

ADJUST-A-THRUST
INSTALLATION INSTRUCTIONS
Model, SEA1 - Sea-Doo 140mm

- *Before installing the Adjust-A-Thrust, read and understand the instructions and the tuning sheet.
- *Remove steering cable, trim/ reverse rods.
- *Remove the 4 bolts that secure the exit nozzle to the pump, and the nozzle assy.
- *Remove the 3 bolts that secure the stock tailcone, and the tailcone. Drain pump oil.
- *Remove all traces of sealer from the pump housing.
- *Remove adhesive backing from UHMW disk, clean inside of AAT with contact cleaner, place disk in impeller cavity with cutout towards oil hole to allow for oil flow through the filler passage (see diagram)
- *Put AAT main body onto pump and rotate back and forth by hand.
- *Remove AAT and inspect uhmw disk. if there is no sign of contact with the impeller shaft, then install another disk and try again. Continue this process until you notice marks on the disk. (most units will use 2 or 3 disks)
- *If impeller shaft has burrs or nicks in the end of it, you must remove the sharp edges before installing the AAT.
- *Install AAT with stock hardware and o-ring
- *Clean surface and seal with loctite 518 or equivalent. (see diagram)
- *Install AAT with inlet orifice pointing to 6:00 o'clock. It may be hard to turn the impeller when the unit is tightened down. This is normal as the disks will wear in, and proper clearance will be achieved.
- *Wipe off excess sealer with a shop towel.
- *Fill shaft cavity with synthetic pump oil. Fill slowly allowing air to bleed out.
- *Install plug into fill hole, seal the threads with pipe compound or suitable substitute.
- *Install the 1/4" washer over the shortest bolt. Next, install the shuttle stop tube (aluminum), and spring.
- *Install the shortest shuttle into unit and secure with the spring/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. Don't forget siphon bilge o-rings.
- *Verify that the bilge spigots are still pressed into the exit nozzle, If they are loose, they must be epoxied or siliconed in. If they fall out of the exit nozzle, then your bilge system will pump water INTO the hull.
- *Reinstall the trim / reverse rods and steering cable.

Check our our website for a typical seadoo install with pics. www.wetwolf.com/sea/seainstall.html

SEA1 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) 2.5, 2.75, 3.0, 3.25
 7. Inlet screen, (optional)
- UHMW DISKS

