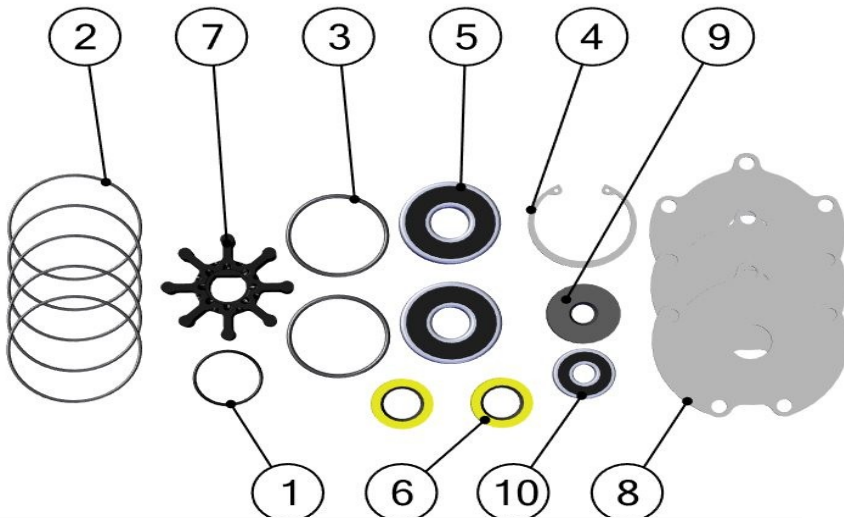


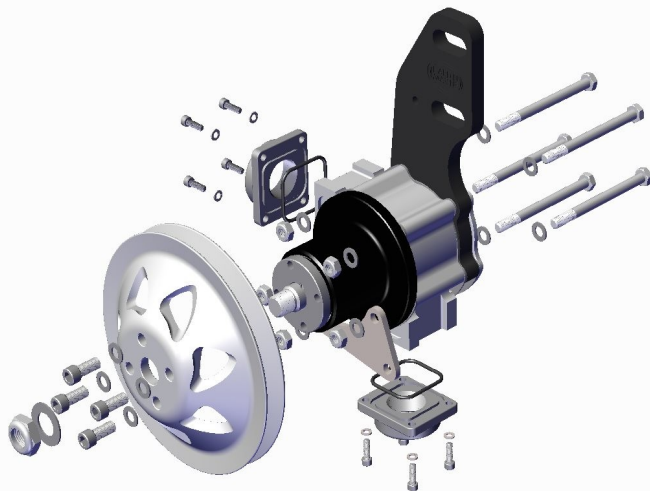


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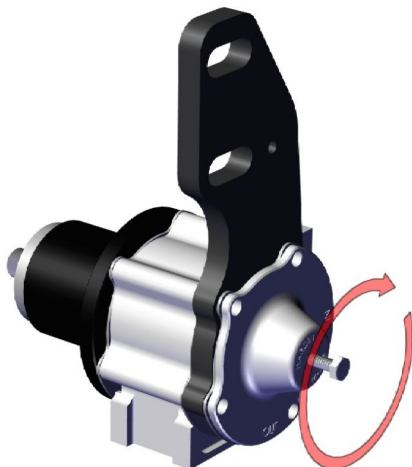


| Description | BOM ID | Qty |
|-------------|--------|-----|
| 625-1026 | 1 | 1 |
| 625-1037 | 2 | 5 |
| 625-1134 | 3 | 2 |
| 625-4003 | 4 | 1 |
| 625-4004 | 5 | 2 |
| 625-4005 | 6 | 2 |
| 625-4011 | 7 | 1 |
| 625-4018 | 8 | 3 |
| 625-4067 | 9 | 1 |
| 625-4068 | 10 | 1 |



- **Step 1:**

- 1) Remove sea pump pulley using 15/16 socket and 1/4 hex socket.
- 2) Remove inlet and outlet adapters using 5/32 allen key.
- 3) Using 1/2 socket or wrench remove nuts and bolts holding sea pump together.



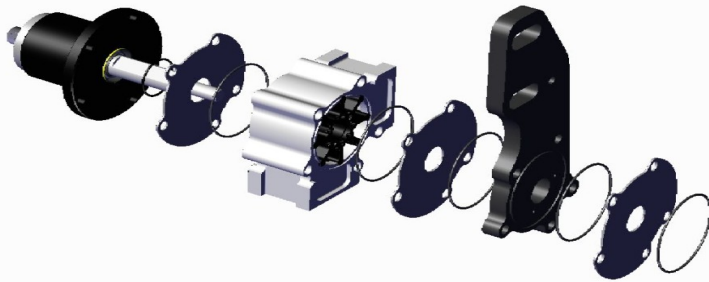
- **Step 2:**

- 1) This is for generation 2 sea pumps only.
- 2) Using 5/32 allen key remove the bolt that is installed into the rear cover.
- 3) Screw a 1/4 fine bolt into the rear cover. Tighten bolt clockwise to remove rear cover and bearing.



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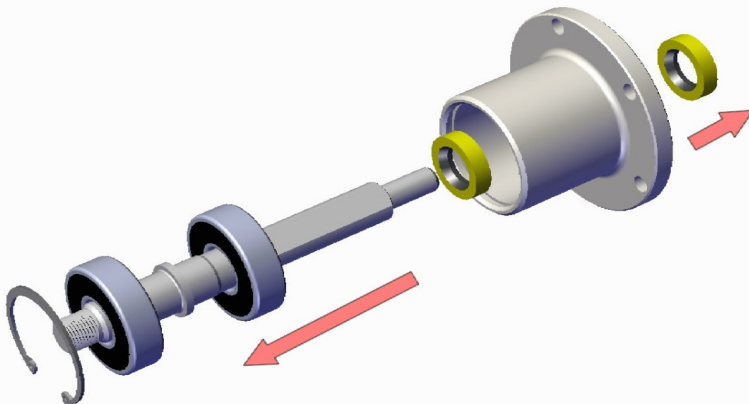


- **Step 3:**

- 1) Remove the sea pump bracket, body, wear plates and impeller.

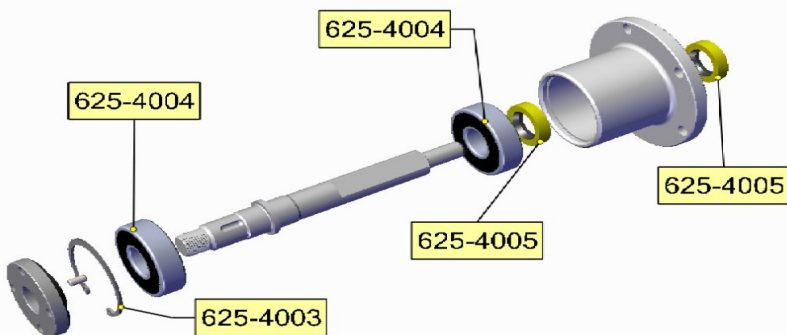
- 2) Discard the impeller, o-rings and wear plates.

- 3) Inspect and clean body, bracket, rear cover and front snout with shaft.



- **Step 4:**

- 1) These are the replacement parts for the front snout assembly.



- **Step 5:**

- 1) Using snap ring pliers, remove snap ring.

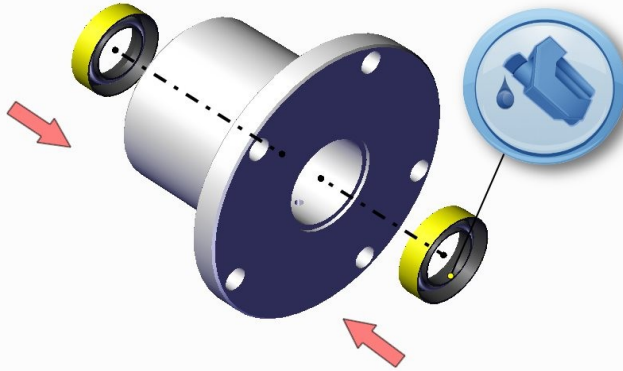
- 2) Slide shaft and bearings out the front. Remove the bearings.

- 3) Remove the 2 seals.



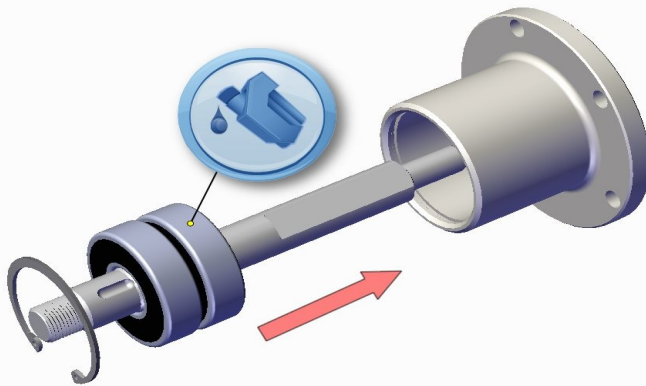
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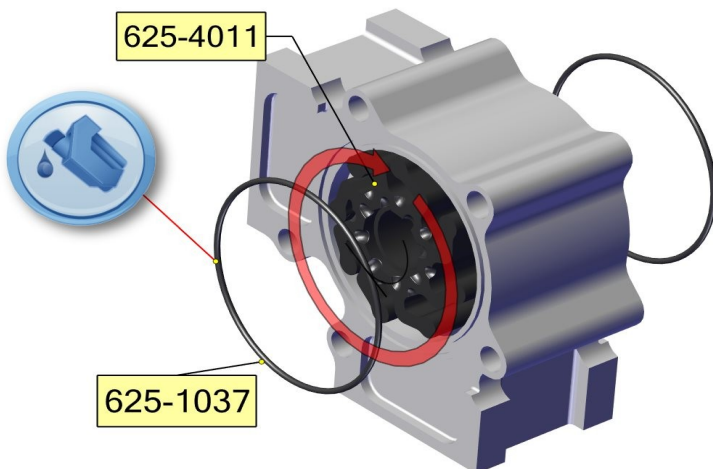
- **Step 6:**

- 1) Press seals into the housing as shown. Make sure the spring side of the seal is towards the impellers.
- 2) Make sure the seals are flush with the inside and back side of the bearing housing.
- 3) Coat seals with petroleum jelly.



- **Step 7:**

- 1) Coat the outside of the bearings with oil. This will help the shaft assemble slide into the housing.
- 2) Using snap ring pliers, install the snap ring.



- **Step 8:**

- 1) Apply petroleum jelly to the inside of the sea pump body and to both ends of the impeller.
- 2) Notice the rotation shown. This is for typical port side mounted sea pump standard rotation engine. When installing on to the shaft keep track of which side is front.
- 3) Apply petroleum jelly to both 625-1037 o-rings. Install 1 on each side of the sea pump body.



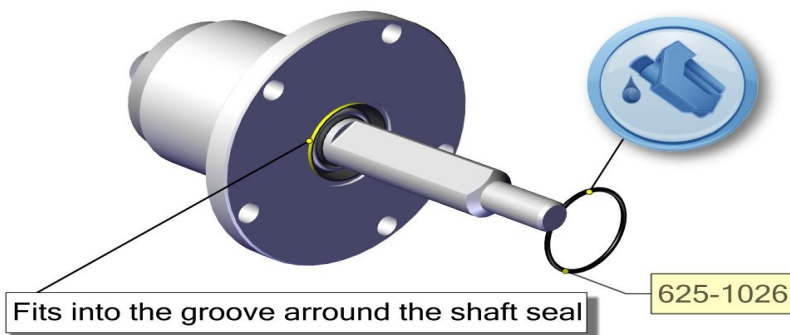
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- **Step 9:**

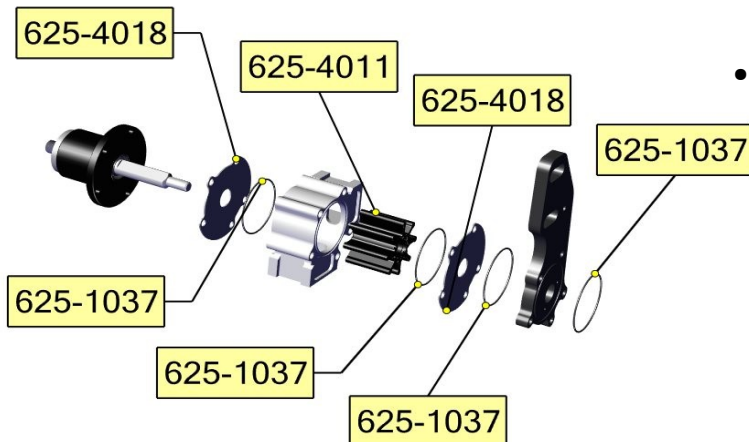
1) Apply petroleum jelly to both 625-1037 o-rings and install into the grooves into the bracket on both sides.



- **Step 10:**

1) Apply petroleum jelly to the small 625-1026 o-ring.

2) Install into the groove around the the shaft seal.



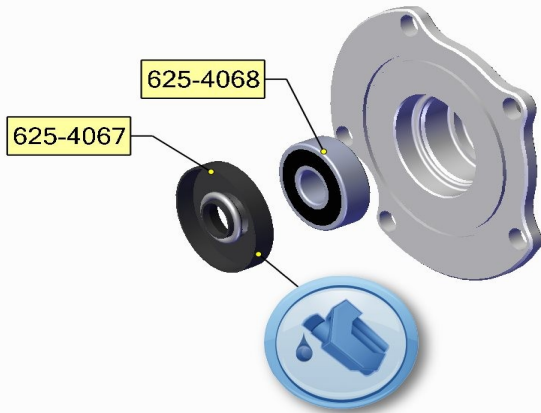
- **Step 11:**

1) Slide the components onto the shaft as shown.



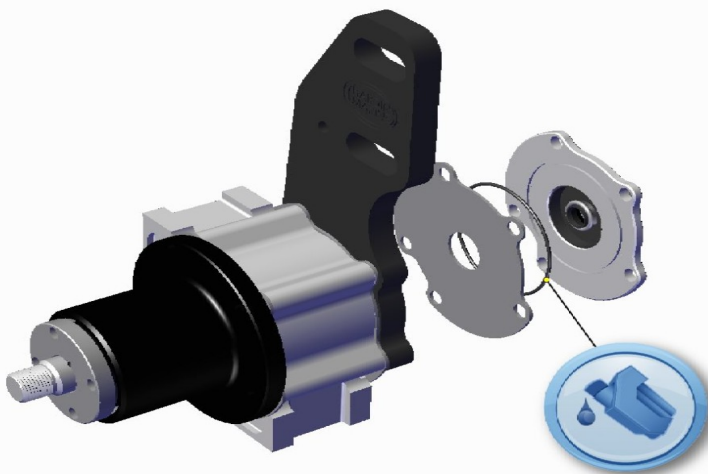
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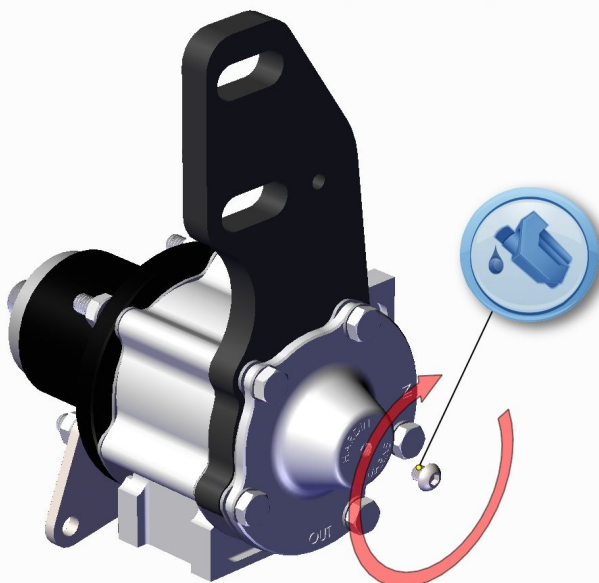
- **Step 12:**

- 1) Remove old seal and bearing from rear cover.
- 2) Install new bearing and seal.
- 3) Coat bearing and seal with petroleum jelly.



- **Step 13:**

- 1) Apply petroleum jelly to the 625-1037 and install into the groove in the rear cover.
- 2) Apply petroleum jelly to the end of the shaft.



- **Step 14:**

- 1) Apply anti-sieze to the bolt. Using 5/32 allen key install into the rear cover. Torque to 80 in. lbs..



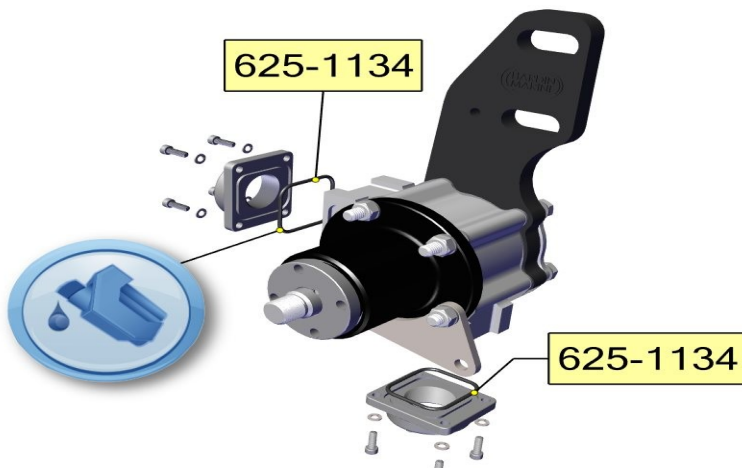
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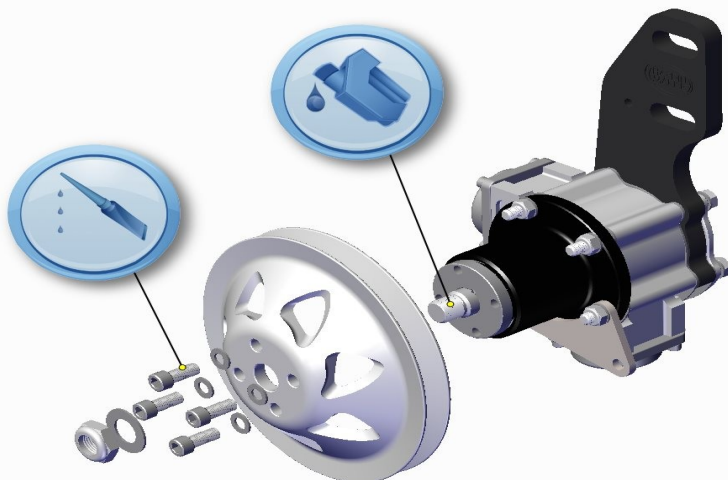
- **Step 15:**

- 1) Install anti-sieze to the bolts.
- 2) Install bolts with washers in from the back side.
- 3) Slide 625-4022 over the bolts.
- 4) Install washers and nuts. Using 1/2 socket torque to 25 ft. lbs



- **Step 16:**

- 1) Using the supplied 625-1134 o-rings install.
- 2) For Stainless bodies, apply anti-sieze to the bolts.
- 3) For Aluminum bodies, apply loctite to the bolts.
- 4) Using 5/32 hex socket, torque to 60 in. lbs..



- **Step 17:**

- 1) Apply anti-sieze to the shaft threads. Install pulley.
- 2) Apply loctite to the 5/16 bolts. Using 1/4 socket torque to 25 ft. lbs..
- 3) Install 5/8 nut and washer. Using 15/16 socket torque to 50 ft. lbs..