

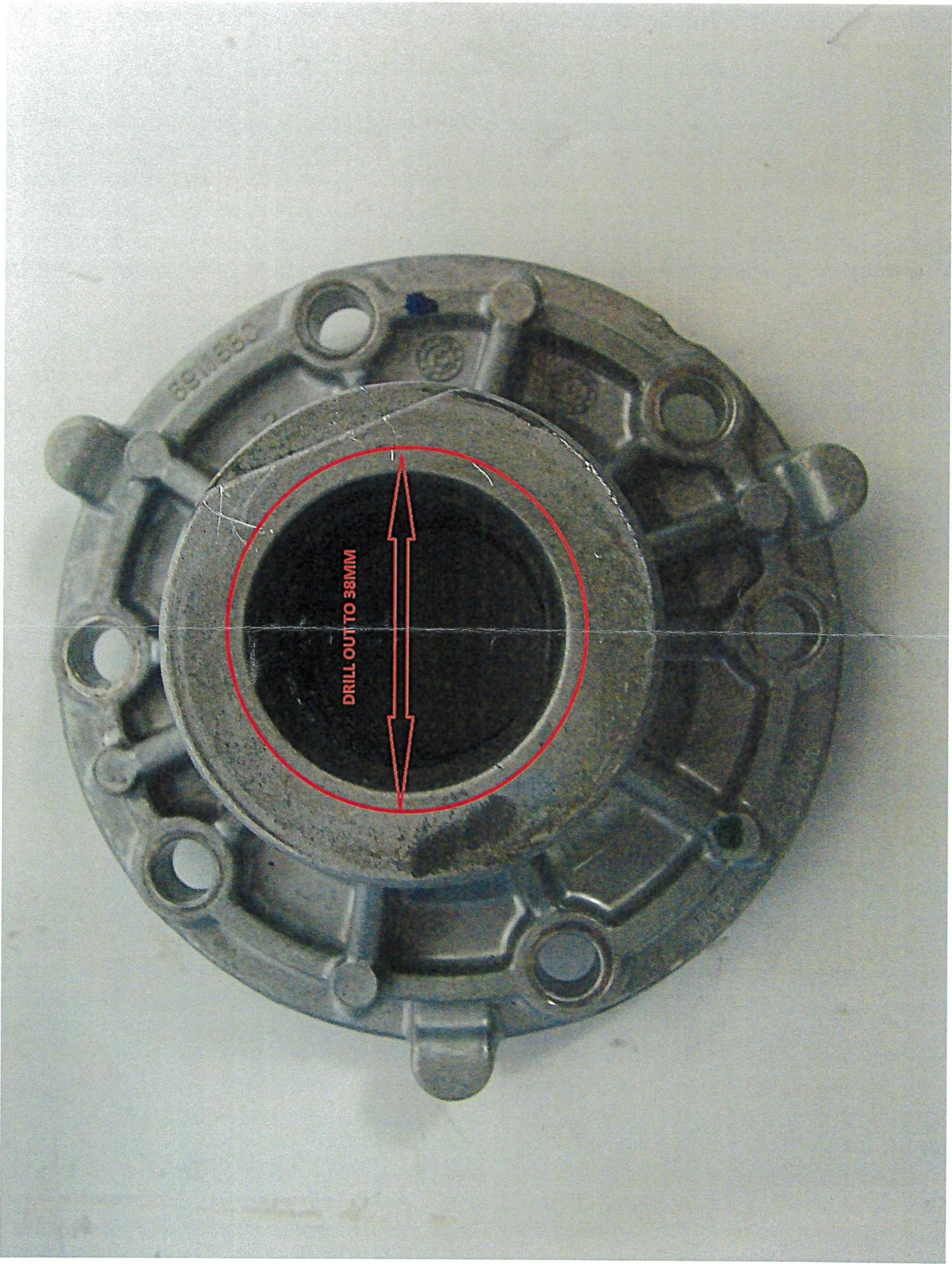
Sea-Doo Spark 2014-2021

PTO / CRANKSHAFT REPERATION KIT INSTALATION MANUAL

- Disassemble PTO as described in workshop manual, remember to drain engine oil.
- Disassemble old seals from PTO
- Modify PTO as shown in the picture 1.
- Modify Retaining Ring 420945693 as shown in the picture 2.
- Assemble PTO water and oil seals as described in workshop manual, instead of original plastic distance ring use the one what is included in the kit..
- Very important to fill all inside area of PTO (water seals side) and inside of simerings with Triple Guard Grease and put some on crankshaft sleeve before mounting back PTO.
- In the picture 3 you can see how PTO supposed to look.
- In the picture 4 you can see how bad is looking original crankshaft when you open PTO.
- Sand down crankshaft. Remove all rust, leave original coating (if its still there) just sand it up to the moment when sleeve will go on it tight. Sleeve is 35mm outside but inside can differs, sand down crankshaft with repeatedly checking if sleeve sliding on properly.
- Clean sleeve inside surface and crankshaft area which you were sanding with brake cleaner.
- In the picture 5 you can see how crankshaft supposed to look after sanding.
- Mix same amount of glue from both tubes (you need about 1/3 of each tube).
- Apply glue on the inside part of sleeve and crankshaft, where sleeve will seat.
- Put sleeve on the crankshaft as shown in the picture 6.
- Clean glue which go out while puting on sleeve.
- You should use dial indicator to check if sleeve sits properly. If its necessary, move it.
- Wait 24hrs before mounting back PTO, in the picture 7 you can see how this supposed look after mounting PTO back.
- Asemble everything back, do it as described in worksop manual.

*It's very important that you use workshop manual and do everything with Sea-Doo specification.

**This is hobby made kit for hobby use, there is no any kind of guarantee for it. The person who made or sell this kit is not responsible for any damage couosed by this kit or unprofessional mounting of it. You mounting it at your own risk!



DRILL OUT TO 38MM

Cut / sand it

**Inside part of Retaining ring
(420945693) locking water
seals in PTO**

As shown on picture.



