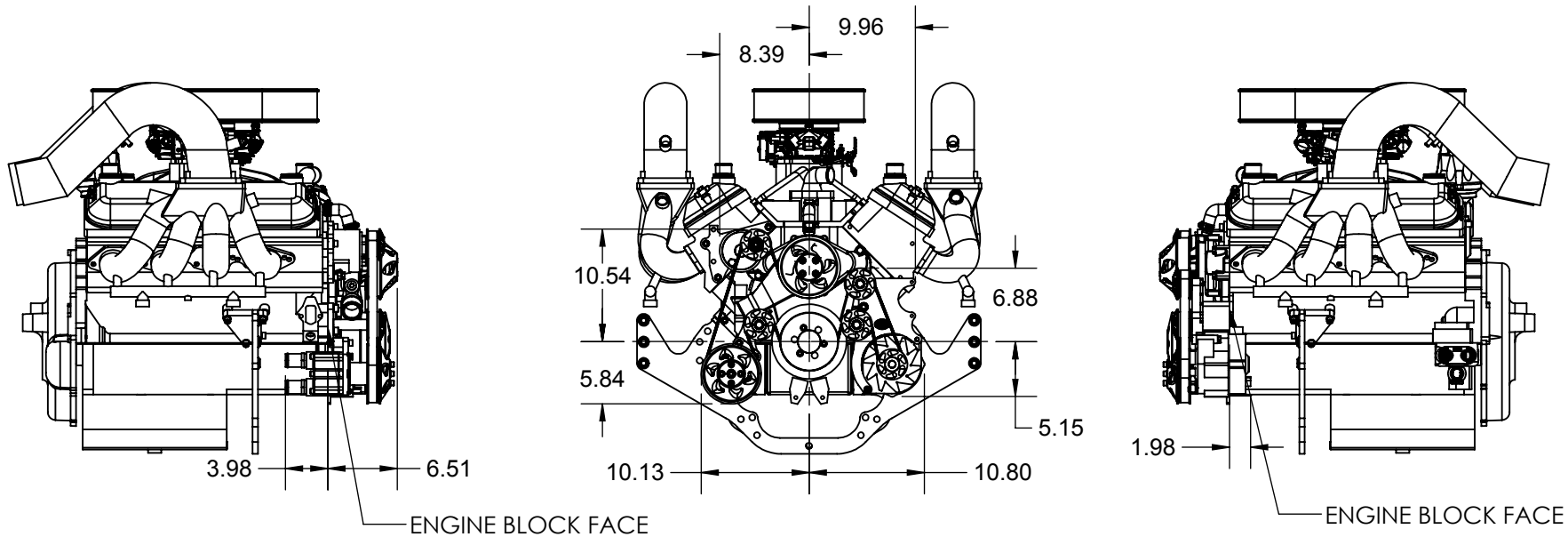
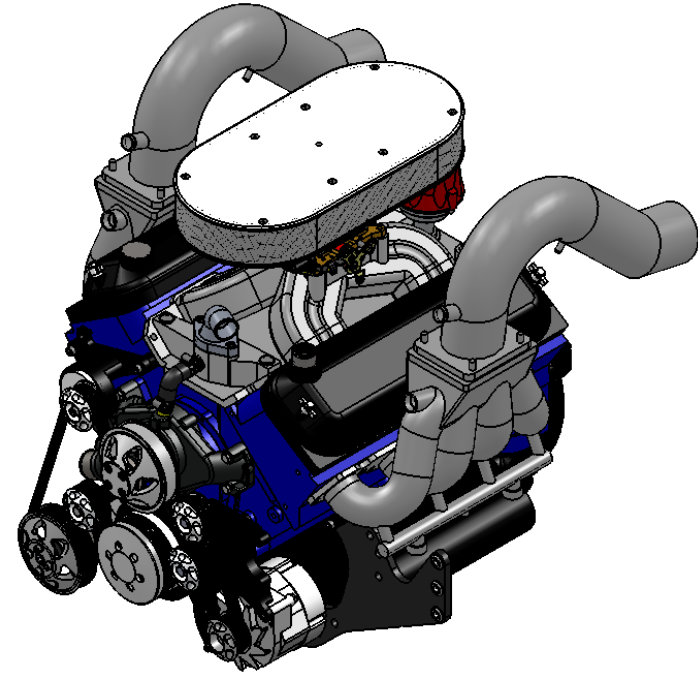


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PART NO.
625-8300

TITLE: 1 STG CIRC PUMP SERPENTINE
DRIVE KIT NON POWER STEERING

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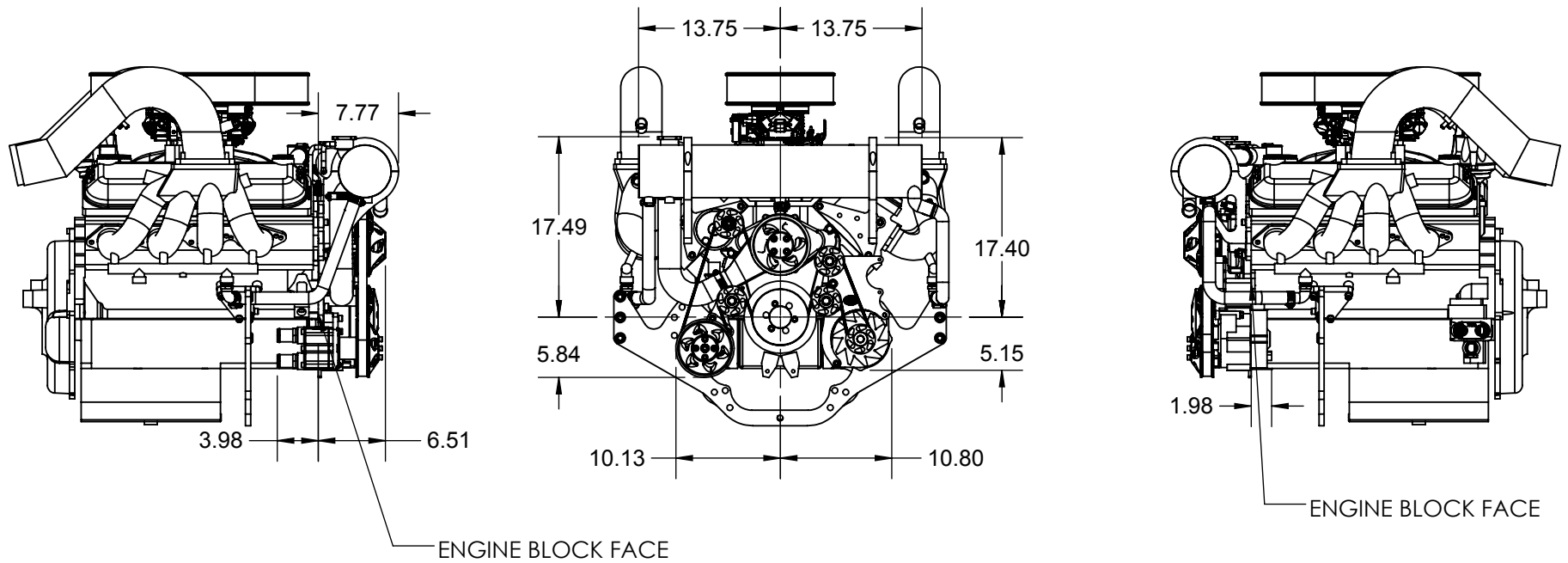
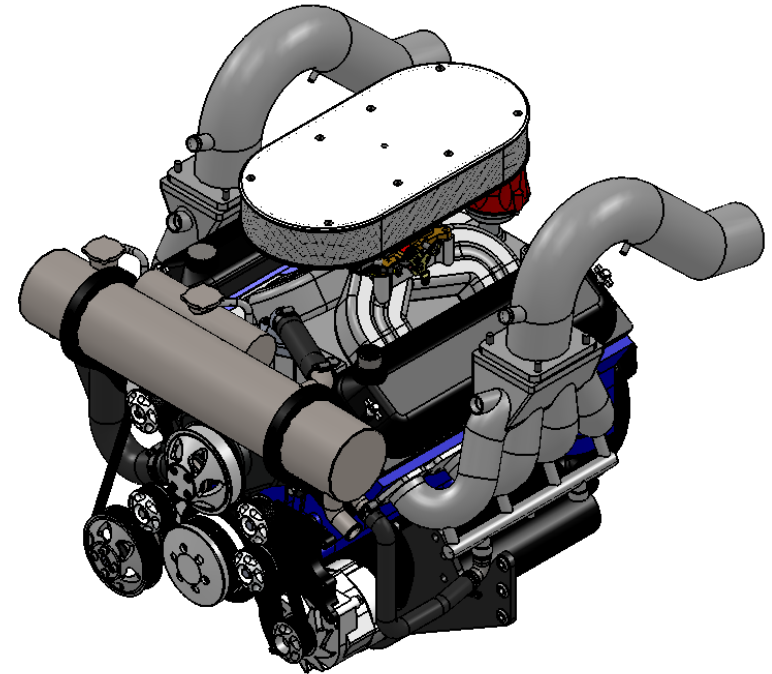
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MARINE 386-445-2500 / FAX 386-445-1122

PART NO.
625-8301

TITLE: 1 STG CIRC PUMP SERPENTINE DIVE KIT
w/HEAT EXCHANGER NON POWER STEERING

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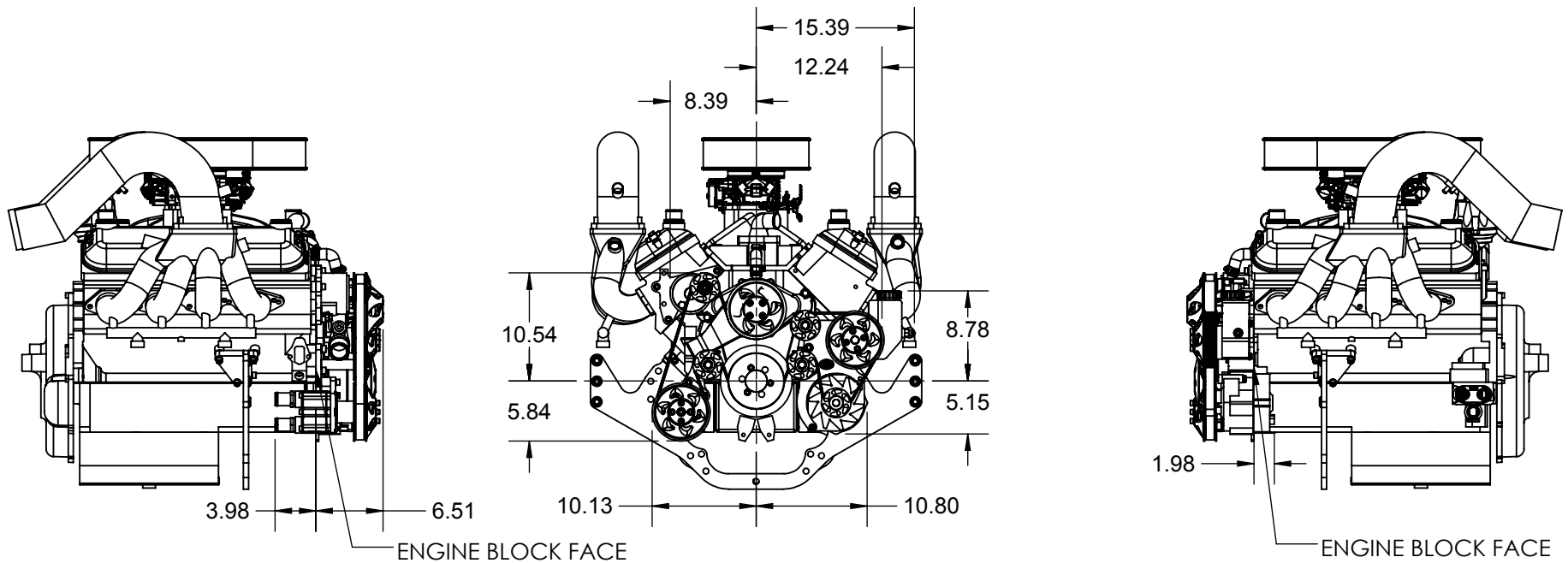
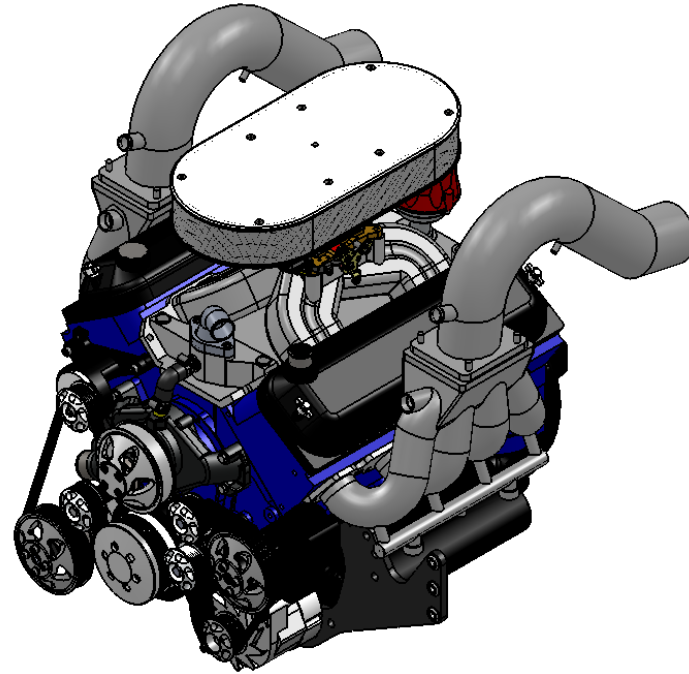
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PART NO.
625-8302

TITLE: 1 STG CIRC PUMP SERPENTINE DRIVE
KIT w/ POWER STEERING

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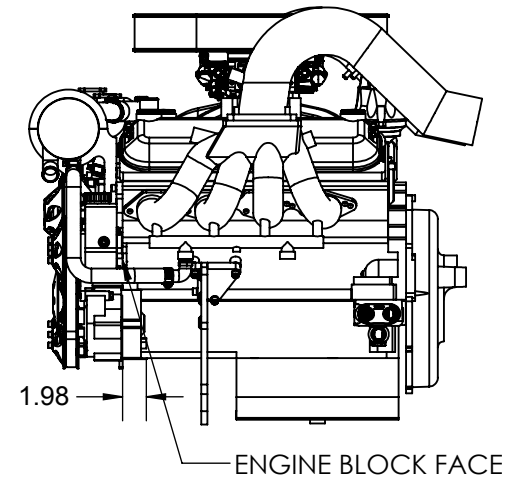
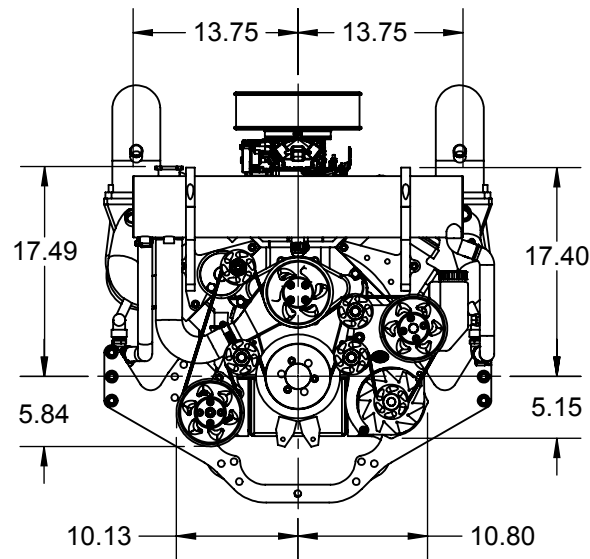
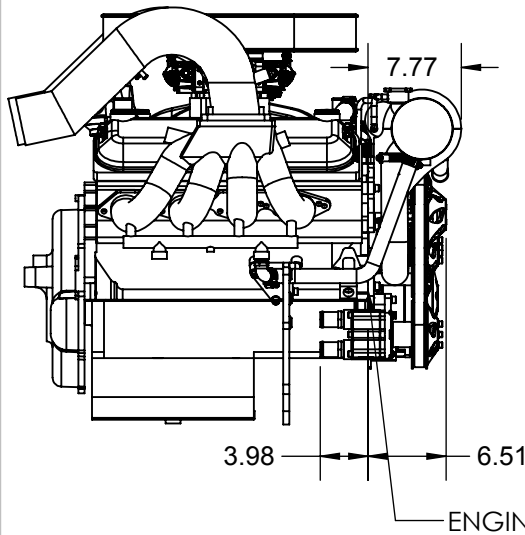
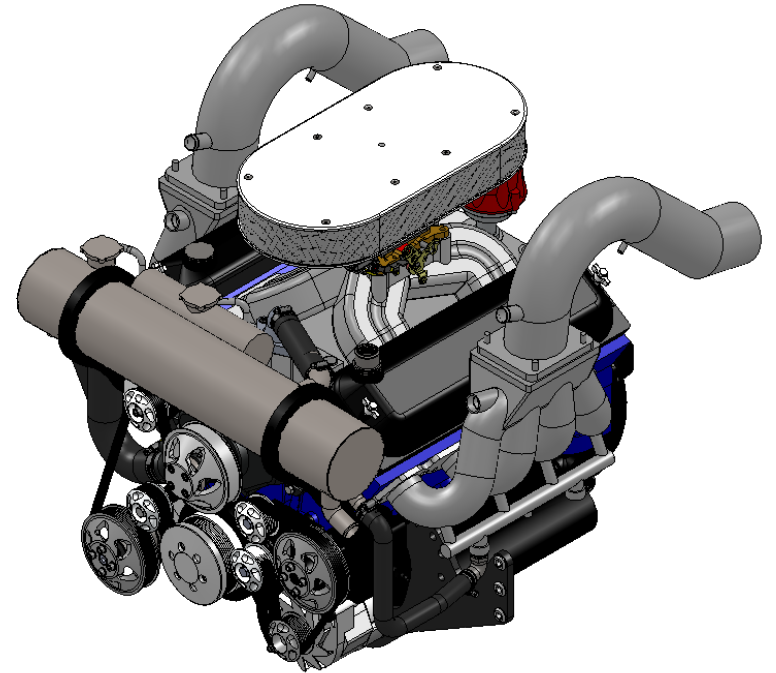
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PART NO.

625-8303

TITLE: 1 STG CIRC PUMP SERPENTINE DRIVE KIT w/
POWER STEERING & HEAT EXCHANGER

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PART NO.

625-830X

TITLE:

BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT - STEP 1

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	625-8176	PULLEY, CRANK - SERPENTINE	1
2	625-8177	COVER, SERPENTINE CRANK PULLEY	1
3	90037AN-STSS	WASHER, 3/8 AN	3
4	90037C150SH8	BOLT, SHCS, 3/8-16x1.50	3
5	90037F075SHS	BOLT, 3/8-24x.75	3
6	90050F200HH8	BOLT, CRANK	1

ASSEMBLY IS USED FOR 625-8300 THROUGH
625-8309 DRIVE KITS.

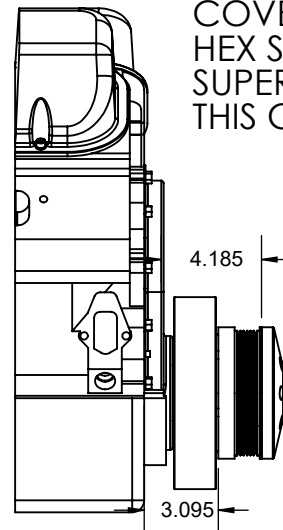
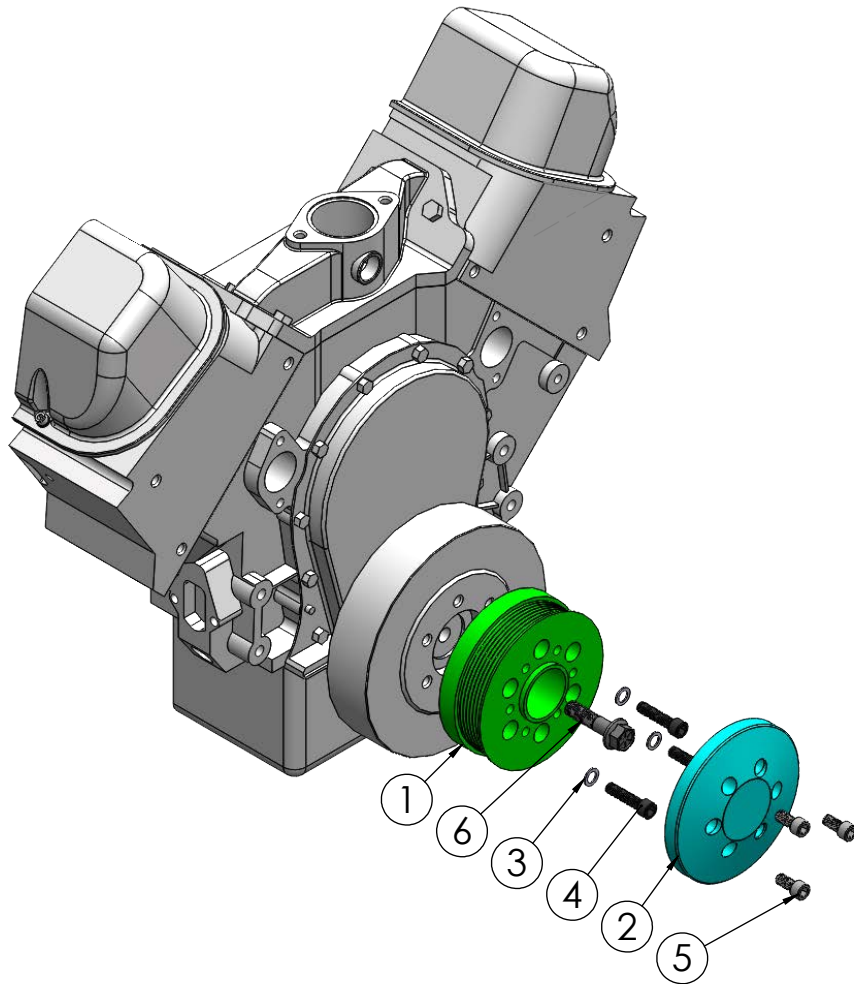
INSTALLATION INSTRUCTIONS:

1) MAKE SURE FACE OF DAMPER IS 3.095
FROM FRONT OF ENGINE BLOCK. CRANK
PULLEY 1.800 WIDE. SUPERCHARGER PULLEY
MOUNTING FACE IS 4.185 FROM BLOCK
FACE.

2) APPLY LOCTITE TO #4 BOLTS. INSTALL INTO
THE #1 CRANK PULLEY WITH #2 WASHERS.
USING 5/16 HEX SOCKET TORQUE TO 35 FT.
LBS..

3) APPLY LOCTITE TO #6. INSTALL INTO
CENTER OF THE CRANK PULLEY. USING 3/4
SOCKET, TORQUE TO 55-60 FT. LBS..

4) APPLY LOCTITE TO #5 BOLTS . INSTALL #2
COVER, TO THE CRANK PULLEY. USING 5/16
HEX SOCKET TORQUE TO 30 FT. LBS.. FOR
SUPERCHARGE APPLICATION, DO NOT INSTALL
THIS COVER.



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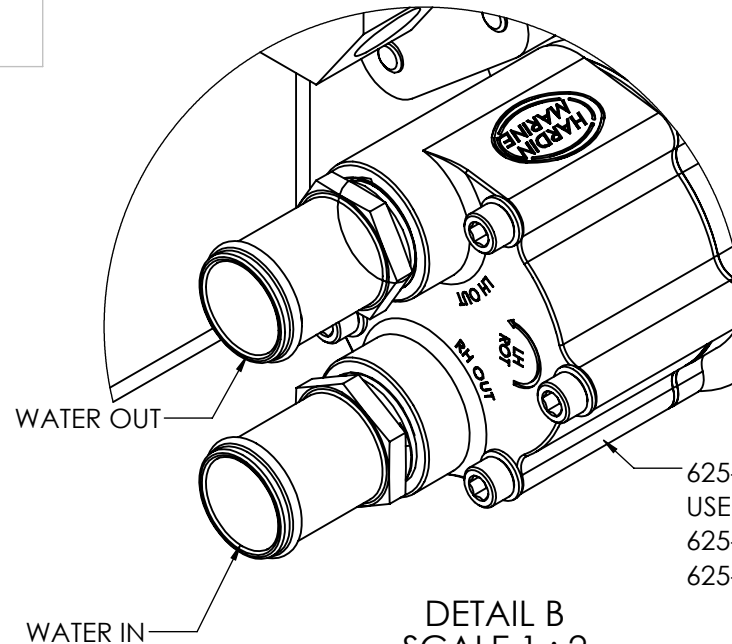
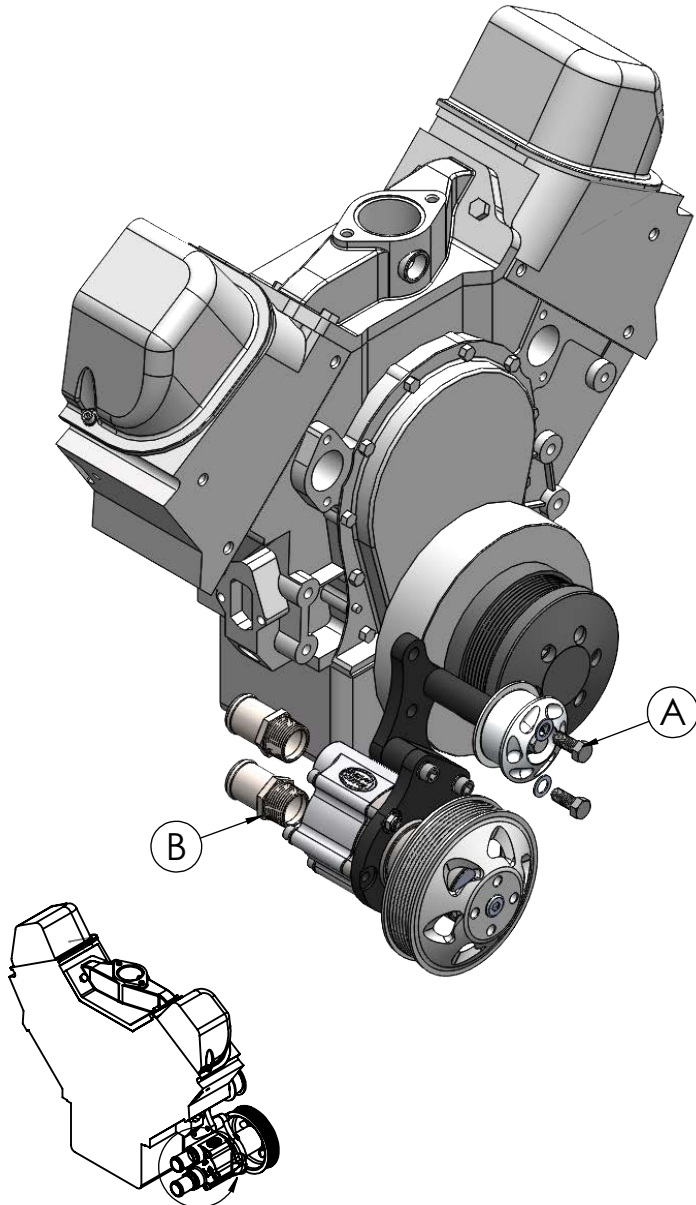
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PART NO.

625-830X

TITLE:
BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT - 1 STG PUMP - STEP -2

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625-4110 SEA PUMP,
USE S REBUILD KITS:
625-4189 IMPELLER KIT
625-4174 MASTER REBUILD KIT

ASSEMBLY IS USED FOR 625-8300, 625-8301, 625-8302 & 625-8303.

INSTALLATION INSTRUCTION:

- 1) APPLY LOCTITE TO THE 7/16 BOLTS, FIGA.
- 2) MOUNT TO ENGINE BLOCK. USING 5/8 SOCKET, TORQUE TO 40/45 FT. LBS..
- 3) FIG. B, SHOWS OPTIONAL 540-222151 1"NPT x 1-1/4 HOSE BARB FITTINGS. NOT INCLUDED.
- 4) DETAIL A SHOWS THE BACK OF THE SEA PUMP. FOR STANDARD ROTATION ENGINE, PORT RH OUT IS THE WATER COMING IN TO THE SEA PUMP. PORT LH OUT IS THE WATER EXITING THE SEA PUMP.

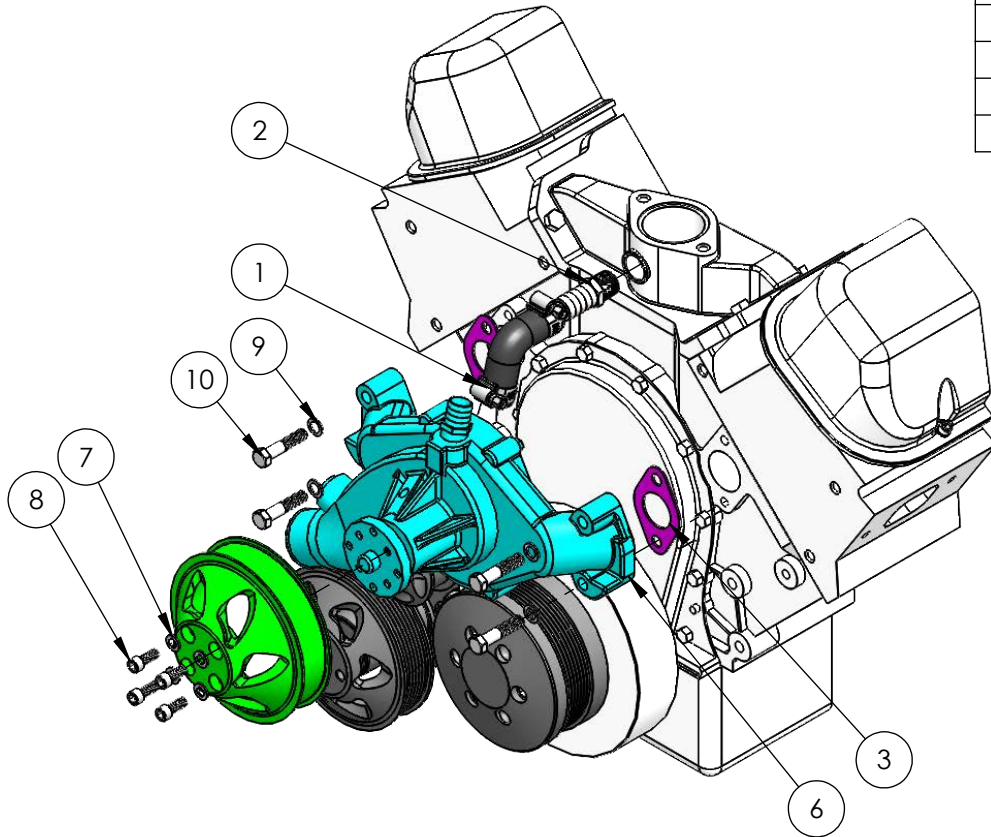
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PART NO.
625-830X

TITLE: BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT - STEP 3

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	100-720-6312	HOSE CLAMP	2
2	540-222107	FITTING, 1/2NPT x 3/4 BARB	1
3	620-05112K	GASKET, BBC WATER INLET	2
4	625-4059	PULLEY, CIRCULATION PUMP	1
5	625-4581	HOSE, JUMP	1
6	700-15301	CIRCULATING PUMP	1
7	90031AN-STSS	WASHER, 5/16 AN	4
8	90031F075SHS	BOLT, SHCS, 5/16-18x3/4	4
9	90037AN-STSS	WASHER, 3/8 AN	7
10	90037C175HHS	BOLT	4

ASSEMBLY IS USED FOR 625-8300 THROUGH
625-8309 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) APPLY GASKET TACH SEALANT TO THE CIRCULATING PUMP GASKETS, #3.
- 6) APPLY LOCTITE TO THE #10 BOLTS. INSTALL #9 WASHERS. USING 9/16 SOCKET INSTALL THE CIRCULATING PUMP. TORQUE BOLTS TO 35 FT. LBS..
- 7) APPLY LOCITE TO THE #8 BOLTS. INSTALL WITH #7 WASHERS. INSTALL #4 CIRCULATING PUMP PULLEY. USING 1/4 ALLEN SOCKET, TORQUE TO 25 FT. LBS..
- 8) APPLY LIQUID TEFLON SEALANT TO #2 FITTING. USING 7/8 WRENCH TO INSTALL INTO THE INTAKE MANIFOLD UNDER THE THERMOSTAT.
- 9) #5 BYPASS HOSE IS EXTRA LONG TO PROVIDE CONNECTION TO VARIOUS INTAKE MANIFOLDS. HOSE WILL NEED TO BE CUT TO SIZE. INSTALL WITH #1 HOSE CLAMPS.

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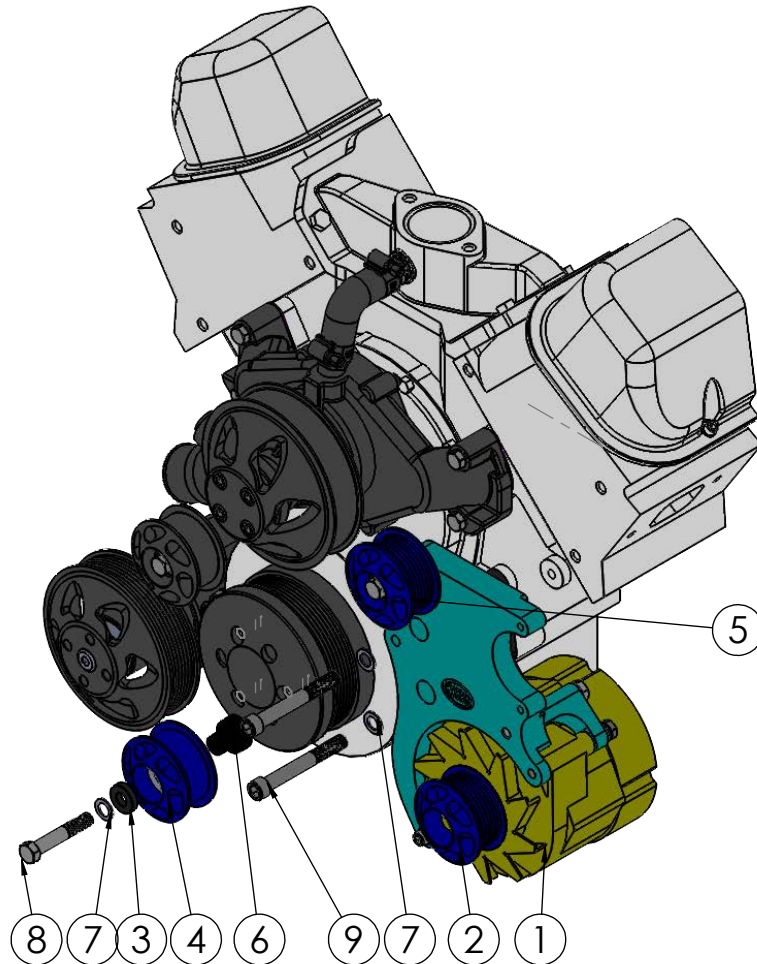
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PART NO.

625-830X

TITLE: **BBC CIRCULATION PUMP
SERPENTINE DRIVE KIT - STEP 4**

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	620-3147M-NC	94 AMP CHROME ALTERNATOR	1
2	625-3130	PULLEY, ALTERNATOR	1
3	625-4039	SPACER, 1" x7/16x.240	2
4	625-4364	PULLEY, SMOOTH IDLER	1
5	625-4365	PULLEY, RIBBED IDLER	1
6	625-8322	SPACER, IDLER - CIRC DRIVE KIT	2
7	90043AN-STSS	WASHER , 7/16AN	4
8	90043C250HHS	BOLT, HHCS, 7/16-14x2.50	2
9	90043C350SHS	BOLT, SHCS, 7/16-14x3.50	2

ASSEMBLY IS USED IN 625-8300, 625-8301, 625-8304, & 625-8305 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) THIS ACCESSORY BRACKET COMES PRE ASSEMBLED.
- 2) REMOVE #8 BOLT, #7 WASHER & #3 SPACER THAT HOLDS THE #4 SMOOTH IDLER & # 8 SPACER TO THE BRACKET.
- 3) APPLY LOCTITE TO #9 BOLTS. INSTALL BOLTS WITH #7 WASHERS INTO LOWER PORT SIDE HOLES NEXT TO THE TIMING COVER. USING 3/8 ALLEN SOCKET, TORQUE TO 40 FT. LBS..
- 4) APPLY LOCTITE TO THE IDLER BOLT. RE-INSTALL THE IDLER PULLEY. USING 5/8 SOCKET, TORQUE TO 40 FT. LBS.
- 5) FOR ALTERNATOR WIRING AND POWER STEERING PLUMBING, SEE 625-8338-1 INSTRUCTIONS.

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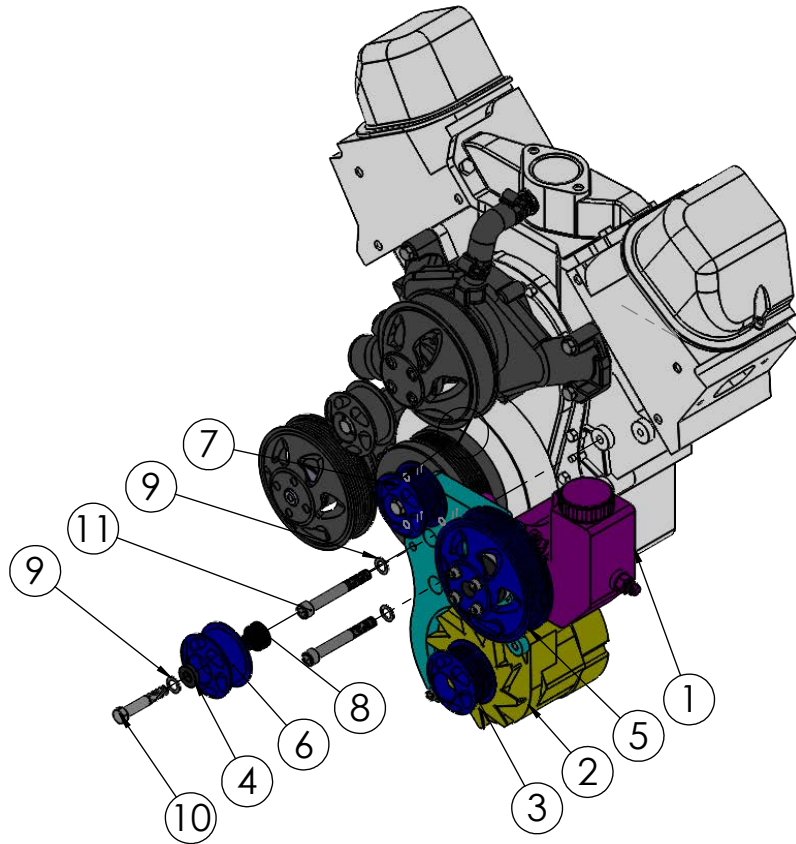
PART NO.

625-830X

TITLE: BBC CIRCULATION PUMP SERPENTINE
DRIVE KIT w/ POWER STEERING - STEP

4

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	135-802226	PUMP, POWER STEERING	1
2	620-3147M-NC	94 AMP CHROME ALTERNATOR	1
3	625-3130	PULLEY, ALTERNATOR	1
4	625-4039	SPACER	2
5	625-4055	PULLEY, SEA PUMP	1
6	625-4364	PULLEY, SMOOTH IDLER	1
7	625-4365	PULLEY, RIBBED IDLER	1
8	625-8322	SPACER, IDLER PULLEY	2
9	90043AN-STSS	WASHER, 7/16AN	4
10	90043C250HHS	BOLT, HHCS, 7/16-14x2.50	2
11	90043C350SHS	BOLT, SHCS, 7/16-14x3.50	2

ASSEMBLY IS USED IN 625-8302, 625-8303, 625-8306,
625-8307, 625-8308 & 625-8309 DRIVE KITS.

INSTALLATION INSTRUCTIONS:

- 1) THIS ACCESSORY BRACKET COMES PRE ASSEMBLED.
- 2) REMOVE #10 BOLT, #9 WASHER & #4 SPACER THAT HOLDS THE #6 SMOOTH IDLER & #8 SPACER TO THE BRACKET.
- 3) APPLY LOCTITE TO #11 BOLTS. INSTALL BOLTS WITH #9 WASHERS INTO LOWER PORT SIDE HOLES NEXT TO THE TIMING COVER. USING 3/8 ALLEN SOCKET, TORQUE TO 40 FT. LBS..
- 4) APPLY LOCTITE TO THE IDLER BOLT. RE-INSTALL THE IDLER PULLEY. USING 5/8 SOCKET, TORQUE TO 40 FT. LBS.
- 5) FOR ALTERNATOR WIRING AND POWER STEERING PLUMBING, SEE 625-8338-1 INSTRUCTIONS.

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PART NO.

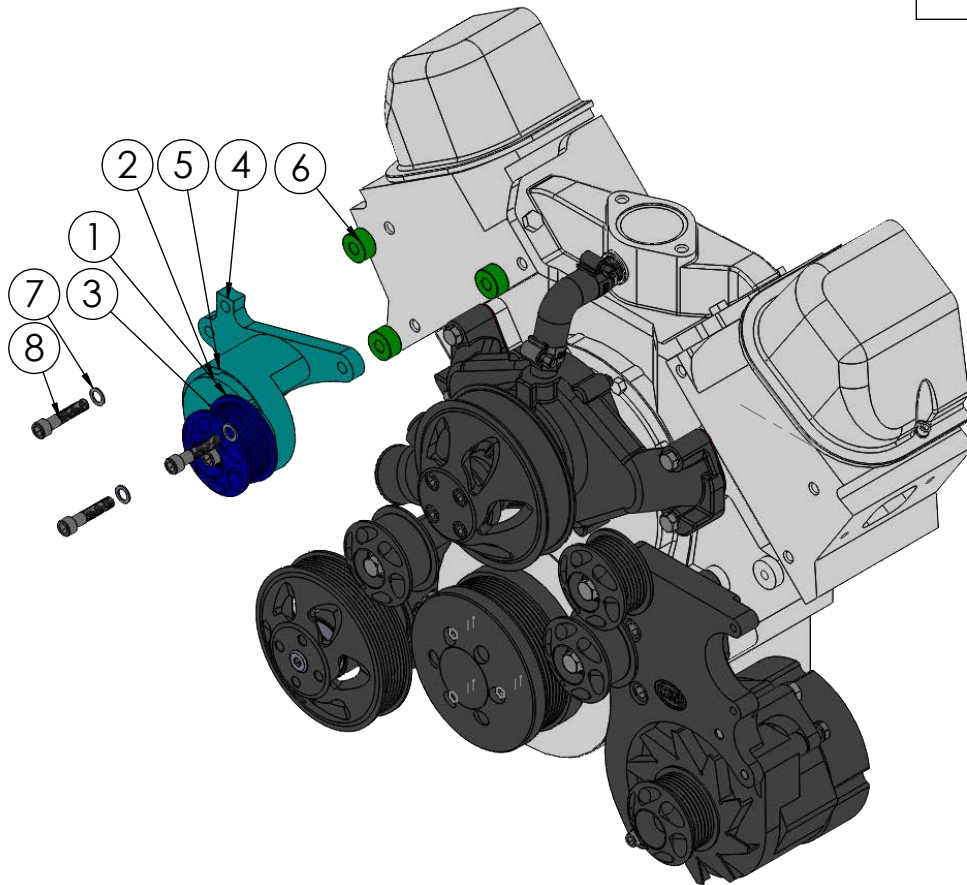
625-830X

TITLE:

BBC CIRCULATION PUMP SERPENTINE DRIVE KIT - STEP 5

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	625-4364	PULLEY, RIBBED IDLER	1
2	625-4442	ARM, TENSIONER - GEN 3	1
3	625-4444	PIN, HARDIN TENSIONER	1
4	625-4551	BASE, HEAT EXCHANGER MOUNT- STRB	1
5	625-8323	BODY, TENSIONER - CIRC SERPENTINE DRIVE KIT	1
6	755-5118	SPACER	3
7	90037AN-STSS	WASHER, 3/8 AN	3
8	90037C175SHS	BOLT,SHCS, 3/8-16 x 1-3/4	3



ASSEMBLY IS USED FOR 625-8300 THROUGH
625-830\9 DRIVE KITS.

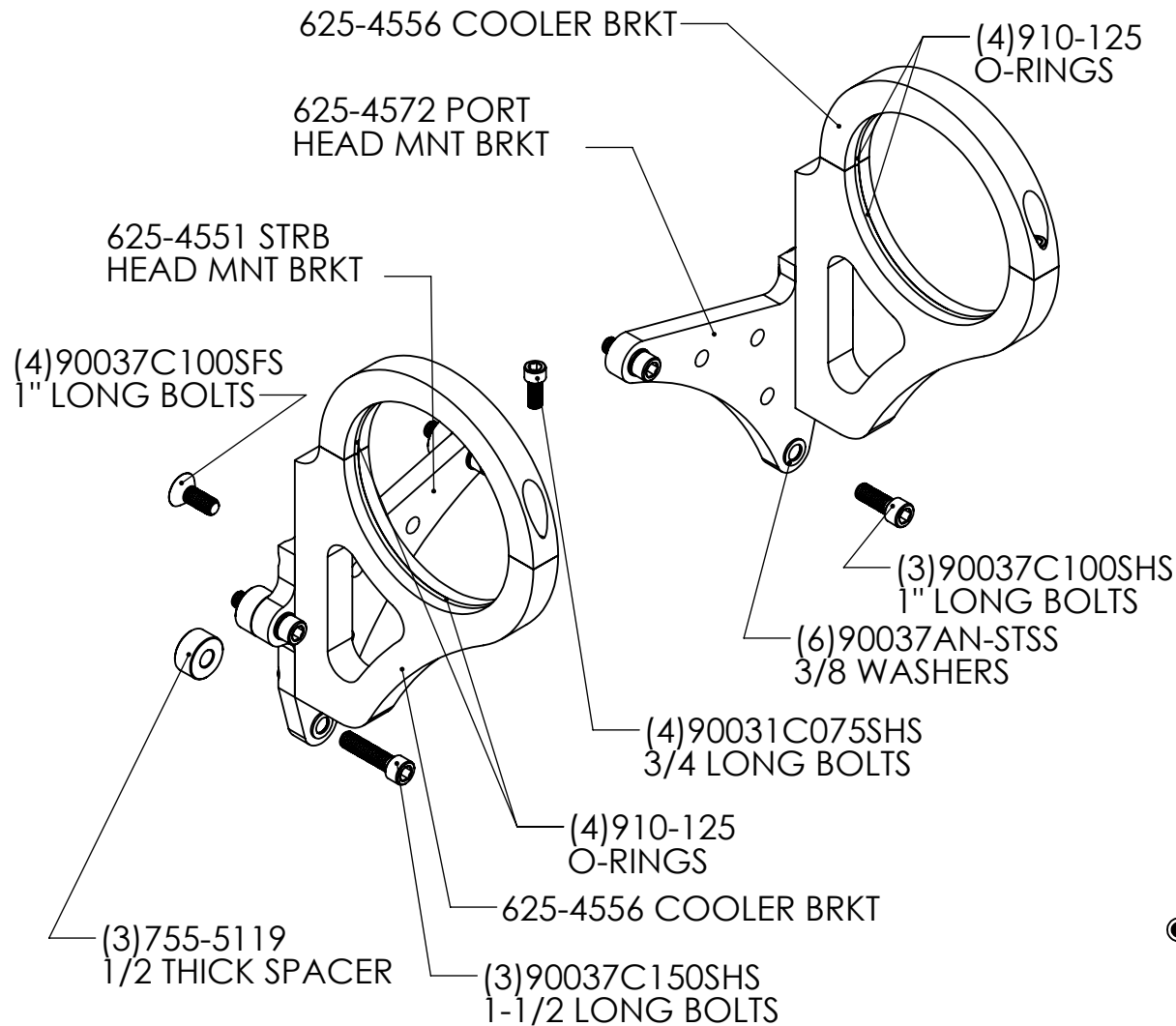
INSTALLATION INSTRUCTIONS:

- 1) THE TENSIONER ASSEMBLY COMES PRE ASSEMBLED. IF TENSIONER IS BEING USED WITH 625-8301, 625-8303, 625-8305, 625-8307 & 625-8309 HEAT EXCHANGER KITS, 625-4655 BRACKETS WILL BE INSTALLED.
- 2) APPLY LOCTITE TO THE SUPPLIED #8 BOLTS. INSTALL BOLTS WITH #7 WASHERS INTO THE #4 TENSIONER BRACKET.
- 3) #6 SPACERS ARE INSTALLED BETWEEN THE TENSIONER BRACKET AND CYLINDER HEAD.
- 4) SLIDES BOLTS THRU THE SPACERS AND THREAD INTO THE CYLINDER HEAD, FIG C. USING 5/16 ALLEN SOCKET, TORQUE BOLTS TO 30 FT. LBS..

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PART NO.
625-4544

TITLE:
HEAT EXCHANGER MOUNTING BRACKETS



MOUNTING INSTRUCTIONS:

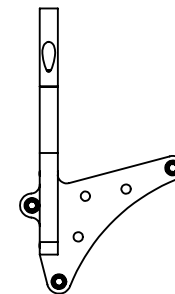
1) ATTACH 625-4556 OIL COOLER BRACKETS TO HEAD MOUNT BRACKETS. APPLY LOCTITE TO THE (4) 90037C100SFS BOLTS & INSERT THROUGH THE COUNTERSUNK SIDE OF THE BRACKET. TORQUE TO 30 FT. LBS..

2) THE PORT SIDE BRACKET ASSEMBLY MOUNTS DIRECTLY ON THE HEAD. APPLY LOCTITE TO THE (3) 90037C100SHS BOLTS WITH WASHERS, TORQUE TO 30 FT. LBS..

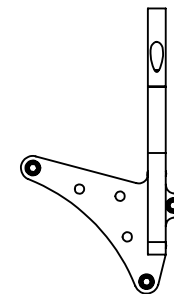
3) THE STARBOARD SIDE BRACKET IS SPACED OFF THE HEAD BY THE (3) 755-5119 SPACERS. APPLY LOCTITE TO THE (3) 90037C150SHS BOLTS WITH WASHERS, TORQUE TO 30 FT. LBS..

4) MAKE SURE THE 900-125 ORINGS ARE INSTALLED IN THE BRACKETS.

5) AFTER INSTALLING THE HEAT EXCHANGER, APPLY LOCTITE TO (4) 90031C075SHS BOLTS AND TORQUE TO 20 FT. LBS..



STARBOARD HEAD



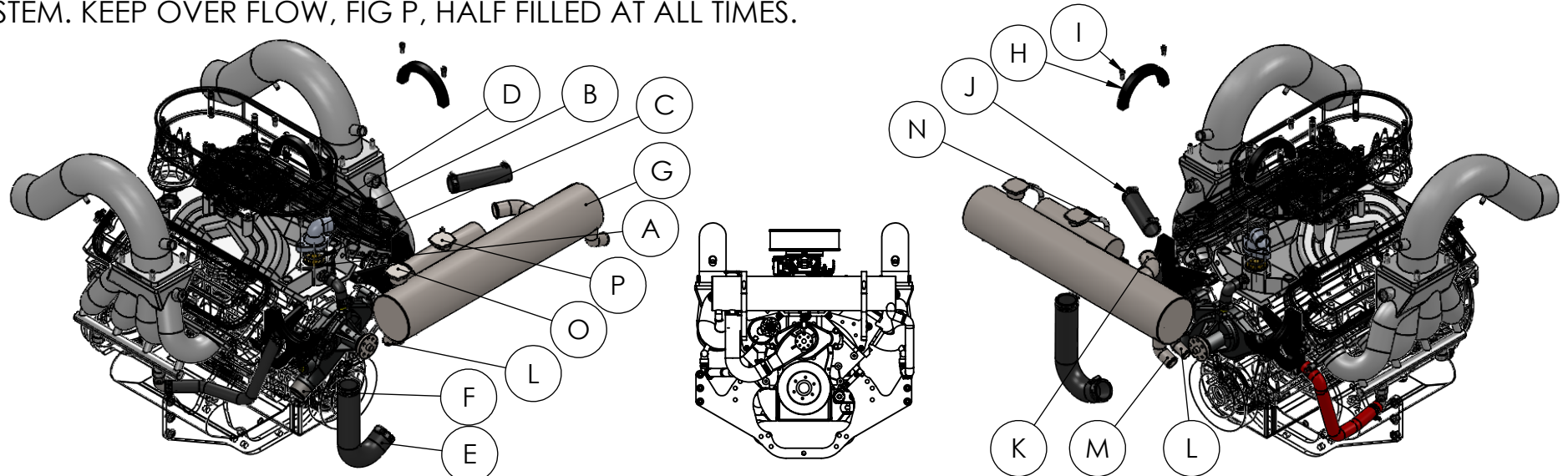
PORT SIDE

TITLE: CIRC PUMP SERPENTINE DRIVE
KIT HEAT EXCHANGER

ASSEMBLY IS USED FOR 625-8301 & 625-8303 DRIVE KIT.

INSTALLATION INSTRUCTIONS:

- 1) FOLLOW 625-4544 BRACKET MOUNTING INSTRUCTIONS TO MOUNT HEAT EXCHANGER BRACKETS.
- 2) INSTALL 540-160106 140 DEGREES THERMOSTAT, FIG. A, INTO THE COUNTERBORE IN THE INTAKE MANIFOLD.
- 2) INSTALL 625-4555 THERMOSTAT HOUSING, FIG.B , TO THE INTAKE MANIFOLD. APPLY GREASE TO THE THERMOSTAT HOUSING O-RING, FIG. C. APPLY LOCTITE TO THE (2)3/8-16x3/4 BOLTS, FIG. D. SLIDE BOLTS THROUGH THE HOUSING AND THREAD TO INTAKE MANIFOLD. DO NOT TORQUE THE BOLTS YET.
- 3) INSTALL 625-4544 HOSE, FIG. E, TO THE CIRCULATING PUMP, FIG. F. LOOSELY INSTALL HOSE CLAMPS.
- 4) INSTALL 625-4550 HEAT EXCHANGER, FIG. G, INTO THE BRACKET CRADLES.
- 5) INSTALL UPPER BRACKET CLAMP, FIG. H. APPLY LOCTITE TO THE 5/16-18 BOLTS, FIG. I. LOOSELY THREAD INTO THE LOWER BRACKETS.
- 6) INSTALL 625-4573 HOSE, FIG. J AND CLAMPS BETWEEN THE HEAT EXCHANGER CONNECTOR, FIG. K AND 625-4555 THERMOSTAT HOUSING.
- 7) TORQUE UPPER BRACKET CLAMP, FIG. H, TO 20 FT. LBS..
- 8) TORQUE THERMOSTAT HOUSING BOLTS, FIG.D, TO 30 FT. LBS..
- 9) CONNECT HOSE FROM EXHAUST TO THE THE 1" BARB CONNECTIONS, FIG. L.
- 10) CONNECT 1-1/4 WATER INLET HOSE TO THE PORT SIDE HEAT EXCHANGER BARB, FIG.M.
- 11) CONNECT 625-4578, FIG.N, DRAIN HOSE TO OVER FLOW TANK NIPPLE.
- 12) HEAT EXCHANGER MAIN FILL, FIG. O, WITH 50/50 PROPYLENE GYLCOL ANTIFREEZE. RUN ENGINE TO BURP SYSTEM. KEEP OVER FLOW, FIG P, HALF FILLED AT ALL TIMES.



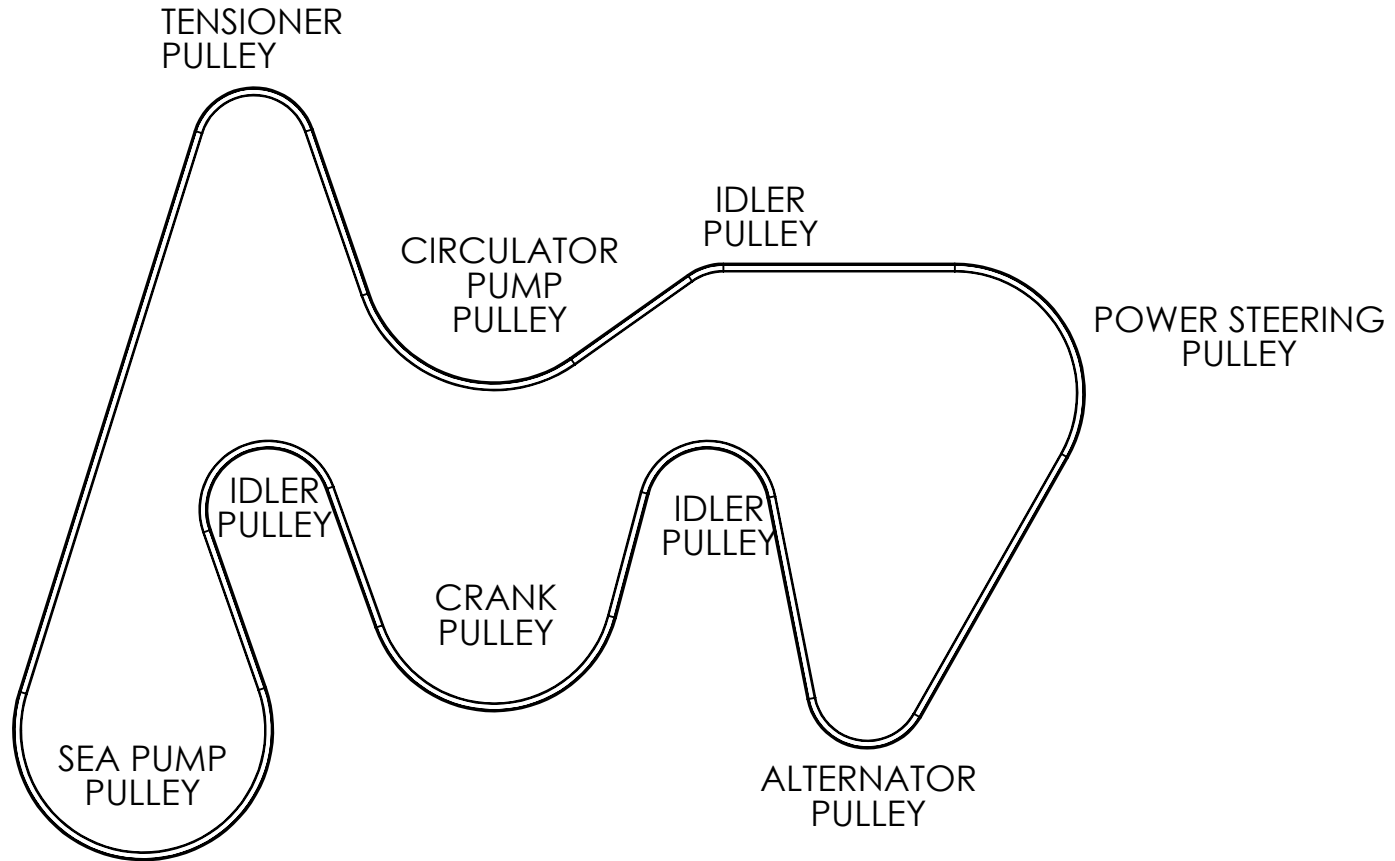
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PART NO.
625-2319

USED IN KITS:
625-8302
625-8303
625-8306
625-8307
625-8308
625-8309

TITLE:
BELT, CIRC PUMP KIT w POWER STEERING

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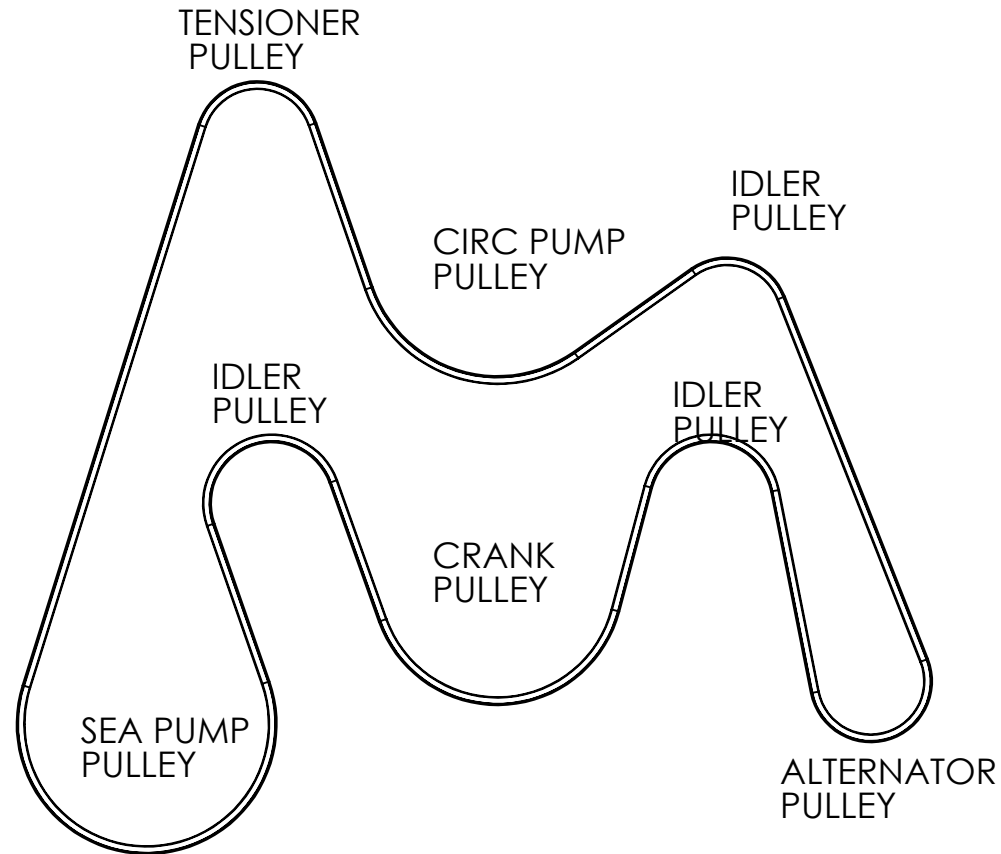
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PART NO.
625-2322

USED IN KITS:
625-8301
625-8302
625-8304
625-8305

TITLE: BELT, CIRC PUMP KIT NON POWER
STEERING

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