



GLOBAL MX-5 CUP SADEV GEARBOX INSTALLATION

Kit includes:

- Sadev Gearbox – (0000-02-5901-SD)
- Shift Rod with load Cell – (0000-02-5903) (Installed on Gearbox)
- ACT Clutch Disc – (0000-02-5438-SS)
- Stock ND1 Pressure Plate – (PE3116410)
- Stock ND1 Release Bearing – (LF01-16-510)
- Driveshaft – (0000-02-5902)
- Driveshaft Bolt Kit Top Hats – (0000-02-5902-BT)
- Banjo Fitting Kit – (0000-02-5902-BJ) (Installed on Gearbox)
- Differential (Limited Slip, Gear Set, Diff cover and Vent) – (0000-02-MS14-SD)
- Wiring Kit (Car Side Loom) – (0000-10-5916)
- Gearbox to Pump Hose – (0000-02-5902-L2)
- Gearbox to Filter Hose – (0000-02-5902-L1)
- Bosch Firmware Update
- Installation Instructions
- **Customer will use Stock ND1 Flywheel (Not included in Kit)**

SAFETY FIRST – Please Reference Torque Specifications from ND2User Guide

1. Disconnect Battery
2. Remove Strut Tower Brace
3. Unplug O2 Sensor
4. Remove Header Nuts
5. Remove Aluminum Support Braces (Under Car)
6. Remove Exhaust System from Header Back
7. Remove All Gearbox Oil
8. Remove Gearbox cooler hoses from Gearbox
9. Unbolt Clutch Slave from Gearbox
10. Remove Front Cross Member Braces Right/Left (PIC #3)
11. Remove Driveshaft Bolts
12. Remove Power Plant Frame (Support Gearbox with Jack) (PIC #4)
13. Remove Bellhousing and Starter Bolts
14. Remove Stock Gearbox
15. Remove Stock Shift Fork and Boot
16. Remove Differential
17. Install Updated Differential (Part # 0000-02-MS14-SD) (Remember to Torque all Bolts)(check axle seals to make sure they did not move in shipping)
18. Remove Stock Pressure Plate and Clutch Disc

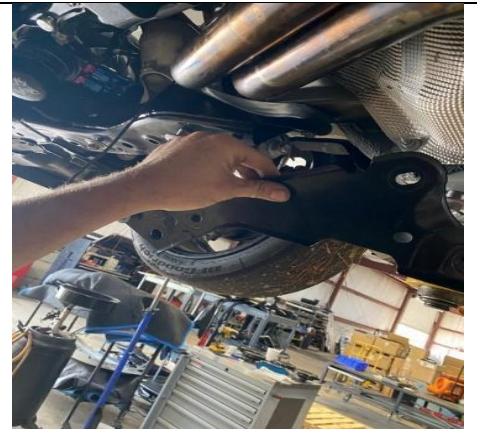
19. Install New ACT Clutch Disc (Part # 0000-02-5438-SS)
20. Install New Stock Pressure Plate and align clutch with a clutch alignment tool (Alignment tool can be found at most local part stores. 1"x23 Spline) (with Blue Loctite and 26-28 ft.-lbs. Torque) (Recommended Bolt Pressure Plate in a star pattern) (Part # PE3116410)
21. Install New Pressure Plate Bearing (LF01-16-510)
22. Install Stock Shift Fork and Boot on New Sadev Gearbox
23. Replace Rear Studs with Stock Studs in tail-shaft (PIC #12,#13 & #14)
24. Remove Front Linkage Bolt PIC #1, Reverse Cable (PIC #2) and Shifter mount from New Sadev Gearbox (4 Allen bolts on shifter mount PIC #9)
25. Install New Sadev Gearbox (twist counterclockwise and have tail shaft down and to the right side of tunnel)
26. Install Gearbox Bolts and Starter Bolts (replace lower bellhousing bolts with m10x1.5m with washers)(PIC #11) (install washers on upper starter bolt and mid bellhousing bolt) (PIC #10 & #15) (washer 4.5mm thick)
27. With Gearbox supported, install Shifter and Linkage (PIC #4) (PIC #1)
28. Reattach Clutch Slave to Gearbox (Recommend updated Slave kit Part #0000-02-5116KT and Bleed Slave)
29. Install Drive Shaft with Top Hat Spacers Part # 0000-02-5902-BT (37-43ft-lbs)(PIC #16)
30. Install Power Plant Frame (Diff End 121-147ft-lbs and Gearbox End 100-120ft-lbs)
31. Remember Specification Between bottom surface of power plant frame and top surface of tunnel member: 22.4-28.4 mm (Reference User Guide)
32. Install Reverse Cable (PIC #2)
33. Install Header Nuts (32-37ft-lbs)
34. Install Exhaust System
35. Connect Battery and Run Gearbox Pump to Remove all Oil from Cooler and Hoses
36. Replace Gearbox to Pump Hose (Part # 0000-08-D213 or LRR-036 with New Hose Part # 0000-02-5902-L2 or LRR-044) (PIC #6)
37. Replace Gearbox to Filter Hose (Part # 0000-08-D210 or LRR-033 With New Hose Part #0000-02-5902-L1 or LRR-043) (PIC #6)
38. Connect New Gearbox lines. (Making sure NOT to OVER TIGHTEN the lines which can crack and prematurely fail). While installing the Gearbox lines remove right side drain plug (the one closest to the tail shaft) and install banjo fitting. (Clock the same as PIC #5)
39. Fill Gearbox and Cooler with 2.2 liters (75W-140 Synthetic Gear Oil)
40. Install Car Side Wire Loom Running Loom Inside car Under Center Console (Drill Shifter Boot Plate with 1" Hole to pass loom through with Grommet) (PIC #7 & #8)
41. Install Front Cross Member Braces Right/Left (PIC #3)
42. Plug in O2 Sensor
43. Install Aluminum Support Braces (14-19ft-lbs)
44. Install Strut Tower Brace (2 Center nuts 12-19ft-lbs and 6 Tower Brace nuts 37-43ft-lbs)
45. Install Firmware (calibrate Gear position sensor)
46. Make sure everything is torqued and tied up
47. Go Have some FUN



Picture #1



Picture #2



Picture #3



Picture #4



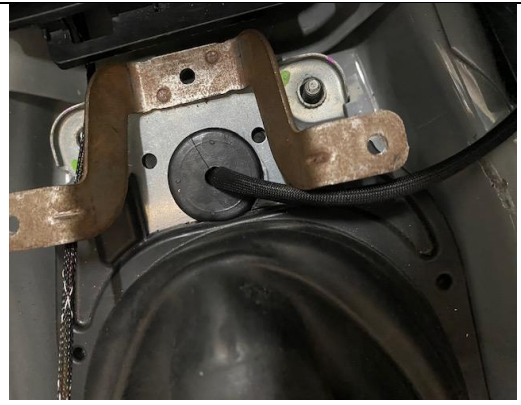
Picture #5



Picture #6



Picture #7



Picture #8



Picture #9



Picture #10



Picture #11



Picture #12



Picture #13



Picture #14



Picture #15



Picture #16