



340/350 Series Motor Removal/Replacement Instructions

Tools & supplies needed: sockets- 7/16", 11/16", wrenches – 3/8", 7/16", 1/2", water pump pliers, 5/32" allen key, #2, #3 phillips screw-driver.

Supplied in kit: Motor, mounting straps, anti-seize compound, blue threadlocker, propeller pin, propeller washer, propeller nut.

Removal of Old Motor

1. Do not remove the motor in the water. **Note the orientation of motor on mounting bracket. We recommend taking a few pictures for reference when re-installing the new motor.**
2. Disconnect power to the system by removing the positive lead on motor controller.
3. Remove mounting hardware holding the motor to the mounting base with 7/16" socket and a 5/32" allen key.
4. Remove the rear mounting hardware holding the straps to the mounting base, with a 7/16" socket and #3 phillips screwdriver.
5. Cut and remove the black rubber protection boots on the motor, and remove sealant to access the brass connection studs
6. Remove thruster cables from motor.
7. On older motors prior to 2020, remove the plastic airline(no longer required)
8. Remove propellers and dowel pins from motor.

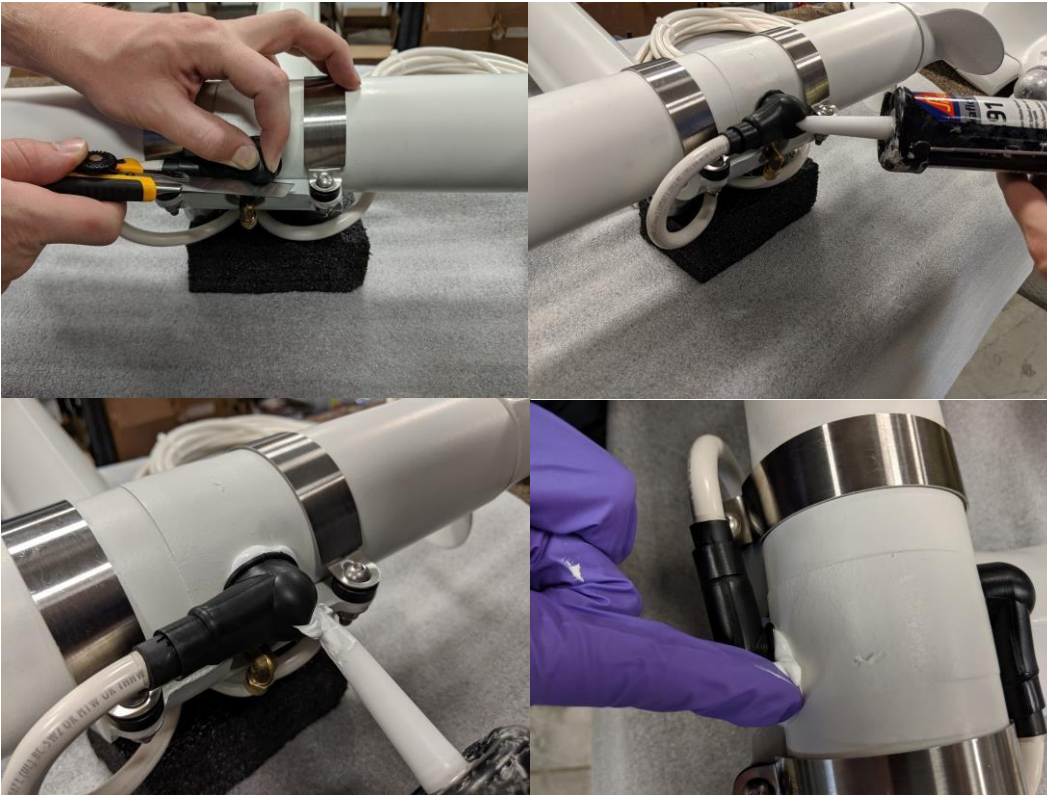
Re-Installing New Motor

Note: Apply anti-seize compound on threads of all stainless steel parts when reinstalling hardware

Note: **The plastic airline has been eliminated and is no longer required**

1. Reinstall new motor straps, ensuring they are straight and parallel across the motor body.
2. Position the motor on the mounting base in the same position as the old motor.(refer to your photographs of old installation) Apply anti-seize to bolt threads and install hardware using 7/16" wrench and 5/32 allen key. Ensure motor is completely secure in the mounting bracket.
3. Thread on the two anodes to the mounting bracket and tighten with pliers.
4. Slip the black rubber protection boots loosely over the cable ends
5. Connect thruster cables with brass nuts; **moderately** tighten with 1/2" wrench. **Warning: Do not overtighten or damage will occur**
6. Pull the rubber protection boots over the motor stud and cable connection until snug against the motor.

7. Cut a small slit in the back of the rubber protection boot. Inject marine sealant(We recommend Sikaflex) through the slit into the protection boot until full, removing any excess sealant. Allow to cure for at least six hours. If you use another brand of marine sealant please follow manufacturer's curing directions.



Installing Propeller to Motor Instructions

1. Cover the prop pins with an all purpose grease. Insert prop pins into the motor shafts.
2. Slide propellers onto the shafts. Ensure that the prop pin is nested in the slot on the propeller. Please note the propeller only fits one way.
3. Put blue threadlocker on the prop shaft.
4. Slide on the washer and nut and securely tighten with an 11/16" socket wrench.
5. Thread on the two anodes to the ends of the prop shafts and tighten with pliers.