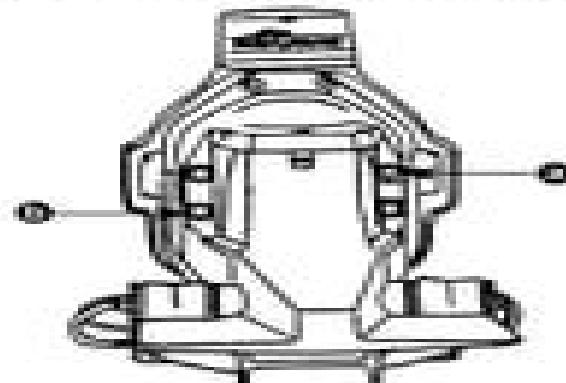


8. Install stern drive unit.
 - a. Position stern cylinders so they point 45 degrees upward. Be careful not to scratch splash plate.
 - b. Align universal joint shaft with bell housing bore.
 - c. Slide U-joint shaft through bearing housing and into engine coupler. Make sure that shaft linkage jaws engage with shaft collar.
 - d. If necessary, rotate propeller shaft slightly to align U-joint shaft splines with engine coupler splines, then slide drive unit all the way into bell housing.
 - e. Rotate propeller shaft slightly to ensure that drive unit is still in neutral when installed.
 - f. Align stern drive unit to bell housing. Starting from center, torque nuts to 50 lb. ft. (68 N-m).



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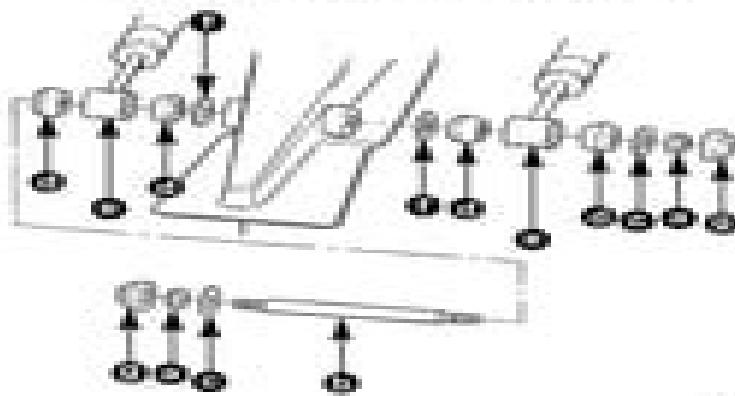
a - Locknut (20) and Flat Washers (20)
b - Oilseal Plate - Do Not Use Flat Washers

IMPORTANT: To avoid damage to rubber bushings, use a washer and locknut solution.

10. Loosen nuts which secure stern cylinders to forward anchor pins. Be careful not to scratch splash plate.

11. Install left anchor pin as follows:
 - a. Install rubber bushings in one left stern cylinder pivot end. Be sure to install bushings with small diameter end facing each other.
 - b. Align cylinder bore with stern drive housing bore.

- c. Place large 1.0" flat washer between rubber bushing and stern drive housing.
- d. Slide left anchor pin through rubber bushings, large 1.0" flat washer and stern drive housing bore.
- e. Place large 1.0" flat washer on left anchor pin against stern drive housing.
- f. Install rubber bushings in other left stern cylinder pivot end. Be sure to install bushings with small diameter end facing each other.
- g. Align cylinder bore with stern drive housing bore and slide left anchor pin through rubber bushings.
- h. Place small 1.0" flat washer onto each end of anchor pin and install locknut/snap nuts.



270245

a - Locknut
b - Locknut Pin
c - Small 1.0" Flat Washer
d - Rubber Bushings
e - Stern Cylinder Pivot End
f - Large 1.0" Washer
g - Stern Cylinder Cap

12. Tighten forward and aft anchor pin nuts until nuts and washers bottom out against anchor pin shoulders.
13. Attach stern cylinder caps; hand tighten only. If caps will not catch threads, retighten rightness of anchor pin nuts.

Mer Repair Manual

Liying Dong

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General Aircraft Maintenance Manual United States. Department of the Army, 1970
Manual, 1990 **Direct Support, General Support, and Depot Maintenance Manual**, 1991 *General Aircraft Maintenance Catalogue of Publications*

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