



C23 R2 MAX

Version 05 – 14 May 2009

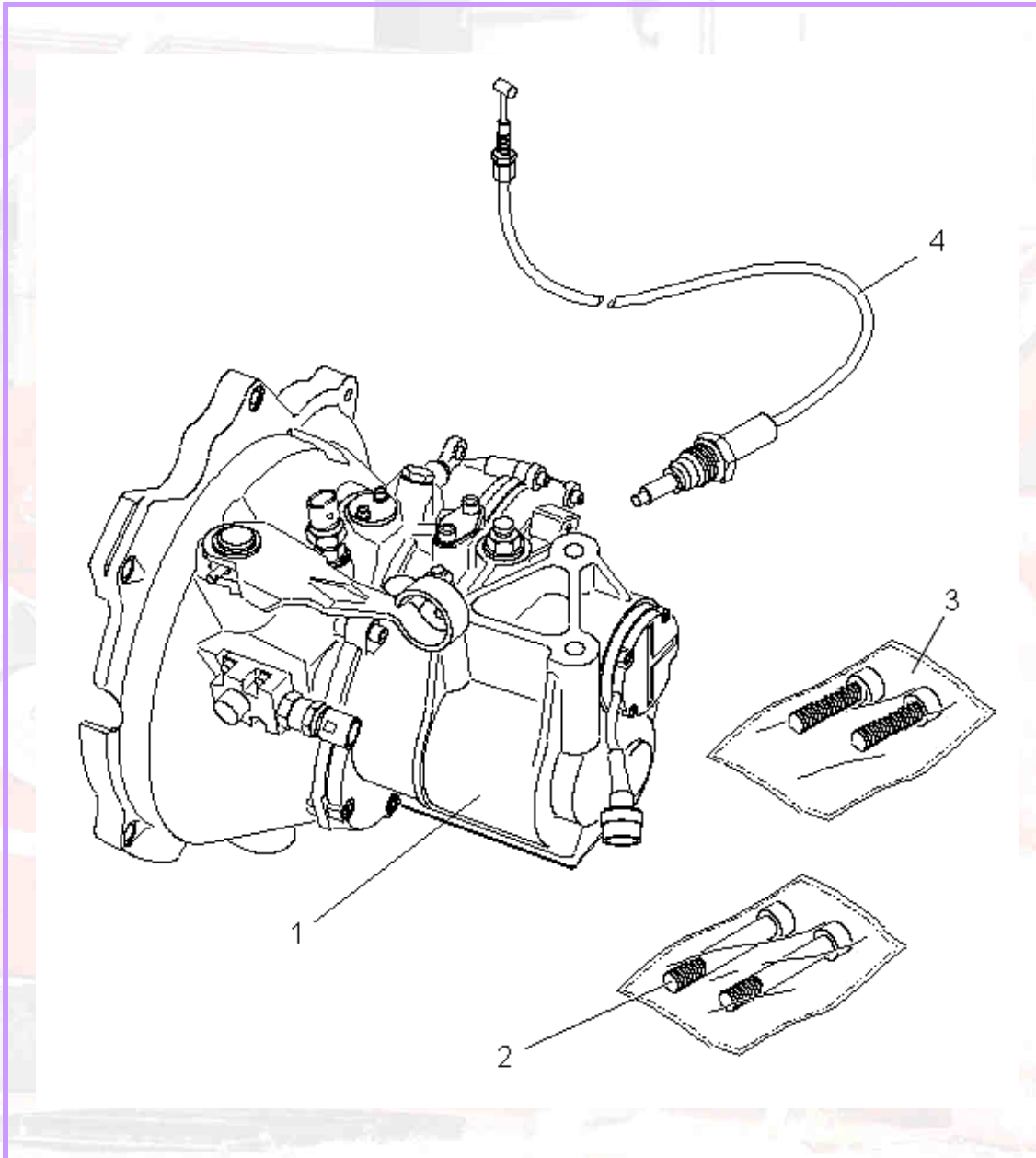
C23

GEAR BOX



C2R2 MAX

Version 06 – 26 august 2009



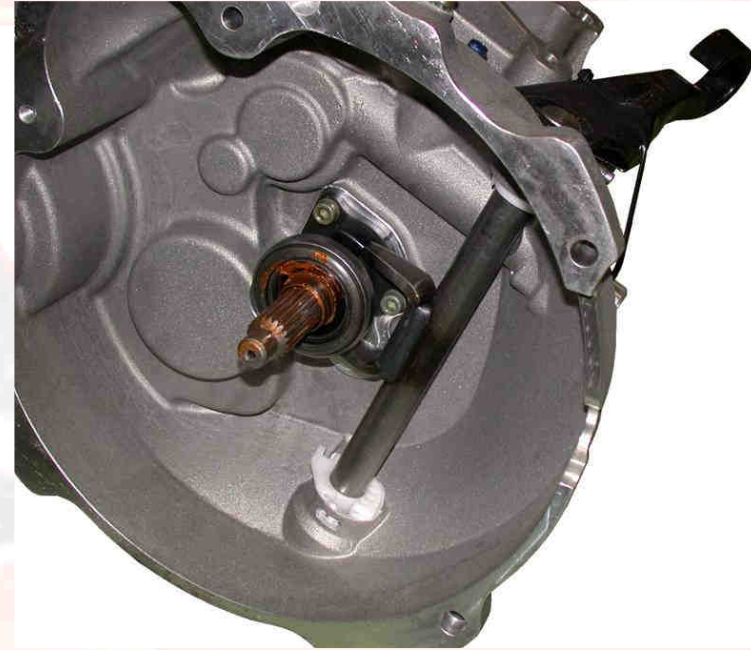
Ref	Part Number	Qty	Description
1	1C2362847D	1	5-speed gear box, torque 12x53 (medium).
1	1C2363402A	1	5-speed gear box, torque 12x57 (short).
2	PS82145A10	2	Long screw, gear box circumference HSHC M10x150 lg55.
3	PS82095A10	2	Short screw, gear box circumference HSHC M10x150 lg40.
4	F9019608	1	Reverse release cable
	CPL13549019011	1	Long final drive, 13x54
	CPL12539019011	1	Medium final drive, 12x53
	CPL12579019011	1	Short final drive, 12x57
	696843	2	Gear box centring device



Fitting the gear box.

Lubricate the grooves of the primary shaft.

Lubricate the throwout bearing and its guide, and make the assembly operate a dozen times.

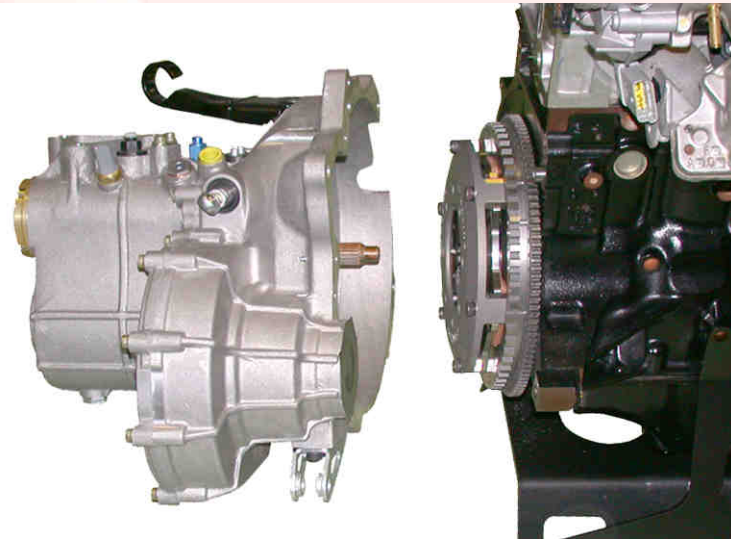


Copper grease

Fit the gear box ([Ref. 1](#)) on the engine.

Make sure beforehand that the two centring devices are present.

Ref: 696843 No. 2)

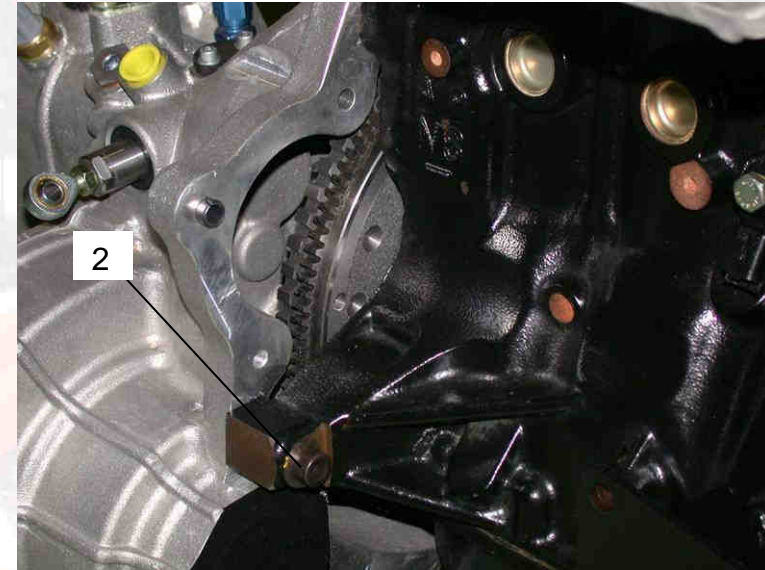
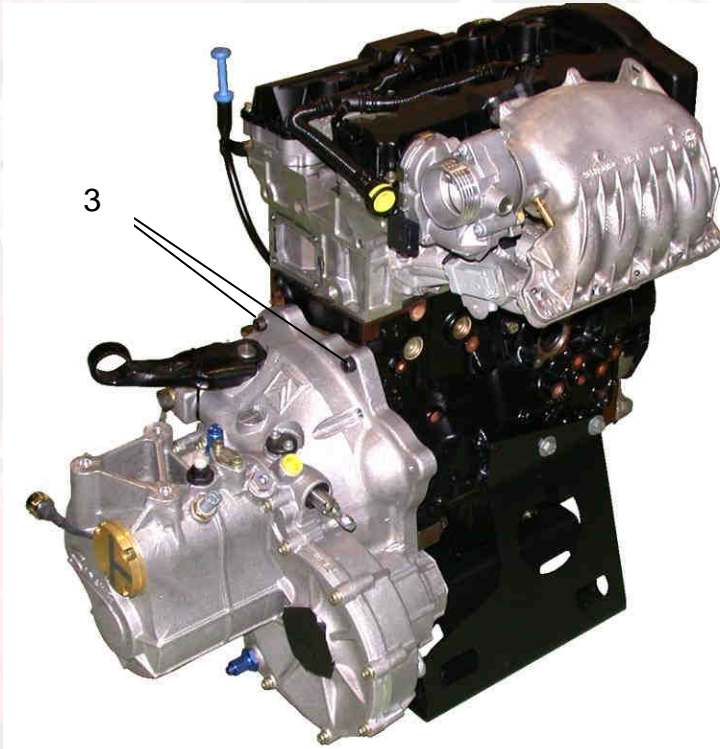


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Torque tighten the short screws ([ref. 3](#)) and the long screws ([ref. 2](#)) for fixing the gear box.



6.5 m.kg



Fit the reverse release cable (*ref. 4*) on the gear box, having taken care to apply copper grease on the threads (**not Loctite**).

! Moderate tightening !



Moderate tightening

Connect the reverse release cable to the gearshift lever trigger.

Using the adjustable cable stop of the trigger, obtain at least **2mm** play in the gearshift.

!!! Make sure that this play is kept when the engine / gear box assembly is warmed !!!

Otherwise, locking is not activated, and shifting to neutral or even reverse is possible.



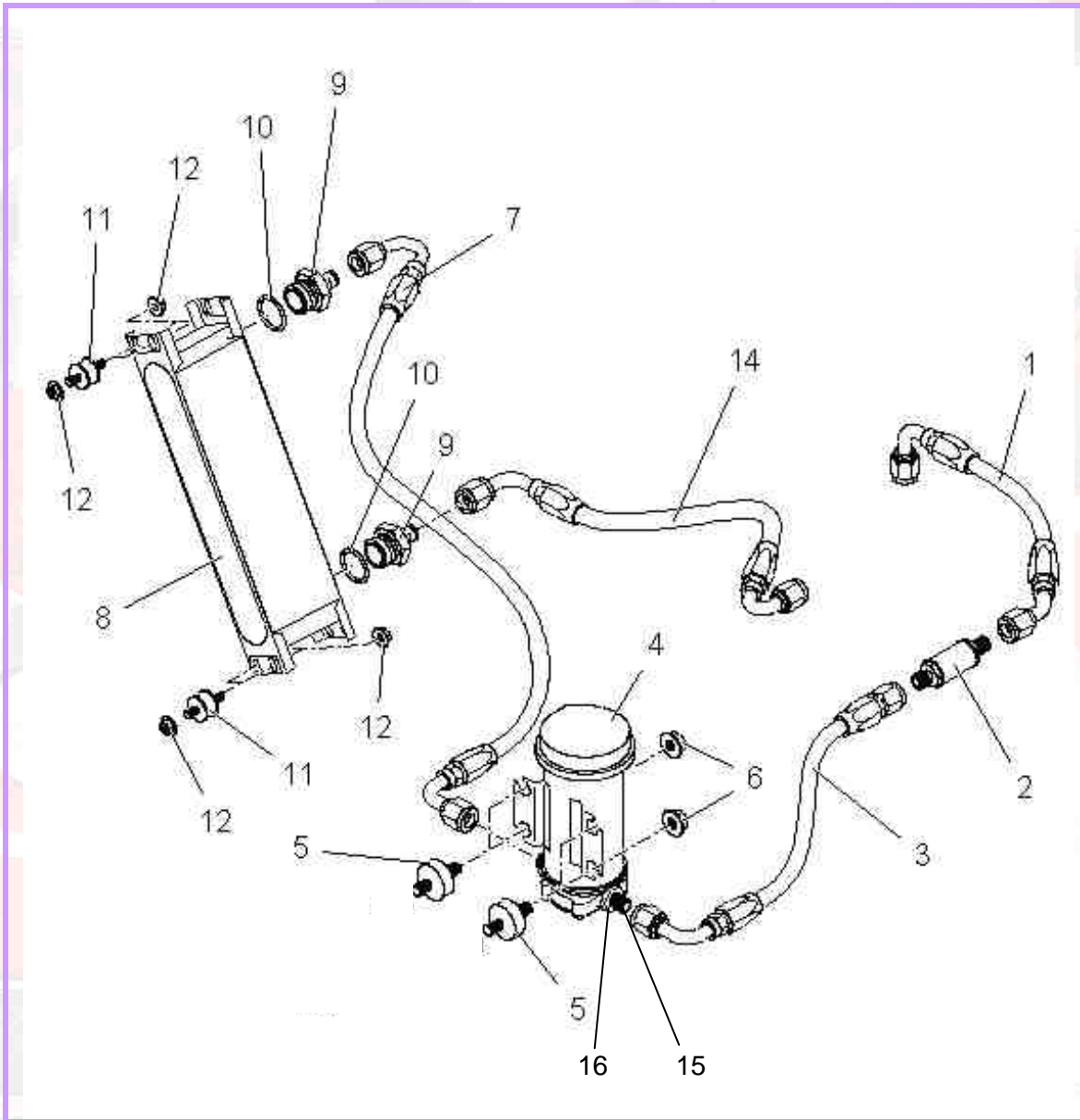
2 mm





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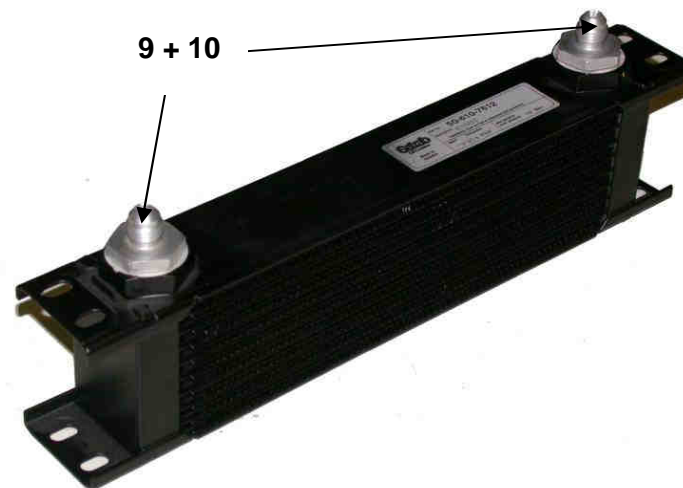


Ref	Part Number	Qty	Description
1	1C2363255A	1	Gear box / Filter hose
2	1C2329683A	1	Gear box oil filter
3	1C2363256A	1	Filter / Pump hose
4	1C2327049B	1	Oil pump
5	PS93510A10	4	Oil pump silent-block
6	BCSP6936C9	4	Oil pump silent-block nut
7	1C2363257A	1	Pump / Radiator hose
8	1C2340820B	1	Radiator
9	1C8160527A	2	Aeroquip radiator connector M22 Dash 6
10	1C8160564A	2	Aeroquip radiator connect gasket Ø22.
11	PS93012A10	4	Radiator silent-block.
12	BCSP6935A6	6	Silent-block collar nut M6x100.
14	1C2363258A	1	Radiator / Gear box hose
15	PS773907A10	2	Dash 6 connector
16	BCSP016488	2	Ø16x24 bi material seal

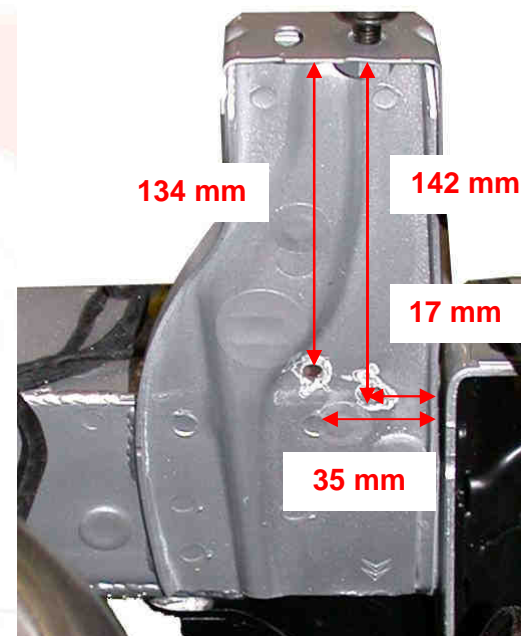


Fitting the gear box cooling radiator.

Fit the two male / male connectors (*ref. 9*) and their gaskets (*ref. 10*) on the oil radiator.



Drill the left front surface cusp of the block to $\text{Ø}6.2\text{mm}$, according to the dimensions given in the photo opposite.



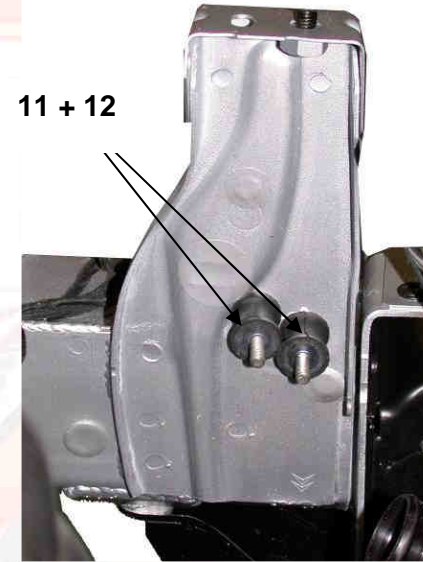
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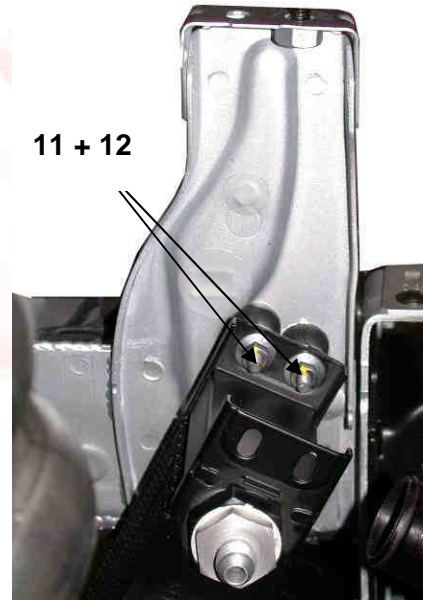
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Fit the two silent-blocks ([ref. 11](#)) on the cusp, using nuts ([ref. 12](#)).

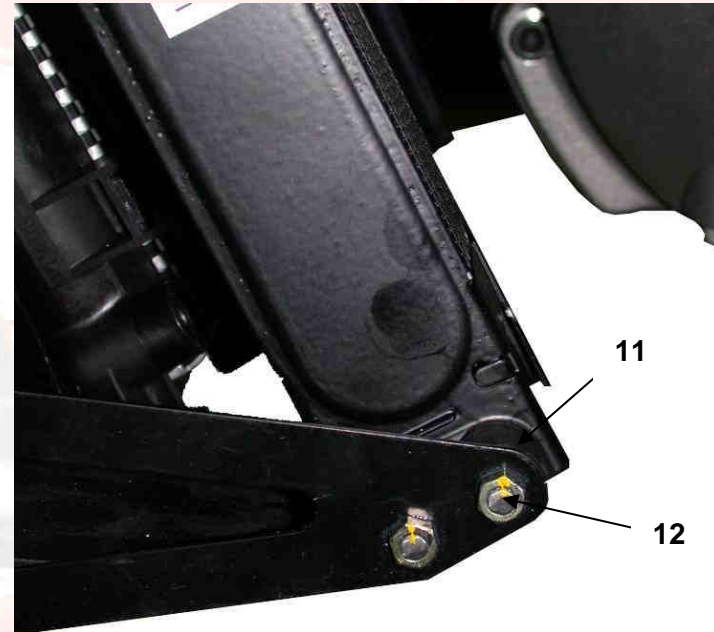


Fit the already assembled radiator on the two silent-blocks using nuts ([ref. 12](#)).

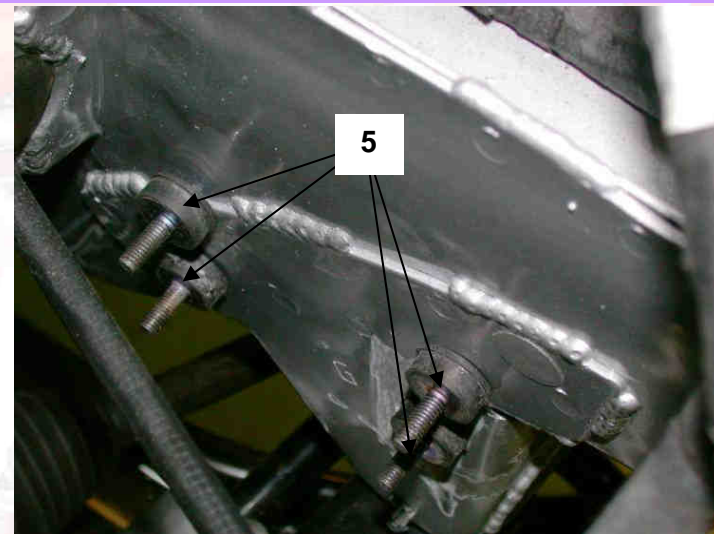


The procedure is the same for the lower radiator fixing. Fit the silent-blocks (*ref. 11*) on the lower crossmember bracket using nuts (*ref. 12*).

Fit the radiator on the silent-blocks using nuts (*ref. 12*).



Fit the oil pump silent-blocks (*ref. 5*) on the left support of the front side-member, tapped beforehand (refer to the body preparation sheet).



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Prepare the oil pump by the assembly of both dash 6 connectors ([ref. 15](#)) and bi-material seal ([ref. 16](#)) on the oil pump.



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Assembly the oil pump on silent-blocks with nuts ([ref. 6](#)) as shown in the photo below.



Connecting up the oil pump:

You have to make the bundle connecting the front engine compartment / passenger compartment bundle to the oil pump.

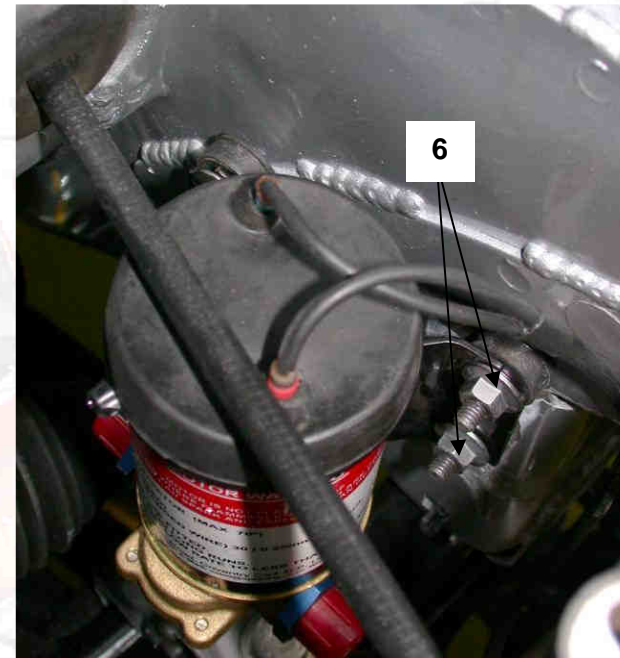
You will find the "reverse" connector for the connection to the front engine compartment / passenger compartment bundle in the package reference [3Z9S82148D](#).

The pin out (to be followed accurately for the pump's direction of rotation) is as follows:

Pin 1: - (to be connected to the – pin of the pump)

Pin 2: + (to be connected to the + pin of the pump)

Recommended wire size: **AWG 20**





Fit the hoses for the pump, gear box and radiator, and also the oil filter, as shown in the diagram on [page 6](#).

Oil to be used: TOTAL BV 75W90 Transmission H50168B (ref CITROËN Sport 1C2340626B)

Quantity:

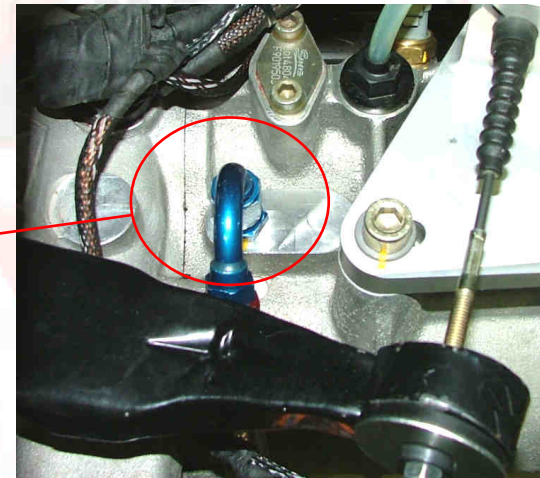
When the gear box is new, or disassembled and serviced (without oil) and the cooling circuit is also new:

1.2 Litres.

When it is changed in operation or in the workshop, and the cooling circuit has not been changed: **1 Litre.**

Topping up:

Top up the gear box via the connector shown in the photo opposite:



Topping up

For the references of the parts making up the gear box, as well as recommendations for use and maintenance, download the SADEV notice via the following link:

http://www.citroen.com/NR/rdonlyres/51C68D84-FA58-484F-B46F-C1EBAFE48859/102039/C2R2_CitroenSport_13052008.pdf