

1. Remove 4 bolts securing gear case to drive shaft housing.



2. Remove cover, washer (above impeller), impeller, key and washer (below impeller).

3. Remove cover gasket, base plate and base gasket.

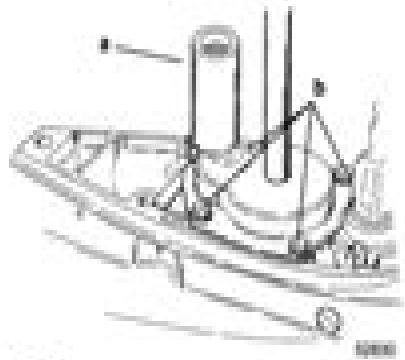


## Disassembly

### Water Pump

**NOTE:** If water tube seal remained in drive shaft housing, remove seal from housing and reseal on water pump cover. Secure seal to cover with Locite 403.

1. Remove 4 bolts securing pump cover.

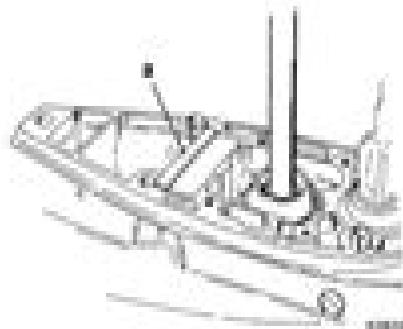


**NOTE:** Replace cover if thickness of steel at discharge slots is 0.005 in. (1.27mm) or less, or if grooves (other than impeller sealing grooves) in cover roof are more than 0.005 in. (0.127mm) deep.

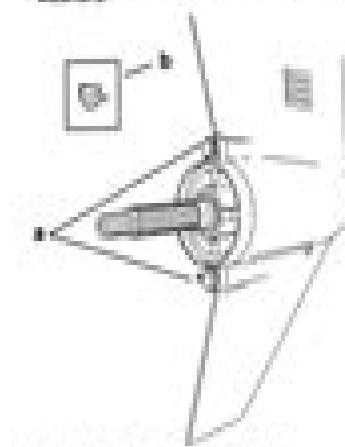
#### NOTE: Replace impeller if:

- Impeller blades are cracked, bent or worn.
- Impeller is glazed or melted.
- Rubber portion of impeller is not bonded to impeller hub.

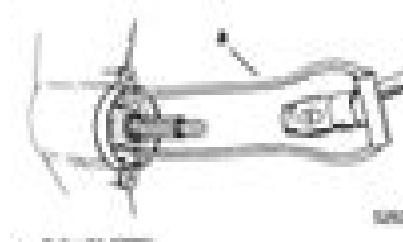
4. Remove and/or replace exhaust deflector plate if damaged.



5. Remove bearing carrier attaching bolts and locking tab washers or flat washers. Discard tab washers.

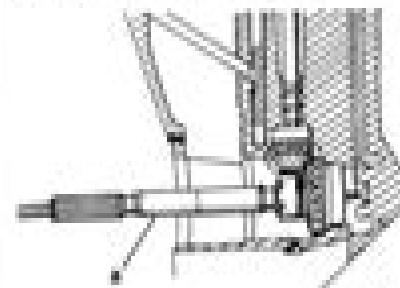


6. Using Puller (SI-27780), remove carrier assembly from gear case.



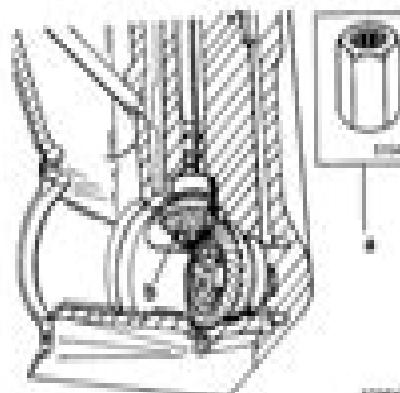
**NOTE:** When removing propeller shaft assembly, gear follower may dislodge. Retain follower from gear housing.

7. Remove propeller shaft assembly.



Model	Drive Shaft Holding Tool
SI-4000/4000A	SI-23100A
Force 4000	SI-23210A
SI-340/340A	SI-23210A

8. Remove pinion nut and discard.



9. Drive shaft housing tool

10. Pinion Gear

11. Remove drive shaft assembly and pinion gear.

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**Z. Xu**

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