



MERCUISER

#1-R Gear Housing Components

	Description	O.E. #	Sierra #	AP #		Description	O.E. #	Sierra #	AP #
1.	Lower Gear Housing	—	18-2402	—	42.	Trim Tab	31640A1	18-6011	4000
2.	Water Tube Guide	23-29804	18-3109	601	43.	Needle Roller Bearing	31-92366A1	18-1150	13030
3.	Bushing/Water Pump Housing	26-38970 *	18-3110	187	44.	Lower Unit Gear Set (pinion gear)	23-96084A4	18-2200	2670
4.	O-Ring, Upper - Drive Shaft ..	25-30613 *	18-7158	205	45.	Pinion Nut	11-35921	18-3719	2678
5.	Slinger	25-30221	18-7426	226	46.	Shift Shaft Washer	12-29395	18-4267	—
6.	Stainless Steel Locknuts (1) (5/16 -24)	11-45592	18-3723	120	47.	Washer, Rubber Shift Shaft Bushing	12-31266	18-2340	132
7.	Stainless Steel Locknuts (2) (1/4 -28)	11-20361, 11-35888	18-3722	5165	48.	Oil Seal	26-89236 *	18-2009	172
8.	Washer	12-36001	18-4270	—	49.	Shift Bushing	23-30617A2 *	18-2154	513
9.	Screw	10-30720	18-3226	5157	50.	O-Ring	25-25439 *	18-7153	1625
10.	Washer, Water Pump Body	—	N/A	N/A	51.	Washer, Lower Shift Shaft Bushing	—	N/A	N/A
11.	Upper Pump Housing	46-96148A1	18-3116	043	52.	Retaining Clip, Shift Shaft	53-29641	18-2347	—
12.	Insert Cup	48752	18-3114	042	53.	Stainless Steel Shift Shaft	77481-1	18-2150	505
13.	Impeller	47-89984	18-3017	001	54.	Cotter Pin, w/Shift Spool Assembly	19755A	18-2196	—
14.	Drive Key	—	N/A	N/A	55.	Sleeve, w/Shift Spool Assembly	19755A	18-2196	—
15.	Gasket, Upper Water Pump to Wear Plate (upper)	27-85609-1 *	18-2915	672	56.	Retainer Spring, w/Shift Spool Assembly	19755A	18-2196	—
16.	Impeller Plate	32435	18-3117	030	57.	Washers, w/Shift Spool Assembly	19755A	18-2196	—
17.	Gasket, Upper Water Pump to Wear Plate (lower)	27-85608-1 *	18-2914	671	58.	Spring, w/Shift Spool Assembly	19755A	18-2196	—
18.	Dowel Pin	17-35973	18-3227	13166	59.	Spool, w/Shift Spool Assembly	19755A	18-2196	—
19.	Water Pump Base	46-57234A1	18-3417	046	60.	Shift Crank	76865	18-2130	2630
20.	Oil Seal (upper)	26-16977 *	18-2026	024	61.	Shaft, w/Shift Spool Assembly	19755A4	18-2196	—
21.	Oil Seal (lower)	26-89238 *	18-2014	171	62.	Shim, Forward Gear Bearing	15-47397A1	18-2285	2472
22.	O-Ring	25-90011 *	18-7176	274	63.	Tapered Roller Bearing	31-35928A1	18-1159	570
				088	64.	Needle Roller Bearing	31-30895	18-1157	2125
23.	Gasket, Water Pump Base to Gear Housing	27-85610-1 *	18-2826	—	65.	Lower Unit Gear Set (forward)	23-96084A4	18-2200	2670
24.	Spring	—	N/A	N/A	66.	Spring, Retainer, Cross Pin ..	24-30893	18-2348	—
25.	Tapered Roller Bearing	31-53079A1	18-1164	1904	67.	Sliding Clutch	52-66063	18-2202	2415
26.	Shim (s), Drive Shaft Bearing	15-57007A	18-2295	2473	68.	Cross Pin, Clutch to Clutch Actuating Shaft	—	18-2348	N/A
27.	Drive Shaft	45-41939A1	18-2167	1803	69.	Propeller Shaft .	44-66060, 44-66060-3	18-2166	1802
28.	Insert, Water Pickup	—	N/A	N/A	70.	Shim (s) Thrust Ring to Gear Housing	15-31535A1	18-2284	—
29.	Screw, Insert to Gear Housing	10-76156	18-3197	2679	71.	Lower Unit Gear Set (reverse)	43-96084A4	18-2200	2670
30.	Nut, Insert Screw	11-45812	18-2344	13083	72.	Thrust Ring, Bearing Carrier	35915	18-3759	2694
31.	Screw, Trim Tab to Gear Housing Gear Housing	—	N/A	N/A	73.	Ball Bearing	30-88957A1	18-1155	1900
32.	Dowel Pin, Gear Housing to Drive Shaft Housing	—	N/A	N/A	74.	O-Ring	25-31534	18-7159	217
33.	Stud, Water Pump to Gear Housing (3 - 1/4")	—	N/A	N/A	75.	Needle Roller Bearing	31-30956	18-1158	2126
34.	Stud, Gear Housing to Drive Shaft Housing (1 - 31/32)	—	N/A	N/A	76.	Bearing Carrier Assembly ...	73020A14	18-2191	2178
35.	Stud, Water Pump to Gear Housing (3 - 3/8")	—	N/A	N/A	77.	Key, Locating - Bearing Carrier	—	N/A	N/A
36.	Stud, Gear Housing to Drive Shaft Housing (3 - 3/16")	—	N/A	N/A	78.	Oil Seals	26-76868	18-2002	238
37.	Oil Passage Seal	26-45577 *	18-2944	221	79.	Tab Washer	14-79447	18-2299	2179
38.	Plug, Oil Fill/Drain	10-79953A2	18-2244	221	80.	Spanner Nut	79448	18-3751	1117
39.	Gasket, Gear Housing Drain Screw	12-19183, 12-20260 *	18-2945	2108	81.	Thrust Washer	13171, 77987	18-4220	1192
40.	Nut (2) Gear Housing to Drive Shaft Housing	—	N/A	N/A	82.	Continuity Washer	—	N/A	N/A
41.	Screw, Gear Housing to Drive Shaft Housing	10-30206	18-2361	5207	83.	Brass Castle Washer	12-31211A2	18-3714	2668
					84.	Tab Washer	14-31210, 14-816629	18-3200	2708
					85.	Prop Nut	11-52707	18-3700	—

* Included in Seal Kit 18-2652 AP# 1287 (Not Pictured)

N/A Not Available

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