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## INSTALLATION INSTRUCTIONS

### Nose Cone #620-11250

**Step 1:** It is advisable to remove the lower gear case from your existing stern drive to facilitate the installing of the nose cone. If your gear case has speedo pick-up on leading edge, either drill hole in the cone or better, use external transom pick-up, which is more accurate.

**Step 2:** Place straight edge on front center of cavitation plate. Align straight edge with skeg by eye. Any deviation right or left of center 1/32" or more will cause increased steering torque and less speed gain than anticipated. Also eye straight edge down centerline or propshaft from side view. Straight edge should come through center of nose.

**Step 3:** After scribing the line, remove the nose cone and either sand or use strip ease, or some heavy duty paint remover, to remove the paint and primer down to the bare metal on the nose of the lower unit all the way back to the line that was scribed in step #2. Rough sand the area with 80 grit sand paper, rough sand the bar aluminum casting on your existing lower unit and feather in the existing baked on enamel paint that remains on the gear case.

**Step 4:** Apply 1/16" to 1/8" layer epoxy on bow half inside cone. Apply 1/8" layer on prop half of circular portion that surrounds bottom of gear case bullet. Important- Front view and side view alignment is critical. Remove side water pick-up screen and plug cav. with rag and tape over it. This is to keep water inlet clean.

**Step 5:** After contact has been made, apply firm downward force on the nose-cone which will allow the epoxy to ooze out the edges where it makes up with the existing lower unit. While gently holding pressure on the cone, take knife and gently remove excess epoxy. Cone should seat down almost to line scribed.

**Step 6:** After allowing the epoxy to set between 8-12 hours, depending on temperature, you may begin the application of marine epoxy to feather into the existing lower unit. After you have blended the nose cone in with the existing gear case, begin the process of sanding the filler to feather it in to the existing gear case, which will then form one continuous shape to the gear case.

**Step 7:** After you have completed sanding the entire assembly, primer the gear case with a good primer. Use very light coating. After the primer has dried and been sanded, you may then apply a good quality high gloss black enamel paint to return the unit to its original finish.



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