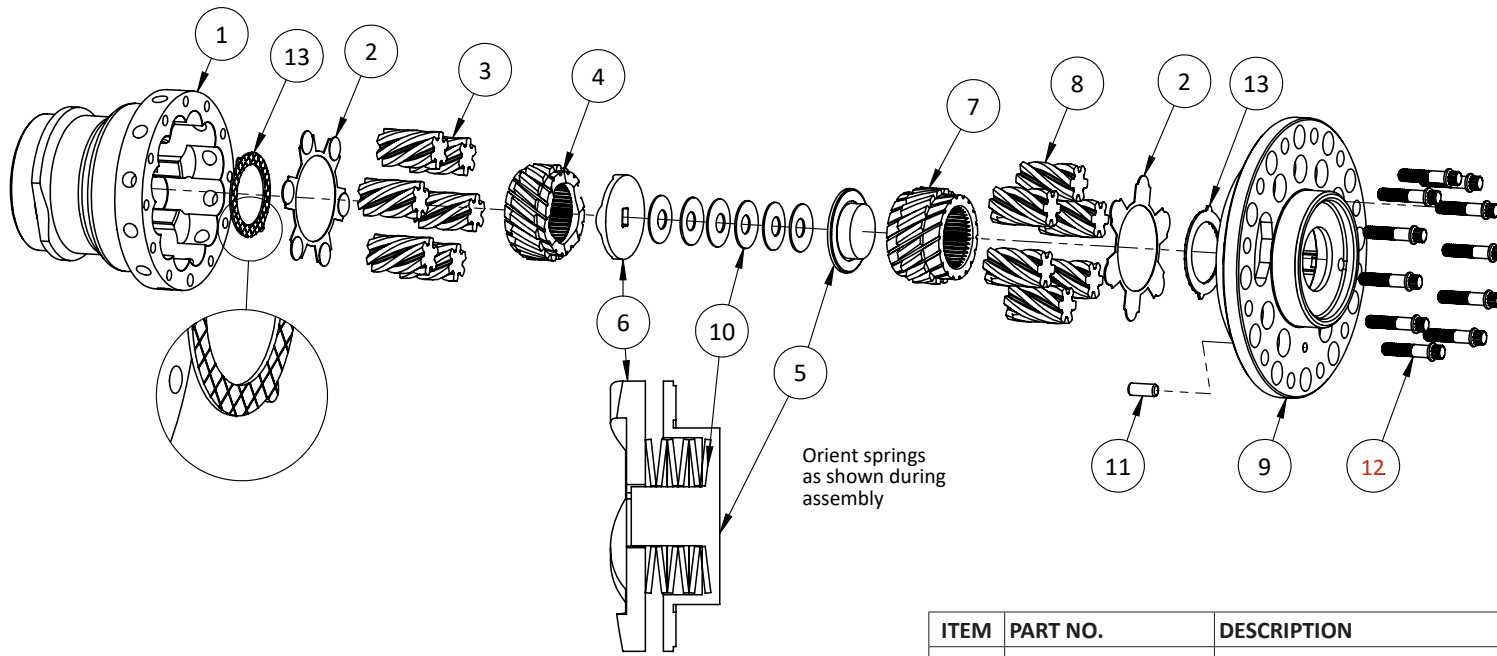


# HV-520 DIFF ASSEMBLY



ITEM	PART NO.	DESCRIPTION	QTY
1	HV-520-01	Diff Housing	1
2	HV-520-05	Friction Plate for Planet Gears	2
3	HV-520-06	Planetary Gear, LH Helix	6
4	HV-520-09	Sun Gear, RH Helix	1
5	HV-520-03	Preload Hub, Pin Side	1
6	HV-520-04	Preload Hub, Ramp Side	1
7	HV-520-08-A	Sun Gear, LH Helix (Use with HV-520-07)	1
8	HV-520-07	Planetary Gear, RH Helix (Use with HV-520-8A)	6
9	HV-520-02-A	Diff Cover	1
10	HV-520-10	Disc Spring for Preload Hub	6
11	H-DM8X20	Locating Dowel	1
12	H-BM8X35XHD	M8x35 12-Point Bolt Torque to 22 ft-lb Loctite 272 (red)	11
13	HV-520-11	Friction Plate for Sun Gear	2

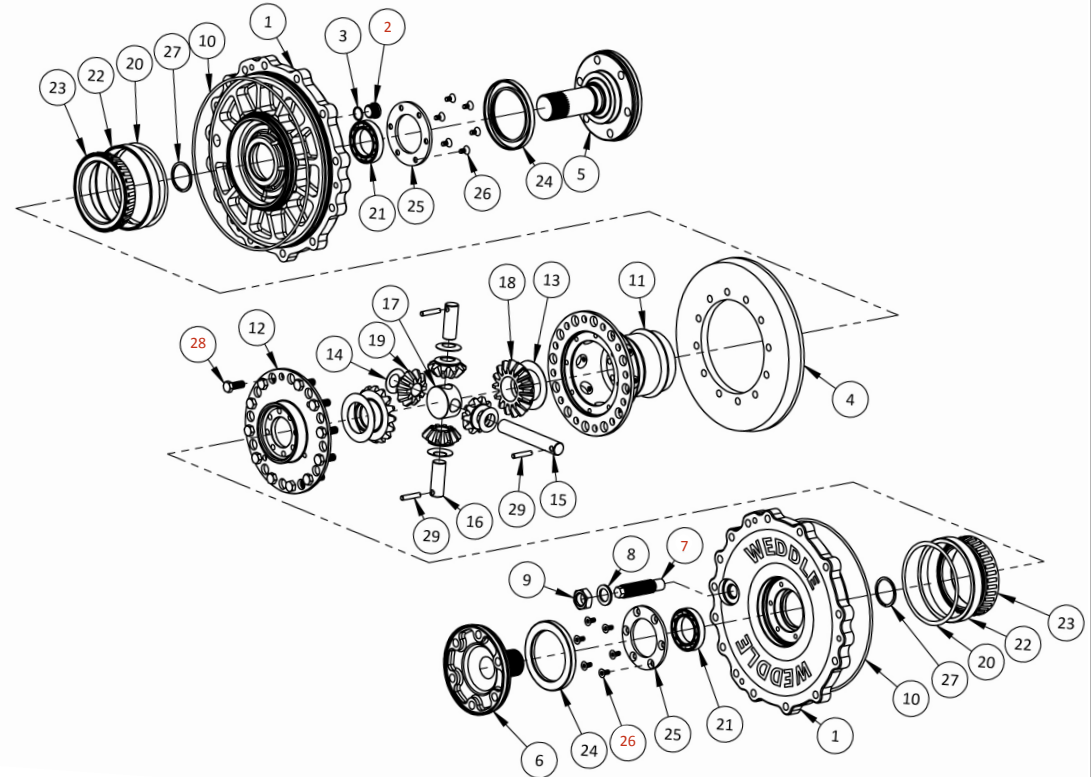


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Drawing No: HV-520-ASSY  
Drawing Name: HV-520 Diff, Exploded  
Drawn By: TS  
Revised: 03/17/2022

ITEM	PART NO.	DESCRIPTION	QTY
01	HV-6934	Sidecover	2
02	AGB-00109-A	3/4-16" Plug W/O-Ring <b>Torque to 40 ft.lb Lube O-ring</b>	1
03	H-OR34	Replacement O-Ring	1
04	HV1-RP###	Ring Gear ( ### denotes ratio )	1
(04)	HV24-RP###	Ring Gear ( ### denotes ratio )	1
(04)	HV25-RP###	Ring Gear ( ### denotes ratio )	1
05	MD-5930L	930 Final Drive Flange, Long	1
(05)	HV-5930L	Heavy Duty 930 Final Drive Flange, Long	1
(05)	HV-5934L	Heavy Duty 934 Final Drive Flange, Long	1
06	MD-5930S	930 Final Drive Flange, Short	1
(06)	HV-5930S	Heavy Duty 930 Final Drive Flange, Short	1
(06)	HV-5934S	Heavy Duty 934 Final Drive Flange, Short	1
07	MD-945	Bronze Load Bolt Seal threads with 3-Bond sealant or equivalent <b>Seal with 3-Bond</b>	1
08	AGB-00197	Washer for Load Bolt Jam Nut	1
09	H-JN3416	3/4" Jam Nut Plated	1
10	HV-922	O-ring for Sidecover	2
11	MD-535	Diff Housing	1
12	MD-530	Diff Cover	1
13	MD-552	Sidegear Thrust Washer	2
14	MD-551	Spider Gear Thrust Washer	4
15	MD-538	Cross Shaft, Long	1
16	MD-539	Cross Shaft, Short	2
17	MD-540	Diff Center Block	1
18	MD-545HD	Sidegear	2
19	MD-550	Spider Gear	4
(19)	MD-550HD	Spider Gear, Heavy Duty	4
20	MD-500#	Diff Shim (7 Sizes Available Denoted by #)	2
21	MD-422	Ball Bearing for Drive Flange	2
22	MD-420	Diff Bearing Cup for HV, MD, LQ, S4, S5 trans	2
23	MD-421	Diff Bearing Cone for HV, MD, LQ, S4, S5 trans	2
24	MD-920	FD Seal for HV, MD, S4, S5 trans	2
25	MD-925	Final Drive Flange Bearing Retainer Plate	2
26	HV-926	Torx Bolt for Output Bearing Plate <b>Torque to 8 ft. lb. with LT-243 (blue)</b>	12
27	MD-930	Spiral Lock for 930 Drive Flange	2
27	MD-934	Spiral Lock for HD 930 and 934 Drive Flanges	2
28	H-B38241000X-HD	3/8-24X1.00" XHD Ring Gear Bolt <b>Torque to 55 ft. lb. with LT-272 (red)</b>	12
(28)	H-B38241000ARP	ARP Ring Gear Bolts <b>Torque to 55 ft. lb. with LT-272 (red)</b> <b>Clearance case for bolt heads</b>	12
29	H-D141375	Dowel Pin for Diff Cross Shaft	3

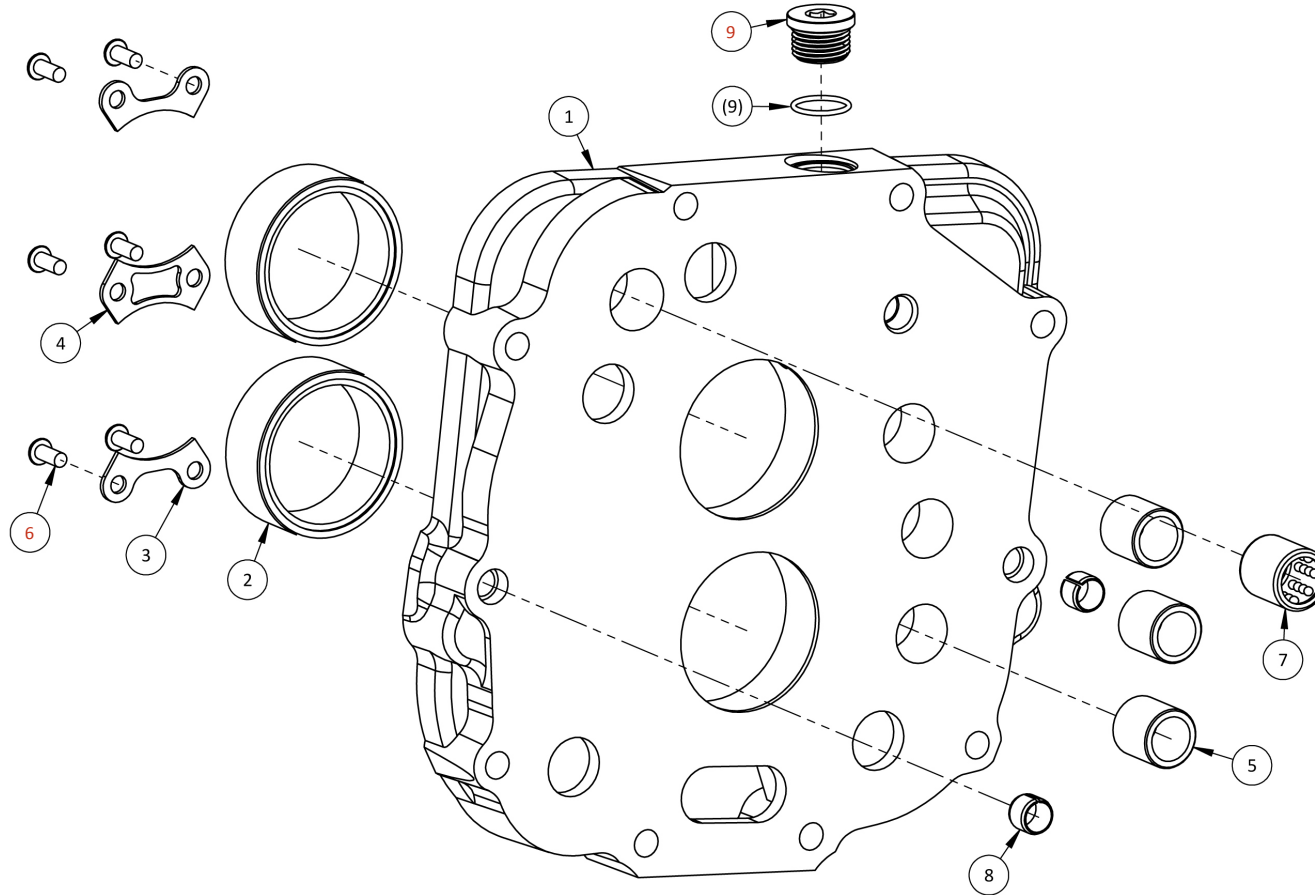
## WEDDLE HV DIFF ASSEMBLY



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Drawing No: HV-EXP-DIFF  
Drawing Name: HV Diff Assembly  
Drawn By: RX  
Revised: 4/7/2025

# WEDDLE HV2 600 ASSEMBLY



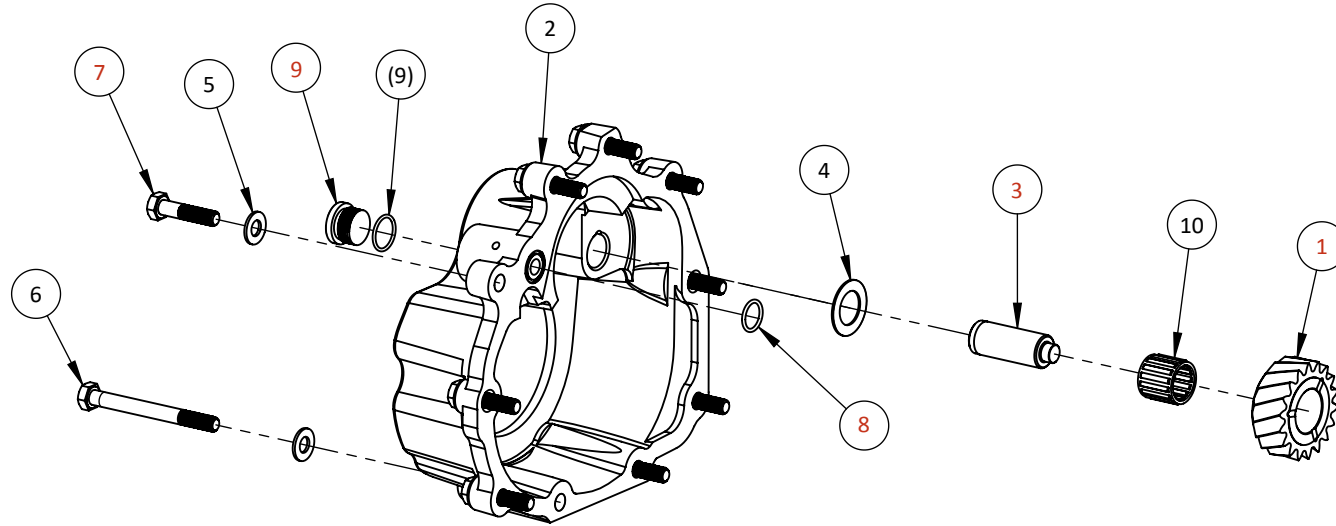
ITEM	PART NO.	DESCRIPTION	QTY
1	HV2-600	Mid Plate	1
2	HV2-409	Roller Bearing for Mid Plate	2
0	HV2-935	Bearing Retainer Plate	2
4	HV2-936	Bearing Retainer Plate	1
5	HV2-923	HV2 Shift Rail Bushing	3
6	H-BM5X12BH	M5X12 Button Head Bolt Torque to 65 in. lb. with LT-243 (blue)	6
7	091-301-207	Linear Motion Bearing	1
8	02M-301-153-A	Hollow Dowel Sleeve	2
9	AGB-00109-A	3/4"-16 UNF Steel Fill Plug, w/O-ring Torque to 40 ft. lb. Lube O-Ring	1
(9)	H-OR34	OPTION Replacement O-Ring for 3/4" UNF Fitting	1



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Drawing No: HV2-EXP-600  
Drawing Name: HV2 Mid Plate Exploded View  
Drawn By: DS  
Revised: 03/17/2022

# WEDDLE HV24 FRONT HOUSING



ITEM	PART NO.	DESCRIPTION	QTY
1	HV2-RI	Reverse Intermediate Idler Gear <i>Chamfer on gear faces nosecone</i>	1
2	HV24-605	Front Housing for HV2 4-Speed	1
3	HV-9374-02	Reverse Idler Shaft for Reverse Int Idler <i>See bearing retainer plate assembly, drawing HV2-EXP-607</i>	1
4	091-311-517	Thrust Washer for Reverse Intermediate Idler	1
5	H-WM8-17	8mm Flat Washer, 17.6mm OD	10
6	H-BM8X80H	M8X80 Hex Bolt, Class 8.8 <i>Torque to 18 ft. lb. with LT 243 (blue)</i>	2
7	H-BM8X35H	M8X35 Hex Bolt, Class 8.8 <i>Torque to 18 ft. lb. with LT 243 (blue)</i>	8
8	HV2-913-17	O-Ring for Oil Passage in Front Housing <i>Used with internal oil pump option</i>	1
9	AGB-00109-A	3/4-16 Steel Fill Plug w/O-Ring <i>Torque to 40 ft. lb. Lube O-Ring</i>	1
(9)	H-OR34	O-Ring for 3/4-UNF Fitting	1
10	091-311-523	Needle Bearing for Reverse Int Idler	1

  
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Drawing No: HV24-EXP-605  
 Drawing Name: HV24 Front Assy  
 Drawn By: DS  
 Revised: 03/17/2022

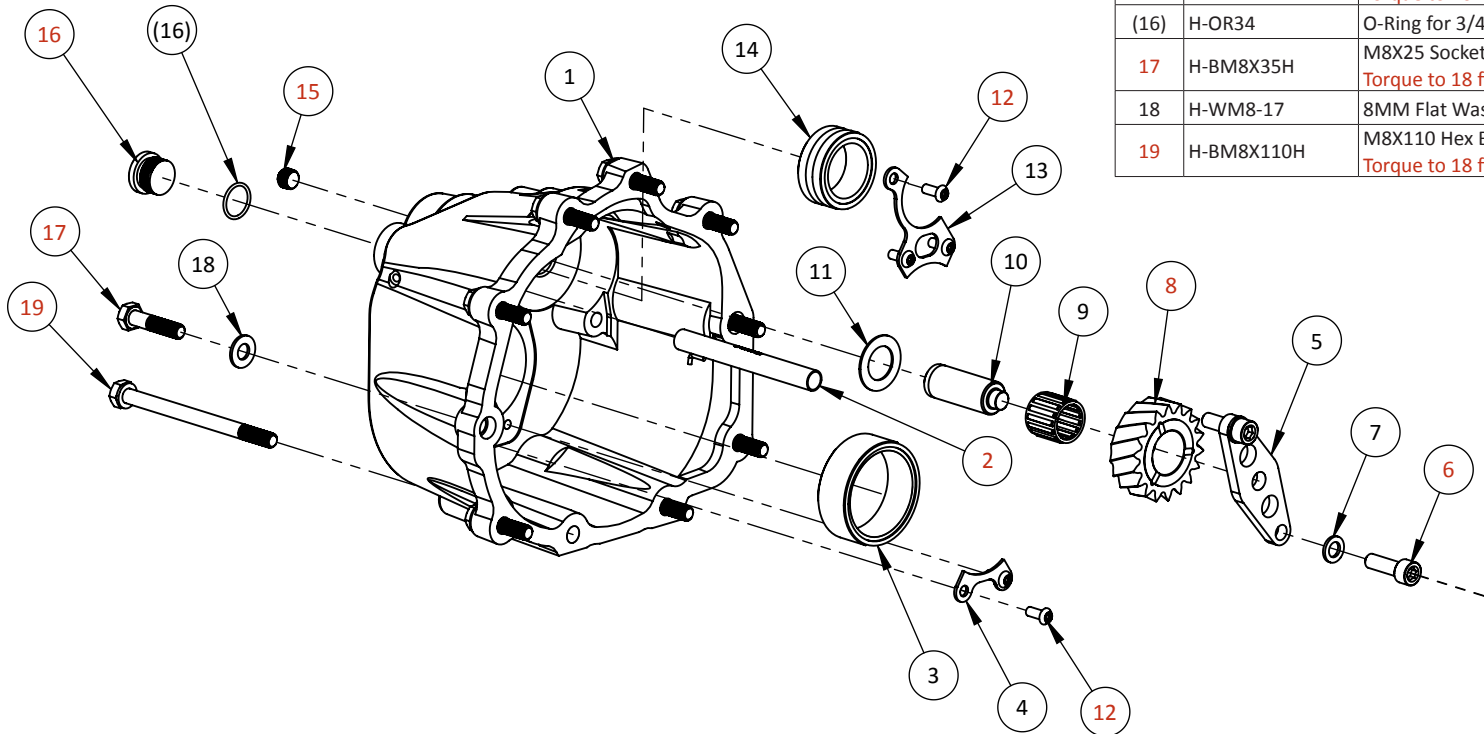


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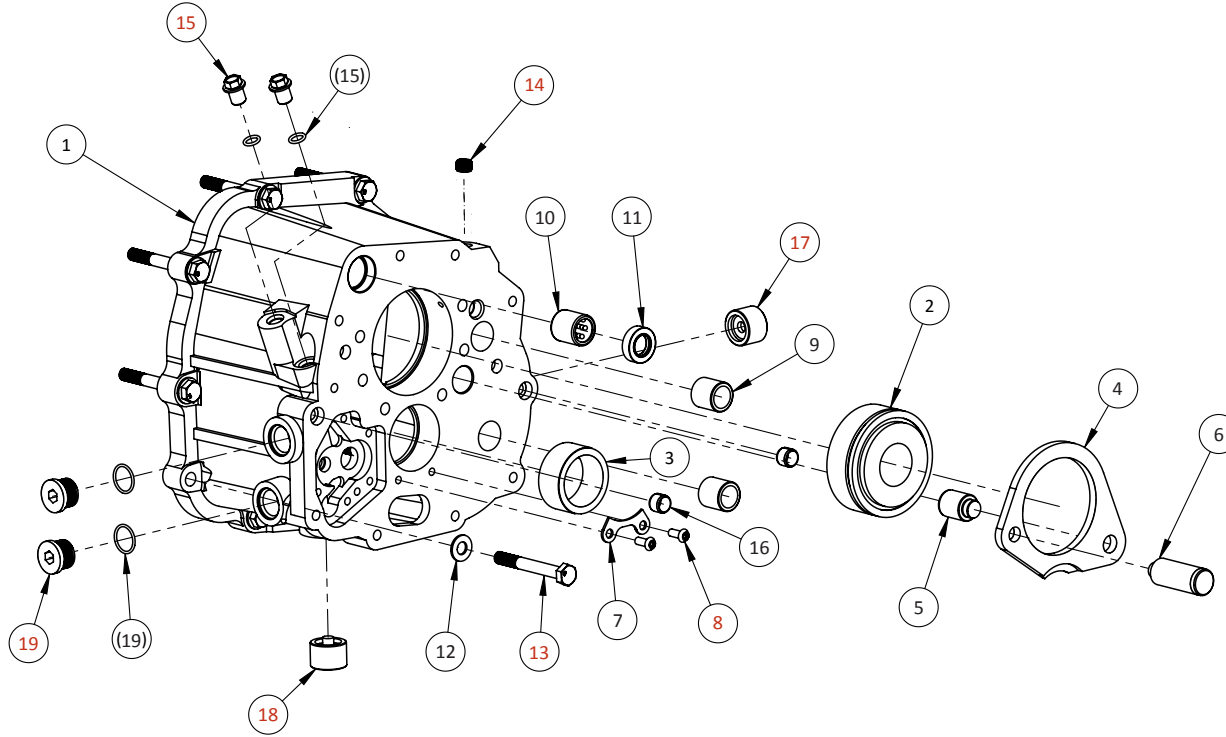
Drawing No: HV25-EXP-605  
Drawing Name: HV25 Front Assy  
Drawn By: DS  
Revised: 03/17/2022

## WEDDLE HV25 FRONT HOUSING

ITEM	PART NO.	DESCRIPTION	QTY
01	HV25-605	Front Housing for HV2 5-Speed	1
02	HV2-913-16	Oil Spray Bar for 5th & Rev <i>Use only with internal oil pump option</i>	1
03	HV2-409	Roller Bearing	1
04	HV2-935	Bearing Retainer for HV2	1
05	HV25-946	Reverse Idler Shaft Support Plate	1
06	H-BM8X25SH	M8X25 Socket Head Cap Bolt <i>Torque to 18 ft. lb. with LT 243 (blue)</i>	2
07	H-WM8-14	8MM Flat Washer, 14.3MM OD	2
08	HV2-RI	Reverse Intermediate Idler Gear <i>Chamfer on gear faces away from support plate</i>	1
09	091-311-523	Reverse Intermediate Idler Needle Bearing	1
10	HV-9374-02	HV Reverse Idler Shaft	1
11	091-311-517	Thrust Washer for Reverse Intermediate Idler	1
12	H-BM5X12BH	M5X12 Button Head Bolt, Torx <i>Torque to 65 in. lb. with LT 243 (Blue)</i>	5
13	HV25-937	Bearing Retainer Plate for HV25 Front Housing	1
14	HV25-429	Needle Bearing for end of HV25 MS	1
15	H-PLUG-18PISD	1/8" Pipe Plug <i>Torque to 14 ft. lb. with 3-BOND sealant</i>	1
16	AGB-00109-A	3/4-16 Steel Plug w/O-Ring <i>Torque to 40 ft. lb. Lube O-Ring</i>	1
(16)	H-OR34	O-Ring for 3/4-UNF Fitting	1
17	H-BM8X35H	M8X35 Socket Head Cap Bolt <i>Torque to 18 ft. lb. with LT 243 (Blue)</i>	8
18	H-WM8-17	8MM Flat Washer, 17.6MM OD	8
19	H-BM8X110H	M8X110 Hex Bolt, Class 8.8 <i>Torque to 18 ft. lb. with LT 243 (Blue)</i>	2



# WEDDLE HV24 GEAR CARRIER ASSEMBLY



ITEM	PART NO.	DESCRIPTION	QTY
1	HV2-607	Gear Carrier Housing	1
2	HV2-425	Front Mainshaft Bearing	1
3	HV2-415	Pinion Shaft Roller Bearing	1
4	HV24-915	Main Shaft Bearing Thrust Plate	1
5	9374-01	Dowel Shaft for Bearing Retainer Plate	1
6	9374-02	HV24 Reverse Idler Shaft	1
7	HV2-935	Bearing Retainer Plate	1
8	H-BM5X12BH	M5X12 Button Head Bolt, TORX Head Torque to 65 in. lb. LT 243 (blue)	2
9	HV2-923	HV2 Shift Rail Bushing (ream to fit after installation)	2
10	091-301-207	Linear Motion Bearing	1

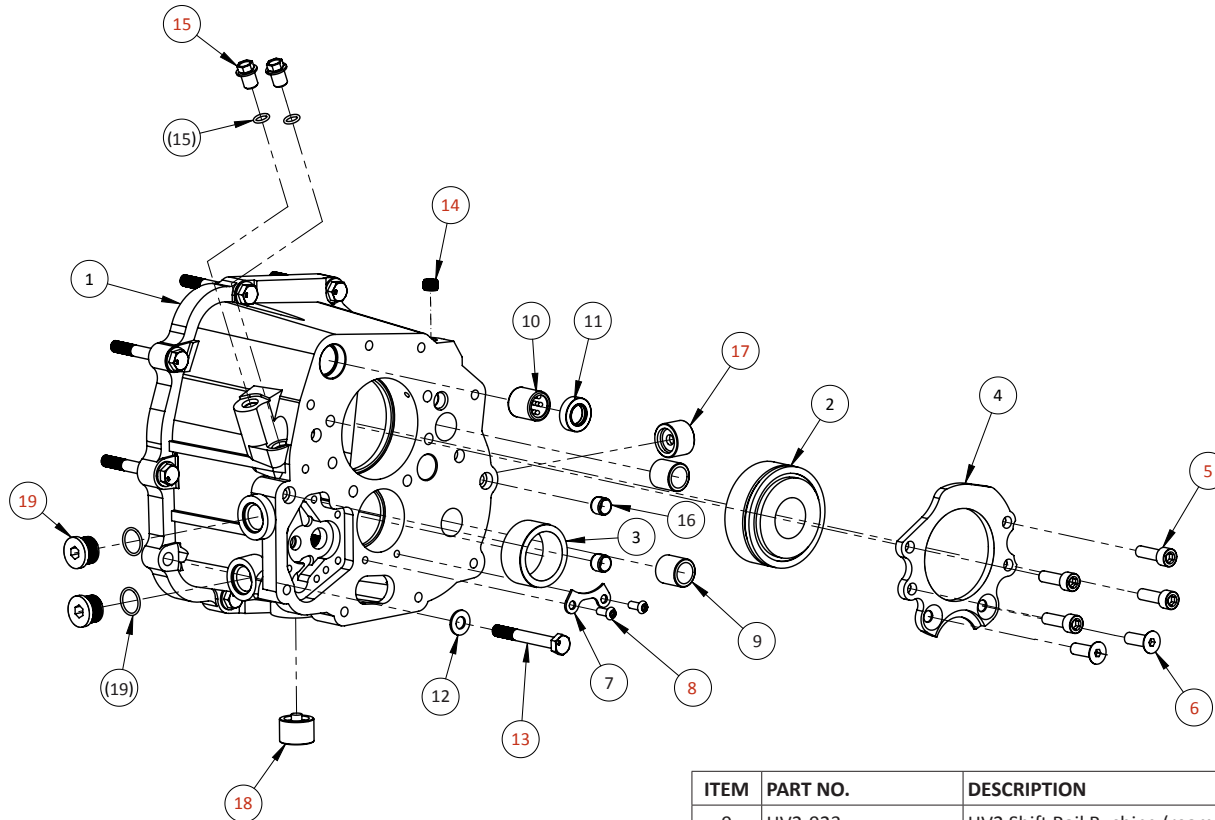
ITEM	PART NO.	DESCRIPTION	QTY
11	001-301-227	VW Nosecone Seal	1
12	H-WM8-17	8mm Flat Washer 17.60mm OD	10
13	H-BM8X65H	M8X65 Hex Bolt, Class 8.8 Torque to 18 ft. lb. with LT 243 (blue)	10
14	H-PLUG-18PISD	1/8" Pipe Plug, Internal Socket Torque to 14 ft. lb. with 3-Bond	1
15	HV2-913-13	M10x1.0x12 Bolt w/O-Ring Torque to 12 ft. lb. Lube O-Ring	2
(15)	HV2-913-13-1	Replacement O-Ring for M10 Bolt	2
16	02M-301-153-A	Hollow Dowel Sleeve, 094	2
17	012-301-127-F	Oil Fill Plug Torque to 35 ft. lb. with Loctite 243 (Blue)	1
18	113-301-141-A	Drain Plug, Short Magnet Torque to 35 ft. lb. with Loctite 243 (Blue)	1
19	AGB-00109-A	3/4"-16 Steel Fill Plug, w/O-Ring Torque 40 ft. lb. Lube O-ring	2
(19)	H-OR34	O-Ring for 3/4-UNF Fitting	2



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Drawing No: HV24-GC-ASSY  
Drawing Name: HV24 Gear Carrier Exploded View  
Drawn By: RX  
Revised: 6/19/23

# WEDDLE HV25 GEAR CARRIER ASSEMBLY



ITEM	PART NO.	DESCRIPTION	QTY
1	HV2-607	Gear Carrier Housing	1
2	HV2-425	Front Mainshaft Bearing	1
3	HV2-415	Pinion Shaft Roller Bearing	1
4	HV25-915	Main Shaft Bearing Thrust Plate	1
5	H-BM8X25SH	M8X25 Socket Head Cap Bolt Torque to 18 in. lb. LT 243 (blue)	4
6	H-BM8X25FSH	M8X25 Flat Socket Head Bolt Torque to 18 in. lb. LT 243 (blue)	2
7	HV2-935	Bearing Retainer Plate	1
8	H-BM5X12BH	M5X12 Button Head Bolt, TORX Head Torque to 65 in. lb. LT 243 (blue)	2

ITEM	PART NO.	DESCRIPTION	QTY
9	HV2-923	HV2 Shift Rail Bushing (ream to fit after installation)	2
10	091-301-207	Linear Motion Bearing	1
11	001-301-227	VW Nosecone Seal	1
12	H-WM8-17	8mm Flat Washer 17.60mm OD	10
13	H-BM8X65H	M8X65 Hex Bolt, Class 8.8 Torque 18 ft. lb. with LT 243 (blue)	10
14	H-PLUG-18PISD	1/8" Pipe Plug, Internal Socket Torque 14 ft. lb. with 3-Bond	1
15	HV2-913-13	M10x1.0x12 Bolt w/O-Ring Torque to 12 ft. lb. Lube O-Ring	2
(15)	HV2-913-13-1	Replacement O-Ring for M10 Bolt	2
16	02M-301-153-A	Hollow Dowel Sleeve, 094	2
17	012-301-127-F	Oil Fill Plug Torque to 35 ft. lb. with Loctite 243 (Blue)	1
18	113-301-141-A	Drain Plug, Short Magnet Torque to 35 ft. lb. with Loctite 243 (Blue)	1
19	AGB-00109-A	3/4"-16 Steel Fill Plug, w/O-Ring Torque to 40 ft. lb. Lube O-ring	2
(19)	H-OR34	O-Ring for 3/4-UNF Fitting	2

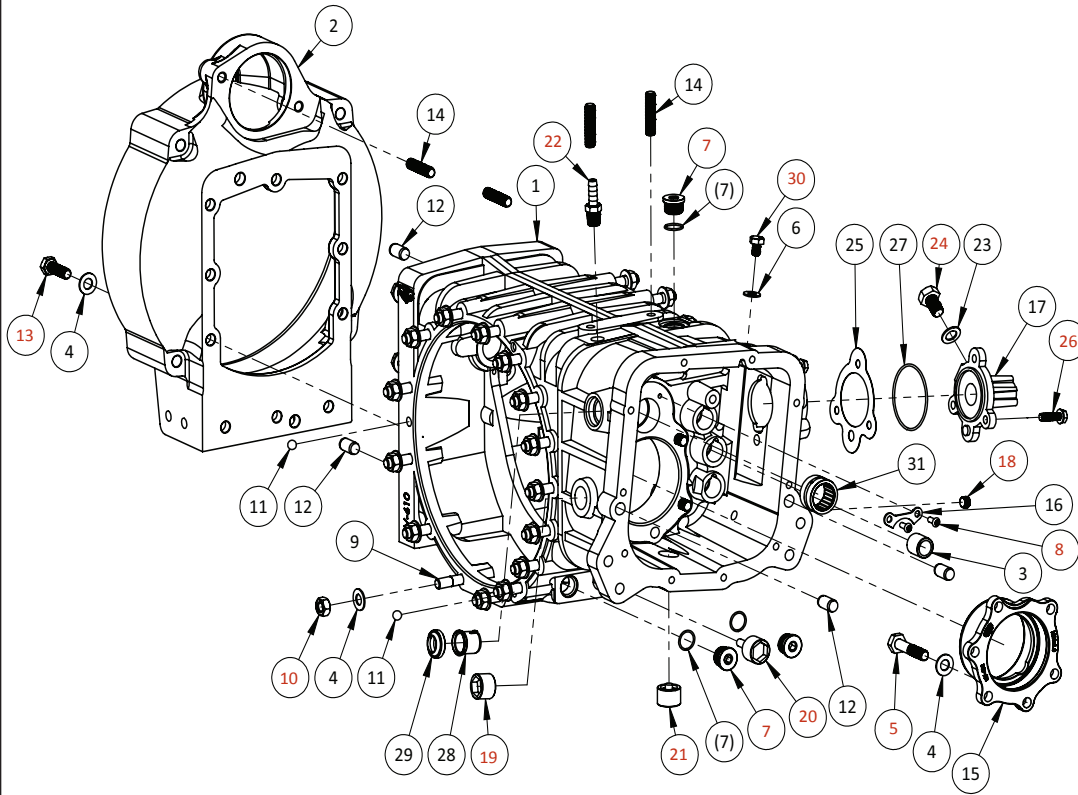


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Drawing No: HV25-GC-ASSY  
Drawing Name: HV25 Gear Carrier Exploded View  
Drawn By: RX  
Revised: 6/20/23



# WEDDLE HV2 MAIN CASE



ITEM	PART NO.	DESCRIPTION	QTY
01	HV-610	Main Case for HV Trans	1
02	AGB-00101-A	Bell Housing, VW Style	1
(02)	AGB-00101-B	Bell Housing, LS style	1
03	HV2-923	HV2 Shift Rail Bushing	1
04	H-WM10	10mm Flat Washer, Hardened	46
05	H-BM10X50H-FFT	M10x1.0x50 Hex Bolt, Extra Fine <b>Torque 50 ft. lb. with LT-272 (Red)</b>	6
06	H-WM8-17	8mm Flat Washer 17.6mm OD	1
07	AGB-00109-A	3/4-16 Steel Plug w/O-Ring <b>Torque to 40 ft. lb. lube o-ring</b>	3
(07)	H-OR34	Replacement O-Ring for 3/4" UNF Fitting	3
(07)	H-AN834	OPTION AN8-3/4x16 fitting, w/internal oil pump only <b>Torque 35 ft.lb. lube o-ring</b>	1
08	H-BM5X12BH	M5X12 Button Head Bolt, Torx Head <b>Torque 65 in. lb. with LT-243 (Blue)</b>	2
09	H-SM10X55	M10X55 Stud, Class 10.9	30
10	H-NM10	M10X1.5 Nut with 16mm Hex <b>Torque 40 ft. lb. with LT-243 (Blue)</b>	30
11	N-025-667-2	Detent Ball (9mm)	6
12	H-DM12X25	M12X25 Dowel, Hardened Steel	4
13	H-BM10X32H	M10X32 Hex Bolt, Class 10.9 <b>Torque 32 ft. lb. with LT-243 (Blue)</b>	10
14	H-SM10X45	M10X45 Stud	4
15	HV-402	Pinion Bearing Carrier	1
(15)	HV-402+	Pinion Bearing Carrier, Oversize	1
16	HV-993	HV Rear Main Shaft Bearing Retainer Plate	1
17	091-301-232-A	094 Selector Shaft Cover	1
18	H-PLUG-18PISD	1/8" Pipe Plug, Internal Socket <b>Torque 14 ft. lb with 3-Bond</b>	1
19	012-301-127-F	Oil Fill Plug <b>Torque to 35 ft. lb. with Loctite 243 (Blue)</b>	1
20	091-301-141-A	Drain Plug, Long Magnet <b>Torque to 35 ft. lb. with Loctite 243 (Blue)</b>	1
21	113-301-141-A	Drain Plug, Short Magnet <b>Torque to 35 ft. lb. with Loctite 243 (Blue)</b>	1
22	H-VENT-14PX516B	Vent, 1/4" NPT X 5/16" Barb <b>Torque to 22 ft. lb. with 3-BOND</b>	1
23	020-301-244	Crush Washer, 094 Back Up Light Switch	1
24	H-BM12X20H-FT	Plug for 094 Reverse Light Switch <b>Torque to 30 ft. lb. with LT-243 (Blue)</b>	1
25	091-301-278-B	094 Selector Shaft Cover Gasket	1
26	H-BM7X25H	Bolt for Shift Shaft Cover <b>Torque to 14 ft. lb. with LT-243 (Blue)</b>	3
27	094-301-278-A	O-Ring for 094 Selector Cover	1
28	020-141-711-A	094 Selector Shaft Bushing	1
29	020-141-733	094 Selector Shaft Seal, No Spring	1
30	H-BM8X12H	M8X12 Hex Bolt, Class 8.8 <b>Torque to 14 ft. lb. with LT-243 (Blue)</b>	1
31	HV2-430	Rear Mainshaft Bearing	1

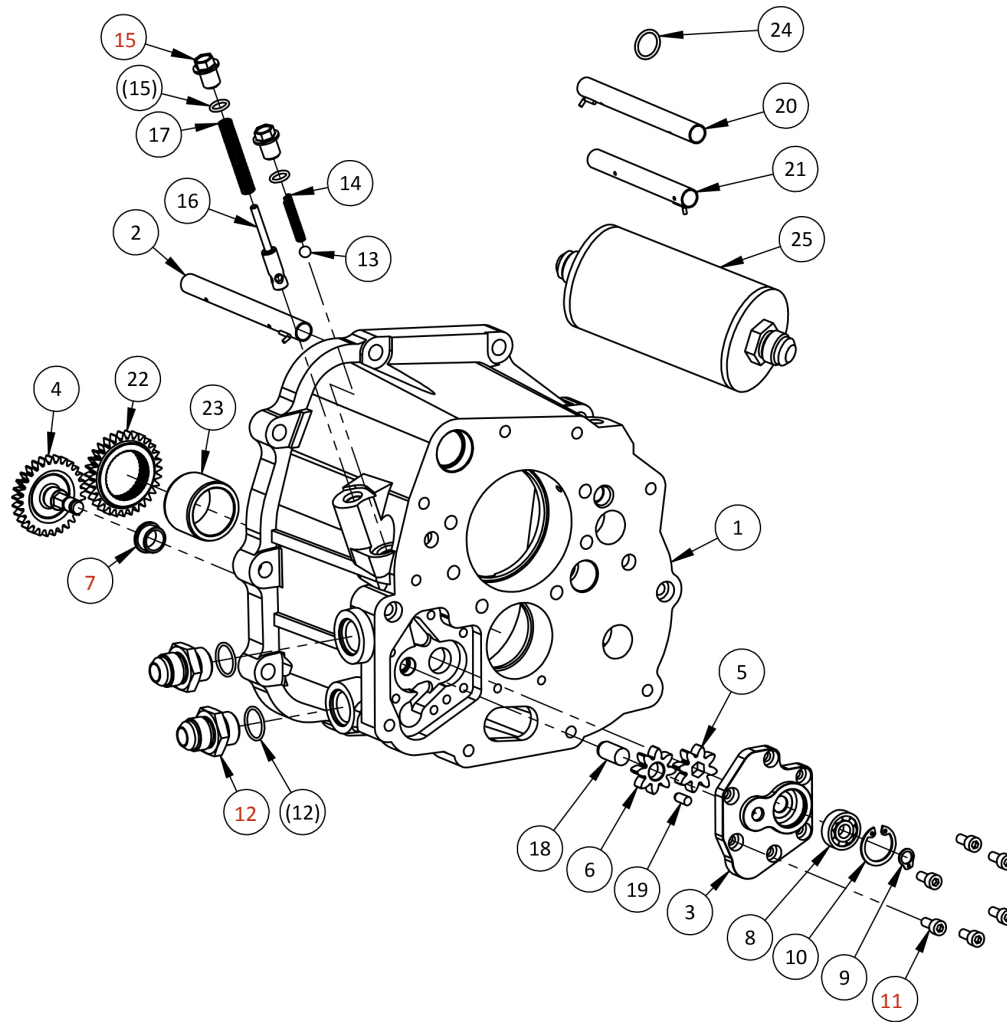


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Drawing No: HV2-EXP-610  
Drawing Name: HV2 Mid Plate Exploded View  
Drawn By: DS  
Revised: 4/7/2025



# WEDDLE HV2 OIL PUMP ASSEMBLY



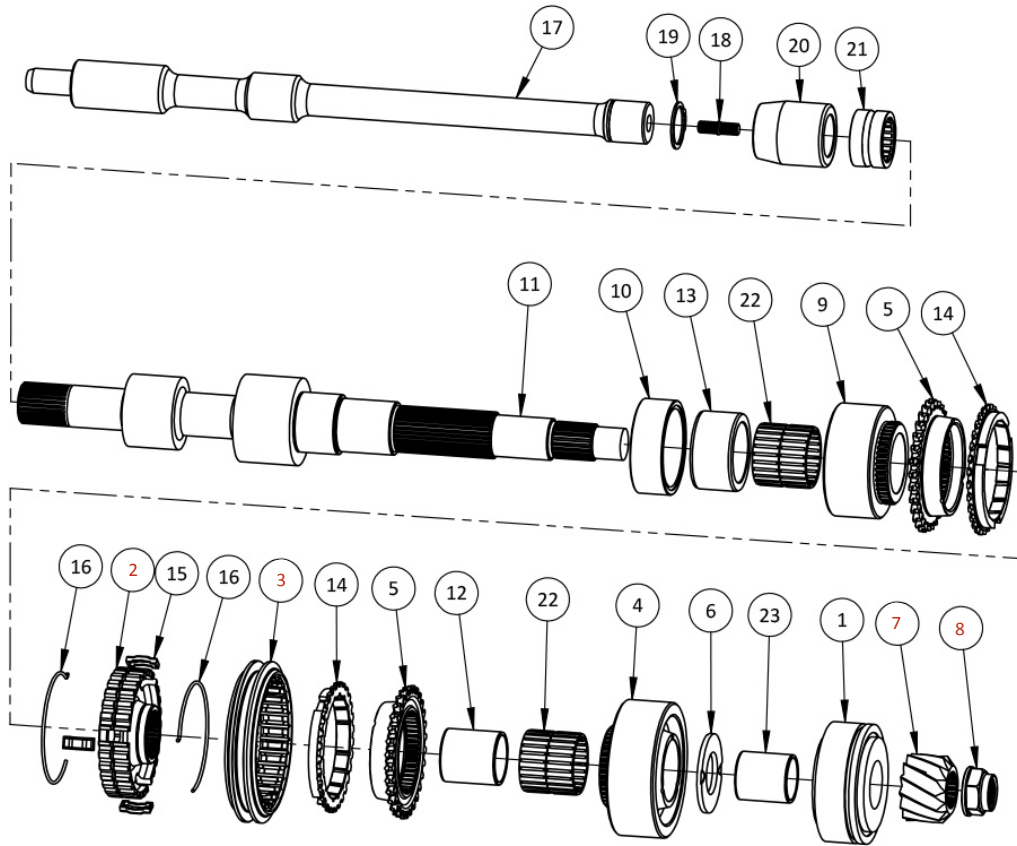
ITEM	PART NO.	DESCRIPTION	QTY
01	HV2-607	Gear Carrier Housing	1
02	HV2-913-15	Oil Spray Bar, 3rd & 4th Gear	1
03	HV2-913-05	Cover for HV2 Oil Pump	1
04	HV2-913-02	Oil Pump Gear Drive Shaft	1
05	HV2-913-03	Oil Pump Gear w/ Internal Hex	1
06	HV2-913-04	Oil Pump Idler Gear	1
07	HV2-913-06	Bushing for Oil Pump <i>Ream to size after installation</i>	1
08	HV2-913-07	Ball Bearing for Oil Pump	1
09	HV2-913-08	Circlip for Oil Pump Shaft	1
10	HV2-913-09	Circlip for Oil Pump Bearing	1
11	H-BM5X12SH	M5X12 Socket Head Cap Bolt <i>Torque 65 in. lb. with LT 243 (blue)</i>	6
12	H-AN834	AN-8x3/4-16 Straight Fitting (2 go in Main Case) <i>Torque 35 ft. lb. Lube O-Ring</i>	4
(12)	H-OR34	Replacement O-Ring for 3/4-UNF Fitting	4
13	H-BALL-0250	1/4" Steel Ball	1
14	HV2-913-10	Spring for Pressure Relief Valve Assy	1
15	HV2-913-13	M10x1.0x12 Bolt With O-Ring <i>Torque 12 ft. lb. Lube O-Ring</i>	2
(15)	HV2-913-13-1	Replacement O-Ring for M10 Bolt	2
16	HV2-913-12	Plunger for Pressure Regulator Valve Assy	1
17	HV2-913-11	Spring for Pressure Regulator Valve Assy	1
18	H-DM10X20	M10X20 Dowel, Hardened Steel	1
19	H-DM5X12	M5X12 Dowel, Hardened Steel	1
20	HV2-913-14	Oil Spray Bar, 1st & 2nd Gear	1
21	HV2-913-16	Oil Spray Bar, 5th & Reverse (HV25 Only)	1
22	HV2-913-01	Oil Pump Drive Gear on Pinion Shaft	1
23	HV2-424A	Pinion Shaft Bearing Race for Oil Pump Option	1
24	HV2-913-17	O-Ring for Oil Passage in HV24 Nose Cone (HV24 Only)	1
25	9-FILTER2	Oil Filter, 2 of 9-CTC-AH8 required	1



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Drawing No: HV2-EXP-913  
Drawing Name: HV2-913-Assy  
Drawn By: DS  
Revised: 4/7/2025

# WEDDLE HV24 MAIN SHAFT ASSEMBLY



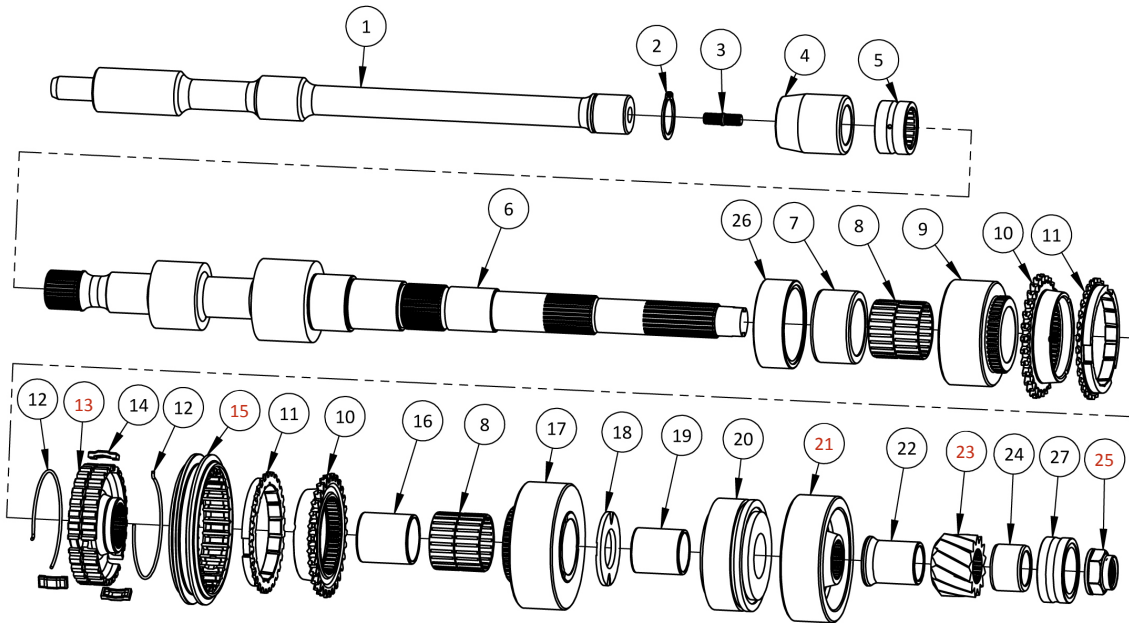
ITEM	PART NO.	DESCRIPTION	QTY
01	HV2-425	Front Mainshaft Bearing	1
02	HV2-844	3-4 Slider Hub Identifying groove on OD of hub goes to 3rd gear	1
03	091-311-315-B	3-4 Slider Machined groove on side of slider faces 4th gear (opposite of the groove on hub)	1
04	HV2-####	4th Gear Idler ( #### denotes ratio )	1
05	8D8-CONE	Syncho Cone (37mm) Use with 1.50 and taller ratios	2
(05)	8D6-CONE	Syncho Cone (36mm) Use with 1.56 and lower ratios	2
06	113-311-151-D	4th Gear Thrust Washer	1
07	HV2-RM	Reverse Gear on Mainshaft Chamfered side faces lock nut	1
08	5AB-NUT	Lock Nut for End of Mainshaft Torque 200 ft. lb. with LT-272 (red) Peen lock tab after tightening	1
09	HV2-####	3rd Gear Idler ( #### denotes ratio )	1
10	HV2-409	Needle Roller Bearing for Mid Plate	1
11	HV24-#####	HV24 Mainshaft ( #### denotes ratio )	1
12	HV2-427	4th Gear Bearing Race 28x32x34	1
13	HV2-410	Intermediate Bearing Race 36x47x25	1
14	091-311-295-A	Synchronizer 3rd and 4th	2
15	091-311-313	Syncho Catch Keys	3
16	113-311-249-A	Single Ended Wire Spring	2
17	HV-9106	Input Shaft	1
18	N-902-210-01	Connecting Stud, Input Shaft to Mainshaft	1
19	N-012-425-1	Input Shaft circlip	1
20	HV-933	Input Coupler	1
21	HV-430	Rear Mainshaft Bearing, Goes in Main Case	1
22	HV2-437	37mm Needle Bearing Use with 1.50 and taller ratios	2
(22)	HV2-436	36mm Needle Bearing (with Spacer Ring) Use with 1.56 and lower ratios	2
23	HV2-952	Inner Sleeve for Front Mainshaft Bearing	1



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Drawing No: HV2-EXP-MS4  
Drawing Name: HV24 Main Shaft Assy  
Drawn By: DS  
Revised: 03/17/2022

# WEDDLE HV25 MAIN SHAFT ASSEMBLY



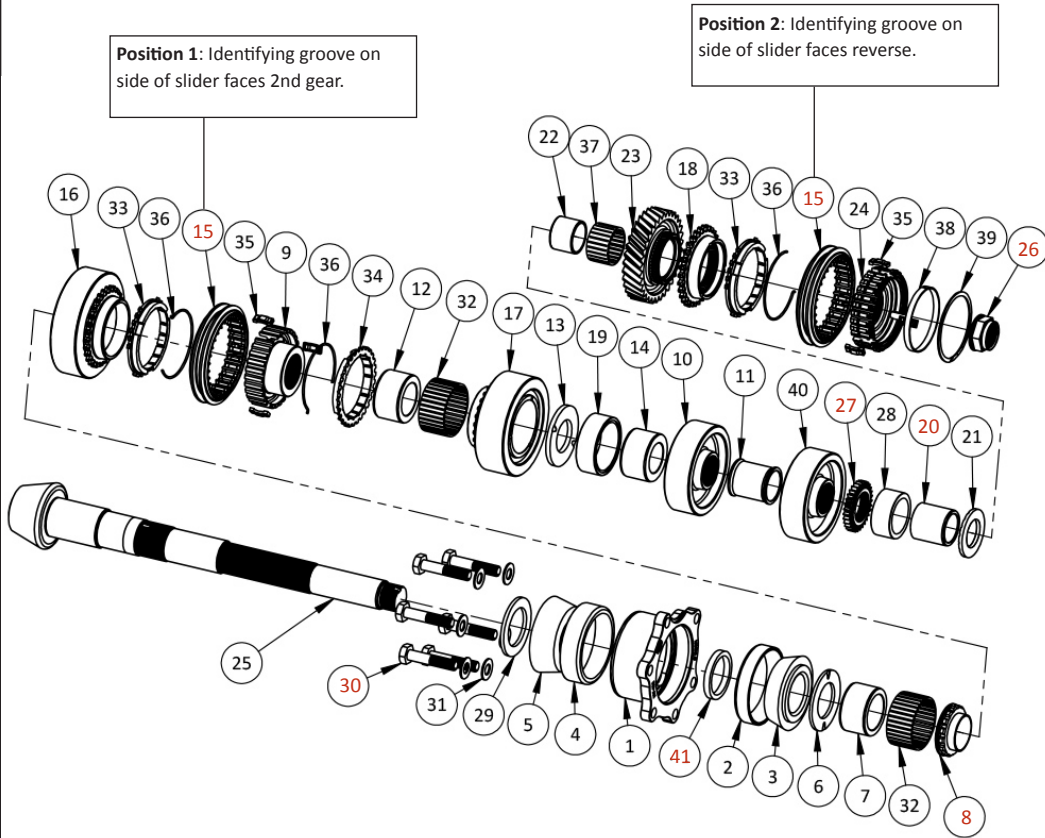
ITEM	PART NO.	DESCRIPTION	QTY
01	HV-9106	Input Shaft	1
02	N-012-425-1	Input Shaft Circlip	1
03	N-902-210-01	Connecting Stud, Input Shaft To Mainshaft	1
04	HV-933	Input Coupler	1
05	HV-430	Rear MS Bearing, Goes in Main Case	1
06	HV25-#####	HV25 Mainshaft ( ##### denotes ratio )	1
07	HV2-410	Intermediate Bearing Race 36x47x25	1
08	HV2-437	37mm needle bearing kit Use with 1.50 and taller ratios	2
(08)	HV2-436	336mm needle bearing kit Use with 1.56 and lower ratios	2
09	HV2-####I	3rd Gear Idler ( ### denotes ratio )	1
10	8D8-CONE	Synchro cone, 37mm Use with 1.50 and taller ratios	2
(10)	8D6-CONE	Synchro cone, 36mm Use with 1.56 and lower ratios	2
11	091-311-295-A	Synchronizer 3rd and 4th	2
12	113-311-249-A	Single Ended Wire Spring	2
13	HV2-844	3-4 Slider Hub <b>Identifying groove towards 3rd gear</b>	1
14	091-311-313	Synchro Catch Keys	3
15	091-311-315-B	3-4 Slider <b>Identifying groove towards 4th gear</b>	1
16	HV2-427	4th Gear Bearing Race 28x32x34	1
17	HV2-####I	4th Gear Idler ( ### denotes ratio )	1
18	113-311-151-D	Early 4th Gear Thrust Washer	1
19	HV2-952	Inner Sleeve for Bearing 25x29x32	1
20	HV2-425	Front Mainshaft Bearing	1
21	HV25-####S	5th Gear Splined ( ### denotes ratio ) <b>Larger shoulder towards mainshaft bearing</b>	1
22	HV25-929	5-R Spacer Sleeve	1
23	HV2-RM	Reverse Gear on Mainshaft <b>Chamfered side of gear towards 5th gear</b>	1
24	113-311-375-R4	Front Pinion Bearing Race	1
25	5AB-NUT	Lock Nut for End of Mainshaft <b>Torque 200 ft. lb. with LT-272 (red)</b>	1
26	HV2-409	Needle Roller Bearing for Mid Plate	1
27	HV25-429	Bearing for end of HV25 Mainshaft	1




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Drawing No: HV2-EXP-MS5  
Drawing Name: HV25 Main Shaft Assy  
Drawn By: DS  
Revised: 03/17/2022

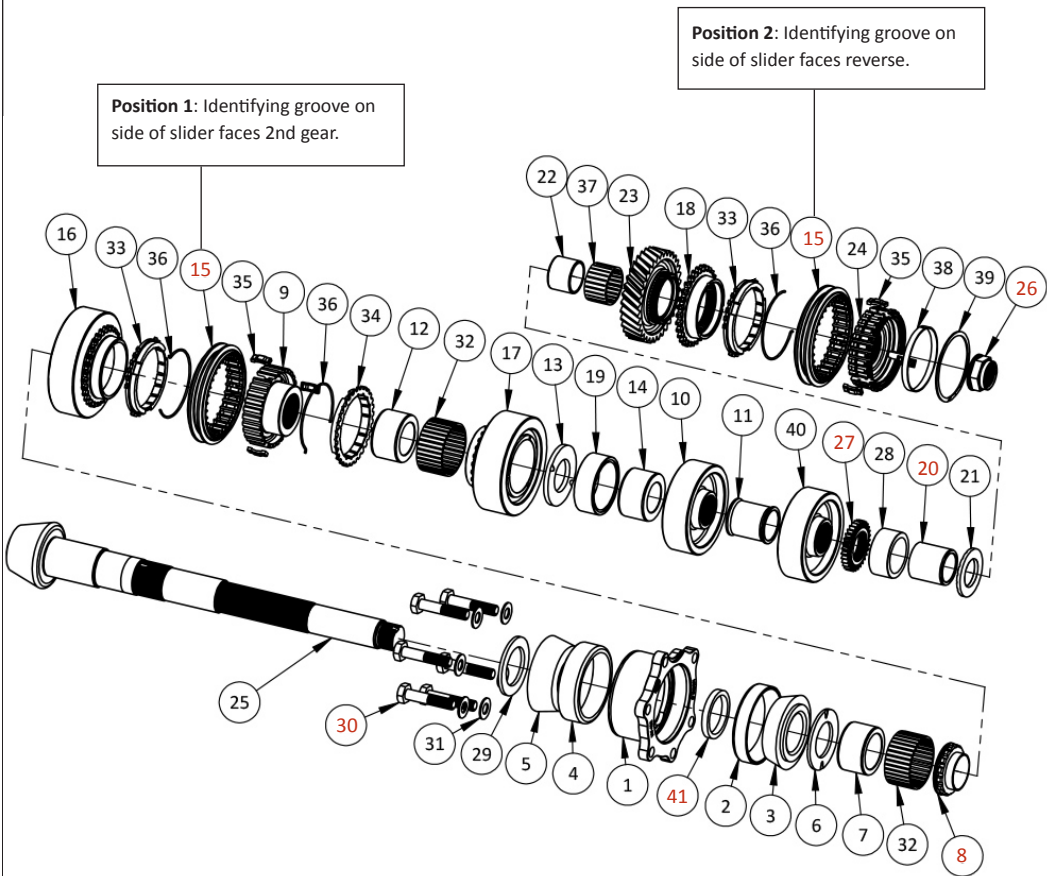
# WEDDLE HV24 PINION SHAFT ASSEMBLY



ITEM	PART NO.	DESCRIPTION	QTY
01	HV-402	Pinion Brg Carrier	1
(01)	HV-402+	Oversize Pinion Brg Carrier	1
02	MD-404	Pinion Bearing Cup, Small	1
03	MD-403	Pinion Bearing Cone, Small	1
04	MD-406	Pinion Bearing Cup, Large	1
05	MD-405	Pinion Bearing Cone, Large	1
06	113-311-221-A	Late 1st Gear Thrust Washer with Oil Slots	1
07	HV2-414	1st Gear Bearing Race	1
08	113-311-237-A	Late Small Round Nut Torque 152 lb. with LT-272 (red) Peen lock tab after tightening	1
09	HV2-843	1-2 Slider Hub	1
10	HV2-###S	3rd Gear Splined ( ### denotes ratio )	1
11	HV2-903	HV2 3-4 Spacer Sleeve on Pinion Shaft	1
12	HV2-417	2nd Gear Bearing Race	1
13	HV2-921	HV2 2nd Gear Thrust Washer	1
14	HV2-408	Intermediate Bearing Race on Pinion Shaft	1
15	091-311-255-A	1-2 and R Slider See orientation notes in diagram	2
16	HV2-###I	1st Gear Idler ( ### denotes ratio )	1
17	HV2-###I	2nd Gear Idler ( ### denotes ratio )	1
18	8D8-CONE	Synchronizer Cone for Reverse (37mm)	1
19	HV2-409	Needle Bearing for Mid-Plate	1
20	HV2-424	Pin. Shaft Bearing Race at Gear Housing (No Oil Pump)	1
(20)	HV2-424A	Pin. Shaft Bearing Race at Gear Housing Only used w/ internal oil pump. Use with oil pump drive gear, part #HV2-913-01	1

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	Drawing Name: HV24 Pinion Shaft Assy
	Drawn By: DS
	Revised: 03/17/2022


# WEDDLE HV24 PINION SHAFT ASSEMBLY



ITEM	PART NO.	DESCRIPTION	QTY
21	002-311-151-A	Reverse Gear Thrust Washer	1
22	HV2-428	Reverse Gear Bearing Race	1
23	HV2-RP	Reverse Gear on Pinion Shaft	1
24	HV24-845	HV24 Reverse Slider Hub	1
25	HV24-RP###	HV24 Pinion Shaft ( ### denotes ratio )	1
26	HV2-924	Nut for end of HV2 Pinion Shaft Torque 200 ft. lb. with LT-272 (red) Peen lock tab after tightening	1
27	HV2-913-01	Oil Pump Drive Gear Only used w/ internal oil pump. Must be used with bearing race #HV2-424A	1
28	HV2-415	Pinion Shaft Roller Bearing, Installs in Gear Housing	1
29	HV-903##	Pinion Depth Shim (## Denotes Thickness)	1
30	H-BM10X50H-FFT	M10X1.0X50 Hex Bolt, Extra Fine Thread, Class 10.9 Torque 50 ft. lb. with LT-272 (red)	6
31	H-WM10	10mm Flat Washer, Hardened	6
32	4-475227	1-2 Needle Bearing	2
34	091-311-295-A	Synchronizer	3
35	091-311-313	Synchro Catch Keys	6
36	113-311-249-A	Single Ended Wire Spring	3
37	4-323723	Needle Bearing for Reverse Gear on Pinion Shaft	1
38	HV24-805	Support Ring for Reverse Catch Key	1
39	HV24-806	Spiral Lock for Reverse Catch Keys	1
40	HV2-###S	4th Gear Splined ( ### denotes ratio )	1
41	MD-407-###	Pinion bearing preload spacer (### denotes thickness) Bearing preload 25-30 in lb. of rolling torque	1

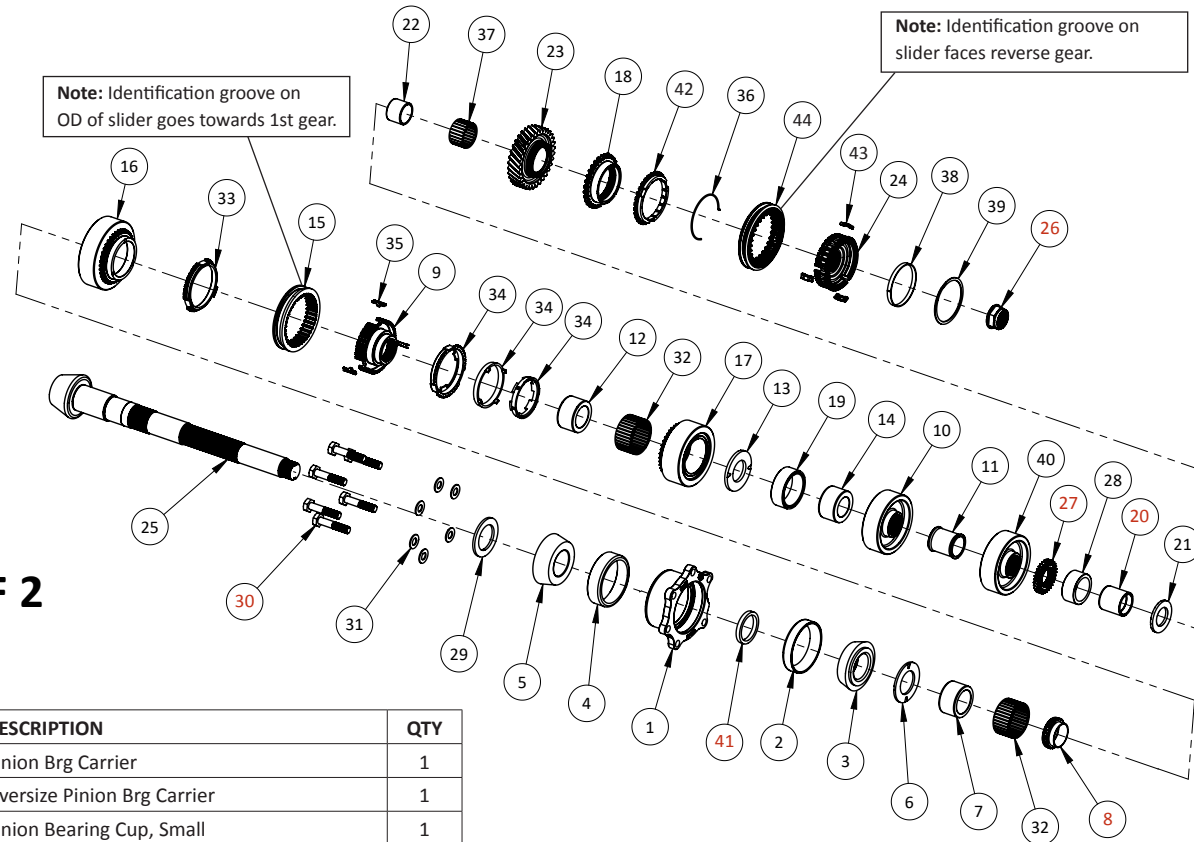
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HV-INST HV.22

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	Drawing Name: HV24 Pinion Shaft Assy
	Drawn By: DS
	Revised: 03/17/2022



# WEDDLE HV24 PINION SHAFT ASSEMBLY WITH MULTI CONE SYNCHRO



PAGE 1 OF 2

ITEM	PART NO.	DESCRIPTION	QTY
1	HV-402	Pinion Brg Carrier	1
(1)	HV-402+	Oversize Pinion Brg Carrier	1
2	MD-404	Pinion Bearing Cup, Small	1
3	MD-403	Pinion Bearing Cone, Small	1
4	MD-406	Pinion Bearing Cup, Large	1
5	MD-405	Pinion Bearing Cone, Large	1
6	113-311-221-A	Late 1st Gear Thrust Washer with Oil Slots	1
7	HV2-414	1st Gear Bearing Race	1
8	113-311-237-A	Late Small Round Nut <b>Torque 152 lb. with LT-272 (red) Peen lock tab after tightening</b>	1
9	HV2-843A	HV2 1-2 Slider Hub, Gen 2	1
10	HV2-###S	3rd Gear Splined ( ### denotes ratio )	1

ITEM	PART NO.	DESCRIPTION	QTY
11	HV2-903	HV2 3-4 Spacer Sleeve on Pinion Shaft	1
12	HV2-417	2nd Gear Bearing Race	1
13	HV2-921	HV2 2nd Gear Thrust Washer	1
14	HV2-408	Intermediate Bearing Race on Pinion Shaft	1
15	HV2-8255	HV2 1st-2nd Slider, Gen 2	1
16	HV2-####I-A	1st Gear Idler, Gen 2, ### Denotes Ratio	1
17	HV2-####I-A	2nd Gear Idler, Gen 2, ### Denotes Ratio	1
18	8D8-CONE	Synchronizer Cone for Reverse (37mm)	1
19	HV2-409	Needle Bearing for Mid-Plate	1
20	HV2-424	Pin. Shaft Bearing Race at Gear Housing (No Oil Pump)	1
(20)	HV2-424A	Pin. Shaft Bearing Race at Gear Housing <b>Only used w/ internal oil pump. Use with oil pump drive gear, part #HV2-913-01</b>	1
21	002-311-151-A	Reverse Gear Thrust Washer	1

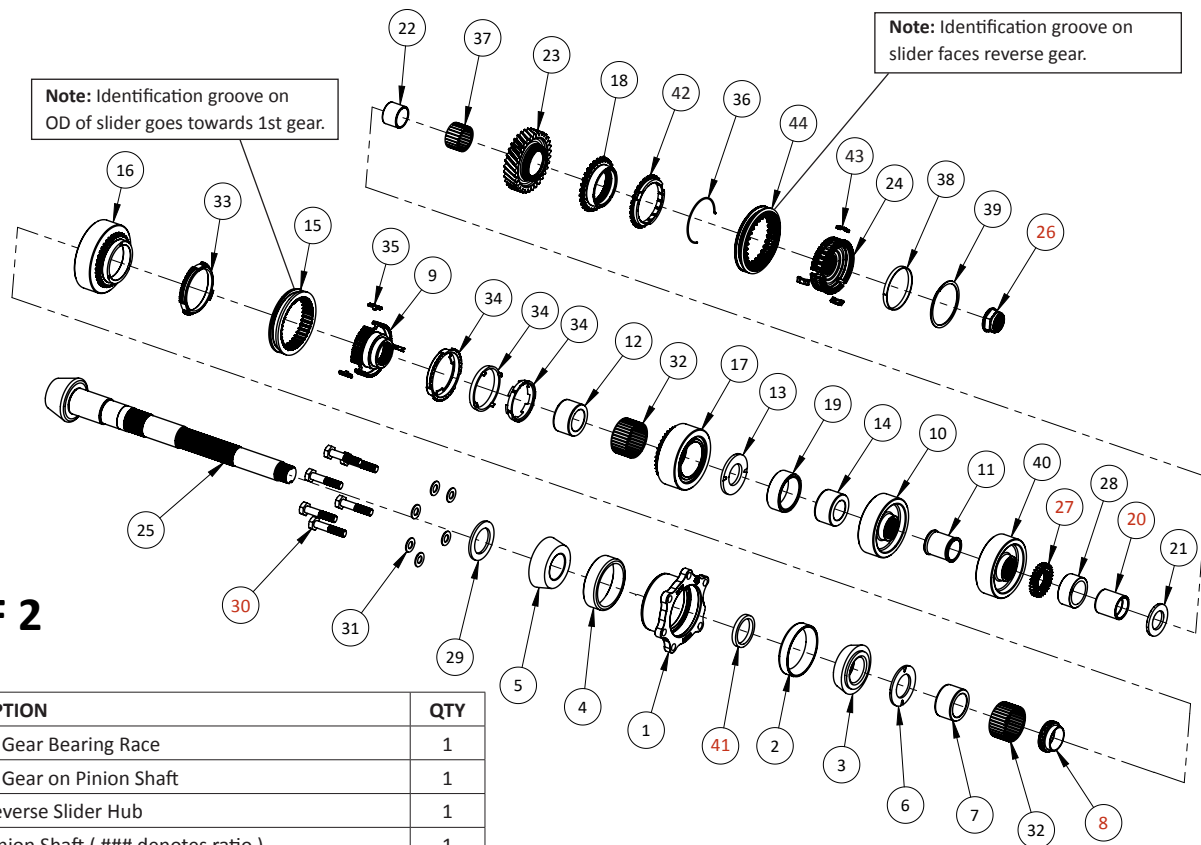


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Drawing No: HV2-EXP-PS4-MC  
Drawing Name: HV24 Pinion Shaft Assy  
Drawn By: RX  
Revised: 6/21/23



# WEDDLE HV24 PINION SHAFT ASSEMBLY WITH MULTI CONE SYNCHRO



PAGE 2 OF 2

ITEM	PART NO.	DESCRIPTION	QTY
22	HV2-428	Reverse Gear Bearing Race	1
23	HV2-RP	Reverse Gear on Pinion Shaft	1
24	HV24-845	HV24 Reverse Slider Hub	1
25	HV24-RP###	HV24 Pinion Shaft ( ### denotes ratio )	1
26	HV2-924	Nut for end of HV2 Pinion Shaft <b>Torque 200 ft. lb. with LT-272 (red)</b> <b>Peen lock tab after tightening</b>	1
27	HV2-913-01	Oil Pump Drive Gear <b>Only used w/ internal oil pump.</b> <b>Must be used with bearing race #HV2-424A</b>	1
28	HV2-415	Pinion Shaft Roller Bearing, Installs in Gear Housing	1
29	HV-903##	Pinion Depth Shim (## Denotes Thickness)	1
30	H-BM10X50H-FFT	M10X1.0X50 Hex Bolt, Extra Fine Thread, Class 10.9 <b>Torque 50 ft. lb. with LT-272 (red)</b>	6
31	H-WM10	10mm Flat Washer, Hardened	6

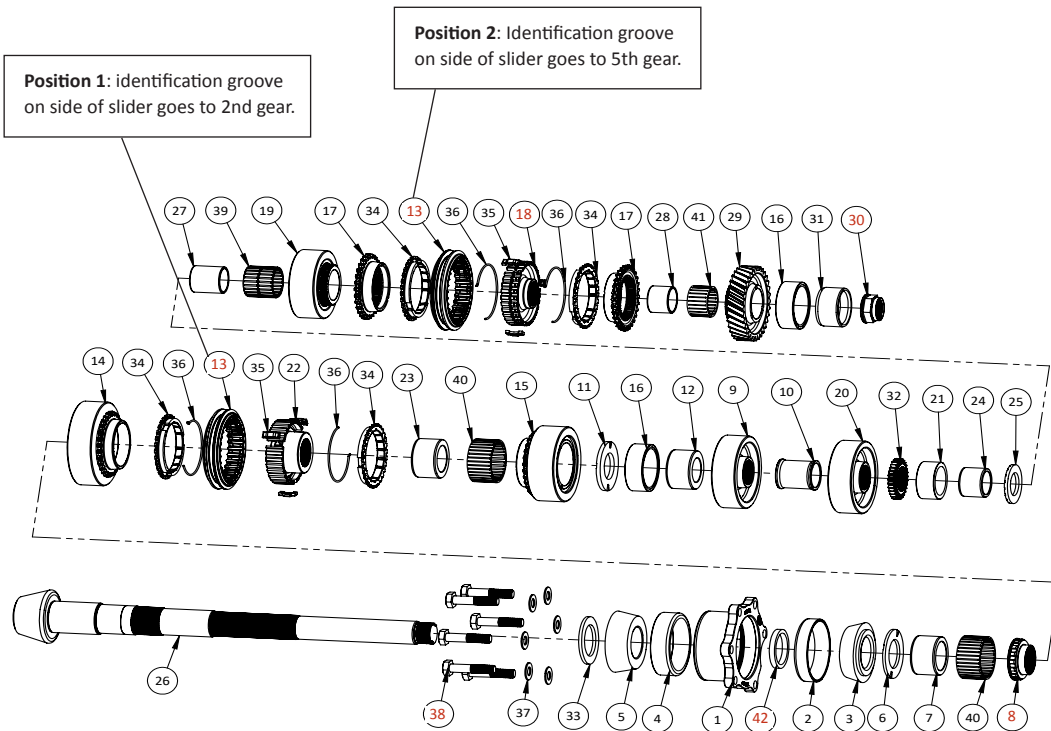
ITEM	PART NO.	DESCRIPTION	QTY
32	4-475227	1-2 Needle Bearing	2
33	HV2-8247	HV2 1st Gear Synchro, Gen 2 (Carbon Lined)	1
34	HV2-8295	HV2 2nd Gear Synchro Assembly, Gen 2 (3 Piece Assembly)	1
35	HV2-8313	Insert Key for 1-2 Slider Hub Assembly, Gen 2	3
36	113-311-249-A	Single Ended Wire Spring	1
37	4-323723	Needle Bearing for Reverse Gear on Pinion Shaft	1
38	HV24-805	Support Ring for Reverse Catch Key	1
39	HV24-806	Spiral Lock for Reverse Catch Keys	1
40	HV2-###S	4th Gear Splined ( ### denotes ratio )	1
41	MD-407-###	Pinion bearing preload spacer (### denotes thickness) <b>Bearing preload 25-30 in lb. of rolling torque</b>	1
42	091-311-295-A	Synchronizer	1
43	091-311-313	Synchronizer Catch Keys	3
44	091-311-255-A	5-R Slider	1



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Drawing No: HV2-EXP-PS4-MC  
Drawing Name: HV24 Pinion Shaft Assy  
Drawn By: RX  
Revised: 6/22/23

# WEDDLE HV25 PINION SHAFT ASSEMBLY



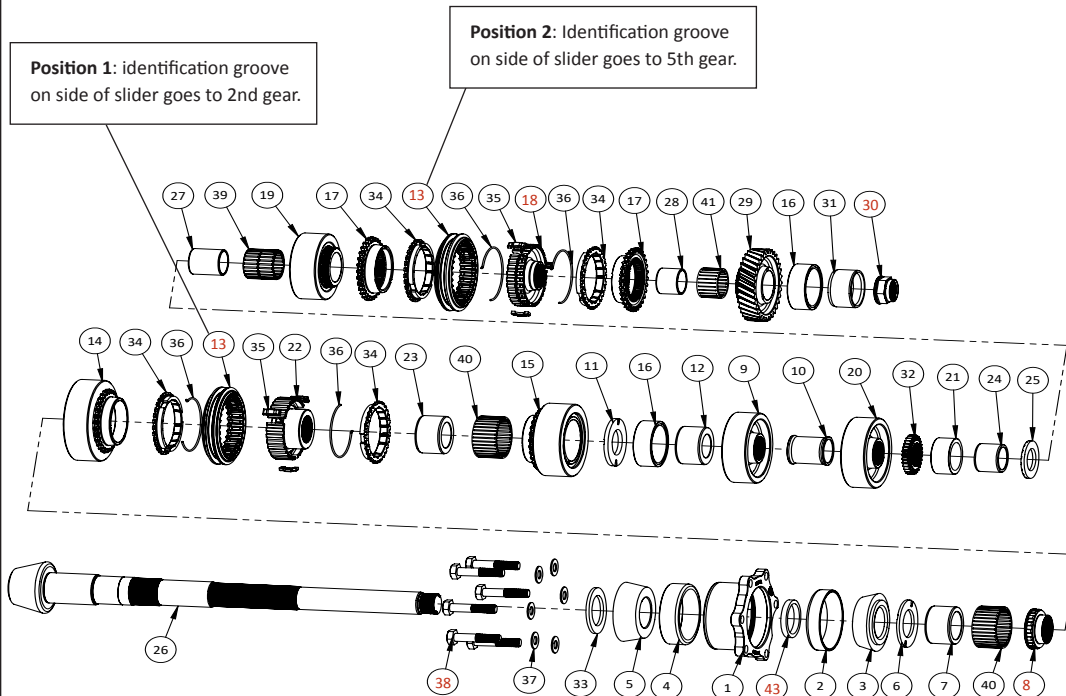
ITEM	PART NO.	DESCRIPTION	QTY
01	HV-402	Pinion Bearing Carrier	1
(01)	HV-402+	Pinion Bearing Carrier, oversize	1
02	MD-404	Pinion Bearing Cup, Small	1
03	MD-403	Pinion Bearing Cone, Small	1
04	MD-406	Pinion Bearing Cup, Large	1
05	MD-405	Pinion Bearing Cone, Large	1
06	113-311-221-A	Late 1st Gear Thrust Washer with Oil Slots	1
07	HV2-414	1st Gear Bearing Race	1
08	113-311-237-A	Late Small Round Nut <b>Peen lock tab after tightening Torque 152 ft. lb. with LT-272 (red)</b>	1
09	HV2-###S	3rd Gear Splined ( ### denotes ratio )	1
10	HV2-903	HV2 3-4 Spacer Sleeve on Pinion Shaft	1
11	HV2-921	HV2 2nd Gear Thrust Washer	1
12	HV2-408	Intermediate Bearing Race on Pinion Shaft	1
13	091-311-255-A	1-2 and 5-R slider <b>See orientation notes in diagram</b>	2
14	HV2-###I	1st Gear Idler ( ### denotes ratio )	1
15	HV2-###I	2nd Gear Idler ( ### denotes ratio )	1
16	HV2-409	Needle Bearing for Mid-Plate and end of Pinion Shaft	2
17	8D8-CONE	Synchro Cone	2
18	HV25-845	5-R Slider Hub <b>Identification groove on hub goes toward reverse</b>	1
19	HV2-###I	5th Gear Idler ( ### denotes ratio )	1
20	HV2-###S	4th Gear Splined ( ### denotes ratio )	1
21	HV2-415	Pinion Shaft Roller Bearing Installs in gear housing	1
22	HV2-843	1-2 Slider Hub	1



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Drawing No: HV2-EXP-PS5  
Drawing Name: HV25 Pinion Shaft Assy  
Drawn By: DS  
Revised: 03/17/2022


# WEDDLE HV25 PINION SHAFT ASSEMBLY



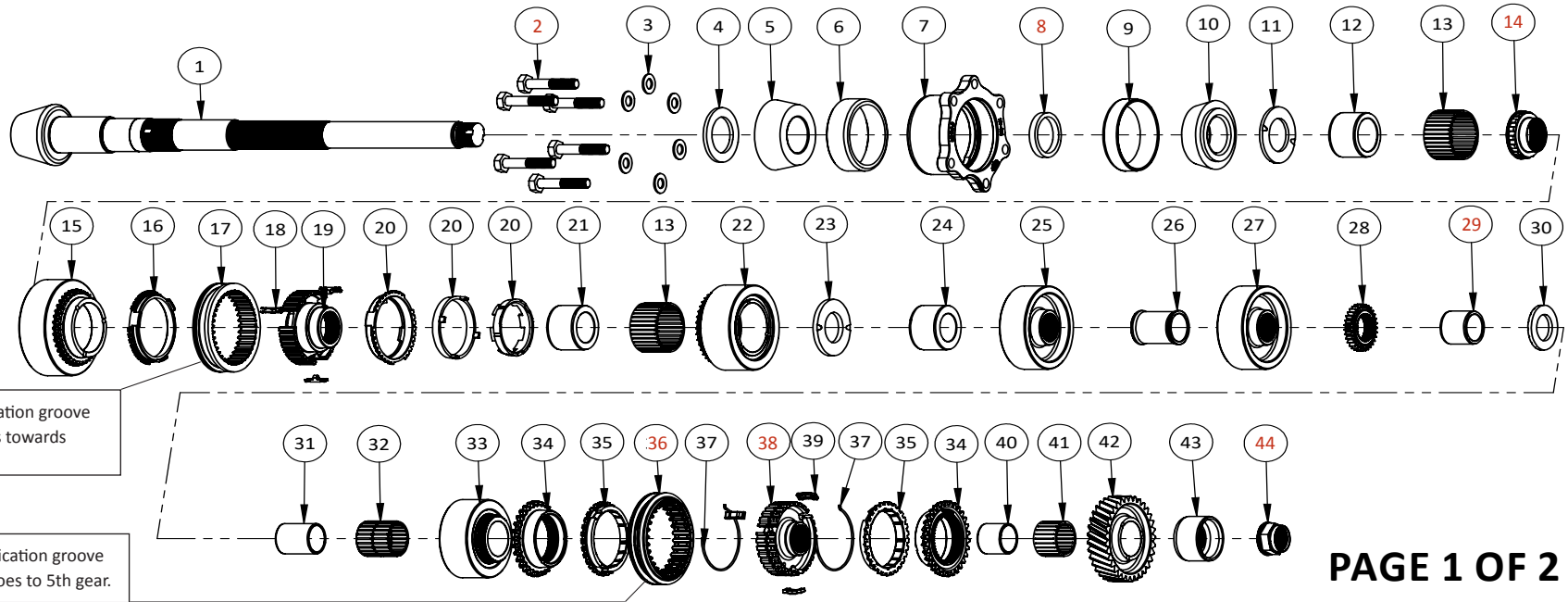
ITEM	PART NO.	DESCRIPTION	QTY
23	HV2-417	2nd Gear Bearing Race	1
24	HV2-424	Pin. Shaft Bearing Race at Gear Housing ( no oil pump )	1
(24)	HV2-424A	Pinion shaft bearing race at gear housing Used with internal oil pump option only. Use with oil pump drive gear, part 3HV2-913-01	1
25	002-311-151-A	5th Gear Thrust Washer	1
26	HV25-RP###	HV25 Pinion Shaft ( ### denotes ratio )	1
27	HV2-427	5th Gear Bearing Race	1
28	HV2-428	Reverse Gear Bearing Race	1
29	HV2-RP	Reverse Gear on Pinion Shaft	1
30	HV2-924	Nut for end of HV2 Pinion Shaft (M25X1.5) Peen lock tab after tightening Torque 200 ft. lb. with LT-272 (red)	1
31	HV25-426	Bearing Race for end of Pinion Shaft	1
32	HV2-913-01	Oil pump drive gear Used with internal oil pump option only. Must be used with bearing race #HV2-424A	1
33	HV-903##	Pinion Depth Shim (## denotes thickness)	1
34	091-311-295-A	Synchronizer 2nd and 5th	4
35	091-311-313	Synchro Catch Keys	6
36	113-311-249-A	Single Ended Wire Spring	4
37	H-WM10	10mm Flat Washer, Hardened	6
38	H-BM10X50H-FFT	M10X1.0X50 Hex Bolt, Extra Fine Thread, Class 10.9 Torque 50 ft. lb. with LT-272 (red)	6
39	HV2-437	37mm Needle Bearing Kit (2 bearings)	1
40	4-475227	1-2 Needle Bearing	2
41	4-323723	Needle Bearing Reverse Gear on Pinion Shaft	1
42	MD-407-###	Pinion Bearing Preload Spacer ( ### denotes thickness ) Bearing preload 25-30 in lb. of rolling torque	1

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	Drawing Name: HV25 Pinion Shaft Assy
	Drawn By: DS
	Revised: 03/17/2022

# WEDDLE HV25 PINION SHAFT ASSEMBLY WITH MULTI CONE SYNCHRO



**PAGE 1 OF 2**

ITEM	PART NO.	DESCRIPTION	QTY
1	HV25-RP###	HV25 Pinion Shaft ( ### denotes ratio )	1
2	H-BM10X50H-FFT	M10X1.0X50 Hex Bolt, Extra Fine Thread, Class 10.9 <b>Torque 50 ft. lb. with LT-272 (red)</b>	6
3	H-WM10	10mm Flat Washer, Hardened	6
4	HV-903##	Pinion Depth Shim (## denotes thickness)	1
5	MD-405	Pinion Bearing Cone, Large	1
6	MD-406	Pinion Bearing Cup, Large	1
7	HV-402	Pinion Bearing Carrier	1
(7)	HV-402+	Pinion Bearing Carrier, oversize	1
8	MD-407-###	Pinion Bearing Preload Spacer ( ### denotes thickness ) <b>Bearing preload 25-30 in lb. of rolling torque</b>	1
9	MD-404	Pinion Bearing Cup, Small	1
10	MD-403	Pinion Bearing Cone, Small	1
11	113-311-221-A	Late 1st Gear Thrust Washer with Oil Slots	1
12	HV2-414	1st Gear Bearing Race	1
13	4-475227	1st / 2nd Idler Gear Needle Bearing	2
14	113-311-237-A	Pinion Bearing Preload Nut <b>Peen lock tab after tightening</b> <b>Torque 152 ft.lb. with LT-272 (red)</b>	1
15	HV2-####I-A	1st Gear Idler, Gen 2 ( ### denotes ratio )	1

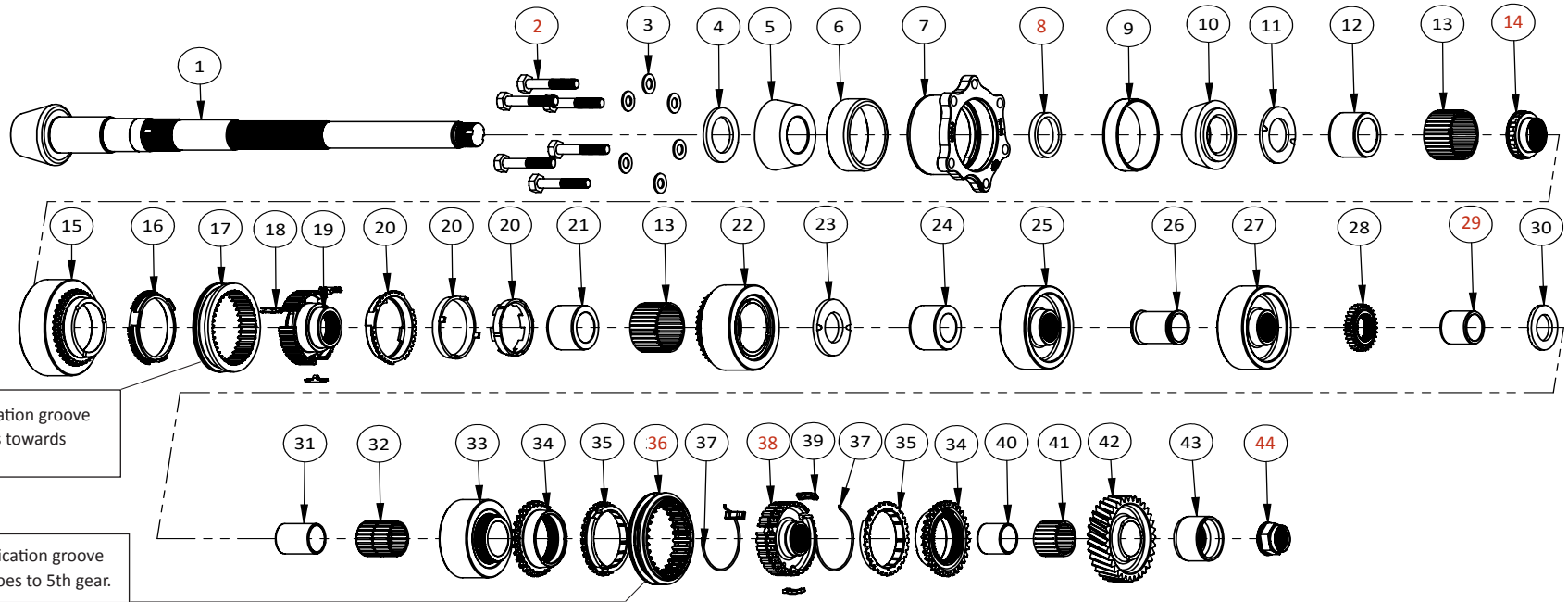
ITEM	PART NO.	DESCRIPTION	QTY
16	HV2-8247	HV2 1st Gear Synchro, Gen 2 (Carbon Lined)	1
17	HV2-8255	HV2 1st-2nd Slider, Gen 2	1
18	HV2-8313	Insert Key for 1-2 Slider Hub Assy, Gen 2	3
19	HV2-843A	HV2 1-2 Slider Hub, Gen 2	1
20	HV2-8295	HV2 2nd Gear Synchro Assy, Gen 2 (3 Piece Assembly)	1
21	HV2-417	2nd Gear Bearing Race	1
22	HV2-####I-A	2nd gear Idler, Gen2 ( ### denotes ratio )	1
23	HV2-921	HV2 2nd Gear Thrust Washer	1
24	HV2-408	Intermediate Bearing Race on Pinion Shaft	1
25	HV2-####S	3rd Gear Splined ( ### denotes ratio )	1
26	HV2-903	HV2 3-4 Spacer Sleeve on Pinion Shaft	1
27	HV2-####S	4th Gear Splined ( ### denotes ratio )	1



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Drawing No: HV2-EXP-PS5-MC  
Drawing Name: HV25 Pinion Shaft Assy  
Drawn By: DL  
Revised: 6/22/2022

# WEDDLE HV25 PINION SHAFT ASSEMBLY WITH MULTI CONE SYNCHRO



## PAGE 2 OF 2

ITEM	PART NO.	DESCRIPTION	QTY
28	HV2-913-01	Oil pump drive gear <i>Used with internal oil pump option only. Must be used with bearing race #HV2-424A</i>	1
29	HV2-424	Pin. Shaft Bearing Race at Gear Housing ( no oil pump )	1
(29)	HV2-424A	Pinion shaft bearing race at gear housing <i>Used with internal oil pump option only. Use with oil pump drive gear, part HV2-913-01</i>	1
30	002-311-151-A	5th Gear Thrust Washer	1
31	HV2-427	5th Gear Bearing Race	1
32	HV2-437	37mm Needle Bearing Kit (2 bearings)	1
33	HV25-###I	5th Gear Idler ( ### denotes ratio )	1
34	8D8-CONE	Synchro Cone	2
35	091-311-295-A	Synchronizer Ring 5th & Reverse	2
36	091-311-255-A	5-R slider <i>See orientation notes in diagram</i>	1
37	113-311-249-A	Single Ended Wire Spring	2
38	HV25-845	5-R Slider Hub <i>Identification groove on hub goes toward reverse</i>	1

ITEM	PART NO.	DESCRIPTION	QTY
39	091-311-313	Synchro Catch Keys	3
40	HV2-428	Reverse Gear Bearing Race	1
41	4-323723	32X37X23 Caged Needle Bearing	1
42	HV2-RP	Reverse Gear on Pinion Shaft	1
43	HV25-426	Bearing Race for end of Pinion Shaft	1
44	HV2-924	Nut for end of HV2 Pinion Shaft (M25X1.5) <i>Peen lock tab after tightening Torque 200 ft. lb. with LT-272 (red)</i>	1



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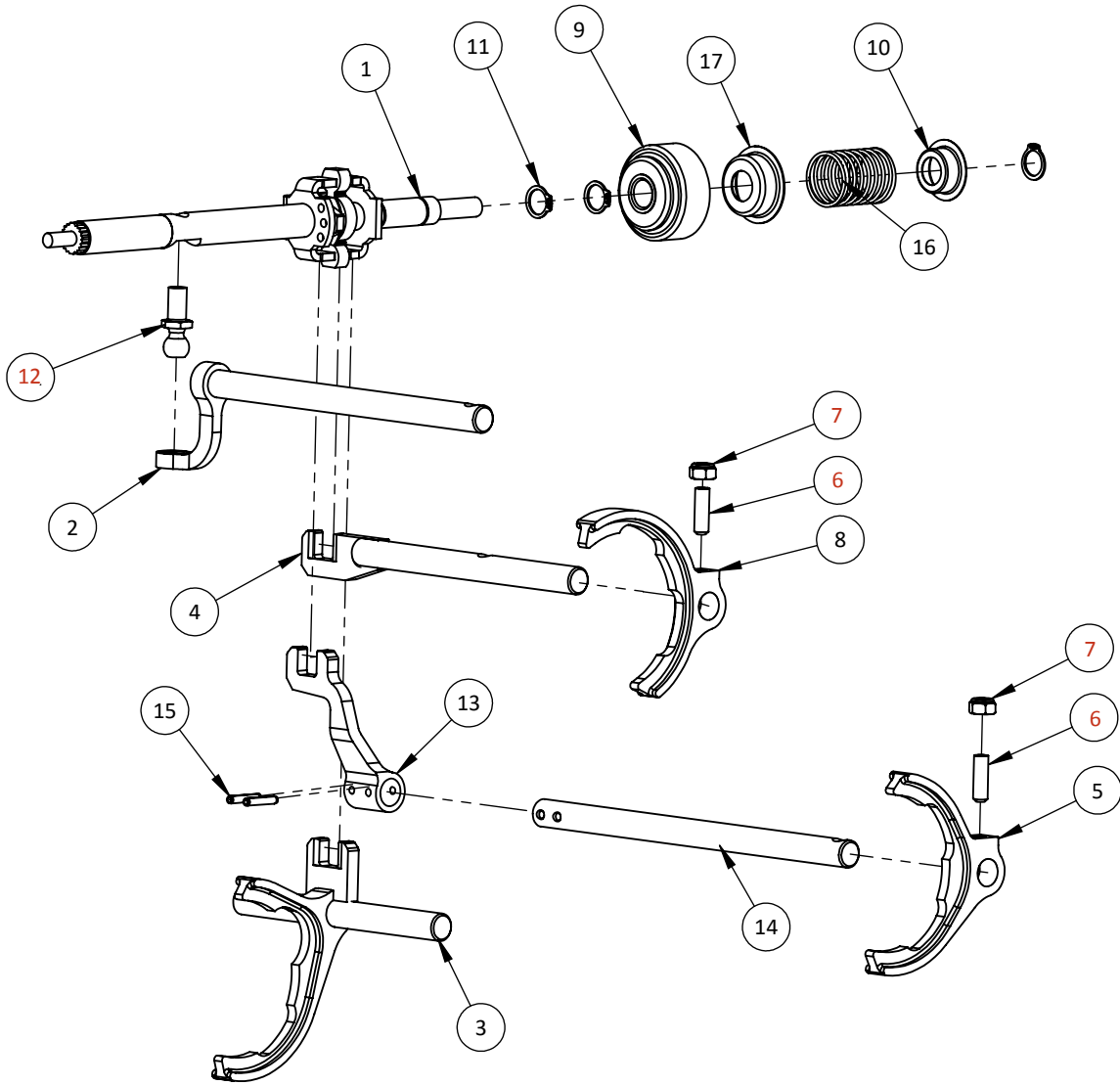
Drawing No: HV2-EXP-PS5-MC  
Drawing Name: HV25 Pinion Shaft Assy  
Drawn By: DL  
Revised: 6/22/2022



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Drawing No: HV2-EXP-SHIFT  
 Drawing Name: Weddle HV2 Shift Exploded View  
 Drawn By: DS  
 Revised: 09/25/2018

## WEDDLE HV2 SHIFT EXPLODED VIEW



ITEM	PART NO.	DESCRIPTION	QTY
01	HV2-8534	Selector Shaft (Includes 9-11, 16, 17)	1
02	HV2-856	Shift Rod Assembly	1
03	HV2-812	1-2 Shift Fork Assembly	1
(03)	HV2-812-A	1-2 Shift Fork Assembly, Gen 2	1
04	HV24-834R	3-4 Shift Rail Assembly— 4-speed	1
(04)	HV25-834R	3-4 Shift Rail Assembly— 5-speed	1
05	HV2-85RF	5-R Shift Fork	1
06	HV2-846	Set Screw Torque 14 ft. lb. with LT-243 (Blue)	2
07	H-NLM8	M8 Nyloc Nut Torque 18 ft. lb. with LT-243 (Blue)	2
08	HV2-834F	3-4 Shift Fork	1
09	020-301-268-D	Large Cup for Selector Shaft	1
10	HV2-8534-1	Small Cup for Selector Shaft	1
11	N-012-415-1	Circlip for Selector Shaft Assembly	3
12	HV2-855	Shift Ball Torque 35 ft. lb. with LT-272 (red)	1
13	HV2-85RG	5-R Shift Gate	1
14	HV24-8RR	4 speed Reverse Shift Rail	1
(14)	HV25-85RR	5 Speed Reverse Shift Rail	1
15	H-RP5320875	Roll Pin	2
16	091-311-548-B	Spring for Selector Shaft	1
17	111-141-727	16mm Spring Collar	1



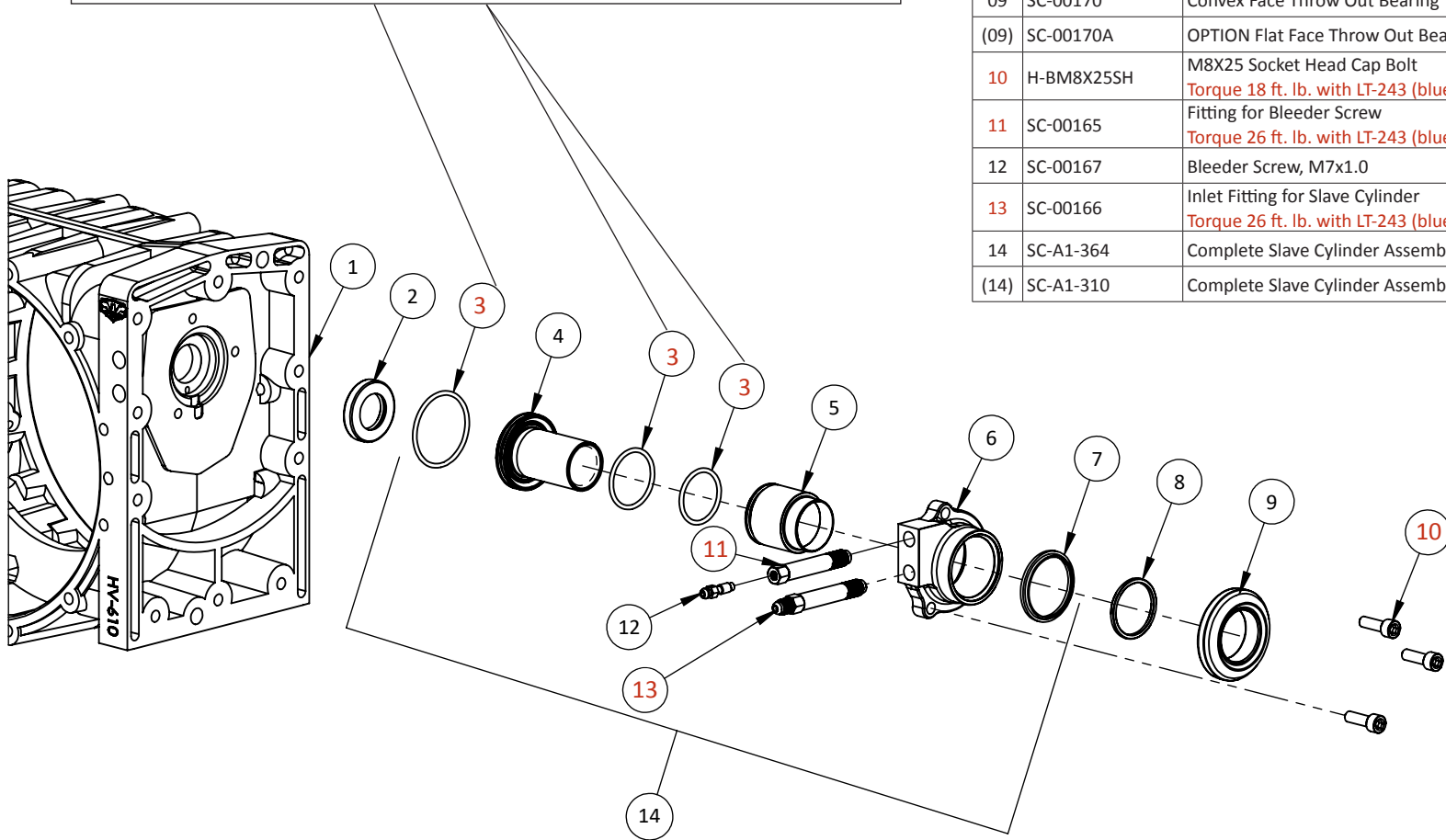


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Drawing No: HV2-EXP-SLAVE  
 Drawing Name: Weddle HV Slave Cylinder Exploded View  
 Drawn By: RX  
 Revised: 12/8/23

## WEDDLE HV SLAVE CYLINDER EXPLODED VIEW

**IMPORTANT:** Use only silicone-based lube (part # 9-SILICONE) when installing slave cylinder o-rings. Petroleum-based grease or oil will attack the o-rings, causing them to swell and eventually fail.



ITEM	PART NO.	DESCRIPTION	QTY
01	HV-610	HV Main Case	1
02	AGB-00133	AGB/HV Input Shaft Seal	1
03	SC-00243	O-Ring Kit for Slave Cylinder <i>See lubrication note on diagram</i>	1
04	SC-05073	Center Support for Slave Cylinder	1
05	SC-05084	36.4mm Piston for Slave Cylinder	1
(05)	SC-05738	OPTION 41.2mm Piston for Slave Cylinder	1
(05)	SC-20866	OPTION 31.0mm Piston for Slave Cylinder	1
06	SC-05072	Slave Cylinder Housing	1
(06)	SC-05072A	OPTION Short Slave Cylinder Housing	1
07	SC-05075	Piston Wiper for Slave Cylinder	1
(08)	SC-00331	OPTIONAL 3mm Spacer for Throw Out Bearing	1
09	SC-00170	Convex Face Throw Out Bearing	1
(09)	SC-00170A	OPTION Flat Face Throw Out Bearing	1
10	H-BM8X25SH	M8X25 Socket Head Cap Bolt <i>Torque 18 ft. lb. with LT-243 (blue)</i>	3
11	SC-00165	Fitting for Bleeder Screw <i>Torque 26 ft. lb. with LT-243 (blue)</i>	1
12	SC-00167	Bleeder Screw, M7x1.0	1
13	SC-00166	Inlet Fitting for Slave Cylinder <i>Torque 26 ft. lb. with LT-243 (blue)</i>	1
14	SC-A1-364	Complete Slave Cylinder Assembly 36.4mm	1
(14)	SC-A1-310	Complete Slave Cylinder Assembly 31.0mm	1