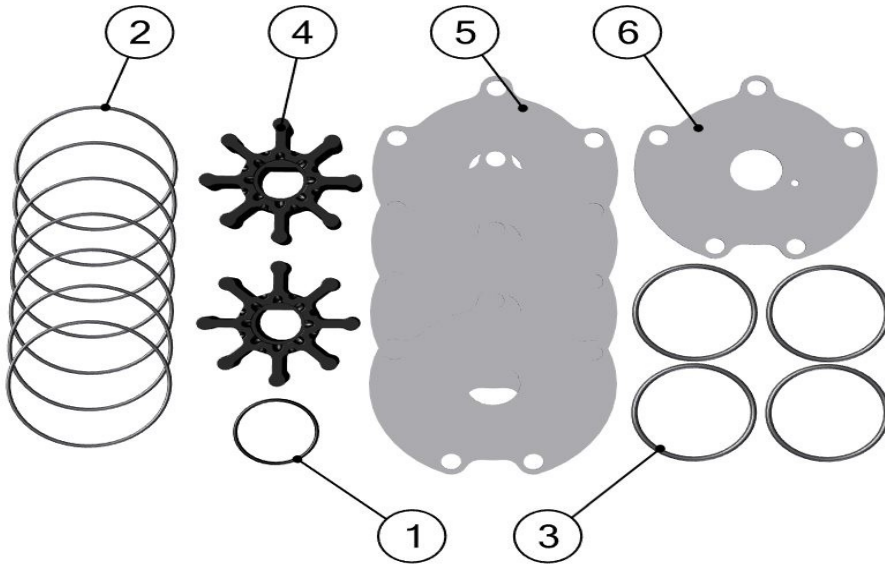


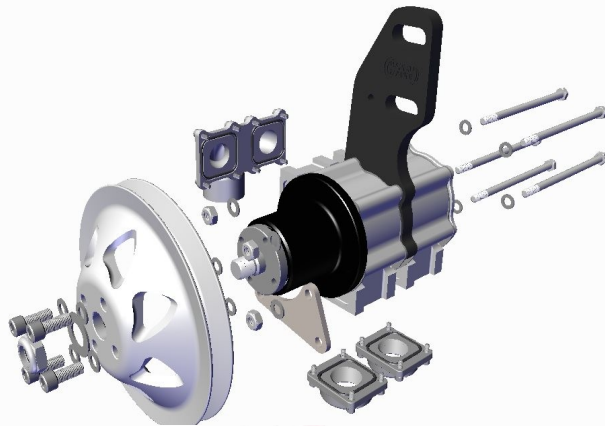


DUAL STAGE STD REBUILD KIT

625-4181

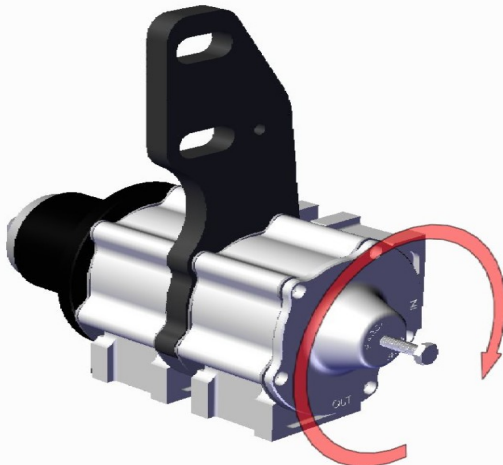


ID	Part #	Qty
1	625-1026	1
2	625-1037	7
3	625-1134	4
4	625-4011	2
5	625-4018	4
6	625-4019	1



- 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.



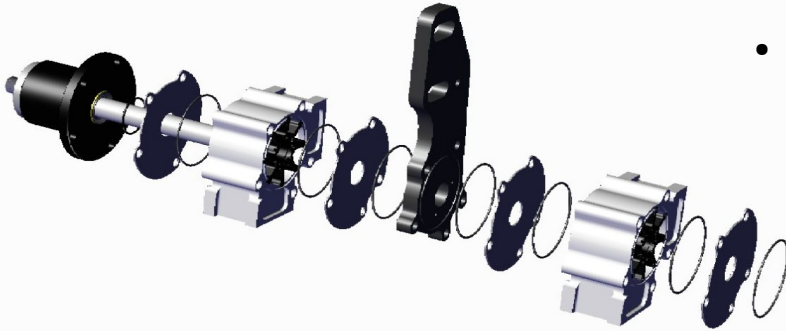
- Step 2:**

- 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.

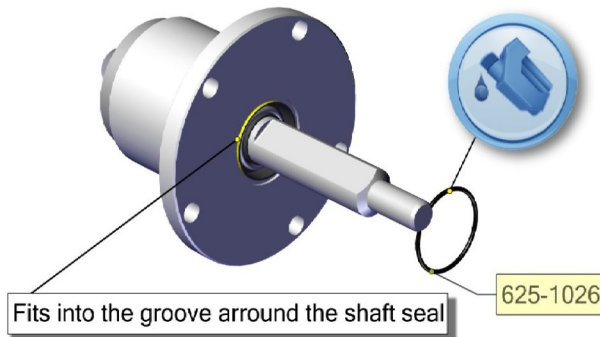


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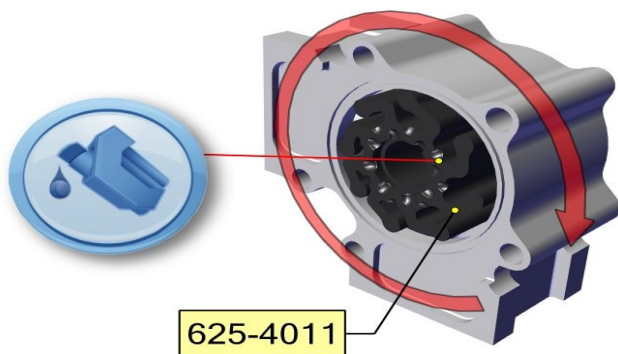
625-4180



- **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) Apply petroleum jelly to the small 625-1026 o-ring.
 - 2) Install into the groove around the the shaft seal.



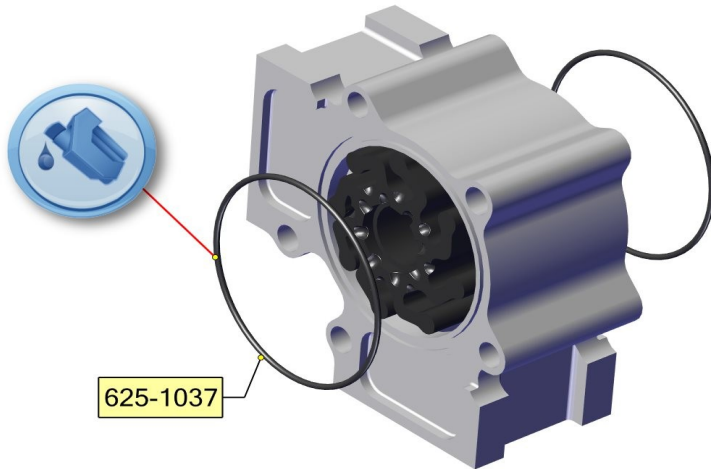
- **Step 5:**
 - 1) Apply petroleum jelly to the inside of the sea pump body and to both sides of the impeller.
 - 2) Notice the rotation shown. This is for typical port side mounted sea pump standard rotation engine. When installing on to the shaft keep track of which side is front.



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- **Step 6:**

1) Apply petroleum jelly to both 625-1037 o-rings and install in the sea pump body on both sides of the body.



- **Step 7:**

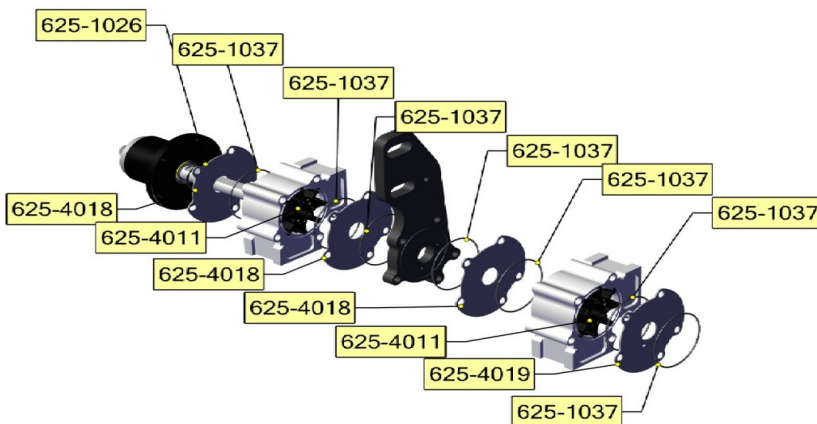
1) Apply petroleum jelly to both 625-1037 o-rings and install into the grooves into the bracket on both sides.



Step 8 Gen 1:

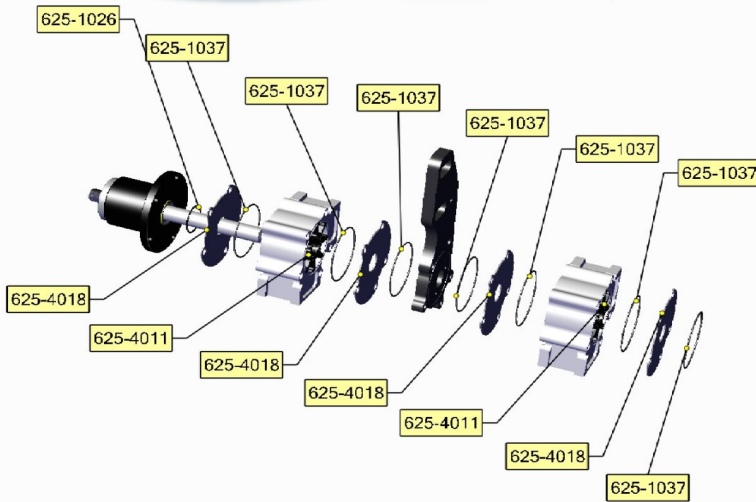
1) Slide the components onto the shaft as shown.

2) Notice 625-4019 wear plate hole position. This is for GEN 1 ONLY.



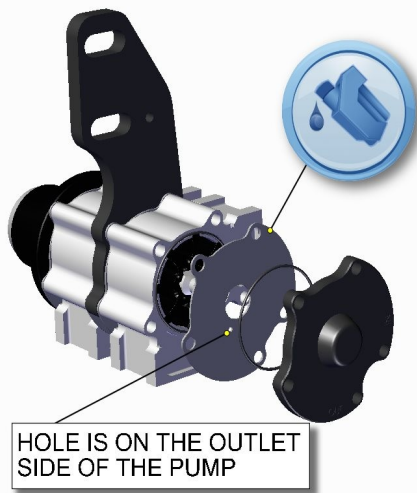


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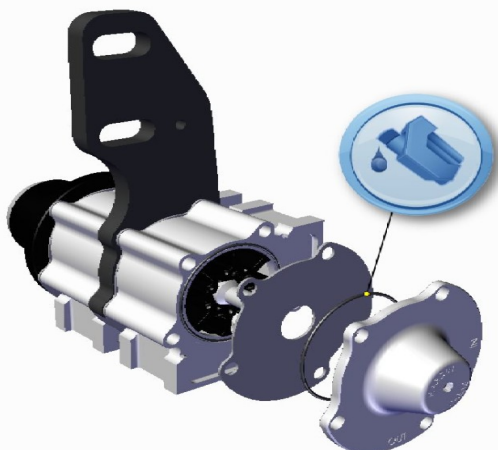
- **Step 8 Gen 2:**

- 1) Slide the components onto the shaft as shown,
- 2) Gen 2 uses only 625-4018 wear plates without holes.



- **Step 9 Gen 1:**

- 1) Apply petroleum jelly to the 625-1037 and install into the groove in the rear cover.
- 2) Apply lubricate to the end of the shaft.
- 3) Install 625-4019 wear plate, notice the hole in the plate position. Install rear cover.



- **Step 9 Gen 2:**

- 1) Apply petroleum jelly to the 625-1037 and install into the groove in the rear cover.
- 2) Apply lubricate to the end of the shaft.
- 3) Install 625-4018 wear plate then tap on the rear cover.



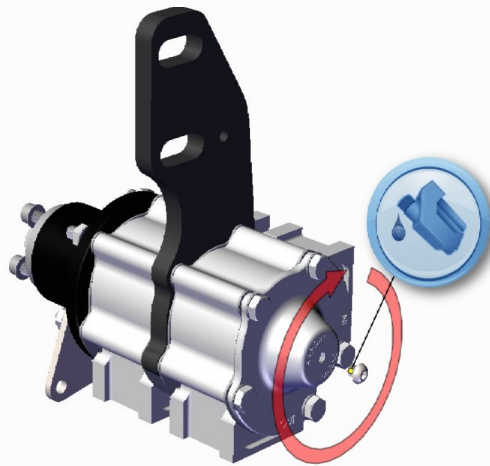
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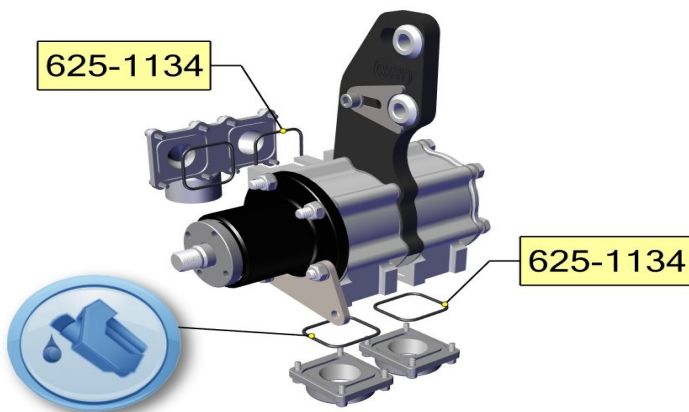
- **Step 10:**

- 1) Install anti-seize 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 11 Gen 2:**

- 1) For gen 2 only.
- 2) Apply anti-seize to the bolt. Using 5/32 allen key install into the rear cover. Torque to 80 in. lbs..

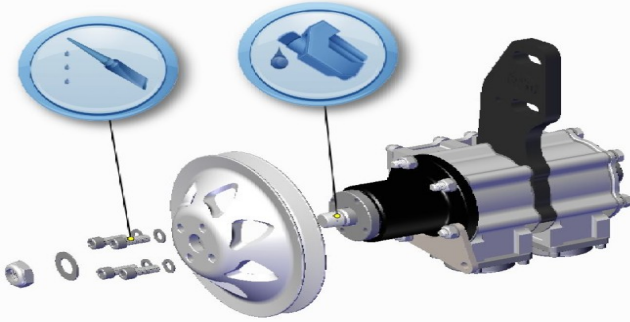


- **Step 12:**

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



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- **Step 13:**
 - 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..