

## KIT 429

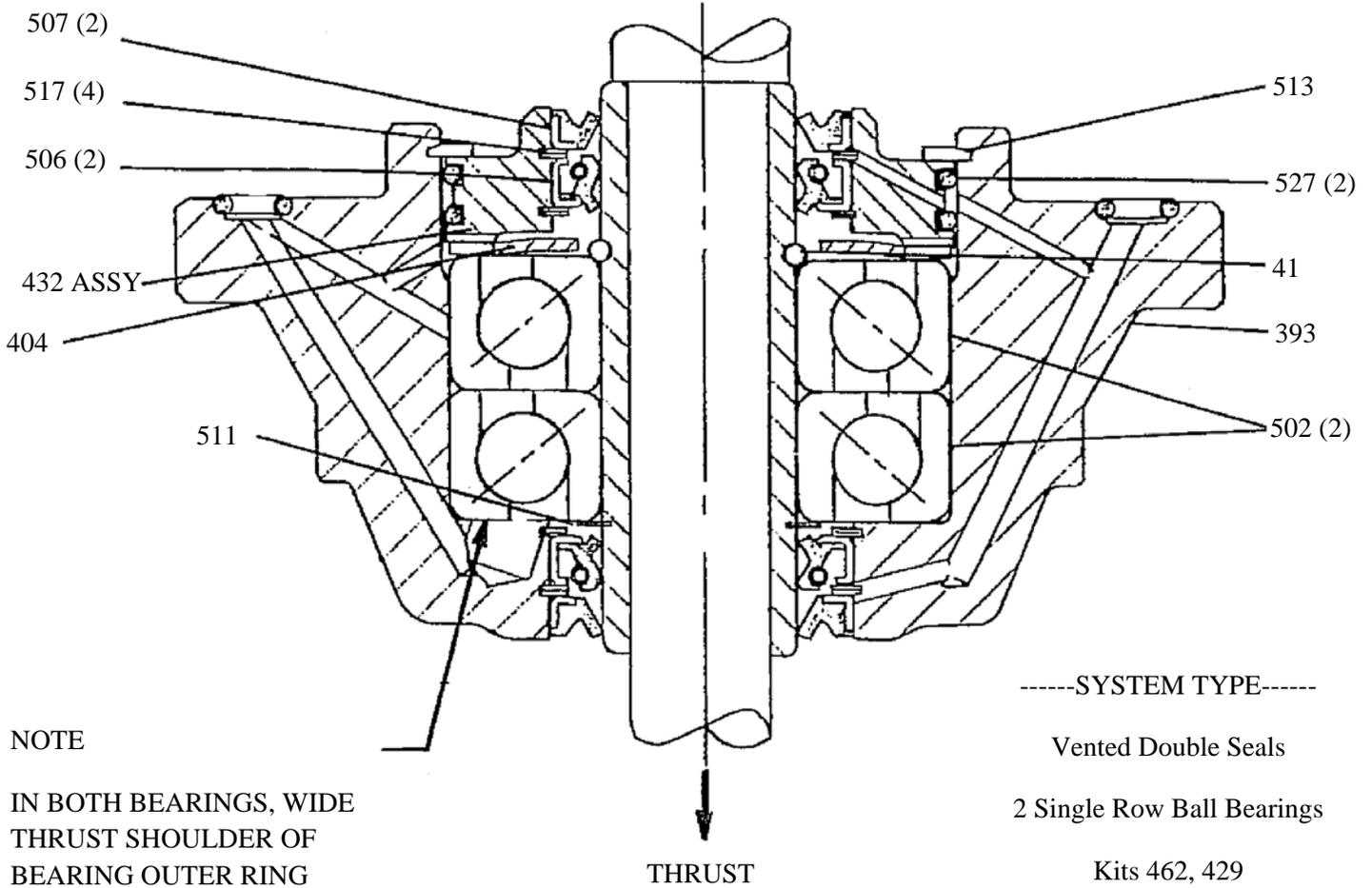
### BEARING AND SEAL REMOVAL AND INSTALLATION

1. Remove the large snap ring 513 from the bearing housing. Heat the housing with a torch only until you can barely touch it. Holding the driveshaft vertically, bump the impeller end of the shaft against a wooden block causing the housing to slide down off the bearings.
2. Press the bearings off the driveshaft. Leave the round thrust ring 41 on the shaft unless damaged. Remove the seals from the housing and upper seal ring. Clean all parts thoroughly. Remove burrs.
3. Press the new bearings 502 on the shaft, pressing against the inner races only. Note thrust direction and press up against the thrust ring, locking it in its groove.
4. To install seals, install the inner seal retaining rings 517 first. Place a light film of grease on each surface before pressing in the seals. Press in the garter spring seals 506. Garter spring faces out.
5. Install the outer seal retaining ring 517. If the system is vented (uses 4 seals) align the notched ends of the retaining ring to straddle the small vent hole drilled in the ring groove.
6. Fill the garter spring cavity in the seals with grease. Install the outer seals 507. Grease all 6 seal lips.
7. Grease the two “O” rings 527 and install them on the upper seal ring 432. Apply a thin film of grease inside the housing bore to ease entry of the bearings and upper seal ring “O” rings.
8. Install the housing 393 on the shaft and bearing assembly. You may want to head the housing slightly again. It is important to slide the housing on squarely and not to use a hammer or in any way apply impact loads to the balls. If you use a hand press, as we do, press against the outer race of the bearings. Only a light load is needed if everything is lined up properly.
9. Install the backup washer 404 against the upper bearing, with the dished center section facing up, giving clearance against the inner race of the bearing. See diagram.
10. Install the upper seal ring assy 432 being careful not to shear the “O” rings 527 as they pass the snap ring groove. Only finger pressure should be necessary here. Install the beveled retaining ring 513, beveled side up.
11. Install the driveshaft assembly in the jet drive and fill with grease. We recommend using the small jiffy luber grease gun supplied with the jet. If you use a hand lever gun, pump very slowly so as to not build up internal grease pressure and damage the seals or housing.

BEARING & SEAL KIT 429

Two Bearing System

Large Series Jet Drives, 2-1/2 inch exhaust pipes  
(for seals, "O" rings & snap rings only, order kit 462)



NOTE

IN BOTH BEARINGS, WIDE  
THRUST SHOULDER OF  
BEARING OUTER RING  
FACES DOWNWARD

-----SYSTEM TYPE-----

Vented Double Seals

2 Single Row Ball Bearings

Kits 462, 429

Outboard Jets

2035 Edison Ave

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