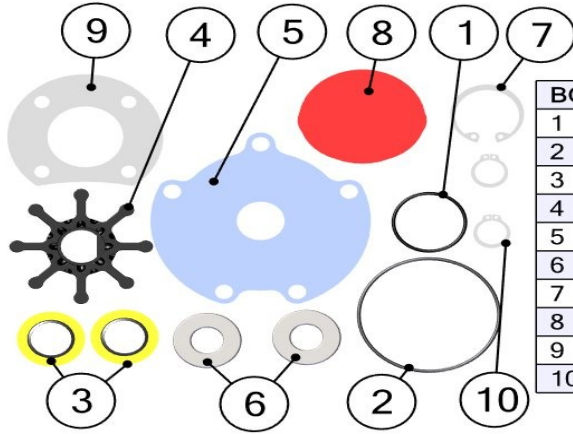


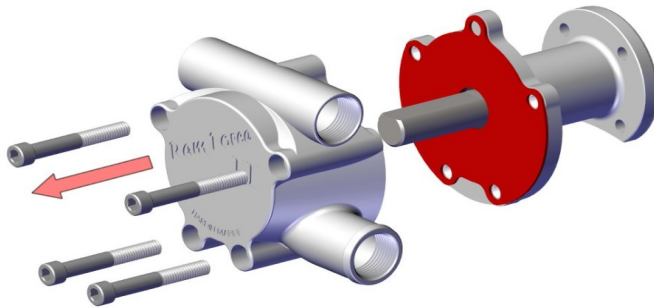


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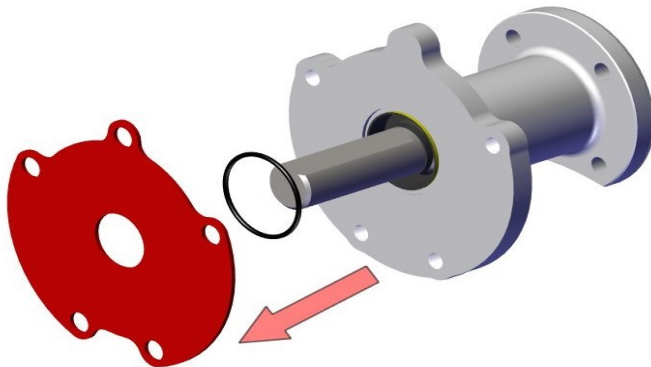


BOM ID	Qty	Name	Description
1	1	625-1026	O-RING
2	1	625-1037	O-RING
3	2	625-4005	SEAL, SEA PUMP
4	1	625-4011	IMPELLER, SEA PUMP
5	1	625-4018	WEAR PLATE, SEA PUMP
6	2	625-4252	BEARING, CAM DRIVEN SEA PUMP
7	1	625-4253	RING
8	1	625-4265	WEAR PLATE, INTERNAL
9	1	625-4277	GASKET
10	2	625-4303	SNAP RING, SHAFT



Step 1:

- 1) Remove the sea pump from the engine.
- 2) Use a 1/4 hex socket, remove the 4 bolts.
- 3) Slide housing off the shaft.



Step 2:

- 1) Remove the wear plate and o-ring,

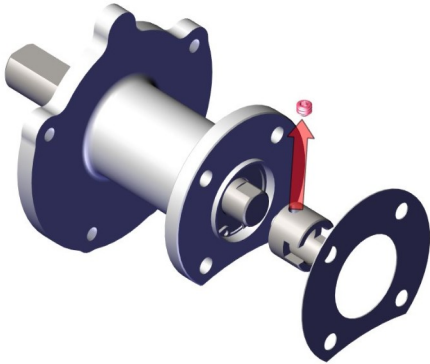


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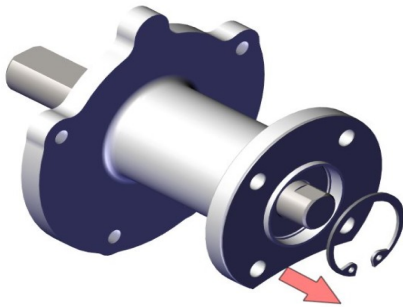
Step 3:

- 1) Remove gasket and clean the surface.
- 2) Use a 1/8 allen key to loosen the set screw.
- 3) Remove driver.



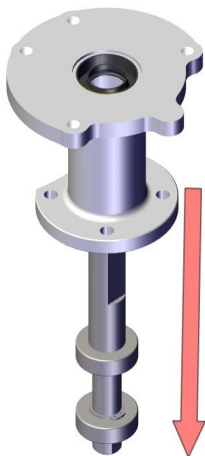
Step 4:

- 1) Remove snap ring.



Step 5:

- 1) Press the shaft out the snap ring side.



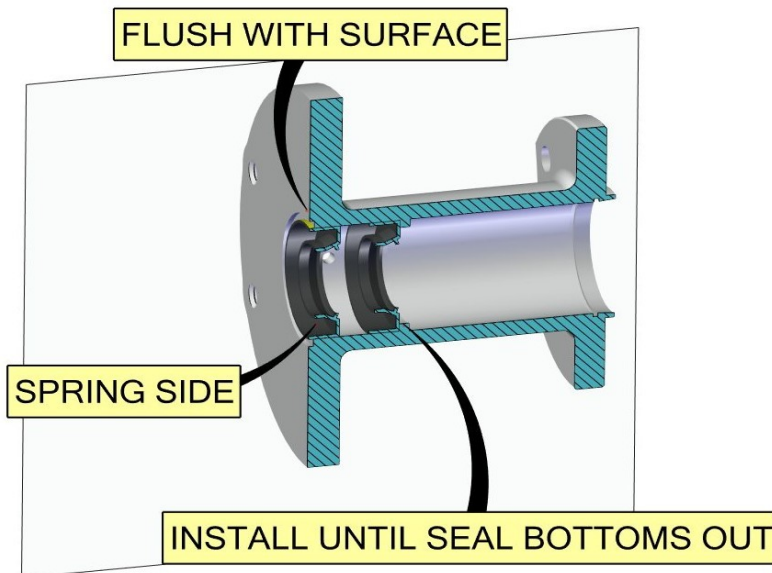
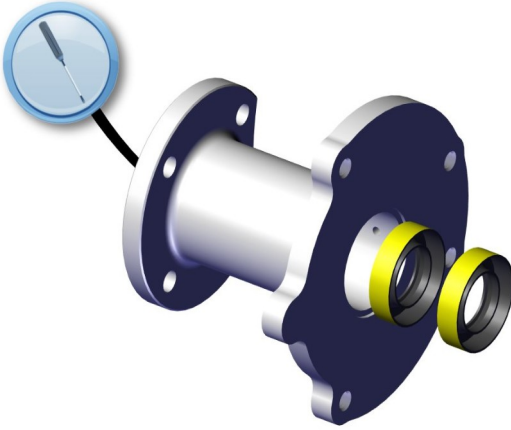


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Step 6:

- 1) Use screwdriver to remove both seals.
- 2) Clean inside the housing and both faces.

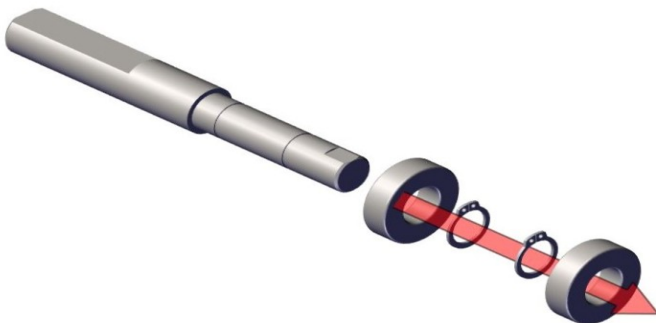


Step 7:

- 1) Use a 1.245 diameter seal installer to install seals.
- 2) Make sure the side is outward.
- 3) The first seal is pressed to the step in the bore.
- 4) The outer seal flush with the face.

Step 8:

- 1) Remove the outer bearing.
- 2) Remove both snap rings.
- 3) Remove the last bearing.
- 4) Clean the shaft.



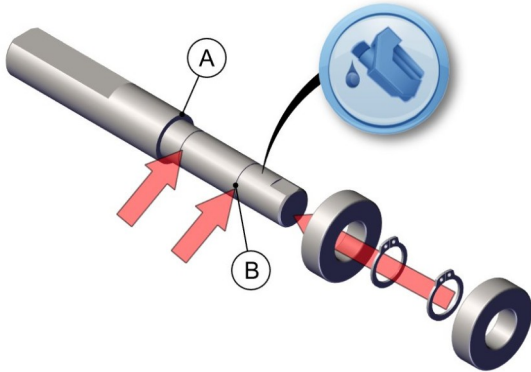


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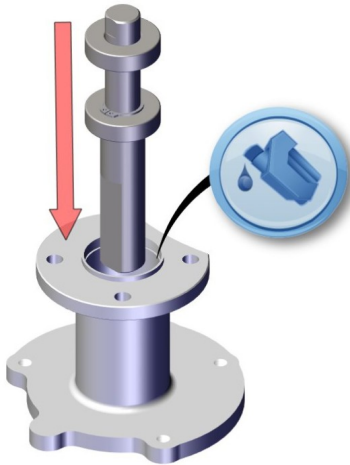
Step 9:

- 1) Use grease to install the first bearing till it hits the step.
- 2) Install snap ring in the grooves, Fig. A & B.
- 3) Use grease to press the last bearing till it hits B groove.



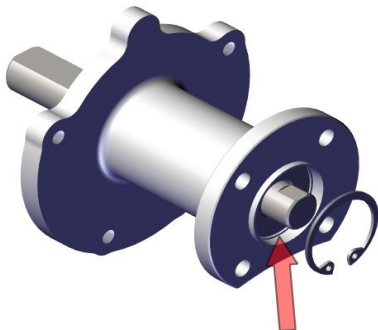
Step 10:

- 1) Apply white lithium grease to the inside bore.
- 2) Press shaft assembly in the housing as shown.



Step 11:

- 1) Install snap ring.



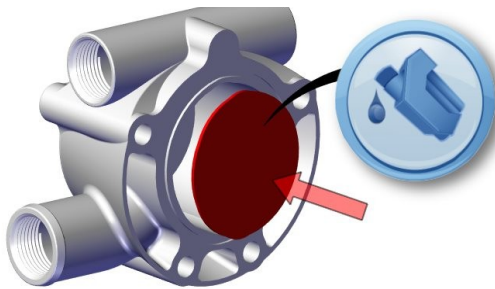
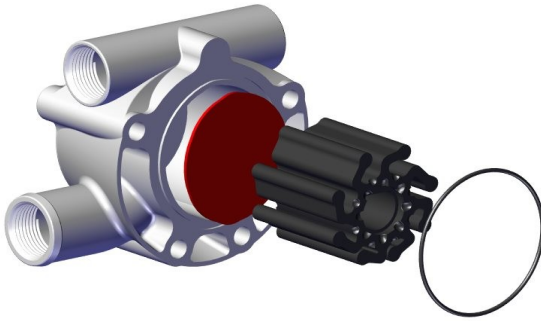


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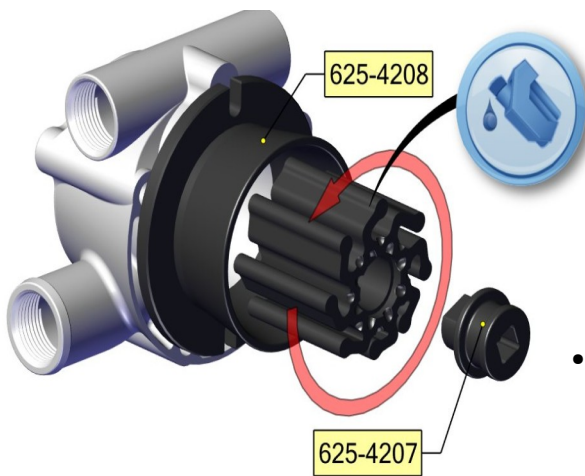
Step 12:

- 1) Remove the o-ring and impeller.
- 2) Use a pick to remove to remove the wear plate if it does not fall out.
- 3) Clean out the body.



Step 13:

- 1) Install wear plate.
- 2) Coat the face with white lithium grease.



Step 14:

- 1) Coat the impeller housing with white lithium grease.
- 2) Use 625-4209 kit to install impeller.
- 3) Make sure to install the impeller with the blades bent backwards. The impeller turns CCW.

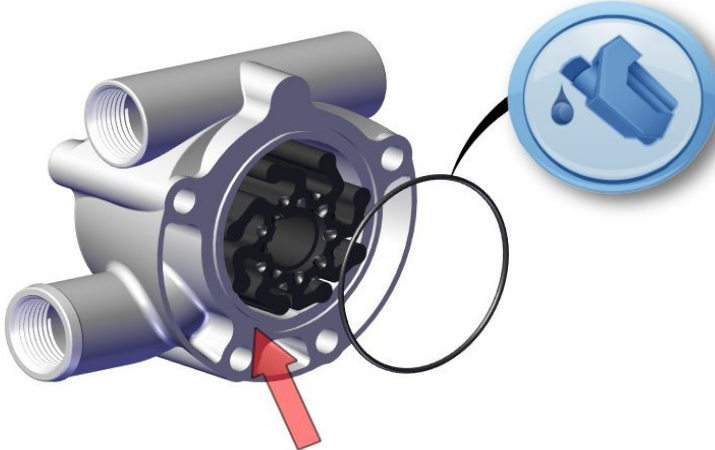


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Step 15:

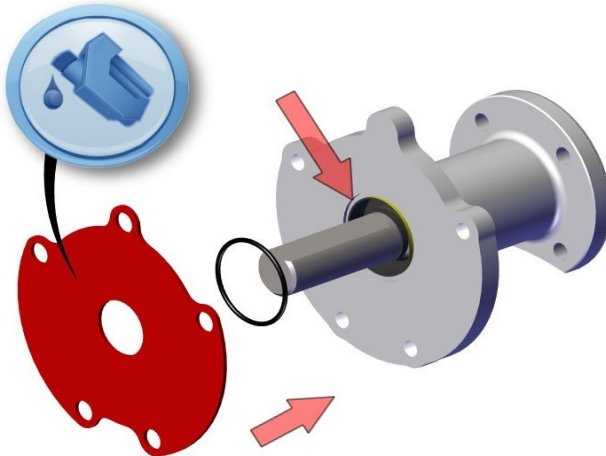
1) Apply white lithium grease to the large o-ring and install into the groove.



Step 16:

1) Apply white lithium grease to the o-ring and the face of the wear plate.

2) Install o-ring into the groove and the wear plate.

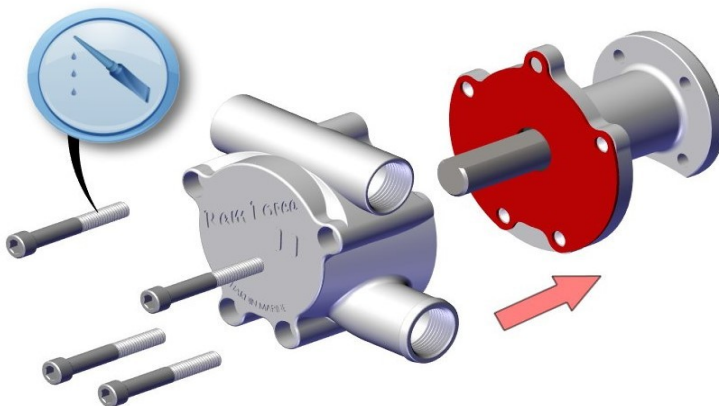


Step 17:

1) Slide body assembly onto the shaft.

2) Apply anti-sieze to the bolts.

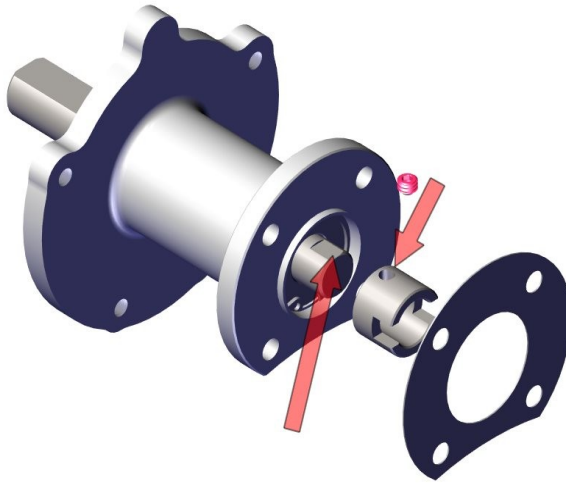
3) Using 1/4 socket to install the bolts and torque to 20 ft. lbs..





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Step 18:

- 1) Install driver onto the shaft.
- 2) Apply red Loctite to the set screw,
- 3) Use a 1/8 allen key to install set screw. Make sure it bottoms out on the flat on the shaft.
- 4) Install gasket and reinstall pump on the engine.