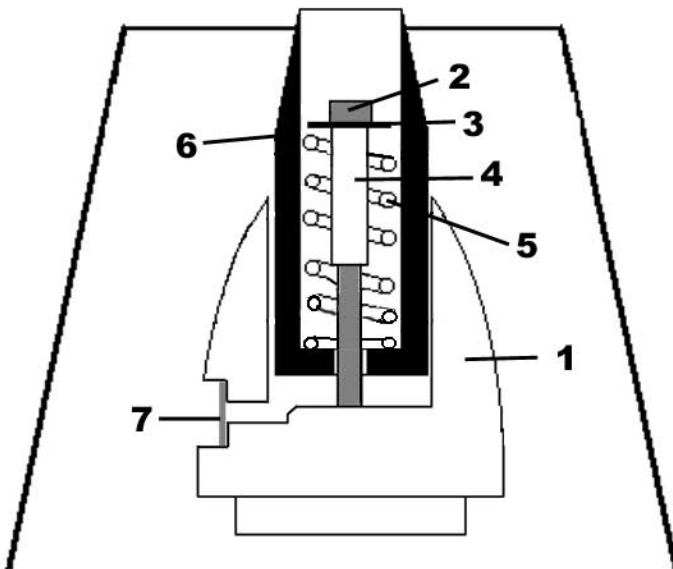


**ADJUST-A-THRUST**  
**INSTALLATION INSTRUCTIONS**  
 Model POL1(a), 2(a), 148mm pump

- \***Before installing the Adjust-A-Thrust, read and understand the instructions and the tuning sheet.**
- \*Remove steering cable, trim/ reverse rods, and bilge hoses from the steering nozzle.
- \*Remove the bolts that secure the exit nozzle to the pump, and the exit nozzle and wedge if present.
- \*Remove the 3 bolts that secure the stock tailcone. Remove the tailcone and tailcone spacer if present.
- \*The stock nozzle may need to be bored, refer to the tuning sheet before boring nozzle.
- \*Before installing unit, remove sealing oring from pump.
- \*Push unit onto pump and verify that it bottoms on the pump housing, and not the impeller stub shaft.
- \*If it bottoms on the stub shaft, grind about .040" (1mm) off the end of the stub shaft to achieve clearance.
- \***Not all pumps are the same -- failure to check clearance may result in pump bearing failure!**
- \*POL 2 installation does not require that you check clearance as the 3" spacer provides adequate clearance.
- \*Reinstall sealing oring, and grease lightly.
- \*Apply an 1/16" bead of ultra blue RTV sealant or equivalent to the body (pol1) or spacer (pol2). See diagram.
- \*Install unit so that the inlet orifice points as close to 6:00 o'clock as possible, fasten with hardware provided.
- \*On POL 2 installation, bolt 3" spacer to pump and then install main body onto spacer.
- \*Install the 1/4" washer over the shoulder bolt. Next, install the shuttle stop tube (aluminum), then the spring.
- \*Install the shortest shuttle into main body, and secure with shoulder bolt assembly.
- \*It takes some force to collapse the spring in order to tighten the shoulder bolt into the main body.
- \***When installing the shoulder bolt, Do not torque to over 7 ft/lbs, or you will break off the bolt!!**
- \**When tightening the shoulder bolt with the provided wrench, screw it in until it bottoms, then give the wrench about an 1/8 turn more "tweak." Torque is 7 ft/lbs*
- \**Once you have determined which shuttle is your favorite, the bolt may be loctited in using yellow loctite only!*
- \*Reinstall the exit nozzle and wedge onto pump.
- \*Reinstall the trim / reverse rod, steering cable, and bilge and cooling hoses.



- POL1, 2, parts list
1. MAIN BODY
  2. 2.75" X 1/4x20 SS BOLT
  2. 2.5" X 1/4x20 SS BOLT (optional, for tuning)
  3. 1/4" SS WASHER (1 required, 2 for tuning)
  4. SHUTTLE STOP
  5. SPRING
  6. SHUTTLES (4) (pol1, 1a) 2.0, 2.25, 2.5, 2.75  
 (pol2, 2a) 2.75, 3.0, 3.25, 3.5
  7. Inlet screen, (optional)
  - (3) #10 SS LOCK WASHERS
  - (3) 10/24 x 1" SS CAP SCREWS. pol1, 2
  - (3) 10/24 x 3" SS CAP SCREWS. pol2
  - 3" ALUMINUM SPACER. pol2

