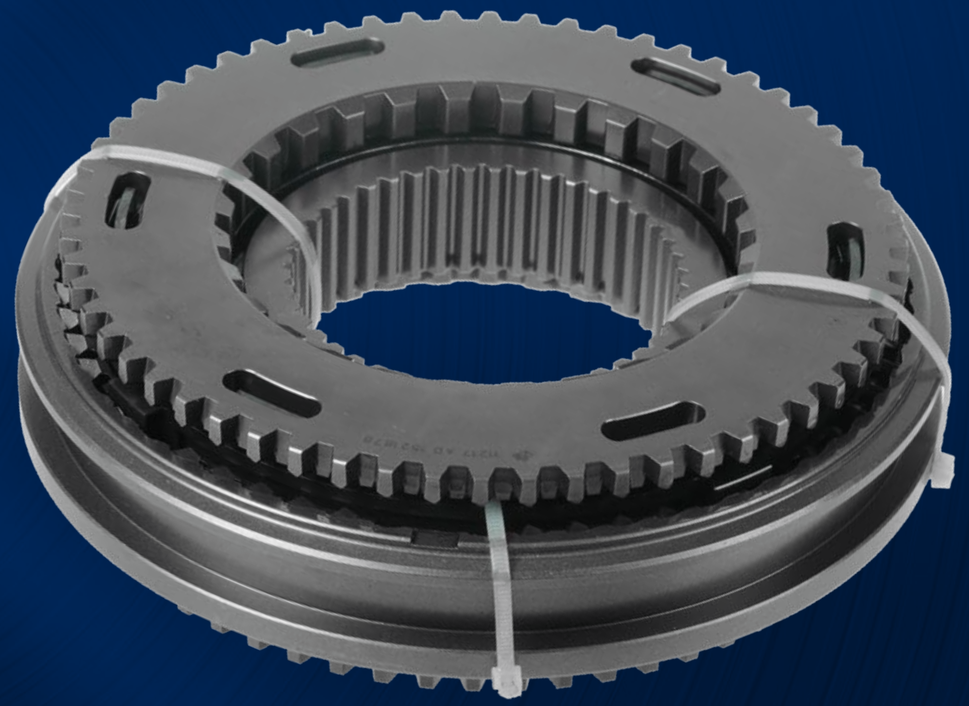
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REPAIR KIT ASSEMBLY MANUAL
20907441 (88530697)
SUITABLE TO **VOLVO**



Transmissions: VT2014 B - VT/VTO2214 B - VT/VTO2514 B - VT2514 (OD) - VT2814 B

Exploded B.O.M.

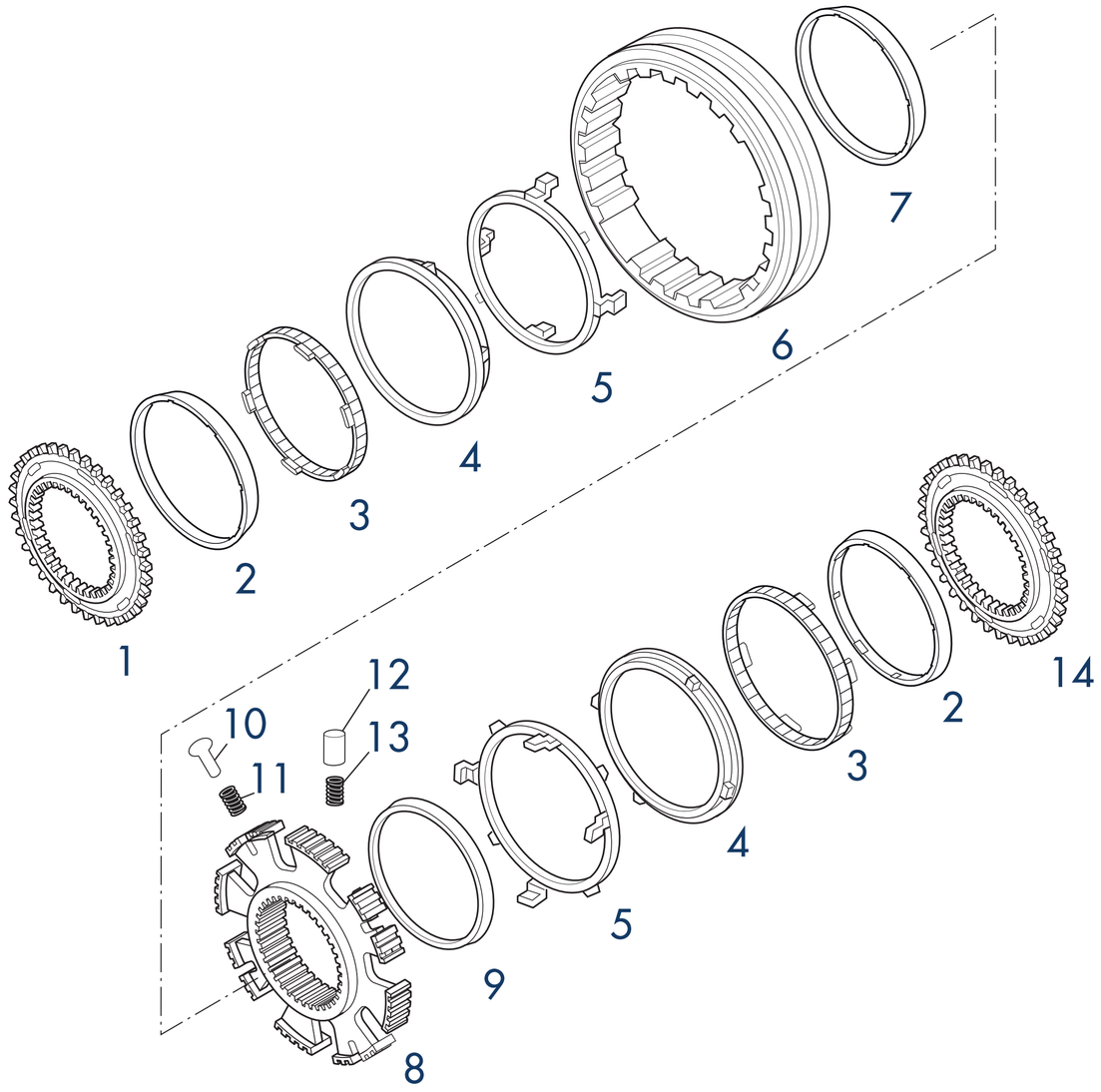
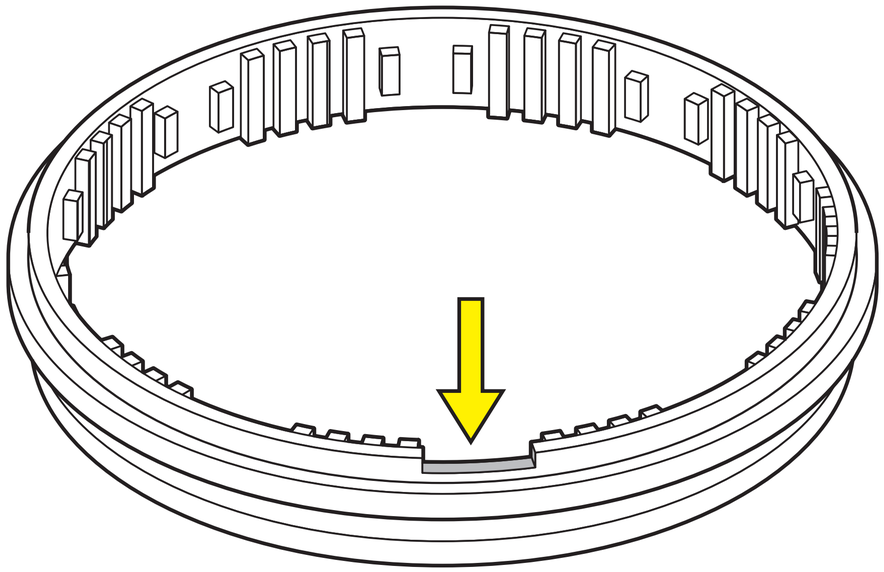


Fig.	Qty	Our No.	OEM Part	Description
(1)	1	**88530505**	1521878	CLUTCH RING 1ST/3RD SPEED
(2)	2	**88530507**	3192951	SYNCHRONIZER RING INNER
(3)	2	**88530506**	1069254	SYNCHRONIZER RING INTERM.
(4)	2	**88530508**	1069255	SYNCHRONIZER RING OUTER
(5)	2	**88530509**	1521890	THRUST DISK
(6)	1	**88530518**	20588775	SLIDING SLEEVE
(7)	1	**88530633**	20588777	ELASTIC DISK 1ST SPEED
(8)	1	**88530520**	20858492	SYNCHRONIZER HUB
(9)	1	**88530522**	1069888	ELASTIC DISK 2ND SPEED
(10)	4	**88530623**	20804800	PIN
(11)	4	**88530624**	20845629	SPRING
(12)	2	**88530513**	1521870	KEY
(13)	2	**88530514**	8172433	SPRING
(14)	1	**88530523**	1521879	CLUTCH RING 2ND SPEED

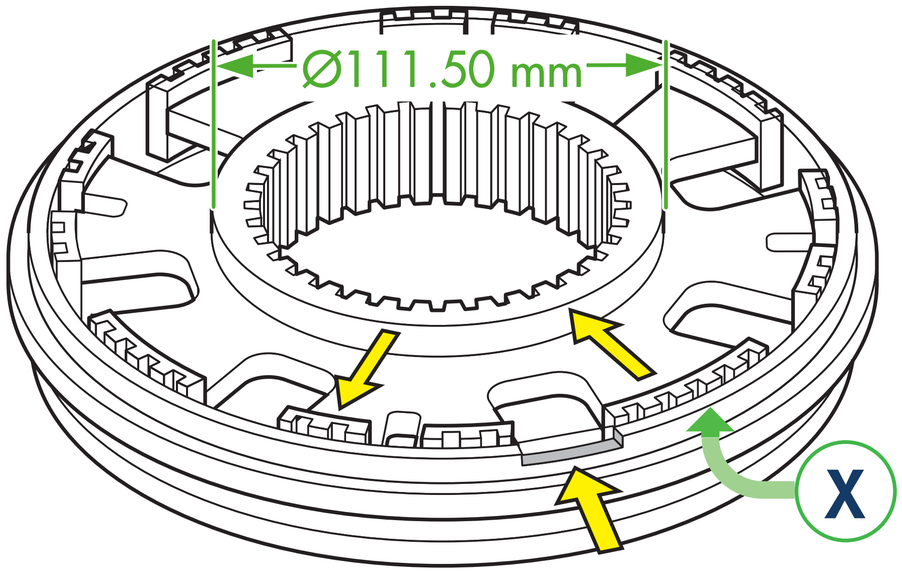
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Assembly (A view side)

1. Place the SLIDING SLEEVE **88530518** (**6**) on the workbench with the indentation facing up



2. Insert the SYNCHRONIZER HUB **88530520** (**8**) into the SLIDING SLEEVE (**6**) with the highest hub (Ø111.50x11.10) facing up.



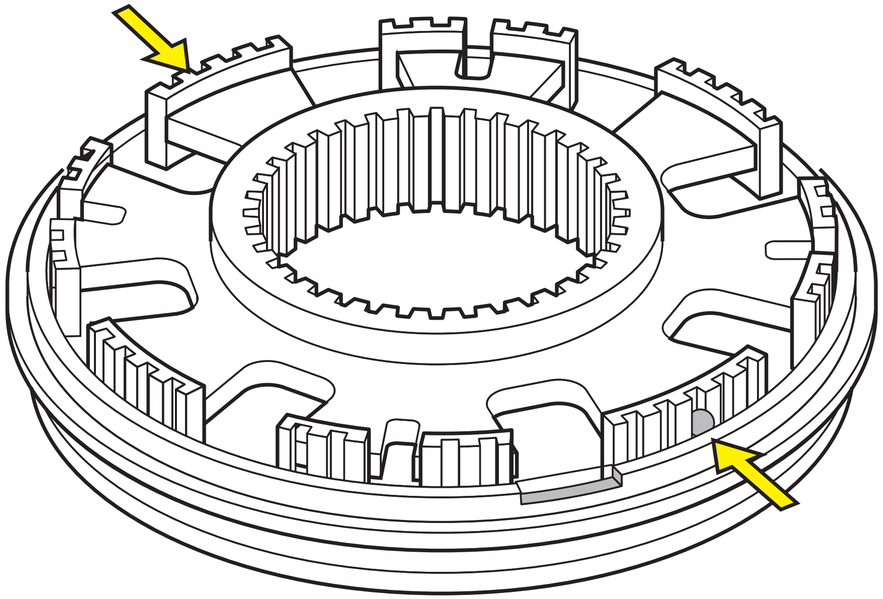
NOTE: Position the SYNCHRONIZER HUB (**8**) in such a way that the large slit (23.20 mm) on the HUB (**8**) lines up with the indentation on the SLEEVE (6), the small slit (9.20 mm) on the HUB (**8**) lies to the LEFT of the indentation on the SLEEVE (**6**) and the tooth slot (wider than the others) with the hole for the STOP PIN is in position "X".

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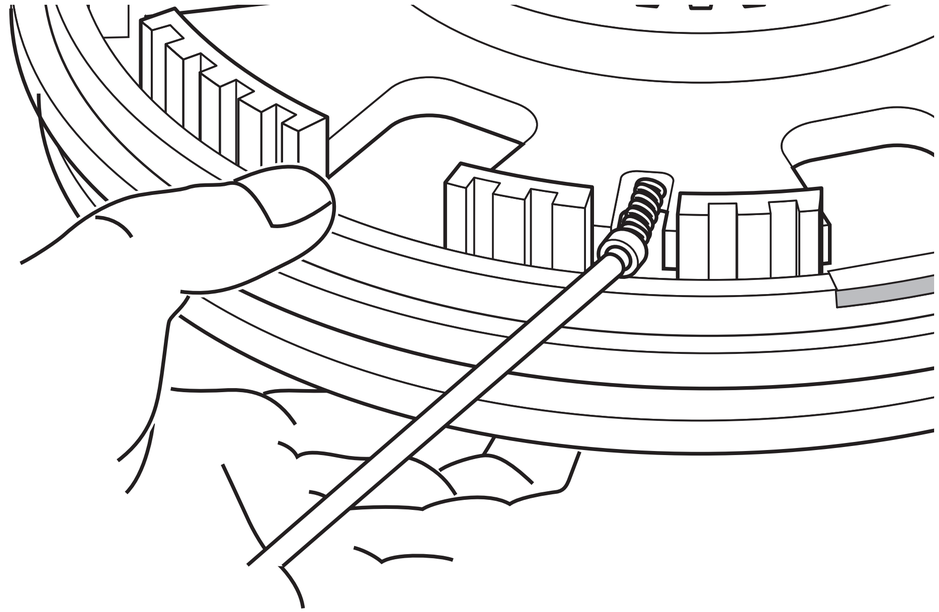
Assembly (A view side)

3. Insert the 2 (two) SPRINGS **88530514** (**13**) and respective 2 (two) KEYS **88530513** (**12**) in the SYNCHRONIZER HUB (**8**), press the SYNCHRONIZER HUB (**8**) into the SLIDING SLEEVE (**6**) until the KEYS (**12**) click into position.



NOTE: The ball ends of the KEYS **88530513** (**12**) must be on the outside.

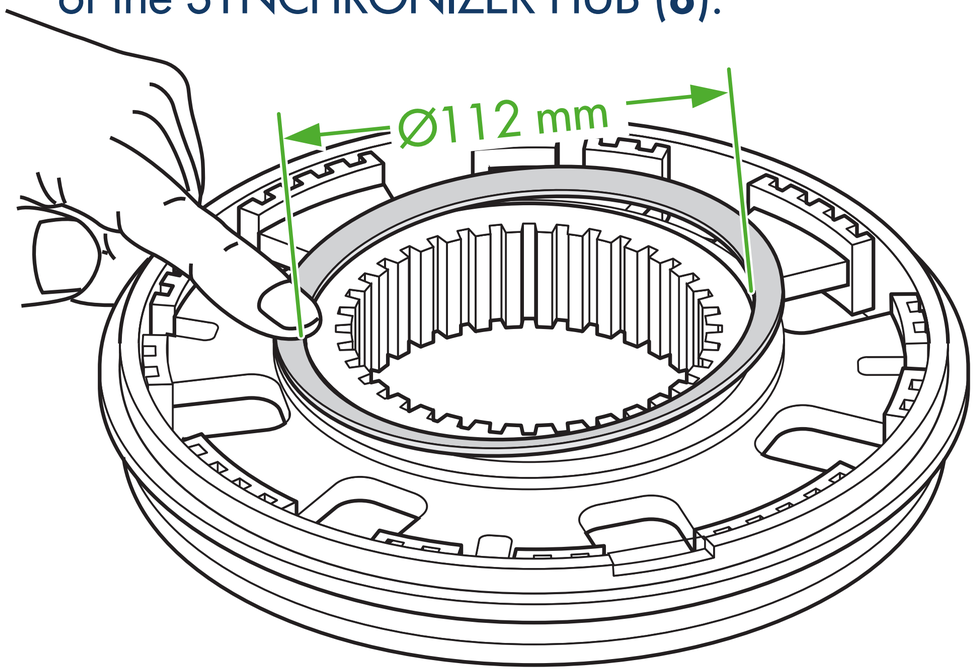
4. Insert the 4 (four) SPRINGS **88530624** (**11**) and respective 4 (four) PINS **88530623** (**10**) in the SYNCHRONIZER HUB (**8**), position them in their seat using a suitable drift from above and a finger from below if necessary.



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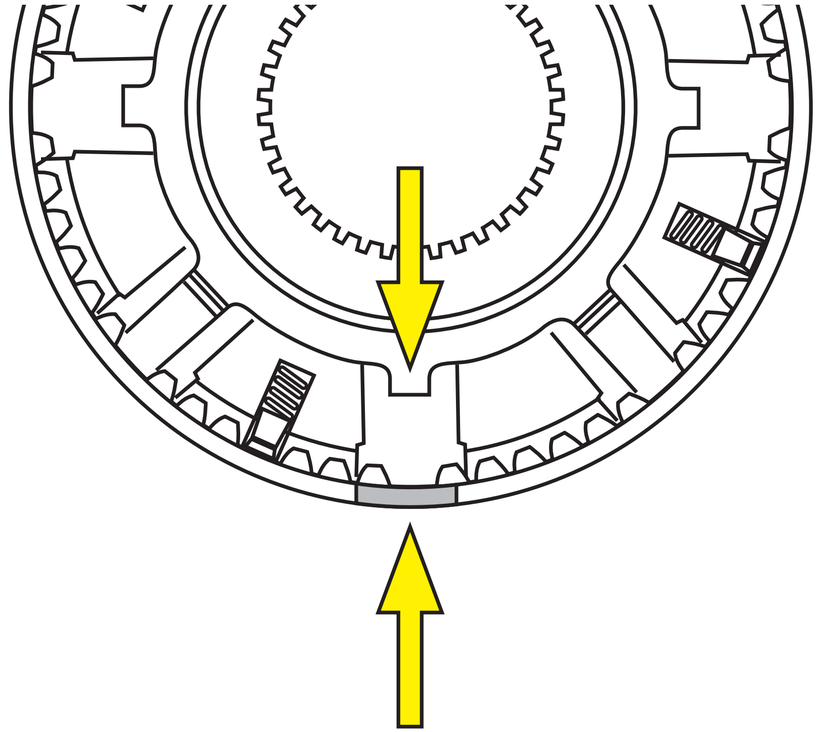
Assembly (A view side)

5. Insert the ELASTIC DISK 1ST SPEED **88530633** (**7**) with the lowest point against the projection of the SYNCHRONIZER HUB (**8**).



NOTE: If you press the edge of the SPRING DISK (**7**), it should lift up on the opposite side.

6. Place the THRUST DISK **88530509** (**5**) on the SYNCHRONIZER HUB (**8**).



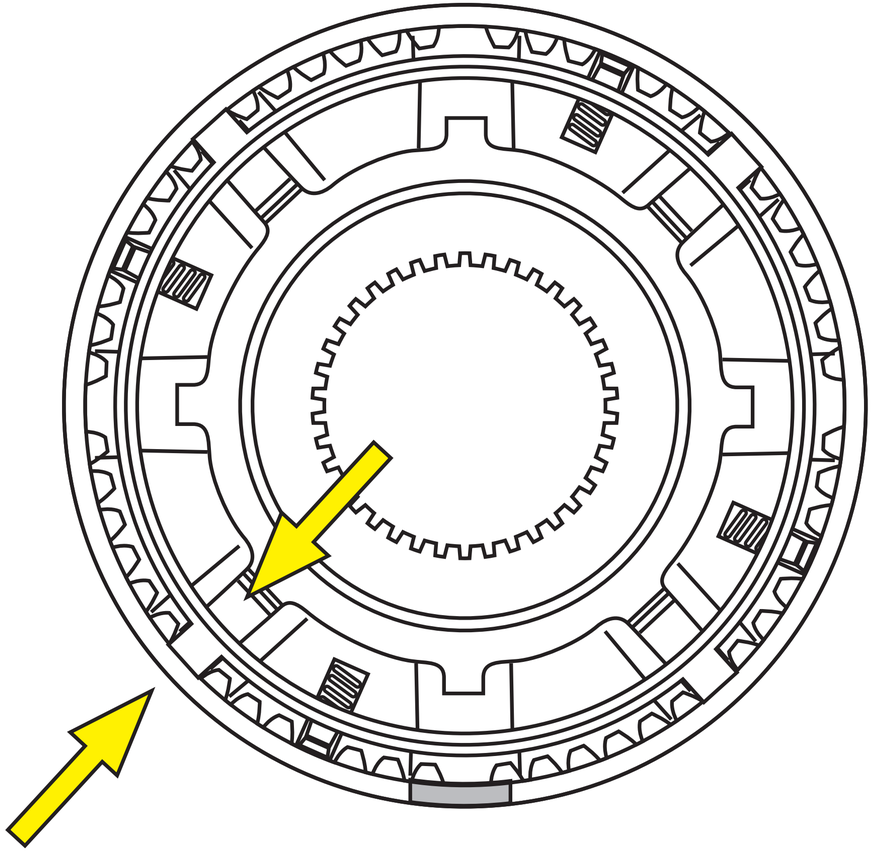
NOTE: One of the four small arms of the THRUST DISK (**5**) should be ALIGNED with the INDENTATION on the SLIDING SLEEVE (**6**) and with the long arms facing down.

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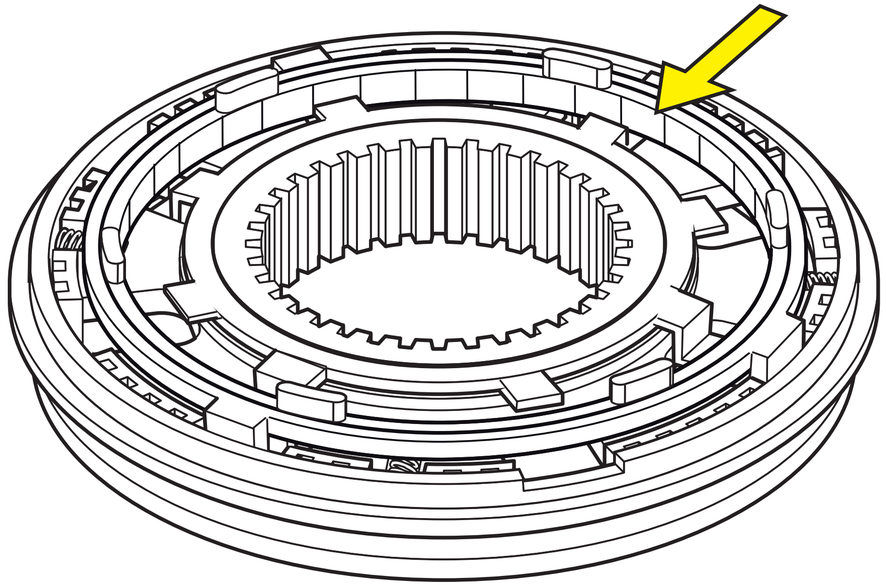
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Assembly (A view side)

7. Insert the SYNCHRONIZER RING (external) **88530508** (**4**) with the fins in the same position as the long arms on the THRUST DISK (**5**).



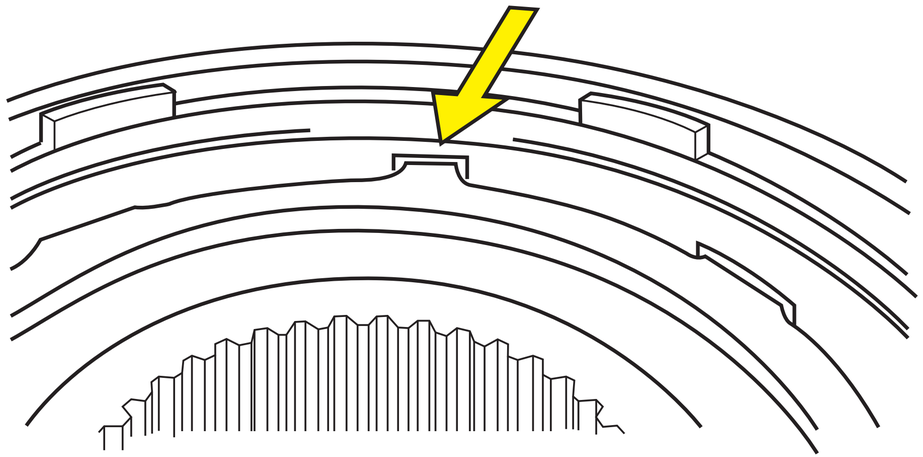
8. Insert the SYNCHRONIZER RING (intermediate) **88530506** (**3**).



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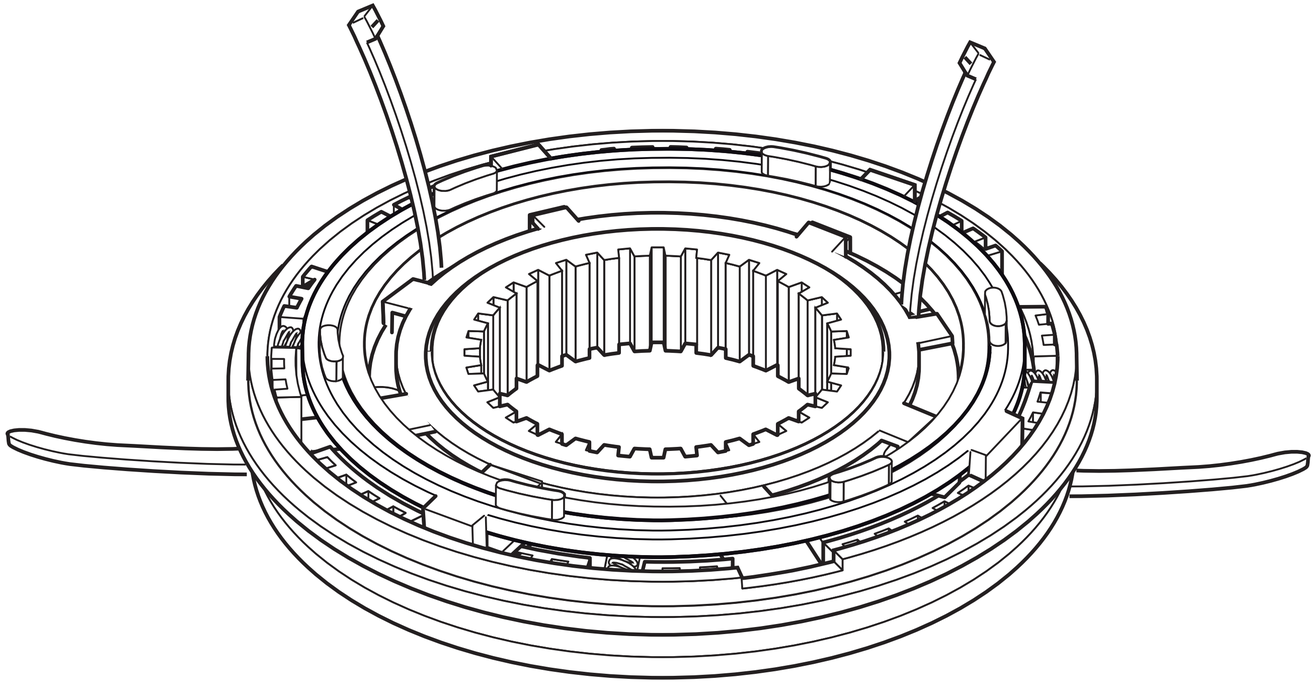
Assembly (A view side)

9. Insert the SYNCHRONIZER RING (internal) **88530507** (**2**).



NOTE: Insert the small grooves of the SYNCHRONIZER RING (**2**) in the small arms of the THRUST DISK (**5**).

10. Insert two cable ties, threading them through two opposite cuts in the SYNCHRONIZER hub.

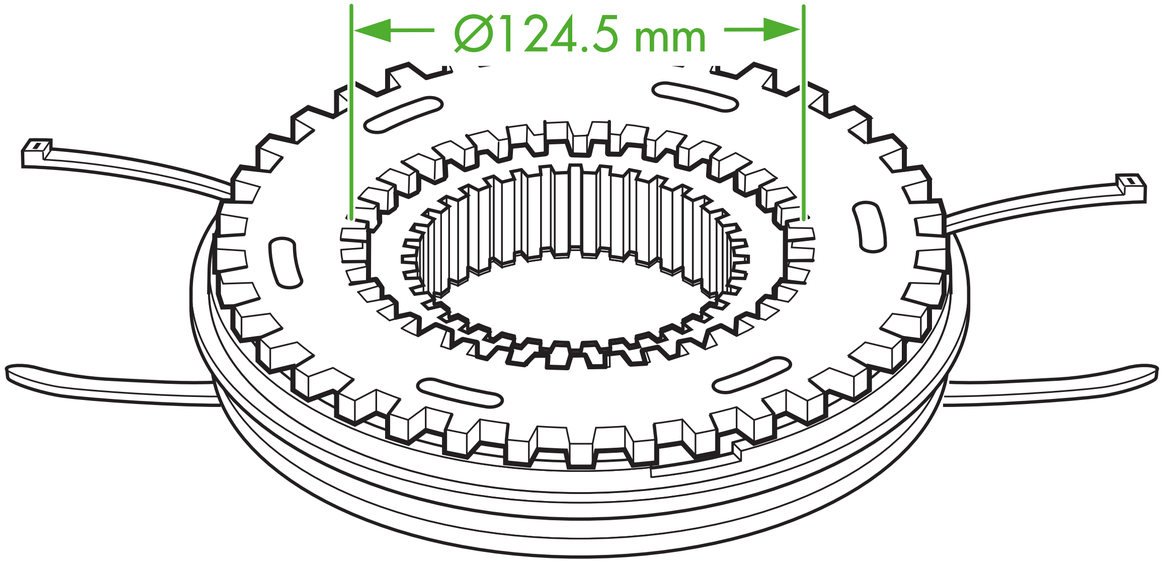


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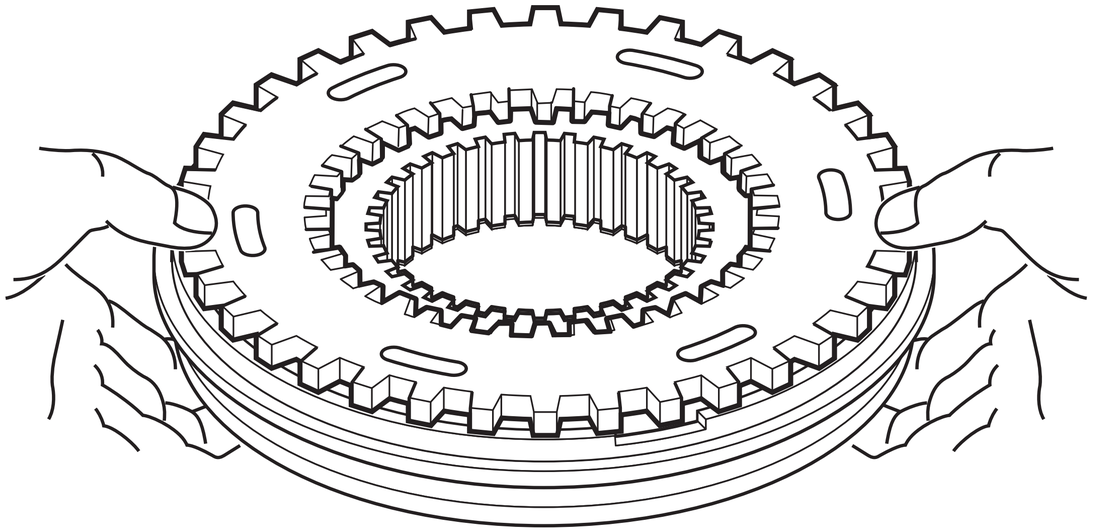
Assembly (A view side)

11. Position the CLUTCH RING 1ST/3RD SPEED **88530505** (**1**) with the flat side facing up, introducing the 6 fins of the SYNCHRONIZER RING **88530506** (**3**) into the slots of the CLUTCH RING, overlapping the two cable ties.



NOTE: To identify the CLUTCH RING **88530505** (**1**) measure the diameter of the bevelling (Ø 124.50 mm) or check the marking of the original code (1521878).

12. Keep the SLIDING SLEEVE in the idle position, turn the assembly making sure it does not come apart.

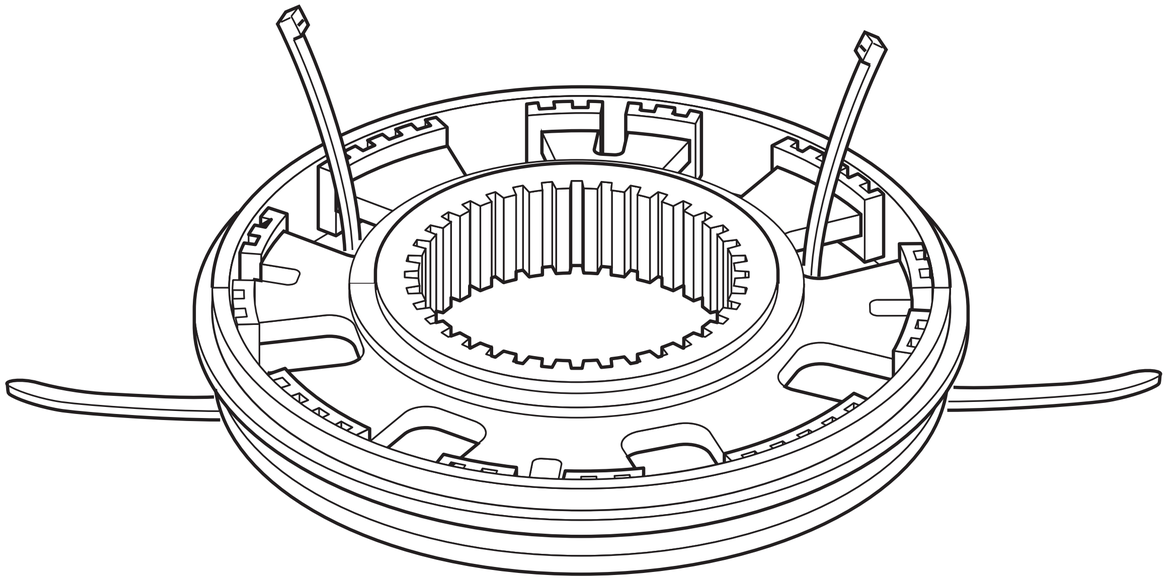


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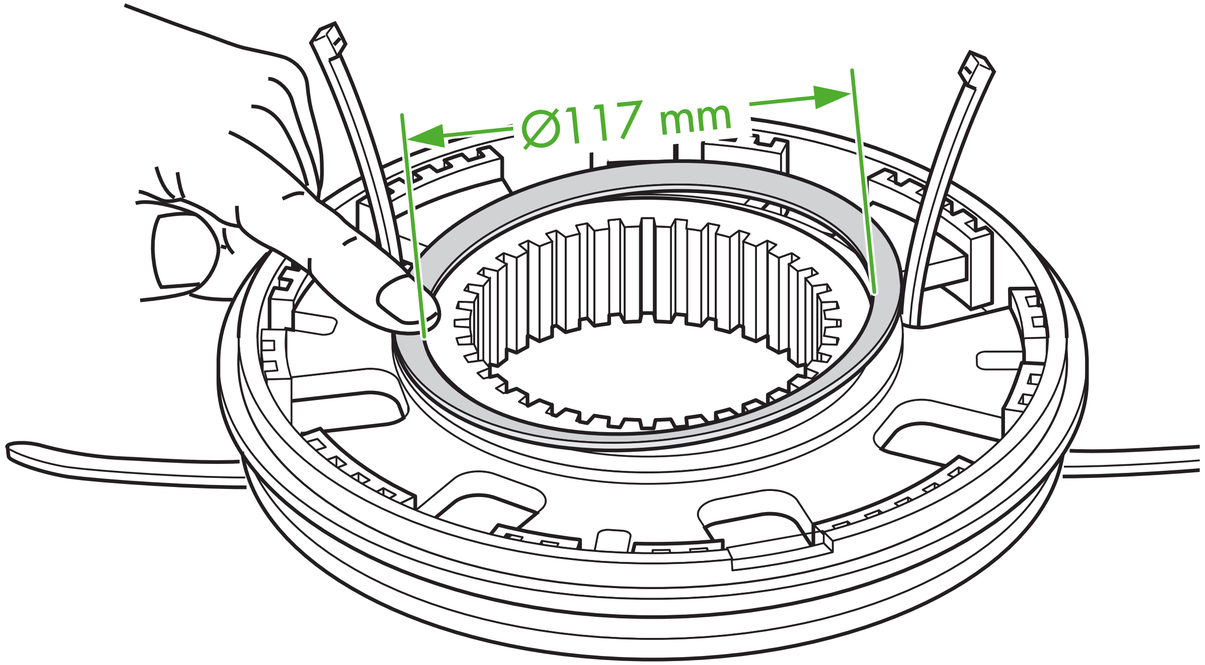
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Assembly (B view side)

13. Insert the ELASTIC DISK 2ND SPEED **88530522** (**9**) with the lowest point against the projection of the SYNCHRONIZER HUB (**8**).



NOTE: If you press the edge of the ELASTIC DISK (**9**), it should lift up on the opposite side

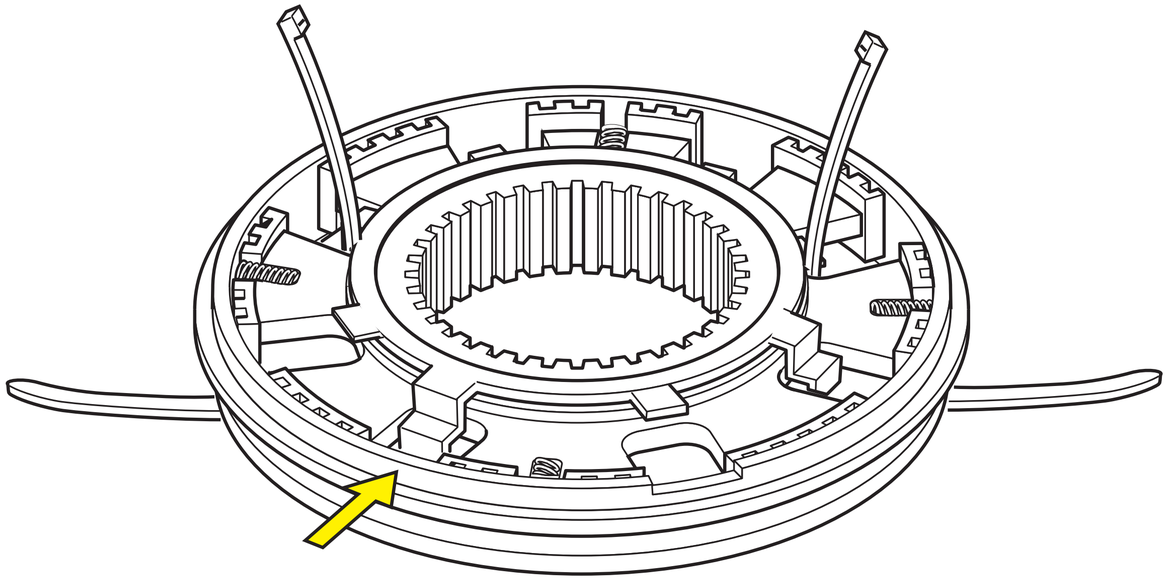


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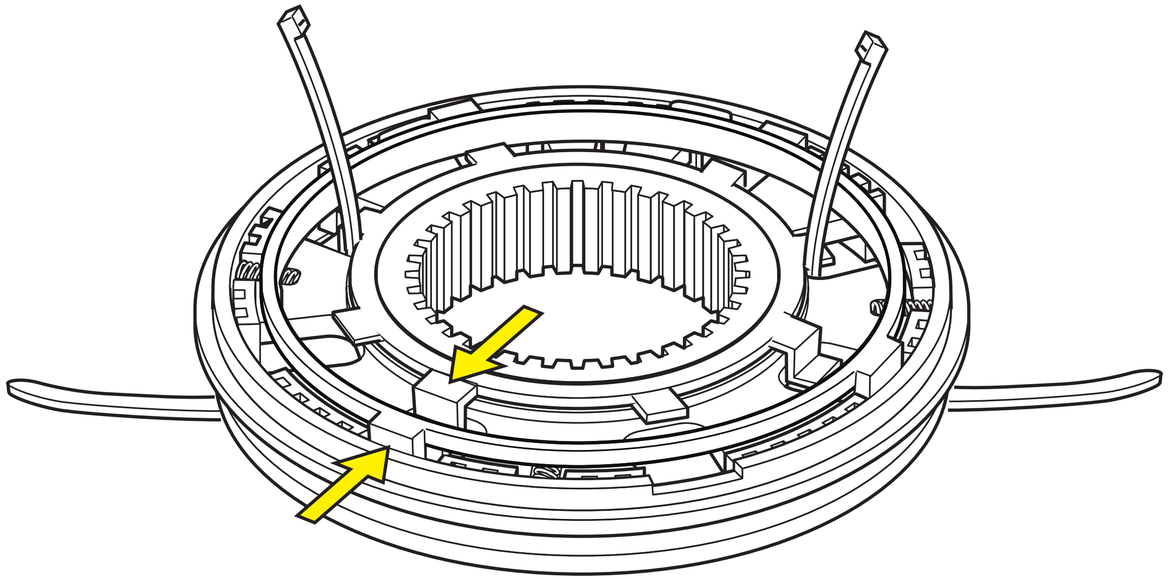
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Assembly (B view side)

14. Insert the THRUST DISK **88530509** (**5**) with the long arms in the free slits of the SLIDING SLEEVE (6) and facing down



15. Insert the SYNCHRONIZER RING (external) **88530508** (**4**) with the fins in the same position as the long arms on the THRUST DISK (**5**)

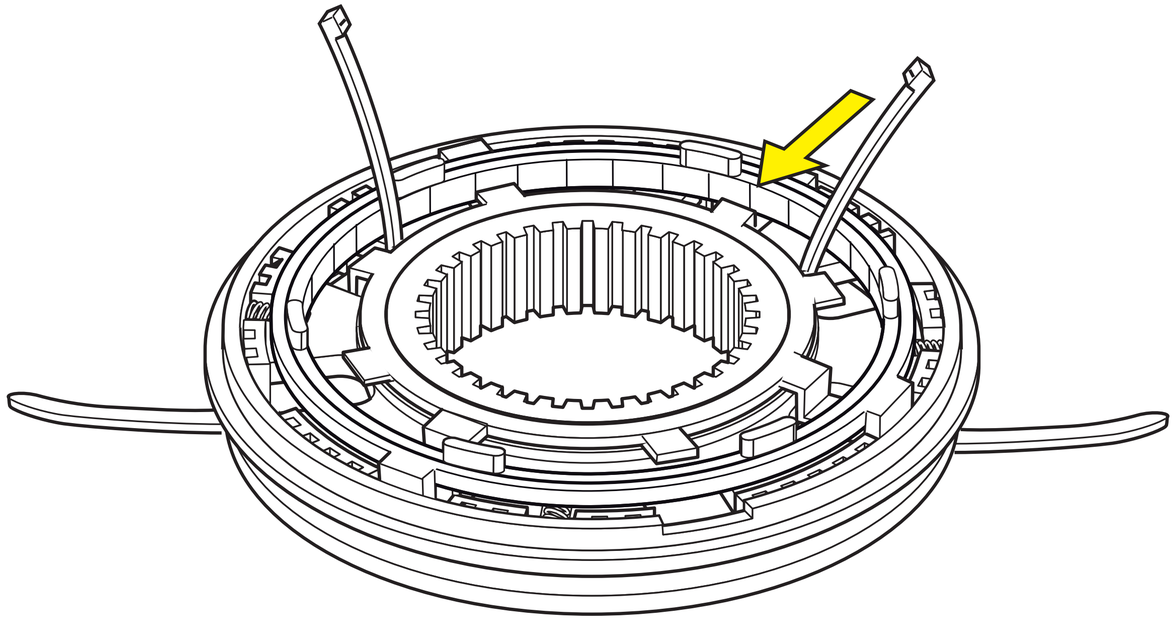


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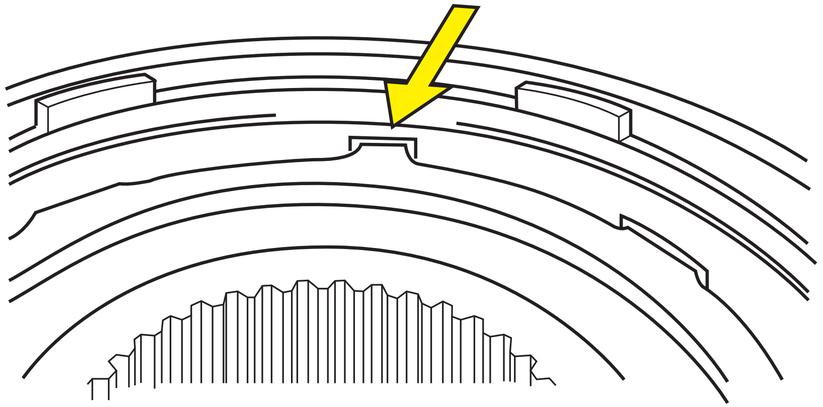
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Assembly (B view side)

16. Insert the SYNCHRONIZER RING (intermediate) **88530506** (3)



17. Insert the SYNCHRONIZER RING (internal) **88530507** (2)



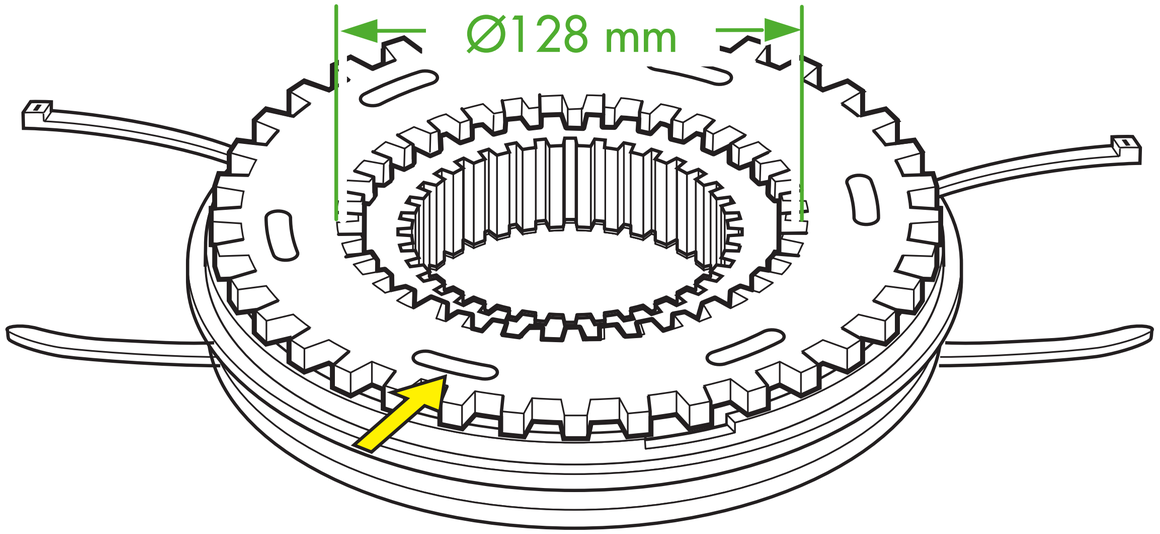
NOTE: Insert the small grooves of the SYNCHRONIZER RING (**2**) in the small arms of the THRUST DISK (**5**).

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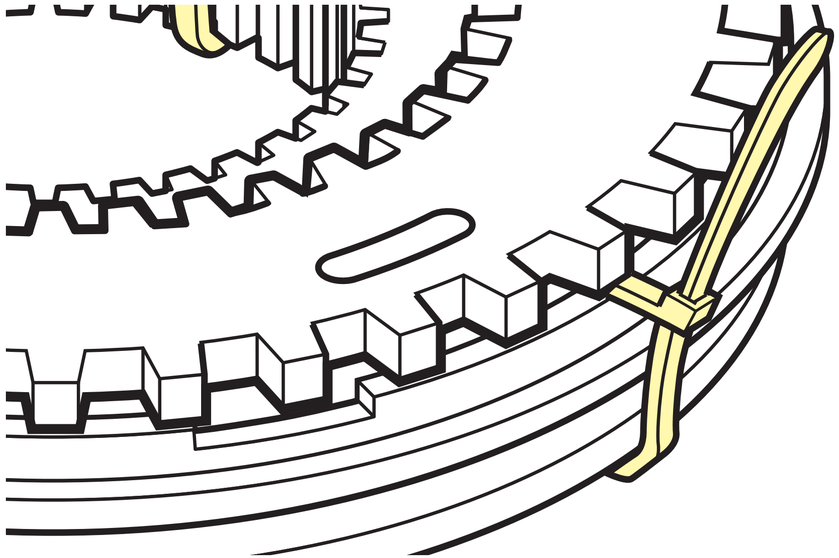
Assembly (B view side)

18. Position the CLUTCH RING 2ND SPEED **88530523** (**14**) with the flat side facing up, introducing the 6 fins of the SYNCHRONIZER RING **88530506** (**3**) into the slots of the CLUTCH RING.



NOTE: To identify the CLUTCH RING **88530523** (**14**) measure the diameter of the bevelling (**Ø 128** mm) or check the marking of the original code (**1521879**).

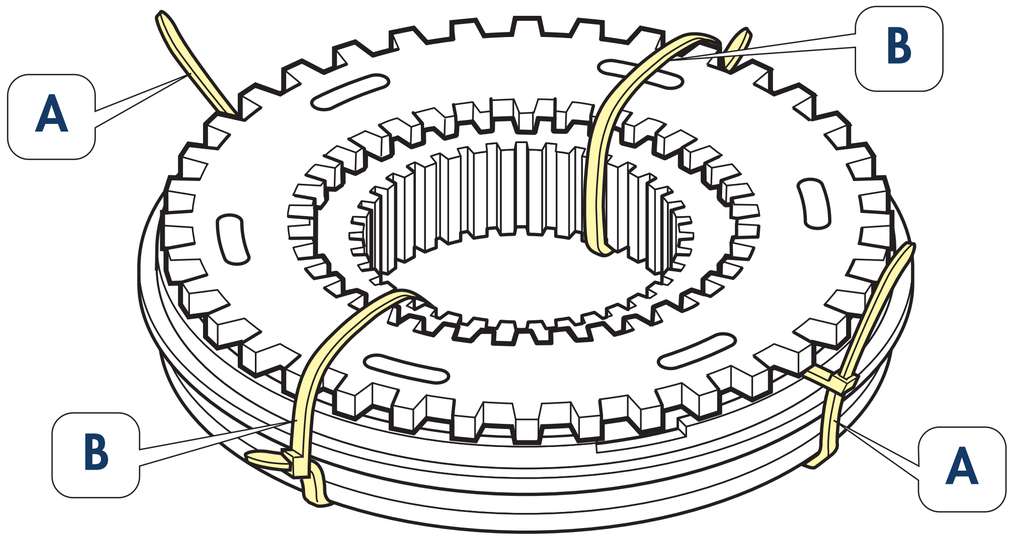
19. Pull the cable ties partially enveloping the assembly. Envelop the entire assembly with two more cable ties and pull these too.
Cut the excess off the ends and coat with protection.



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20. APPEARANCE OF COMPLETED SYNCHRO ASSEMBLY

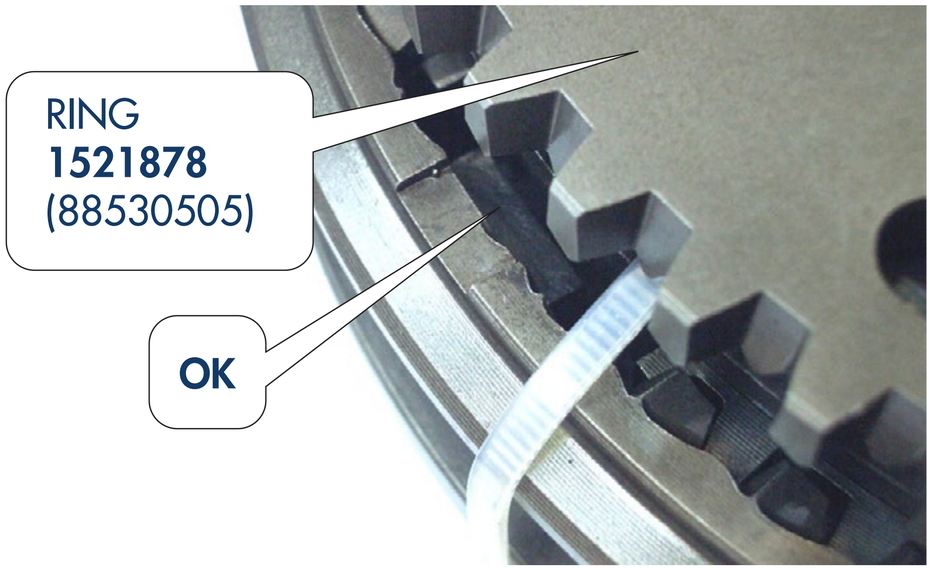


Note: Two cable ties (**A**) should close the entire assembly except for the CLUTCH RINGS without enveloping the broached hole of the SYNCHRONIZER HUB (they should be threaded through the slits); the other two (**B**) should instead close the entire assembly, enveloping it from the broached hole of the SYNCHRONIZER HUB.

21. FINAL CHECK

✓ The end of the LONG ARM of the THRUST DISC must be found opposite the indentation of the SLIDING SLEEVE.

✓ The connecting ring from the side of the SLIDING SLEEVE with the indentation must be marked **1521878** (88530505).



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