

Assembly

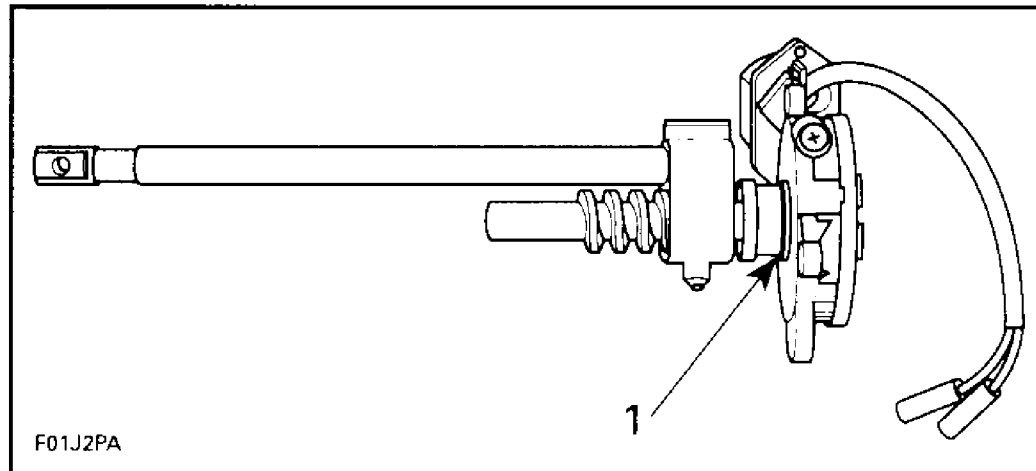
Assembly is essentially the reverse of disassembly procedures. However pay particular attention to the following.

Motor, Worm and Sliding Shaft

Apply XP-S synthetic grease (P/N 293 550 010) to worm.

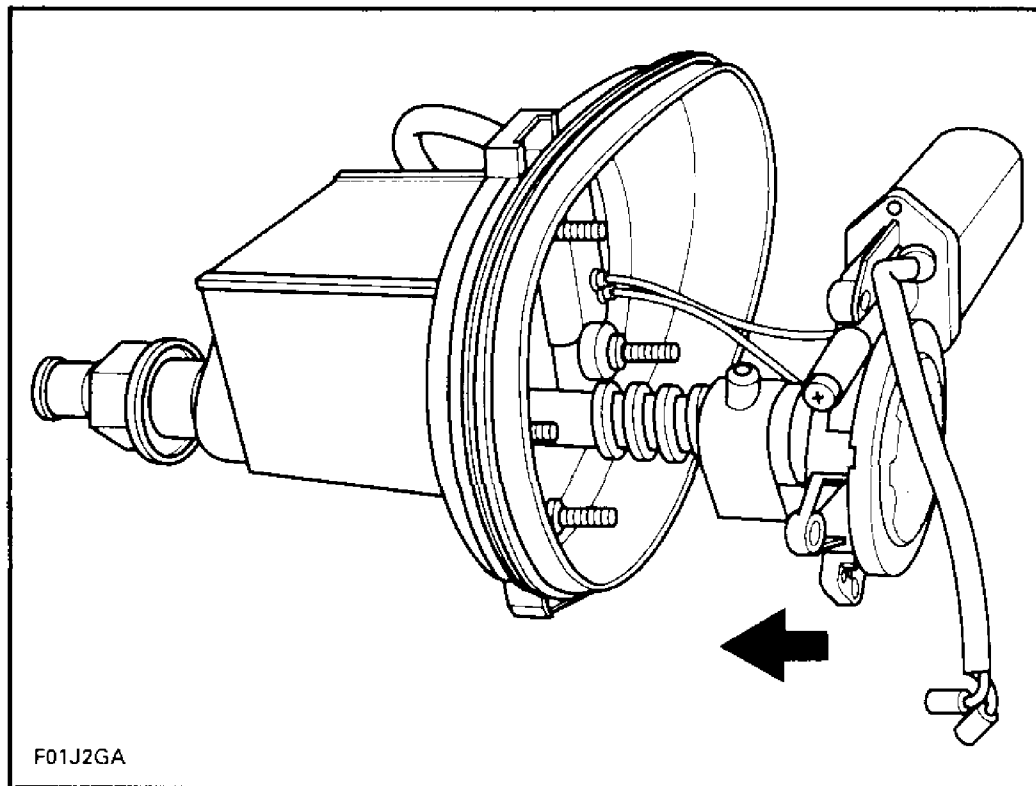
Screw worm **no. 9** to sliding shaft **no. 10**.

Mesh worm splines to gear of motor.



1. Mesh worm spline to gear of motor

Install motor **no. 8**, worm and sliding shaft in VTS housing.



Tighten nuts **no. 11** to 7 N•m (62 lbf•in).

Connect wires of motor.

CAUTION: Make sure wire color codes match.

Install cover **no. 7**.

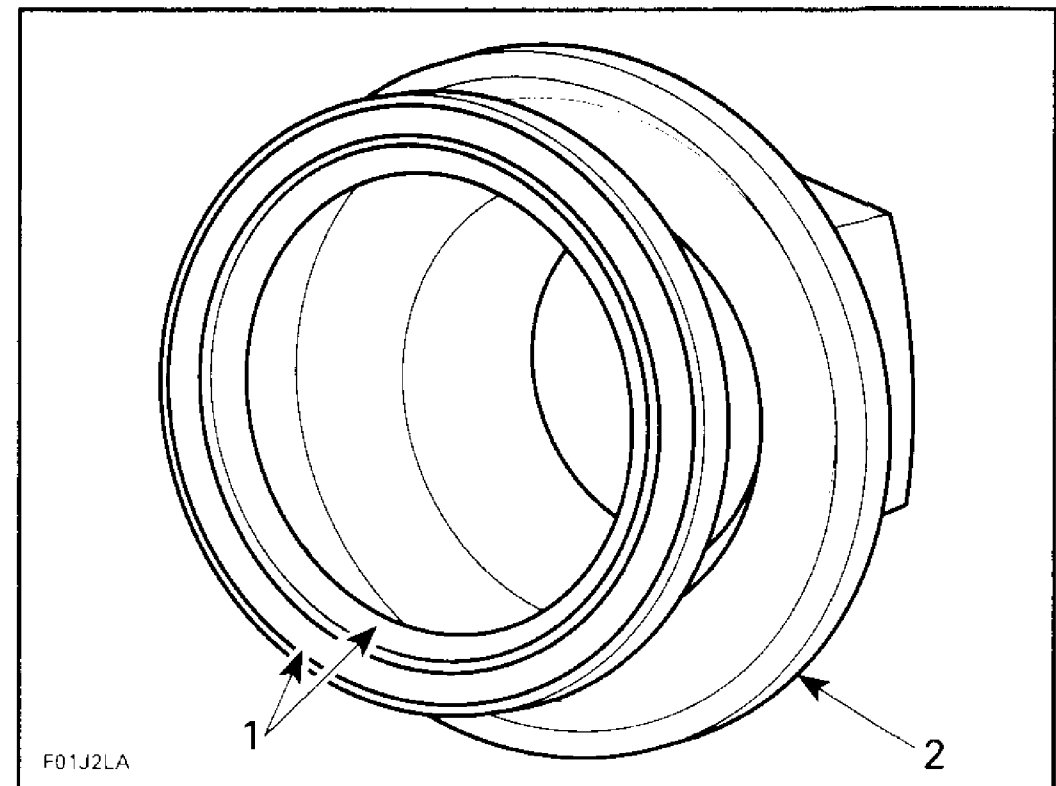
NOTE: Make sure seal **no. 12** is in place.

Installation

Installation is essentially the reverse of removal procedures. However pay particular attention to the following.

Nut and Sealing Washer

Place sealing washer **no. 5** on nut **no. 4**. Make sure seal lips are facing toward hull.



1. Seal lips facing hull
2. Nut

Apply Loctite Primer N (P/N 293 800 041) to threads of VTS housing, and to nut **no. 4**.

Apply Loctite 243 (blue) (P/N 293 800 060) to nut **no. 4**.

Install nut with sealing washer and torque to 7 N•m (62 lbf•in) using the VTS socket tool (P/N 295 000 133).

Sliding Shaft and Rubber Boot

Apply XP-S synthetic grease (P/N 293 550 010) to sliding shaft.

Install rubber boot **no. 3**, over sliding shaft and secure with clamps.

VTS Rod

Secure the VTS rod onto the sliding shaft end using bolt **no. 13** and nut **no. 14**. Torque nut to 4 N•m (35 lbf•in).

Adjustment

No adjustment is required.