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## 3000 Series Zeus Pod – Gearcase Stud Replacement Interval

### Models Affected

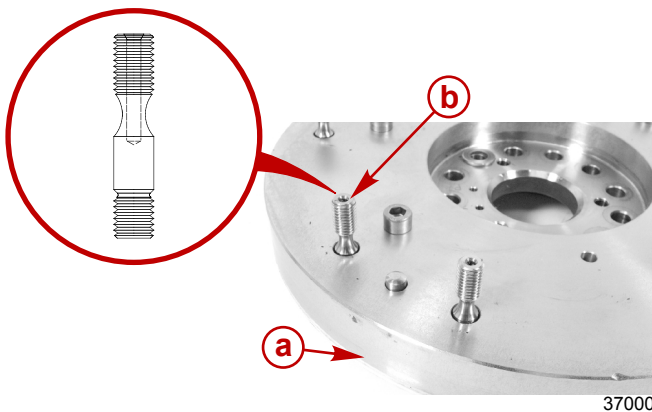
Models Covered
All Zeus 3000 Series Pods

### Scope

Worldwide

### Situation

Special fuse studs used for fastening the pod gearcase assembly to the kingpin adaptor plate contain a unique reduced neck diameter design. If a significant underwater strike occurs, these studs are the mechanical fuse for the pod assembly.



a - Kingpin adaptor plate  
 b - Special fuse stud

During a service event when the gearcase is removed, it may not be visually evident there is deterioration in the load carrying capabilities of the special fuse studs. Therefore, these studs should be replaced each time the gearcase assembly is removed.


### Parts Required

Qty.	Description	Part Number
8	Special fuse stud	8M0035876

### Procedure

**IMPORTANT: A suitable stud installation tool must be utilized when installing the studs into the kingpin adaptor plate. The use of an incorrect tool will damage or stretch the fuse area of the stud.**

1. Apply Loctite 271 Threadlocker to the special fuse stud threads that will be in the kingpin adaptor.

Tube Ref No.	Description	Where Used	Part No.
 7	Loctite 271 Threadlocker	Special fuse stud threads	92-809819

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- Use a stud installation tool (obtain locally) and a calibrated torque wrench to tighten the studs to the specified torque.

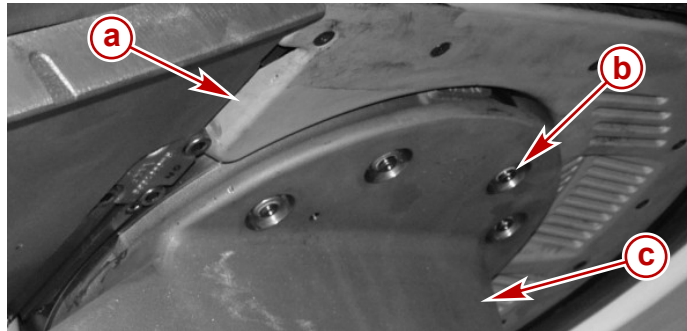
Description	Nm	lb-in.	lb-ft
Special fuse stud	16.2	144	–

**NOTE:** The two solid studs do not need replacement every service event, if no visual damage is evident. Refer to part number 8M0007531.

- Apply Loctite Primer T (obtain locally) to the threads of the solid stud that will be in the kingpin adaptor. Allow the primer to dry.
- Apply a liberal amount of Loctite 680 Retaining Compound to the threads that have the primer on them.

Tube Ref No.	Description	Where Used	Part No.
 33	Loctite 680 Retaining Compound	Threads of the solid stud	92-809833

- Install the studs into the kingpin adaptor up to the shoulder, and then unthread 1–1.25 turns out (360°–450°).  
**IMPORTANT: The studs with the Loctite 680 must cure for 24 hours before any torque is applied.**
- Allow the Loctite 680 to cure for 24 hours.
- Install the gear housing assembly.



Starboard side, port similar

- a - Center section
- b - Self-locking nut and washer (8)
- c - Gear housing

33511

- Apply 20W-50 oil (obtain locally) to threads of all studs.
- Using a calibrated torque wrench, tighten the eight nuts on the fuse studs to the specified torque in a crisscross pattern. Perform this sequence twice.

Description		Nm	lb-in.	lb-ft
Self-locking nut for gear housing to center section (fuse studs)	<b>First</b>	34	–	25
	<b>Final</b>	34	–	25

- After completing the tightening sequence on the fuse studs, tighten the nuts on the two aft solid studs to 50 lb-ft, one time only.

Description	Nm	lb-in.	lb-ft
Self-locking nut for gear housing to center section (solid studs)	68	–	50

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