

## Section 07 PROPULSION

### Subsection 01 JET PUMP

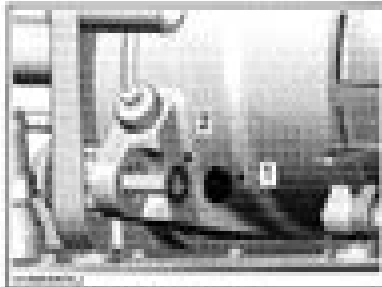


FIGURE 1  
JET PUMP HOUSING AND IMPELLER  
1. Jet pump housing and  
2. Impeller

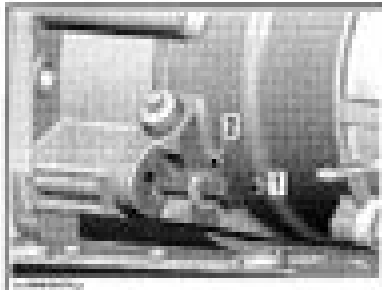


FIGURE 2  
JET PUMP HOUSING AND IMPELLER  
1. Jet pump housing and  
2. Impeller

Tighten as per the following sequence:

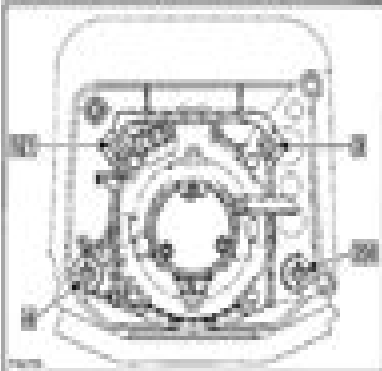


FIGURE 3  
JET PUMP HOUSING AND IMPELLER  
1. Jet pump housing and  
2. Impeller

**NOTE:** Slightly lubricate wear ring with XPS Lube (PN 280 600 018) to minimize friction during initial start.

Reconnect O.P.A.S. hose. Torque-clamp screw to 4 Nm (35 lbf-in).

Position O.P.A.S. "U" lever to middle and side levers.

Apply Loctite 343 (blue) (PN 280 800 060) on screw threads (or use new self-locking screws).

Torque-joint screws to 25 Nm (18 lbf-ft) and side screws to 7 Nm (62 lbf-in).

## IMPELLER COVER

### Impeller Cover Removal

With pump housing in vertical position, remove and discard 3 retaining screws.



Using a flat hammer, gently tap impeller cover to release it from jet pump housing.

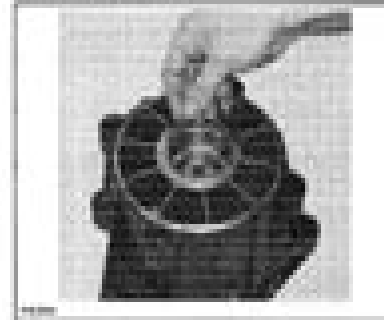
Use flat screwdriver to remove cover.



## Section 07 PROPULSION

### Subsection 01 JET PUMP

Remove both O-rings.



### Impeller Cover Inspection

Check for presence of water in cover and bearing. If so, replace seal and sleeve on impeller side. Also replace O-rings and/or impeller cover.



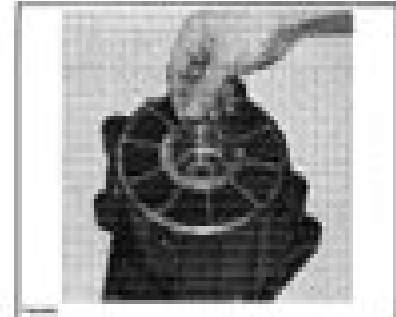
FIGURE 7  
JET PUMP HOUSING AND IMPELLER

Check O-rings condition. Replace as required.

Perform a leak test. Refer to LEAK TEST at the beginning of this section.

### Impeller Cover Installation

Install O-rings in their respective grooves.



Put 25 parts of jet pump bearing grease (PN 280 600 010) in cover.

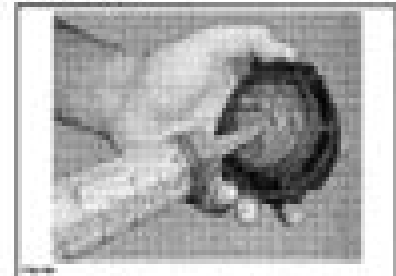


FIGURE 9  
JET PUMP HOUSING AND IMPELLER

Install impeller cover with NEW self-locking screws.

Torque to 7.5 Nm (62 lbf-in).

**NOTE:** Push cover against pump housing while tightening screws. Make sure O-rings are positioned correctly and they are not damaged when pushing the cover.

## IMPELLER

### Impeller Removal

Remove jet pump housing. Refer to JET PUMP HOUSING in this section.

Remove impeller cover. Refer to IMPELLER COVER in this section.

Remove impeller bolt by turning it clockwise.

# Rxp 255 Service Manual

**M Carnoy**



## **Rxp 255 Service Manual:**

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