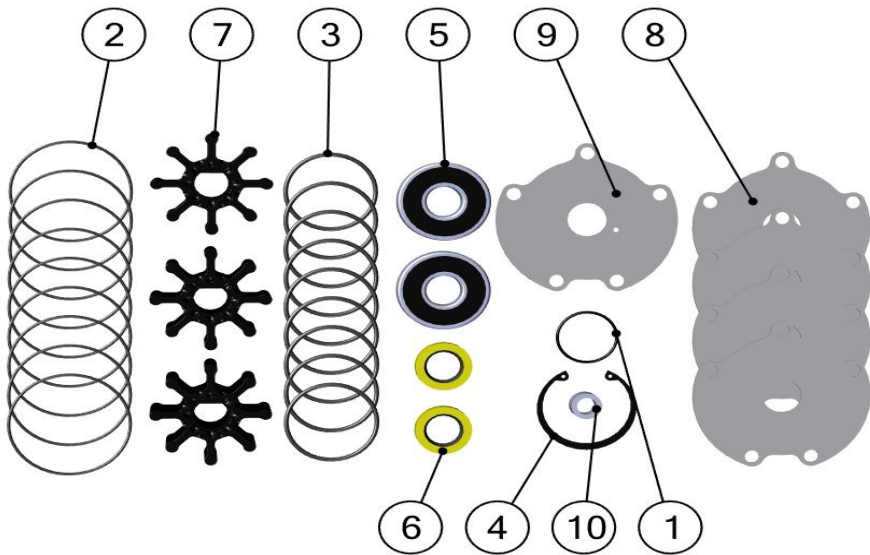


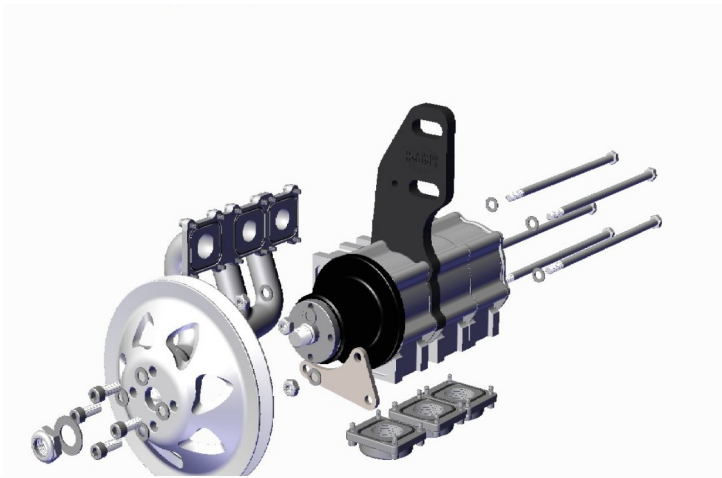


# TRIPLE STAGE GEN 1 MASTER REBUILD KIT

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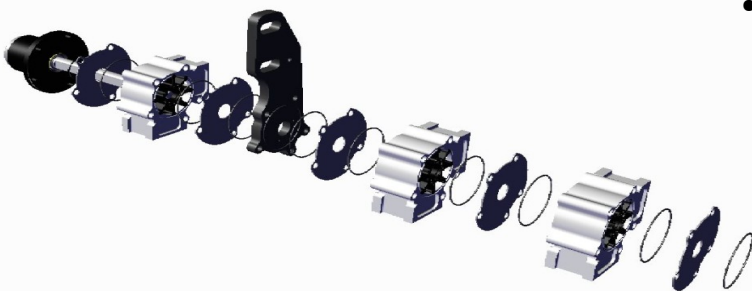


Description	BOM ID	Qty
625-1026	1	1
625-1037	2	9
625-1134	3	9
625-4003	4	1
625-4004	5	2
625-4005	6	2
625-4011	7	3
625-4018	8	4
625-4019	9	1
625-4020	10	1



- **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.



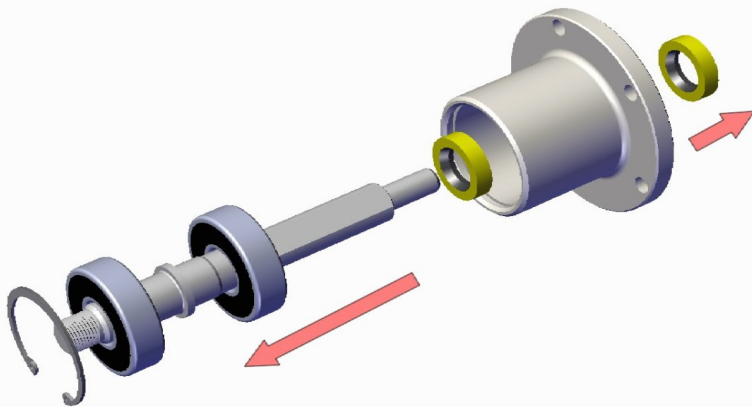
- **Step 2:**

- 1) 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.

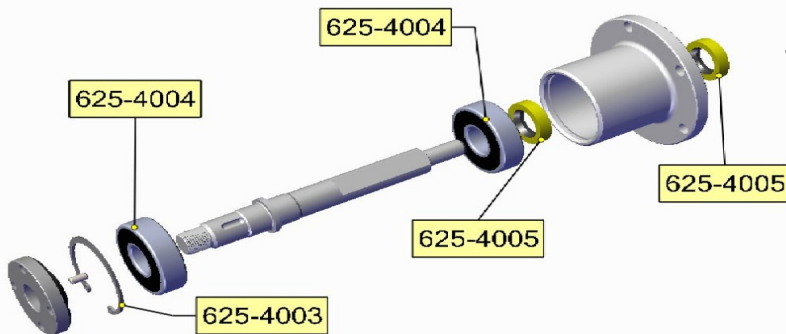


# TRIPLE STAGE GEN 1 MASTER REBUILD KIT

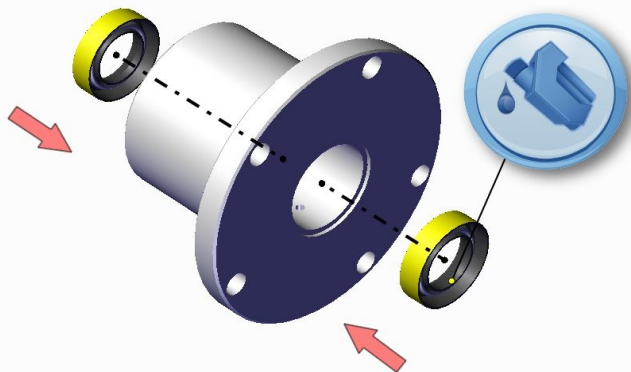
625-4168



- **Step 3:**
  - 1) Using snap ring pliers, remove snap ring.
  - 2) Slide shaft and bearings out the front. Remove the bearings.
  - 3) Remove the 2 seals.



- **Step 4:**
  - 1) These are the replacement parts for the front snout assembly.

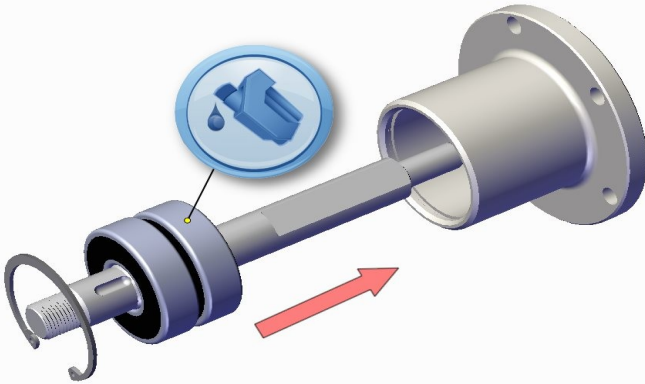


- **Step 5:**
  - 1) Press seals into the housing as shown. Make sure the spring side of the seal is towards the impellers.
  - 2) Make sure the seals are flush with the inside and back side of the bearing housing.
  - 3) Coat seals with petroleum jelly.



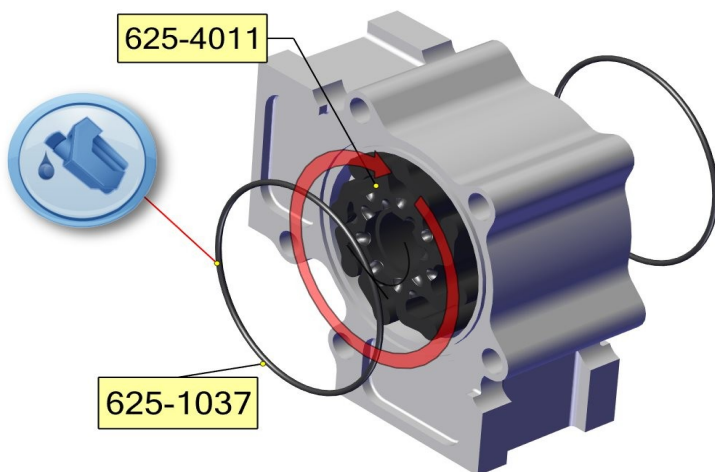
# TRIPLE STAGE GEN 1 MASTER REBUILD KIT

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- **Step 6:**

- 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 7:**

- 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.



- **Step 8:**

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

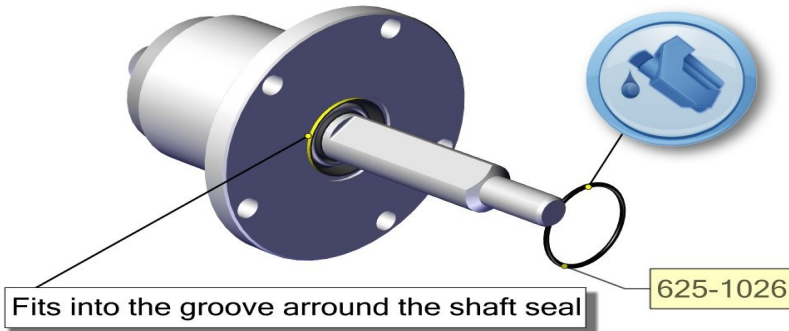


# TRIPLE STAGE GEN 1 MASTER REBUILD KIT

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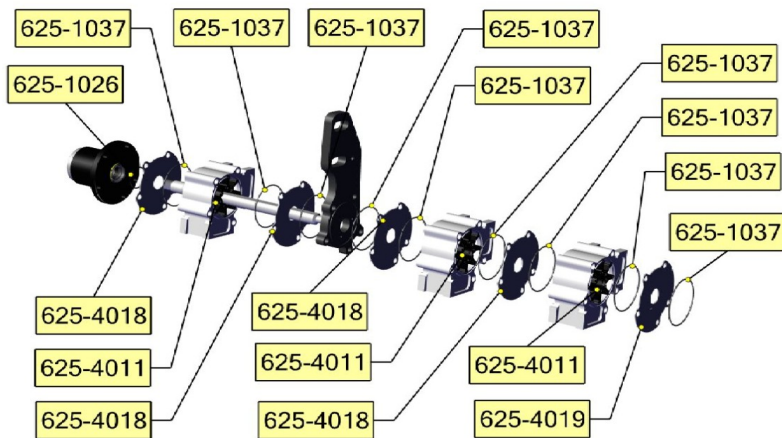
- **Step 9:**

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



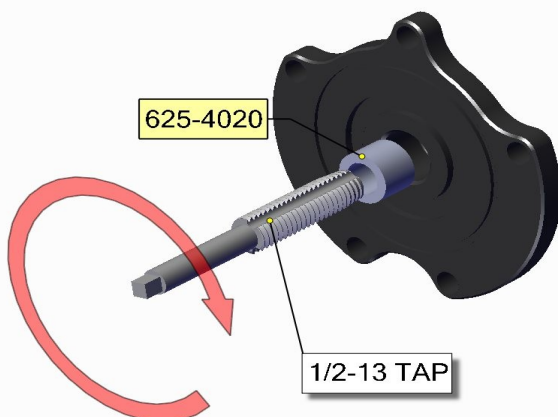
- **Step 10:**

- 1) Slide the components onto the shaft as shown.
- 2) Notice 625-4019 wear plate hole position. This is for GEN 1 ONLY.



- **Step 11:**

- 1) Screw 1/2-13 tap into the bushing in the rear cover. When the tap bottoms out, it will pull out the old bushing.
- 2) Press new bushing back into the rear cover.
- 3) Coat the bushing with petroleum jelly.

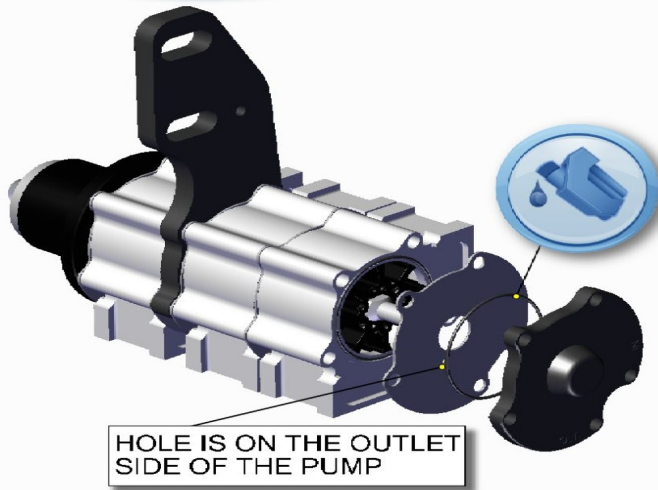






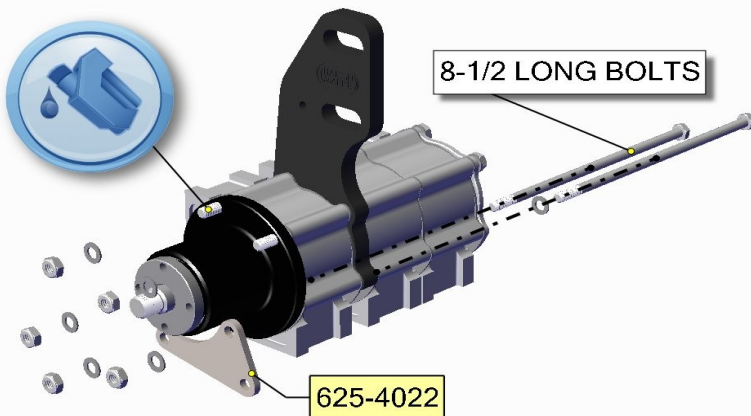
# TRIPLE STAGE GEN 1 MASTER REBUILD KIT

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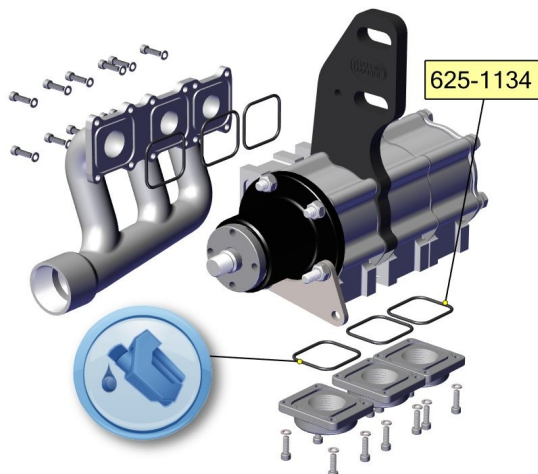
- **Step 12:**

- 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.
- 3) Install 625-4019 wear plate, notice the hole in the plate position. Install rear cover.



- **Step 13:**

- 1) Install anti-sieze to the bolts.
- 2) Install bolts with washers in from the back side.
- 3) Install the 8-1/2 long bolts in the same holes that 625-4022 slides over.
- 4) Install washers and nuts. Using 1/2 socket torque to 25 ft. lbs..



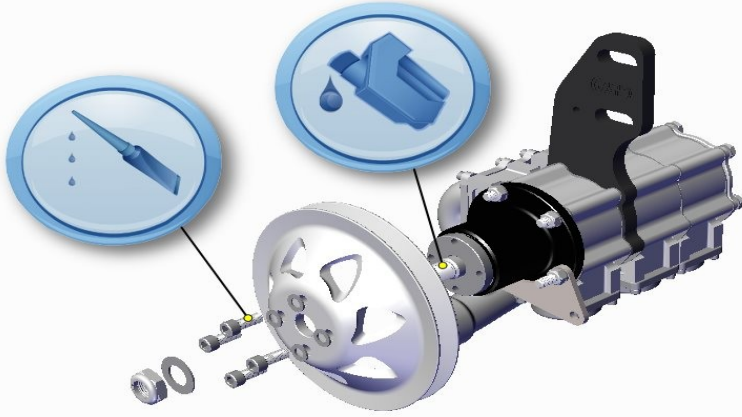
- **Step 14:**

- 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..



## TRIPLE STAGE GEN 1 MASTER REBUILD KIT

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- **Step 15:**

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..