

**Sea-Doo 4TEC Core:  
Picture 1**



**As in any SBT exchange motor we do not want any electronics, intake or exhaust. Starting at the valve cover, remove: all sensors, PTO and magneto covers, PTO coupler, plastic cam cover, and oil cooler.**

**Picture 2**



**Parts that need to be left on: Timing chain tensioner, timing chain guides, the plastic crank cover, crankcase, crankshaft, camshaft & sprocket, valve cover and all associated bolts.**

**Sea-Doo cores MUST be opened for full inspection for up-front costs. Remove the screw caps, and all case bolts from the bottom of the case to split them.**



**As you can see, externally this case shown no damage, yet it is punched out in several places internally.**



**The bearing surfaces on the case must be inspected. If the bearing has spun and damaged the case surface as shown below, it's a \$300 welding charge.**

**Good Surface**



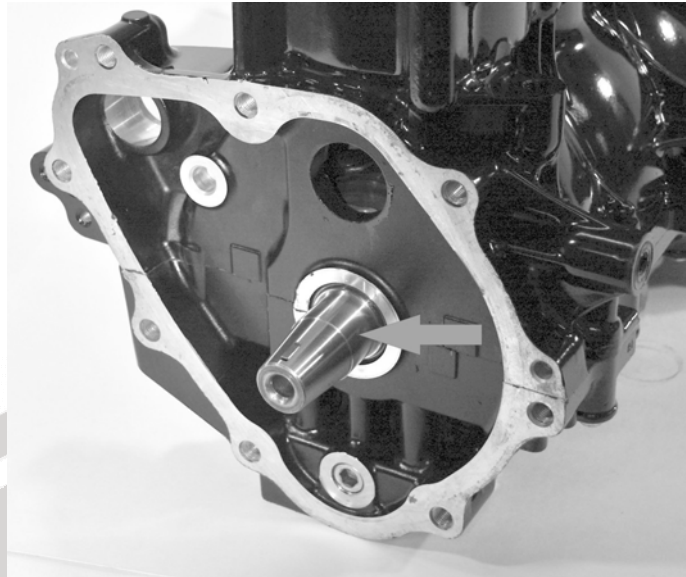
**Bad Surface**



# *Identifying a Yamaha FX 4 Stroke*

## *408A vs. 408B*

Customers of the 2001-2002 Yamaha FX can look at the Flywheel end of the engine to see the snout of the crank.



The end of the two OEM cranks at this end look like this:



# *Identifying a Yamaha FX 4 Stroke*

## *408A vs. 408B*

The gear that mounts on the end of the flywheel is also different on the inside diameter. Both the diameter and the oil control method are different, with the oil control slots or holes can be seen like this:



The 408A ID has dimples for oil



The 408B ID has slots for oil

# *4-Stroke Exchange Motors*

As in any SBT exchange motor, please remove all electronics, exhaust, and oil pump equipment. On the Yamaha 4-Stroke, starting from the valve cover you should remove:

- Head Cooling Pipe
- All Injectors (including throttle body mounts)
- All Sensors
- Oil Filter
- Pressure Control Valve
- PTO
- Magneto Cover Crank Reducer gear
- Oil Tank
- It is not necessary to send in the timing Chain

**Parts that need to be left on:**

- Timing Chain Tensioner
- 2 Cam Chain Guides with dowel pins
- Zinc Anode
- Oil Pan
- All bolts
- Crankcase
- Crankshaft
- Camshafts
- Valve Cover
- Cylinder
- Cylinder Head