

12. Insert feeler gauge through hole in pinion location tool between gauging surface of tool and flats on bottom of pinion gear teeth.

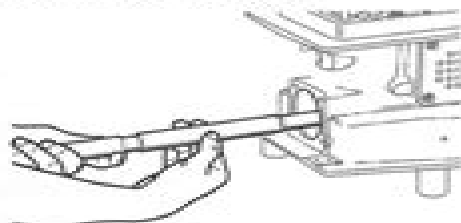


IMPORTANT: The correct clearance is .025 inch (0.64 mm).

13. Use .025 inch (.064 mm) feeler gauge as a starting thickness. Adjust thickness of feeler gauge until a slight drag is felt as gauge is drawn out between gauging surface of tool and pinion gear.

NOTE: Once the thickness is determined, the difference between feeler gauge thickness and .025 inch (0.64mm) required clearance must be either added or subtracted from the total thickness of shims between pinion shaft housing and drive housing.

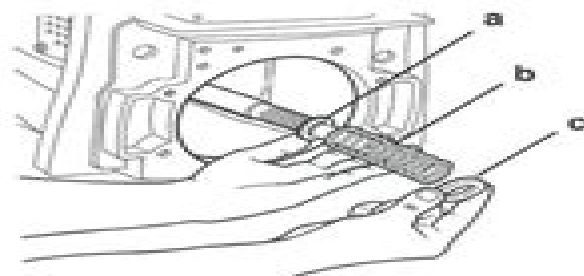
- Remove the screws securing the pinion shaft housing assembly to the drive housing. Lift assembly out of the drive housing (the preload tool need not be removed).
 - Adjust shim thickness as required.
14. Install Impeller Shaft Seal Protector (Special Tool 91-820553) over impeller threads of impeller shaft assembly.
 15. Using a twisting motion install impeller shaft assembly in drive housing.



16. Install original shims on impeller shaft cover. Install O-ring on impeller shaft cover.

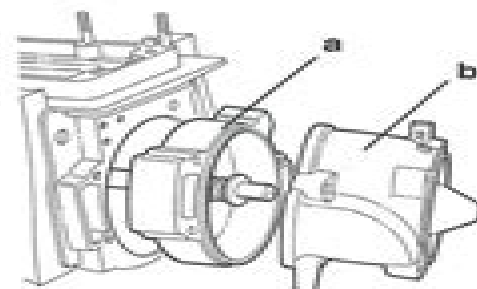
NOTE: If original shims are not available, start with .030 in. (.76 mm) shims (three brown colored shims).

- Lubricate O-ring and bore with Quicksilver lubricant 2-4-C.
 - Lubricate cone bearing with gearcase lubricant.
17. Install impeller shaft cover. Torque screws to 180 lb. in. (20.3 N-m).
 - Rotate impeller shaft ten revolutions to properly seat roller bearings.
 18. Install impeller shaft pre-load tool (91-824871A1).
 - Remove seal protector from impeller shaft.
 - Install spring seat, spring, and impeller thrust washer on impeller shaft.



- a - Spring Seat
- b - Spring
- c - Thrust Washer

19. Install wear ring and stator on impeller shaft. Secure assembly with two bolts (opposite corners). Torque bolts to 30 lb. ft. (40.7 N-m).



- a - Wear Ring
- b - Stator

Sport Jet 90 Manual

Daniel F McAuley



Sport Jet 90 Manual:

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