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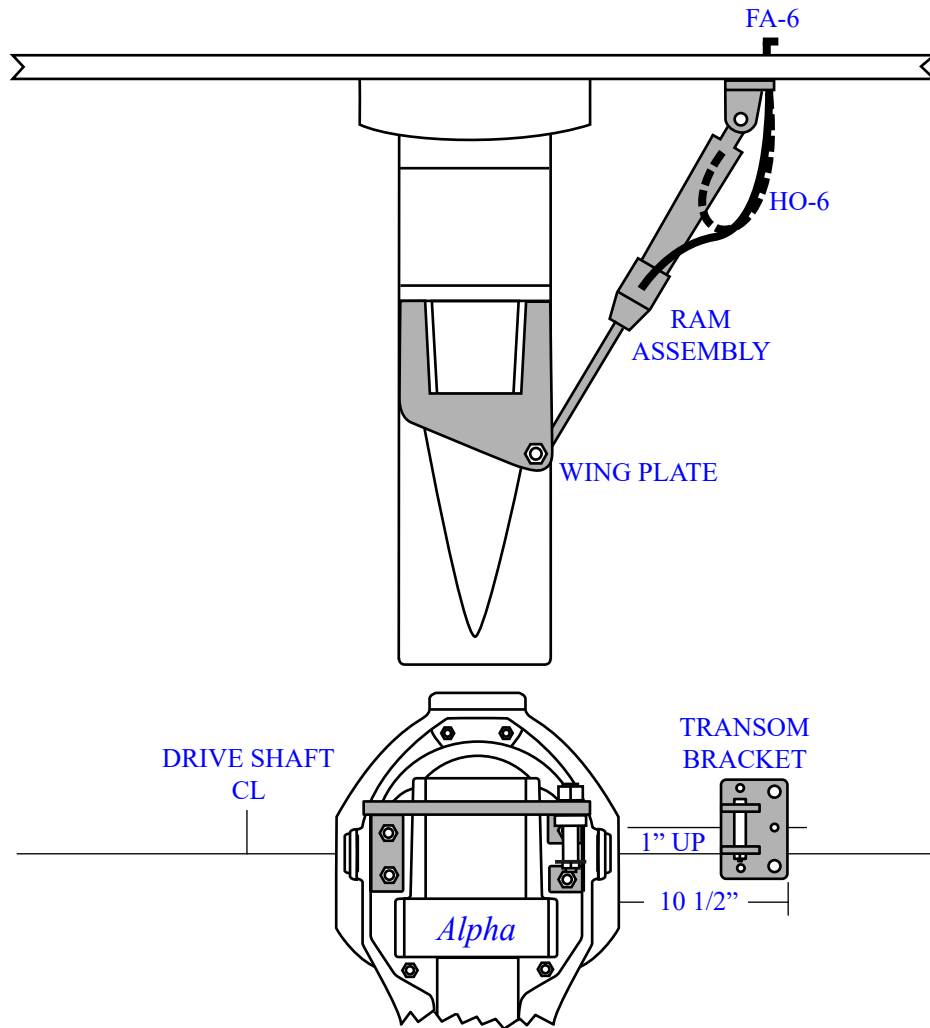
### PARTS

ADAPTERS  
BRAZIL MANIFOLD  
BULKHEAD TUBES  
CLEVIS' CLEVIS BUSHINGS  
DRIVE SHOWERS  
DRIVE SPACERS  
ELECTRIC PUMP  
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HARDWARE (NUTS, STUDS, PINS)  
HELM POST PARTS  
HELM POST, HELM CONTROLS  
HOSE, HOSE ENDS, HOSE ASSEMBLIES  
OIL FILTERS  
OIL TANKS, PUMP CAP  
RAMS  
RAM PARTS  
STER CAPS BRAVO  
TIE BARS W/CLEVIS, PINS, STUDS  
TIE BARS & WING PLATES  
TIE BARS TRIPLE BRAVO  
TRANSOM BRACKETS  
WING PLATES, ALPHA, EVINRUDE, TRS WING  
PLATES, MERC OUTBOARD  
VALVES, 2 HELM, 2 PUMP

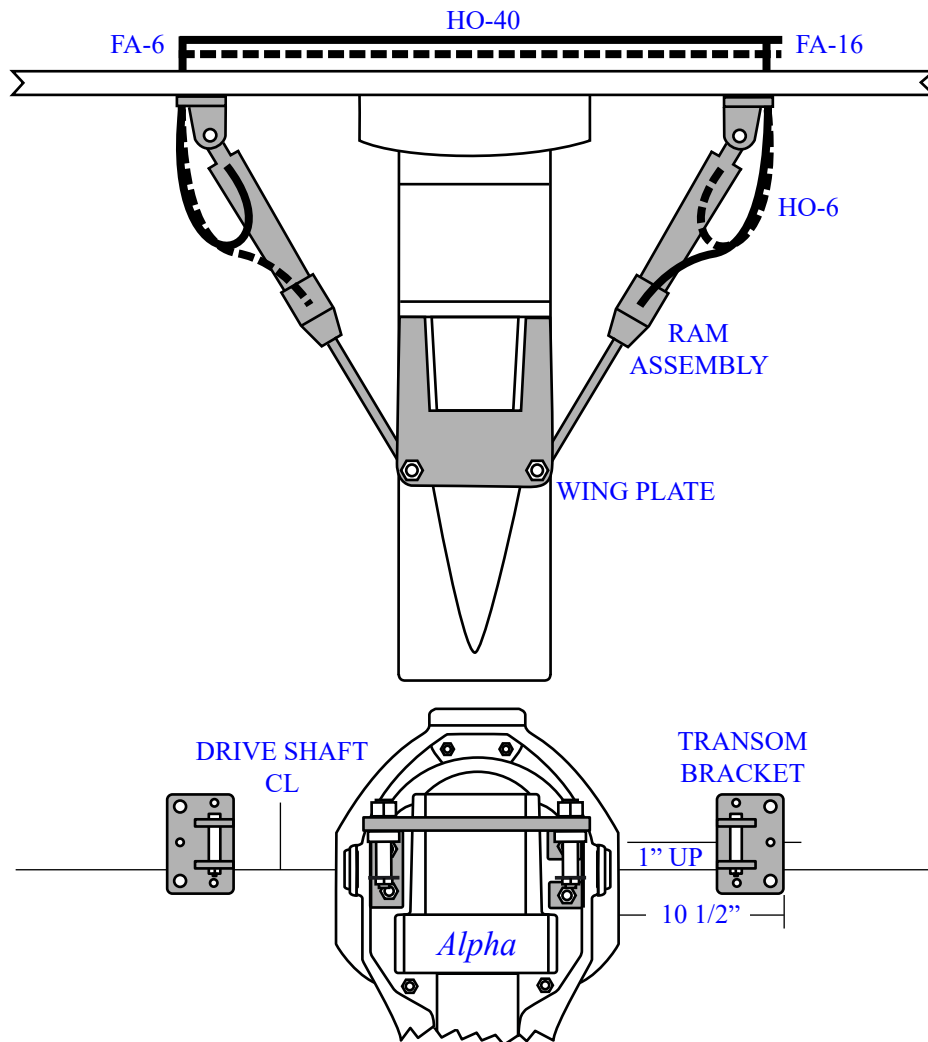
### INFORMATION

DRIVE SHOWERS  
DRIVE SPACERS  
ELECTRIC PUMP  
FIELD ATTACH HOSE  
FILLING AND PURGING  
HELM POST  
LOCK TO LOCK IMCO RAMS  
LOCK TO LOCK STERN DRIVES  
MERC BRAZIL VALVE  
MERC SAGINAW VALVE  
OUTBOARD  
STER CAPS BRAVO  
TRANSOM BRACKET MOUNTING  
LOCATIONS TRANSOM HARDWARE  
WING PLATES ALPHA  
WING PLATES TRS  
X-BOX

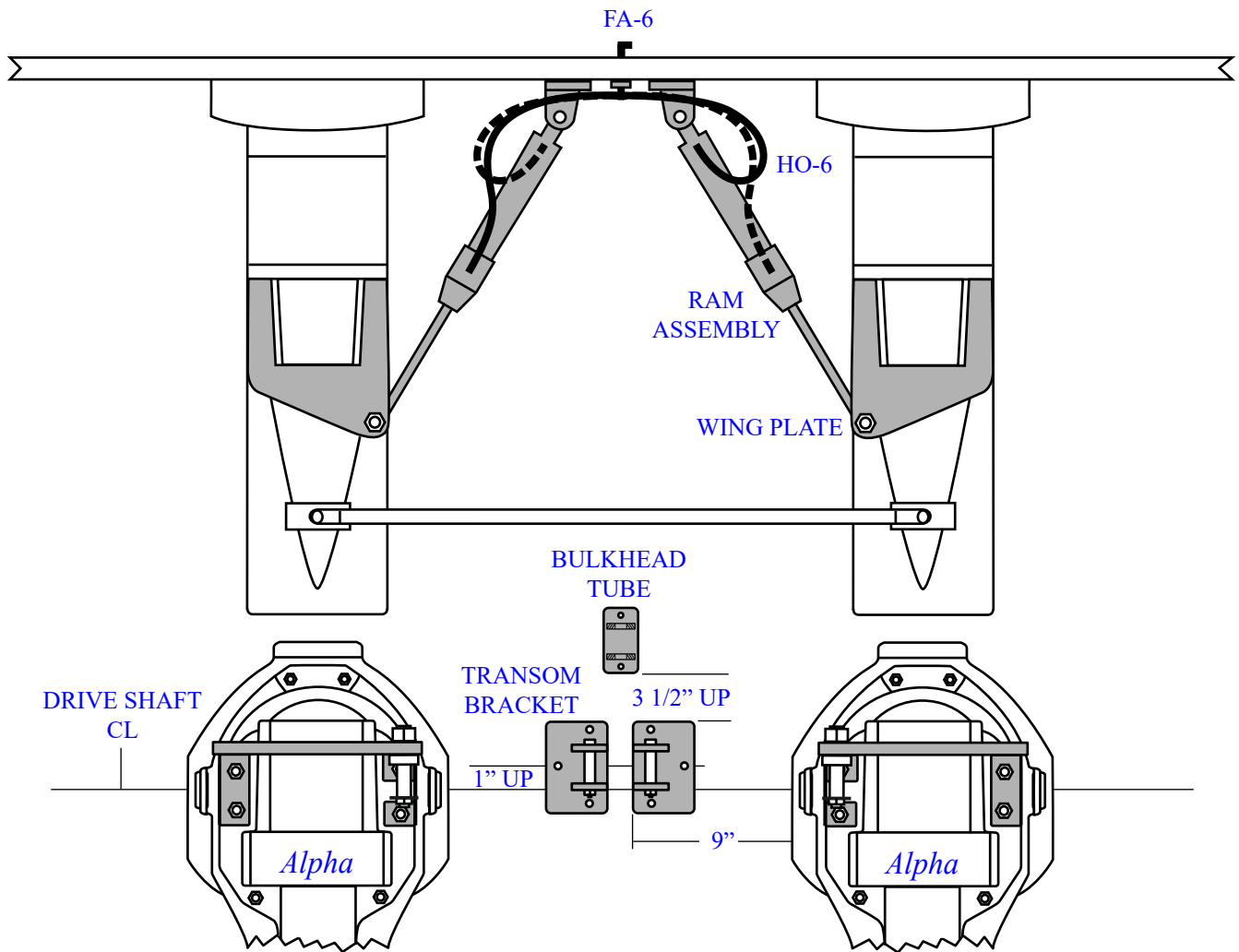
QTY	P/N	KIT
1	SA-26	STER KIT MERC ALPHA SINGLE 1 RAM MOUNT 10 1/2"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	WP-14-R	WING PLATE KIT MERC ALPHA RH 1 RAM



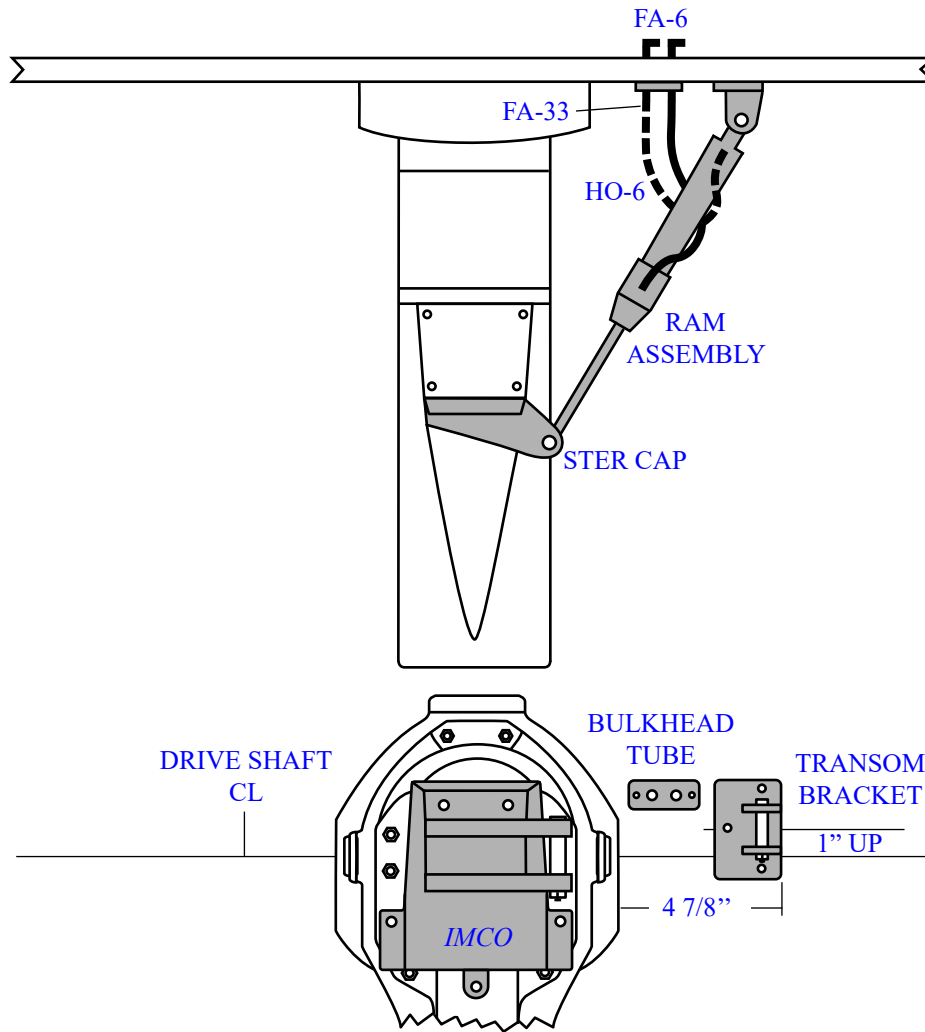
QTY	P/N	KIT
1	SA-25	STER KIT MERC ALPHA SINGLE 2 RAMS MOUNT 10 1/2"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	FA-16	ADAPTER -6 JIC SWIVEL T SS
2	HO-40	HOSE ASSEMBLY HP CRIMP 3/8" X 40" W/-6 JIC SS HOSE ENDS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-31	TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	WP-17	WING PLATE KIT MERC ALPHA 2 RAMS



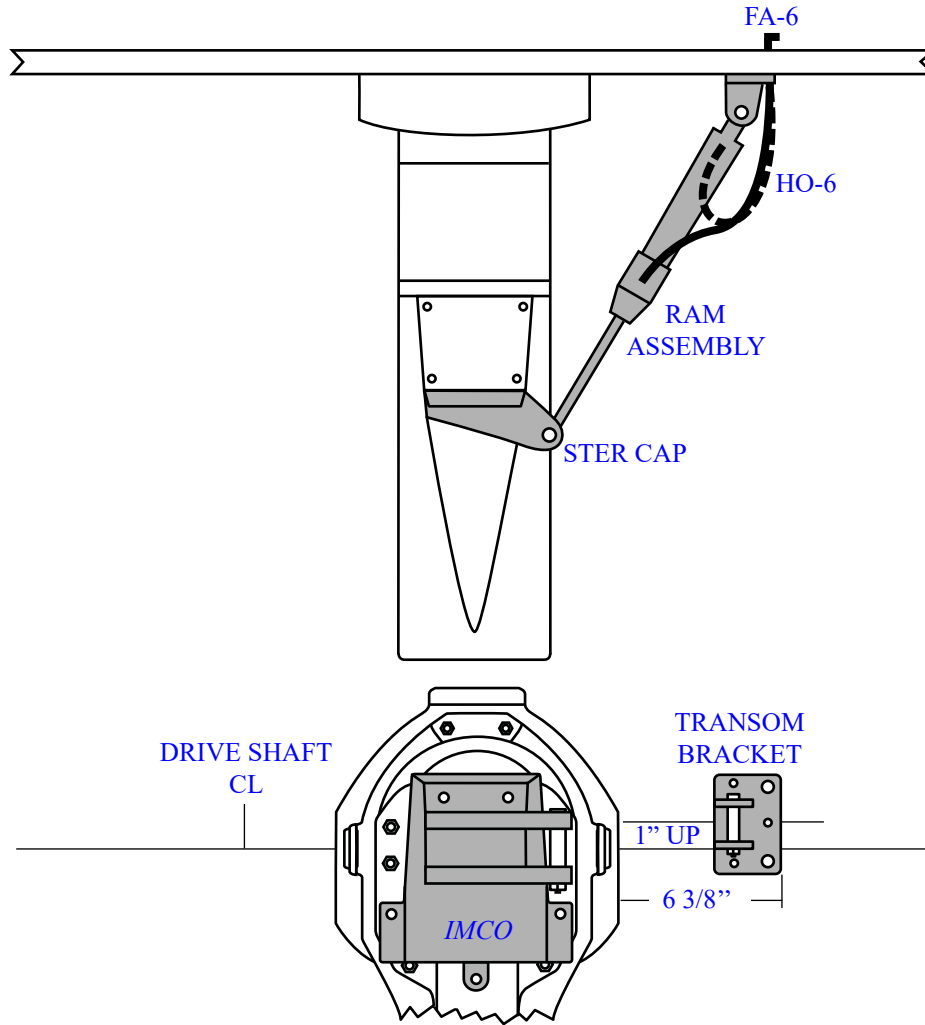
QTY	P/N	KIT
1	SA-28-R	STER KIT MERC ALPHA TWIN BETWEEN MOUNT 9"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-3	BULKHEAD TUBE ASSEMBLY -6 JIC T
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-32	TRANSOM BRACKET KIT LH REVERSE
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	WP-14-L	WING PLATE KIT MERC ALPHA LH 1 RAM
1	WP-14-R	WING PLATE KIT MERC ALPHA RH 1 RAM



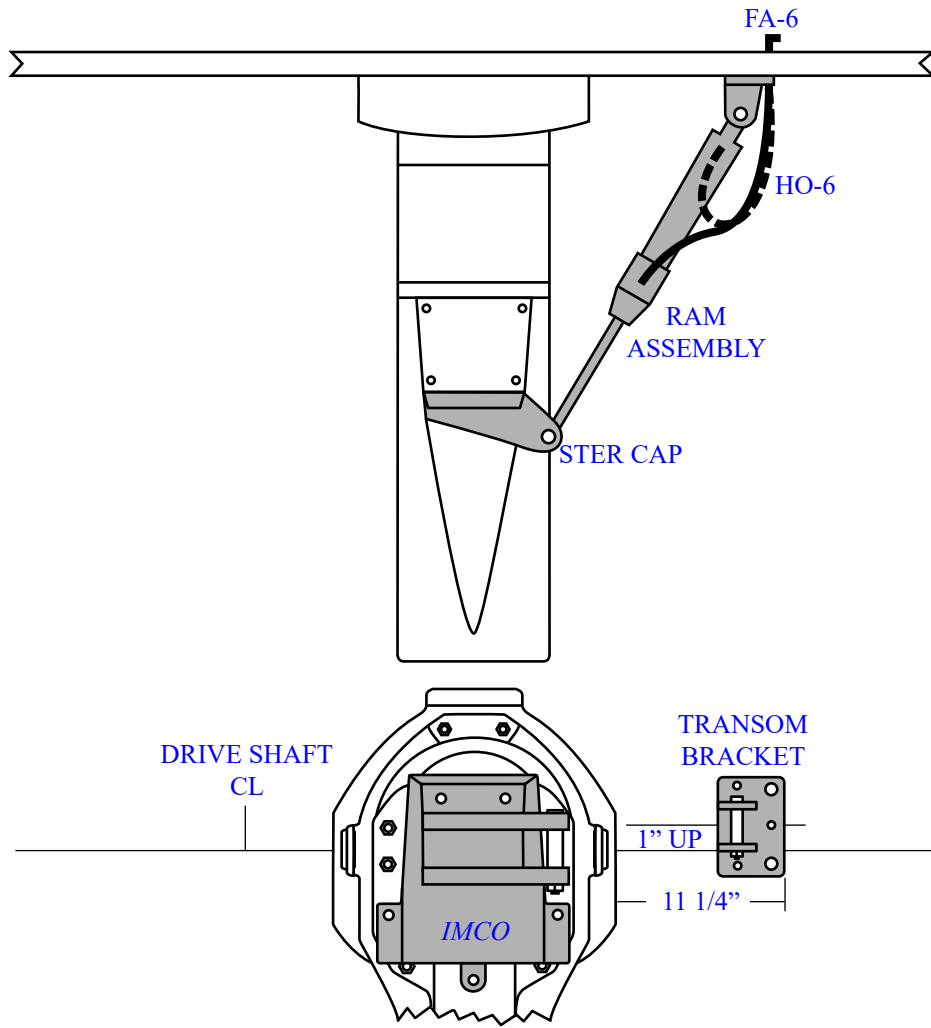
QTY	P/N	KIT
1	SA-30-R	STER KIT MERC BRAVO SINGLE 1 RAM MOUNT 4 7/8"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	FA-33	ADAPTER -6 JIC SWIVEL 45° SS
1	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
1	SR-6-5-12	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 15 9/16" OPEN 21 7/8")
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	AEC-8	STER CAP KIT MERC BRAVO 2 EAR RH 3 1/4" CLEVIS PIN OFFSET



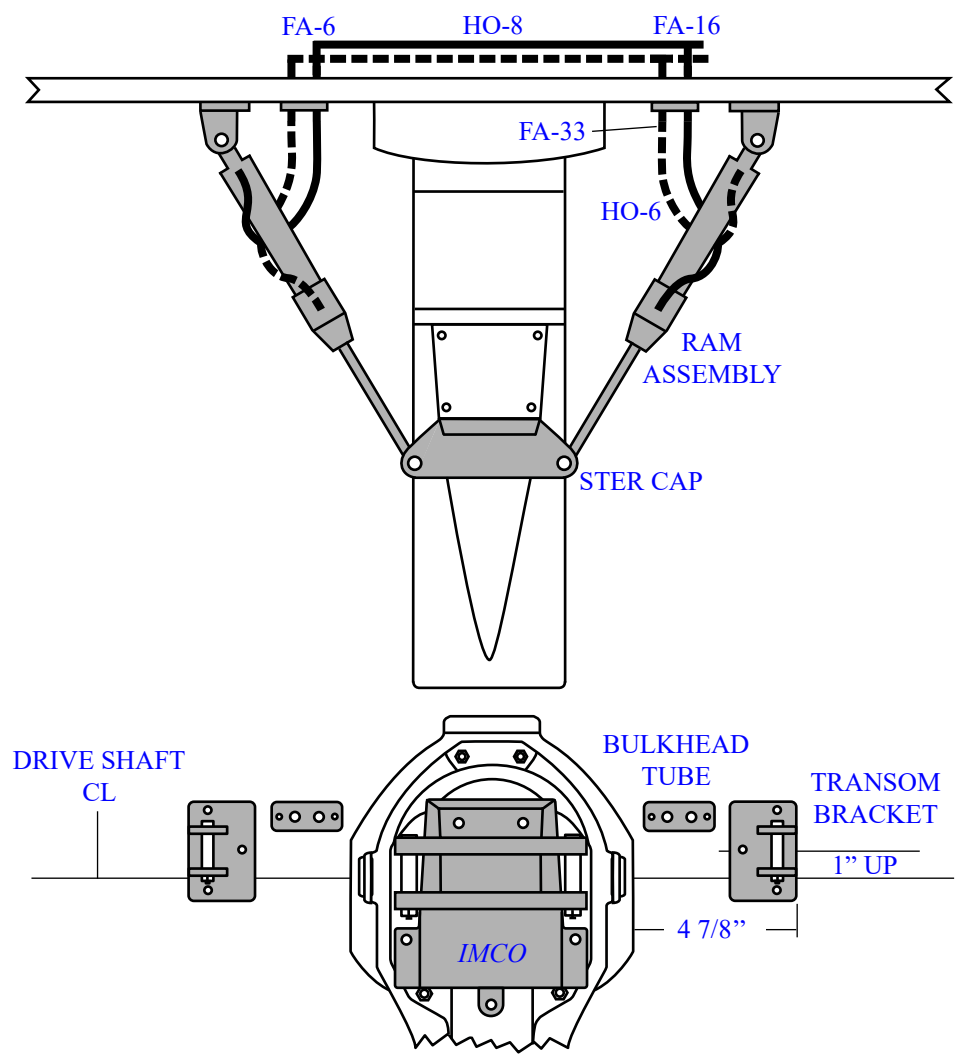
QTY	P/N	KIT
1	SA-30	STER KIT MERC BRAVO SINGLE 1 RAM MOUNT 6 3/8"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
1	SR-6-5-12	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 15 9/16" OPEN 21 7/8")
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	AEC-8	STER CAP KIT MERC BRAVO 2 EAR RH 3 1/4" CLEVIS PIN OFFSET



QTY	P/N	KIT
1	SA-1	STER KIT MERC BRAVO SINGLE 1 RAM MOUNT 11 1/4"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	AEC-1	STER CAP KIT MERC BRAVO 2 EAR RH 1 5/8" CLEVIS PIN OFFSET

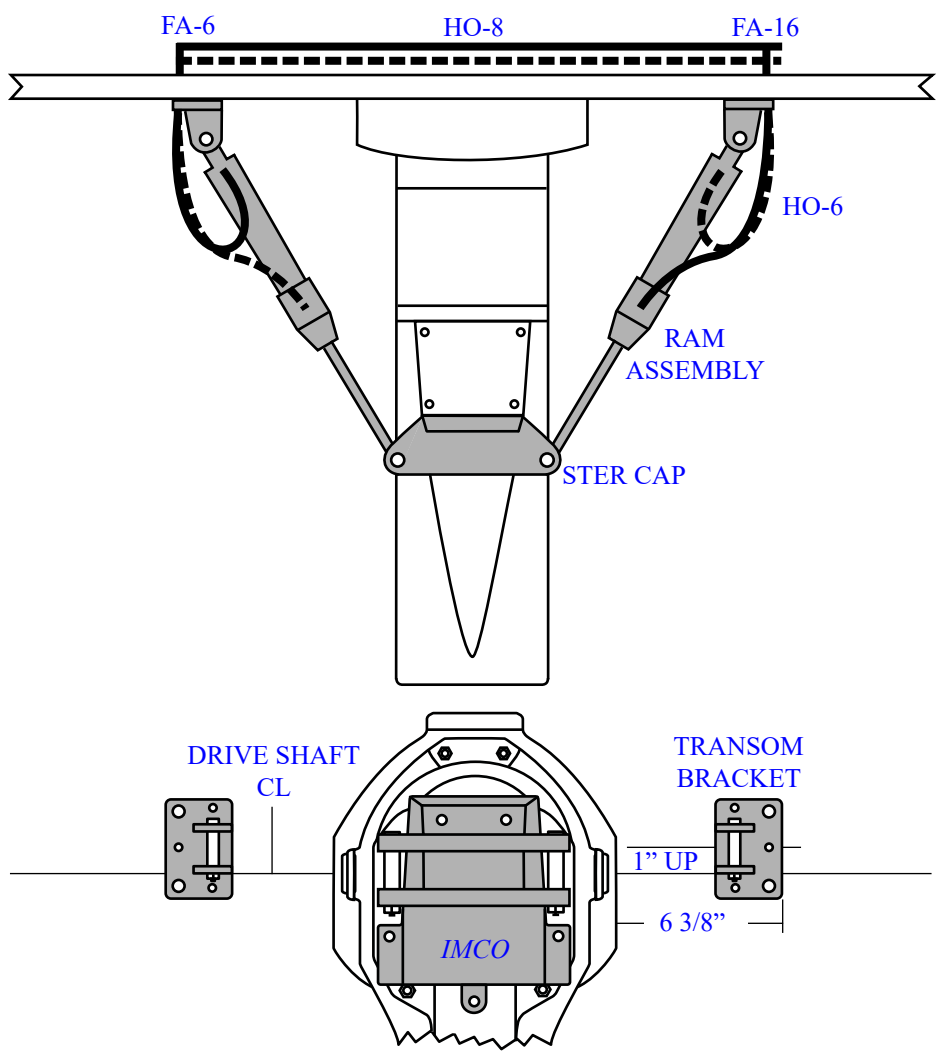


QTY	P/N	KIT
1	SA-20-R	STER KIT MERC BRAVO SINGLE 2 RAMS MOUNT 4 7/8"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	FA-16	ADAPTER -6 JIC SWIVEL T SS
4	FA-33	ADAPTER -6 JIC SWIVEL 45° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	HO-8	HOSE ASSEMBLY HP CRIMP 3/8" X 30" W/-6 JIC SS HOSE ENDS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-6-1-12	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 15 9/16" OPEN 21 7/8")
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	TB-32	TRANSOM BRACKET KIT LH REVERSE
1	AEC-7	STER CAP KIT MERC BRAVO 2 EAR 3 1/4" CLEVIS PIN OFFSET

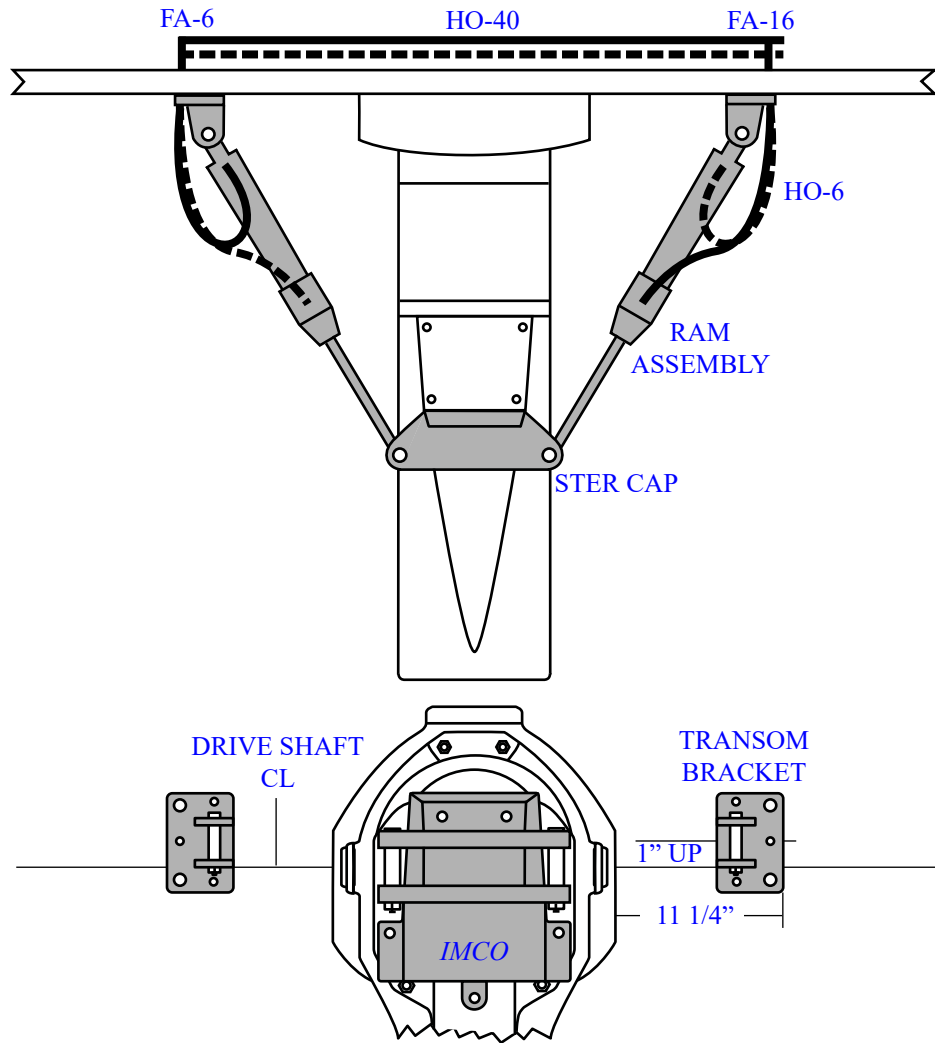




QTY	P/N	KIT
1	SA-20	STER KIT MERC BRAVO SINGLE 2 RAMS MOUNT 6 3/8"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	FA-16	ADAPTER -6 JIC SWIVEL T SS
2	HO-8	HOSE ASSEMBLY HP CRIMP 3/8" X 30" W/-6 JIC SS HOSE ENDS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-6-1-12	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 15 9/16" OPEN 21 7/8")
1	TB-31	TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	AEC-7	STER CAP KIT MERC BRAVO 2 EAR 3 1/4" CLEVIS PIN OFFSET

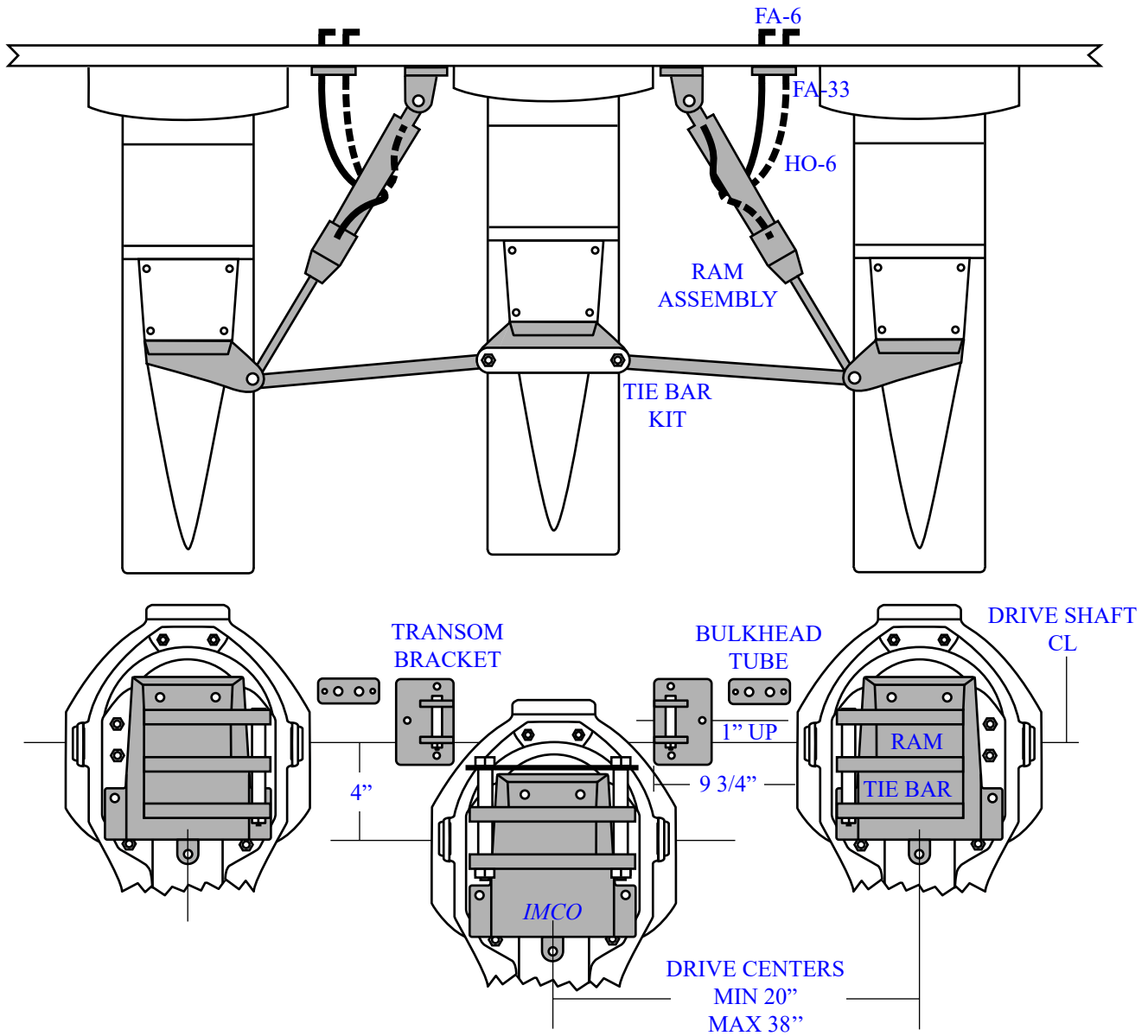


QTY	P/N	KIT
1	SA-2	STER KIT MERC BRAVO SINGLE 2 RAMS MOUNT 11 1/4"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	FA-16	ADAPTER -6 JIC SWIVEL T SS
2	HO-40	HOSE ASSEMBLY HP CRIMP 3/8" X 40" W/-6 JIC SS HOSE ENDS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-31	TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	AEC-5	STER CAP KIT MERC BRAVO 2 EAR 1 5/8" CLEVIS PIN OFFSET



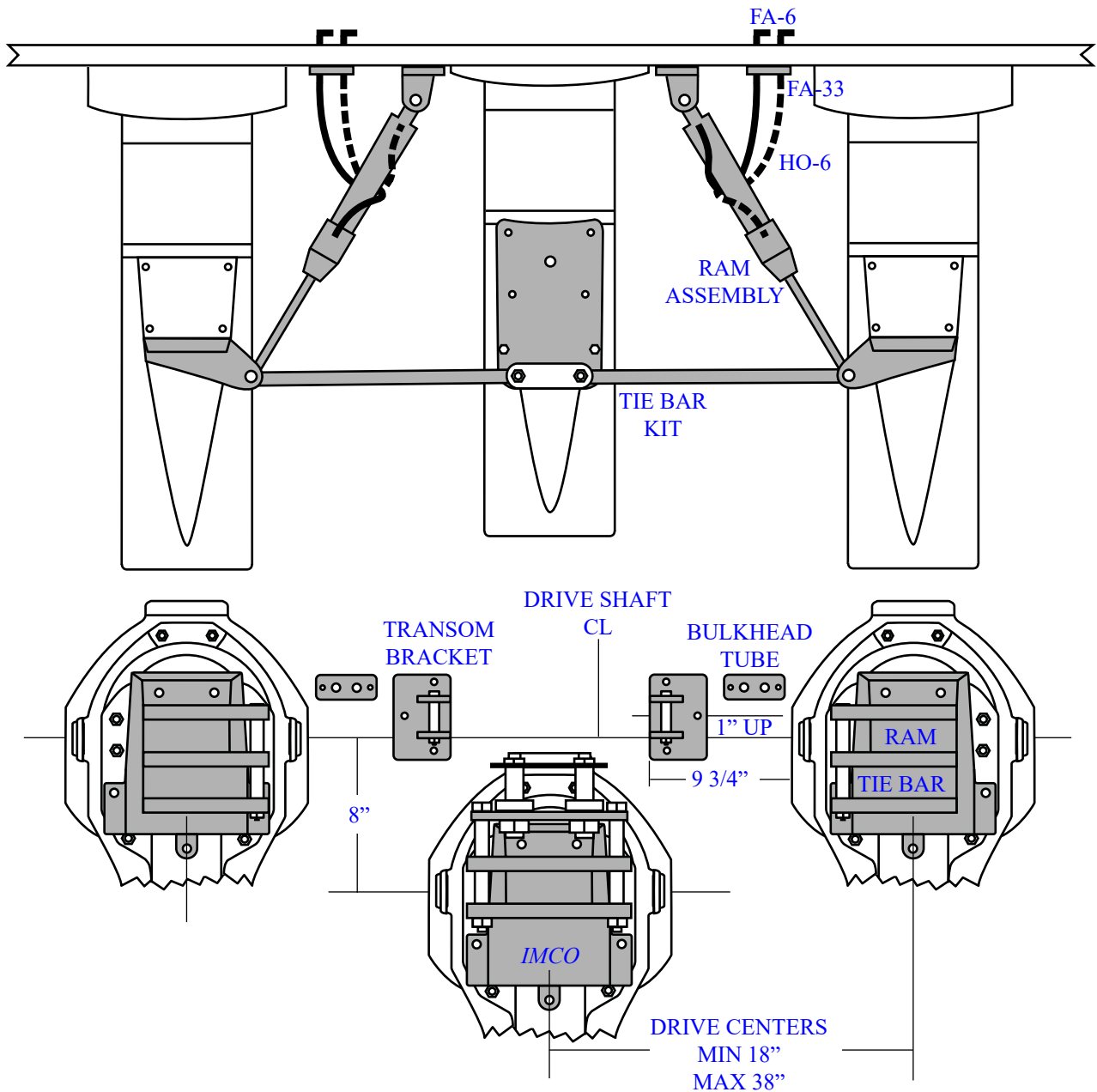
QTY	P/N	KIT
1	SA-15-4	STER KIT MERC BRAVO TRIPLE 4" CENTER DROP
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
4	FA-33	ADAPTER -6 JIC SWIVEL 45° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-32	TRANSOM BRACKET KIT LH REVERSE
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	TB-77	TIE BAR KIT FOR MERC BRAVO DRIVES 4" OF DROP TO CENTER DRIVE

NOTE: TIE BARS ARE LEVEL AT 4" OF DROP TO THE CENTER DRIVE



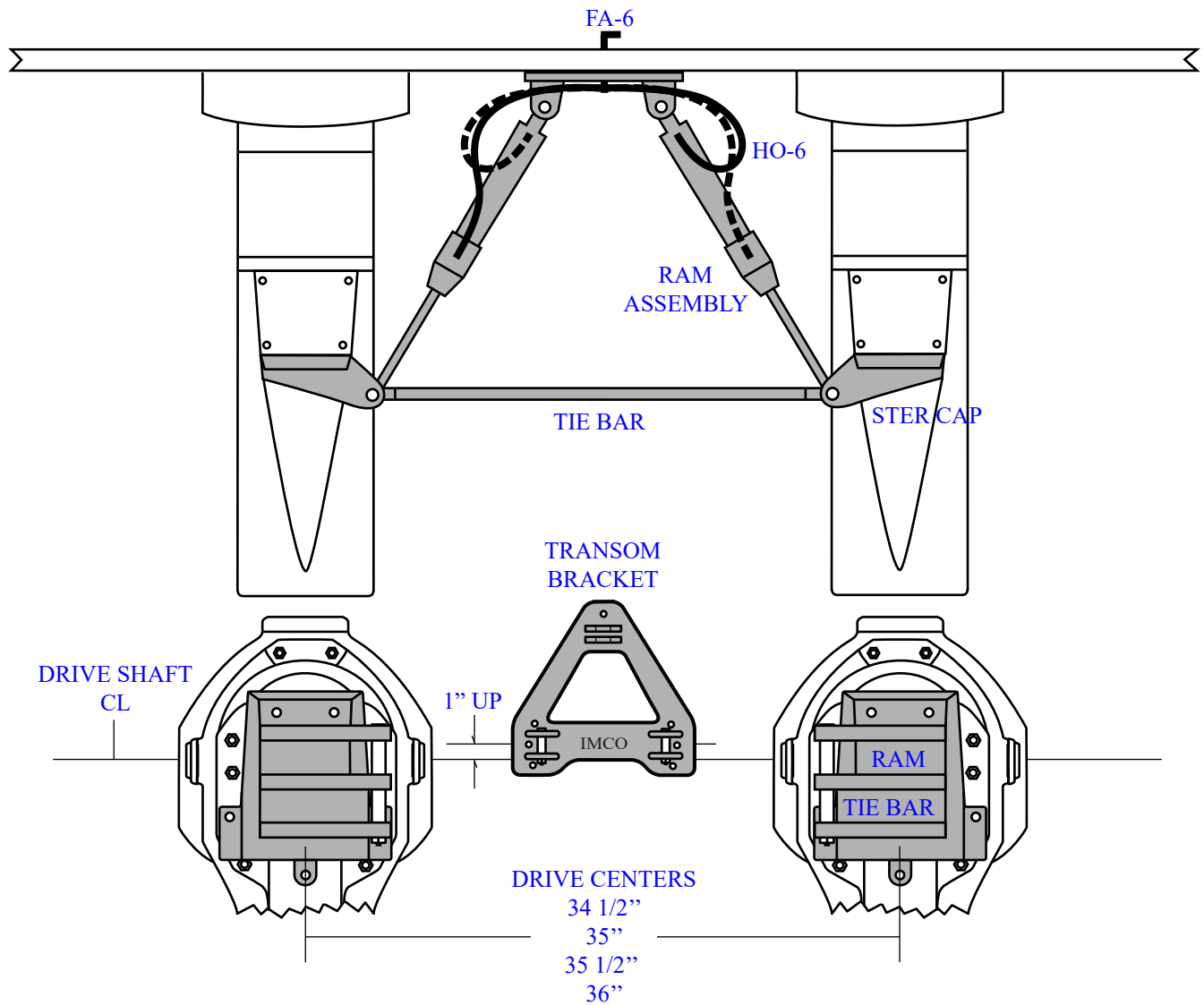
QTY	P/N	KIT
1	SA-15-8	STER KIT MERC BRAVO TRIPLE 8" CENTER DROP
PARTS INCLUDED		
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
4	FA-33	ADAPTER -6 JIC SWIVEL 45° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-32	TRANSOM BRACKET KIT LH REVERSE
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	TB-100	TIE BAR KIT FOR MERC BRAVO DRIVES 8" OF DROP TO CENTER DRIVE

NOTE: TIE BARS ARE LEVEL AT 8" OF DROP TO THE CENTER DRIVE

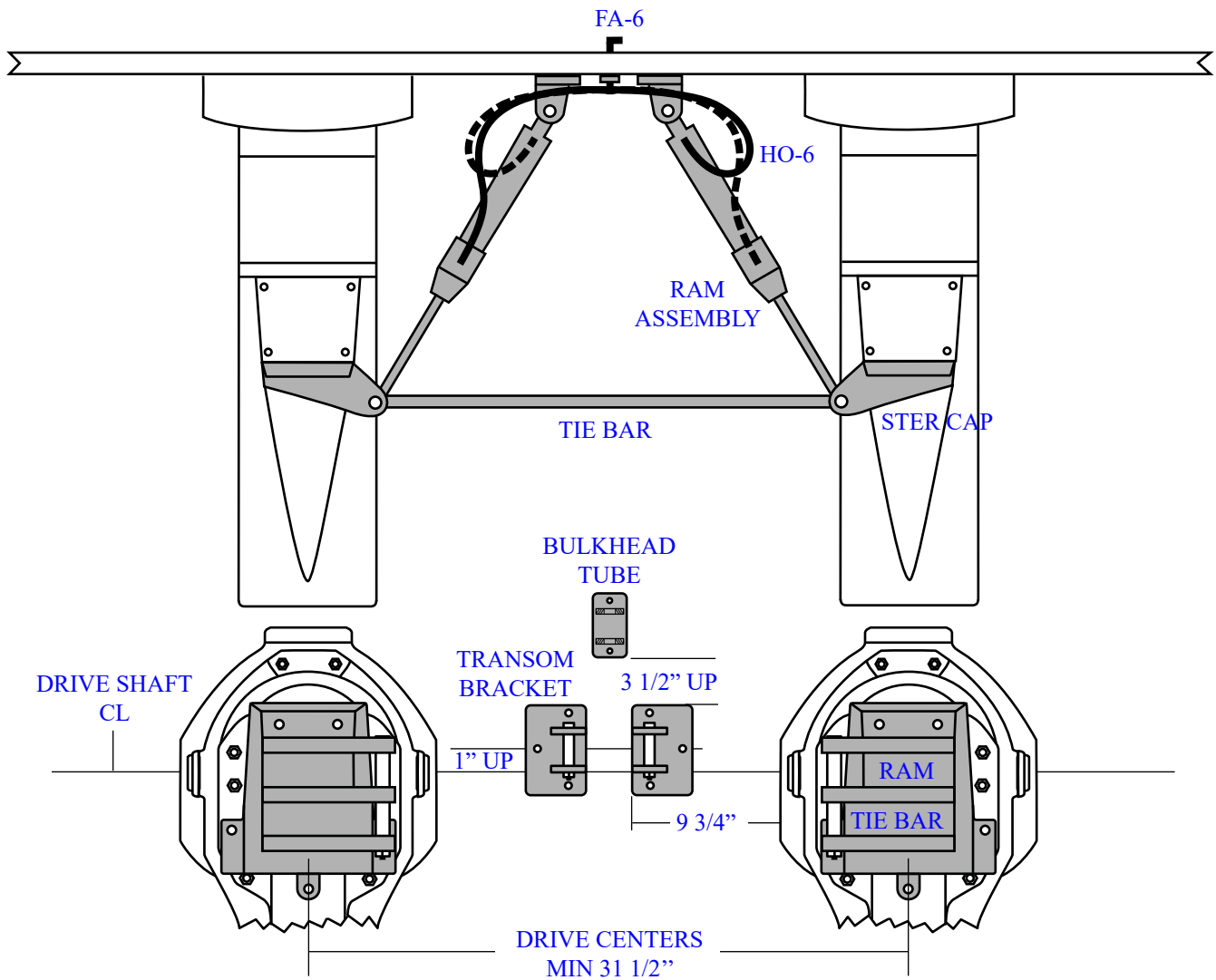




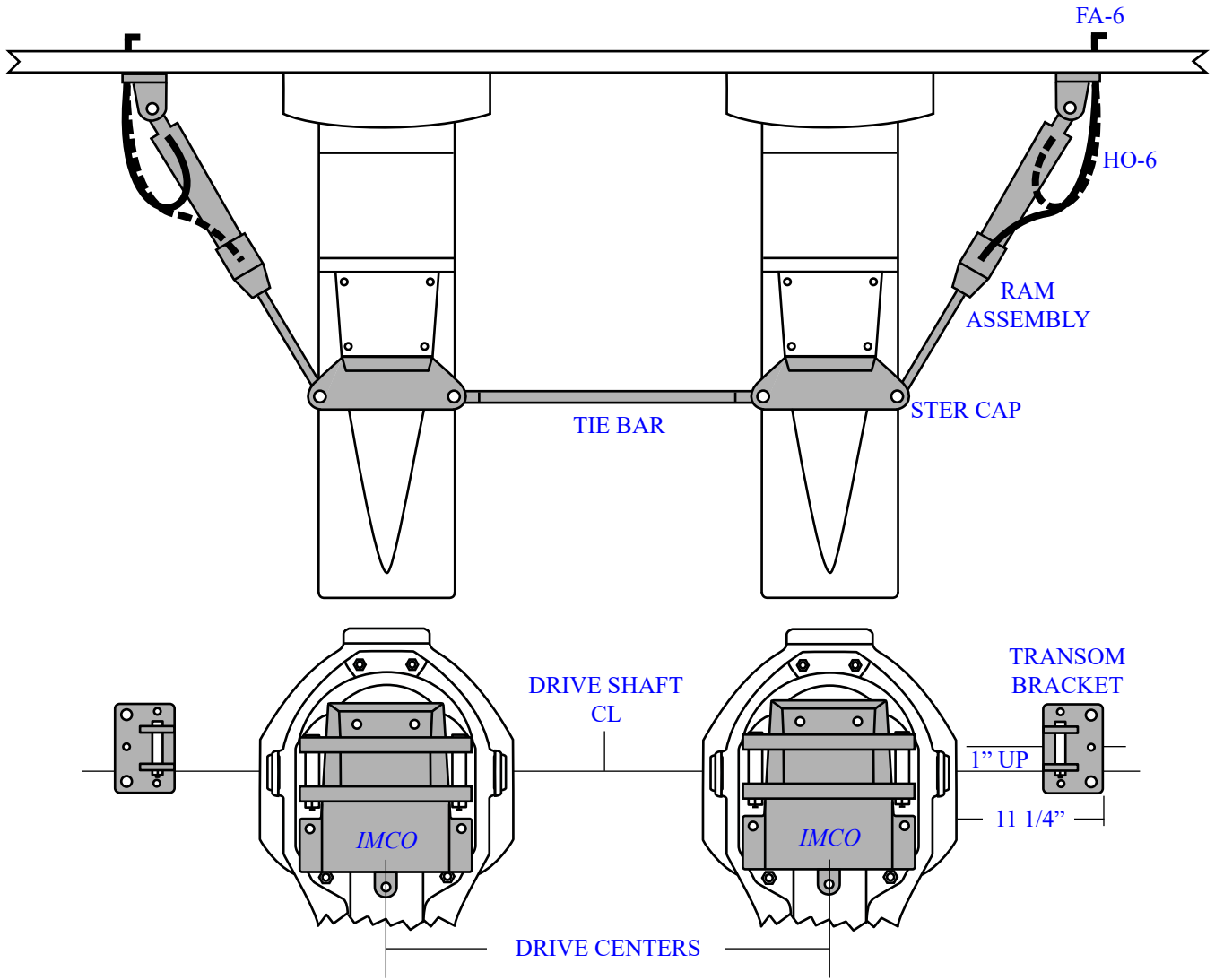
QTY	P/N	KIT
1	SA-345-T	STER KIT MERC BRAVO TWIN 34 1/2" DRIVE CENTERS UNI MOUNT
1	SA-35-T	STER KIT MERC BRAVO TWIN 35" DRIVE CENTERS UNI MOUNT
1	SA-355-T	STER KIT MERC BRAVO TWIN 35 1/2" DRIVE CENTERS UNI MOUNT
1	SA-36-T	STER KIT MERC BRAVO TWIN 36" DRIVE CENTERS UNI MOUNT
<b>PARTS INCLUDED</b>		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TBK	TRANSOM BRACKET KIT
1	AEC-4	STER CAP KIT MERC BRAVO 3 EAR RH 1 5/8" CLEVIS PIN OFFSET
1	AEC-3	STER CAP KIT MERC BRAVO 3 EAR LH 1 5/8" CLEVIS PIN OFFSET
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
<b>ADDITIONAL ITEMS TO COMPLETE THIS KIT</b>		
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS



QTY	P/N	KIT
1	SA-4-R	STER KIT MERC BRAVO TWIN BETWEEN MOUNT 9 3/4"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-3	BULKHEAD TUBE ASSEMBLY -6 JIC T
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-32	TRANSOM BRACKET KIT LH REVERSE
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	AEC-4	STER CAP KIT MERC BRAVO 3 EAR RH 1 5/8" CLEVIS PIN OFFSET
1	AEC-3	STER CAP KIT MERC BRAVO 3 EAR LH 1 5/8" CLEVIS PIN OFFSET
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
ADDITIONAL ITEMS TO COMPLETE THIS KIT		
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS



QTY	P/N	KIT
1	SA-42	STER KIT MERC BRAVO TWIN OUTSIDE MOUNT 11 1/4"
PARTS INCLUDED		
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-31	TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
2	AEC-5	STER CAP KIT MERC BRAVO 2 EAR 1 5/8" CLEVIS PIN OFFSET
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
ADDITIONAL ITEMS TO COMPLETE THIS KIT		
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS

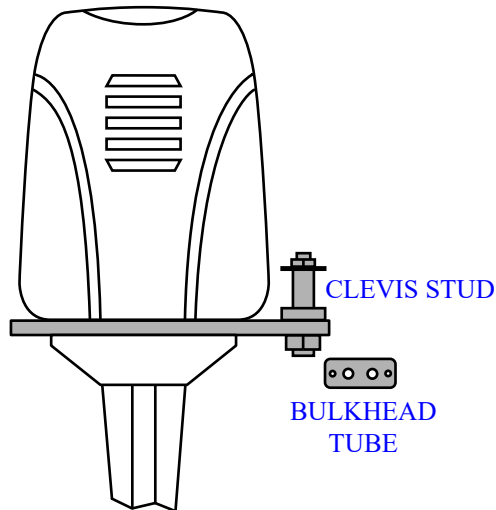
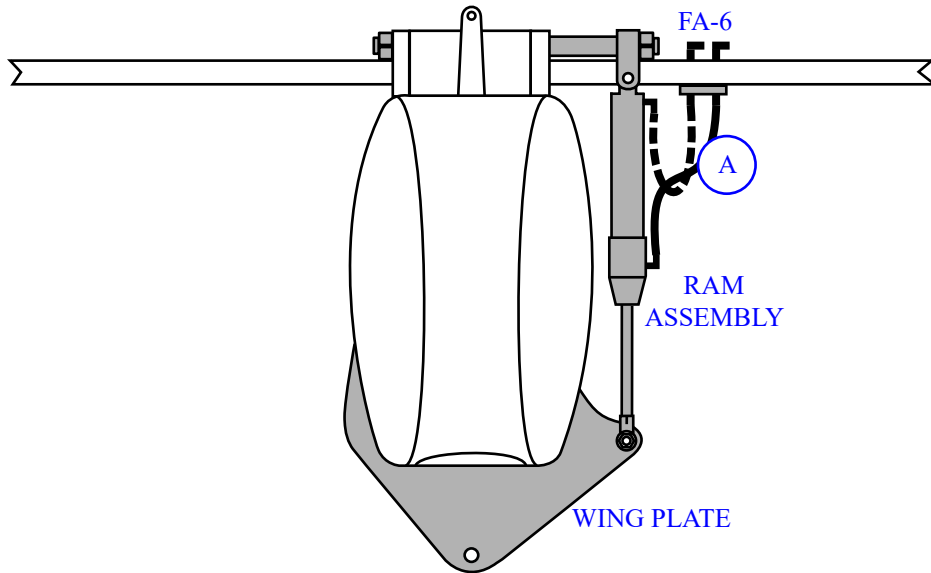




QTY	P/N	KIT
1	SA-71	STER KIT MERC 2.5 EFI
		PARTS INCLUDED
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	WP-9-LR	WING PLATE KIT MERC 2.5L/EFI, 1 RAM 1 TIE BAR
1	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
4	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)

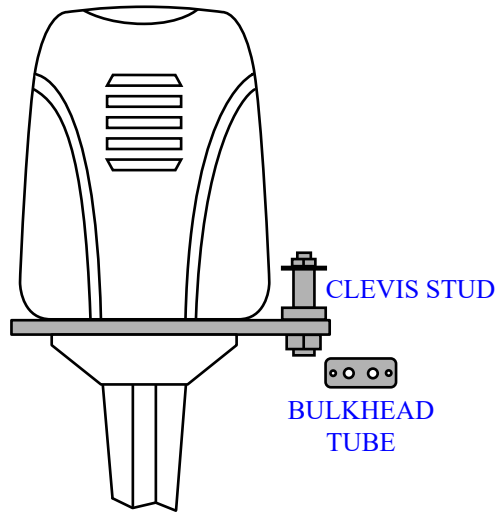
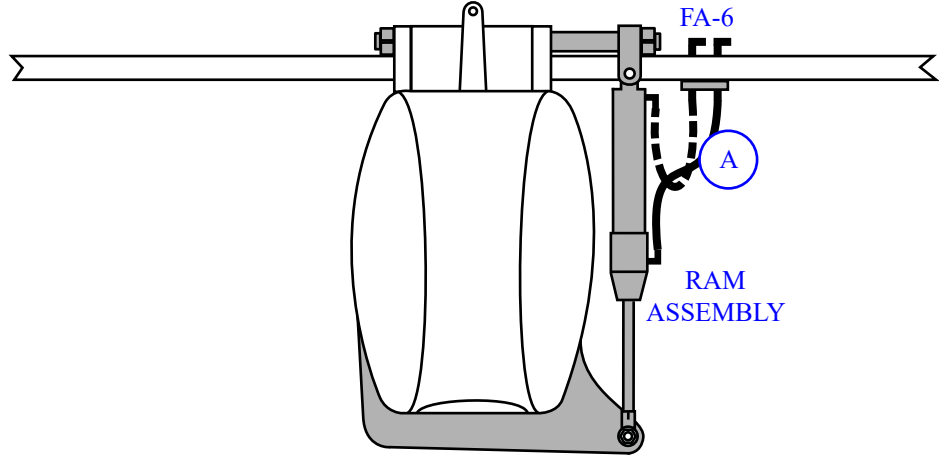
NOTE: WHEN ORDERING FOR A SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-5-15

QTY	P/N	HOSE	LENGTH
2	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-82	STER KIT EVINRUDE E-TEC 250 HO
		PARTS INCLUDED
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	WP-25-LR	WING PLATE KIT EVINRUDE V6 E-TEC 250 HO, 1 RAM
1	TP-8	TILT PIN ASSEMBLY EVINRUDE V6 1992 & LATER
4	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)

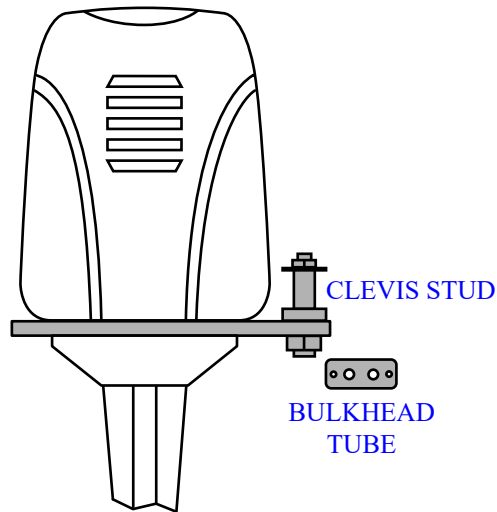
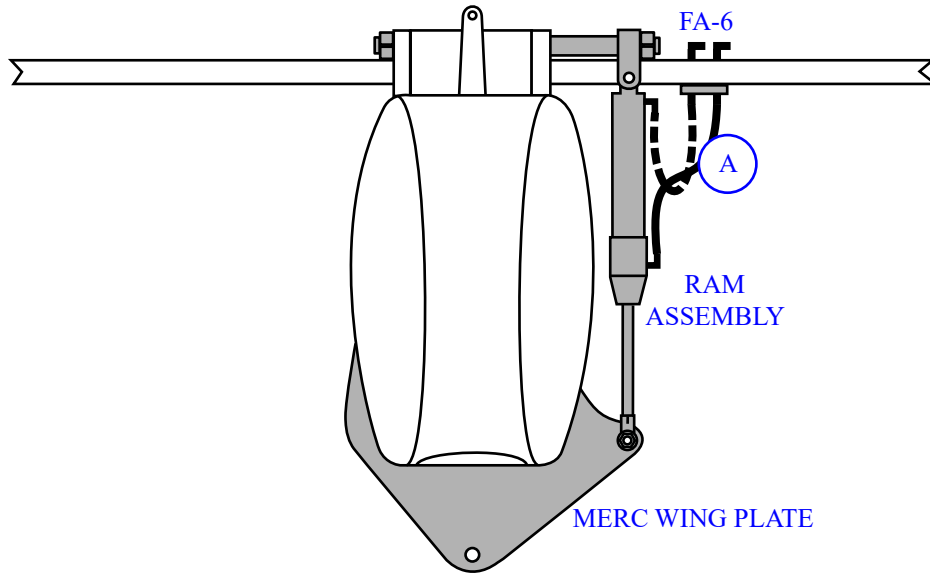
QTY	P/N	HOSE	LENGTH
2	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-72	STER KIT MERC 300R
		PARTS INCLUDED
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
1	SR-8-5-14	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 18 1/8" OPEN 26 3/8")
1	MP-13	CLEVIS STUD ASSEMBLY 3/4"
1	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
4	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____	" HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)

NOTE: MERCURY PROVIDED WING PLATE

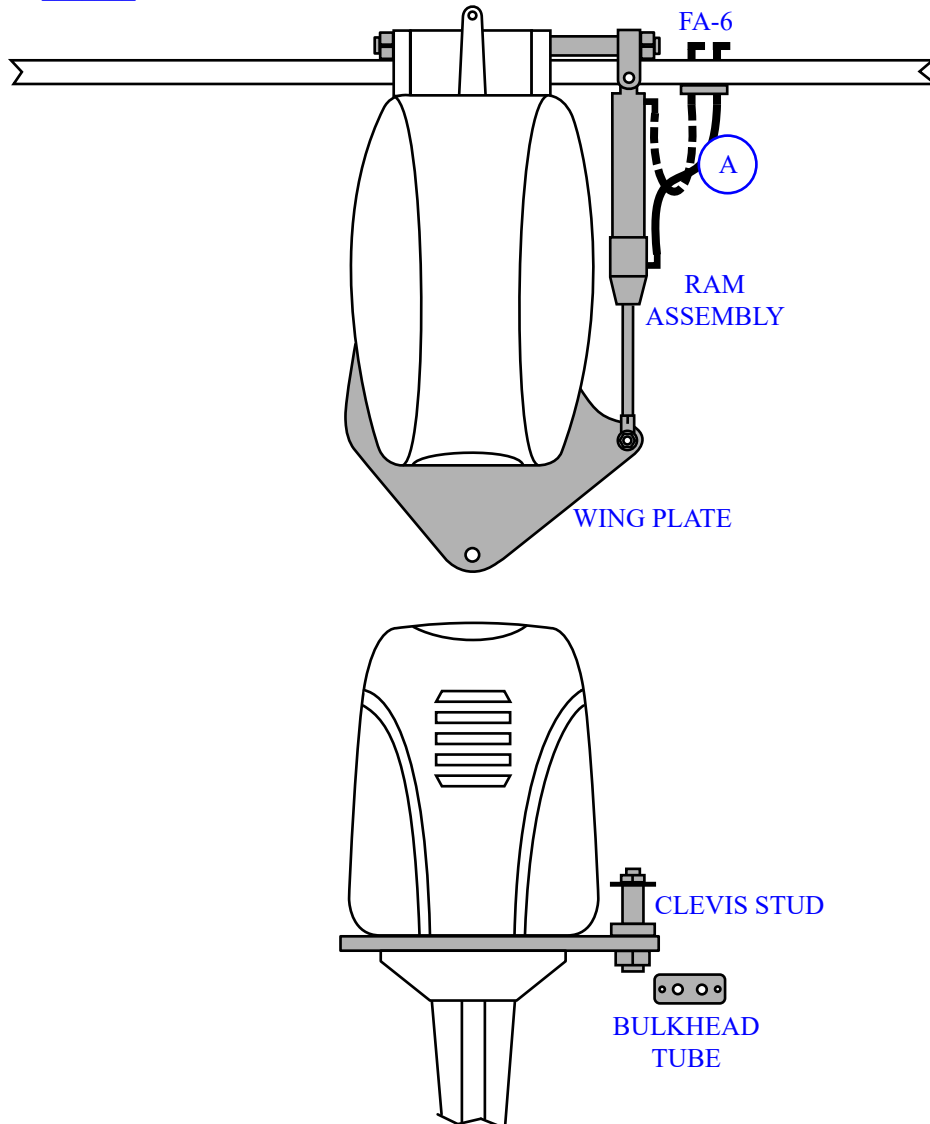
QTY	P/N	HOSE	LENGTH
2	HO-13	A	_____"



QTY	P/N	KIT
1	SA-73	STER KIT MERC PROMAX 3L/300 X
		PARTS INCLUDED
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	WP-11-LR	WING PLATE KIT MERC PROMAX 3L/300 X, 1 RAM 1 TIE BAR
1	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
4	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)

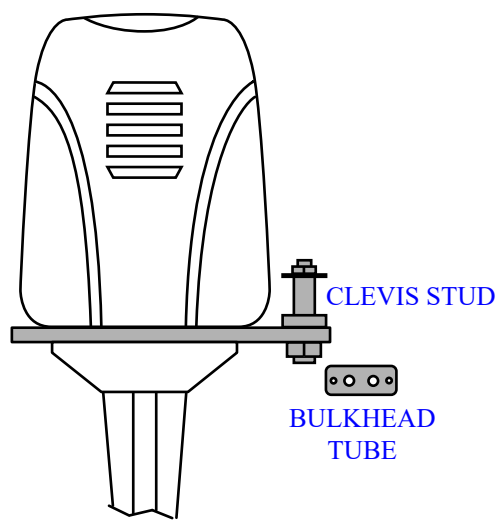
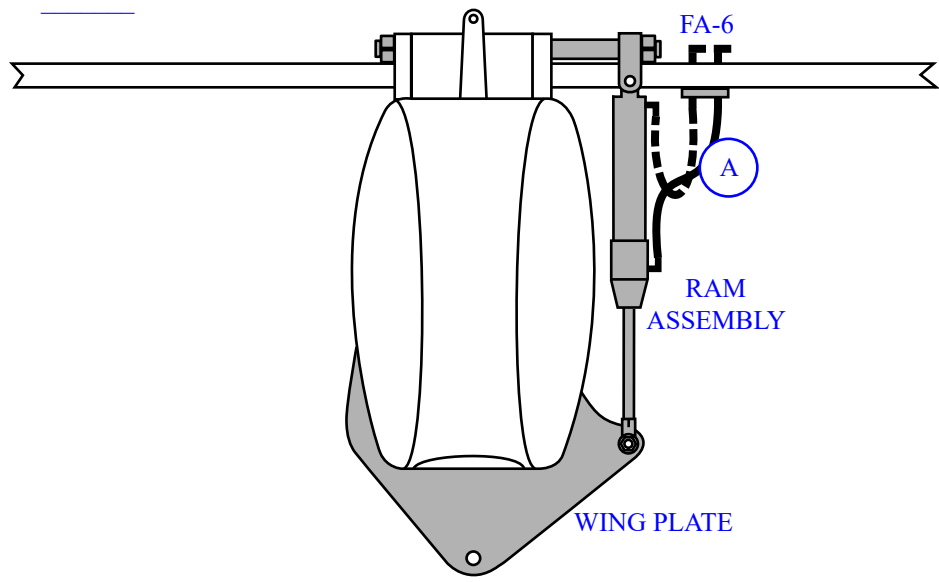
NOTE: WHEN ORDERING FOR A SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-5-15

QTY	P/N	HOSE	LENGTH
2	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-74	STER KIT MERC 200, 225, 250, 300 XS
		PARTS INCLUDED
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	WP-26-LR	WING PLATE KIT MERC 200, 225, 300 XS, 1 RAM 1 TIE BAR
1	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
4	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)

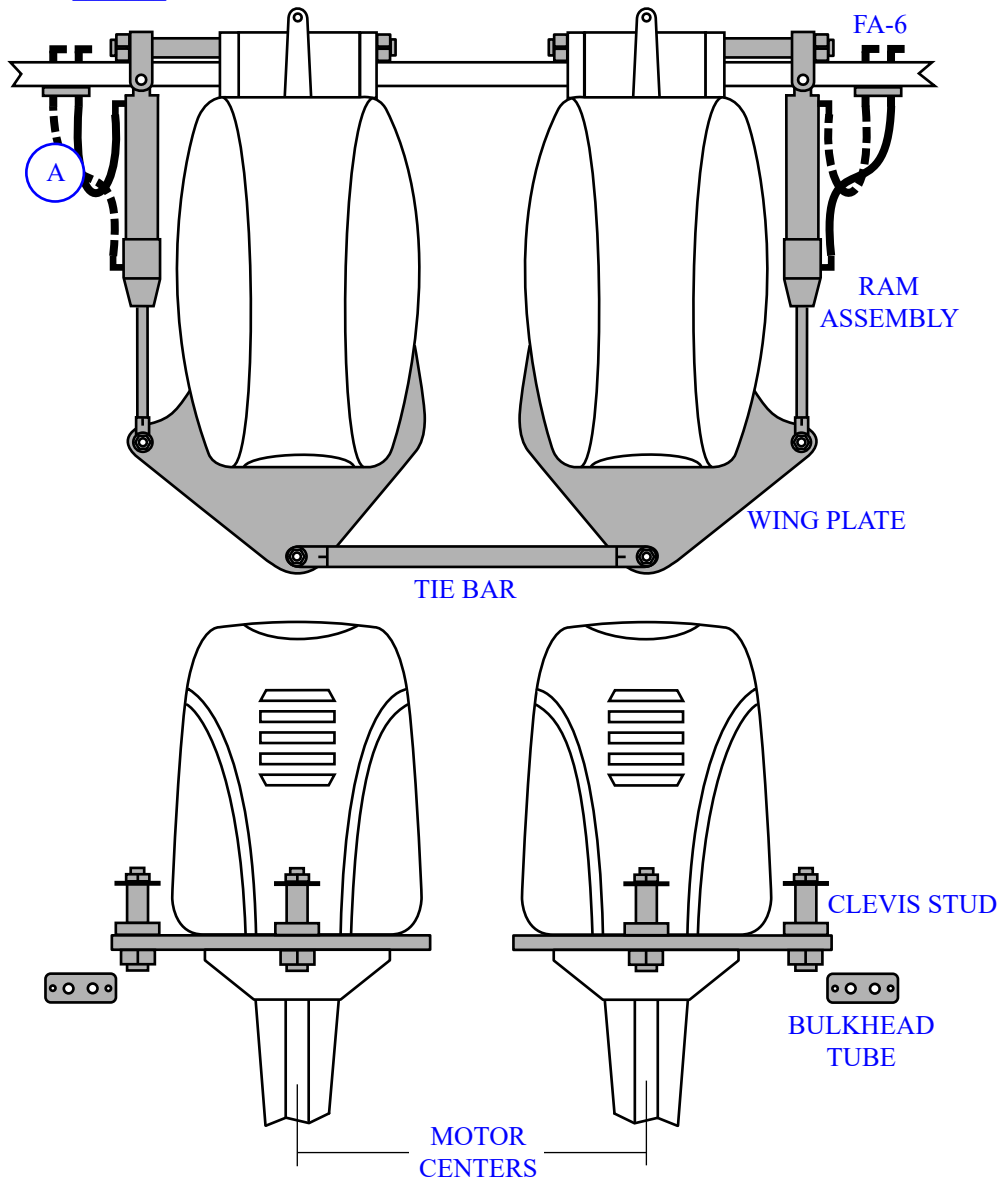
QTY	P/N	HOSE	LENGTH
2	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-91	STER KIT MERC 2.5 EFI
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-9-LR	WING PLATE KIT MERC 2.5L/EFI, 1 RAM 1 TIE BAR
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
		OR
1	TB-27	TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")
TBD	TB-3	TIE BAR PER INCH 1 3/8" SS
2	0229	CLEVIS STUD ASSEMBLY 7/8"

NOTE: WHEN ORDERING FOR A 15" SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-1-15

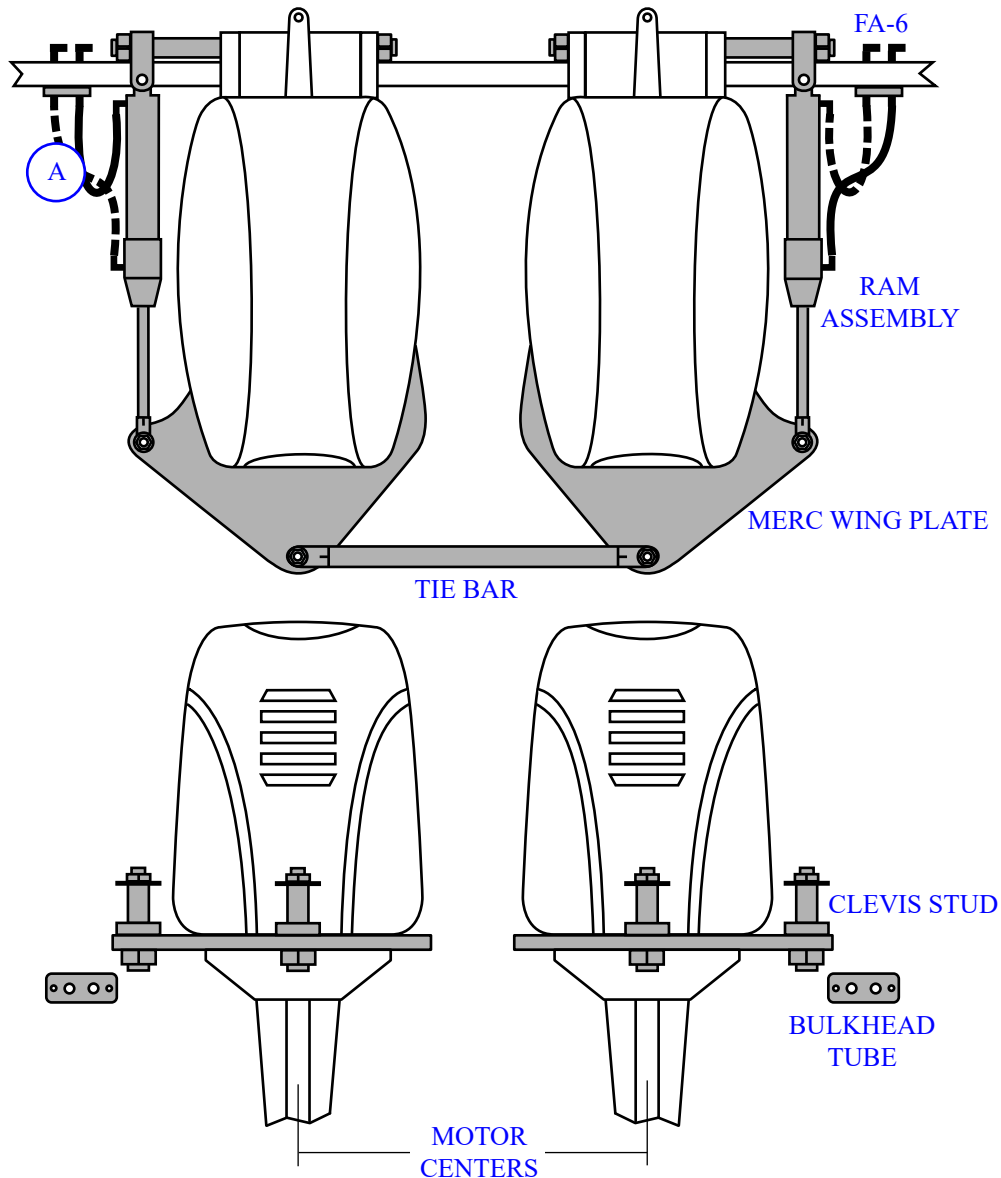
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-75	STER KIT MERC 300R
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-14	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 18 1/8" OPEN 26 3/8")
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
		OR
1	TB-27	TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")
TBD	TB-3	TIE BAR PER INCH 1 3/8" SS
2	0229	CLEVIS STUD ASSEMBLY 7/8"

NOTE: MERCURY PROVIDED WING PLATE

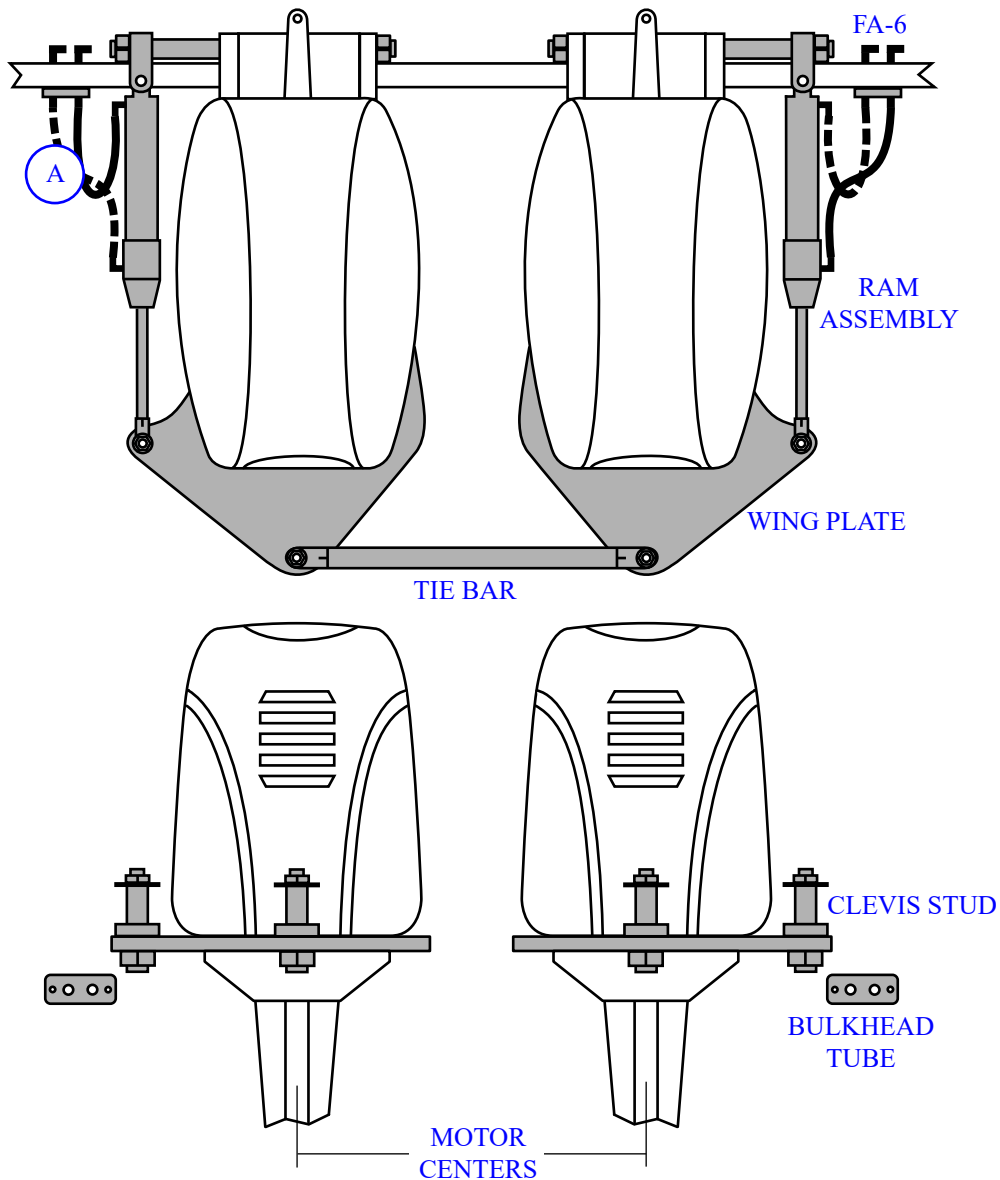
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-93	STER KIT MERC PROMAX 3L/300 X
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-11-LR	WING PLATE KIT MERC PROMAX 3L/300 X, 1 RAM 1 TIE BAR
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
		OR
1	TB-27	TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")
TBD	TB-3	TIE BAR PER INCH 1 3/8" SS
2	0229	CLEVIS STUD ASSEMBLY 7/8"

NOTE: WHEN ORDERING FOR A SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-1-15

QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "

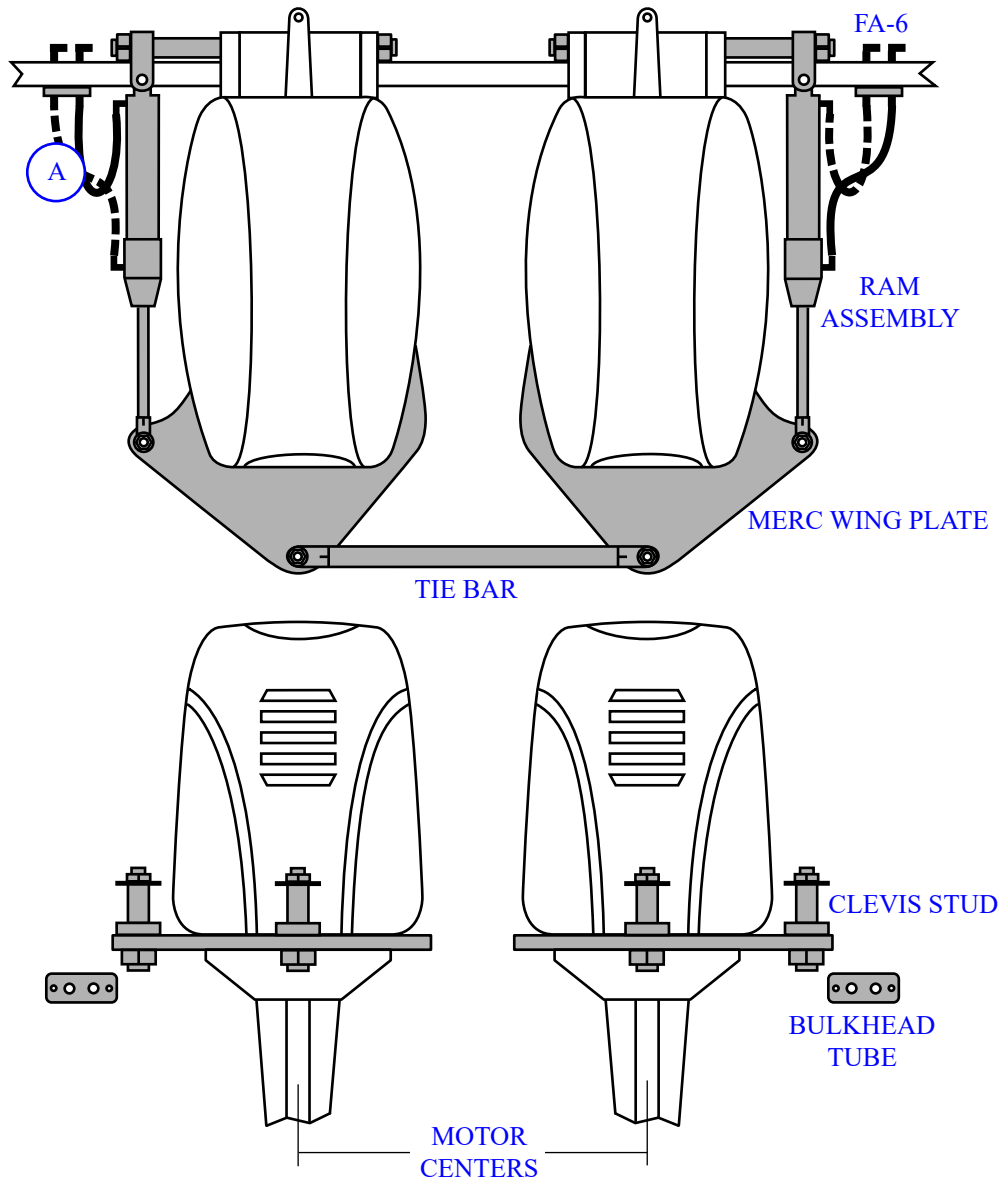




QTY	P/N	KIT
1	SA-75	STER KIT MERC 300R
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-14	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 18 1/8" OPEN 26 3/8")
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
		OR
1	TB-27	TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")
TBD	TB-3	TIE BAR PER INCH 1 3/8" SS
2	0229	CLEVIS STUD ASSEMBLY 7/8"

NOTE: MERCURY PROVIDED WING PLATE

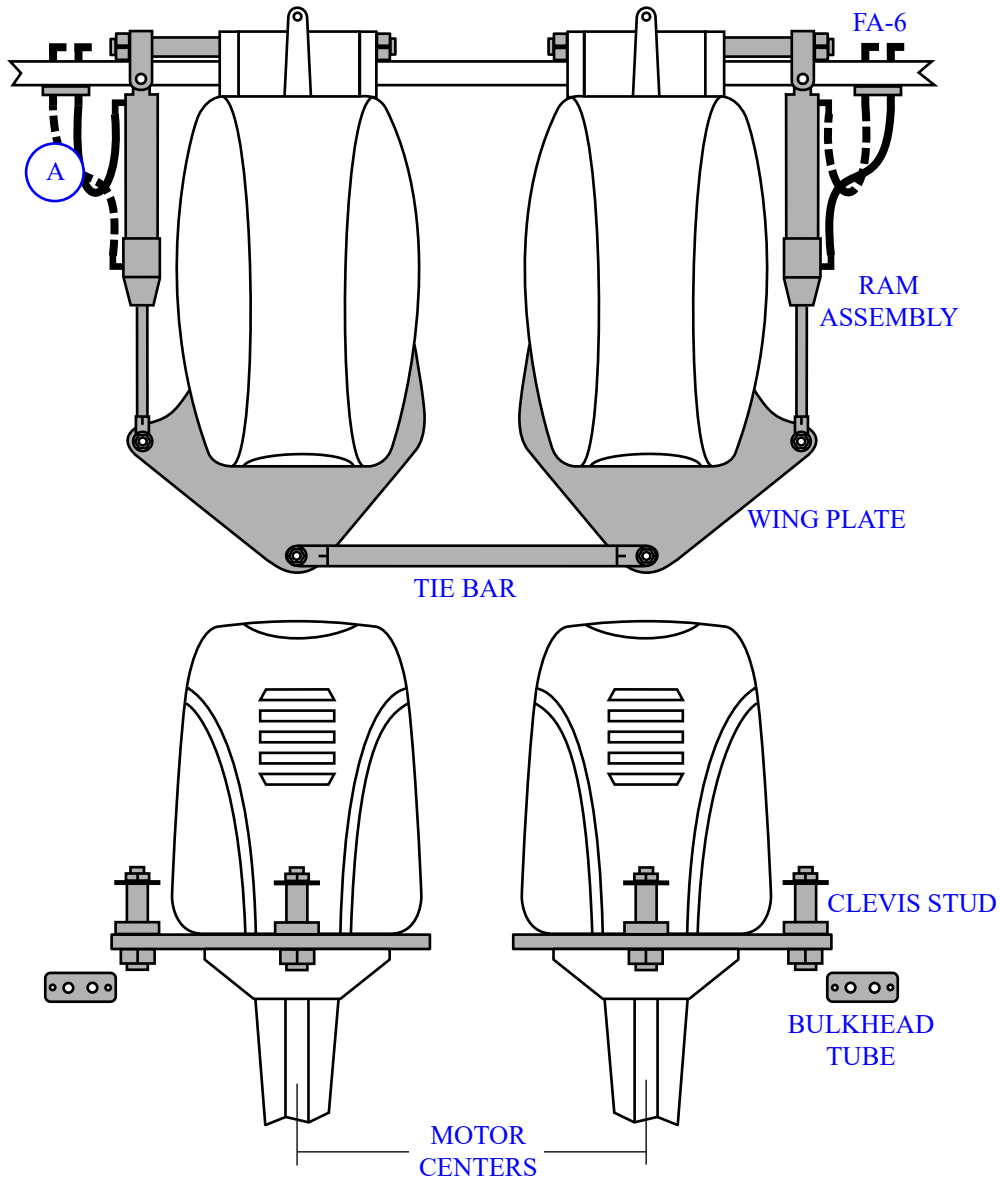
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-93	STER KIT MERC PROMAX 3L/300 X
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-11-LR	WING PLATE KIT MERC PROMAX 3L/300 X, 1 RAM 1 TIE BAR
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
		OR
1	TB-27	TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")
TBD	TB-3	TIE BAR PER INCH 1 3/8" SS
2	0229	CLEVIS STUD ASSEMBLY 7/8"

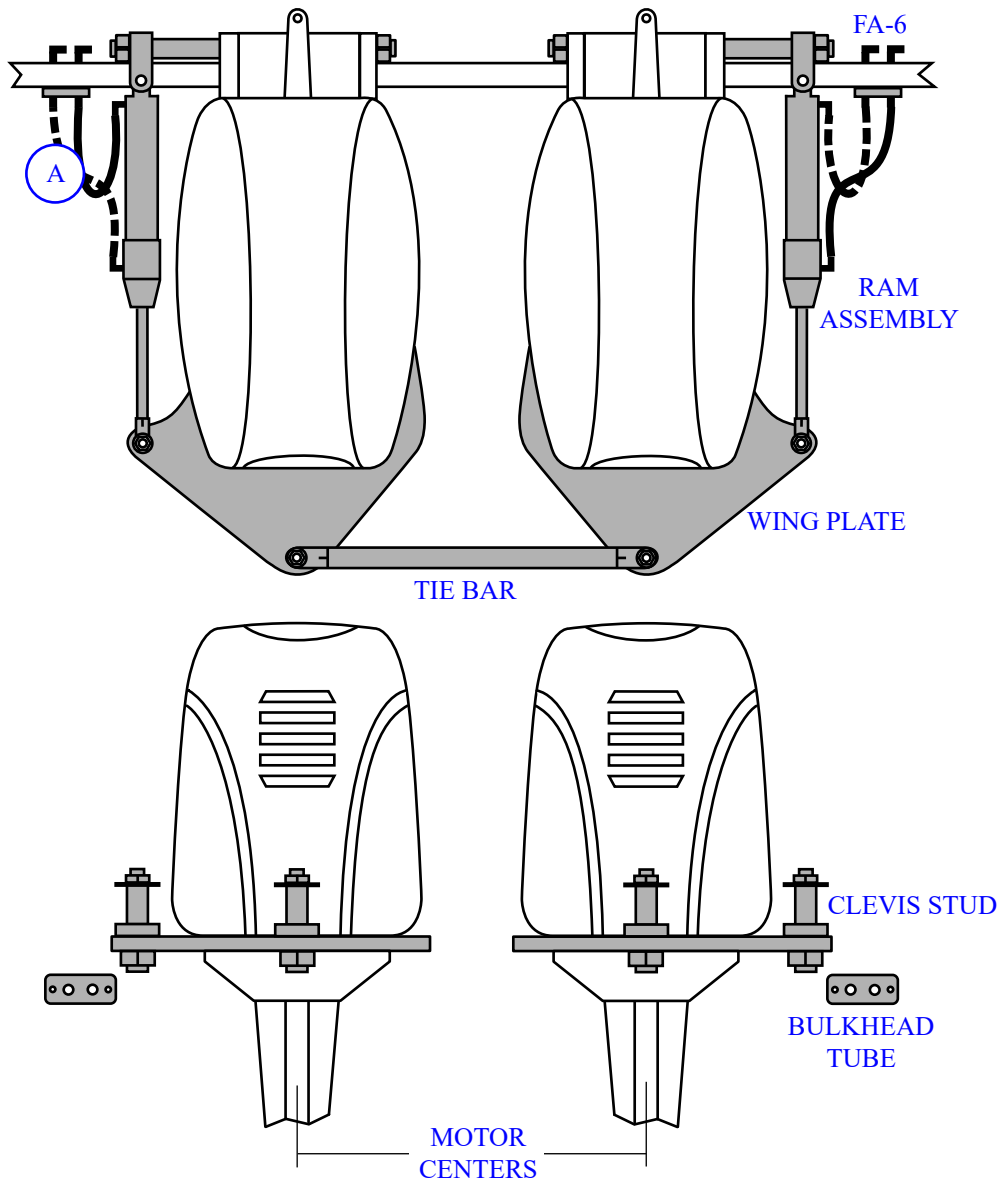
NOTE: WHEN ORDERING FOR A SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-1-15

QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-94	STER KIT MERC 200, 225, 250, 300 XS
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-26-LR	WING PLATE KIT MERC 200, 225, 300 XS, 1 RAM 1 TIE BAR
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
		OR
1	TB-27	TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")
TBD	TB-3	TIE BAR PER INCH 1 3/8" Ss
2	0229	CLEVIS STUD ASSEMBLY 7/8"

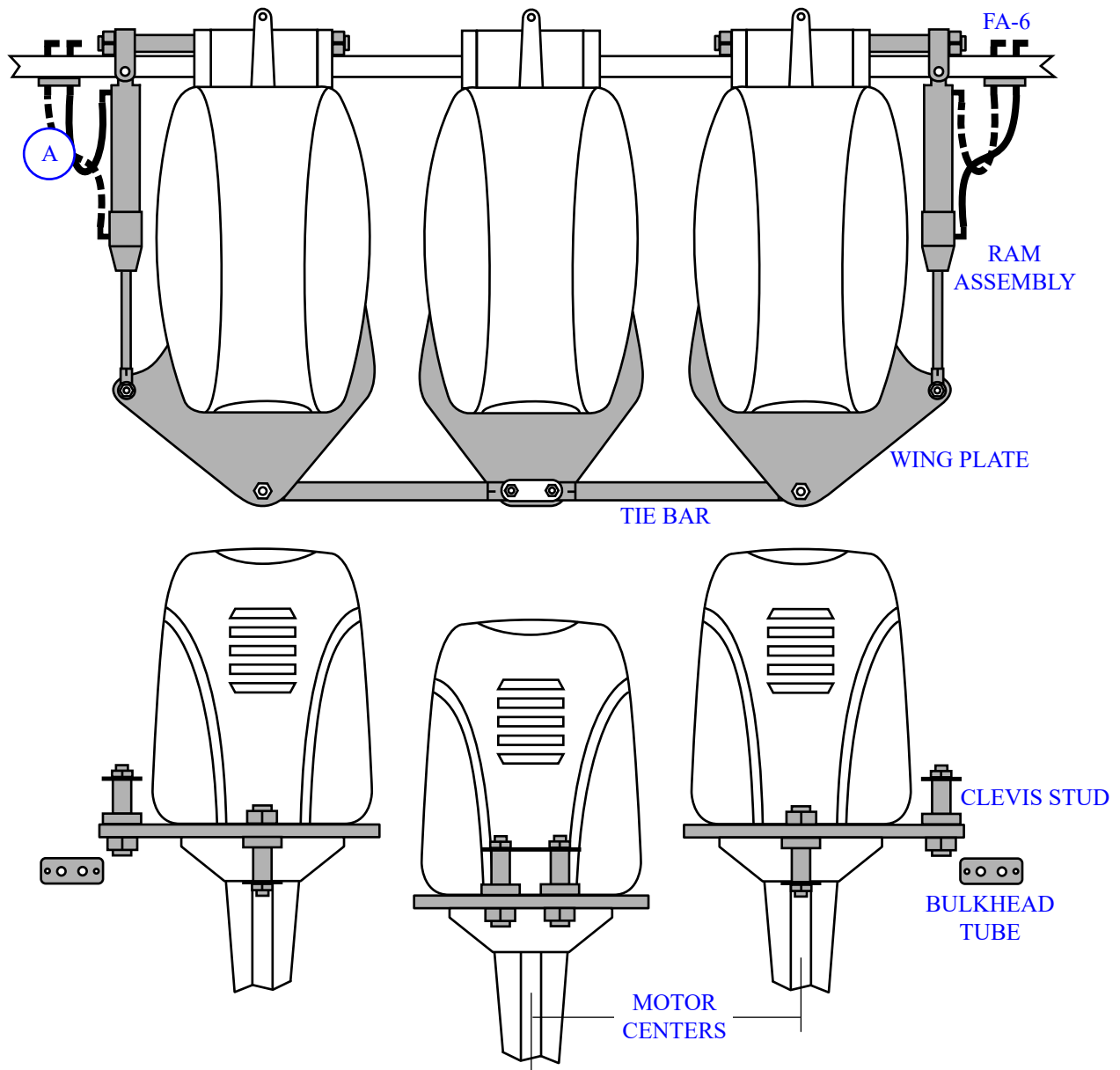
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-81	STER KIT MERC 2.5 EFI
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-9-LR	WING PLATE KIT MERC 2.5L/EFI, 1 RAM 1 TIE BAR
1	WP-9-C	WING PLATE KIT MERC 2.5L/EFI, 2 TIE BARS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
2	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS

NOTE: TIE BARS ARE LEVEL AT 3" OF DROP TO THE CENTER MOTOR.  
 WHEN ORDERING FOR A SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-1-15

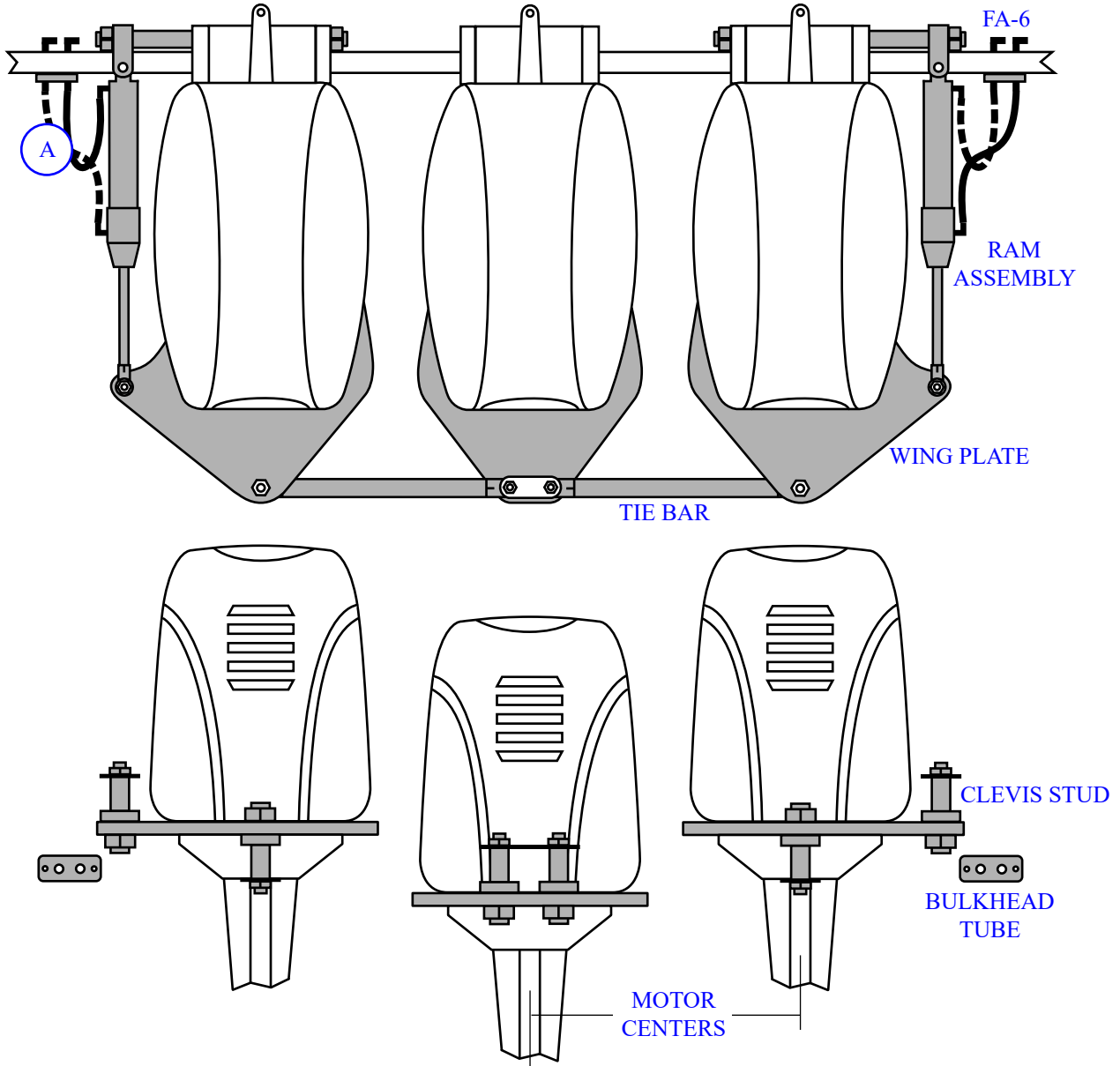
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-83	STER KIT MERC PROMAX 3L/300 X
PARTS INCLUDED		
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-11-LR	WING PLATE KIT MERC PROMAX 3L/300 X, 1 RAM 1 TIE BAR
1	WP-11-C	WING PLATE KIT MERC PROMAX 3L/300 X, 2 TIE BARS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
2	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT		
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS

NOTE: TIE BARS ARE LEVEL AT 3" OF DROP TO THE CENTER MOTOR  
 WHEN ORDERING FOR A SHORT SHAFT MOTOR CHANGE THE RAM ASSEMBLY TO SR-8-1-15

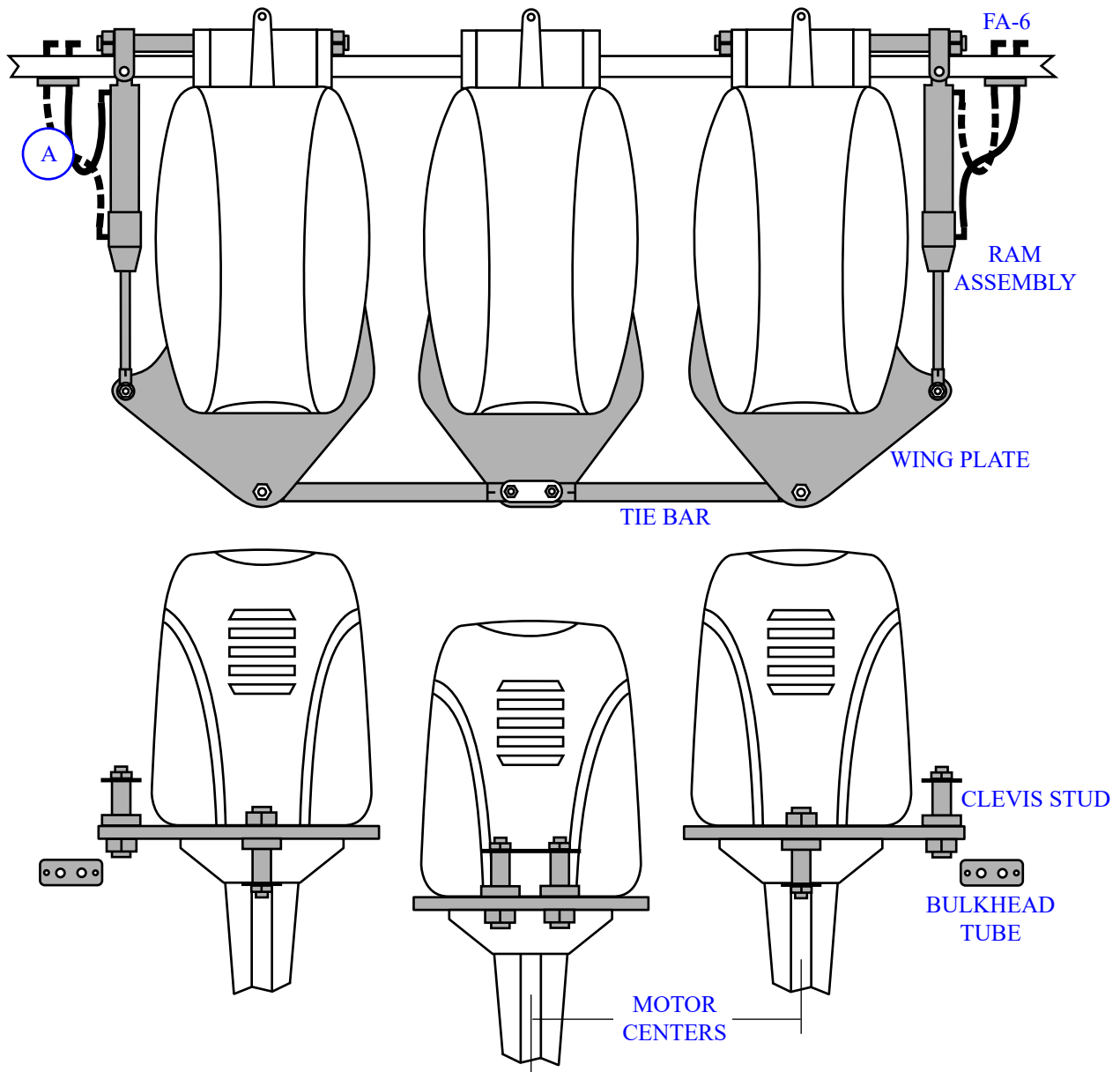
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



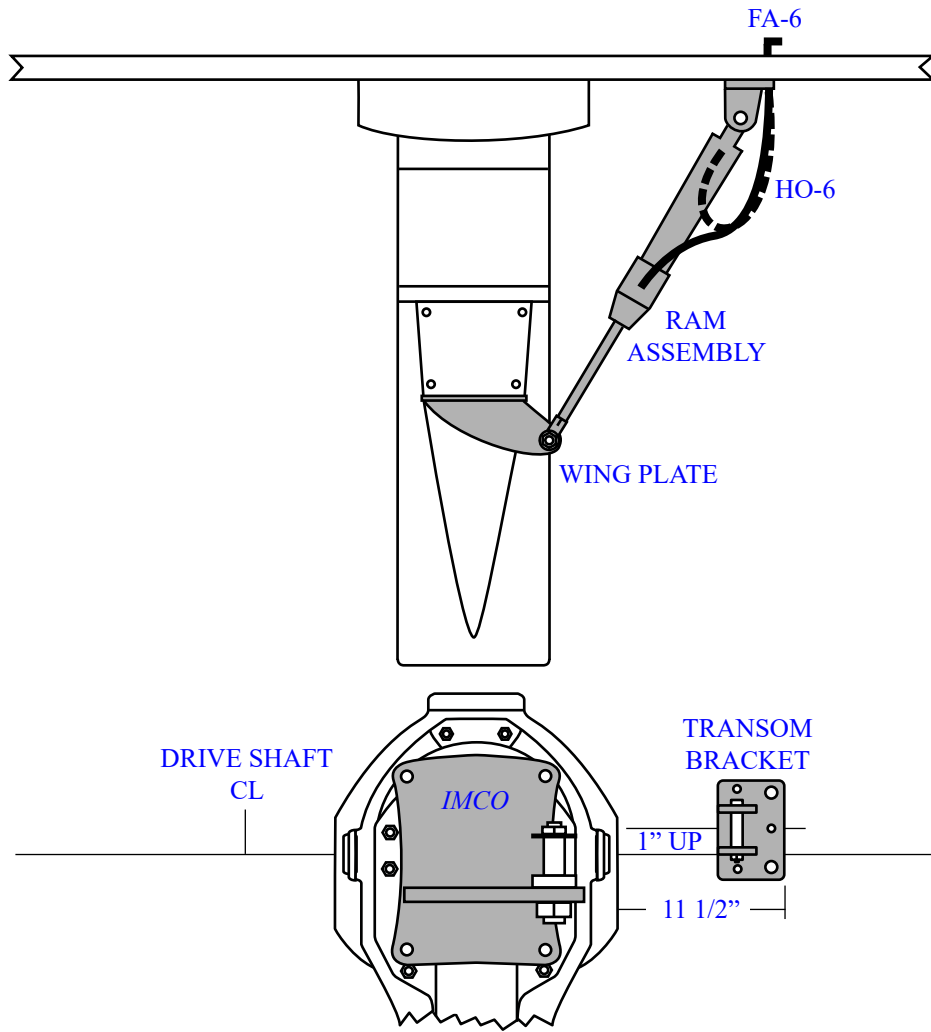
QTY	P/N	KIT
1	SA-84	STER KIT MERC 200, 225, 250, 300 XS
		PARTS INCLUDED
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	BT-1	BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
2	WP-26-LR	WING PLATE KIT MERC 200, 225, 300 XS, 1 RAM 1 TIE BAR
1	WP-26-C	WING PLATE KIT MERC 200, 225, 300 XS, 2 TIE BARS
2	MP-13	CLEVIS STUD ASSEMBLY 3/4"
2	TP-1	TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)
2	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
8	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
		ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT
_____ "	HO-13	HOSE HP CRIMP 3/8" (TOTAL INCHES FROM CHART BELOW)
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS

NOTE: TIE BARS ARE LEVEL AT 3" OF DROP TO THE CENTER MOTOR

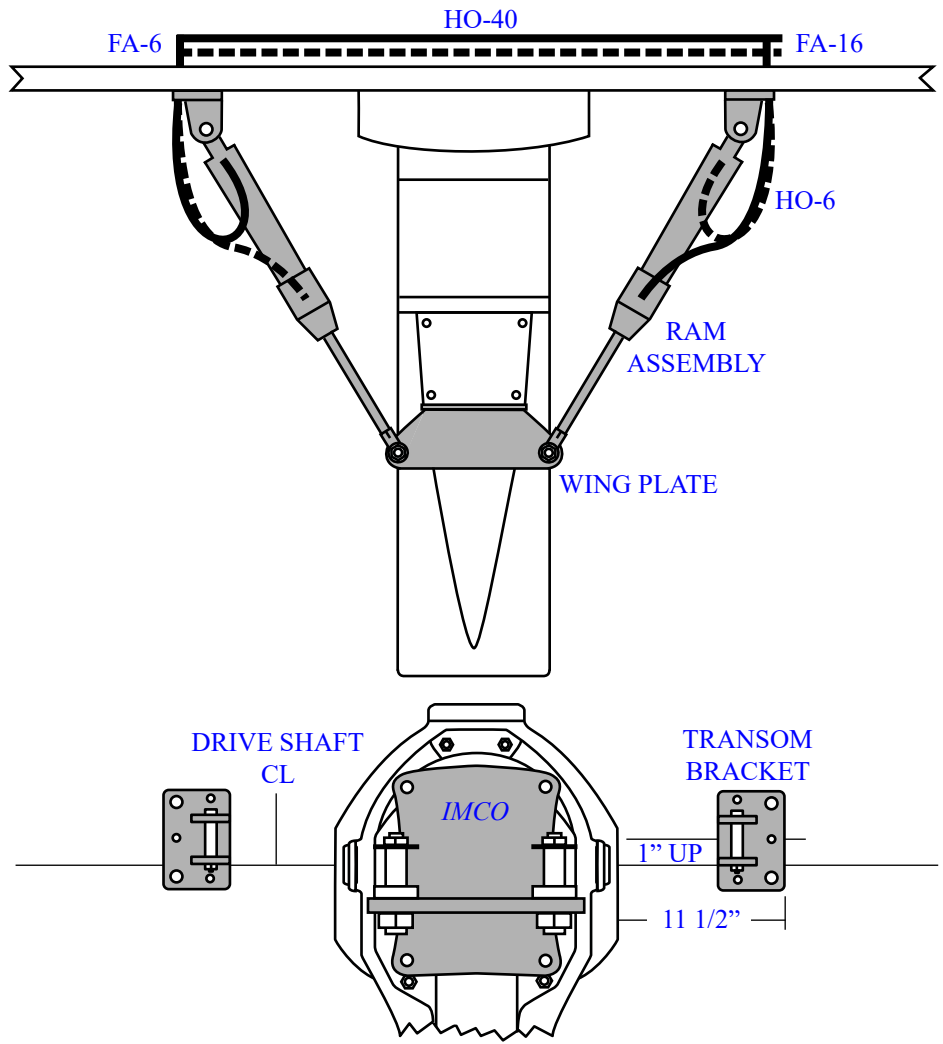
QTY	P/N	HOSE	LENGTH
4	HO-13	A	_____ "



QTY	P/N	KIT
1	SA-21	STER KIT MERC TRS SINGLE 1 RAM MOUNT 11 1/2"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
1	SR-8-5-13	RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	WP-6-R	WING PLATE KIT MERC TRS RH 1 RAM

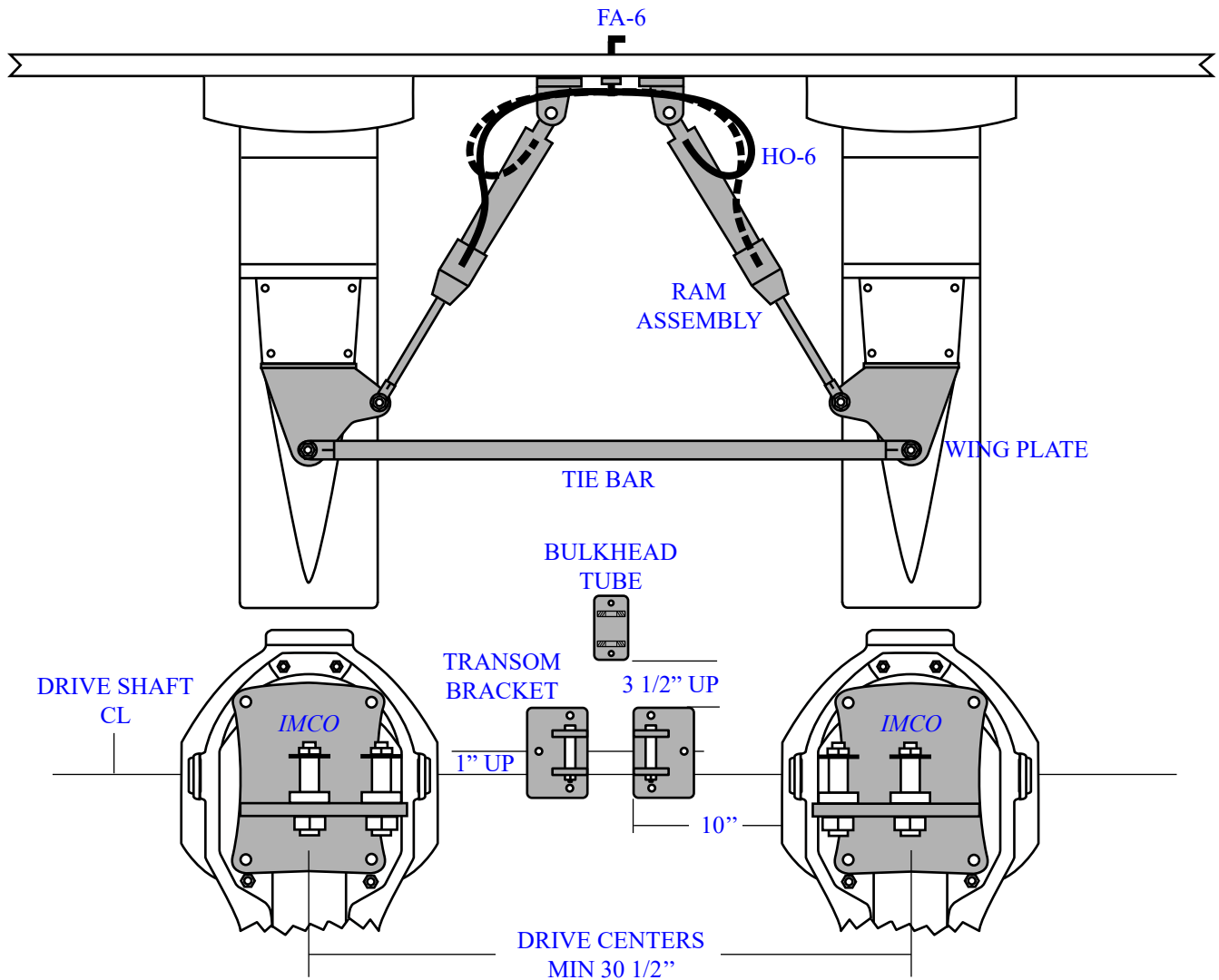


QTY	P/N	KIT
1	SA-22	STER KIT MERC TRS SINGLE 2 RAMS MOUNT 11 1/2"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
2	FA-16	ADAPTER -6 JIC SWIVEL T SS
2	HO-40	HOSE ASSEMBLY HP CRIMP 3/8" X 40" W/-6 JIC SS HOSE ENDS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-31	TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	WP-6-LR	WING PLATE KIT MERC TRS 2 RAMS

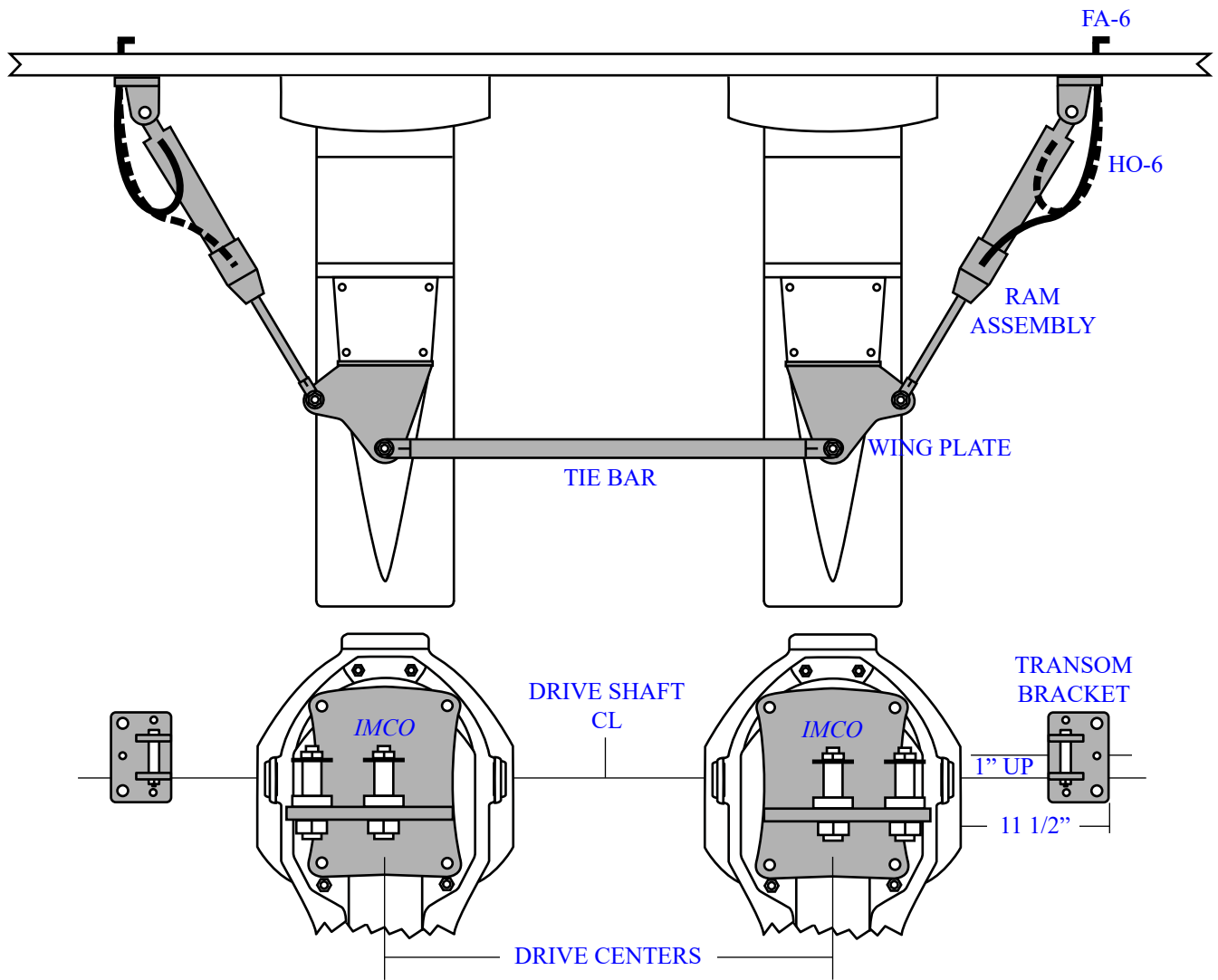




QTY	P/N	KIT
1	SA-24-R	STER KIT MERC TRS TWIN BETWEEN MOUNT 10"
PARTS INCLUDED		
2	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
1	BT-3	BULKHEAD TUBE ASSEMBLY -6 JIC T
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-32	TRANSOM BRACKET KIT LH REVERSE
1	TB-22	TRANSOM BRACKET KIT RH REVERSE
1	WP-6-LT	WING PLATE KIT MERC TRS LH 1 RAM 1 TIE BAR
1	WP-6-RT	WING PLATE KIT MERC TRS RH 1 RAM 1 TIE BAR
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
ADDITIONAL ITEMS TO COMPLETE THIS KIT		
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS



QTY	P/N	KIT
1	SA-23	STER KIT MERC TRS TWIN OUTSIDE MOUNT 11 1/2"
PARTS INCLUDED		
4	FA-6	ADAPTER -6 JIC SWIVEL 90° SS
4	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
2	SR-8-1-13	RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
1	TB-31	TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES
1	TB-21	TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES
1	WP-6-LT	WING PLATE KIT MERC TRS LH 1 RAM 1 TIE BAR
1	WP-6-RT	WING PLATE KIT MERC TRS RH 1 RAM 1 TIE BAR
1	TB-6	TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")
ADDITIONAL ITEMS TO COMPLETE THIS KIT		
TBD	TB-2	TIE BAR PER INCH 1 1/4" SS



## HOSE KIT IMCO 1 PUMP W/CRIMP HOSE

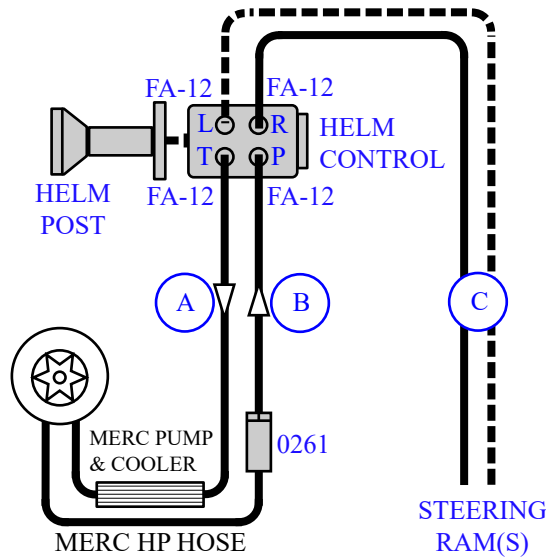
BY HAVING IMCO MAKE YOUR HOSE ASSEMBLIES FOR YOU, YOU'LL SAVE TIME,  
MONEY AND YOU CAN REST ASSURED KNOWING THE HOSE ASSEMBLIES WON'T FAIL!  
THIS HOSE AND THESE HOSE ASSEMBLIES ARE ABSOLUTLY THE VERY BEST YOU CAN BUY.

QTY	P/N	KIT
1	HK-2-C	HOSE KIT IMCO 1 PUMP W/CRIMP HOSE
		PARTS INCLUDED
1	0261	OIL FILTER ASSEMBLY
4	FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
6	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
1	FA-5	HOSE END LP 3/8" TO -6 JIC BRASS

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

1	<u>          </u> ?	HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD	
1	<u>          </u> ?	HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU	
<u>      </u>	" HO-2	HOSE LP 3/8"	TOTAL INCHES FROM CHART BELOW
<u>      </u>	" HO-13	HOSE HP CRIMP 3/8"	TOTAL INCHES FROM CHART BELOW

1	HO-2	(A)	_____"
1	HO-13	(B)	_____"
2	HO-13	(C)	_____"



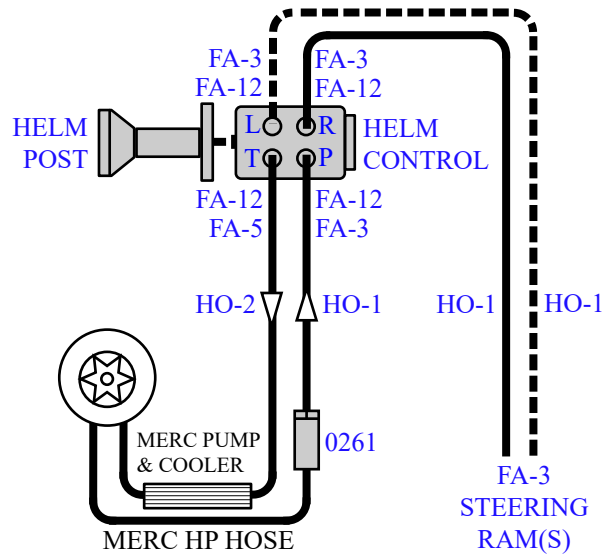
## HOSE KIT IMCO 1 PUMP W/FIELD ATTACH HOSE

IF YOU SIMPLY HAVE NO TIME FOR IMCO TO MAKE THE HOSE ASSEMBLIES FOR YOU, THEN THIS DO IT YOURSELF KIT IS THE ALTERNATIVE, HOWEVER YOU MUST BE AWARE THAT THESE HOSE ENDS ARE NOT EASY TO INSTALL AND WILL FAIL IF NOT INSTALLED PROPERLY! BECAUSE YOU HAVE CHOSEN TO INSTALL THE HOSE ENDS YOURSELF, YOU AND YOU ALONE EXCEPT ALL RESPONSIBILITY! (IMCO IN NO WAY WILL BE HELD LIABLE FOR ANY FAILURS ON YOUR BEHALF!)

QTY	P/N	KIT
1	HK-2	HOSE KIT IMCO 1 PUMP W/FIELD ATTACH HOSE
		PARTS INCLUDED
1	0261	OIL FILTER ASSEMBLY
4	FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
720	HO-1	HOSE HP FIELD ATTACH 5/16" (PER INCH)
6	FA-3	HOSE END HP FIELD ATTACH 5/16" TO -6 JIC
1	FA-35	HOSE END MANDREL -6 JIC
240	HO-2	HOSE LP FIELD ATTACH 3/8" (PER INCH)
1	FA-5	HOSE END LP FIELD ATTACH 3/8" TO -6 JIC BRASS

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

- 1 \_\_\_\_\_? HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD
- 1 \_\_\_\_\_? HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU



## HOSE KIT IMCO 2 PUMP W/CRIMP HOSE

BY HAVING IMCO MAKE YOUR HOSE ASSEMBLIES FOR YOU, YOU'LL SAVE TIME,  
MONEY AND YOU CAN REST ASSURED KNOWING THE HOSE ASSEMBLIES WON'T FAIL!  
THIS HOSE AND THESE HOSE ASSEMBLIES ARE ABSOLUTLY THE VERY BEST YOU CAN BUY.

QTY	P/N	KIT
1	HK-14-C	HOSE KIT IMCO 2 PUMP W/CRIMP HOSE
		PARTS INCLUDED
4	FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
4	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
2	FA-5	HOSE END LP 3/8" TO -6 JIC BRASS
6	HO-9	HOSE END HP CRIMP 1/2" TO -8 JIC SS
2	FA-4	HOSE END LP 1/2" TO -8 JIC BRASS
1	PT-13	VALVE ASSEMBLY 2 PUMP
1	PT-6	OIL TANK ASSEMBLY 1 OR 2 PUMP RECIRCULATING

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

1	<u>          </u> ?	HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD
1	<u>          </u> ?	HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU

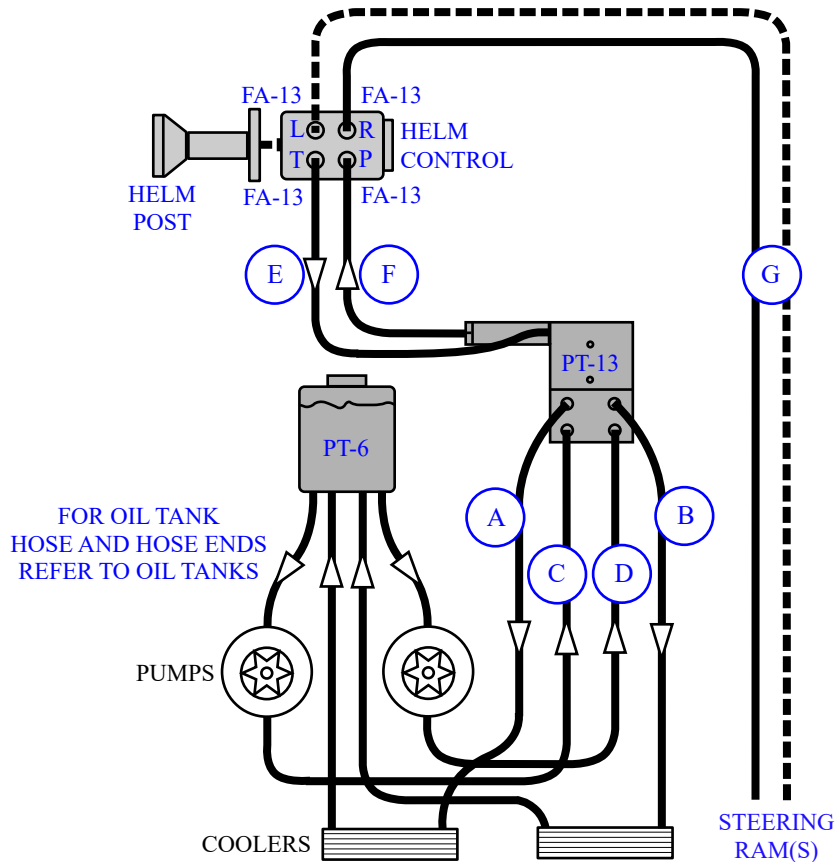
         " HO-2 HOSE LP 3/8" TOTAL INCHES FROM CHART BELOW

         " HO-13 HOSE HP CRIMP 3/8" TOTAL INCHES FROM CHART BELOW

         " HO-5 HOSE LP 1/2" TOTAL INCHES FROM CHART BELOW

         " HO-14 HOSE HP CRIMP 1/2" TOTAL INCHES FROM CHART BELOW

1	HO-2	(A)	<u>        </u> "
1	HO-2	(B)	<u>        </u> "
1	HO-13	(C)	<u>        </u> "
1	HO-13	(D)	<u>        </u> "
1	HO-5	(E)	<u>        </u> "
1	HO-14	(F)	<u>        </u> "
2	HO-14	(G)	<u>        </u> "



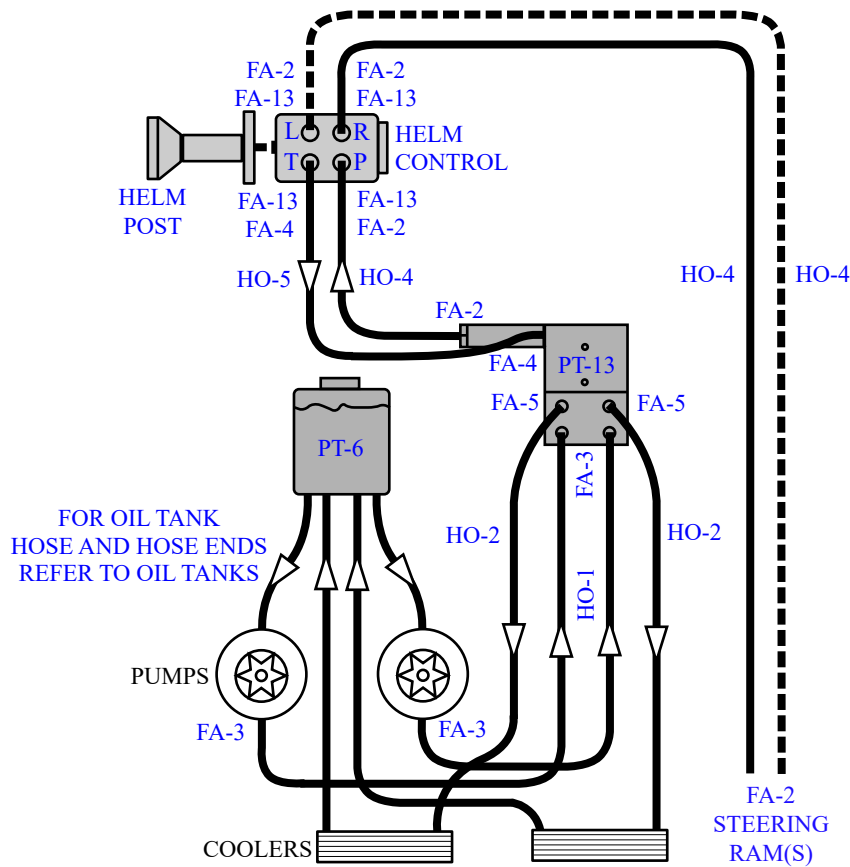
## HOSE KIT IMCO 2 PUMP W/FIELD ATTACH HOSE

IF YOU SIMPLY HAVE NO TIME FOR IMCO TO MAKE THE HOSE ASSEMBLIES FOR YOU, THEN THIS DO IT YOURSELF KIT IS THE ALTERNATIVE, HOWEVER YOU MUST BE AWARE THAT THESE HOSE ENDS ARE NOT EASY TO INSTALL AND WILL FAIL IF NOT INSTALLED PROPERLY! BECAUSE YOU HAVE CHOSEN TO INSTALL THE HOSE ENDS YOURSELF, YOU AND YOU ALONE EXCEPT ALL RESPONSIBILITY! (IMCO IN NO WAY WILL BE HELD LIABLE FOR ANY FAILURES ON YOUR BEHALF!)

QTY	P/N	KIT
1	HK-14	HOSE KIT IMCO 2 PUMP W/FIELD ATTACH HOSE
PARTS INCLUDED		
4	FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
180	HO-1	HOSE HP FIELD ATTACH 5/16" (PER INCH)
4	FA-3	HOSE END HP FIELD ATTACH 5/16" TO -6 JIC
1	FA-35	HOSE END MANDREL -6 JIC
180	HO-2	HOSE LP FIELD ATTACH 3/8" (PER INCH)
2	FA-5	HOSE END LP FIELD ATTACH 3/8" TO -6 JIC BRASS
840	HO-4	HOSE HP FIELD ATTACH 13/32" (PER INCH)
6	FA-2	HOSE END HP FIELD ATTACH 13/32" TO -8 JIC
1	FA-1	HOSE END MANDREL -8 JIC
360	HO-5	HOSE LP FIELD ATTACH 1/2" (PER INCH)
2	FA-4	HOSE END LP FIELD ATTACH 1/2" TO -8 JIC BRASS
1	PT-13	VALVE ASSEMBLY 2 PUMP
1	PT-6	OIL TANK ASSEMBLY 1 OR 2 PUMP RECIRCULATING

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

- 1 \_\_\_\_\_? HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD
- 1 \_\_\_\_\_? HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU



## HOSE KIT IMCO ELECTRIC PUMP W/CRIMP HOSE

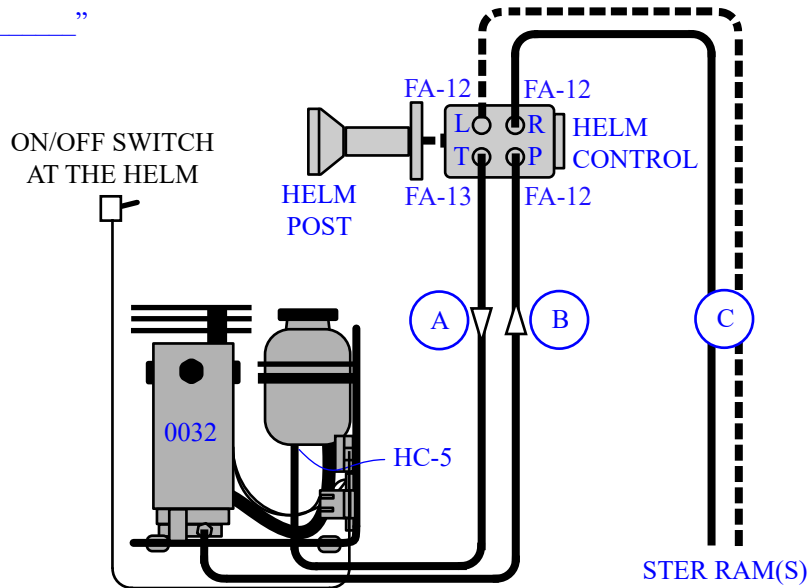
BY HAVING IMCO MAKE YOUR HOSE ASSEMBLIES FOR YOU, YOU'LL SAVE TIME,  
MONEY AND YOU CAN REST ASSURED KNOWING THE HOSE ASSEMBLIES WON'T FAIL!  
THIS HOSE AND THESE HOSE ASSEMBLIES ARE ABSOLUTLY THE VERY BEST YOU CAN BUY.

QTY	P/N	KIT
1	HK-29-C	HOSE KIT IMCO ELECTRIC PUMP W/CRIMP HOSE
		PARTS INCLUDED
1	0032	ELECTRIC POWER STEERING PUMP
1	FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
3	FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
6	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
1	FA-4	HOSE END LP 1/2" TO -8 JIC BRASS
1	HC-5	HOSE CLAMP 7/8"

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

1	<u>          </u> ?	HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD	
1	<u>          </u> ?	HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU	
<u>          </u> "	HO-5	HOSE LP 1/2"	TOTAL INCHES FROM CHART BELOW
<u>          </u> "	HO-13	HOSE HP CRIMP 3/8"	TOTAL INCHES FROM CHART BELOW

1	HO-5	(A)	<u>          </u> "
1	HO-13	(B)	<u>          </u> "
2	HO-13	(C)	<u>          </u> "



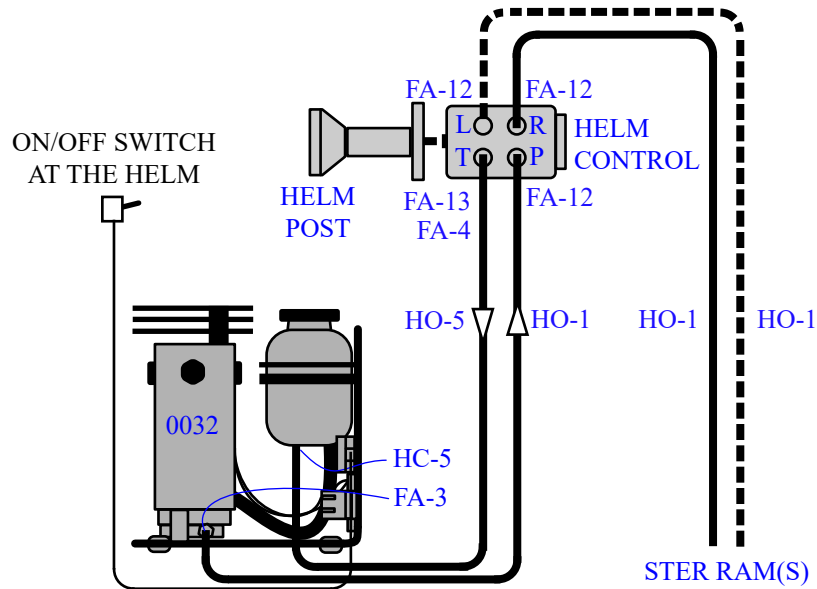
## HOSE KIT IMCO ELECTRIC PUMP W/FIELD ATTACH HOSE

IF YOU SIMPLY HAVE NO TIME FOR IMCO TO MAKE THE HOSE ASSEMBLIES FOR YOU, THEN THIS DO IT YOURSELF KIT IS THE ALTERNATIVE, HOWEVER YOU MUST BE AWARE THAT THESE HOSE ENDS ARE NOT EASY TO INSTALL AND WILL FAIL IF NOT INSTALLED PROPERLY! BECAUSE YOU HAVE CHOSEN TO INSTALL THE HOSE ENDS YOURSELF, YOU AND YOU ALONE EXCEPT ALL RESPONSIBILITY! (IMCO IN NO WAY WILL BE HELD LIABLE FOR ANY FAILURES ON YOUR BEHALF!)

QTY	P/N	KIT
1	HK-29	HOSE KIT IMCO ELECTRIC PUMP W/FIELD ATTACH HOSE
		PARTS INCLUDED
1	0032	ELECTRIC POWER STEERING PUMP
1	FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
3	FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
720	HO-1	HOSE HP FIELD ATTACH 5/16" (PER INCH)
6	FA-3	HOSE END HP FIELD ATTACH 5/16" TO -6 JIC
1	FA-35	HOSE END MANDREL -6 JIC
240	HO-5	HOSE LP FIELD ATTACH 1/2" (PER INCH)
1	FA-4	HOSE END LP FIELD ATTACH 1/2" TO -8 JIC BRASS
1	HC-5	HOSE CLAMP 7/8"

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

- 1 \_\_\_\_\_? HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD
- 1 \_\_\_\_\_? HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU





## HOSE KIT MERC 1 PUMP W/CRIMP HOSE

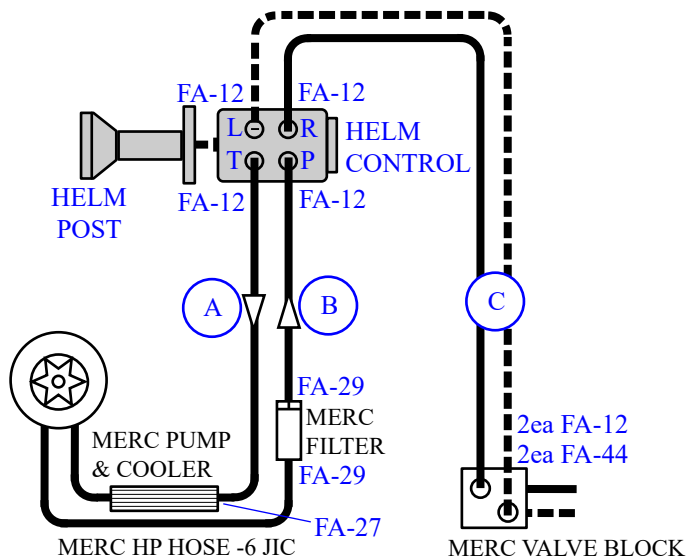
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THIS HOSE AND THESE HOSE ASSEMBLIES ARE ABSOLUTLY THE VERY BEST YOU CAN BUY.

QTY	P/N	KIT
1	HK-6-C	HOSE KIT MERC 1 PUMP W/CRIMP HOSE
PARTS INCLUDED		
1	FA-27	ADAPTER 1/2 MP TO -6 JIC BRASS
6	FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
2	FA-44	ADAPTER 3/4-16 O-RING SWIVEL TO -6 JIC 90° ZPS
2	FA-29	ADAPTER 3/8 MP TO -6 JIC BRASS
6	HO-3	HOSE END HP CRIMP 3/8" TO -6 JIC SS
2	FA-5	HOSE END LP 3/8" TO -6 JIC BRASS

**ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT**

- |                 |                 |  |
|-----------------|-----------------|--|
| 1               | <u>      </u> ? | HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD       |
| 1               | <u>      </u> ? | HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU |
| <u>      </u> " | HO-2            | HOSE LP 3/8"                      TOTAL INCHES FROM CHART BELOW  |
| <u>      </u> " | HO-13           | HOSE HP CRIMP 3/8"            TOTAL INCHES FROM CHART BELOW  |

- |   |       |     |                 |
|---|-------|-----|-----------------|
| 1 | HO-2  | (A) | <u>      </u> " |
| 1 | HO-13 | (B) | <u>      </u> " |
| 2 | HO-13 | (C) | <u>      </u> " |



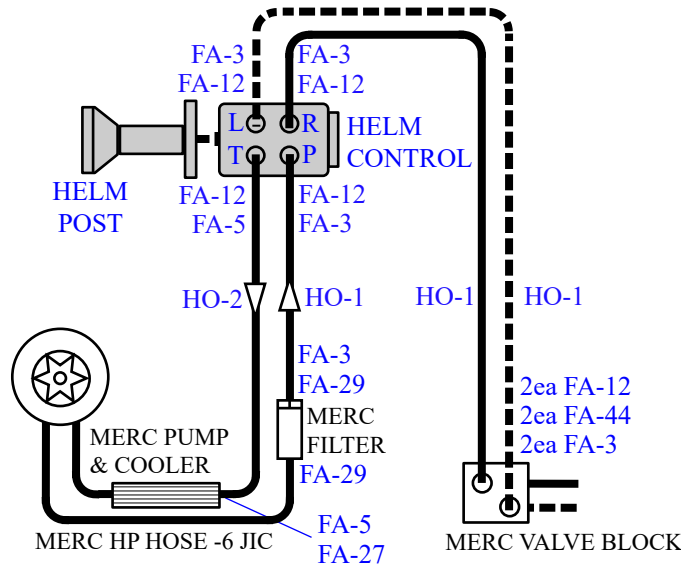
## HOSE KIT MERC 1 PUMP W/FIELD ATTACH HOSE

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QTY	P/N	KIT
1	HK-6	HOSE KIT MERC 1 PUMP W/FIELD ATTACH HOSE
PARTS INCLUDED		
1	FA-27	ADAPTER 1/2 MP TO -6 JIC BRASS
6	FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
2	FA-44	ADAPTER 3/4-16 O-RING SWIVEL TO -6 JIC 90° ZPS
2	FA-29	ADAPTER 3/8 MP TO -6 JIC BRASS
720	HO-1	HOSE HP FIELD ATTACH 5/16" (PER INCH)
6	FA-3	HOSE END HP FIELD ATTACH 5/16" TO -6 JIC
1	FA-35	HOSE END MANDREL -6 JIC
240	HO-2	HOSE LP FIELD ATTACH 3/8" (PER INCH)
1	FA-5	HOSE END LP FIELD ATTACH 3/8" TO -6 JIC BRASS

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

- 1 \_\_\_\_\_? HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD
- 1 \_\_\_\_\_? HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU



## HOSE KIT MERC 2 PUMP W/CRIMP HOSE

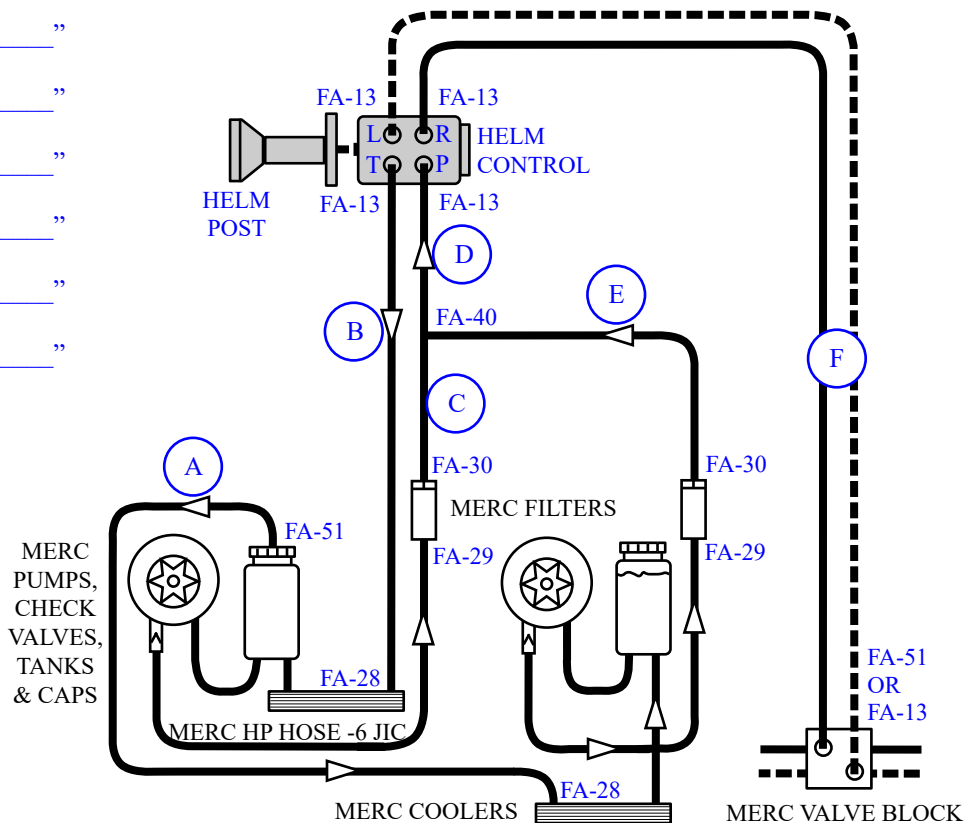
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QTY	P/N	KIT
1	HK-28-C	HOSE KIT MERC 2 PUMP W/CRIMP HOSE
PARTS INCLUDED		
2	FA-29	ADAPTER 3/8 MP TO -6 JIC BRASS
3	FA-51	ADAPTER 3/4-16 O-RING SWIVEL TO -8 JIC 90° ZPS
6	FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
2	FA-28	ADAPTER 1/2 MP TO -8 JIC BRASS
2	FA-30	ADAPTER 3/8 MP TO -8 JIC BRASS
1	FA-40	ADAPTER -8 JIC MALE T SS
10	HO-9	HOSE END HP CRIMP 1/2" TO -8 JIC SS
4	FA-4	HOSE END LP 1/2" TO -8 JIC BRASS

### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

1	<u>        </u> ?	HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD	
1	<u>        </u> ?	HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU	
<u>        </u> "	HO-5	HOSE LP 1/2"	TOTAL INCHES FROM CHART BELOW
<u>        </u> "	HO-14	HOSE HP CRIMP 1/2"	TOTAL INCHES FROM CHART BELOW

1	HO-5	(A)	<u>        </u> "
1	HO-5	(B)	<u>        </u> "
1	HO-14	(C)	<u>        </u> "
1	HO-14	(D)	<u>        </u> "
1	HO-14	(E)	<u>        </u> "
2	HO-14	(F)	<u>        </u> "



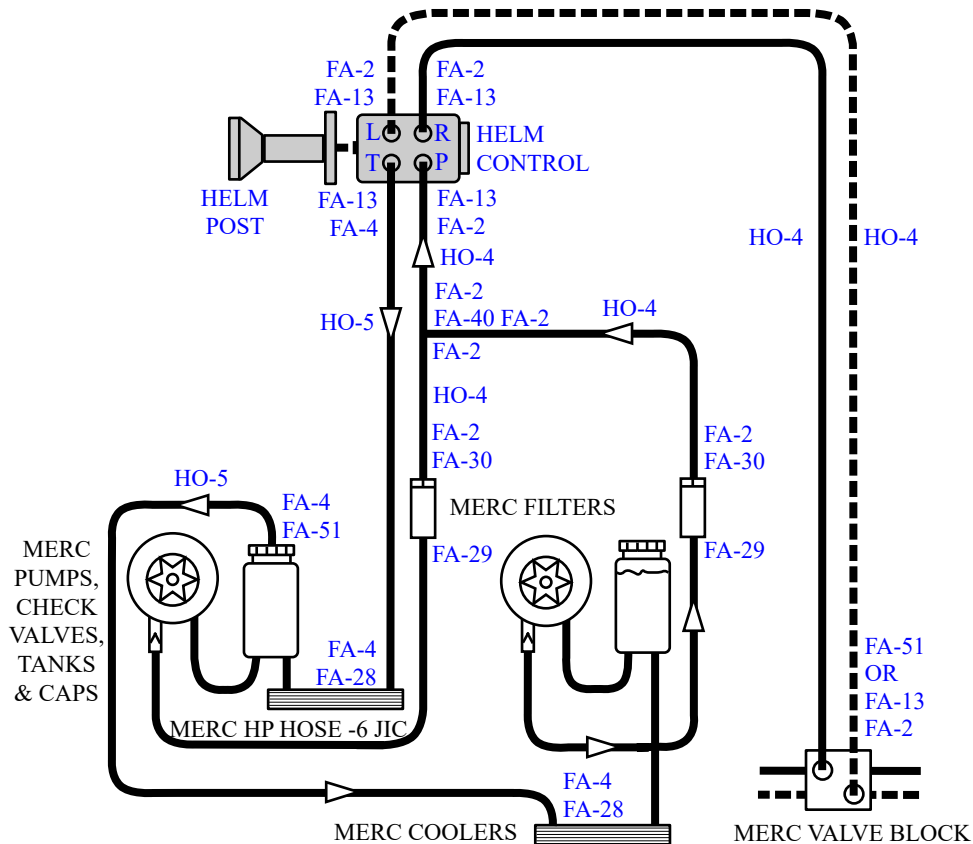
## HOSE KIT MERC 2 PUMP W/FIELD ATTACH HOSE

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QTY	P/N	KIT
1	HK-28	HOSE KIT MERC 2 PUMP W/FIELD ATTACH HOSE
PARTS INCLUDED		
2	FA-29	ADAPTER 3/8 MP TO -6 JIC BRASS
3	FA-51	ADAPTER 3/4-16 O-RING SWIVEL TO -8 JIC 90° ZPS
6	FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
2	FA-28	ADAPTER 1/2 MP TO -8 JIC BRASS
2	FA-30	ADAPTER 3/8 MP TO -8 JIC BRASS
1	FA-40	ADAPTER -8 JIC MALE T SS
1320	HO-4	HOSE HP FIELD ATTACH 13/32" (PER INCH)
10	FA-2	HOSE END HP FIELD ATTACH 13/32" TO -8 JIC
1	FA-1	HOSE END MANDREL -8 JIC
420	HO-5	HOSE LP FIELD ATTACH 1/2" (PER INCH)
4	FA-4	HOSE END LP FIELD ATTACH 1/2" TO -8 JIC BRASS

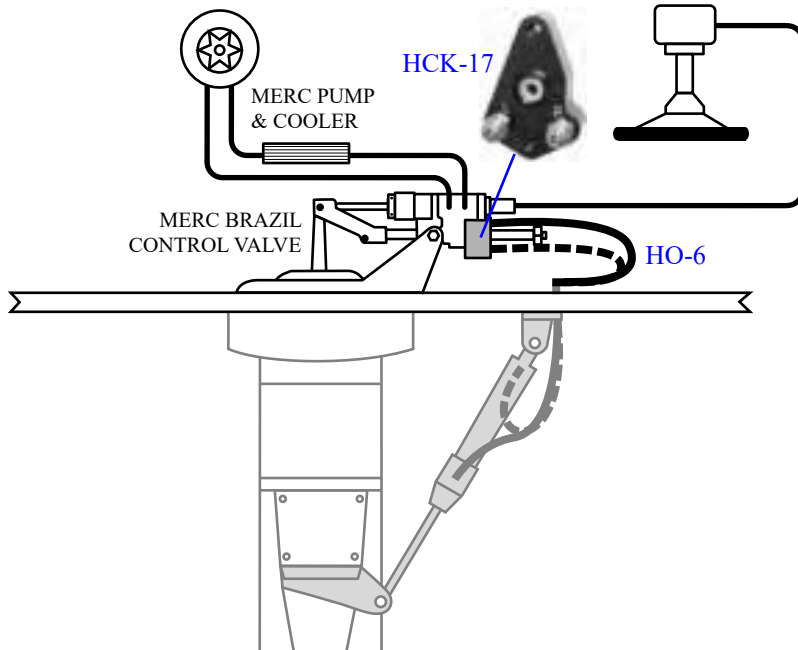
### ADDITIONAL ITEMS NEEDED TO COMPLETE THIS KIT

- 1 \_\_\_\_\_? HELM CONTROL, FOR CHOOSING THE CORRECT HELM DISPLACEMENT REFER TO (STEERING WHEEL TURNS LOCK TO LOCK) NOTE: 3 TO 4 TURNS IS STANDARD
- 1 \_\_\_\_\_? HELM POST, THIS IS DETERMINED BY REACH WHILE SITTING IN THE DRIVERS SEAT, REFER TO HELM POSTS FOR CHOOSING THE ONE THAT WORKS BEST FOR YOU

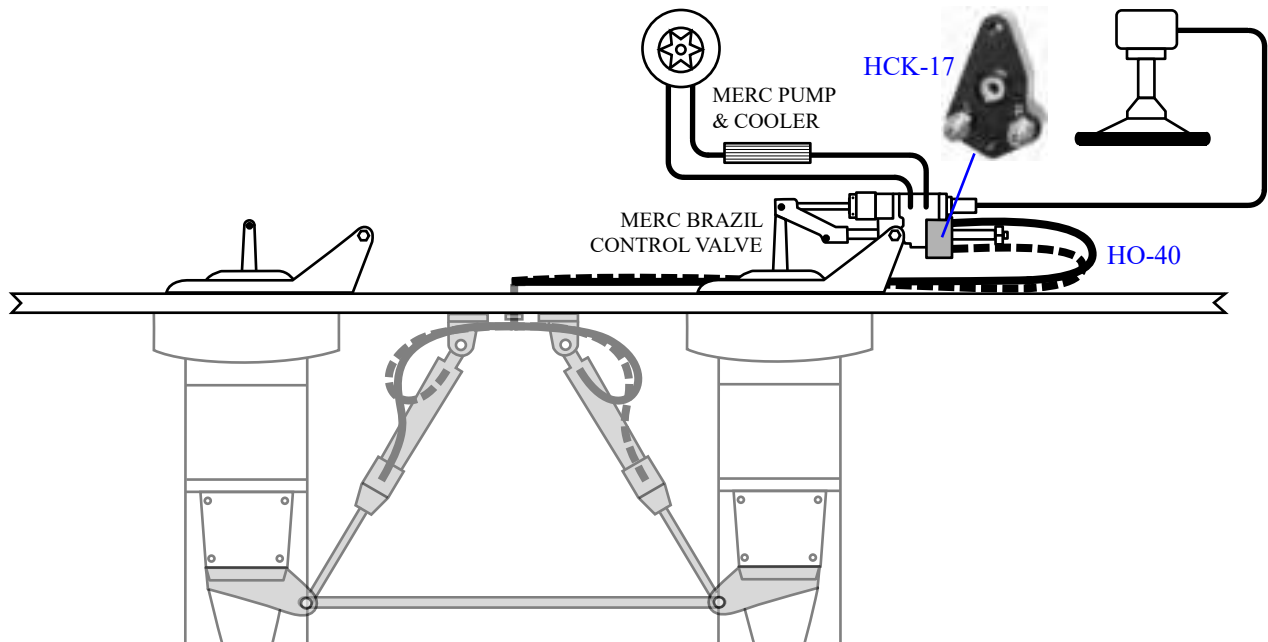


## MERC BRAZIL CONTROL VALVE HOSE KITS

QTY	P/N	KIT
1	HK-11	MERC BRAZIL CONTROL VALVE SHORT HOSE KIT
		PARTS INCLUDED
1	HCK-17	BRAZIL MANIFOLD ASSEMBLY W/-6 JIC ADAPTERS
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS

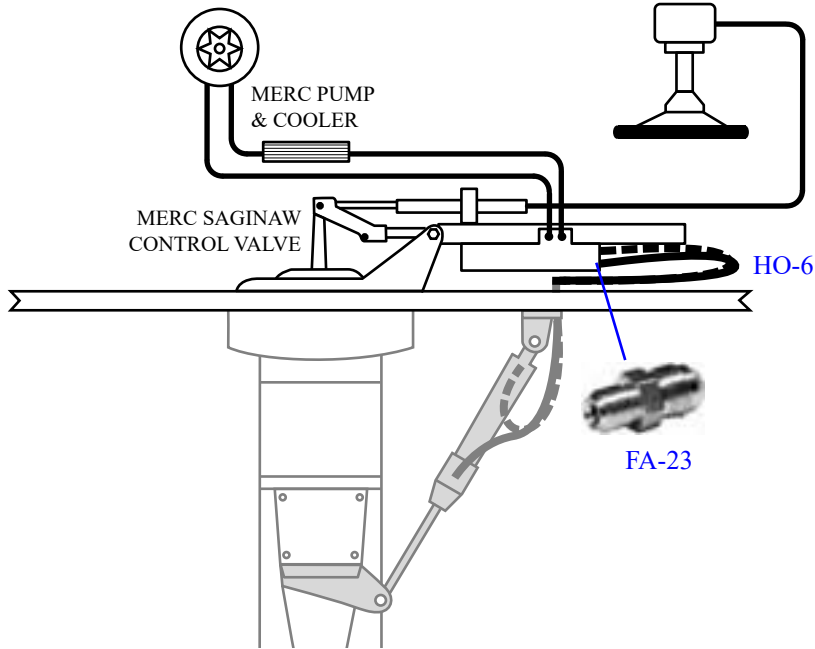


QTY	P/N	KIT
1	HK-12	MERC BRAZIL CONTROL VALVE LONG HOSE KIT
		PARTS INCLUDED
1	HCK-17	BRAZIL MANIFOLD ASSEMBLY W/-6 JIC ADAPTERS
2	HO-40	HOSE ASSEMBLY HP CRIMP 3/8" X 40" W/-6 JIC SS HOSE ENDS

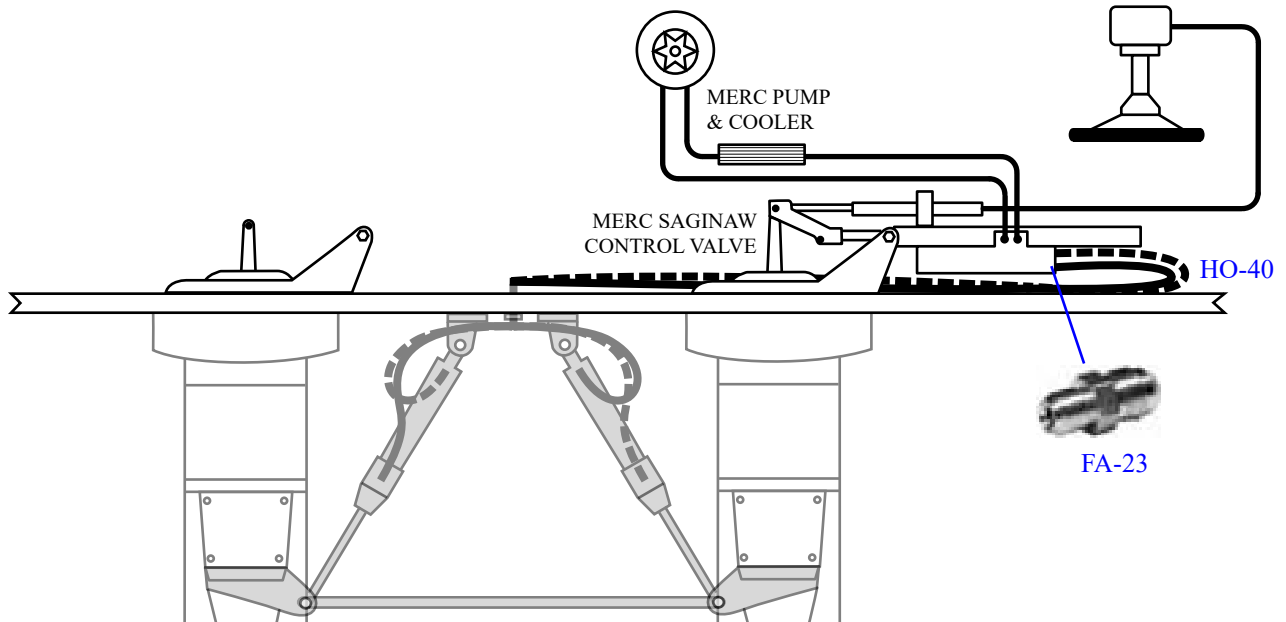


## MERC SAGINAW CONTROL VALVE HOSE KITS

QTY	P/N	KIT
1	HK-9	MERC SAGINAW CONTROL VALVE SHORT HOSE KIT
PARTS INCLUDED		
2	FA-23	ADAPTER 7/16-20 MALE FLAIR TO -6 JIC BRASS
2	HO-6	HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS



QTY	P/N	KIT
1	HK-10	MERC SAGINAW CONTROL VALVE LONG HOSE KIT
PARTS INCLUDED		
2	FA-23	ADAPTER 7/16-20 MALE FLAIR TO -6 JIC BRASS
2	HO-40	HOSE ASSEMBLY HP CRIMP 3/8" X 40" W/-6 JIC SS HOSE ENDS



NOTE: -6 JIC= 9/16-18 THREAD 37° FLAIR

-8 JIC=3/4-16 THREAD 37° FLAIR

FA-18	ADAPTER 1/8 MP TO -6 JIC BRASS
FA-110	ADAPTER 1/4 MP TO -4 JIC 45° SS
FA-109	ADAPTER 1/4 MP TO -4 JIC 90° SS
FA-36	ADAPTER 1/4 MP TO -6 JIC SS
FA-10	ADAPTER 1/4 MP TO -6 JIC 90° SS
FA-31	ADAPTER 3/8 MP TO -8 JIC 90° SS
FA-29	ADAPTER 3/8 MP TO -6 JIC BRASS
FA-30	ADAPTER 3/8 MP TO -8 JIC BRASS
FA-24	ADAPTER 3/8 MP TO -6 JIC X 3" LONG SS
FA-25	ADAPTER 3/8 MP TO -8 JIC X 3" LONG SS
FA-27	ADAPTER 1/2 MP TO -6 JIC BRASS
FA-28	ADAPTER 1/2 MP TO -8 JIC BRASS
FA-14	ADAPTER 1/2 MP TO 14-1.25 MM FM O-RING BRASS
FA-12	ADAPTER 3/4-16 O-RING TO -6 JIC ZPS
FA-13	ADAPTER 3/4-16 O-RING TO -8 JIC ZPS
FA-44	ADAPTER 3/4-16 O-RING SWIVEL TO -6 JIC 90° ZPS
0262	ADAPTER 3/4-16 O-RING SWIVEL TO -6 JIC 45° ZPS
FA-51	ADAPTER 3/4-16 O-RING SWIVEL TO -8 JIC 90° ZPS
0174	ADAPTER 9/16-18 O-RING SWIVEL TO -6 JIC 90° SS
FA-33	ADAPTER -6 JIC SWIVEL 45° SS
FA-32	ADAPTER -8 JIC SWIVEL 45° SS
FA-6	ADAPTER -6 JIC SWIVEL 90° SS
FA-7	ADAPTER -8 JIC SWIVEL 90° SS
FA-57	ADAPTER -6 JIC SWIVEL TO -8 JIC 90° SS
FA-16	ADAPTER -6 JIC SWIVEL T SS
FA-17	ADAPTER -8 JIC SWIVEL T SS
FA-19	ADAPTER -6 JIC SWIVEL T RUN SS
FA-37	ADAPTER -8 JIC SWIVEL T RUN SS
FA-21	ADAPTER -6 JIC MALE T SS
FA-40	ADAPTER -8 JIC MALE T SS
FA-22	ADAPTER -6 JIC BRANCH -6 -8 RUN MALE T SS
FA-23	ADAPTER 7/16-20 MALE FLAIR TO -6 JIC BRASS (SAGINAW VALVE)
FA-67	ADAPTER 16-1.5 MM SEAL RING FACE BANJO TO -6 JIC 90° SS (PWR STER PUMP)
FA-8-P	ADAPTER 16-1.5 MM O-RING FACE TO -6 JIC ZPS (PWR STER PUMP)



FA-18



FA-30



FA-28



FA-27



FA-24, FA-25



FA-14



FA-12, FA-13



FA-8-P



FA-23, FA-36



FA-32, FA-33



FA-110



FA-6, FA-7, FA-57



FA-10, FA-31, FA-109



FA-44, FA-51, 0174



FA-67



FA-22



FA-21, FA-40



FA-19, FA-37



FA-16, FA-17



FA-41

HCK-17

DID YOU KNOW IMCO INVENTED THE BRAZIL MANIFOLD!  
BRAZIL MANIFOLD ASSEMBLY W/-6 JIC ADAPTERS

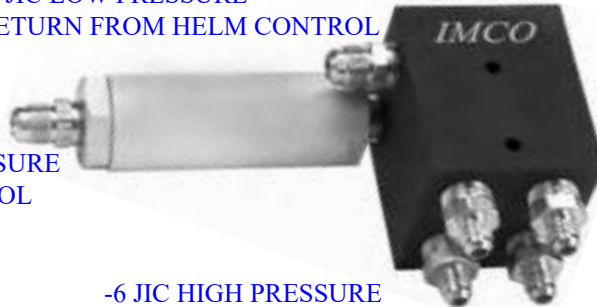


PT-13

VALVE ASSEMBLY 2 PUMP

-8 JIC LOW PRESSURE  
RETURN FROM HELM CONTROL

-8 JIC HIGH PRESSURE  
TO HELM CONTROL

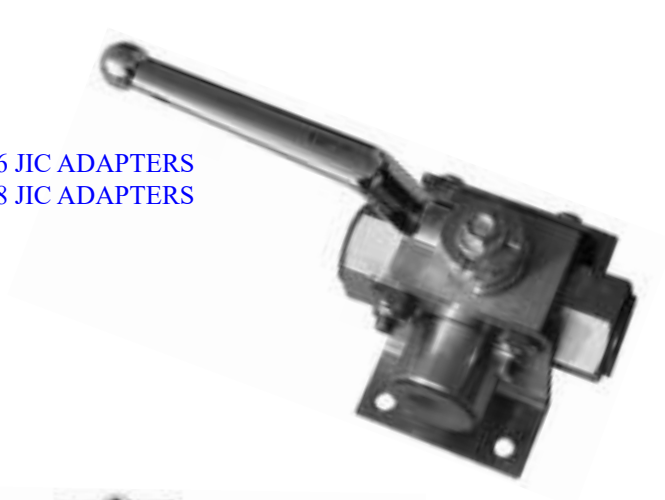


-6 JIC LOW PRESSURE  
RETURN TO COOLERS

-6 JIC HIGH PRESSURE  
W/INTERNAL CHECK VALVES, FROM PUMPS

PT-4-6  
PT-4-8

VALVE ASSEMBLY 2 HELM W/-6 JIC ADAPTERS  
VALVE ASSEMBLY 2 HELM W/-8 JIC ADAPTERS



0261

OIL FILTER ASSEMBLY



-6 JIC OR 14-1.25 MM FM O-RING  
FROM PUMP



-6 JIC TO HELM CONTROL

MP-20

OIL FILTER REPLACEMENT KIT (FITS ALL IMCO OIL FILTERS)





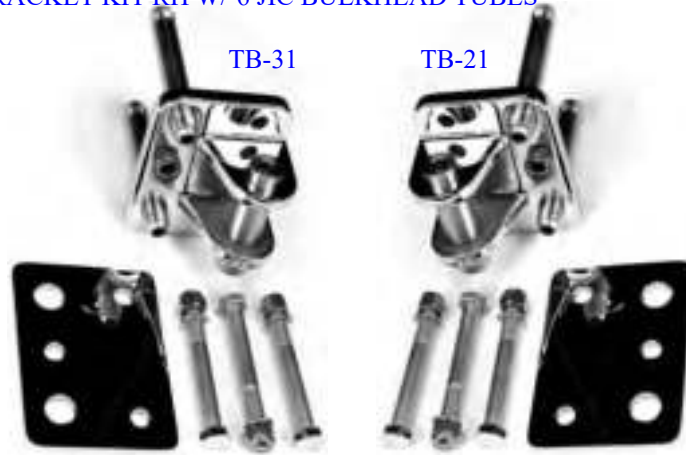
BT-1  
BT-3

BULKHEAD TUBE ASSEMBLY -6 JIC STRAIGHT  
BULKHEAD TUBE ASSEMBLY -6 JIC T



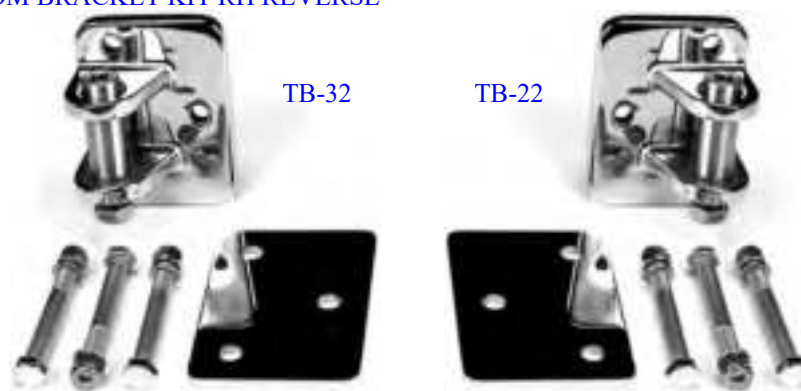
TB-31  
TB-21

TRANSOM BRACKET KIT LH W/-6 JIC BULKHEAD TUBES  
TRANSOM BRACKET KIT RH W/-6 JIC BULKHEAD TUBES



TB-32  
TB-22

TRANSOM BRACKET KIT LH REVERSE  
TRANSOM BRACKET KIT RH REVERSE

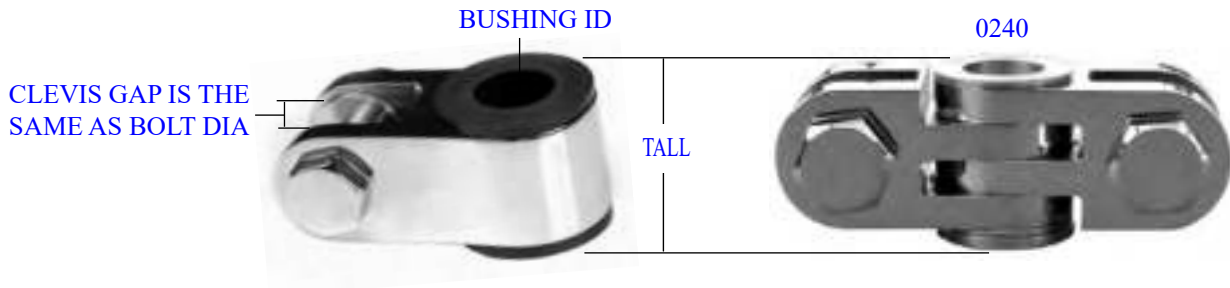


TBK  
TBK  
TBK  
TBK

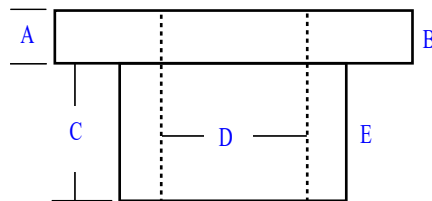
TRANSOM BRACKET KIT FOR 34 1/2" BRAVO DRIVE CENTERS W/-6 JIC BULKHEAD TUBES  
TRANSOM BRACKET KIT FOR 35" BRAVO DRIVE CENTERS W/-6 JIC BULKHEAD TUBES  
TRANSOM BRACKET KIT FOR 35 1/2" BRAVO DRIVE CENTERS W/-6 JIC BULKHEAD TUBES  
TRANSOM BRACKET KIT FOR 36" BRAVO DRIVE CENTERS W/-6 JIC BULKHEAD TUBES



MP-14	CLEVIS ASSEMBLY (3/4" ID BUSHING)	(1/2" DIA BOLT)	(1.375 TALL)
MP-25	CLEVIS ASSEMBLY (7/8" ID BUSHING)	(5/8" DIA BOLT)	(1.762 TALL)
0240	CLEVIS ASSEMBLY (7/8" ID BUSHING)	(5/8" DIA BOLT)	(1.752 TALL)
TB-7	CLEVIS ASSEMBLY (1" ID BUSHING)	(5/8" DIA BOLT)	(1.840 TALL)
TB-40	CLEVIS ASSEMBLY (1 1/4" ID BUSHING)	(7/8" DIA BOLT)	(2.400 TALL)



MP-3	CLEVIS BUSHING (A .148) (B 1.453 OD) (C .533) (D 3/4" ID)	(E 1.133 OD) POLY
0026	CLEVIS BUSHING (A .214) (B 1.453 OD) (C .450) (D 3/4" ID)	(E 1.133 OD) POLY
MP-49	CLEVIS BUSHING (A .145) (B 1.720 OD) (C .570) (D 7/8" ID)	(E 1.387 OD) POLY
TB-18	CLEVIS BUSHING (A .198) (B 1.944 OD) (C .650) (D 1" ID)	(E 1.505 OD) POLY
TB-48	CLEVIS BUSHING (A .215) (B 2.450 OD) (C .850) (D 1 1/4" ID)	(E 1.875 OD) POLY
0239	CLEVIS BUSHING (A .080) (B 1.500 OD) (C .740) (D 7/8" ID)	(E 1.000 OD) BRONZE



SK-1	DRIVE SHOWER KIT ALPHA 25" HOSE
SK-2	DRIVE SHOWER KIT BRAVO 1 OR 2 W/SMOOTH TOP CAP, 25" HOSE
SK-6	DRIVE SHOWER KIT BRAVO 3 W/SMOOTH TOP CAP, 32" HOSE
SK-5	DRIVE SHOWER KIT BRAVO ITS, 27" HOSE
SK-10	DRIVE SHOWER KIT BRAVO 1 OR 2 FIN OR TEAGUE TOP CAP, 25" HOSE
SK-11	DRIVE SHOWER KIT BRAVO 3 FIN TOP CAP, 32" HOSE



EB-12-B EXTENSION BOX KIT W/MOTOR BRKT AND MNT BOLTS (3" RISE ONLY)  
 MB-12-B EXTENSION BOX MOTOR BRKT  
 DS-12-X EXTENSION BOX DRIVE SHAFT (1.328 BEARING CAP DIA)  
 DS-12-S EXTENSION BOX DRIVE SHAFT (1.077 BEARING CAP DIA)  
 DS-13-S EXTENSION BOX DRIVE SHAFT (1.062 BEARING CAP DIA)  
 AT-12 EXTENSION BOX DRIVE SHAFT ALIGNMENT TOOL



DS-1 DRIVE SPACER KIT 1" BRAVO 1 OR 3  
 DS-2 DRIVE SPACER KIT 2" BRAVO 1 OR 3  
 DS-3 DRIVE SPACER KIT 3" BRAVO 1 OR 3  
 DS-003 DRIVE SPACER O-RING KIT



NOTE: WILL NOT WORK WITH BRAVO SPORT MASTER OR IMCO STERN DRIVES,  
 FOR A BRAVO 2 ADD 1 1/4" TO THE REAR BOLT LENGTH

TH-01 HELM POST HUB 2" TALL W/TWO 6 MM BOLT PATTERNS, SS  
 TH-01-2 HELM POST HUB 4" TALL W/TWO 6 MM BOLT PATTERNS, SS  
 TH-01-A HELM POST HUB 2" TALL W/TWO 6 MM BOLT PATTERNS, ALUM  
 0231 HELM POST HUB 4" TALL W/TWO 6 MM BOLT PATTERNS, ALUM  
 0243 HELM POST HUB 2" TALL W/TWO 6 MM BOLT PATTERNS, **BLACK ALUM**  
 0244 HELM POST HUB 4" TALL W/TWO 6 MM BOLT PATTERNS, **BLACK ALUM**  
 AD-21 HELM POST HUB DISCONNECT W/TWO 6 MM BOLT PATTERNS, ALUM  
 AD-25 HELM POST HUB DISCONNECT MALE, SS  
 AD-7 HELM POST HUB HORN BUTTON, ALUM  
 0029 DASHBOARD COVER PLATE 3 1/4" ID X 6" OD, SS



0032 ELECTRIC POWER STEERING PUMP, -6 JIC PRESSURE 1/2" BARB RETURN

NOTE:

1. 12 VDC CONTINUOUS RUNNING
2. AMPS: NO STEERING 12, STEERING 22-44, FULL LOCK 66
3. GPM: 1.8
4. DIMENTIONS: 12" TALL X 6" WIDE X 9 1/4" LONG
5. WEIGHT: 17.8 LBS
6. MAX PRESSURE 800 PSI
7. MAX HELM CONTROL SIZE 80CC
8. MUST HAVE FRESH AIR FOR COOLING



HP-0	HELM POST ASSEMBLY (FIXED 90° X 3") DASH BOARD TO HUB FACE, SS
HP-2	HELM POST ASSEMBLY (FIXED 90° X 5") DASH BOARD TO HUB FACE, SS
HP-5	HELM POST ASSEMBLY (FIXED 90° X 7") DASH BOARD TO HUB FACE, SS
HP-8	HELM POST ASSEMBLY (FIXED 90° X 11") DASH BOARD TO HUB FACE, SS
HP-4	HELM POST ASSEMBLY (FIXED 15° X 5") DASH BOARD TO HUB FACE, SS
HP-7	HELM POST ASSEMBLY (FIXED 15° X 8") DASH BOARD TO HUB FACE, SS
HP-10	HELM POST ASSEMBLY (FIXED 15° X 11") DASH BOARD TO HUB FACE, SS
HP-16	HELM POST ASSEMBLY (TILT X 4 5/8") DASH BOARD TO HUB FACE, SS
HP-19	HELM POST ASSEMBLY (TILT X 7") DASH BOARD TO HUB FACE, SS
HP-19-9	HELM POST ASSEMBLY (TILT X 9") DASH BOARD TO HUB FACE, SS
HP-14	HELM POST ASSEMBLY (TILT X 7") DASH BOARD TO HUB FACE, ALUM
HP-14-9	HELM POST ASSEMBLY (TILT X 9") DASH BOARD TO HUB FACE, ALUM
HP-14-A	HELM POST ASSEMBLY (TILT X 7") DASH BOARD TO HUB FACE, <b>BLACK ALUM</b>
HP-14-B	HELM POST ASSEMBLY (TILT X 9") DASH BOARD TO HUB FACE, <b>BLACK ALUM</b>



- NOTE:
1. STEERING WHEEL AND HELM CONTROL NOT INCLUDED
  2. 15° HELM POST CAN BE TURNED UP OR DOWN
  3. TILT HELM HAS 5 ADJUSTMENTS, 90° STRAIGHT, 10° & 20° DOWN, 10° & 20° UP

		PER REVOLUTION	POWER STEERING PUMPS
HC-13	HELM CONTROL	50 CC	1 MIN. 2 MAX.
HC-1	HELM CONTROL	80 CC	1 MIN. 2 MAX.
HC-7	HELM CONTROL	100 CC	1 MIN. 2 MAX.
HC-2	HELM CONTROL	125 CC	1 MIN. 2 MAX.
HC-3	HELM CONTROL	160 CC	MIN. DRILL ORIFICE TO A .170 DIA. 2 MAX.
HC-9	HELM CONTROL	185 CC	2 MIN. 2 MAX.
HC-4	HELM CONTROL	230 CC	2 MIN. 2 MAX.
HC-10	HELM CONTROL	295 CC	2 MIN. 2 MAX.



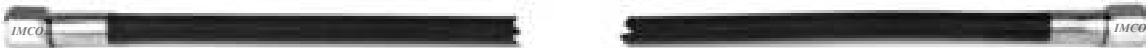
- |       |                                  |                                 |
|-------|----------------------------------|---------------------------------|
| NOTE: | HELM CONTROL SPECIFICATIONS      | SAGINAW PUMP SPECIFICATIONS     |
|       | 1. FLOW RATE 2 TO 8 GPM          | 1. FLOW RATE 1 1/2 TO 3 1/2 GPM |
|       | 2. MAX PRESSURE 2500 PSI         | 2. MAXIMUM PRESURE 1300 PSI     |
|       | 3. OPEN CENTER NON LOAD REACTION |                                 |
|       | 4. 3/4-16 O-RING PORTS           |                                 |

DID YOU KNOW 100% OF IMCO'S CRIMP HOSE AND HOSE ENDS ARE MADE TO IMCO'S SPECIFICATIONS!  
 FOR MARINE USE IN FRESH OR SALT WATER YOU SIMPLY WILL NOT FIND THIS QUALITY  
 OF A HOSE ASSEMBLY ANYWHERE ELSE ON THIS PLANET!



- NOTE: HP = 2500 PSI MAX
- HO-24 HOSE HP CRIMP 1/4" (PER INCH)
  - HO-10 HOSE END HP CRIMP 1/4" TO -4 JIC SS
  - HO-13 HOSE HP CRIMP 3/8" (PER INCH)
  - HO-3 HOSE END HP CRIMP 3/8" TO -6 JIC SS
  - HO-14 HOSE HP CRIMP 1/2" (PER INCH)
  - HO-9 HOSE END HP CRIMP 1/2" TO -8 JIC SS

**MADE TO ORDER**



- NOTE: HP = 2500 PSI MAX
- HO-6 HOSE ASSEMBLY HP CRIMP 3/8" X 20" W/-6 JIC SS HOSE ENDS
  - HO-8 HOSE ASSEMBLY HP CRIMP 3/8" X 30" W/-6 JIC SS HOSE ENDS
  - HO-40 HOSE ASSEMBLY HP CRIMP 3/8" X 40" W/-6 JIC SS HOSE ENDS
  - HO-50 HOSE ASSEMBLY HP CRIMP 3/8" X 50" W/-6 JIC SS HOSE ENDS
  - HO-60 HOSE ASSEMBLY HP CRIMP 3/8" X 60" W/-6 JIC SS HOSE ENDS
  - HO-25 HOSE ASSEMBLY HP CRIMP 1/4" X 16" W/-4 JIC SS HOSE ENDS (TRIM RAM)
  - HO-28 HOSE ASSEMBLY HP CRIMP 1/4" X 20" W/-4 JIC SS HOSE ENDS (TRIM RAM)

**PRE MADE**



- NOTE: HP = 2500 PSI MAX
- HO-1 HOSE HP FIELD ATTACH 5/16" (PER INCH)
  - FA-3 HOSE END HP FIELD ATTACH 5/16" TO -6 JIC
  - FA-35 HOSE END MANDREL -6 JIC
  - HO-4 HOSE HP FIELD ATTACH 13/32" (PER INCH)
  - FA-2 HOSE END HP FIELD ATTACH 13/32" TO -8 JIC
  - FA-1 HOSE END MANDREL -8 JIC

**DO IT YOURSELF**



(NOT RECOMENDED FOR USE OUTSIDE OF THE BOAT)

- NOTE: LP = 250 PSI MAX
- HO-2 HOSE LP FIELD ATTACH 3/8" (PER INCH)
  - FA-5 HOSE END LP FIELD ATTACH 3/8" TO -6 JIC BRASS
  - HO-5 HOSE LP FIELD ATTACH 1/2" (PER INCH)
  - FA-4 HOSE END LP FIELD ATTACH 1/2" TO -8 JIC BRASS

**DO IT YOURSELF**



MP-65 THIN NYLOC NUT (1/2-20) SS  
 MP-50 THIN NYLOC NUT (5/8-18) SS  
 MP-51 THIN NYLOC NUT (3/4-16) SS  
 MP-66 THIN NYLOC NUT (7/8-14) SS



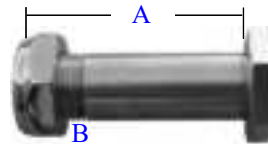
MP-96 FULL NYLOC NUT (1/2-20) SS  
 MP-70 FULL NYLOC NUT (5/8-18) SS  
 MP-54 FULL NYLOC NUT (3/4-16) SS  
 MP-57 FULL NYLOC NUT (7/8-14) SS  
 MP-53 FULL NYLOC NUT (1-14) SS  
 MP-56 FULL NUT (1 1/4-12) SS



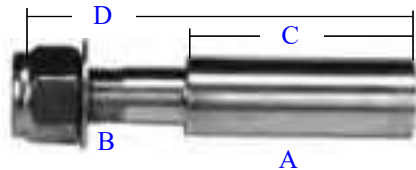
SW-17 BEVELED WASHER (5/8" ID) (1 1/2" OD) (.200 THICK) SS  
 0203 BEVELED WASHER (5/8" ID) (1 3/4" OD) (.200 THICK) SS  
 TB-14 BEVELED WASHER (3/4" ID) (2" OD) (.300 THICK) SS  
 TB-45 BEVELED WASHER (7/8" ID) (2 1/2" OD) (.375 THICK) SS  
 0061 BEVELED WASHER (1 1/4" ID) (3" OD) (.250 THICK) SS



MP-7 CLEVIS BOLT ASSEMBLY (A 1.600) (B 1/2-20) SS  
 MP-4 CLEVIS BOLT ASSEMBLY (A 1.955) (B 5/8-18) SS  
 TB-13 CLEVIS BOLT ASSEMBLY (A 2.280) (B 5/8-18) SS  
 TB-46 CLEVIS BOLT ASSEMBLY (A 2.870) (B 7/8-14) SS



MP-12 CLEVIS PIN ASSEMBLY (A 3/4" OD) (B 1/2-20) (C 2.000) (D 2.800) SS (TRANSOM BRACKETS)  
 MP-9 CLEVIS PIN ASSEMBLY (A 3/4" OD) (B 1/2-20) (C 2.060) (D 3.200) SS (2 EAR STER CAP)  
 MP-8 CLEVIS PIN ASSEMBLY (A 3/4" OD) (B 1/2-20) (C 4.040) (D 5.190) SS (3 EAR STER CAP)  
 0230 CLEVIS PIN ASSEMBLY (A 7/8" OD) (B 5/8-18) (C 2.600) (D 4.360) SS (MERCURY MARINE)



MP-13 CLEVIS STUD ASSEMBLY (A 3/4" OD) (B 3/4-16) (C .500) (D 3.960) (E 5/8-18) SS  
 0199 CLEVIS STUD ASSEMBLY (A 3/4" OD) (B 3/4-16) (C 1.50) (D 4.960) (E 5/8-18) SS  
 0229 CLEVIS STUD ASSEMBLY (A 7/8" OD) (B 7/8-14) (C 1.50) (D 5.600) (E 5/8-18) SS  
 TB-17 CLEVIS STUD ASSEMBLY (A 1" OD) (B 1-14) (C .750) (D 5.370) (E 3/4-16) SS  
 TB-20 CLEVIS STUD ASSEMBLY (A 1" OD) (B 1-14) (C 1.50) (D 8.120) (E 3/4-16) SS  
 TB-43 CLEVIS STUD ASSEMBLY (A 1 1/4" OD) (B 1 1/4-12) (C 1.00) (D 6.250) (E 7/8-14) SS



RAM PARTS ARE FOR REFERENCE ONLY AND NOT SOLD SEPARATE TO ANYONE!  
 TO INSURE PROPER RAM REPAIR ALL RAMS MUST BE SENT TO IMCO NV.

P/N	DESCRIPTION
P-1	RAM PISTON ASS
GC-2	RAM CYLINDER CAP ASS 1" ROD HOLE
GC-3	RAM CYLINDER CAP ASS 5/8" ROD HOLE



P/N	DESCRIPTION
C-6	RAM CYLINDER ASS 6 1/4" STROKE
C-7	RAM CYLINDER ASS 7 1/4" STROKE
C-8	RAM CYLINDER ASS 8 1/4" STROKE
C-9	RAM CYLINDER ASS 9 1/4" STROKE
C-10	RAM CYLINDER ASS 10 1/4" STROKE
TC-7	RAM TRIM CYLINDER ASS 7 1/4" STROKE
TC-6	RAM TRIM CYLINDER ASS 6 1/4" STROKE IMCO CA



P/N	DESCRIPTION
R-5-12	RAM ROD ASS 5/8" DIA X 12"
R-5-13	RAM ROD ASS 5/8" DIA X 13"
R-5-14	RAM ROD ASS 5/8" DIA X 14"
R-5-15	RAM ROD ASS 5/8" DIA X 15"
R-5-16	RAM ROD ASS 5/8" DIA X 16"



P/N	DESCRIPTION
R-1-11	RAM ROD ASS 1" DIA X 11"
R-1-12	RAM ROD ASS 1" DIA X 12"
R-1-13	RAM ROD ASS 1" DIA X 13"
R-1-14	RAM ROD ASS 1" DIA X 14"
R-1-15	RAM ROD ASS 1" DIA X 15"
R-1-16	RAM ROD ASS 1" DIA X 16"
R-1-17	RAM ROD ASS 1" DIA X 17"
R-1-18	RAM ROD ASS 1" DIA X 18"
R-1-19	RAM ROD ASS 1" DIA X 19"
R-1-20	RAM ROD ASS 1" DIA X 20"
R-1-21	RAM ROD ASS 1" DIA X 21"
R-1-22	RAM ROD ASS 1" DIA X 22"
TR-1-16	RAM TRIM ROD ASS 1" DIA X 16"



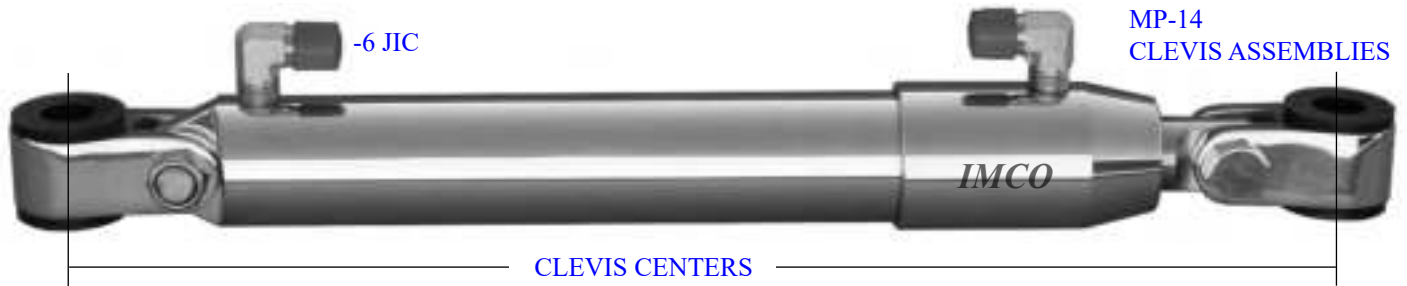


NOTE: 2 OR 4 RAM STEERING KITS USE 1" DIA RODS

- SR-6-1-12 RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 15 9/16" OPEN 21 7/8")
- SR-8-1-13 RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
- SR-8-1-14 RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 18 1/8" OPEN 26 3/8")
- SR-8-1-15 RAM ASSEMBLY (1" DIA ROD) (CLEVIS CENTERS CLOSED 19 1/8" OPEN 27 3/8")

NOTE: 1 RAM STEERING KITS USE A 5/8" DIA ROD

- SR-6-5-12 RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 15 9/16" OPEN 21 7/8")
- SR-8-5-13 RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 17 1/8" OPEN 25 3/8")
- SR-8-5-14 RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 18 1/8" OPEN 26 3/8")
- SR-8-5-15 RAM ASSEMBLY (5/8" DIA ROD) (CLEVIS CENTERS CLOSED 19 1/8" OPEN 27 3/8")



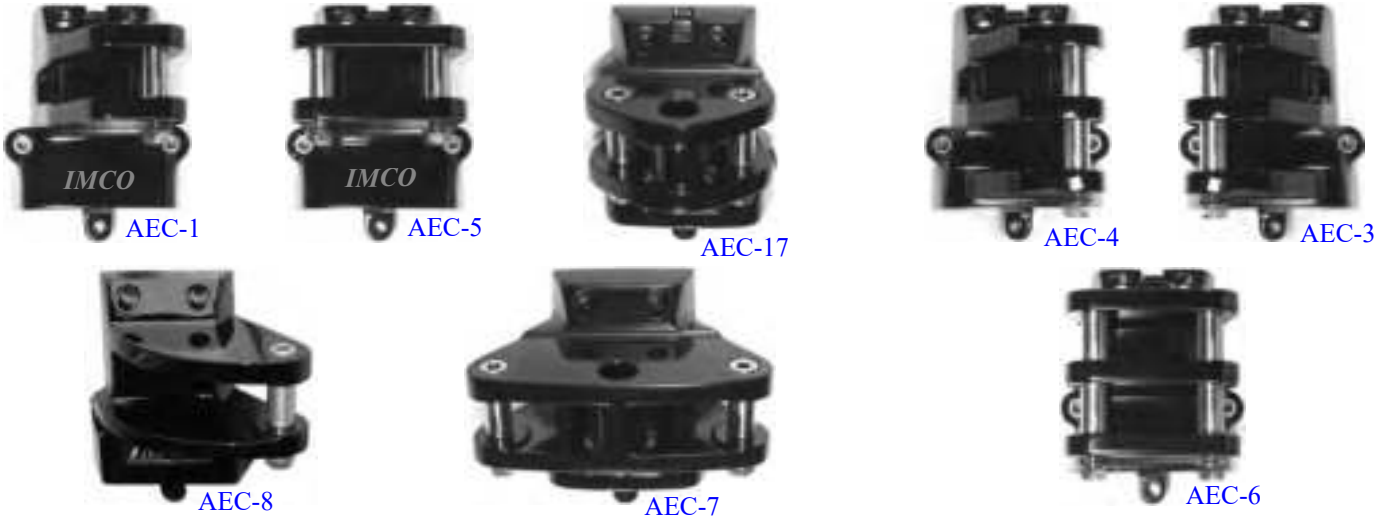
NOTE: ABOVE ARE THE MOST COMMON STEERING RAMS USED WITH IMCO STEERING KITS!  
IF YOU HAVE SOMETHING SPECIAL JUST TELL US YOUR CLOSED AND OPEN DIMENSIONS  
AND WE CAN MOST LIKELY MAKE IT HAPPEN!

- TR-7-16-L RAM ASSEMBLY TRIM LH W/HOSES (STOCK BRAVO REPLACEMENT)
- TR-7-16-R RAM ASSEMBLY TRIM RH W/HOSES (STOCK BRAVO REPLACEMENT)



**DID YOU KNOW IMCO INVENTED THE 5 BOLT STEERING CAP!**

- AEC-1 STER CAP KIT MERC BRAVO 2 EAR RH 1 5/8" CLEVIS PIN OFFSET
- AEC-4 STER CAP KIT MERC BRAVO 3 EAR RH 1 5/8" CLEVIS PIN OFFSET
- AEC-3 STER CAP KIT MERC BRAVO 3 EAR LH 1 5/8" CLEVIS PIN OFFSET
- AEC-8 STER CAP KIT MERC BRAVO 2 EAR RH 3 1/4" CLEVIS PIN OFFSET
- AEC-7 STER CAP KIT MERC BRAVO 2 EAR 3 1/4" CLEVIS PIN OFFSET, 1" CENTER HOLE
- AEC-17 STER CAP KIT MERC BRAVO 2 EAR 1 5/8" CLEVIS PIN OFFSET, OPTIONAL 1" CENTER HOLE
- AEC-6 STER CAP KIT MERC BRAVO 3 EAR 1 5/8" CLEVIS PIN OFFSET
- AEC-5 STER CAP KIT MERC BRAVO 2 EAR 1 5/8" CLEVIS PIN OFFSET



- PT-30 OIL TANK ASSEMBLY 1 OR 2 PUMP RESERVOIR WITH -8 JIC RETURN/EXIT ADAPTERS
- PT-6 OIL TANK ASSEMBLY 1 OR 2 PUMP RECIRCULATING WITH -6 JIC RETURN, -10 JIC EXIT ADAPTERS
- 0273 OIL TANK CAP ASSEMBLY



- HO-2 HOSE LP FIELD ATTACH -6 3/8" (PER INCH)
- HO-5 HOSE LP FIELD ATTACH -8 1/2" (PER INCH)
- HO-16 HOSE LP FIELD ATTACH -10 5/8" (PER INCH)



- 0069 HOSE END LP FIELD ATTACH 3/8" TO -6 JIC STRAIGHT
- 0072 HOSE END LP FIELD ATTACH 3/8" TO -6 JIC 90°
- 0070 HOSE END LP FIELD ATTACH 1/2" TO -8 JIC STRAIGHT
- 0073 HOSE END LP FIELD ATTACH 1/2" TO -8 JIC 90°
- 0071 HOSE END LP FIELD ATTACH 5/8" TO -10 JIC STRAIGHT
- 0074 HOSE END LP FIELD ATTACH 5/8" TO -10 JIC 90°



- PT-10 PUMP CAP ASSEMBLY



TB-33  
TB-4

TIE BAR ASSEMBLY 2 1/4" DIA X 18" LONG WITH 1 1/4" ID CLEVIS' (MAX LENGTH 120")  
TIE BAR PER INCH 2 1/4" DIA



0264  
0265  
0274

WING PLATE KIT LONG FOR MERC M6, M8 DRIVES (UNDER MOUNT V-BOTTOM)  
WING PLATE KIT SHORT FOR MERC M6, M8 DRIVES (TOP MOUNT CAT)  
WING PLATE SUPORT BOLT KIT FOR M8 DRIVES ONLY (NOT INCLUDED WITH WING PLATE)



TB-71

TIE BAR KIT FOR MERC M6, M8 DRIVES 4 3/4" DROP TO CENTER DRIVE  
24" MAX DRIVE CENTERS



TB-75

TIE BAR KIT FOR MERC BRAVO ITS DRIVES 4 1/2" DROP TO CENTER DRIVE  
24" MAX DRIVE CENTERS



TB-77

TIE BAR KIT FOR MERC BRAVO DRIVES 4" OF DROP TO CENTER DRIVE,  
24" MAX DRIVE CENTERS

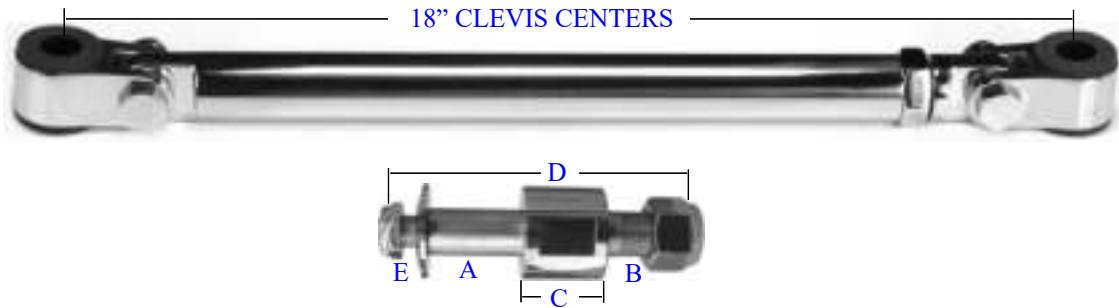


TB-100

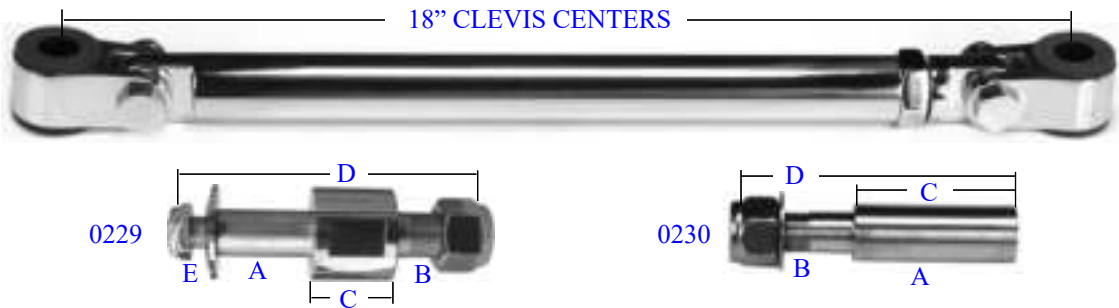
TIE BAR KIT FOR MERC BRAVO DRIVES 8" OF DROP TO CENTER DRIVE,  
24" MAX DRIVE CENTERS  
NOTE: PLEASE INDICATE IF YOU HAVE SMOOTH OR FINN TOP STYLE DRIVES



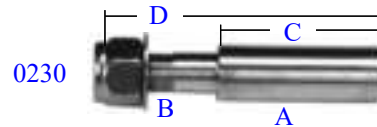
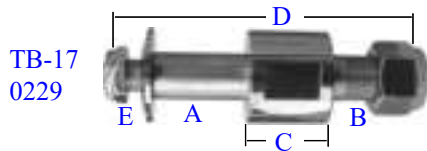
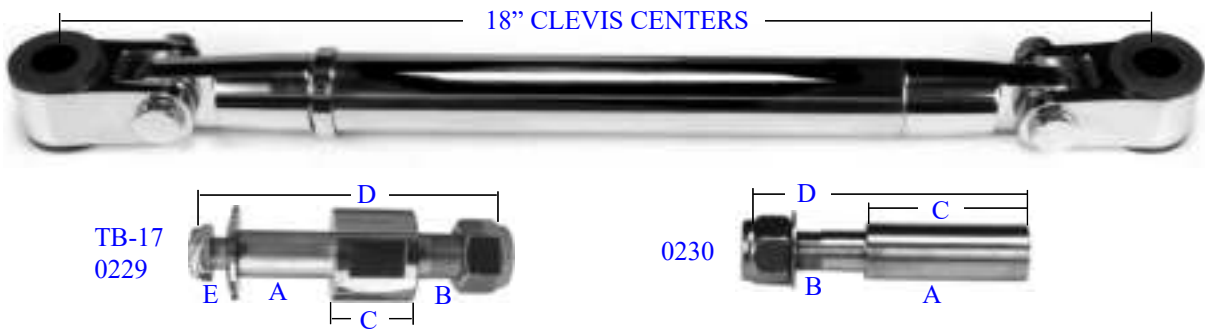
TB-6 TIE BAR ASSEMBLY 1 1/4" DIA X 18" WITH 3/4" ID CLEVIS' (MAX LENGTH 60")  
 TB-2 TIE BAR PER INCH 1 1/4" DIA  
 MP-13 CLEVIS STUD ASSEMBLY (A 3/4" OD) (B 3/4-16) (C 1/2") (D 4") (E 5/8-18)  
 0199 CLEVIS STUD ASSEMBLY (A 3/4" OD) (B 3/4-16) (C 1 1/2") (D 5") (E 5/8-18)



TB-27 TIE BAR ASSEMBLY 1 3/8" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 80")  
 TB-3 TIE BAR PER INCH 1 3/8" DIA  
 0229 CLEVIS STUD ASSEMBLY (A 7/8" OD) (B 7/8-14) (C 1 1/2") (D 5 5/8") (E 5/8-18)  
 0230 CLEVIS PIN ASSEMBLY (A 7/8" OD) (B 5/8-18) (C 2 5/8") (D 4 3/8") SS (MERCURY MARINE)



TB-97 TIE BAR ASSEMBLY 1 3/4" DIA X 18" LONG WITH 7/8" ID CLEVIS' (MAX LENGTH 100")  
 TB-29 TIE BAR ASSEMBLY 1 3/4" DIA X 18" LONG WITH 1" ID CLEVIS' (MAX LENGTH 100")  
 TB-1 TIE BAR PER INCH 1 3/4" DIA  
 TB-17 CLEVIS STUD ASSEMBLY (A 1" OD) (B 1-14) (C 3/4") (D 5 3/8") (E 3/4-16)  
 0229 CLEVIS STUD ASSEMBLY (A 7/8" OD) (B 7/8-14) (C 1 1/2") (D 5 5/8") (E 5/8-18)  
 TB-20 CLEVIS STUD ASSEMBLY (A 1" OD) (B 1-14) (C 1 1/2") (D 8 1/8") (E 3/4-16)  
 0230 CLEVIS PIN ASSEMBLY (A 7/8" OD) (B 5/8-18) (C 2 5/8") (D 4 3/8") SS (MERCURY MARINE)



FOR STER CAPS WITH A 1" CENTER HOLE

WP-11-LR  
WP-11-C

WING PLATE KIT MERC PROMAX 3L/300 X, 1 RAM 1 TIE BAR  
WING PLATE KIT MERC PROMAX 3L/300 X, 2 TIE BARS



WP-11-LR



WP-11-C

WP-9-LR  
WP-9-C

WING PLATE KIT MERC 2.5L/EFI, 1 RAM 1 TIE BAR  
WING PLATE KIT MERC 2.5L/EFI, 2 TIE BARS



WP-9-LR



WP-9-C

WP-26-LR  
WP-26-C

WING PLATE KIT MERC 200, 225, 300 XS, 1 RAM 1 TIE BAR  
WING PLATE KIT MERC 200, 225, 300 XS, 2 TIE BARS



WP-26-LR



WP-26-C

TP-1

TILT PIN ASSEMBLY (FITS ALL MERC OUTBOARD MOTOR BRACKETS)



WP-25-LR WING PLATE KIT EVINRUDE V6 E-TEC 250 HO, 1 RAM



TP-8 TILT PIN ASSEMBLY EVINRUDE V6 1992 & LATER



WP-6-LR WING PLATE KIT MERC TRS 2 RAMS  
WP-6-R WING PLATE KIT MERC TRS RH 1 RAM  
WP-6-LT WING PLATE KIT MERC TRS LH 1 RAM 1 TIE BAR  
WP-6-RT WING PLATE KIT MERC TRS RH 1 RAM 1 TIE BAR

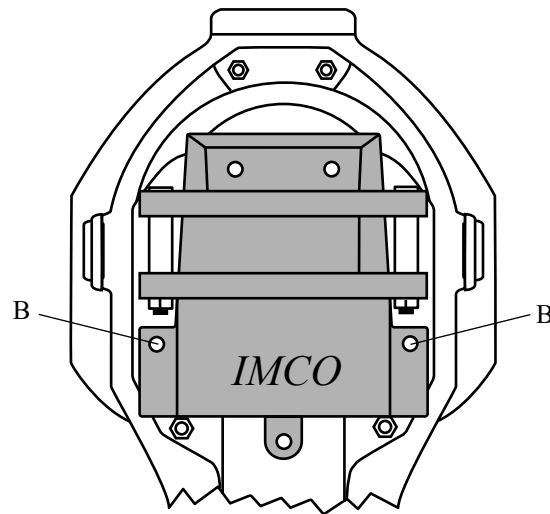


WP-14-L WING PLATE KIT MERC ALPHA LH 1 RAM  
WP-14-R WING PLATE KIT MERC ALPHA RH 1 RAM  
WP-17 WING PLATE KIT MERC ALPHA 2 RAMS



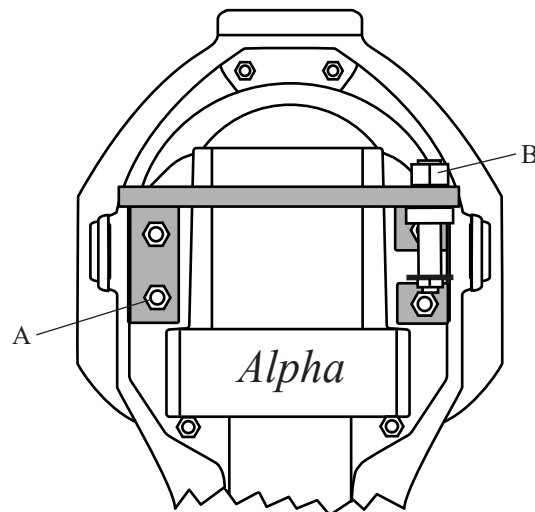
## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO STEER CAPS

- A. USING A CLEAN CONTAINER DRAIN OIL FROM STERN DRIVE, REMOVE STOCK BRAVO SHIFT COVER AND TAPE OVER OPENING LEAVING THE THREE BOLT HOLES CLEAR
- B. BOLT ON STEERING CAP (USE WD-40 OR SIMILAR TO HELP DRILL & TAP HOLES) USE A 3/8" DRILL BIT AND SPOT DRILL 1/8" DEEP, REMOVE STEERING CAP AND DRILL 5/16" X 1 1/4" DEEP, TAP HOLES 3/8-16 X 3/4" DEEP PERFECT THREAD, CLEAN ALL BOLT HOLES AND REMOVE TAPE
- C. REMOVE O-RING AND DETENT PIN FROM STOCK BRAVO SHIFT COVER AND INSTALL IN STEERING CAP
- D. INSTALL STEERING CAP, TORQUE BOLTS @ 35 FT LBS
- E. (FROM THE BOTTOM) REFILL STERN DRIVE WITH DRAINED OR NEW OIL



## INSTALLATION INSTRUCTIONS FOR IMCO-NV ALPHA WING PLATE

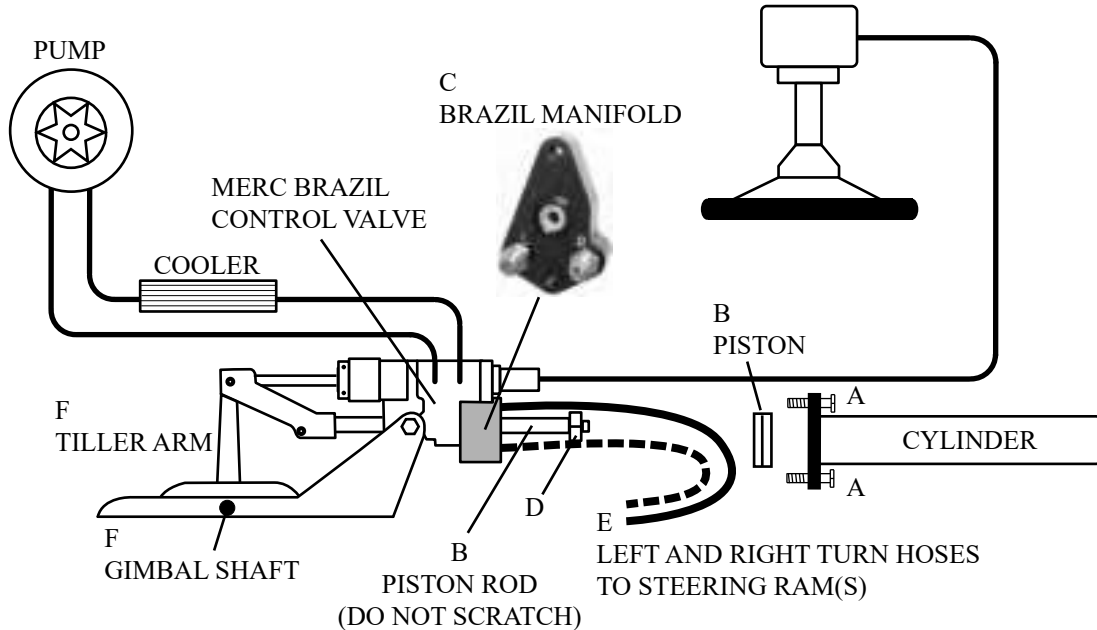
- A. REMOVE THE TOP FOUR 7/16" NUTS & WASHERS THAT HOLD THE STERN DRIVE TO THE GIMBAL ASSEMBLY, INSTALL WING PLATE USING THE STOCK NUTS ONLY (NO WASHERS) TORQUE TO 60 FT LBS
- B. INSTALL CLEVIS STUD AS SHOWN ON DRAWING, TORQUE NUT @ 120 FT LBS





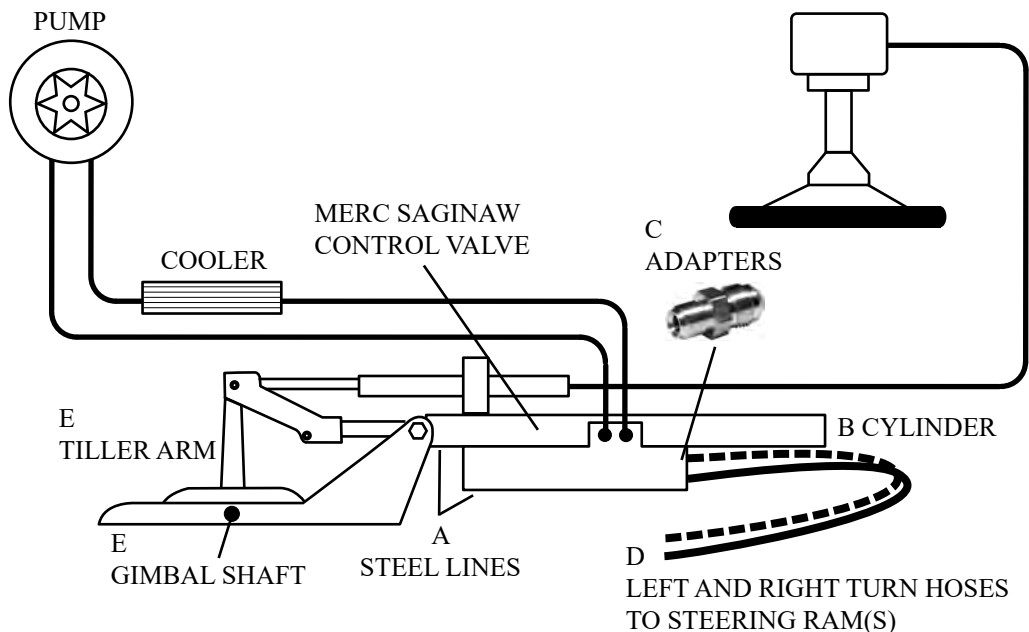
## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAZIL MANIFOLD

- A. REMOVE BOLTS THAT ATTACH THE CYLINDER TO THE CONTROL VALVE, REMOVE CYLINDER SLOWLY AND TAKE NOTE ON THE TWO O-RING LOCATIONS
- B. REMOVE PISTON CAREFULLY (DO NOT SCRATCH PISTON ROD)
- C. SLIDE MANIFOLD OVER PISTON ROD (BE SURE THAT BOTH O-RINGS ARE IN PLACE) USE STOCK BOLTS AND TIGHTEN EVENLY
- D. INSTALL LOCK NUT PROVIDED ON END OF PISTON ROD (DO NOT SCRATCH PISTON ROD)
- E. INSTALL LEFT AND RIGHT TURN HOSES PER DRAWING
- F. BE SURE THAT THE TILLER ARM IS TIGHT TO THE GIMBAL SHAFT OR BUMP STEERING WILL OCCUR



## INSTALLATION INSTRUCTIONS FOR IMCO-NV SAGINAW ADAPTERS

- A. REMOVE THE STEEL HYDRAULIC LINES THAT CONNECT THE STEERING CYLINDER TO THE CONTROL VALVE
- B. DRAIN FLUID IN CYLINDER BY TURNING STEERING WHEEL LOCK TO LOCK (LEAVE PORTS OPEN ON CYLINDER)
- C. INSTALL PROVIDED ADAPTERS IN VALVE, SEALANT NOT REQUIRED
- D. INSTALL LEFT AND RIGHT TURN HOSES PER DRAWING
- E. BE SURE THAT THE TILLER ARM IS TIGHT TO THE GIMBAL SHAFT OR BUMP STEERING WILL OCCUR

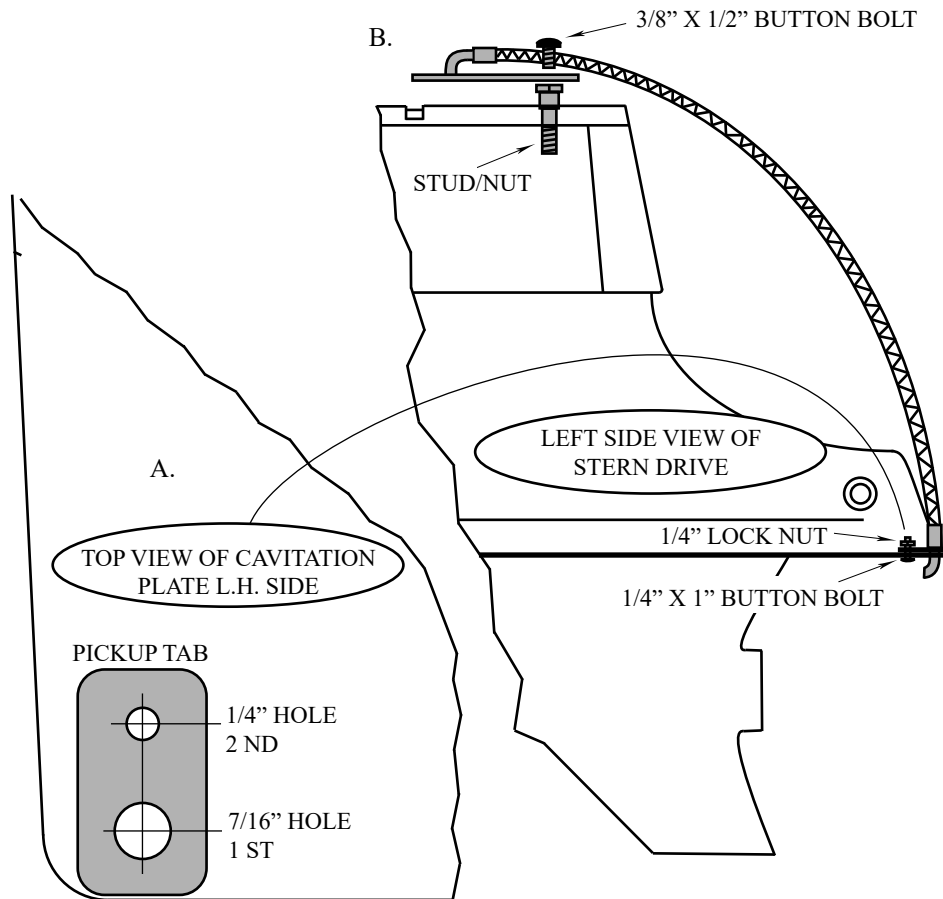


# INSTALLATION INSTRUCTIONS FOR IMCO-NV DRIVE SHOWERS

NOTE: DRAWING SHOWS PROPER LOCATION FOR A R.H. ROTATING PROPLER, FOR A L.H. ROTATING PROPLER SWITCH SIDES.

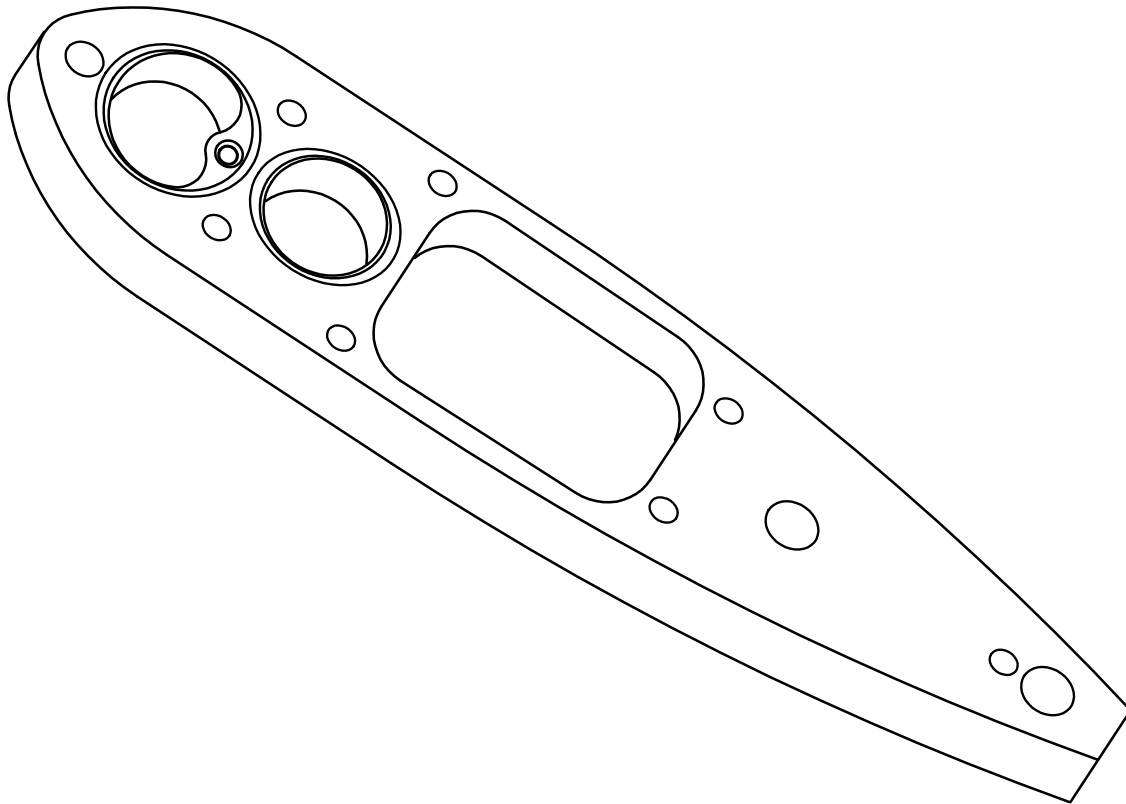
- A. LOCATE PICKUP ON CAVITATION PLATE PER DRAWING AND DRILL THE 7/16" HOLE FIRST, INSTALL PICKUP AND DRILL THE 1/4" HOLE, INSTALL 1/4" NUT AND BOLT PROVIDED
- B. REMOVE THE TOP TWO REAR BOLTS OR NUTS (THIS WILL DEPEND ON WHICH STERN DRIVE YOU HAVE) INSTALL NEW STUDS OR NUTS AND TIGHTEN TO 35 FT LBS, INSTALL DRIVE SHOWER USING THE 3/8" BUTTON BOLTS TIGHTEN TO 15 FT LBS.

CAUTION: CHECK FOR CLEARANCE BEFORE TRIMMING DRIVE ALL THE WAY UP, ADJUST ACCORDINGLY



## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO DRIVE SPACERS ON MERCURY BRAVO STERN DRIVES

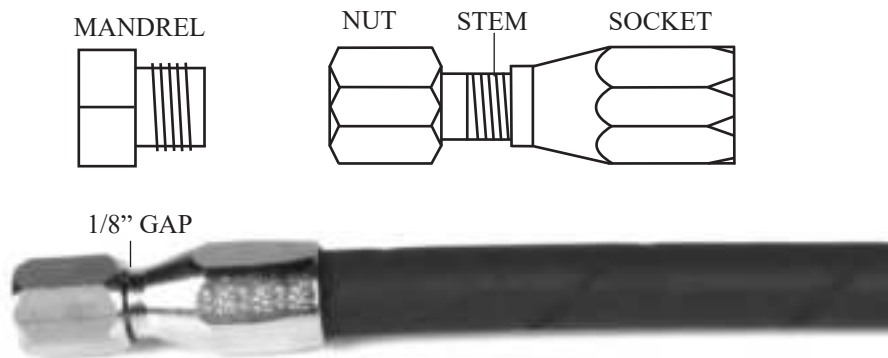
- A. DRAIN DRIVE OIL INTO A CLEAN CONTAINER
- B. SEPARATE UPPER AND LOWER GEAR CASES
- C. REMOVE DRIVE SHAFT SPLINE COUPLER
- D. REMOVE 7/16" STUDS 4EA ON UPPER AND 2EA ON LOWER GEAR CASES
- E. INSTALL NEW STUDS USING LOCTITE, BE SURE ALL HOLES ARE CLEAN AND DRY FIRST!
- F. CHECK THAT ALL STOCK O-RINGS & SPEEDO GROMMET ARE IN PLACE ON LOWER GEAR CASE
- G. PLACE DRIVE SPACER ON LOWER GEAR CASE
- H. INSTALL ALUMINUM LOCATOR BUSHING, SPEEDO GROMMET & O-RINGS ON DRIVE SPACER
- I. FOR MULTIPLE SPACERS KEEP STACKING AND ADDING, SPEEDO GROMMET & O-RINGS
- J. INSTALL NEW DRIVE SHAFT SPLINE COUPLER
- K. RE ASSEMBLE UPPER AND LOWER GEAR CASES
- L. PUT DRIVE OIL BACK IN GEAR CASE





## INSTALLATION INSTRUCTIONS FOR IMCO-NV FIELD ATTACHABLE HOSE FITTINGS

- A. WHEN CUTTING THIS HOSE, USE ONLY AN ABRASIVE WHEEL CUT-OFF SAW AND NOTHING ELSE! BE SURE ALL CUTS ARE SQUARE AND CLEAN!
- B. LOCK MANDREL INTO NUT & STEM USING TWO BOX END WRENCHES (BE FIRM) REMOVE SOCKET FROM STEM
- C. (USING A BENCH VICE WITH V-JAWS) CLAMP HOSE INTO V-JAWS HORIZONTALLY WITH APPROXIMATELY 2" HANGING OUT, SCREW SOCKET (COUNTER CLOCKWISE) ONTO HOSE UNTIL SOCKET BOTTOMS, BE GENTLE DO NOT OVER TIGHTEN SOCKET OR YOU WILL DAMAGE THE HOSE! BACK SOCKET OFF 1/4 TURN, CHECK INSIDE OF HOSE WITH A FLASHLIGHT BE SURE THAT HOSE END IS OPEN FOR STEM TO BE INSERTED, OPEN VICE AND CLAMP ONTO SOCKET FIRMLY
- D. LUBRICATE STEM AND SOCKET THREADS WITH POWER STEERING FLUID, USE YOUR HAND ONLY TO START STEM INTO SOCKET, YOU WILL FEEL THE STEM SLIP INTO THE END OF THE HOSE BEFORE IT STARTS THREADING INTO THE SOCKET, USING A BOX END WRENCH ON THE MANDREL ONLY SCREW STEM INTO SOCKET CLOCKWISE UNTIL THERE IS A 1/8" GAP BETWEEN THE NUT AND SOCKET, REMOVE MANDREL
- E. USE COMPRESSED AIR TO BLOW OUT THE HOSE AND A FLASHLIGHT TO INSPECT THE INSIDE FOR ANY OBSTRUCTIONS



## IMCO-NV

### FILLING & PURGING FOR AN ENGINE POWER STEERING PUMP SYSTEM

- A. TRIM STERN DRIVE(S) DOWN TO A LEVEL POSITION BE SURE THEY ARE ABLE TO TURN FULL LOCK TO LOCK WITHOUT TOUCHING ANYTHING, ATTACH GARDEN HOSE TO MOTOR/STERN DRIVE THAT WILL POWER THE STEERING SYSTEM, TURN WATER ON
- B. USE POWER STEERING FLUID TO FILL THE PUMP(S), TURN MOTOR OVER FOR 2 SECONDS ONLY! (DO NOT START MOTOR OR TURN THE STEERING WHEEL AT THIS TIME) FILL PUMP(S) REPEAT UNTIL FLUID LEVEL STAYS FULL
- C. START MOTOR FOR 1 SECOND (**DO NOT ALLOW THE PUMP(S) TO SUCK AIR OR IT WILL BE IMPOSSIBLE TO PURGE THE SYSTEM**) FILL PUMP(S), REPEAT UNTIL FLUID LEVEL STAYS FULL WITH MOTOR RUNNING
- D. START MOTOR AND TURN THE STEERING WHEEL A 1/4 TURN, SHUT MOTOR OFF AND FILL THE PUMP(S) **NOTE:** FOR CABLE ASSIST STEERING, IF THE STEERING WHEEL TAKES OFF IN THE OPPOSITE DIRECTION THEN THE LEFT AND RIGHT TURN HOSES ARE CROSSED! CORRECT PROBLEM AND CONTINUE. REPEAT STARTING MOTOR AND TURNING STEERING WHEEL UNTIL THE PUMP(S) STAY FULL FOR A TWIN PUMP SYSTEM REPEAT STEPS A. THRU D. WITH OPPOSITE MOTOR
- E. WITH THE MOTOR(S) RUNNING TRY MOVING THE STERN DRIVE(S) BY HAND, BE FIRM, IF THEY ARE SOILD THEN THE SYSTEM IS COMPLETE, FOR A TWIN PUMP SYSTEM SWITCH MOTORS AND REPEAT THIS STEP, IF THE STERN DRIVE(S) MOVE MORE THEN 2" THEN YOU WILL NEED TO PURGE THE SYSTEM AT THE STEERING RAM(S), WITH THE MOTOR(S) RUNNING AND IN ONE CONTINUOUS MOTION TURN THE STEERING WHEEL WHILE CRACKING OPEN ONE HOSE FITTING AT A TIME, CLOSE FITTING AS SOON AS FLUID STOPS, DO THIS UNTIL ALL AIR IS PURGED AND THE STERN DRIVE(S) ARE SOLID, DON'T FORGET TO FILL THE PUMP(S) AS NEEDED DURING THIS PROCEDURE!

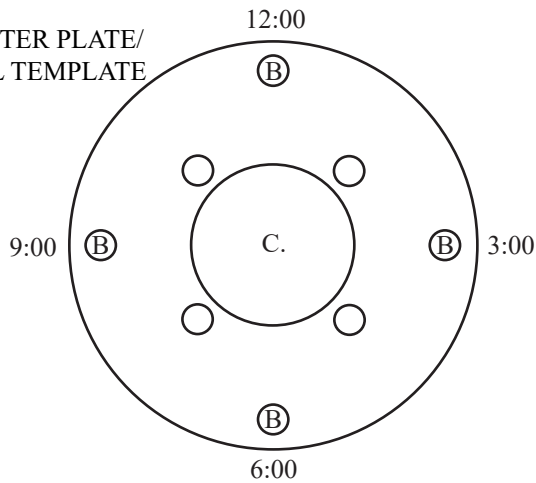
## CLEANING THE STEERING RAM(S)

WITH EXTREME EXHAUST HEAT AND HARD WATER CONDITIONS THE STEERING RAM RODS WILL NEED TO BE CLEANED AS NEEDED! IT IS IMPORTANT THAT THE CAPTAIN OF THE VESSEL PAY CLOSE ATTENTION TO THIS DETAIL! TURN DRIVE(S) TO ONE SIDE EXPOSING THE RAM ROD, CLEAN ROD USING VINEGAR, CLR, LIME AWAY OR SIMILAR, IF MORE THEN ONE RAM REPEAT IN THE OPPOSITE DIRECTION.

# INSTALLATION INSTRUCTIONS FOR IMCO-NV HELM POST AND HELM CONTROL

- A. USE THE ADAPTER PLATE FOR LOCATING HOLES TO BE DRILLED IN DASHBOARD
- B. DRILL 4ea 1/2" HOLES
- C. DRILL 3" CENTER HOLE
- D. ATTACH ADAPTER PLATE TO THE HELM CONTROL USING THE 3/8" BOLTS PROVIDED
- E. INSTALL HELM POST THRU DASHBOARD AND SECURE WITH 1/2" NUTS PROVIDED
- F. FACE OIL PORTS IN THE 12, 3, 6 OR 9 O-CLOCK POSITION INSTALL HELM CONTROL W/ADAPTER PLATE TO END OF STEP STUDS SECURE WITH 3/8" NUTS PROVIDED

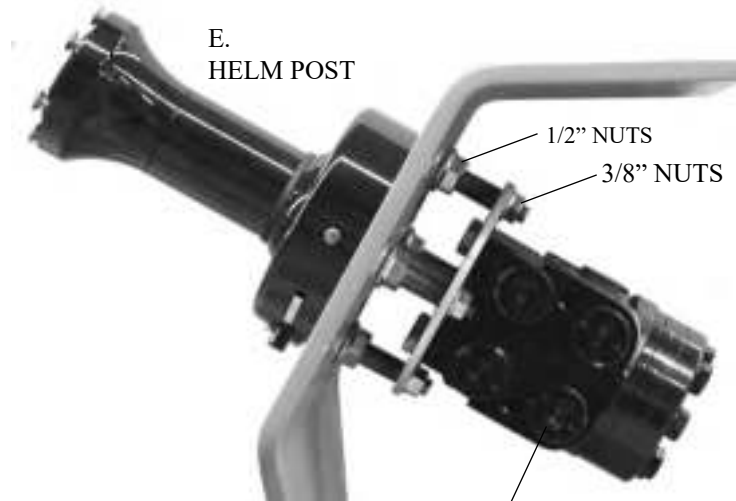
A.  
ADAPTER PLATE/  
DRILL TEMPLATE



D.  
ADAPTER PLATE



E.  
HELM POST



F.  
OIL PORTS

## STEERING WHEEL TURNS LOCK TO LOCK

THIS CHART IS FOR CHOOSING THE CORRECT HELM DISPLACEMENT, NOTE: 3 TO 4 TURNS IS STANDARD

### 1 RAM WITH A 5/8" DIA ROD

HELM DISPLACEMENT	6 1/4" STROKE	7 1/4" STROKE	8 1/4" STROKE	9 1/4" STROKE	10 1/4" STROKE
50 CC	3.5	3.9	4.4	4.8	
80 CC		2.5	2.8	3	3.3
100 CC			2.4	2.6	2.9
	↑	↑	TURNS LOCK TO LOCK		↑

### 2 RAMS WITH 5/8" DIA RODS

HELM DISPLACEMENT	6 1/4" STROKE	7 1/4" STROKE	8 1/4" STROKE	9 1/4" STROKE	10 1/4" STROKE
80 CC	4.4	5			
100 CC	3.8	4.3	4.8		
125 CC	3	3.3	3.6	4.2	4.6
160 CC			2.8	3	3.3
185 CC			2.4	2.6	2.8
	↑	↑	TURNS LOCK TO LOCK		↑

### 2 RAMS WITH 1" DIA RODS

HELM DISPLACEMENT	6 1/4" STROKE	7 1/4" STROKE	8 1/4" STROKE	9 1/4" STROKE	10 1/4" STROKE
80 CC	3.5	4.3	5		
100 CC	3	3.6	4.2	4.9	
125 CC	2.4	2.8	3.2	3.8	4.4
160 CC			2.4	2.8	3.2
185 CC				2.4	2.7
	↑	↑	TURNS LOCK TO LOCK		↑

### 4 RAMS WITH 1" DIA RODS

HELM DISPLACEMENT	6 1/4" STROKE	7 1/4" STROKE	8 1/4" STROKE	9 1/4" STROKE	10 1/4" STROKE
160 CC	3.4	3.7			
185 CC	2.9	3.6	4.2	4.8	
230 CC		2.9	3.4	3.9	4.4
295 CC			2.6	3	3.4
	↑	↑	TURNS LOCK TO LOCK		↑



## STEERING WHEEL TURNS LOCK TO LOCK

THIS CHART IS FOR CHOOSING THE CORRECT HELM DISPLACEMENT, NOTE: 3 TO 4 TURNS IS STANDARD

IMCO STERN DRIVES			
HELM DISPLACEMENT	1 DRIVE	2 DRIVES	3 DRIVES
80 CC	3.5		
100 CC	3		
125 CC	2.3	4.6	
160 CC		3.4	5
185 CC		2.9	4.4
230 CC			3.5
295 CC			2.7

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Turns Lock to Lock

MERC ITS STERN DRIVES			
HELM DISPLACEMENT	1 DRIVE	2 DRIVES	3 DRIVES
80 CC	5.8		
100 CC	4	6.2	
125 CC	3.1	5	
160 CC	2.5	3.6	5.4
185 CC		3	4.7
230 CC		2.5	3.8
295 CC			2.9

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Turns Lock to Lock

MERC M6/M8 STERN DRIVES			
HELM DISPLACEMENT	1 DRIVE	2 DRIVES	3 DRIVES
80 CC	6.5		
100 CC	5.1		
125 CC	4		
160 CC	3	6	
185 CC	2.6	5.2	
230 CC		4.2	6.3
295 CC		3.3	4.9

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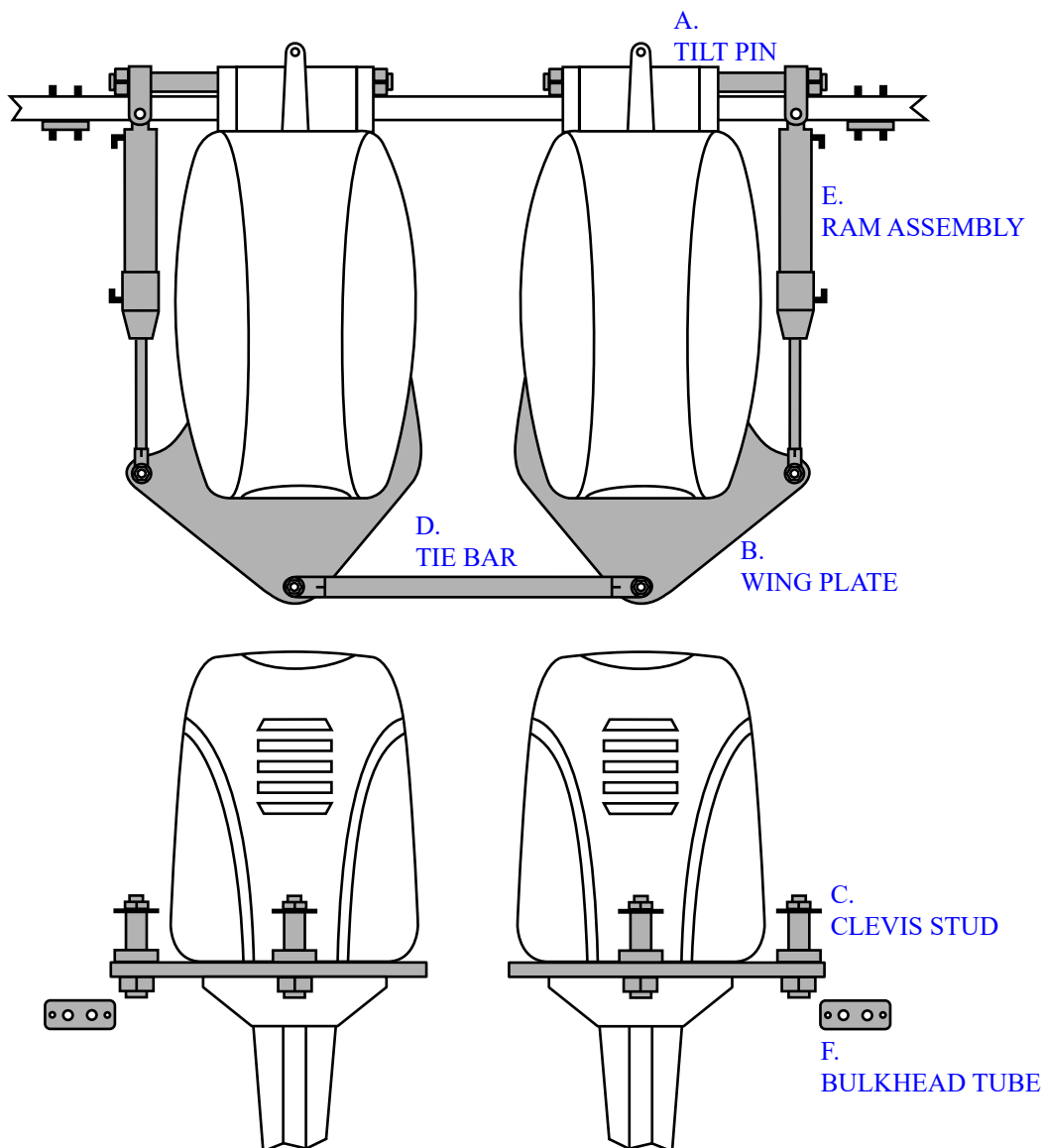
Turns Lock to Lock

## INSTALLATION INSTRUCTIONS FOR IMCO-NV OUTBOARD STEERING

- A. REMOVE THE STOCK TILT TUBE AND REPLACE WITH IMCO TILT PIN TIGHTEN THE 7/8" NUT UNTIL THE TILT PIN IS SNUG, DO NOT OVER TIGHTEN FOR THEY MUST PIVOT!
- B. INSTALL WING PLATE, FOR PROPER FIT IT MAY BE NECESSARY TO TRIM OR REMOVE THE COWLING TORQUE NUTS @ 35 FT LBS, FOR STUDS AND BOLTS PROVIDED USE 1 FULL DROP OF LOCTITE PER STUD/BOLT AND TORQUE @ 40 FT LBS
- C. INSTALL CLEVIS STUD(S) ON WING PLATE PER DRAWING TORQUE 3/4" NUT @ 120 FT LBS
- D. IF APPLICABLE INSTALL TIE BAR PER DRAWING, FOR PROPER MOTOR ALIGNMENT MEASURE PROP SHAFT CENTERS TO NOSE CONE CENTERS, ADJUST UNTIL THEY BECOME EQUAL, INSTALL BEVELED WASHERS AND NYLOC JAM NUTS TORQUE @ 30 FT LBS
- E. INSTALL STEERING RAM PER DRAWING, INSTALL BEVELED WASHERS AND NYLOC JAM NUTS TORQUE @ 30 FT LBS
- F. INSTALL THE BULKHEAD TUBE(S) IN AN AREA WHERE HOSES CAN MOVE FREELY WITH NO TIGHT BENDS, FOR SEALING USE 100% SILICONE

### NOTE:

IT IS IMPORTANT THAT THE CAPTAIN OF THE VESSEL INSPECT ALL STEERING HARDWARE BEFORE EACH USE!



## TRANSOM BRACKET MOUNTING LOCATIONS

### FOR STER CAPS WITH 1 5/8" CLEVIS PIN OFFSET

RAM STROKE	ROD LENGTH	TURN RADIUS	TBML
8 1/4"	13"	48°	11 1/4"
8 1/4"	14"	43°	12 3/4"
9 1/4"	14"	48°	13 3/4"
8 1/4"	15"	40°	14 1/4"
9 1/4"	15"	46°	15 1/4"
10 1/4"	15"	48°	16"
10 1/4"	16"	47°	17 1/4"
10 1/4"	17"	46°	18 1/2"
10 1/4"	18"	45°	19 3/4"
10 1/4"	19"	44°	21"
10 1/4"	20"	43°	22 1/4"
10 1/4"	21"	42°	23 1/2"
10 1/4"	22"	41°	24 3/4"

### FOR STER CAPS WITH 3 1/4" CLEVIS PIN OFFSET

RAM STROKE	ROD LENGTH	TURN RADIUS	TBML
6 1/4"	12"	44°	6 3/8"
6 1/4"			
6 1/4"			
7 1/4"			
7 1/4"			
7 1/4"			

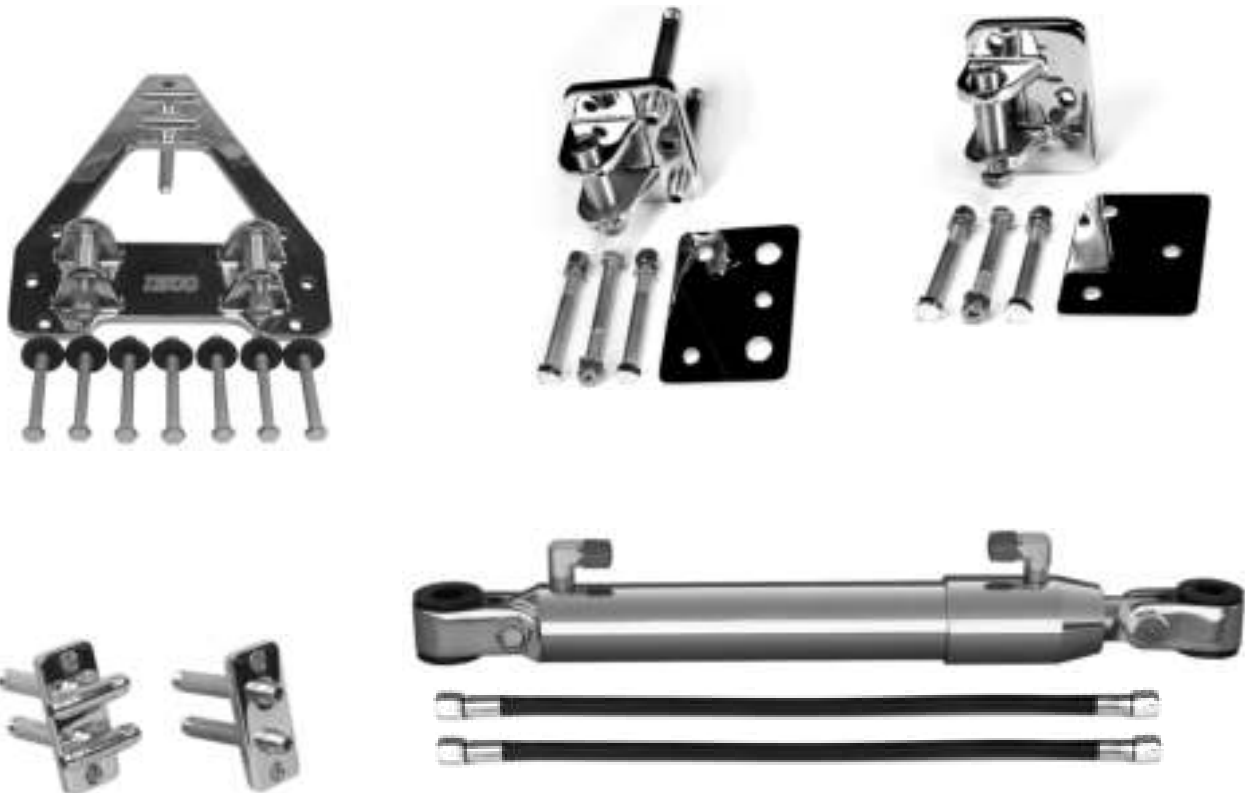
## INSTALLATION INSTRUCTIONS FOR IMCO-NV TIE BARS

REMOVE THE INTERNAL TIE BAR, INSTALL EXTERNAL TIE BAR PER DRAWING PROVIDED, FOR PROPER STERN DRIVE ALIGNMENT MEASURE PROP SHAFT CENTERS TO NOSE CONE CENTERS, ADJUST TIE BAR UNTIL THEY BECOME EQUAL



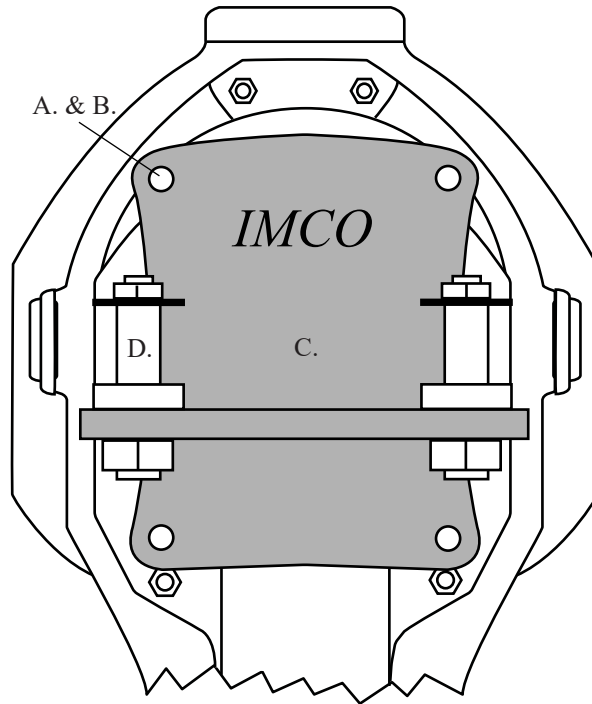
## INSTALLATION INSTRUCTIONS FOR IMCO-NV TRANSOM HARDWARE STEERING RAMS & HOSES

- A. ATTACH DRILL TEMPLATE TO TRANSOM AND DRILL HOLES, REMOVE TEMPLATE CLEAN AREA AND INSTALL TRANSOM HARDWARE, FOR SEALING USE 100% SILICONE
- B. INSTALL RAM(S) AND CONNECT HOSES PER DRAWING, DO NOT USE TIE STRAPS TO BIND HOSES THEY MUST MOVE INDEPENDENTLY OR DAMAGE WILL OCCUR



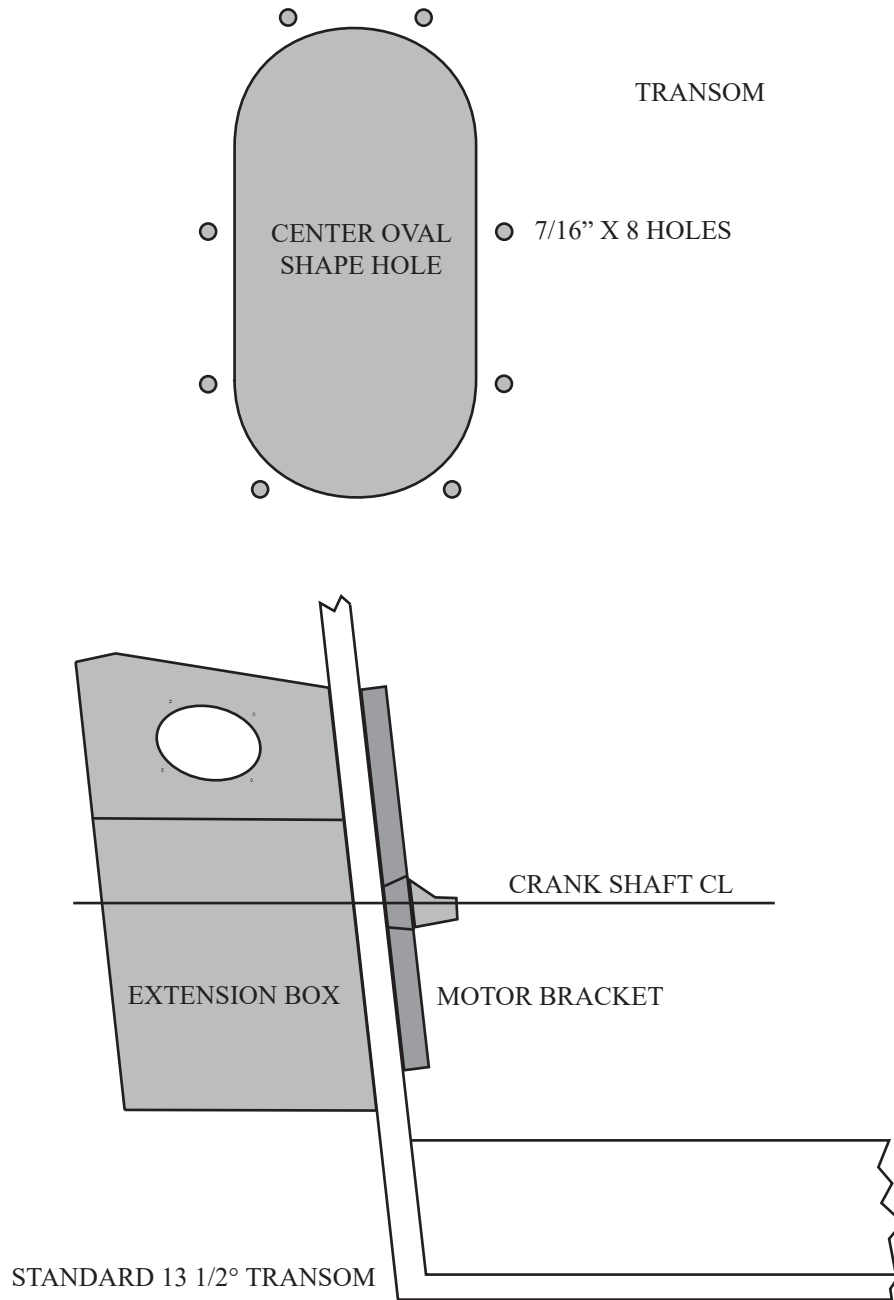
## INSTALLATION INSTRUCTIONS FOR IMCO-NV TRS WING PLATE

- A. REMOVE BOLTS ONLY FROM THE REAR ALUMINUM COVER PLATE (DO NOT REMOVE COVER PLATE)
- B. INSTALL STUDS PROVIDED, TORQUE @ 35 FT LBS
- C. INSTALL WING PLATE PER DRAWING, TORQUE NUTS @ 30 FT LBS
- D. INSTALL CLEVIS STUDS PER DRAWING, TORQUE 3/4" NUT(S) @ 120 FT LBS



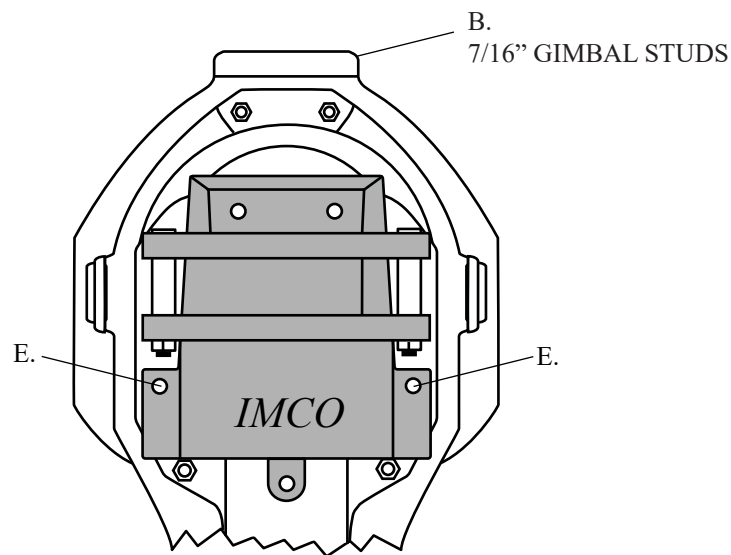
# INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO EXTENSION BOX

- A. USE THE EXTENSION BOX AS YOUR TEMPLATE AND DRILL 8ea 7/16" HOLES  
TRACE AND CUT OUT THE ENTIRE CENTER OVAL SHAPE HOLE, INSTALL EXTENSION BOX AND MOTOR  
BRACKET FOR SEALING EXTENSION BOX TO TRANSOM USE 100% SILICONE



## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO EXTENSION BOX

- B. REMOVE THE TOP TWO 7/16" GIMBAL STUDS AND REPLACE WITH SHORTER STUDS PROVIDED, BE SURE THE WATER INLET FITTING IS POSITIONED SO WATER INLET HOSE WILL NOT COME IN CONTACT WITH THE DRIVE SHAFT, INSTALL EXHAUST BLOCKOFF PLATE (NOT PROVIDED) INSTALL GIMBAL HOUSING TO THE EXTENSION BOX, INSTALL MOTOR AND ALIGN WITH IMCO ALIGNMENT TOOL
- C. REMOVE THE STOCK DRIVE SHAFT FROM STERN DRIVE (IT IS BEST TO REMOVE THE PAINT AROUND THE BEARING CAPS AND SNAP RINGS FIRST) REMOVE SNAP RINGS, USING A U-JOINT TOOL SLIDE THE DRIVE SHAFT TO ONE SIDE AND REMOVE IT, INSTALL IMCO DRIVE SHAFT IN REVERSE ORDER, INSTALL STERN DRIVE TO GIMBLE HOUSING
- D. USING A CLEAN CONTAINER DRAIN OIL FROM STERN DRIVE, REMOVE STOCK BRAVO SHIFT COVER AND TAPE OVER OPENING LEAVING THE THREE BOLT HOLES CLEAR
- E. BOLT ON STEERING CAP (USE WD-40 OR SIMILAR TO HELP DRILL & TAP HOLES) USE A 3/8" DRILL BIT AND SPOT DRILL 1/8" DEEP, REMOVE STEERING CAP AND DRILL 5/16" X 1 1/4" DEEP, TAP HOLES 3/8-16 X 3/4" DEEP PERFECT THREAD, CLEAN ALL BOLT HOLES AND REMOVE TAPE
- F. REMOVE O-RING AND DETENT PIN FROM STOCK BRAVO SHIFT COVER AND INSTALL IN STEERING CAP
- G. INSTALL STEERING CAP, TORQUE BOLTS @ 35 FT LBS
- H. (FROM THE BOTTOM) REFILL STERN DRIVE WITH DRAINED OR NEW OIL



## INSTALLATION INSTRUCTIONS FOR IMCO-NV BRAVO EXTENSION BOX

- I. FOR A SINGLE EX-BOX STER SYSTEM, DRILL ONE 1/2" HOLE AS MARKED PER SIDE, ATTACH SIDE MOUNT BRACKETS TO THE EX-BOX THRU THE CENTER SLOTTED HOLE AND SNUG BOLTS
- J. INSTALL STEERING RAMS WITH 3/4" CLEVIS PINS ONLY (NO NUTS AT THIS TIME) IF MULTIPLE STERN DRIVES INSTALL TIE BAR PER DRAWING, FOR PROPER STERN DRIVE ALIGNMENT MEASURE PROP SHAFT CENTERS TO NOSE CONE CENTERS & ADJUST TIE BAR UNTIL THEY BECOME EQUAL, AT THIS POINT ALL STEERING HARDWARE SHOULD BE CONNECTED
- K. TURN STERN DRIVE ALL THE WAY TO THE LEFT AND HOLD FIRM, ADJUST SIDE MOUNT BRACKETS EQUALLY UNTIL THE LEFT STER RAM IS 100% COLLAPSED AND THE RIGHT STER RAM IS 100% EXTENDED, LEVEL SIDE MOUNT BRACKETS WITH BOTTOM OF BOAT AND TIGHTEN BOLTS, REMOVE RAMS, MARK AND DRILL THE REMAINING HOLES, REATTACH SIDE MOUNT BRACKETS USE 100% SILICONE TO SEAL AROUND BOLT HOLES
- L. LOCATE BULKHEAD TUBE BRACKETS PER DRAWING, DRILL HOLES AND INSTALL, FOR SEALING USE 100% SILICONE, ATTACH STER RAMS, HOSES & TIE BARS PER DRAWING

