

Sample Set

MODEL "L, M, R" SERIES
ASSEMBLY INSTRUCTIONS

(See sheet 5)

1. Place the engine on the transom of your boat so that it is mounted vertically, in the normal position. Remove the engine cover and disconnect the electric shift wires. Slide the insulating sleeves back over the bare wire hot leads on the power head. As the gearbox is lowered, the lower wire leads will come out of the exhaust housing. (On mechanical shift models, disconnect upper shift rod pin).
2. To lower the gearbox, remove the 5 exposed bolts. Remove the trim tab and the bolt up inside the trim tab opening. Bump the gearbox loose and slowly lower, at the same time push and pull on the electric shift wire leads to assist them in coming out of the exhaust housing. Seal wire hole with 3/8 x 1 rubber plug.
3. Remove the water pump, including stainless steel plate, and the upper drive shaft "O" ring from the gearbox assembly.
4. Where required, cut about 7/8 inch off the plastic tube extending beneath the water pump, so that when it is installed in the jet, it will clear the bottom of the housing. This is for recirculating cooling water. See diagram on page 4.
5. In the engine exhaust housing, the rear 7/16 inch bolt hole must be drilled out for a smaller bolt coming down from above. A drill and spotfacer kit is available on loan from the factory or your dealer. Drill the hole through with a 25/64 drill first. Then back spot face the top of the hole to provide a flat seat for the 1/2 inch long spacer sleeve which goes under the bolt head to provide wrench clearance. Spot face until the bolt, with spacer sleeve in place, will extend through 5/8 inch. See diagram on page 4.
6. Attach the driveshaft assembly to the jet drive using the 4 - 1/4-20 x 7/8 long screws and lockwashers.
7. Mount the water pump assembly to the jet. Be sure the water pump impeller key is in place. Slide the "O" ring onto the driveshaft spline, where used. See page 3*.
8. Remove the rubber cushion exhaust tube seal from the propeller gearbox and place in the jet housing. Place the 2 plastic water tube guides into the water pump. Lightly grease the water tube ends and rubber sockets, and the exhaust tube and rubber seal, for easy entry. Generously grease the driveshaft spline and you are ready to install the jet.
9. The jet is held in place by 4 - 3/8 bolts and lockwashers from below and 1 - 3/8 bolt and spacer sleeve from above, rear. Lightly grease the bolt threads and carefully guide the jet into place being sure the water tubes engage properly. Tighten the 5 bolts.

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