ASSEMBLY IS USED FOR 625-8280, 625-8281, 625-8282 & 625-8283 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) MAKE SURE FACE OF DAMPER, FIG A IS 3.095 FROM FRONT OF ENGINE BLOCK, FIG B.
2) KIT IS SUPPLIED WITH (3) 3/8-16 & 3/8-24 x 1-1/2 BOLTS #6, TO MOUNT CRANK PULLEY TO DAMPER. APPLY LOCTITE TO BOLTS. INSTALL INTO THE #1 CRANK PULLEY WITH WASHERS. USING 5/16 HEX SOCKET TORQUE TO 35 FT. LBS..
3) APPLY LOCTITE TO #4 1/2-20x 2" BOLT. INSTALL WITH WASHER INTO CENTER OF THE CRANK PULLEY. USING 3/4 SOCKET, TORQUE TO 55-60 FT. LBS..
4) APPLY LOCTITE TO THE #3 3/8-24x1/2 BOLTS #5. INSTALL #2 COVER, TO THE CRANK PULLEY. USING 5/16 HEX SOCKET TORQUE TO 30 FT. LBS..

ITEM NO. | PART NUMBER | DESCRIPTION | QTY.
--- | --- | --- | ---
1 | 625-8176 | PULLEY, CRANK - SERPENTINE | 1
2 | 625-8177 | COVER, SERPENTINE CRANK PULLEY | 1
3 | 90050AN-STSS | WASHER, 1/2 AN | 1
4 | 90050F200HH8 | BOLT | 1
5 | 90037F075SHS | BOLT, 3/8-24x.75 | 3
6 | 90037C150SH8 | BOLT, SHCS, 3/8-16x1.50 | 3
7 | 90037AN-STSS | WASHER, 3/8 AN | 3

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ASSEMBLY IS USED FOR 625-8280 & 625-8281 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) SEA PUMP IS PREASSEMBLED AS SHOWN IN FIG A. THE BRACKET IS INSTALLED ON THE PUMP. SEA PUMP PULLEY IS ALSO INSTALLED.
2) IN THIS STEP, THE PUMP IS INSTALLED USING ONLY THE BOTTOM #6 BOLT & #7 WASHER.
3) INSTALL #3 SPACERS INTO THE POCKETS ON THE BACK SIDE OF THE SEA PUMP BRACKET.

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
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<tbody>
<tr>
<td>1</td>
<td>625-4110</td>
<td>SEA PUMP</td>
<td>1</td>
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<tr>
<td>2</td>
<td>625-4098</td>
<td>BRACKET, SEA PUMP - GEN 2 SERPENTINE KIT</td>
<td>1</td>
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<tr>
<td>3</td>
<td>625-4040</td>
<td>SPACER, SEA PUMP TO X-OVER</td>
<td>2</td>
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<tr>
<td>4</td>
<td>625-4041</td>
<td>WASHER, HAT</td>
<td>1</td>
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<tr>
<td>5</td>
<td>625-4055</td>
<td>PULLEY, SEA PUMP</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>90043C275HHS</td>
<td>BOLT, 7/16-14x2.75</td>
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<tr>
<td>7</td>
<td>90043AN-STSS</td>
<td>WASHER, 7/16AN</td>
<td>1</td>
</tr>
<tr>
<td>8</td>
<td>90031AN-STSS</td>
<td>WASHER, 5/16 AN</td>
<td>5</td>
</tr>
<tr>
<td>9</td>
<td>90031CN-HNSS</td>
<td>NUT, NYLON, HALF, 5/16-18</td>
<td>5</td>
</tr>
</tbody>
</table>

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ASSEMBLY IS USED IN 625-8280 & 625-8282 DRIVE KITS WITHOUT POWER STEERING.

INSTALLATION INSTRUCTIONS:
1) CROSSOVER COMES COMPLETELY ASSEMBLED.
2) APPLY WHITE LITHIUM GREASE TO #1 O-RINGS AND INSTALL INTO THE GROOVES IN THE CROSSOVER BODY.
3) #2 SPACER IS INSTALLED BETWEEN THE BLOCK AND CROSSOVER. IT IS HELD IN BY THE PORT SIDE IDLER ASSEMBLY.
4) INSTALL CROSSOVER USING #7 BOLTS AND #8 WASHERS. USING 5/16 HEX SOCKET TORQUE TO 35 FT. LBS..
5) SLIDE #8 WASHER & #6 SPACERS OVER #9 BOLTS.
6) SLIDE #3 IDLER SPACES INTO THE BACKSIDE OF #4 IDLERS. INSTALL BOLTS INTO IDLERS AND INSTALL INTO BLOCK.
6) ROTATE SEA PUMP ALL THE WAY OUT. USING 5/8 SOCKET, TORQUE SEA PUMP LOWER BOLT AND BOTH IDLER BOLTS TO 45 FT. LBS..
7) APPLY LIQUID TEFLON TO #10 FITTING AND INSTALL INTO WATER INLET.
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Assembly is used for 625-8280, 625-8281, 625-8282 & 625-8283 drive kits.

Installation Instructions:
1) The alternator pulley comes installed on the alternator.
2) Remove the 3/8 x 3-1/2 bolt that comes with the alternator bracket, Fig. A.
3) Apply loctite to the alternator bolt. Slide alternator into the bracket. Using 5/16 hex socket snug the bolt.
4) Apply red loctite to both #5 & 6 bolts. Install #4 washer onto the bolts.
5) Position #3 cross support on the front side of the sea pump bracket. Install #5 bolt and washer from the back side of the bracket and screw into the support rail.
6) On the alternator side, the bracket sits behind the alternator. Slide #6 bolt and washer in from the back side and screw into the support rail.
7) Slide alternator all the way out. Using 5/16 hex socket tighten upper bolt to 30 ft. lbs.
8) Using 1/2 socket torque both support rails bolts to 20 in. lbs.
9) This is a single wire self exciting internally regulated alternator. Connect the battery cable to the B+ stud on the backside of the alternator. The ground tab is not necessary as it is negative ground and grounds through the engine. The mercury purple exciter wire is not used.

ITEM NO. | PART NUMBER | DESCRIPTION | QTY.
--- | --- | --- | ---
1 | 620-3147M-NC | 94 amp chrome alternator | 1
2 | 625-3130 | Pulley, Alternator | 1
3 | 625-3133 | Rail, Serpentine Cross Support | 1
4 | 90031AN-STSS | Washer, 5/16 an | 2
5 | 90031C100HHS | Bolt, 5/16-18 x 1.00 | 1
6 | 90031C125HHS | Bolt, 5/16-18x1.25 | 1

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ASSEMBLY IS USED FOR 625-8280 & 625-8282 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) USING 5/8 WRENCH, INSTALL IN HEX BOSS ON TENSIONER ARM, FIG. A.
2) PULLING UP WRENCH INSTALL 625-2318 SERPENTINE BELT, AS SHOWN.
ASSEMBLY IS USED FOR 625-8280 & 625-8281 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) SINGLE STAGE SEA PUMP PLUMBING SHOWN. DUAL STAGE SEA PUMP USED IN KITS 625-8182 & 625-8183 WILL DEPEND ON HOW THE SEA PUMP IS PLUMBLED.
2) FITTINGS ARE NOT SUPPLIED WITH THE KIT. DRAWING SHOWN WITH 540-222151.
3) ON THE BACKSIDE OF THE SEA PUMP. BUNG MARKED RH OUT IS THE FRESH WATER INLET. LH OUT IS THE FRESH WATER EXIT.
4) RUN EITHER 1-1/4 OR -24 HOSE, SHOWN IN BLUE, OUT OF THE PUMP.
5) PICTURE SHOWS TYPICAL STARBOARD SIDE WATER PLUMBING. OUT IS THE PUMP TO THE OIL COOLER. YOU CAN ALSO INSTALL A FUEL COOLER INLINE BETWEEN THE PUMP AND OIL COOLER.

540-222151 FITTING 1" NPT x 1-1/4 HOSE BARB NOT INCLUDED.

LH OUT IS THE WATER OUTLET.

RH OUT IS THE WATER INLET.

DETAIL A
SCALE 1 : 2
ASSEMBLY IS USED FOR 625-8280, 625-8281, 625-828 & 625-8283 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) TYPICAL PORT SIDE FRESH WATER PLUMBING SHOWN. THE FRESH WATER INLET HOSE IS SHOWN IN BLUE.
2) COME OUT OF THE ENGINE COOLER AND RUN THROUGH THE POWER STEERING COOLER, FIG. A.
3) COME OUT OF THE POWER STEERING COOLER RUN INTO THE FRONT OF THE CROSSOVER, FIG. B.
4) SHOWN WITH 1-1/4 HOSE. YOU CAN ALSO USE -24 HOSE.
POWER STEERING PLUMBING:
1) -6 JIC HIGH PRESSURE FITTING COMES OUT THE TOP, SIDE OF THE PUMP, FIG. A.
2) -6 JIC LOW PRESSURE RETURN COMES INTO THE SIDE OF THE RESERVOIR, FIG. B.
3) AS SHOWN IN THE DRAWING, THE LOW PRESSURE RETURN COMES FROM THE POWER STEERING OIL COOLER, FIG. C.
4) IF USING WITH EXTERNAL POWER STEERING RESERVOIR, PURCHASE 625-8171 DUMP CAP TO CONNECT TO RESERVOIR. CAP OFF THE LOWER PRESSURE RETURN. COME OUT OF THE OIL COOLER AND RETURN THE RESERVOIR.
5) USE GM POWER STEERING FLUID.