

## GEAR SET (18-2200) Installation Instructions

**IMPORTANT NOTE:** Supplied pinion bearing (18-1150) **MUST BE** installed with this gear set. The bearing is designed to provide additional drive shaft support required when using this style gear set. **THIS BEARING MUST BE INSTALLED WITH "THIS END UP" TOWARD TOP OF GEAR HOUSING.**

**1.** Install this gear set according to the directions in Mercruiser I-Drive Service Manual #90-86137 or Sierra/Seloc Manual 18-3200, with the following exceptions:

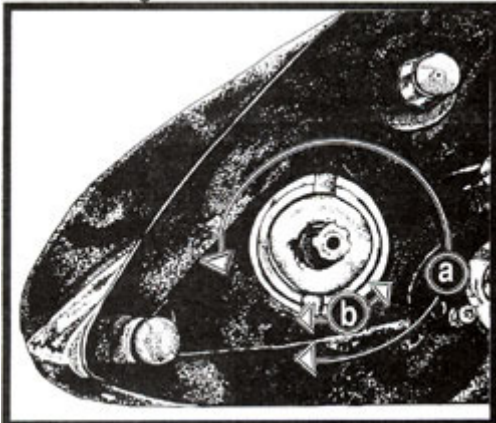
Forward/Pinion Gear Backlash .020" - .023" (.508mm - .584mm)  
Reverse/Pinion Gear Backlash .040" - .060" (1.02mm - 1.52mm)

EXCEPT AS IN "IMPORTANT", BELOW

**IMPORTANT:** 120/140/165 (S/N 3780849 & below)

888 (S/N 3784374 & below)

**Reverse/Pinion Gear Backlash for the above listed models must be set at .025" - .030" (.64mm - .76mm). These units have a short clutch travel and will not tolerate the higher reverse/pinion gear backlash. If the drive unit serial number is unknown, clutch travel length may be determined by checking the shift shaft rotation (with the propeller shaft removed), as shown in Figure 1. ↓**



**2.** To indicate the installation of the new gear set, stamp a "Z" in the trim tab cavity of the gear housing.

**3.** This gear set, as does all gear sets, **REQUIRES** a BREAK-IN PERIOD. We recommend that these instructions be attached to the final user's copy of your repair order with the following Break-In Instructions highlighted.

### INSTRUCTIONS FOR 10 HOUR BREAK-IN PERIOD

1. Avoid full throttle starts.
2. **DO NOT** operate at constant speeds for extended periods.
3. **DO NOT** exceed 75% of full throttle during the first 5 hours of operation. During the next 5 hours, full throttle operation is permissible for brief periods.
4. Shift into forward gear a minimum of 10 times during break-in, with moderate engine speed after each shift.

**a.** Drive unit has LONG clutch travel. Set Reverse/Pinion Backlash at .040" - .060" (1.02 - 1.52mm).

**b.** Drive unit has SHORT clutch travel. Set reverse/Pinion Backlash at .025" - .030" (.64mm-.76mm)

N-1584