

Install a thinner shim (35). Tighten pinion nut (46) securely and tighten bearing housing screws to shim gage. Adjust shim gage support so drive shaft assembly is parallel to shim gage. Press drive shaft assembly against bearing housing (32) and measure clearance (8). Clearance (8) plus thickness of shim (35) is the required shim thickness for proper pinion gear depth.

NOTE: Shim (35) is available in sizes from 0.50 mm to 1.30 mm in 0.05 mm increments. Shim should be selected so only ONE shim is installed.

Backlash between forward gear (49—Fig. S218-31) and pinion gear (45) should be 0.5-0.65 mm (0.020-0.026 in.) and is adjusted by varying thickness of shim (47). Use only ONE shim (47). Backlash between reverse gear (59) and pinion gear (45) should be 0.7-0.85 mm (0.028-0.033 in.) and is adjusted by varying thickness of shim (60). Use only ONE shim (60).

Propeller shaft (57) end play should be 0.10-0.20 mm (0.004-0.008 in.). Adjust end play by varying thickness of thrust washer (58).

Remainder of reassembly is the reverse of disassembly noting the following: Apply Suzuki Thread Lock 1342 or a suitable thread locking compound to threads of pinion nut (46) and tighten to 80-100 N·m (59-73 ft.-lbs.). Install bearing housing (32) with the mark "F" facing forward. Install dog clutch (54) with the side with six dogs facing forward. Lubricate slider (51) and pin (52) with a suitable water-resistant grease. Apply a suitable water-resistant grease to lips of seals (63) and to "O" ring (66). When installing bearing housing (66) and propeller shaft assembly, position flat surface of slider (51) facing up, align slot in housing (66) with slot in gearcase housing and install key. Apply Suzuki Bond 1207B to threads of ring nut (68). Install ring nut with the side marked "OFF" facing propeller and tighten to 150-175 N·m (111-129 ft.-lbs.). Shaft unit must be in the neutral position when installing. Tighten propeller nut to 50-62 N·m (37-45 ft.-lbs.). Apply water-resistant grease to drive shaft splines. Apply a suitable silicone sealant to gearcase-to-drive shaft housing mating surfaces and shank of gearcase mount-

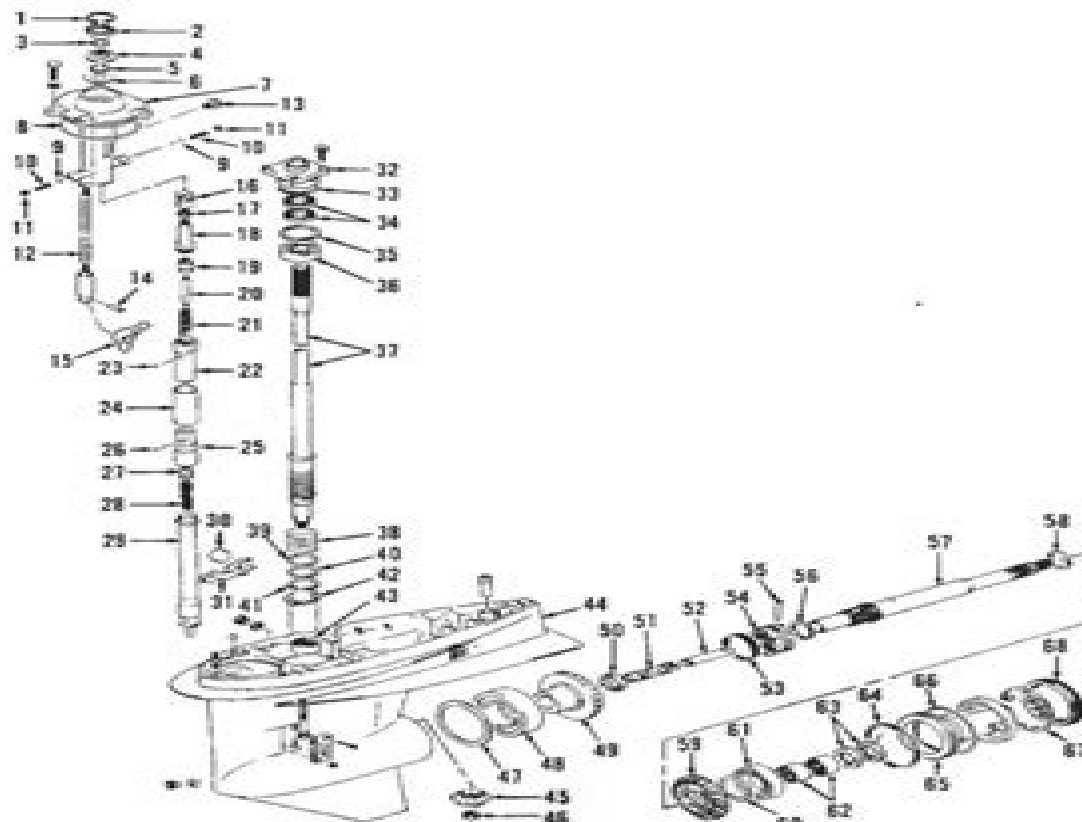


Fig. S218-31—Exploded view of lower unit gearcase assembly.

- | | | | | |
|------------------------|---------------------|---------------------|----------------------|---------------------|
| 1. Snap ring | 14. Pin | 28. Spring | 42. Collar | 56. Thrust washer |
| 2. Seal | 15. Pinion pulley | 29. Vertical slider | 43. Bearing | 57. Propeller shaft |
| 3. "O" ring | 16. Coupler nut | 30. Magnet | 44. Gearcase housing | 58. Thrust washer |
| 4. Gasket | 17. Nut | 31. Magnet holder | 45. Pinion gear | 59. Reverse gear |
| 5. "O" ring | 18. Shim | 32. Bearing housing | 46. Nut | 60. Shim |
| 6. Washer | 19. Forward plunger | 33. "O" ring | 47. Shim | 61. Forward |
| 7. Bearing | 20. Seal | 34. Seal | 48. Bearing | 62. Reverse |
| 8. "O" ring | 21. Spring | 35. Shim | 49. Forward gear | 63. Seal |
| 9. Ball | 22. Reverse slider | 36. Bearing | 50. Spring | 64. Propeller shaft |
| 10. Spring | 23. Ball | 37. Drive shaft | 51. Slider | 65. Bearing housing |
| 11. Screw | 24. Lock screw | 38. Spring | 52. Connector pin | 66. "O" ring |
| 12. Thrust nut & shaft | 25. Forward screw | 39. Thrust washer | 53. Retainer | 67. Thrust washer |
| 13. Seal | 26. Nut | 40. Thrust washer | 54. Dog clutch | 68. Ring nut |
| 14. Seal | 27. Reverse plunger | 41. Protector | 55. Pin | |

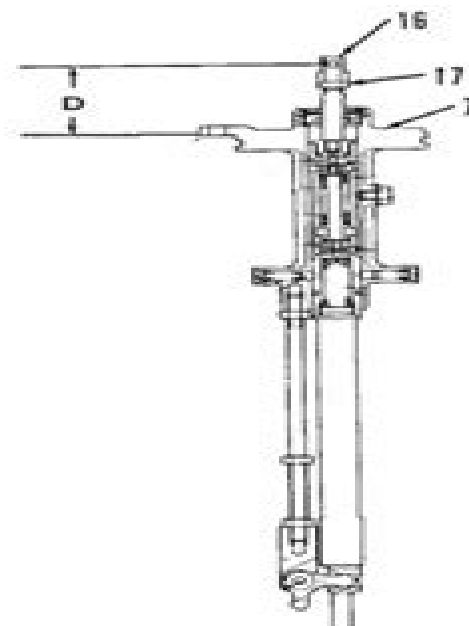


Fig. S218-32—Cross-sectional view of shift assembly. Distance (D) between housing (7) and center of hole in connector (16) with shift assembly in the neutral position, should be 46 mm (1.81 in.) on long shaft models and 173 mm (6.81 in.) on extra long shaft models. Tighten nut (17) securely.

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web 3 iso 22001 this standard includes gmp haccp along with some other requirements that are mostly similar to iso 9001 management review internal audits this is why most food factories that have implemented a haccp system are also iso 22001 certified

difference fssc 22000 and iso 22000 kiwa - Apr 17 2022

web iso 22000 and fssc 22000 are both international standards and both relate to the most important components for ensuring food safety two certification schemes that are very similar and play a key role in ensuring safe and high quality food products

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web aug 18 2015 3 iso 22001 this standard includes gmp haccp along with some other requirements that are mostly similar to iso 9001 management review internal audits this is why most food factories that have implemented a

iso 22001 2005 food safety certification iso ce ltd - Feb 13 2022

web iso 22001 is a complete food safety management system which has been designed for any organisation in the food chain from the growing to the service of produce the standard allows an organisation to develop a food safety management system tailored to its particular suppliers customers and relevant parties and does not follow an exhaustive and

iso 22000 2018 en food safety management systems - May 31 2023

web 0 1 general the adoption of a food safety management system fsms is a strategic decision for an organization that can help to improve its overall performance in food safety the potential benefits to an organization of implementing a fsms

iso 22000 2018 food safety management systems - Apr 29 2023

web this document specifies requirements for a food safety management system fsms to enable an organization that is directly or indirectly involved in the food chain a to plan implement operate maintain and update a fsms providing products and services that are safe in accordance with their intended use b to demonstrate compliance with

iso 22000 2018 nqa - Aug 22 2022

web iso 22000 is the food safety management system that can be easily applicable to any organization in the food chain iso 22000 was initially developed on september 1st 2005 by the iso tc 34 sc 17 as the first truly international fsms standard a brief history of iso 22000 iso 22000 was initially published in 2005 as a response to

iso 22001 2018 food safety management systems fsms - Jul 01 2023

web iso 22000 certification is a procedure based standard that one can use to control food safety throughout the whole food

chain from farm to table the standard does not specify criteria for food safety performance nor the design of a management system

iso 22000 sgs - Nov 24 2022

web oct 25 2023 what are the benefits of iso 22000 2018 iso 22000 2018 food safety management system harmonizes various national food safety standards into one easy to understand set of requirements it provides global recognition of your commitment to safety in food beverage ingredient and pet food supply chains and helps you to