

FIG. #1

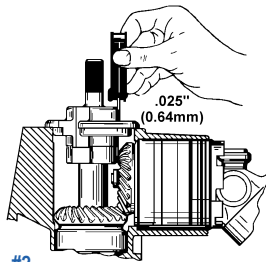


FIG. #2

**FIGURES #1 - #2**

Provides two separate views of the upper gear housing driven gear being properly shimmed using the Sierra installation tools.

**FIGURES #3 - #4**

Provides the same views of the drive gear being shimmed in the same application.

**NOTE:**

This installation **cannot** be performed correctly without the Sierra shim tool. Improper installation **will** result in gear failure. The .025 referenced in **FIG #2** & **FIG #4** is achieved when .026 will not fit the clearance but .025 will.

A service manual should always be consulted for step-by-step instructions. See Sierra Manual and Tool Catalog.

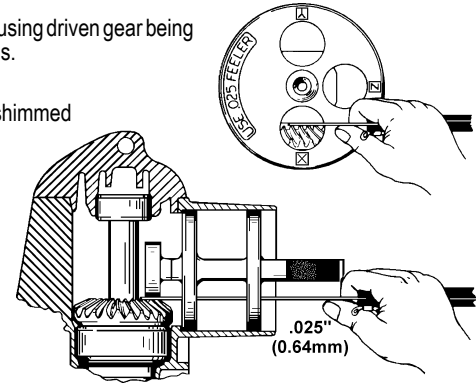
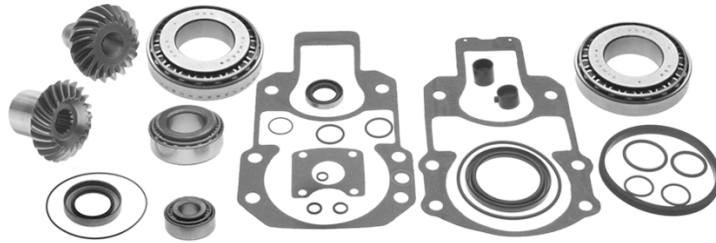


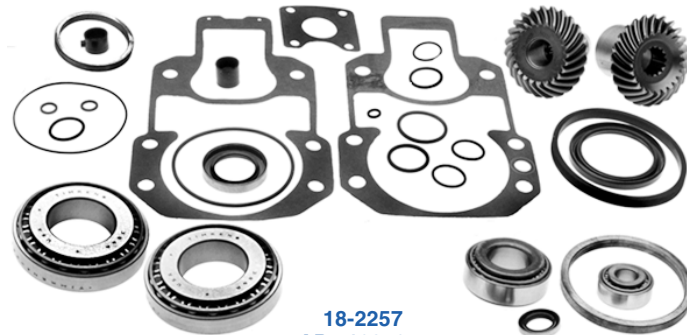
FIG. #3 - #4



**18-2256  
UPPER GEAR SET**  
Replaces: 43-803116T1  
Most V-8 Drives (1.5:1 Ratio)

— CONTAINS —

Sierra#	Description	O.E.#	Qty.
18-2201	Upper Unit Gear Set	43-18410A2	1
18-2648	Seal Kit	26-32511A2	1
18-2618	Outdrive Gasket Set	27-94996A1	1
18-2820	Drive Shaft Housing to Bell Housing Gasket	27-64818	1
18-2743	Drive Shaft Housing to Bell Housing Gasket	27-94996-2	1
18-1160	Bearing	31-35988A2	1
18-1165	Bearing	31-61100A1	1
18-1142	Bearing	31-35990A1	1



**18-2257  
AP# 13078  
UPPER GEAR SET**  
Replaces: 43-803112T1  
6 Cyl. Inline (1.65:1 Ratio)

— CONTAINS —

Sierra#	Description	O.E.#	Qty.
18-2203	Gear Set	43-45814A5	1
18-2648	Seal Kit	26-32511A2	1
18-2618	Outdrive Gasket Set	27-94996A1	1
18-2820	Drive Shaft Housing to Bell Housing Gasket	27-64818	1
18-1160	Bearing	31-35988A2	1
18-1161	Bearing	31-35990A1	1
18-1165	Bearing	31-61100A1	1
18-2743	Drive Shaft Housing to Bell Housing Gasket	27-94996-2	1



**18-2258  
AP# 13079  
UPPER GEAR SET**  
Replaces: 43-803114T1  
V-6 (470/485) (1.84:1 Ratio)

— CONTAINS —

Sierra#	Description	O.E.#	Qty.
18-2204	Gear Set	43-75325A3	1
18-2648	Seal Kit	26-32511A2	1
18-2618	Outdrive Gasket Set	27-94996A1	1
18-2820	Drive Shaft Housing to Bell Housing Gasket	27-64818	1
18-1160	Bearing	31-35988A2	1
18-1161	Bearing	31-35990A1	1
18-2743	Drive Shaft Housing to Bell Housing Gasket	27-94996-2	1
18-1165	Bearing	31-61100A1	1