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ASSEMBLY IS USED FOR 625-8300, 625-8301, 625-8302 & 625-8303 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. FIG C, TO MOUNT CRANK PULLEY TO DAMPER. APPLY LOCTITE TO BOLTS. INSTALL INTO THE CRANK PULLEY, FIG D, WITH WASHERS. TORQUE TO 35 FT. LBS..

3) APPLY LOCTITE TO 1/2-20x 2” BOLT, FIG E. INSTALL WITH WASHER INTO CENTER OF THE CRANK PULLEY. TORQUE TO 55-60 FT. LBS..

4) APPLY LOCTITE TO THE (3)3/8-24x1/2 BOLTS, FIG F. THREAD COVER, FIG G, TO THE CRANK PULLEY.

5) APPLY GASKET TACH SEALANT TO THE CIRCULATING PUMP GASKETS, FIG H.

6) APPLY LOCTITE TO THE (4)3/8-16x1-3/4 BOLTS, FIG I. INSTALL WITH WASHERS INTO THE CIRCULATING PUMP, FIG J. THREAD INTO THE BLOCK. TORQUE BOLTS TO 35 FT. LBS..

7) APPLY LOCITE TO THE (4)5/16-24x3/4 BOLTS, FIG K. INSTALL WITH WASHERS INTO THE CIRCULATING PUMP PULLEY, FIG L. THREADED TO THE CIRCULATING PUMP HUB. TORQUE TO 25 FT. LBS..

8) WE SUPPLY 1/2 NPT BYPASS FITTING, FIG M, TO INSTALL INTO THE INTAKE MANIFOLD UNDER THE THERMOSTAT. APPLY LIQUID PIPE TAPE TO FITTING.

9) THE BYPASS HOSE, FIG N IS EXTRA LONG TO PROVIDE CONNECTION TO VARIOUS INTAKE MANIFOLDS. HOSE WILL NEED TO BE CUT TO SIZE. INSTALL WITH HOSE CLAMPS, FIG O.
ASSEMBLY IS USED FOR 625-8300, 625-8301, 625-8302 & 625-8303 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) SEA PUMP COMES PRE ASSEMBLED.
2) APPLY LOCTITE TO THE SUPPLIED (2) 7/16-14 x 1" BOLTS, FIG A.
3) INSTALL BOLTS WITH WASHERS INTO THE BRACKET, FIG B.
4) THREAD BOLTS INTO THE 2 LOWER STARBOARD SIDE HOLES NEXT TO THE TIMING COVER, FIG C. TORQUE TO 40 FT, LBS.
5) USING LIQUID PIPE SEALANT, INSTALL SUPPLIED 540-222151 1" NPT x 1-1/4 BARB WATER INLET FITTING INTO FIG D.
6) USING LIQUID PIPE SEALANT, INSTALL SUPPLIED 540-222151 1" NPT x 1-1/4 BARB WATER OUTLET FITTING INTO FIG E.

SEA PUMP REBUILT KITS:
625-4174: MASTER REBUILD KIT
625-4189: IMPELLER KIT
ASSEMBLY IS USED IN BOTH 625-8300 & 625-8301 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) THIS ACCESSORY BRACKET COMES PRE ASSEMBLED.
2) REMOVE BOLT, WASHER & SPACER THAT HOLDS THE SMOOTH IDLER TO THE Bracket, FIG A.
3) APPLY LOCTITE TO THE SUPPLIED (2) 7/16-14 x 3-1/2 BOLTS. INSTALL BOLTS WITH WASHERS INTO Bracket, FIG B.
4) THREAD BOLTS INTO THE 2 LOWER PORT SIDE HOLES NEXT TO THE TIMING COVER, FIG C. TORQUE TO 40 FT. LBS.
5) APPLY LOCTITE TO THE IDLER BOLT. RE-INSTALL THE IDLER PULLEY. TORQUE TO 35 FT. LBS.
6) FOR ALTERNATOR WIRING SEE 625-8337-1 INSTRUCTIONS.
ASSEMBLY IS USED IN BOTH 625-8302 & 625-8303 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) THIS ACCESSORY BRACKET COMES PRE ASSEMBLED.
2) REMOVE BOLT, WASHER & SPACER THAT HOLDS THE SMOOTH IDLER TO THE BRACKET, FIG A.
3) APPLY LOCTITE TO THE SUPPLIED (2) 7/16-14 x 3-1/2 BOLTS. INSTALL BOLTS WITH WASHERS INTO BRACKET, FIG B.
4) THREAD BOLTS INTO THE 2 LOWER PORT SIDE HOLES NEXT TO THE TIMING COVER, FIG C. TORQUE TO 40 FT. LBS.
5) APPLY LOCTITE TO THE IDLER BOLT. RE-INSTALL THE IDLER PULLEY. TORQUE TO 35 FT. LBS.
6) FOR ALTERNATOR WIRING AND POWER STEERING PLUMBING, SEE 625-8338-1 INSTRUCTIONS.
ALTERNATOR WIRING INSTRUCTIONS FOR 625-8300, 625-8301, 625-8302 & 625-8303 DRIVE KITS:
1) RUN A 10 GAUGE WIRE FROM THE CHARGING POST ON THE BACK OF THE ALTERNATOR, FIG A, TO THE STARTER STUD WHERE THE BATTERY CABLE ATTACHES TO.
2) RUN A 12 GAUGE GROUND WIRE FROM THE GROUND TAB ON THE BACK OF THE ALTERNATOR, FIG B, TO THE ENGINE BLOCK.

POWER STEERING PUMP HOSE CONNECTIONS AND BLEEDING INSTRUCTIONS FOR 625-8302 & 625-8303 DRIVE KITS:
1) HIGH PRESSURE OUT -6 JIC, SEE FIG. C. LOW PRESSURE RETURN -6 JIC, SEE FIG. D.
2) FILL RESERVOIR 3/4 FULL WITH GM POWER STEERING FLUID. VERY IMPORTANT TO KEEP RESERVOIR HALF FULL DURING BLEEDING PROCESS.
3) START ENGINE. WHILE IDLING CHECK FOR LEAKS.
4) BEGIN TO CYCLE THE STEERING WHEEL FROM SIDE TO SIDE UNTIL YOU START TO FEEL A HARD LOCK OUT. REPEAT THIS PROCESS UNTIL A DELIBERATE STOP OCCURS IN BOTH DIRECTIONS.
5) TO CHECK IF THE SYSTEM IS BLED PROPERLY. WITH THE ENGINE TURNED OFF AND THE STERNDRIVE STRAIGHT AHEAD. GO BEHIND THE BOAT AND MANUALLY TRY TO TURN THE STERNDRIVE BACK AND FORTH. IF THE DRIVE MOVES, THERE IS STILL AIR IN THE SYSTEM. REPEAT PROCESS.
ASSEMBLY IS USED FOR 625-8300, 625-8301, 625-8302 & 625-8303 DRIVE KITS.

INSTALLATION INSTRUCTIONS:
1) THE TENSIONER ASSEMBLY COMES PRE ASSEMBLED. IF TENSIONER IS BEING USED WITH 625-8301 & 625-8303 HEAT EXCHANGER KITS, 625-4655 BRACKETS WILL BE INSTALLED.
2) APPLY LOCTITE TO THE SUPPLIED (3) 3/8-16 x 1-1/4 BOLTS. INSTALL BOLTS WITH WASHERS INTO THE TENSIONER BRACKET, FIG A.
3) SPACERS, FIG B, ARE INSTALLED BETWEEN THE TENSIONER BRACKET AND CYLINDER HEAD.
4) SLIDES BOLTS THRU THE SPACERS AND THREAD INTO THE CYLINDER HEAD, FIG C. TORQUE BOLTS TO 30 FT. LBS..
MOUNTING INSTRUCTIONS:

1) ATTACH 625-4556 OIL COOLER BRACKETS TO HEAD MOUNT BRACKETS. APPLY LOCTITE TO THE (4) 90037C100SFS BOLTS & INSERT THROUGH THE COUNTERSUNK SIDE OF THE BRACKET. TORQUE TO 30 FT. LBS..

2) THE PORT SIDE BRACKET ASSEMBLY MOUNTS DIRECTLY ON THE HEAD. APPLY LOCTITE TO THE (3) 90037C100SHS BOLTS WITH WASHERS, TORQUE TO 30FT. LBS..

3) THE STARBOARD SIDE BRACKET IS SPACED OFF THE HEAD BY THE (3) 755-5119 SPACERS. APPLY LOCTITE TO THE (3) 90037C150SHS BOLTS WITH WASHERS, TORQUE TO 30 FT. LBS..

4) MAKE SURE THE 900-125 ORINGS ARE INSTALLED IN THE BRACKETS.

5) AFTER INSTALLING THE HEAT EXCHANGER, APPLY LOCTITE TO THE (4) 90031C075SHS BOLTS AND TORQUE TO 20 FT. LBS..

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ASSEMBLY IS USED FOR 625-8301 & 625-8303 DRIVE KIT.

INSTALLATION INSTRUCTIONS:
1) FOLLOW 625-4544 BRACKET MOUNTING INSTRUCTIONS TO MOUNT HEAT EXCHANGER BRACKETS.
2) INSTALL 625-4555 THERMOSTAT HOUSING, FIG A, TO INTAKE MANIFOLD. APPLY GREASE TO THE THERMOSTAT HOUSING O-RING, FIG B. APPLY LOCTITE TO THE (2) 3/8-16x3/4 BOLTS, FIG C. SLIDE BOLTS THROUGH THE HOUSING AND THREAD TO INTAKE MANIFOLD. DO NOT TORQUE THE BOLTS YET.
3) INSTALL 625-4544 HOSE, FIG D, TO THE CIRCULATING PUMP, FIG E. LOOSELY INSTALL HOSE CLAMPS.
4) INSTALL 625-4550 HEAT EXCHANGER, FIG F, INTO THE BRACKET CRADLES.
5) INSTALL UPPER BRACKET CLAMP, FIG G. APPLY LOCTITE TO THE 5/16-18 BOLTS, FIG H. LOOSELY THREAD INTO THE LOWER BRACKETS.
6) INSTALL 625-4573 HOSE, FIG I AND CLAMPS BETWEEN THE HEAT EXCHANGER CONNECTOR, FIG J AND 625-4555 THERMOSTAT HOUSING.
7) TORQUE UPPER BRACKET CLAMP, FIG G, TO 20 FT. LBS..
8) TORQUE THERMOSTAT HOUSING BOLTS, FIG C TO 30 FT. LBS..
9) CONNECT HOSE FROM EXHAUST TO THE THE 1" BARB CONNECTIONS, FIG K.
10) CONNECT 1-1/4 WATER INLET HOSE TO THE PORT SIDE HEAT EXCHANGER BARB, FIG L.
11) CONNECT 625-4578, FIG M, DRAIN HOSE TO OVER FLOW TANK NIPPLE.
12) HEAT EXCHANGER MAIN FILL, FIG N WITH 50/50 PROPYLENE GYLCOL ANTIFREEZE. RUN ENGINE TO BURP SYSTEM. KEEP OVER FLOW, FIG O, HALF FILLED AT ALL TIMES.
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THIS IS FOR 625-8300 & 625-8301 DRIVE KITS.