

GHR Installation Kit



Mercruiser Gimbal Housing Repair

Features/Benefits

- *Eliminates costly gimbal housing replacements.*
- *Kit comes complete with all components necessary for repair including bellows.*
- *Permanent repair – not a quick fix.*
- *Saves time – faster than a gimbal housing replacement.*
- *Available for all Mercruiser sterndrives.*

18-8311

For Mercruiser Alpha 1

18-8312

For Mercruiser Gen II

18-8313

For Mercruiser Bravo

GHR Installation Kit

WARNING: This Kit is for Professional Use ONLY

To install this ring kit, follow normal boot replacement steps UNTIL you get to the installation of the boots. It is necessary to REMOVE THE RAW WATER HOSE before this kit is installed.

- You must use a DIE GRINDER WITH AN APPROVED WIREWHEEL, do not use sand paper, to clean the gimbal housing of debris.
- AFTER THIS IS CLEANED THOROUGHLY, YOU MUST CLEAN AREA WITH ACETONE.
- Install the new raw water hose WITH THE CLAMP POINTING UP this will make sure the ring kit will seat correctly.
- Proceed with normal boot, shift cable and gimbal bearing replacement.
- After you have made it to the driveshaft bellows installation, install the boot kit WITH BELLOWS ADHESIVE ONLY ON THE BELLHOUSING SIDE.
- Install the boot normally with the clamp in its normal position and the ring clamp AT 1 O'CLOCK. [Alpha 1, M, R and TRS drives only](#).
- Mix ALL OF THE EPOXY and add thickening agent (white powder). Mix gently, the powder will easily be blown out of the epoxy if mixed too aggressively.
- You will need to use the brush (supplied with the kit) to spread the epoxy on the gimbal housing AND on the inside of the repair ring.
- Set the ring into position on the gimbal housing then install the bellhousing pivot bolts to hold the bellhousing in place. [Alpha 1, M, R and TRS drives only](#).
- USING A 1/2" DIAMETER DRIFT, TAP THE RING INTO PLACE. IT WILL SOUND SOLID WHEN IT BOTTOMS OUT.
- Working inside the bellows, spread the epoxy with the brush evenly around the damaged area making sure not to block the vent hole at the top of the Gimbal housing.
- The epoxy will cure in 24 HOURS at temperature above 60°; 32 hours in temperature below 60°.
- After epoxy has cured, install Gen II Alpha and Bravo Bell Housings and lube Gimbal bearing.
- Reinstall drives.



Required Tools:

- Die Grinder with wirewheel
- 1/2" diameter - 12" long Drift
- Small can of Acetone
- Shop towels

Patent #US D449, 621S

Any questions or problems please call

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