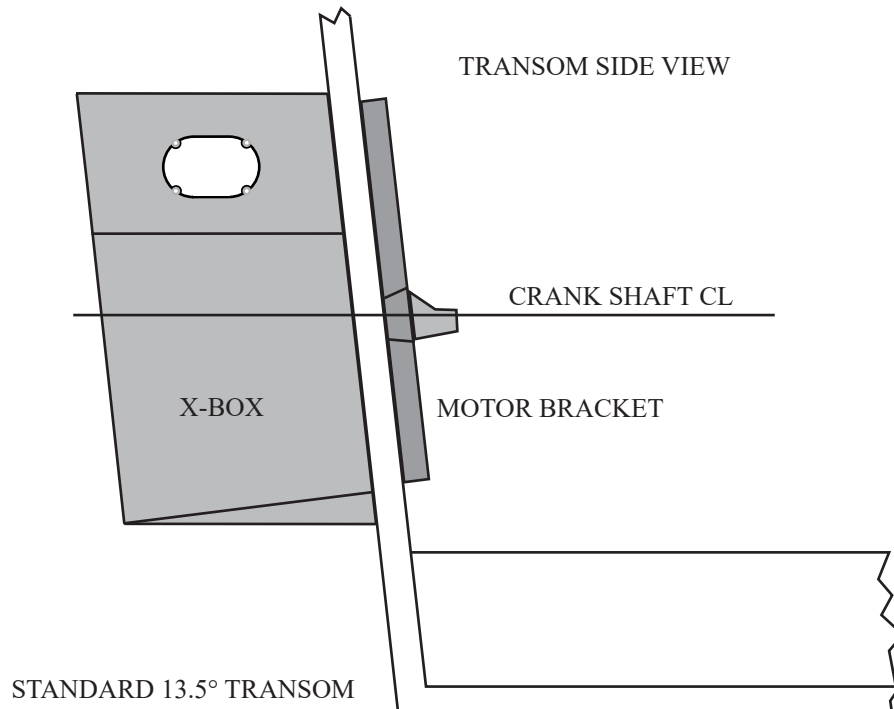
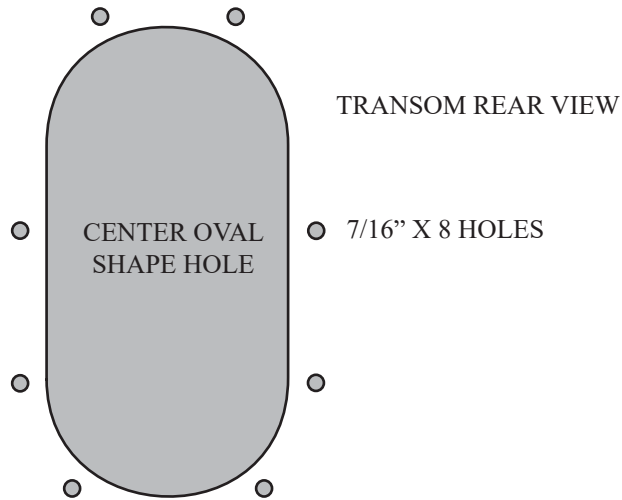


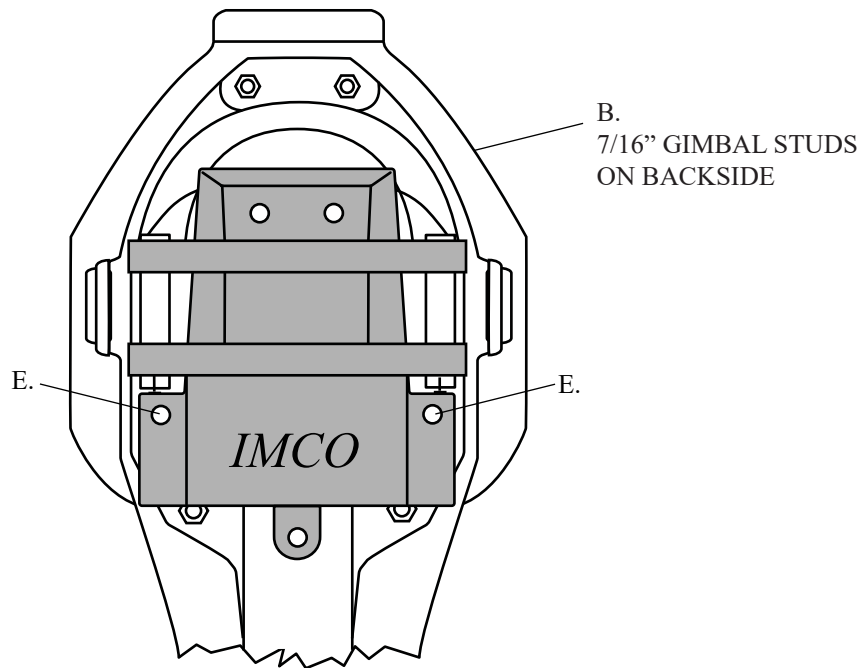
# INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO X-BOX

- A. USE THE X-BOX AS YOUR TEMPLATE AND DRILL 8ea 7/16" HOLES  
TRACE AND CUT OUT THE ENTIRE CENTER OVAL SHAPE HOLE, INSTALL X-BOX AND MOTOR  
BRACKET FOR SEALING X-BOX TO TRANSOM USE 100% SILICONE



## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO X-BOX

- B. REMOVE ALL EIGHT 7/16" GIMBAL STUDS AND REPLACE WITH SHORTER STUDS PROVIDED, BE SURE THE WATER INLET FITTING IS POSITIONED SO WATER INLET HOSE WILL NOT COME IN CONTACT WITH THE DRIVE SHAFT, INSTALL EXHAUST BLOCKOFF PLATE (NOT PROVIDED) INSTALL GIMBAL HOUSING TO THE X-BOX, INSTALL MOTOR AND ALIGN WITH IMCO ALIGNMENT TOOL
- C. REMOVE THE STOCK DRIVE SHAFT FROM STERN DRIVE (IT IS BEST TO REMOVE THE PAINT AROUND THE BEARING CAPS AND SNAP RINGS FIRST) REMOVE SNAP RINGS, USING A U-JOINT TOOL SLIDE THE DRIVE SHAFT TO ONE SIDE AND REMOVE IT, INSTALL IMCO DRIVE SHAFT IN REVERSE ORDER, INSTALL STERN DRIVE TO GIMBLE HOUSING
- D. USING A CLEAN CONTAINER DRAIN OIL FROM STERN DRIVE, REMOVE STOCK BRAVO SHIFT COVER AND TAPE OVER OPENING LEAVING THE THREE BOLT HOLES CLEAR
- E. BOLT ON STEERING CAP (USE WD-40 OR SIMILAR TO HELP DRILL & TAP HOLES) USE A 3/8" DRILL BIT AND SPOT DRILL 1/8" DEEP, REMOVE STEERING CAP AND DRILL 5/16" X 1 1/4" DEEP, TAP HOLES 3/8-16 X 3/4" DEEP PERFECT THREAD, CLEAN ALL BOLT HOLES AND REMOVE TAPE
- F. REMOVE O-RING AND DETENT PIN FROM STOCK BRAVO SHIFT COVER AND INSTALL IN STEERING CAP
- G. INSTALL STEERING CAP, TORQUE BOLTS @ 35 FT LBS
- H. USING A PUMP REFILL STERN DRIVE FROM THE BOTTOM UP WITH DRAINED OR NEW OIL



## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO X-BOX

- I. FOR A SINGLE X-BOX STER SYSTEM, DRILL ONE 1/2" HOLE AS INDICATED PER SIDE, ATTACH SIDE MOUNT BRACKETS TO THE X-BOX THRU THE SLOTTED HOLES AND SNUG BOLTS
- J. INSTALL STEERING RAMS WITH 3/4" CLEVIS PINS ONLY (NO NUTS AT THIS TIME) FOR MULTIPLE STERN DRIVES INSTALL TIE BAR PER DRAWING, FOR PROPER STERN DRIVE ALIGNMENT MEASURE PROP SHAFT CENTERS TO NOSE CONE CENTERS & ADJUST TIE BAR UNTIL THEY BECOME EQUAL, AT THIS POINT ALL STEERING HARDWARE SHOULD BE CONNECTED
- K. TURN STERN DRIVE(S) ALL THE WAY TO THE LEFT AND HOLD FIRM, ADJUST SIDE MOUNT BRACKETS EQUALLY UNTIL THE LEFT STER RAM IS 100% COLLAPSED AND THE RIGHT STER RAM IS 100% EXTENDED, LEVEL SIDE MOUNT BRACKETS LEVEL WITH CRANK SHAFT CL AND TIGHTEN BOLTS, REMOVE RAMS, MARK AND DRILL THE REMAINING HOLES, REATTACH SIDE MOUNT BRACKETS AND GASKETS USE 100% SILICONE TO SEAL AROUND BOLT HOLES
- L. LOCATE BULKHEAD TUBE BRACKETS PER DRAWING, DRILL HOLES AND INSTALL, FOR SEALING USE 100% SILICONE, ATTACH STER RAMS, HOSES & TIE BARS PER DRAWING

