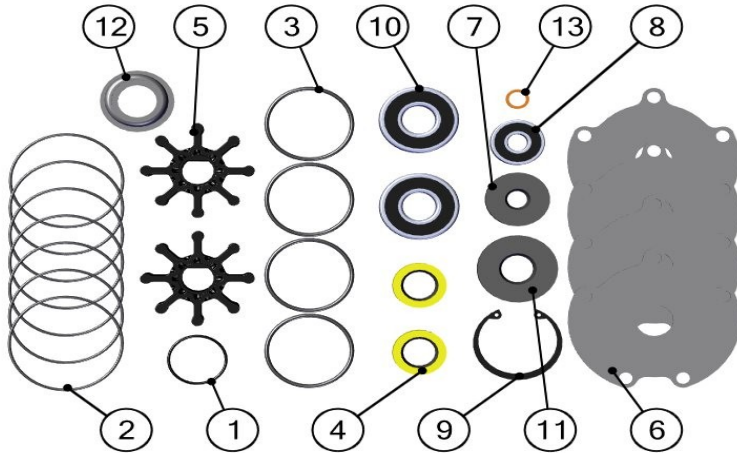
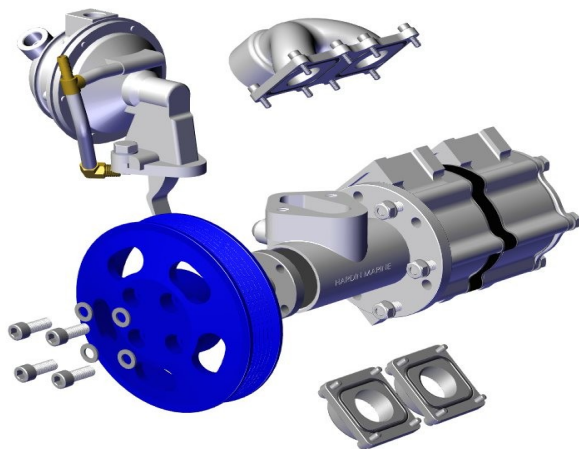




# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



Description	BOM ID	Qty
625-1026	1	1
625-1037	2	7
625-1134	3	4
625-4005	4	2
625-4011	5	2
625-4018	6	4
625-4067	7	1
625-4068	8	1
625-4077	9	1
625-4078	10	2
625-4079	11	1
625-4093	12	2
90037SA-STCO	13	1



- Step 1:**

- 1) Use a 1/4 hex socket to remove the sea pump pulley.
- 2) Use a 9/16 socket to remove fuel pump and hoses.
- 3) Use a 5/32 allen key to remove inlet/outlet adapters.

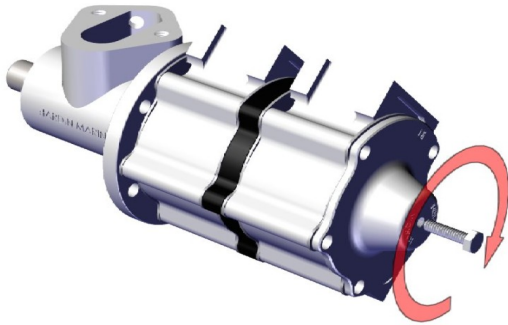
- Step 2:**

- 1) Use a harmonic balancer pulley to remove sea pump hub.
- 2) Use a 1/2 socket to remove bolts and nuts.





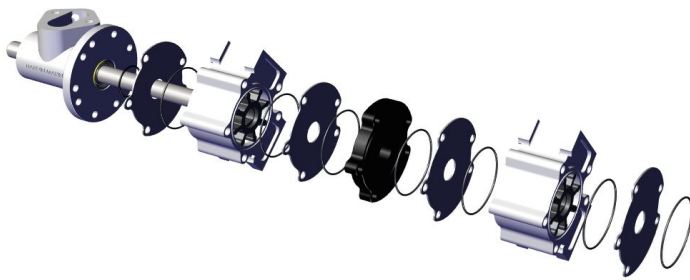
# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



- **Step 3:**

1) Use a 5/32 allen key to remove the bolt that is installed into the rear cover.

2) Screw a 1/4 fine bolt into the rear cover. Tighten bolt clockwise to remove rear cover and bearing.

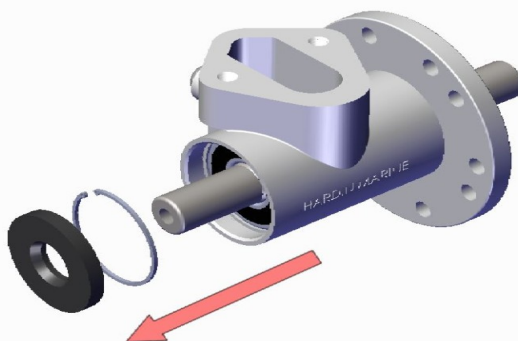


- **Step 4:**

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.



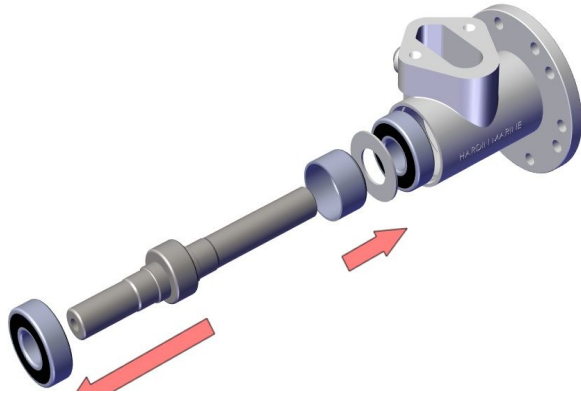
- **Step 5:**

1) Use a screwdriver to remove the front seal.

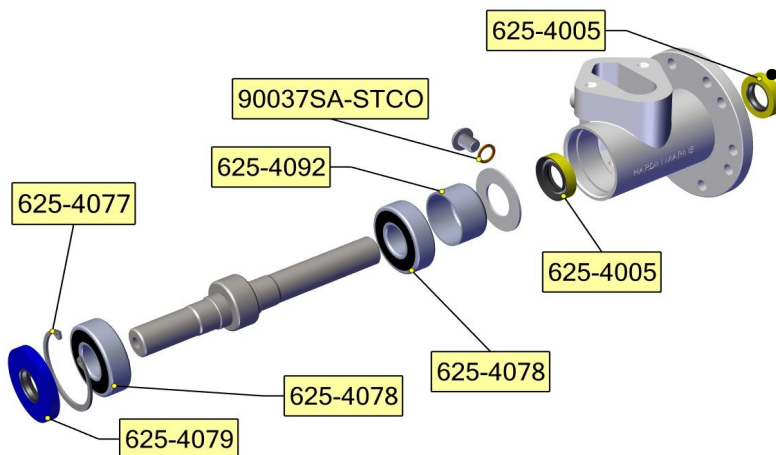
2) Use snap ring pliers to remove snap ring.



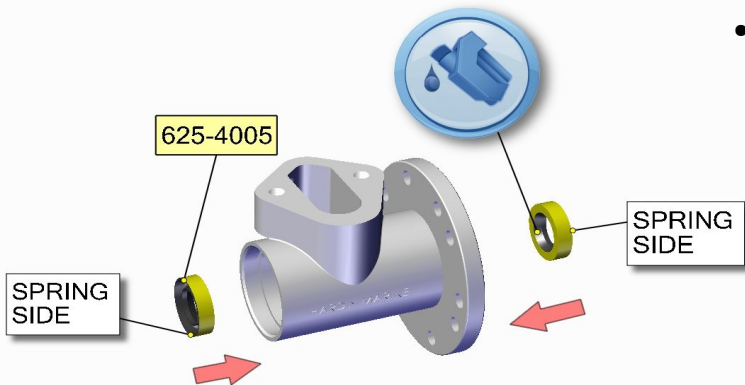
# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



- **Step 6:**
  - 1) Press shaft out of the housing.
  - 2) Remove bearings and wear ring from the shaft and discard.



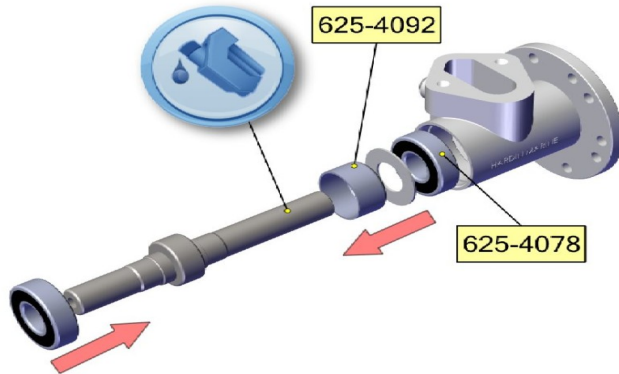
- **Step 7:**
  - 1) These are all the new parts for the front snout assembly.



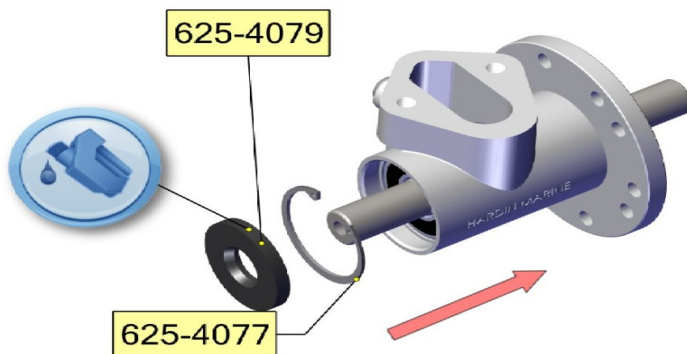
- **Step 8:**
  - 1) Remove both seals and clean the housing.
  - 2) Make sure the seals are flush with the inside and back side of the bearing housing.
  - 3) Install with the spring side of the seals to the outside of the housing.
  - 4) Coat seals with petroleum jelly



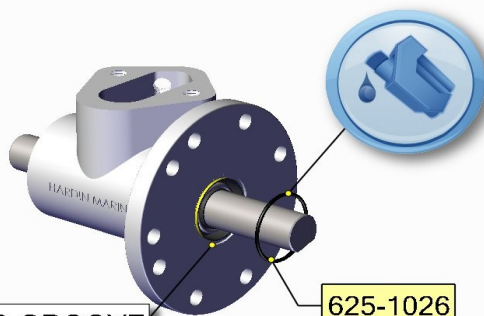
# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



- **Step 9:**
  - 1) Slide new wear ring and washer from the front of the shaft.
  - 2) Press the new bearings on the shaft.
  - 3) Coat bearings with grease and install shaft into the housing.



- **Step 10:**
  - 1) Using snap ring pliers, install the new snap ring
  - 2) Coat seal with petroleum jelly and install flush with housing.



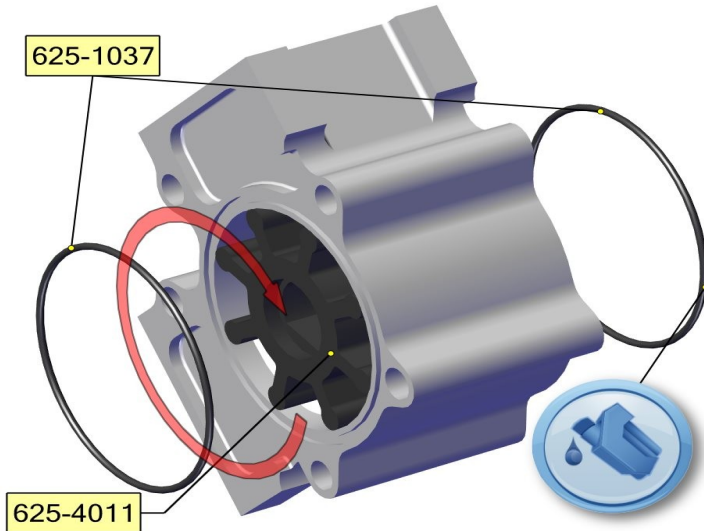
INSTALL INTO GROOVE  
AROUND THE SEAL

- **Step 11:**
  - 1) Coat o-ring with petroleum jelly and install into the groove around the groove around the seal.





# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



- **Step 12:**

1) Apply petroleum jelly to the inside of the sea pump body and to both ends of the impeller.

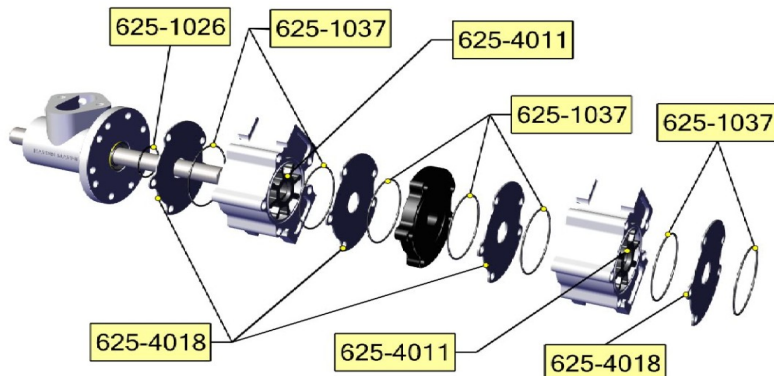
2) Notice the rotation shown. This is for typical port side mounted sea pump standard rotation engine. When installing on to the shaft keep track of which side is front.

3) Apply petroleum jelly to both 625-1037 o-rings. Install 1 on each side of the sea pump body.



- **Step 13:**

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

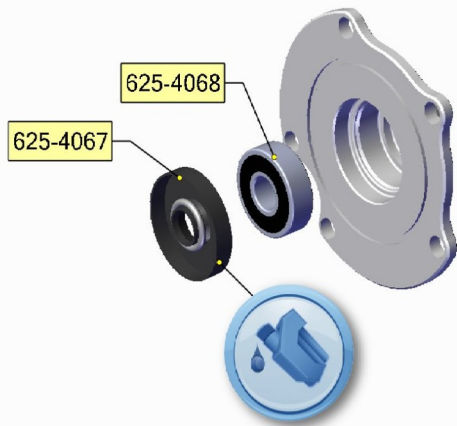


- **Step 14:**

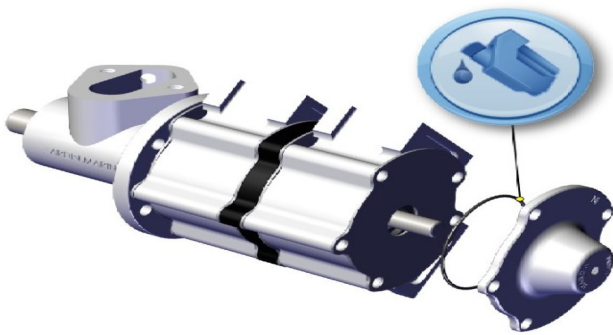
1) Slide the components onto the shaft as shown.



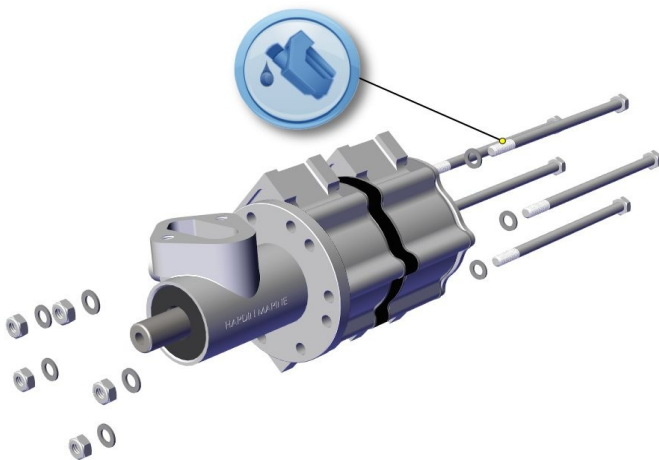
# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



- **Step 15:**
  - 1) Remove old seal and bearing from rear cover.
  - 2) Install new bearing and seal.
  - 3) Coat bearing and seal with petroleum jelly.



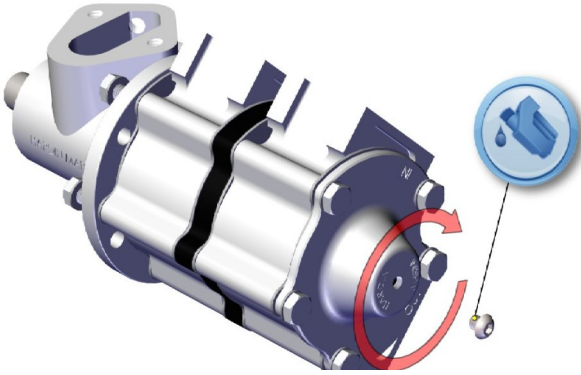
- **Step 16:**
  - 1) Apply petroleum jelly to the 625-1037 and install into the groove in the rear cover.
  - 2) Apply petroleum jelly to the end of the shaft.



- **Step 17:**
  - 1) Apply anti-sieze to the bolts
  - 2) Using 1/2 socket torque to 20 ft. lbs..

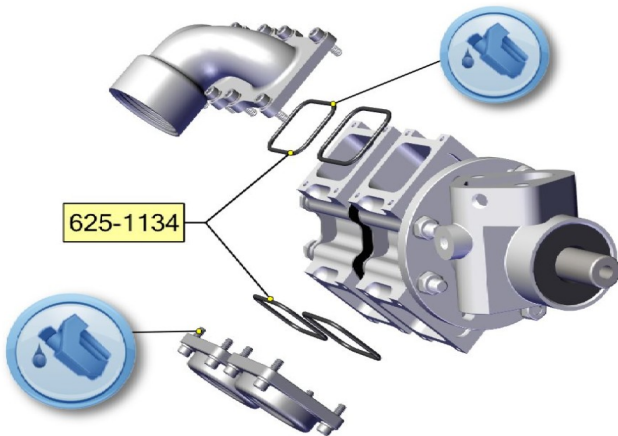


# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177



- **Step 18:**

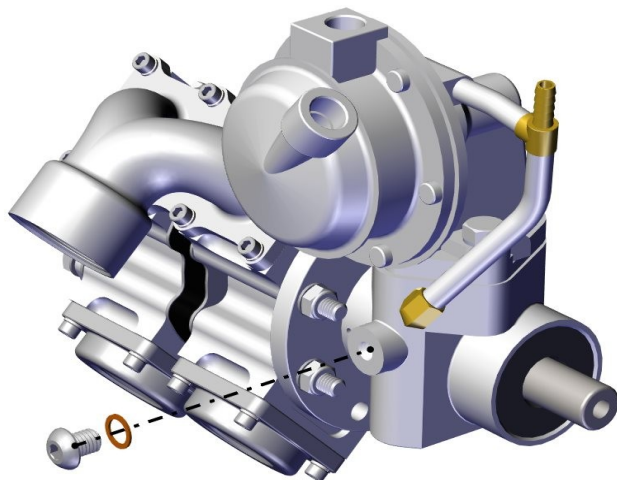
1) Apply anti-sieze to the bolt. Using 5/32 allen key install into the rear cover. Torque to 80 in. lbs..



- **Step 19:**

1) Using the supplied 625-1134 o-rings install.

2) Using 5/32 hex socket, torque to 60 in. lbs..



- **Step 20:**

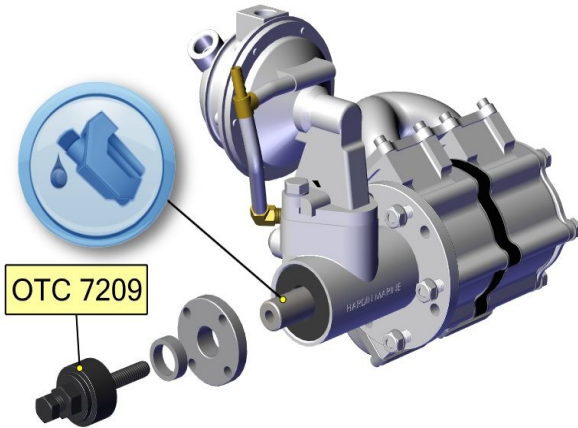
1) Fill cavity with Quicksilver High Performance Gear Lube until the lube pours out of the threads.

2) Using 7/32 hex socket install bolt with new copper washer.

- 3) Install fuel pump and vent equalizer.



# HARDIN 525/700 2 STG MASTER REBUILD KIT 625-4177

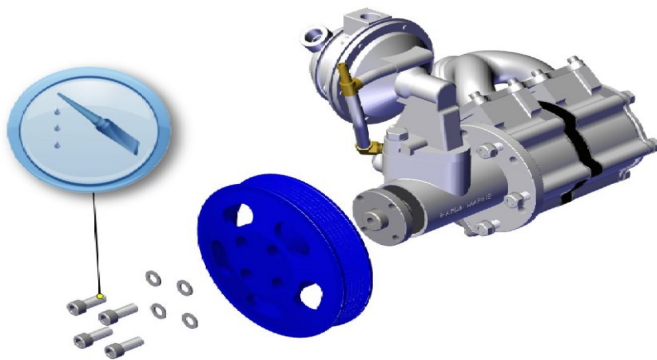


- **Step 21:**

- 1) Make spacer to the distance needed for the hub to be installed from the front of the shaft.

- 2) Using GM power steering pulley install to install hub.

- 3) Make sure to grease the shaft before installing the hub.



- **Step 22:**

- 1) Apply red loctite to the bolts.

- 2) Install pulley. Use a 1/4 hex socket to install the bolts. Torque to 20 in. lbs..