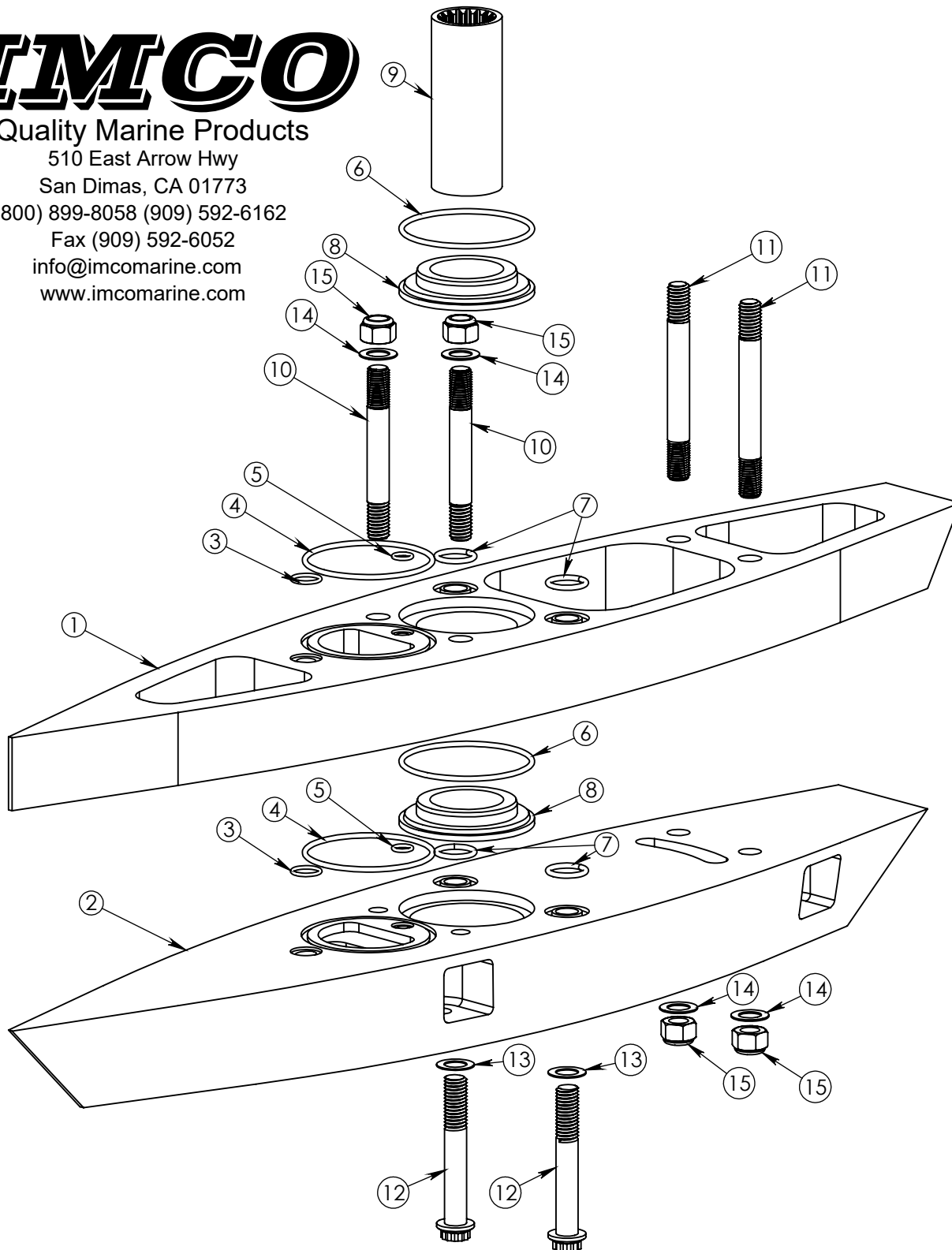


# IMCO

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## 1 1/2" SCX DD SPACER KIT 01-8138 ASSEMBLY INSTRUCTIONS

1. Remove old short studs, 2 ea. on upper housing, 2 ea. on top of gear spacer (top studs only)
2. Install new studs (longer). Use provided Loctite.
3. Install alignment spacers on both spacer and gear spacer with "O" rings provided.
4. Install spacer and gear spacer to upper housing, use #12 bolts first, then nuts with washers, all provided with kit.
5. Tighten nuts and bolts.
6. Install longer coupler to vertical shaft of lower unit. (Make sure all "O" rings are installed).
7. Install lower unit with nuts and washers provide, tighten all nuts.

Note: Studs on lower side of gear spacer and lower unit stay the same!

| Kit Part # 01-8138     |                                            |     |              |
|------------------------|--------------------------------------------|-----|--------------|
| Item                   | Description                                | Qty | Part Number  |
| 1                      | 1 1/2" SCX DD Spacer                       | 1   | 01-7164      |
| 2                      | SCX DD Shaft Gear Spacer (not in kit)      | 1   | 01-7150      |
| 3                      | "O" Ring (Cooling Water Passage Lower)     | 2   | 11-2014      |
| 4                      | "O" Ring (Water Passage)                   | 2   | 11-2143      |
| 5                      | "O" Ring (PTFE Oil Passage)                | 2   | 11-4011      |
| 6                      | "O" Ring (Alignment Spacer)                | 2   | 11-2144      |
| 7                      | "O" Ring (Upper Screws)                    | 4   | 11-2114      |
| 8                      | Alignment Spacer (1 provided)              | 1   | 01-2401      |
| 9                      | 3 1/2" Coupler (17 tooth)                  | 1   | 01-2145      |
| 10                     | Stud 7/16 x 3 1/2" S/S (Gear Spacer)       | 2   | 08-130904181 |
| 11                     | Stud 7/16 x 4" S/S (Upper Case)            | 2   | 08-130904201 |
| 12                     | Bolt 7/16-14 x 3" 12 Point S/S (Thin Head) | 2   | 08-070907161 |
| 13                     | Washer 7/16" ANS/S Thin                    | 4   | 08-160900001 |
| 14                     | Washer 7/16" ANS/S                         | 10  | 08-100900001 |
| 15                     | Nut 7/16-20 Nylock S/S                     | 8   | 08-080904001 |
| Provided But Not Shown |                                            |     |              |
|                        | "O" Ring (Spur Gears)                      | 1   | 11-2165      |
|                        | "O" Ring (Water Passage 2)                 | 1   | 11-2126      |
|                        | "O" Ring (Cooling Water Passage Lower)     | 1   | 11-2135      |
|                        | Nut 7/16-20 Nylock S/S Thin                | 2   | 08-090904001 |
|                        | Loctite                                    | 1   | 09-2038      |