

## KIT 804

### BEARING AND SEAL REMOVAL AND INSTALLATION

1. Remove the large snap ring 512 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 bearing 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. Install collar 477. Install dished washer 1536 as shown with clearance above inner race of bearing. **Black dot on Backup Washer must face toward bearing.** Press the new bearing 504 on the shaft, pressing against the inner race only. Not thrust direction and press up against the thrust ring, locking it in its groove. Install truarc ring 511.
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. (garter spring seals 506 replace old double lip seals 508)
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 seals 507 with the garter springs facing outward. (used only on 4 seal systems) Grease all seal lips.
7. Grease the two "O" rings 526 and install them on the upper seal ring 433 (Seal ring 433 replaces old seal ring which used on "O" ring 524). 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 bearing housing 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 spacer ring 1535.
10. Install the upper seal ring assy 433 being careful not to shear the "O" rings 526 as they pass the snap ring groove. Only finger pressure should be necessary here. Install the beveled retaining ring 512 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 804

Single Bearing System

For use on jet drive models A, A74, B, C, E, F, H, J, Q, U, V, Z, AB, AE, AF, AH

(replaces certain double row ball bearing systems)

(For seals, "O" rings & snap rings only, order kit 803)

