

This is how I upgraded my Ride plate inserts on my 99 GP 1200. I am sure there are many ways but this worked great for me. This can be applied to several applications as well. I considered welding the bracket but was a little concerned about the casting and what it is actually made out of.

Items needed:

- (2) 05 1300 Pump shoe inserts #F1G-U8571-00-00 from boats.net \$8.50 ea.
- (1) package JB weld
- (2) 2" strips of 1/8" x 3/4" aluminum I bought a 4' piece at Home Depot
- (1) tube 3M 5200 fast cure





**Part 1:
Removal of old insert glue and prep**

First I had to remove the glue and the one remaining insert and glue (Fig 1) then prep the area. (Fig 2) This was the hardest part. The Yamaha factory glue is a "pita" to remove I asked for help from the forum and was told heat it up with a heat gun and chisel it off with a hammer and chisel. I did this and then sanded the surface for prep.

This was approx 2 hours work for one side.

Fig 1: Existing condition



Fig 2: Prep work remove the glue and clean

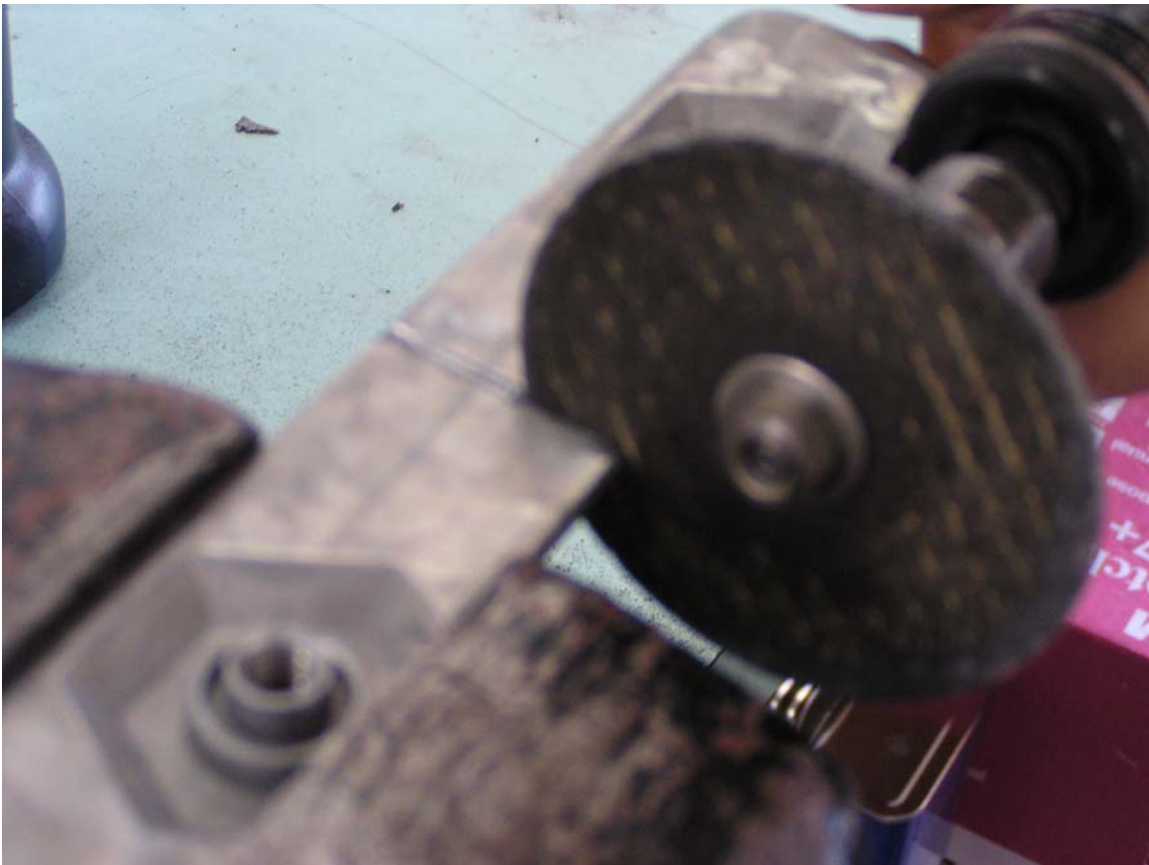


Part 2:
Modify bracket

I modified a 05 GP1300R pump shoe bracket #F1G-U8571-00-00 to fit the bolt hole spacing of the 99 GP1200 it was about 4mm longer than the 99.

- 1) Cut the insert in half and ground some material away to get the proper spacing
- 2) Use a ride plate as a fixture to hold the two pieces and align them
- 3) Cut two pieces of 1/8"x 3/4" aluminum 2" long to use as strengthening ribs, when I bond it with JB weld. I drilled some holes in the aluminum to allow the glue to squeeze out and insure a good bond.
- 4) Apply the JB weld to the supports and clamp it together to cure.
- 5) I found that I had to trim the end to clear the rear transom about 1/2" there will be a left and a right at this point or you could just trim both ends equal.

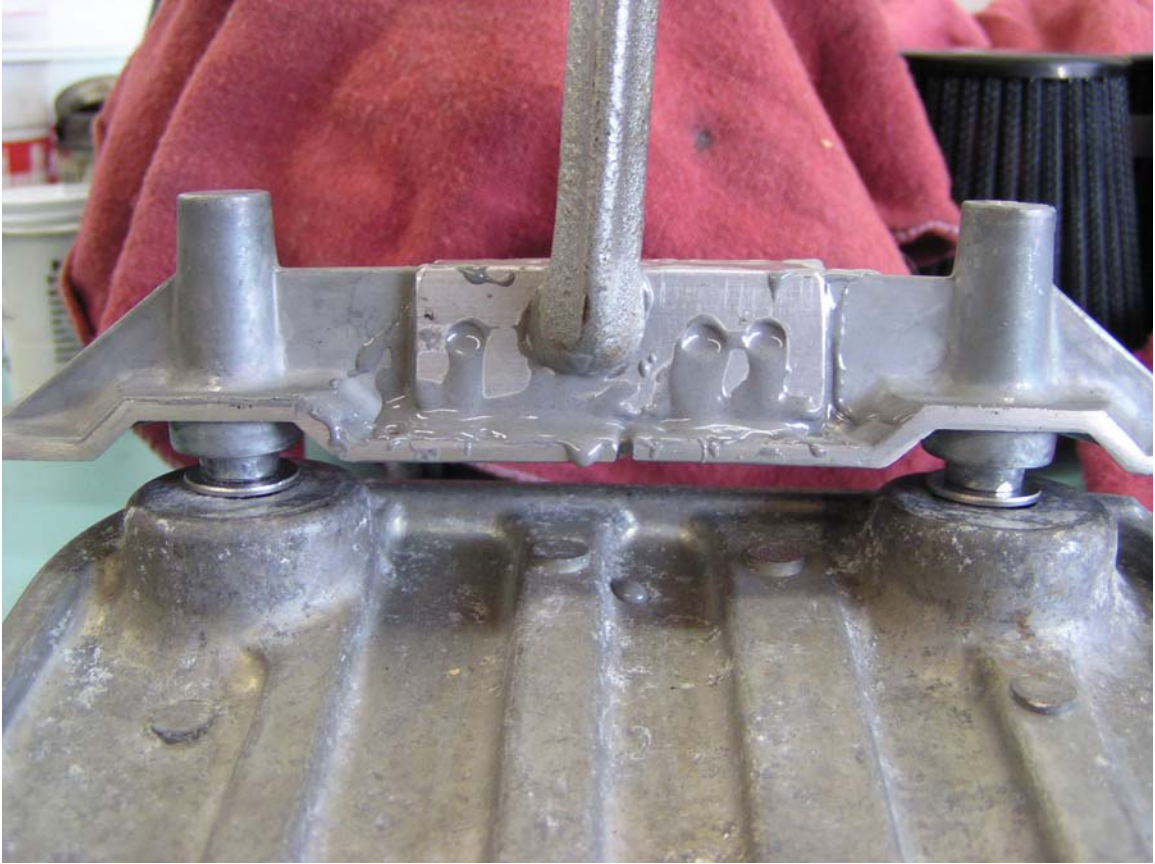
This took maybe 1/2 an hour of work and is easy to do with basic tools.















Part 3:
Install in hull and seal

- 1) I had to trim a little from the rear edge of the bracket to make it fit
- 2) Clean all surfaces with a wire brush
- 3) Wipe all surfaces with Acetone
- 4) Apply 3M 5200 fast cure liberally to the bracket and inside of hull
- 5) Install ride plate to hold bracket down and in position I used washers between ride plate and hull to minimize squeeze out of the adhesive.
- 6) Lightly torque the bolts insure that the bracket is seated and allow adhesive to cure for 24 hours.
- 7) Remove plate and use razor knife blade to remove any excess glue from outer surface of hull.



Repair complete: Install ride plate use some anti-seize on the bolts to keep them from corroding and binding and causing future problems.