1. Locate the centerline on the outside of transom and boat bottom (Figure 1).

2. With a level square and protractor, measure the transom angle. This will decide which transom housing (0° - 9°, 0203-B-06492 or 9° to 18°, 0203-B-06491 or 0203-B-07517) is to be used.

3. Also determine which intake adapter, 12° "V" deadrise or 20° "V" deadrise is to be used.

4. From (2) and (3) above select the proper outline dimension drawing (L-4137, L-4040, L-4155 or L-4157) and mark all the cut-outs on the transom and boat bottom (Figure 2).

5. Step number 4 may be omitted by using marking template 0203-H-02520 (Figure 3).
Cut the openings with a saber saw. The opening thru the boat bottom may be cut from the inside by first drilling four small holes at the corners of the marked cut-out and re-marking it on the inside of the boat (Figure 4).

Loosely insert the intake adapter into the boat with the 4-3/8" leveling bolts threaded into the corners (Figure 5). Raise the casting with the leveling screws so that it matches the outside boat bottom as near as possible with the least amount of filling and fairing. Note: It may be necessary to bevel the bottom inside edge of transom opening if the transom is thick.

In either event the filler should be mixed very thick so that it may be stacked in a pile with no resin run out. Stack the filler on both sides and rear of opening high enough so that some will be squeezed out all around. The front may be packed in after the thru-hull is in place. If the boat bottom is thin and has sagged it will be necessary to install several of the 1/4" fasteners at this time to true up the outside boat bottom. After the resin filler has jelled drill all of the 1/4" holes for the fasteners from the inside of the boat thru the pilot holes in the top flange of the intake adapter (Figure 6). The four leveling screws may be used to jackout the intake adapter so that the sealant may be applied for final installation. Counter-sink the outside boat bottom with a 1/2 inch counter-sink for the 1/4" flat head machine screws. Note: Fixture #0203-8-06506 may be used as a mold instead of the actual intake adapter (Figure 7).

Bolt the Jet-Drive, with gasket in place, to suction thru-hull casting. Make certain all bolts are tightened now because the rear bolts will be difficult to get at later (Figure 8).
14. Screw the steering tube onto the steering cable and tighten (Note: For most steering systems, an adapter is furnished to fit). Remove the first large hex nut from the steering tube and insert tube with push-pull cable thru the hole in the transom housing. Replace the large hex nut outside on the transom housing. Center the short piece of rubber bushing in the hole and tighten the hex nut until the rubber has expanded on both sides of the hole. Tightening with a pair of pliers is sufficient. Install ball joint or eye and on tiller arm and attach steering push-pull cable to tiller. If the steering wheel is not centered with the jet nozzle, the two large hex nuts and rubber bushing may be moved one way or the other on the long running threads of the steering tube (Figure 10).