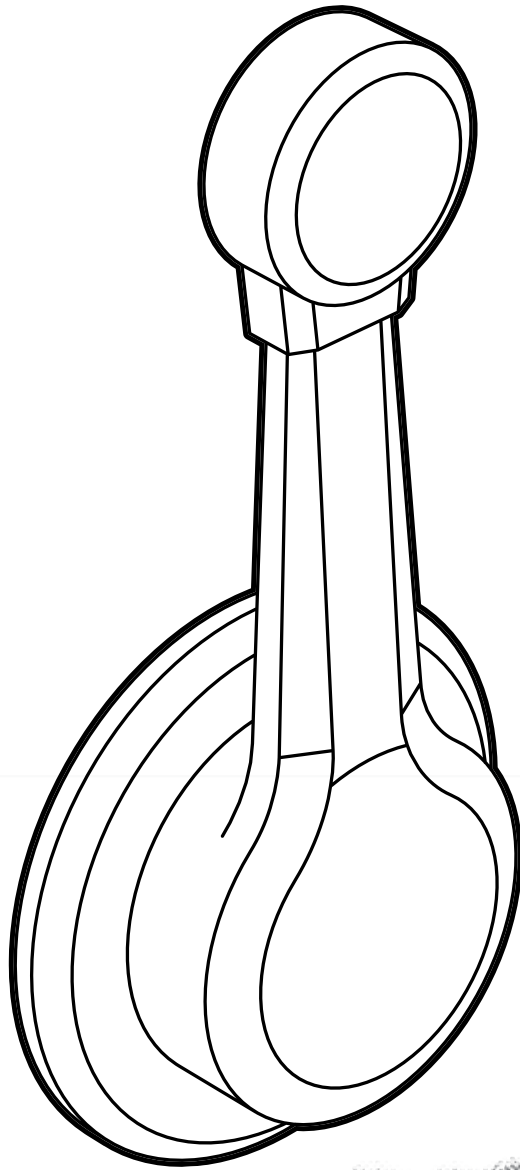




*Craftsman*  
MARINE



**CIRCA**

MANUAL

CRAFTED WITH CRAFTSMAN MARINE

PROPULSION



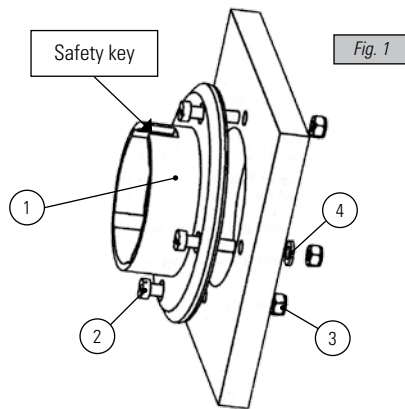
# CIRCA

MANUAL



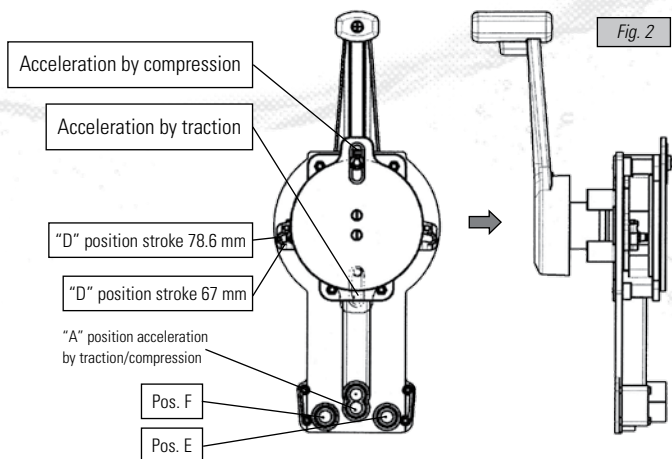
## Flange installation

Carry out the panel drilling, as per attached drilling scheme. Mount the fastening flange (1), by use of 4 M6x25 screws (2), 4 washers (4) and 4 M6 self-locking nuts (3). (See fig.1). The safety key shall be positioned as shown in fig.1



## Setting of throttle lever direction

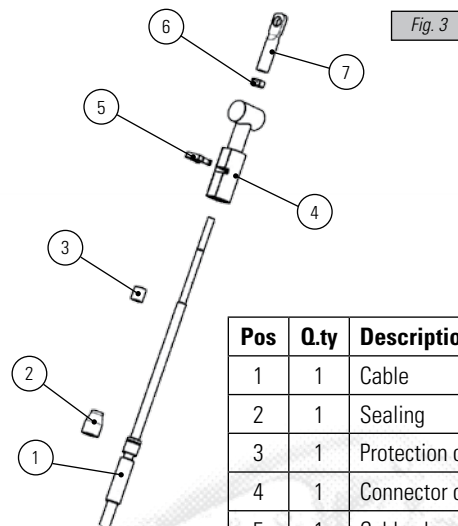
Check in fig. 2 whether the throttle lever position is correct, according to the type of engine. (Craftsman Marine engines are all "acceleration by traction"). In order to invert the throttle direction (from traction to compression or vice-versa), insert the lever in its hub. Apply some pressure on the lever (see fig. 2) so as to position the gear in neutral and rotate it through 180° (to the next release point).



## Control cables preparation

The single lever control SL can be used with all Craftsman Marine cables and most universal cables made by other manufacturers.

Remove the protection cover (3) and the sealing (2) from the cable. Insert the cable connector (4) to the limit stop and insert the cable clamp block (5) in its slot. Screw the nut (6) and the cable end (7) on the threaded cable rod as shown in fig. 3



Pos	Q.ty	Description
1	1	Cable
2	1	Sealing
3	1	Protection cap
4	1	Connector cable
5	1	Cable clamp block
6	1	Nut
7	1	Cable end

## Assembly of the cables on the controller

### Gearbox

Insert the inverter stud (1) in the control cable rod eyelet (fig. 4) and fix it with the stop-ring (2). The cable shall be positioned in the "E" or "F" set (fig. 2), according to the direction of installation of the controller. Travel of the cable can be changed by moving the cable end between "C" position (short stroke) and "D" position (long stroke) (fig. 2). Fasten the stud with one M4x18 screw (3)

### Throttle

Insert the cable in the throttle stud (5) and fix it with the stop-ring (2) (fig.4). Position the cable in position "A". Check the installation by moving the lever forward and backward, and verify that cables allow all the available stroke. Adjust stroke by screwing or unscrewing the cable end (7).

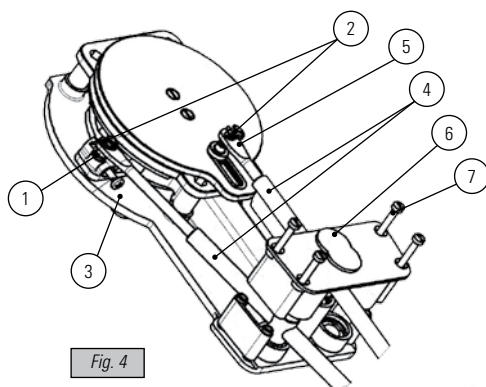


Fig. 4

Pos	Q.ty	Description
1	1	Inverter stud
2	2	Stop-ring
3	1	A2 M4x18 Screw
4	2	Control cable
5	1	Accelerator (throttle) stud
6	1	Cable lock
7	1	A2 M4x40 Screw

Insert the cable lock (6), making sure that the cable barrels are properly positioned in their seats. Fix the cable lock with 4 M4x40 screws (7) (fig. 4). Move the lever backward and forward to check that cables are properly installed and operating.

## Assembly of single lever control on the wall

Position the gear in the desired position (90° intervals), insert in the stud bolts in their seats. Fix by means of 4 M6x25 screws and tighten them. Insert the flange covering, and fit it until it is firmly locked. (fig. 5)

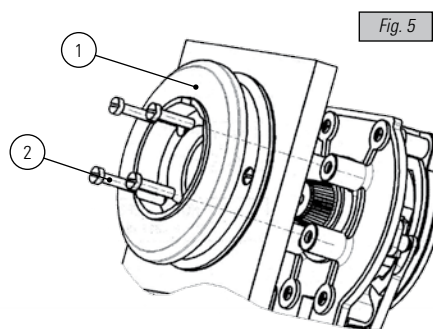


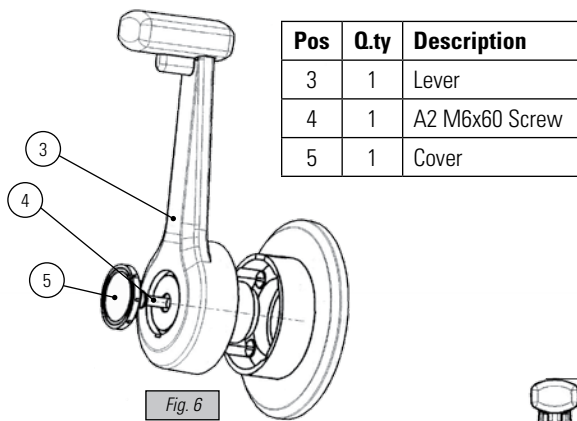
Fig. 5

Pos	Q.ty	Description
1	1	Flange covering
2	4	A2 M6x25 Screw



## Lever installation

Before proceeding, check that the gear is in neutral position. Insert the lever (3) in the hub, positioning the safety lock in the stop ring key (fig. 6). Fasten the lever with one M6x60 screw (4) and tighten. Fix the cover (5) in its seat.



## Use of the controls

The SL single lever controls are provided with a safety lock function, to prevent accidental in gear switching. To engage the gear, press the switch (or pull up the lever) and push the lever in forward or reverse position. Warm up of the engine can be done while in neutral position, by pushing on the front of the lever towards the wall and then move the lever forward or reverse (the safety lock remains engaged). It is recommended to carry out a complete check of the system after few hours of operation, and carry out periodical overhauls.

**Craftsman Marine shall not be liable for any damages and/or bad functioning due to or caused by improper use of the parts supplied or inobservance of the present instruction.**

