

## **F I T T I N G   I N S T R U C T I O N S**

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- Ensure that the correct gap **IE** exists between the propeller and stern gear.  
**Gator 66** - 38mm; **Gator 86** - 44mm; **Gator 110** - 60mm.  
If insufficient space exists, one of our shaft spacers may be fitted.
- Fit the two plastic bearings over the shaft by flexing them apart.
- Ensure that the bearings are fitted so that the sides with the locating nodules face each other. (i.e. flat surfaces facing outwards).
- Separate the two halves of the fixed cutter by sliding them apart and reassemble on the prop shaft with the 'V' shaped tongue facing the stern gear.
- Slide the bearings onto the fixed cutter ensuring that the locating pips on the bearings fit into the hole in the face of the fixed cutter.
- Separate the two halves of the rotary cutter boss and position them around the prop shaft.
- Slide the fixed cutter assembly into position on the rotary cutter boss. Insert the two retaining screws but do not tighten.
- Fit the clamp ring onto the main body of the rotary cutter with the recess facing the stern gear.
- Ensure that the joint of the clamp rings is at 90 degrees to the joint of the rotary cutter. Insert clamping screws but do not tighten. Align the rotary cutter blades so that each blade is positioned centrally behind a propeller blade.
- Locate the fixed anchor on the stern gear so that the tongue of the fixed cutter is positioned into the 'V' slot of the fixed anchor, leaving 6mm (Gap **VG**) of the tongue visible, this is to allow for the forward movement of the shaft under ahead thrust. 6mm is normally more than adequate for this movement.  
**CAUTION: The 6mm gap allowance for ahead movement must be more than the actual shaft movement, otherwise damage to the Gator will result.**
- Mark the position of the centre retaining screw hole on the stern gear.
- Drill and tap the hole for the centre retaining screw using a 6.8mm drill bit and M8 tap.
- Fix the striker plate to the stern gear with an M8 socket head screw and spring washer.
- Using the holes in the striker plate as a guide, drill and tap the remaining two holes and insert the remaining two M8 socket head screws and spring washers.
- Adjust the jacking screws on the striker plate to achieve a good 3 point contact with the stern gear.
- Verify that the correct positional relationship between fixed cutter and striker plate has been maintained and fully tighten all screws.