

**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**





