

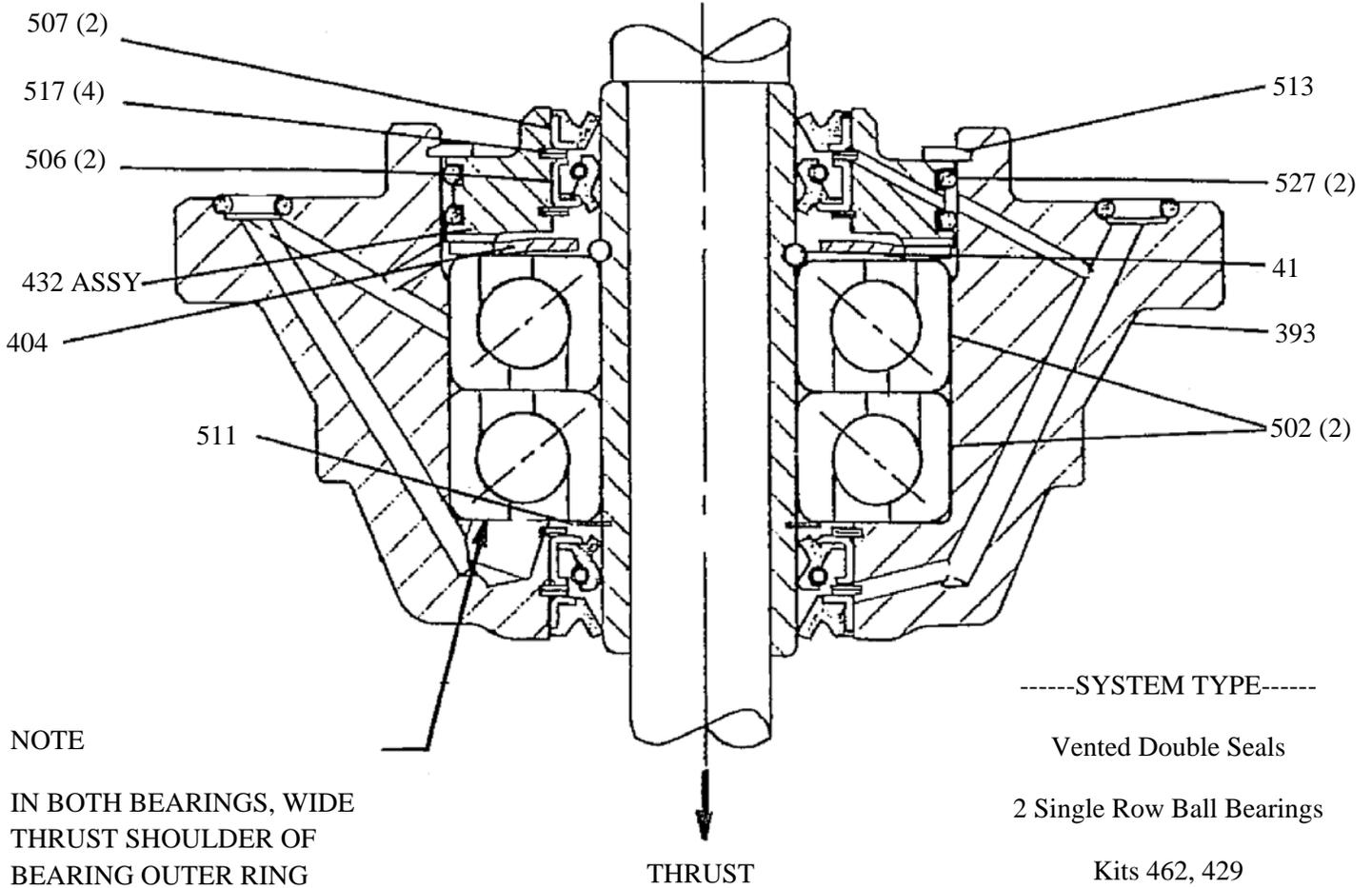
BEARING AND SEAL REMOVAL AND INSTALLATION

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 in.
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. Install the outer seal 507 with the garter spring facing outward. Grease all 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 heat 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 404 backup washer from the splined end of the shaft against the bearings. **Black Dot on backup washer must face toward bearings.**
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

Outboard Jets

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