

## BEARING AND SEAL REMOVAL AND INSTALLATION

1. Remove the large snap ring 513 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. Press the new bearing 501 on the shaft, pressing against the inner race only. Note thrust direction and press up against the thrust ring, locking it in its groove.
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. Carter spring faces out. (gartner 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. Fill the garter spring cavity in the seals with grease. Install the outer seals 507. Used only on 4 seal systems) Grease all seal lips.
7. Grease the two "O" rings 527 and install them on the upper seal ring 432, or use the single "O" ring 525 on the older type upper seal ring. (To replace older type upper seal ring, use seal ring 432). 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 housing 108 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 any 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 the upper seal ring assy 432 being careful not to shear the "O" rings 527 as they pass the snap ring groove. Only finger pressure should be necessary here. Install the beveled retaining ring 513, beveled side up
10. 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.

KIT 146

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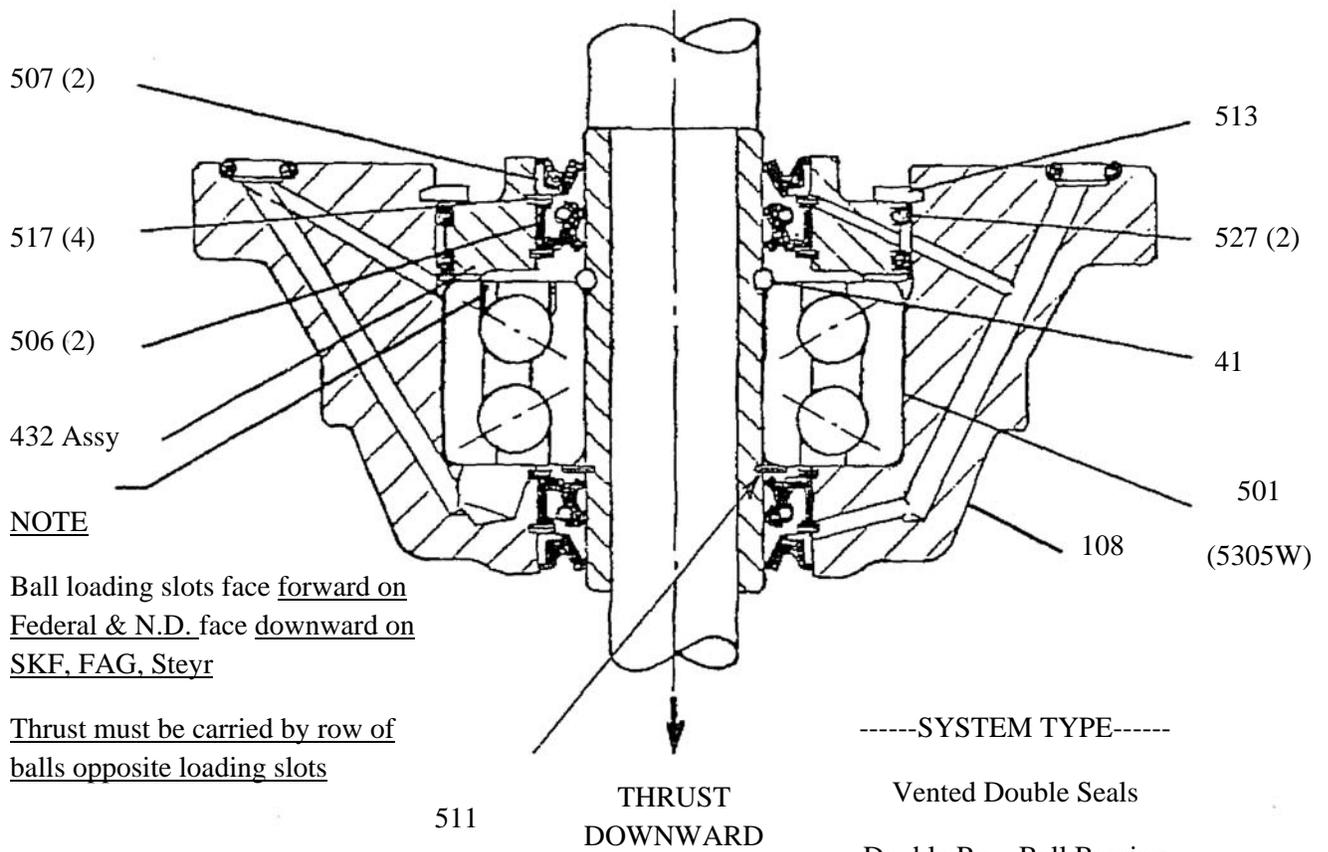
BEARING & SEAL KIT 146

Double row ball bearing system

For use on jet drive models L50

(for seals, "O" rings & snap rings only, order kit 462)

NOTE Bearings with ball loading slots on one face must be mounted in the proper direction. See note below. Bearings without ball loading slots can be mounted in either direction.



NOTE

Ball loading slots face forward on  
Federal & N.D. face downward on  
SKF, FAG, Steyr

Thrust must be carried by row of  
balls opposite loading slots

KITS 462, 146

OUTBOARD JETS

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