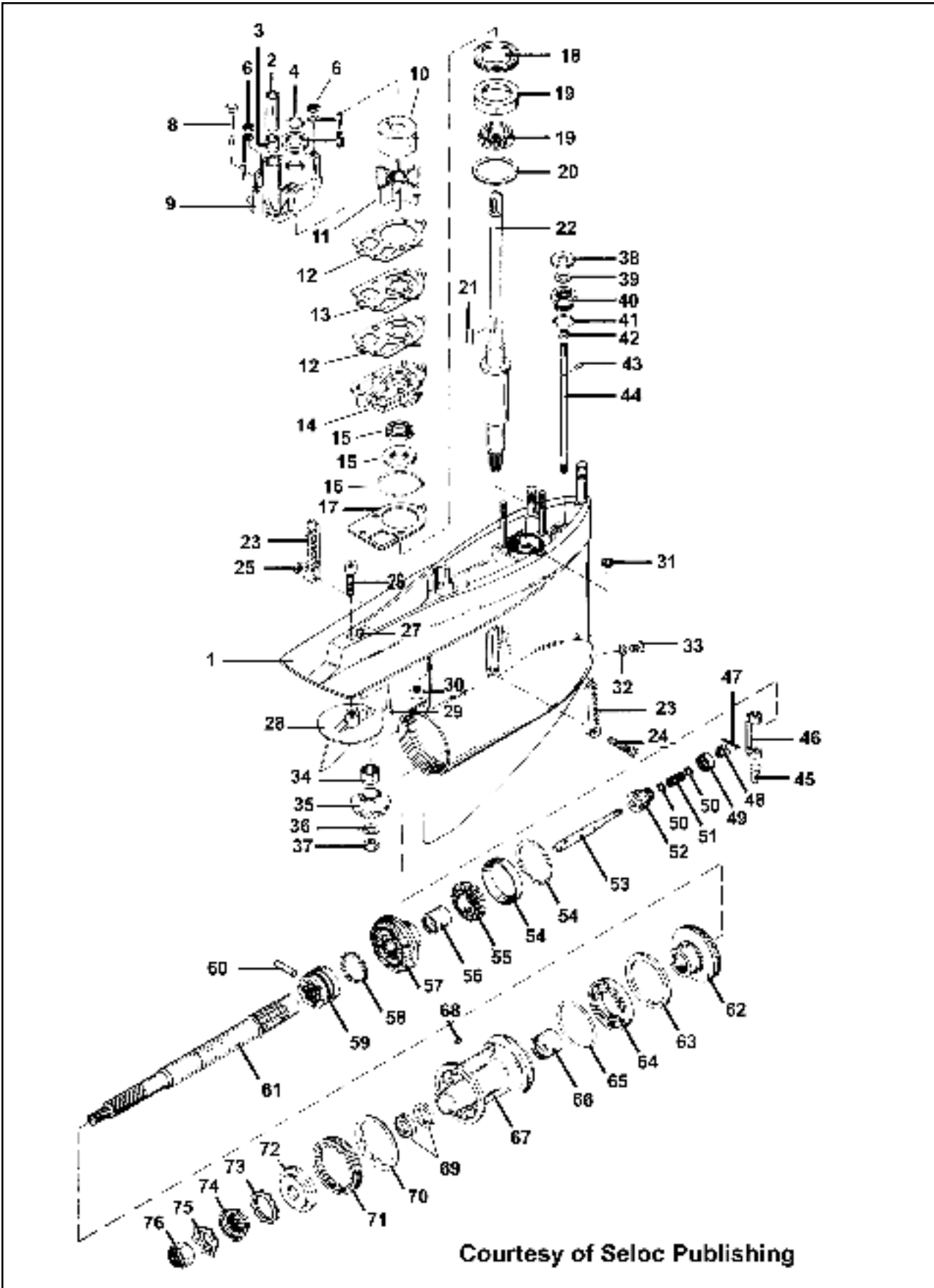


# MERCUISER

## MR/ALPHA Gear Housing Components



Courtesy of Seloc Publishing

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## MERCUISER MR/ALPHA Gear Housing Components

Description	O.E. #	Sierra #	AP #	Description	O.E. #	Sierra #	AP #
1. Gear Housing .....	—	18-2401	—	38. Shift Shaft Washer .....	12-29395	18-4267	—
2. Water Tube Guide .....	23-29804	18-3109	601	39. Washer, Rubber Shift Shaft Bushing .....	12-31266	18-2340	132
3. Bushing/Water Pump Housing .....	26-38970 *	18-3110	187	40. Shift Bushing .....	23-30617A2 *	18-2154	513
4. O-Ring, Upper Drive Shaft .....	25-30613 *	18-7158	205	41. O-Ring, Shift Shaft Bushing ..	25-25439 *	18-7153	203
5. Slinger .....	25-30271	18-7426	266	42. Washer, Lower Shift Shaft .....	—	NSS	NSS
6. Stainless Steel Locknuts (3) .....	11-45592	18-3723	120	43. Retaining Clip, Shift Shaft .....	—	NSS	NSS
7. Washer (3) .....	12-36001	18-4270	—	44. Stainless Steel Shift Shaft .....	77481-1	18-2150	505
8. Screw, Water Pump Body to Water Pump Base .....	—	N/A	N/A	45. Pin, Shift Crank - Gear Housing .....	—	N/A	N/A
9. Upper Pump Housing .....	46-96148A1	18-3116	043	46. Shift Crank .....	76865	18-2130	2630
10. Insert Cup .....	48752	18-3114	042	47. Cotter Pin, w/Shift Spool Assembly .....	19755A2	18-2286	2416
11. Impeller .....	47-89984	18-3017	001	48. Sleeve, w/Shift Spool Assembly .....	19755A2	18-2286	2416
12. Gasket, Upper Water Pump to Wear Plate .....	27-85609-1 *	18-2915	672	49. Retainer, w/Shift Spool Assembly .....	19755A2	18-2286	2416
13. Impeller Plate .....	32435	18-3117	030	50. Washers, w/Shift Spool Assembly .....	19755A2	18-2286	2416
14. Water Pump Base .....	46-44292A3	18-3420	—	51. Spring, w/Shift Spool Assembly .....	19755A2	18-2286	2416
15. Oil Seals, Water Pump .....	26-89238 *	18-2014	171	52. Spool, w/Shift Spool Assembly .....	19755A2	18-2286	2416
.....	26-16977 *	18-2013	174	53. Shaft, w/Shift Spool Assembly .....	19755A2	18-2286	2416
16. O-Ring, Water Pump .....	25-90011 *	18-7176	274	54. Shim (s) Forward Gear ...	15-47397A1	18-2285	2472
17. Gasket, Water Pump Base to Gear Housing ..	27-42631-1 *	18-2919	092	55. Tapered Roller Bearing ....	31-35928A1	18-1159	570
18. Retainer, Drive Shaft Bearing ..	824519	18-2346	2698	56. Needle Roller Bearing .....	31-30895	18-1157	2125
19. Tapered Roller Bearing, Drive Shaft .....	31-36387A1	18-1143	13029	57. Lower Alpha Gear Set (Forward Gear) .....	43-17064A2, 43-17064A3, 43-42934	18-2206	2352
20. Shim (s), Lower Drive Shaft Bearing .....	15-42637A1	18-2294	2470	58. Spring, Retainer - Cross Pin .....	—	18-2348	N/A
21. Drive Key, Water Pump Impeller .....	—	N/A	N/A	59. Sliding Clutch .....	52-66063	18-2202	2415
22. Drive Shaft .....	45-42634	18-2180	1846	60. Cross Pin, Clutch to Actuating Shaft .....	24-30893	18-2348	—
23. Insert (2), Water Pickup .....	93423-1	18-3199	—	61. Propeller Shaft. 44-66060, 44-66060-3	—	18-2166	1802
24. Screw, Insert to Gear Housing .....	10-76156	18-3197	2679	62. Lower Alpha Gear Set .....	—	—	—
25. Nut, Insert Screw .....	11-45812	18-2344	13083	(Reverse Gear) .....	43-17064A2, 43-17064A3, 43-42934	18-2206	2352
26. Screw, Trim Tab to Gear Housing ..	—	NSS	NSS	63. Thrust Ring, Bearing Carrier .	68100-1	18-2342	—
27. Dowel Pin, Gear Housing to Drive Shaft Housing .....	10-30720	18-3226	5157	64. Ball Bearing .....	30-88957A1	18-1155	1900
28. Trim Tab .....	31640A1	18-6011	4000	65. O-Ring, Bearing Carrier .....	25-31534 *	18-7159	217
29. Screw, Gear Housing to Drive Shaft Housing .....	10-30206	18-2361	5207	66. Needle Roller Bearing .....	31-30956	18-1158	2126
30. Nut (2), Gear Housing to Drive Shaft Housing .....	11-13439-1	18-2362	5164	67. Bearing Carrier .....	73020A-14	18-2191	2178
31. Oil Passage Seal .....	26-45577 *	18-2944	221	68. Key, Locating - Bearing Carrier .....	—	N/A	N/A
32. Gasket, Gear Housing Drain Screw .....	12-19183, 12-20260 *	18-2945	2108	69. Oil Seals, Bearing Carrier ....	26-76868 *	18-2002	238
33. Plug, Oil Fill/Drain .....	10-79953A2	18-2244	2686	70. Tab Washer .....	14-18323	18-2298	2634
34. Pinion Bearing .....	31-42647A1	18-1117	2762	71. Spanner Nut .....	79448	18-3751	1117
35. Lower Alpha Gear Set (Pinion Gear) .....	43-17064A2, 43-17064A3, 43-42934	18-2206	2352	72. Thrust Washer .....	13171, 77987	18-4220	1192
36. Anti-Galling Washer Pinion Gear .....	22-92721	18-2343	13082	73. Continuity Washer .....	—	N/A	N/A
37. Pinion Nut .....	11-35921	18-3719	2678	74. Brass Castle Washer .....	12-31211A2	18-3714	2668
				75. Tab Washer .....	14-31210, 14-816629	18-3200	2708
				76. Prop Nut .....	11-52707	18-3700	—
				77. Gasket, Wear Plate to Water Pump Base .....	27-85608-1 *	18-2914	671

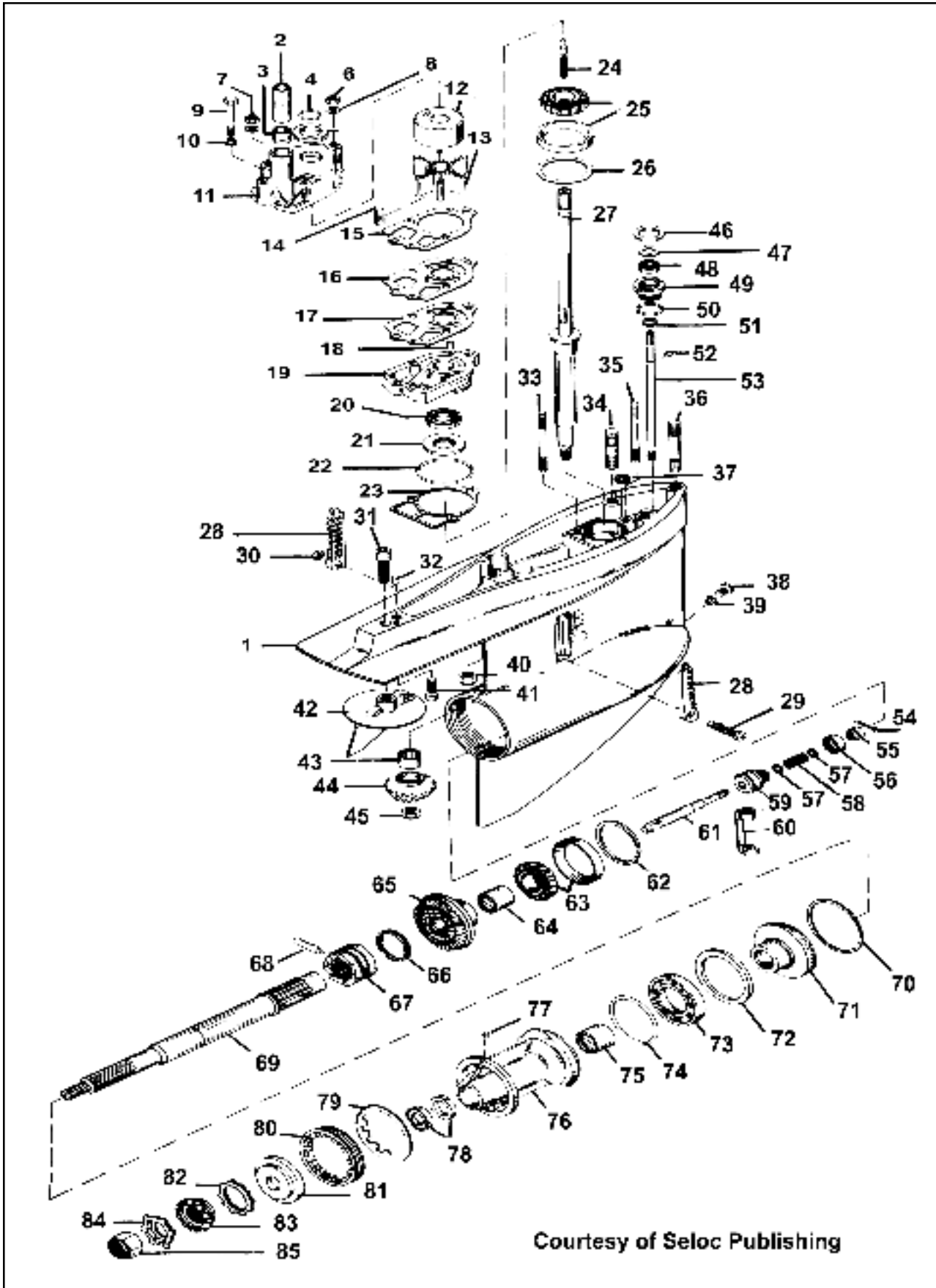
\* Included in Seal Kit 18-2652/AP# 1287 (Not Pictured)

N/A Not Available

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# MERCUISER

## #1-R Gear Housing Components



Courtesy of Seloc Publishing

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# MERCUISER

## #1-R Gear Housing Components

	Description	O.E. #	Sierra #	AP #		Description	O.E. #	Sierra #	AP #
1.	Lower Gear Housing .....	—	18-2402	—	42.	Trim Tab .....	31640A1	18-6011	4000
2.	Water Tube Guide .....	23-29804	18-3109	601	43.	Needle Roller Bearing .....	31-92366A1	18-1150	13030
3.	Bushing/Water Pump Housing .....	26-38970 *	18-3110	187	44.	Lower Unit Gear Set (pinion gear) .....	23-96084A4	18-2200	2670
4.	O-Ring, Upper - Drive Shaft ..	25-30613 *	18-7158	205	45.	Pinion Nut .....	11-35921	18-3719	2678
5.	Slinger .....	25-30221	18-7426	226	46.	Shift Shaft Washer .....	12-29395	18-4267	—
6.	Stainless Steel Locknuts (1) (5/16 -24) .....	11-45592	18-3723	120	47.	Washer, Rubber Shift Shaft Bushing .....	12-31266	18-2340	132
7.	Stainless Steel Locknuts (2) (1/4 -28) .....	11-20361, 11-35888	18-3722	5165	48.	Oil Seal .....	26-89236 *	18-2009	172
8.	Washer .....	12-36001	18-4270	—	49.	Shift Bushing .....	23-30617A2 *	18-2154	513
9.	Screw .....	10-30720	18-3226	5157	50.	O-Ring .....	25-25439 *	18-7153	1625
10.	Washer, Water Pump Body .....	—	N/A	N/A	51.	Washer, Lower Shift Shaft Bushing .....	—	N/A	N/A
11.	Upper Pump Housing .....	46-96148A1	18-3116	043	52.	Retaining Clip, Shift Shaft .....	53-29641	18-2347	—
12.	Insert Cup .....	48752	18-3114	042	53.	Stainless Steel Shift Shaft .....	77481-1	18-2150	505
13.	Impeller .....	47-89984	18-3017	001	54.	Cotter Pin, w/Shift Spool Assembly .....	19755A	18-2196	—
14.	Drive Key .....	—	N/A	N/A	55.	Sleeve, w/Shift Spool Assembly .....	19755A	18-2196	—
15.	Gasket, Upper Water Pump to Wear Plate (upper) .....	27-85609-1 *	18-2915	672	56.	Retainer Spring, w/Shift Spool Assembly .....	19755A	18-2196	—
16.	Impeller Plate .....	32435	18-3117	030	57.	Washers, w/Shift Spool Assembly .....	19755A	18-2196	—
17.	Gasket, Upper Water Pump to Wear Plate (lower) .....	27-85608-1 *	18-2914	671	58.	Spring, w/Shift Spool Assembly .....	19755A	18-2196	—
18.	Dowel Pin .....	17-35973	18-3227	13166	59.	Spool, w/Shift Spool Assembly .....	19755A	18-2196	—
19.	Water Pump Base .....	46-57234A1	18-3417	046	60.	Shift Crank .....	76865	18-2130	2630
20.	Oil Seal (upper) .....	26-16977 *	18-2026	024	61.	Shaft, w/Shift Spool Assembly .....	19755A4	18-2196	—
21.	Oil Seal (lower) .....	26-89238 *	18-2014	171	62.	Shim, Forward Gear Bearing .....	15-47397A1	18-2285	2472
22.	O-Ring .....	25-90011 *	18-7176	274	63.	Tapered Roller Bearing .....	31-35928A1	18-1159	570
				088	64.	Needle Roller Bearing .....	31-30895	18-1157	2125
23.	Gasket, Water Pump Base to Gear Housing .....	27-85610-1 *	18-2826	—	65.	Lower Unit Gear Set (forward) .....	23-96084A4	18-2200	2670
24.	Spring .....	—	N/A	N/A	66.	Spring, Retainer, Cross Pin ..	24-30893	18-2348	—
25.	Tapered Roller Bearing ....	31-53079A1	18-1164	1904	67.	Sliding Clutch .....	52-66063	18-2202	2415
26.	Shim (s), Drive Shaft Bearing .....	15-57007A	18-2295	2473	68.	Cross Pin, Clutch to Clutch Actuating Shaft .....	—	18-2348	N/A
27.	Drive Shaft .....	45-41939A1	18-2167	1803	69.	Propeller Shaft .	44-66060, 44-66060-3	18-2166	1802
28.	Insert, Water Pickup .....	—	N/A	N/A	70.	Shim (s) Thrust Ring to Gear Housing .....	15-31535A1	18-2284	—
29.	Screw, Insert to Gear Housing .....	10-76156	18-3197	2679	71.	Lower Unit Gear Set (reverse) .....	43-96084A4	18-2200	2670
30.	Nut, Insert Screw .....	11-45812	18-2344	13083	72.	Thrust Ring, Bearing Carrier .....	35915	18-3759	2694
31.	Screw, Trim Tab to Gear Housing Gear Housing .....	—	N/A	N/A	73.	Ball Bearing .....	30-88957A1	18-1155	1900
32.	Dowel Pin, Gear Housing to Drive Shaft Housing .....	—	N/A	N/A	74.	O-Ring .....	25-31534	18-7159	217
33.	Stud, Water Pump to Gear Housing (3 - 1/4") .....	—	N/A	N/A	75.	Needle Roller Bearing .....	31-30956	18-1158	2126
34.	Stud, Gear Housing to Drive Shaft Housing (1 - 31/32) .....	—	N/A	N/A	76.	Bearing Carrier Assembly ...	73020A14	18-2191	2178
35.	Stud, Water Pump to Gear Housing (3 - 3/8") .....	—	N/A	N/A	77.	Key, Locating - Bearing Carrier .....	—	N/A	N/A
36.	Stud, Gear Housing to Drive Shaft Housing (3 - 3/16") .....	—	N/A	N/A	78.	Oil Seals .....	26-76868	18-2002	238
37.	Oil Passage Seal .....	26-45577 *	18-2944	221	79.	Tab Washer .....	14-79447	18-2299	2179
38.	Plug, Oil Fill/Drain .....	10-79953A2	18-2244	221	80.	Spanner Nut .....	79448	18-3751	1117
39.	Gasket, Gear Housing Drain Screw .....	12-19183, 12-20260 *	18-2945	2108	81.	Thrust Washer .....	13171, 77987	18-4220	1192
40.	Nut (2) Gear Housing to Drive Shaft Housing .....	—	N/A	N/A	82.	Continuity Washer .....	—	N/A	N/A
41.	Screw, Gear Housing to Drive Shaft Housing .....	10-30206	18-2361	5207	83.	Brass Castle Washer .....	12-31211A2	18-3714	2668
					84.	Tab Washer .....	14-31210, 14-816629	18-3200	2708
					85.	Prop Nut .....	11-52707	18-3700	—

\* Included in Seal Kit 18-2652 AP# 1287 (Not Pictured)

N/A Not Available