

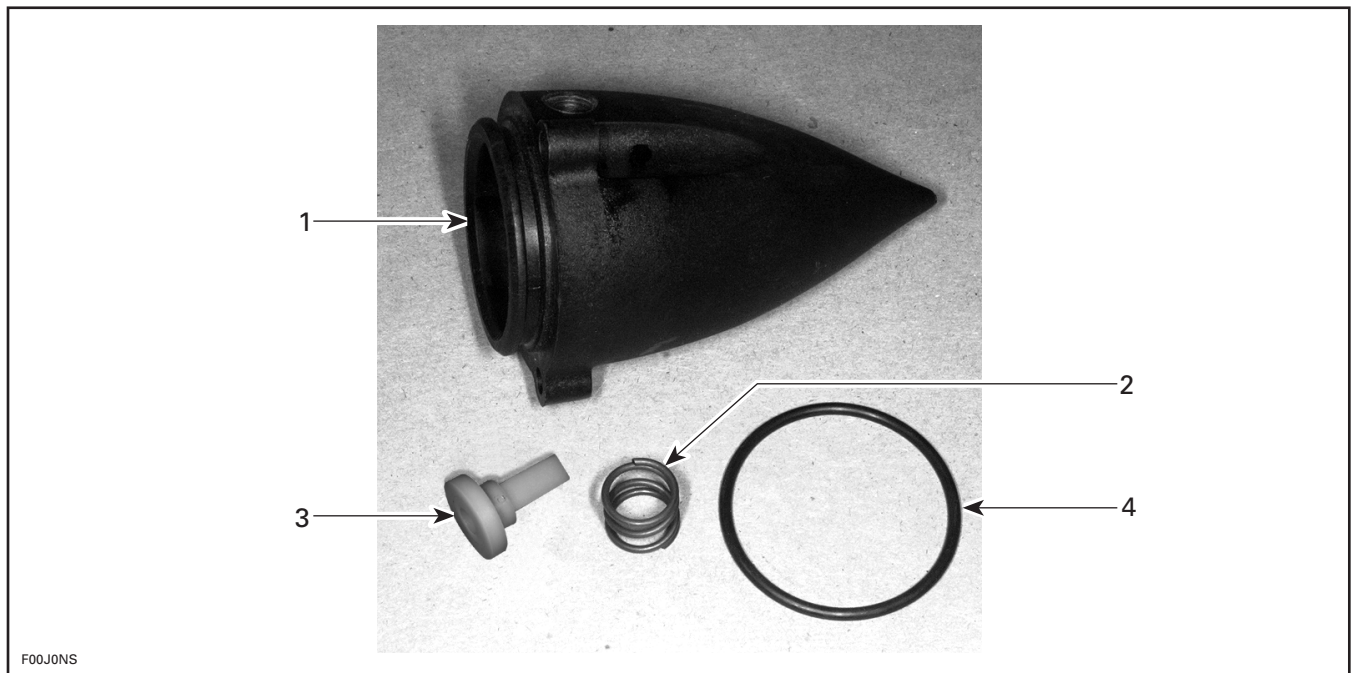


◆ WARNING

For safety reasons, this kit must be installed by an authorized Bombardier Sea-Doo watercraft dealer. Should removal of a locking device be required when undergoing disassembly/assembly, always replace with a new one. This *instruction sheet* should be given to the purchaser. This kit is designed for specific applicable models only. It is not recommended for boats other than those for which it was sold.

NOTE: Installation time is approximately 0.5 hour.

PARTS TO BE INSTALLED



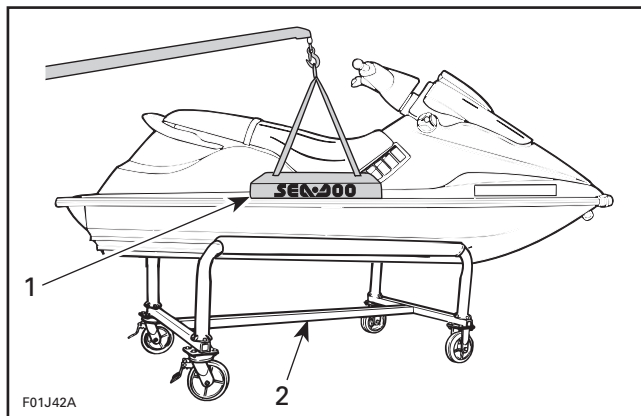
- 1. Cover
- 2. Spring

- 3. Pusher
- 4. O-ring

INSTRUCTION

Preparation

Using an appropriate lift kit, install watercraft on a stand.



1. Lift kit
2. Work stand



WARNING

Ensure safety lanyard is disconnected from DESS post to avoid accidental starting of the engine.

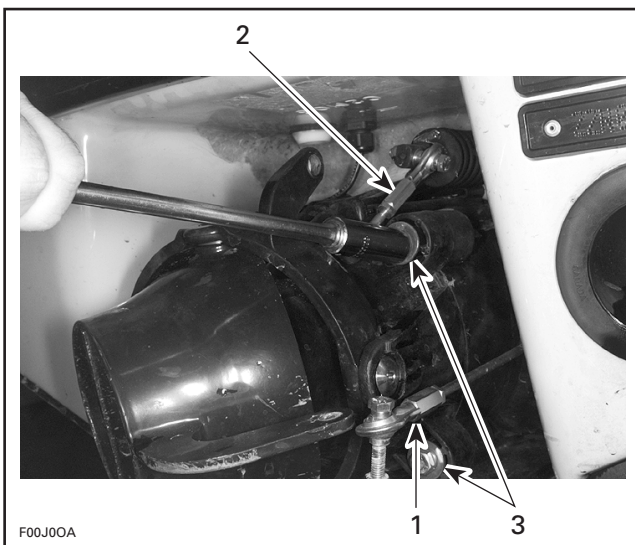
Procedure

Refer to 1996 *Sea Doo Shop Manual*, (P/N 219 100 031), SECTION 09 for complete removal and installation procedure.

Detach reverse cable from reverse gate, if equipped.

Detach VTS link rod from trimming ring, if equipped.

Detach steering cable from jet pump nozzle.



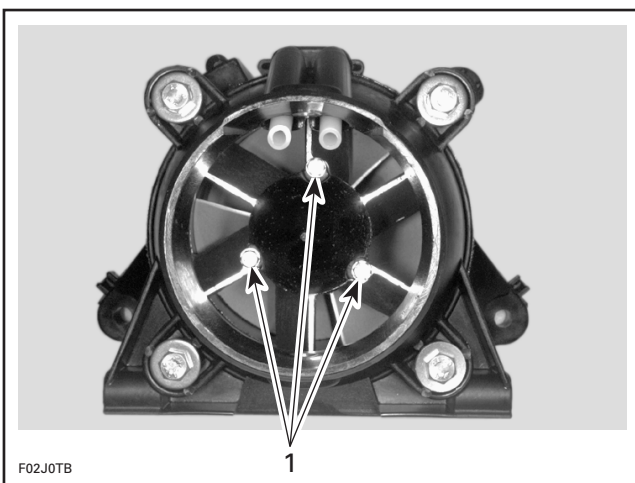
1. Steering cable attachment
2. VTS link rod
3. Remove bolts retaining venturi

Remove 4 bolts retaining venturi to jet pump housing.

Remove reverse gate support (with gate), venturi and nozzle assembly from impeller housing.

Remove 3 screws retaining cover.

Remove filler plug from cover.



1. Screws retaining cover

NOTE: Place a suitable container under jet pump to collect oil when removing cover.

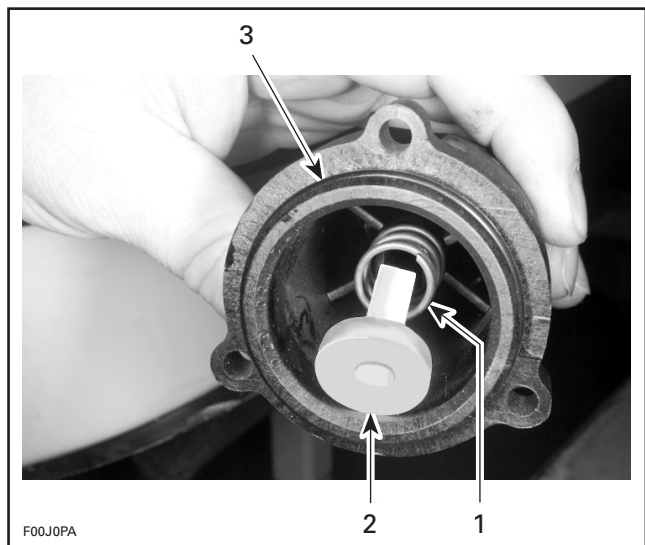
Using a fiber hammer, gently tap cover to release it from housing.

▼ CAUTION

Do not crank engine or apply grease to end of drive shaft at PTO flywheel while cover is removed.

Wipe off any oil spillage.

Install spring **no. 2** and pusher **no. 3** into new cover **no. 1**.



1. Spring
2. Pusher
3. Install new O-ring

Apply a thin layer of Loctite 518 on mating surface of new cover and install O-ring **no. 4**.

Install cover **no. 1**.

Apply loctite 242 on threads and torque screws to 4 N•m (35 lbf•in).

NOTE: Ensure filler plug is toward top side of pump housing.

Pour approximately 70 mL (2.4 oz) of SEA-DOO JET PUMP SYNTHETIC OIL (P/N 293 600 011) through oil filler hole until oil reaches bottom of hole threads. Wait for the oil to drain into center area of housing then fill oil level as necessary.

Pressure test oil reservoir.

Refer to 1996 *Sea Doo Shop Manual*, (P/N 219 100 031), SECTION 09-01 for pump pressurization procedure.

Check oil level and add oil if necessary.

▼ CAUTION

Use Only Sea-Doo jet pump synthetic oil (P/N 293 600 011). Do not mix oil brands. Do not mix with mineral based oil.

Apply Loctite PST 592 on threads then install filler plug.

Clean mating surfaces on pump housing and venturi.

Apply Loctite 518 on mating surface and install venturi assembly.

Make sure to align bailer passages on top.

Apply Loctite 242 on threads and torque bolts to 21 N•m (16 lbf•ft).

Secure ball joint of steering cable and torque bolt to 7 N•m (62 lbf•in).

Secure ball joint of VTS link rod, if equipped, and torque bolt to 10 N•m (89 lbf•in).

Attach reverse cable to reverse gate and adjust reverse mechanism, if equipped.

Start engine and check impeller for proper operation.

295 500 542

1.	271 000 670	Cover	Couvercle
2.	271 000 704	Spring	Ressort
3.	271 000 703	Pusher	Poussoir
4.	293 000 011	O-ring	Joint torique