutch release spring, and install the clutch release spring snap ring. Release the press and remove the clutch assembly.

**CAUTION** While compressing the spring, guide the retainer to keep it from engaging in the snap ring groove. Make sure the snap ring is fully seated in its groove.