

- Remove 4 bolts securing gear case to drive shaft housing.



a - Bolt (2)

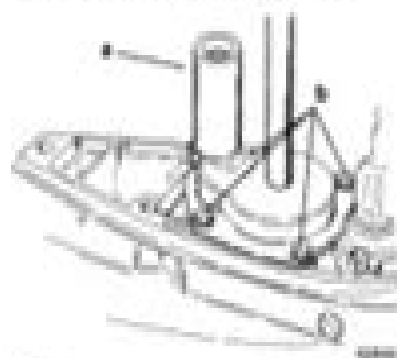
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## Disassembly

### Water Pump

**NOTE:** If water tube seal remained in drive shaft housing, remove seal from housing and reinstall on water pump cover. Secure seal to cover with Loctite 405.

- Remove 4 bolts securing pump cover.



a - Bolt  
b - Bolt (2)

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**NOTE:** Replace cover if thickness of steel at discharge flange is 0.060 in. (1.52mm) or less, or if grooves (other than impeller mounting grooves) in cover roof are more than 0.005 in. (0.127mm) deep.

- Remove cover, washer (above impeller), impeller, key and washer (below impeller).
- Remove cover gasket, base plate and base gasket.



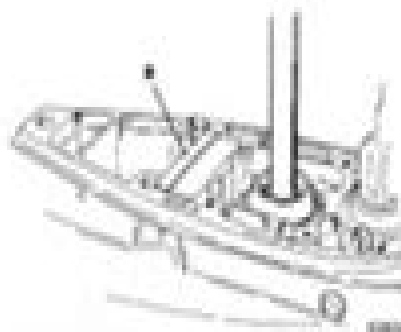
- a - Cover  
b - Washer (above impeller)  
c - Impeller  
d - Key  
e - Washer (below impeller)  
f - Cover Gasket  
g - Base Plate  
h - Base Gasket

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**NOTE:** Replace impeller if

- Impeller blades are cracked, bent or worn.
- Impeller is glazed or melted.
- Rubber portion of impeller is not bonded to impeller hub.

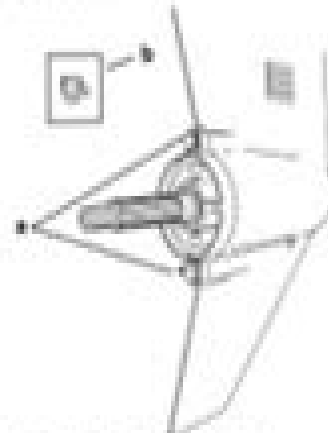
- Remove and/or replace exhaust deflector plate if damaged.



- a - Deflector Plate

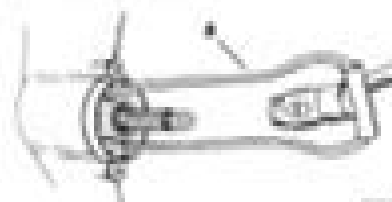
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- Remove bearing carrier attaching bolts and bearing ball washers or ball washers. Discard ball washers.



- a - Balls and Ball Washers or Ball Washers  
b - Ball Washers (Type I)

- Using Pulver (31-2770), remove carrier assembly from gear case.

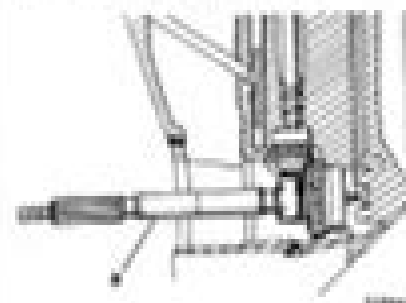


- a - Pulver (31-2770)

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**NOTE:** When removing propeller shaft assembly, cam follower may damage. Remove follower from gear housing.

- Remove propeller shaft assembly.

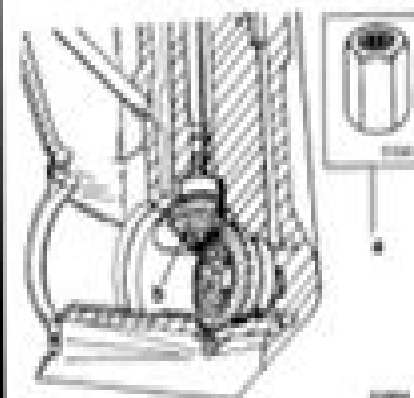


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- a - Propeller Shaft

Model	Drive Shaft Housing Tool
25, 40/50 (4 Stroke)	31-2719M
Force 40/50	31-2719M
50/60, 42/50	31-2719M

- Remove pinion nut and flange.



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- a - Drive Shaft Housing Tool  
b - Pinion Nut

- Remove drive shaft assembly and pinion gear.

# Us Marine 50 Hp Outboard Manual

**United States. Department of the  
Army**



## Us Marine 50 Hp Outboard Manual:

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