

THE CONTENTS OF THIS BOOK

Introduction	3	The Engine Lube Oil	18
The Boater's Dictionary	4	The Power Steering Fluid	19
The Operating Controls		How To Clean And Set The Spark Plugs	19
The Main Gauge Panel	5	How To Replace The Water Separating Fuel Filter	19
The Accessory Switch Panel	6	The Cooling System — Recirculating System	19
The Steering Wheel	7	Fresh Water Coolant — Closed Cooling System	20
The Capacity Specification Plate	7	The Bilge Pump	20
The Ignition Switch	8	The Ventilation System	20
The Horn Button	8	The Fresh Water System	21
The Control Handle	9	The Sanitary System	21
The Outdrive Control Switch — Mercruiser	9	How To Maintain The Exterior Surface Of The Boat	21
The Outdrive Control Switch — Volvo	9	Plexiglass Surfaces	22
The Battery Main Switch	10	How To Maintain The Interior Of The Boat	22
The Compass	10	Below The Water Line Of The Boat	22
The Fire Extinguisher	11	Service Inspection	22
The Washdown Pump	11	How To Prepare The Boat For Lay-Up	
How To Prepare Your Boat For Operation		The Bilge Area	23
How To Fill The Fuel Tank	12	The Engine	23
How To Fill The Water Tank	13	The Battery	23
How To Fill The Baitwell With Water	13	How To Support The Boat During Storage	24
To Remove The Water From The Baitwell	14	Storage	24
How To Open And Close The Windshield Vent	14	To Commission The Boat	25
To Transport The Boat On A Trailer	14	Model 2550 Cuddy Stern Drive Specifications	26
Do These Procedures Before Each Use Of The Boat	15	Drawings And Parts Lists	
How To Operate The Boat		Model 2550 Cuddy Stern Drive Replacement Parts —	
Recommended Safety Check Procedure	16	Exterior Profile	28,29
How To Start The Boat	16	Model 2550 Cuddy Stern Drive Replacement Parts — Exterior	30,31
To Stop The Boat	17	Model 2550 Cuddy Stern Drive Replacement Parts — Interior	32,33
Maintenance		The Mechanical, Fuel & Plumbing Drawing	34,35
The Electrical System	18	The Electrical System Drawing	36
The Engine	18		



Dear Pursuit® Owner:

All of us at S2 Yachts are pleased that you have selected one of our products as your boat. As I'm sure you've discovered during the selection and decision process, your Pursuit® has been designed, engineered and built with care and precision.

Please allow me to note this personal philosophy. When I started this company, my goal was to provide you, our customer, with the finest quality boat available. Everything we have achieved since that time has been with that same goal in mind.

The information in this owner's manual has been assembled to assist you with your Pursuit® Sport Yacht for maximum enjoyment. Please read this manual completely and always operate your boat safely and courteously.

Thank you for selecting a Pursuit®. We all wish you many years of boating fun and safety.


Sincerely,


Leon R. Slikkers
Chief Executive Officer

INTRODUCTION

This manual has important information for the use and safe operation of your Pursuit.® Read and understand the manual before operating your boat. Keep this manual, and tell all operators to read the manual.

For the safe operation of this boat, read and understand all warnings and cautions. Look for these symbols:

“ **WARNING**” means: If you do not follow the instructions in a warning, injury or death can occur to you or other people.

“ **CAUTION**” means: If you do not follow the instructions in a caution, damage can occur to the boat or equipment.

All directions given in this book are as seen from the stern looking toward the bow.

IMPORTANT NOTE: Your boat uses internal combustion engines and flammable fuel. Every precaution has been taken by S2 to reduce the risks associated with possible injury and damage from fire or explosion, but your own precaution and good maintenance procedures are necessary in order to enjoy safe operation of your boat.

Owner manuals from the manufacturers of the engines, the generator, the head, the stove, the refrigerator, etc., are included in the literature packet. Read these manuals. To validate the warranty on these parts, fill out the warranty cards and return the cards to the manufacturers.

A guide to power boat ownership and operation, “You and Your Boat”, is included in the literature packet. **Read it carefully.**

After the boat is delivered, make sure you and your dealer fill out the “Delivery Launching Record and Boat Registration” form. Return the copy marked “S2 Yachts” to S2 Yachts, Inc., 725 E. 40th Street, Holland, Michigan 49423-5392 USA.

THE BOATER'S DICTIONARY

Aft: At, near or toward the stern.

Anchor Rode: Anchor rope.

Athwartship: From side to side of a boat.

Bedding: Caulking compound or application of caulking compound.

Bilge: Inside bottom of the boat's hull.

Bow: The front of the boat.

Bow Rail: A protective guard around the bow of the boat.

Bulkhead: Vertical partitions dividing the hull.

Castoff: To let loose, set free.

Chine: The outer edge of the boat where the bottom meets the side.

Cleat: Hardware to wrap the mooring line around.

Companionway: Doorway.

Cradle: A frame to support the boat while the boat is out of the water.

Deck: The portion of the boat from the gunwales up.

Fender: A cushion or pad to prevent damage to the side of the boat.

Forward: Toward the front.

Galley: The kitchen.

Gunwales: An upper edge of the hull side.

Hatch: A cover for an opening.

Head: Toilet.

Helm: The wheel by which a boat is steered.

Limber Hole: Holes through the bulkhead or stringer to allow water to pass to the pump.

Lay-Up: To put in storage.

Marine Gear: The transmission.

Moored: To keep a boat in place by means of a rope or anchor.

Porthole: An opening in the side of the boat to let in air and light.

Portside: The left side of a boat when facing the bow.

Prop: Propeller.

Rubrail: A protective guard on the gunwale of a boat.

Rudder: A hinged flat piece at the rear end of the boat that directs the boat.

Scupper: An opening in the hull of a boat to let water run off the cockpit floor.

Seacock: A valve on any underwater thru-hull.

Starboard: The right side of a boat when facing forward.

Shaft Log: A tube through which the prop shaft passes through the bottom of the boat.

Slings: Straps by which the boat is lifted.

Stern: The hind part of a boat.

Strake: A rib on the bottom side of the hull running fore and aft.

Stringer: A support member inside the hull.

Strut: The metal casting bolted to the bottom of the hull to support the cutlass bearing for the propeller shaft.

Stuffing Box: A chamber through which the propeller shaft passes.

Taffrails: The rails around the stern of the boat.

Thru-Hulls: A fitting through the hull of the boat.

Thru-Hull Strainer: A filter attached to the thru-hull fitting.

Transom: The vertical portion of the hull at the back of the boat.

Underwater Gear: Any component that is fastened to the outside of the hull under water.

THE OPERATING CONTROLS

The Main Gauge Panels. There are two gauge panels. One panel is above the steering wheel on the main console. The other panel is in the starboard side panel. The gauges on the panels monitor the engines.

The following gauges are found on the panel above the steering wheel. See figure 1.

The Speedometer (1). The speedometer indicates the speed of the boat in miles per hour.

The Tachometer (2). The tachometer measures the rpm of the engine.

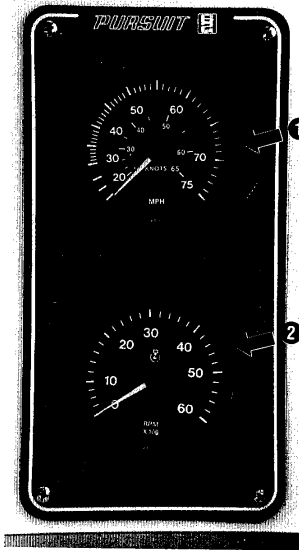


Figure 1

The following gauges are found on the starboard side panel. See figure 2.

The Oil Pressure Gauge (1). The gauge monitors the oil pressure of the engine.

The Engine Temperature Gauge (2). The gauge indicates the operating temperature of the engine.

The Volt Gauge (3). The gauge shows the voltage for the battery. The normal voltage reading is between 11 and 14.5 volts.

The "Trim" Gauge (4). The gauge indicates the operating angle of the lower drive unit. The "Up" position of the gauge indicates the "full up" position of the drive unit. The "full trim" position is when the indicator is in the center position of the gauge. The "DN" position of the gauge indicates the "Full In" position of the drive unit.

The Fuel Gauge (5). The gauge indicates the amount of fuel in the port fuel tank.

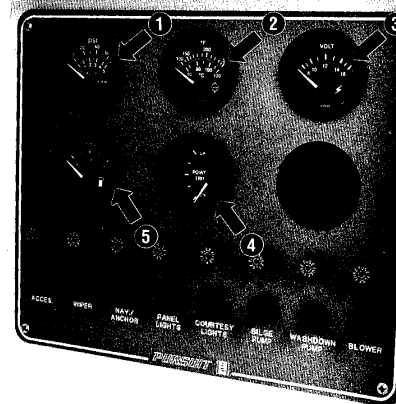


Figure 2

The Accessory Switch Panel. See figure 3.

The accessory switch panel is below the gauge panel. The following switches are found on the accessory switch panel:

The Switch For The Windshield Wipers (1). To activate the wipers, put the switch in the "On" position.

The "Nav-Anchor" Light Switch (2). The switch is a three-position switch. Put the switch in the "Up" position to turn on the navigation lights. Put the switch in the "Down" position to turn on the anchor light. The center position of the switch is the "Off" position.

The Switch For The Panel Lights (3). To illuminate the panel lights, put the switch in the "On" position.

The Switch For The Courtesy Lights (4). To illuminate the lights, put the switch in the "On" position.

NOTE: The bilge pump will start automatically when there is water in the bilge area.

The Switch For The Bilge Pump (5). The bilge pump is installed in the center of the bilge. The pump moves water out through the thru-hull fittings in the transom. To start the pump manually, put the switch in the "On" position.

CAUTION: To prevent damage to the bilge pump, do not operate the pump when there is no water in the bilge area.

The Switch For The Washdown Pump (6). To activate the pump for the washdown system, put the switch in the "Up" position.

The Switch For The Bilge Blower (7). Your boat has a bilge blower to remove the fumes from the engine compartment. The blower is installed in the engine compartment with ducts running to the lowest part of the compartment. To start the blower, put the switch in the "On" position.

NOTE: Each accessory switch is protected by a fuse. The fuse to protect each switch is above the switch.

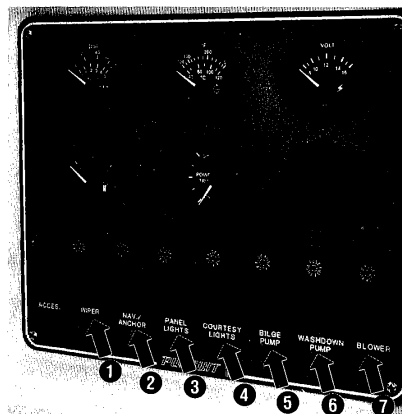


Figure 3

The Steering Wheel. See figure 4.

The steering wheel is below the console gauge panel. The steering wheel controls the direction of the boat.

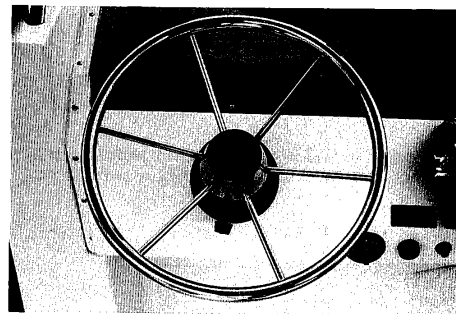


Figure 4

The Capacity Specification Plate. Not shown.

The plate is on the forward starboard side of the cockpit. The maximum safe capacity load for the 2550 Cuddy Stern Drive is 10 persons, or 1,550 lbs. The maximum total combined safe capacity weight of persons, motor and gear is 1,925 lbs.



WARNING: To prevent loss of control or capsizing of the boat, make sure you do not exceed the maximum safe capacity load set for your boat.

The Ignition Switch. See figure 5.

The ignition switch is on the starboard side of the console below the control handle. The ignition switch controls the starting and stopping of the engine.

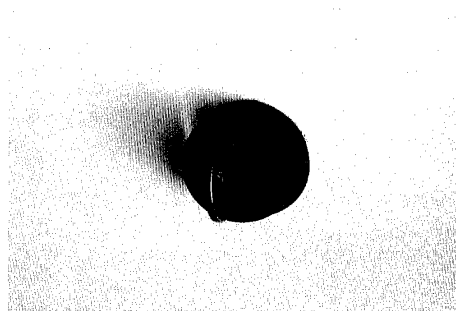


Figure 5

The Horn Button. See figure 6.

The horn button is to the right of the ignition switch. Press the button to activate the horn.

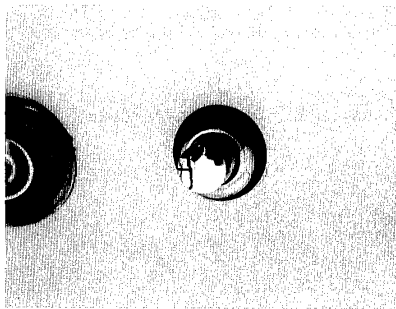


Figure 6

The Control Handle. See figure 7.

The control handle is on the starboard side of the steering wheel. The handle is on a single control which controls the rpm of the engine and the shifting of the marine gear.



Figure 7 MerCruiser

Volvo

The “Outdrive Control” Switch — MerCruiser*. See figure 8.

The “Outdrive Control” switch is in the control handle (1). To lower the outdrive unit, press and hold the switch toward the “Down” position. To raise the outdrive unit, press and hold the switch toward the “Up” position. When the drive unit is in the needed position, release the switch.

To raise the MerCruiser drive unit to the “full-up” position when transporting, beaching or launching the boat, and when operating the boat in shallow water, put the “Trailer” switch in the “Up” position (2).



Figure 8

MerCruiser

The “Outdrive Control” Switch — Volvo*. See figure 9.

The “Outdrive Control” switch is in the control unit (1). To lower the outdrive unit, press and hold the switch toward the “Down” position. To raise the outdrive unit, press and hold the switch toward the “Up” position. When the drive unit is in the needed position, release the switch.

To raise the Volvo drive unit to the “Full Up” position when transporting, beaching or launching the boat, and when operating the boat in shallow water, press the button on the left side of the instrument panel (2). At the same time, push and hold the switch on the right side of the panel (3) in the “Up” position.

For more information on the outdrive control, read the manual for the engine.

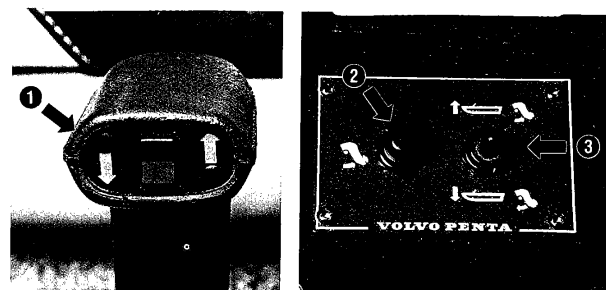


Figure 9

Volvo

*MerCruiser is a trademark of Brunswick Corp.

*Volvo is a trademark of Volvo Penta.

The Battery Main Switch. See figure 10.

The battery main switch is in the battery compartment on the aft port side of the boat. The switch controls the 12-volt electrical system of the boat. To activate the system, the "Battery Main" switch must be in the "On" position.



CAUTION: To prevent damage to the alternator, do not turn the battery main switch off while the engine is running.

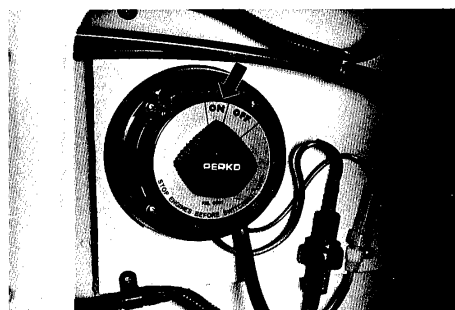


Figure 10

The Compass. See figure 11.

The compass is on top of the console above the steering wheel. To adjust the compass for your area, read the instructions on "Compass Compensation" given to you in the literature packet.

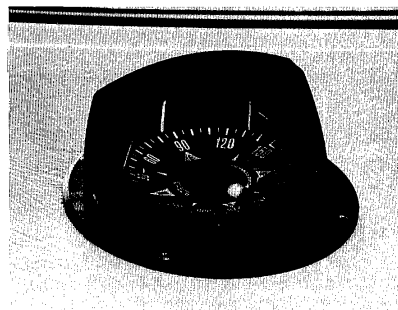


Figure 11

The Fire Extinguisher. See figure 12.

A U.S. Coast Guard approved fire extinguisher is given with the boat. The fire extinguisher is in the cabin on the port side of the companionway.

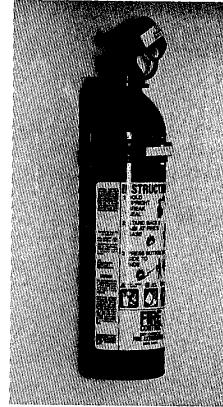


Figure 12

The Washdown Pump Option.

The pump is in the port side of the bilge. To get access to the pump, lift the cover to the engine room. The pump is a pressure demand type pump. The switch to activate the pump is on the accessory switch panel. The hose connector is on the port side of the engine cover. See figure 13.

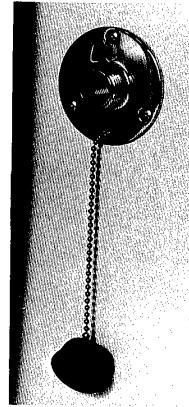


Figure 13

HOW TO PREPARE THE BOAT FOR OPERATION

The fuel system of your boat is designed to use regular or unleaded gasoline.

How To Fill The Fuel Tank

WARNING: Fuel is very flammable. Be careful when filling the fuel tank. NO SMOKING. Never fill the tank while the engines, motors, and fans are running. Fill the fuel tank in an open area.

To fill the fuel tank at a marina, follow this procedure:

1. Make sure all switches are in the "Off" position.
2. Make sure the boat is securely moored.
3. Make sure all passengers leave the boat.
4. Estimate how much fuel is needed.

NOTE: When the fuel tank is full, fuel will come out through the fuel vent fitting. The vent for the fuel is on the port side of the boat. See figure 14.

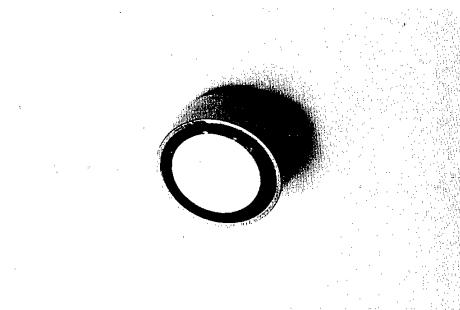


Figure 14

CAUTION: To prevent damage to the fuel system, use only leaded or unleaded gasoline for the gasoline engine. Do not use a fuel which contains harsh additives or is an alcohol blend. Any damage done to the fuel system which is the result of use of an alcohol blend will not be covered by the S2 Warranty.

5. A special key to unlock the fuel cap is given to you. Insert the key in the slot in the fuel cap. The fuel cap for the fuel tank is midship in the covering board on the port side of the boat. See figure 15.

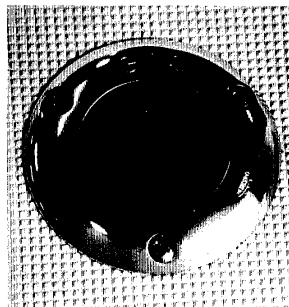


Figure 15

6. Turn the key counterclockwise to unlock the cap.
7. Remove the cap.
8. Put the nozzle in the fuel opening.

WARNING: To prevent static sparks when filling the tank, make sure the nozzle is in contact with the fuel opening.

9. Fill the fuel tank.
10. Remove the nozzle.
11. Install the fuel cap.

WARNING: Make sure the fuel compartment lid is open for five minutes before the engine(s) or electrical equipment are started.

WARNING: To reduce the risk of a fire and/or explosion, do not start the engine(s) when fuel fumes are present. Fuel fumes are dangerous and harmful to your health.

WARNING: Make sure all gasoline odors are investigated immediately.

12. Check the fuel compartment and below deck for fuel odors. If you smell fuel, do not start the engine.

How To Fill The Water Tank

The fill cap to the fresh water tank is midship on the port side of the boat. See figure 16.

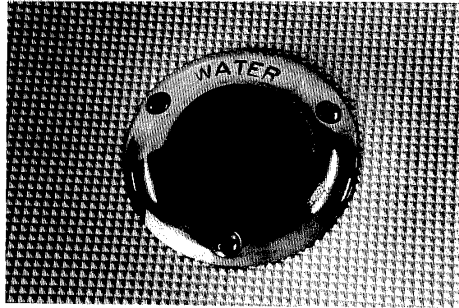


Figure 16

To fill the tank, follow this procedure:

1. A special key to unlock the fill cap is given to you. Insert the key in the slot in the cap.
2. Turn the key counterclockwise to unlock the cap.
3. Remove the cap.
4. Fill the tank with clean fresh water.

NOTE: The water tank is full when water comes out of the water vent fitting. The water vent fitting is in the port side of the boat. See figure 17.

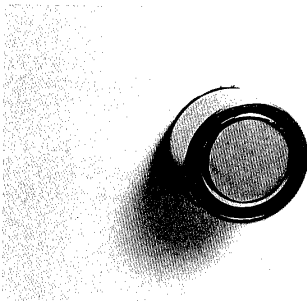


Figure 17

5. Put the cap in position.

6. Turn the key clockwise to lock the water cap in position.

NOTE: The water pressure pump is a demand type pump. If the fresh water tank is empty and the breaker switch for the pump is in the "On" position, the pump will continue to run. Make sure the switch is in the "Off" position when there is no water in the tank.

How To Fill The Baitwell With Water

The "Baitwell" switch is on the accessory panel. See figure 18.

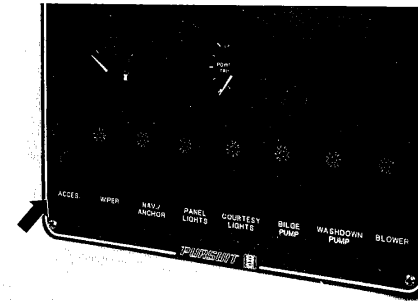


Figure 18

NOTE: A manual valve that allows new water to circulate in the baitwell is in the upper part of the well. See figure 19.

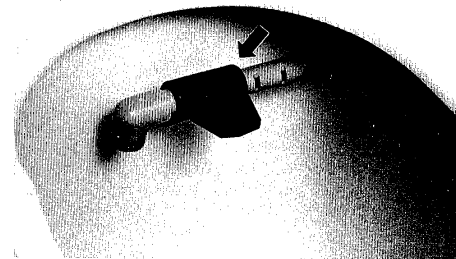


Figure 19

To fill the baitwell with water, follow this procedure:

1. Open the valve. The valve is open when the lever is in-line with the fill tube.
2. Put the baitwell switch in the "On" position.
3. After the baitwell is filled with water, close the manual valve to allow the water to circulate.

To remove the water from the baitwell, follow this procedure:

NOTE: This procedure takes two people, one to operate the boat and one to remove the baitwell plug.

1. Put the baitwell switch and the valve in the "Off" position.
2. While the boat is running, remove the plug from the bottom of the baitwell. See figure 20.

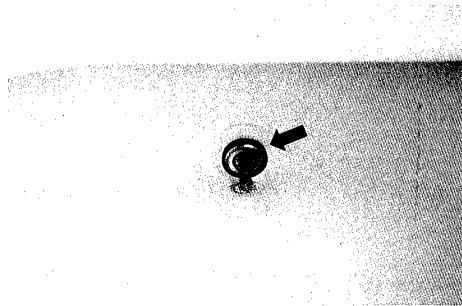


Figure 20

3. Allow the water to drain from the baitwell.
4. After the water has drained from the well, install the plug in the bottom of the baitwell.

How To Open And Close The Windshield Vent

To open the windshield vent, follow this procedure:

1. Turn the knob counterclockwise.
2. Push the knob forward.
3. Turn the knob clockwise to lock the vent in the open position.
4. To close the vent, turn the knob counterclockwise.
5. Pull the knob back until the vent is closed.
6. Turn the knob clockwise to lock the vent in the closed position.

To Transport The Boat On A Trailer

To transport the boat on a trailer, follow this procedure:

1. Make sure the trailer is a match for your boat's weight and hull design.

NOTE: Contact your dealer to evaluate your towing vehicle and hitch, and make sure you have the correct trailer for your boat.

2. The Gross Vehicle Weight Rating must be shown on the trailer. Make sure the weight of the boat, engines, gear and trailer is not more than the Gross Vehicle Weight Rating.
3. Make sure the boat is securely fastened on the trailer to prevent movement between the boat and trailer.

NOTE: Your dealer will give instructions on how to load, fasten and launch your boat.



WARNING: Make sure your towing vehicle and trailer are in compliance with all state and local laws. Contact your state motor vehicle bureau for laws governing the towing of trailers.

Do These Procedures Before Each Use Of The Boat

1. Check the fuel supply. If the fuel is needed, read "How To Fill The Fuel Tank".

⚠ WARNING: Do not operate the boat when fuel fumes are present. Fuel fumes are dangerous and harmful to your health.

2. Check the fuel compartment for fuel leaks and fumes.
3. Remove the inspection plate over the fuel tank. Make sure all fuel lines and fittings are tight. See figure 21.

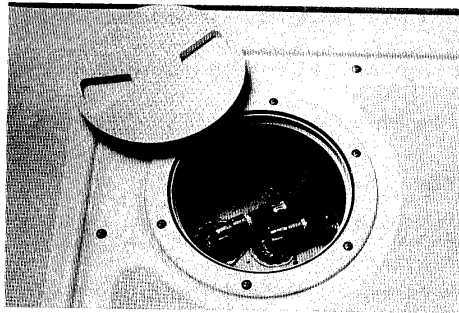


Figure 21

4. Make sure there are no fumes in the fuel compartment.
5. Put the battery main switch in the "On" position. See figure 22. The battery main switch is in the port battery compartment.

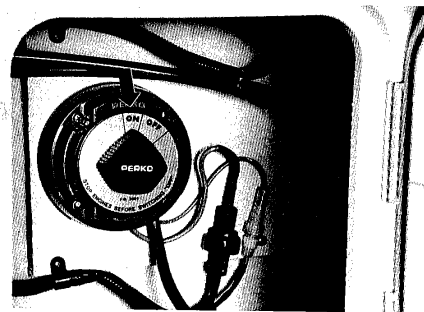


Figure 22

6. Check the engine oil level.

⚠ CAUTION: To prevent damage to the engine, do not operate the boat when the oil level mark is below the "Add" mark.

To check the oil level, remove the dipstick from the engine. If the oil level mark is on or below the "Low" mark, add oil. See figure 23. To add oil, remove the oil filler cap. Make sure the oil does not pass the "Full" mark on the dipstick. Read the engine manual for the correct type of oil.

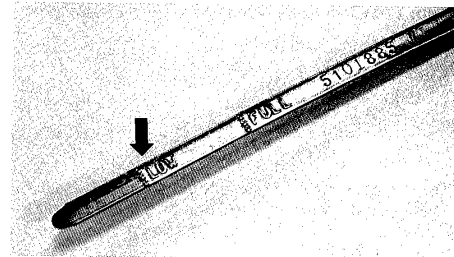


Figure 23

⚠ WARNING: Make sure the bilge pump is in good operating condition. Do not use the boat if the pump is malfunctioning. Replace the pump immediately.

⚠ WARNING: Large debris will clog the bilge pump and hoses and cause switch malfunctioning.

7. Inspect the bilge area. Remove the debris from the bilge area.
8. Test all switches on the accessory panel. See figure 24. Make sure the switches activate the equipment they control, and all equipment is in good operating condition.

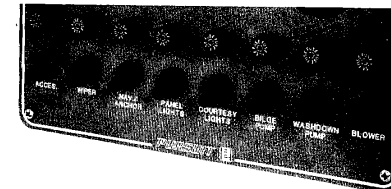


Figure 24

9. Put the outdrive in the full-in position.

HOW TO OPERATE THE BOAT

Recommended Safety Check Procedure

The following is a recommended safety check procedure for getting underway.


1. Make sure you have signal kits and flare guns aboard, and they are in good operating condition.
2. Make sure you have a complete First Aid Kit aboard.
3. Have a tool kit aboard. The kit should include the following basic tools:

Spark plug wrench	Hammer
Spark plug gap gauge	Electrician's tape
Screwdriver	Lubricating oil
Pliers	Jackknife
Adjustable Wrench	Vise grip
Pipe Wrench	


WARNING: There must be at least one personal flotation device on-board for every person on-board and one throw-out flotation device. Check the U.S. Coast Guard standards for the correct type of device for your boat.

4. Make sure life preservers and life rings are on-board and in good condition.
5. Have the following spare parts on-board:

Extra light bulbs	Spark plugs
Fuses	Flashlight and batteries
Drain plug	Engine oil
Propeller	Fuel filters
Propeller nut and washer	Fuel hose and clamps

 **WARNING:** Vaporizing liquid extinguishers give off toxic fumes; use only Coast Guard approved fire extinguishers.

6. Make sure all fire extinguishers are in position and in good operating condition.

 **CAUTION:** To prevent damage to the anchor lines, mooring and towing lines, do not stow wet cordage in the rope locker or below decks.


7. Check the capacity plate. Make sure you do not overload the boat.
8. Make sure all lines, cables, anchors, etc. for securing a boat are on-board and in good condition. Make sure all lines are coiled, secured and off the decks when underway.
9. When you operate a boat, you accept the responsibility for the boat, for the safety of passengers and for others out enjoying the water.


Remember:

1. Alcohol severely reduces the ability to react to several different signals at once.
2. Alcohol makes it difficult to correctly judge speed and distance, or track moving objects.
3. Alcohol reduces night vision, and the ability to distinguish red from green.

Do not operate the boat while under the influence of alcohol.


How To Start The Boat


 **WARNING:** To reduce the risk of a fire or explosion, do not start the engines when fuel fumes are present. Fuel fumes are dangerous and harmful to your health.

 **WARNING:** Make sure the engine lift hatch is open for five minutes before the engine is started.

 **WARNING:** Make sure the bilge blower runs for a minimum of four minutes before the engines are started.

 **WARNING:** Activate the bilge blower when operating the boat below cruising speed.

 **WARNING:** Make sure one other person on the boat is instructed in the operation of the boat.

 **WARNING:** Make sure the boat is operated in compliance with all state and local laws governing the use of a boat.

NOTE: For more instructions on safety, equipment and boat handling, enroll in one of the several free boating courses offered. For information on the courses offered in your area, call the "Boating Course Hotline", 1-800-336-2628.

To start the boat, follow this procedure:

1. Make sure the control handle is in the neutral position

NOTE: The boat has a neutral safety switch. The engine will not start if the control handle is not in the neutral position.


2. Put the key in the ignition.
3. If the engine is cold, follow this procedure:

For the MerCruiser Drive Unit

1. Press the "Throttle Only" button. The "Throttle Only" button is in the lower port side of the control.
2. Push the control handle all the way forward and back to the 1/4 throttle position two times.

For the Volvo Drive Unit — read the owner's manual for the engine given to you in the literature packet.

4. Pull the control handle back to the "Neutral" position.

 **WARNING: Protecting persons on the boat is the owner's responsibility. Do not start an engine until you are sure there are no fuel fumes in the engine compartment or in the bilge of the boat.**

5. Turn the ignition key clockwise to the start position.
6. After the engine starts, release the key.
7. Let the engine run until the oil pressure is at least 30 psi and the operating temperature is normal.

NOTE: The boat can be maneuvered from the slip or launching ramp when the temperature indicator is at 125°F. Normal operating temperature is 140°-150°F. If the temperature reading goes above 150°F, stop the engine. Investigate the cause. Make sure the problem is corrected before you start the engine. If the boat has a closed cooling system, the normal operating temperature is 150°F-180°F.

8. Make sure the volt reading is between 11 and 14.5 volts. If the reading is below 11 or above 14.5, stop the engines. Investigate the cause. Make sure the problem is corrected before you start the engine.
9. To go forward, follow this procedure:
 1. Firmly push the control handle to the "Forward" position.
 2. Then slowly push the control handle to the desired speed.



CAUTION: To prevent damage to the marine gear, make sure the engine is in the idle position before shifting gears. The idle position is when the engine rpm reading is 650. Pause in the neutral position before shifting to the opposite position.

10. To operate the boat in the reverse direction, follow this procedure:
 1. Pull the control handle to the "Neutral" position.
 2. Shift into the reverse gear. To shift into the reverse gear, firmly pull the control handle to the "Reverse" position.
 3. Slowly pull the handle back.

NOTE: For the recommended engine break-in procedures and more operating instructions, read the engine manual given with this boat.



WARNING: Do not operate the boat if the drive unit is damaged.

NOTE: If the drive unit hits an underwater object, stop the engine. Inspect the drive unit for damage. If the unit is damaged, contact your dealer for a complete inspection and repair of the unit.


To Stop The Boat

To stop the boat, follow this procedure:

NOTE: If the engine has been run at high speed for a long period of time, allow the engine to cool down by running the engine at 650 rpm for 3 to 5 minutes.

1. Allow the engine to drop to the idle speed.
2. Make sure the shifting lever is in the neutral position.
3. Turn the ignition key to the "Off" position.
4. If you are going to leave the boat for a short period of time, put the battery main switch in the "Off" position and close all seacocks.
5. Make sure the boat is securely moored.


MAINTENANCE


 **WARNING:** Do not operate the boat unless it is completely assembled. Keep all fasteners tight. Keep adjustments according to specifications.

The Electrical System

Check the electrical system before each use. Make sure all switches activate the equipment they control, and all equipment is in good operating condition.

The boat has a 12-volt electrical system. A 12-volt DC battery supplies power to all electrical equipment on the boat. The battery is a lead-acid type battery.

 **WARNING:** Lead acid batteries generate gases which can cause an explosion. NO SMOKING. Always wear eye protection and protective clothing when working near batteries. Remove all jewelry. Do not put tools or other metal objects across the battery terminals or the tops of the batteries.

 **WARNING:** Before doing any maintenance, make sure all switches are in the "Off" position.


These maintenance procedures must be done to the battery twice every season:

1. Clean the battery. To clean the battery, follow this procedure:
 1. Disconnect the battery.
 2. Use a cloth and a solution of bicarbonate of soda to wipe the tops of the battery.
 3. Clean the battery terminals.
 4. Reconnect the battery.
2. Check the battery and add distilled water as needed. The correct level is within 1/4 inch of the bottom of the tube in each cell.

The battery is self-charging when the engine is running. If the system is used for a long period of time without the engine running, the battery may need to be charged.

 **WARNING:** To prevent an explosion, charge the batteries only in an area with good ventilation.


 **WARNING:** Lead acid batteries generate gases which can cause an explosion. To prevent an explosion, turn the timer knob on the charger to the "Off" position before connecting and disconnecting the charger output connector. Keep sparks and flames away from the batteries. NO SMOKING.

 **CAUTION:** The negative poles are grounded on the batteries. Reverse polarity will cause damage to the alternator. When using a jumper cable or external charging, always connect the red (+) cable to the positive terminal and the black (–) cable to the negative terminal of the battery.


To charge the battery, read the owner's manual for the charger for instructions on how to use the charger and charge the battery.


The Engine

As different types of engines are used to power the boat, read the owner's manual for the engine for more information on the engine installed in your boat.

 **WARNING:** Before doing any maintenance to the engine, make sure all switches are in the "Off" position.


 **WARNING:** Fuel is very flammable. NO SMOKING.

 **CAUTION:** Check the throttle and clutch control system for wear, corrosion, and loose fittings. Keep all connections clean. Make sure all fittings are tight. Have all worn parts replaced.

 **CAUTION:** Check all fittings for leaks. Check all linkage in the steering and rudder system for corrosion, looseness, and wear. Make sure all connections are tight. Have all worn parts replaced.

Check the fluids in the engine before each use of the boat.

The Engine Lube Oil

 **CAUTION:** To prevent damage to the engine, do not operate the boat when the oil level mark is below the "Add" mark or above the "Full" mark on the dipstick.

Remove the dipstick from the engine and check the oil level. If the oil level mark is on or below the "Add" mark, add oil. To add oil, remove the oil filler cap. Make sure the oil does not pass the "Full" mark on the dipstick. Read the engine manual for the correct type of oil.

To change the oil and oil filter, read the instructions given to you in the engine owner's manual.

The Power Steering Fluid

To check the power steering fluid, follow this procedure:

Remove the dipstick from the engine to check the fluid level. If the engine is warm, the fluid level should be between the "Full Hot" mark and the "Add" mark. If the fluid level is below the "Add" mark, add automatic transmission fluid.

NOTE: When adding transmission fluid, make sure the fluid does not pass the "Full Hot" mark on the dipstick.

If the engine is cold, the fluid level should be between the "Full Cold" mark and the bottom of the dipstick. If the fluid level is below the bottom of the dipstick, add transmission fluid.

NOTE: When adding gear fluid, make sure the fluid does not pass the "Full Cold" mark on the dipstick. Read the engine manual for the correct type of automatic transmission fluid.

How To Clean And Set The Spark Plugs

Clean and set the spark plugs after the first 20 hours of use and then at least once a year.



CAUTION: Use only a wire brush and commercial solvent to clean the spark plugs.

To clean and set the spark plugs, follow this procedure:

1. Use a socket wrench to remove the spark plugs from the engine.
2. Use a wire brush and clean the electrodes, insulator and threads.
3. Wash the spark plugs in a commercial solvent.
4. Use a spark plug gauge and adjust the spark plug gap to .035.

NOTE: For Volvo engines, adjust the spark plug gap to .028.

5. Use a socket wrench and install the spark plugs.

NOTE: Replacement spark plugs must be of the same heat range. Change the spark plugs after each 100 hours of use and before each season.

How To Replace The Water Separating Fuel Filter

The water separating fuel filter is in front of the engine on the starboard side. To replace the filter, follow this procedure:

1. Turn the filter cannister counterclockwise.
2. Remove the fuel filter and sealing rings from the holding bracket.
3. Discard the fuel filter.
4. Install a new fuel filter. To install the filter, follow this procedure:
 1. The sealing rings are on top of the filter. Apply a little engine oil to the tops of the sealing rings.
 2. Put the fuel filter and the sealing rings in position on the holding bracket.
 3. Use your hand and turn the fuel filter clockwise until the filter is tight. Do not use a filter wrench to tighten the filter.

The Cooling System — Recirculating System

If the boat has a recirculating cooling system and is used in saltwater, flush the cooling system after each daily use.

To flush the system when the boat is out of the water, follow this procedure:

1. Install a flush-test device over the water inlet holes on the gear housing.

NOTE: Get the flush-test device from your dealer.

2. Connect one end of a garden hose to the flush-test device.
3. Connect the other end of the garden hose to the water supply outlet.



CAUTION: To prevent damage to the engine, do not use full city water pressure.

4. Turn the faucet for the water supply to the half-way open position.
5. Put the control handle in the "Neutral" position.
6. Start the engine.
7. Put the control handle in the "Idle" position.

8. Let the engine run for 10 minutes or until the discharge water is clean.
9. Stop the engine.
10. Turn off the water supply.
11. Remove the garden hose from the flush-test device and the water supply outlet.
12. Remove the flush-test device.

To flush the system when the boat is in the water, follow this procedure:

1. Make sure the outdrive is in the "Full Up" position.
2. Install the flush-test device over the water inlet holes in the gear housing.
3. Connect one end of a garden hose to the water supply outlet.
4. Connect the other end of the garden hose to the water supply outlet.
5. Put the switch for the outdrive control in the "Down" position to lower the outdrive control all the way.

CAUTION: To prevent damage to the engine, do not use full city water pressure.

6. Turn the faucet for the water supply to the half-way open position.
7. Put the control handle in the "Neutral" position.
8. Start the engine.
9. Put the control handle in the "Idle" position.
10. Let the engine run for 10 minutes or until the discharge water is clean.
11. Stop the engine.
12. Turn off the water supply.
13. Put the switch for the outdrive control in the "Up" position to raise the control.
14. Disconnect the garden hose from the flush-test device and the water outlet.
15. Remove the flush-test device.

Fresh Water Coolant — Closed Cooling System

If the engine has a closed cooling system, check the fluid level before each use of the boat.



WARNING: Hot water and steam will cause burns. Make sure the engine is cool before you remove the filler cap from the heat exchanger.

The correct level of fluid is 1" below the filler neck. If fluid is needed in the heat exchanger, fill the system with clean, fresh water or a coolant mixture. Read the engine owner's manual for recommended mixing instructions for the coolant. Do not overfill the system.

The Bilge Pump

NOTE: An inline fuse protects the automatic bilge pump. The fuse is installed in the engine room aft of the engine. See figure 25.

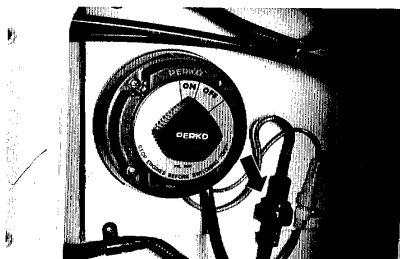


Figure 25

IMPORTANT: Check the fuse frequently to make sure the fuse is good. If the fuse is not good, replace the fuse.

The pump requires no lubrication. Inspect the bilge area. Make sure all connections to the pump and the thru-hull fittings are tight. Inspect the hose. If the hoses are damaged or worn, have the hoses replaced. Make sure the float moves without restriction. Visually inspect the wiring for loose connections and damaged wires. For electrical repairs, contact a qualified electrician.

The Ventilation System

The bilge blower is permanently lubricated and requires no maintenance. Visually inspect the ventilation system after each use of the boat.

1. Make sure the exhaust hoses are in position in the lowest part of the bilge.
2. Make sure the ducts are clean and free of obstructions.

The Fresh Water System

If the water system has not been used for a long period of time and you think it may be contaminated, sanitize the system. To sanitize the water system, follow this procedure:

1. Remove the water from the fresh water tank.
2. Pour a mixture of one gallon of water and 1/4 cup of household bleach for every 15 gallons of the tank capacity into the water tank.
3. Fill the rest of the tank with fresh water.
4. Open each faucet to release all air from the water lines.
5. After all air has been released, turn off each faucet.
6. Leave the mixture in the system for three hours and then remove all liquid from the fresh water tank.
7. Flush the system with potable water.
8. Fill the tank with potable water.

If after doing the above procedure, you can smell or taste the bleach mixture, follow this procedure:

1. Remove the water from the tank.
2. Mix one quart of vinegar with five gallons of water. Pour the solution into the fresh water tank.

NOTE: The motion of the boat while in use will cause the vinegar mixture to splash over the interior of the tank.

3. Leave the solution in the tank for several days.
4. Drain all liquid from the fresh water system.
5. Flush the system with potable water.
6. Fill the tank with potable water.

The Sanitary System

When the system needs to be emptied, follow this procedure:

1. Take the yacht to an area where the holding tank can be pumped out.
2. The cap to the waste deck fitting is in the bow area on the port side of the boat. A special key to unlock the cap is given to you. Insert the key in the slot in the cap.
3. Turn the key counterclockwise to unlock the cap.
4. Remove the cap.
5. Insert the pump out hose in the opening.
6. Remove all waste from the holding tank.
7. Fill the tank with clean water.
8. Remove the water from the tank.
9. Install the cap.

How To Maintain The Exterior Surface Of The Boat



CAUTION: Do not use abrasive cleaners on fiberglass. Abrasive cleaners dull the surface and will allow dirt to penetrate into the finish.

After each use of the boat, follow this procedure:

1. Rinse the boat with clean water.
2. Use a clean sponge and a mixture of detergent and water to wash the fiberglass surfaces.
3. Use a stiff fiber brush to wash the non-skid surfaces.
4. Rinse the boat with clean water.

At least once a year, apply wax and polish the smooth gelcoat surfaces. Use a good automotive wax or a boat wax. Before applying the wax, read the directions given with the wax.

After the boat is exposed to the direct sunlight for a period of time, the color in the gelcoat tends to fade, dull or chalk. A heavier buffing is required to bring the gelcoat back to its original luster. For power cleaning use a light cleaner such as Mirror Glaze #1. To clean the boat by hand, use a heavier automotive cleaner. Before cleaning the surfaces, read the instructions given with the cleaner. After cleaning the surfaces, apply wax and polish all fiberglass surfaces except the non-skid areas.

A pamphlet called "Congratulations Welcome To The Fiberglass Fleet" is included in the literature packet. For more information on the care of fiberglass, read the pamphlet.

If the fiberglass should become damaged and need repair, contact your dealer for an authorized repair person to make the repairs.

Plexiglass Surfaces



CAUTION: Do not use chemical solvents on plexiglass. Solvents scratch the plexiglass and damage the window sealant and hatch gaskets.

Use a mild soap and water, or a plexiglass cleaner to clean the windows and hatches.

How To Maintain The Interior Of The Boat

To keep the interior of the boat clean and dry, follow this procedure:

1. Clean below the decks just like you would a home interior. To preserve the woodwork, use a teak oil on all woodwork. Use a vacuum cleaner to pick up dirt in the cabin.
2. Air and sunlight are very good cleaners. Put cushions, blankets, sleeping bags, etc., up on deck in the sunshine to air and dry out.
3. If cushions or other equipment get wet with salt water, use clean fresh water to rinse off the salt crystals. Salt crystals retain moisture and will cause damage. Dry the equipment thoroughly.
4. If you leave the boat for a long period of time, put all cushions on their sides and open all lockers.



CAUTION: Do not use chemical solvents on plexiglass. Solvents scratch the plexiglass and damage the window sealant and hatch gaskets.

5. Use a mild soap and water, or a plexiglass cleaner to clean the windows.

NOTE: A cleaning kit to help maintain the exterior and interior of your boat, see figure 26, can be obtained from S2 Yachts.



Figure 26

The kit contains a Vinyl Shampoo, Marine Polish, Hull Cleaner, Boat Wash, Vinyl Conditioner, Sponge and a white S2 Bucket.

Call 1-800-843-3172 to order the Starbrite* Kit, part number CK9880.

**Starbrite is a registered trademark of Star Brite, Inc.*

Below The Water Line Of The Boat

When the boat is removed from the water, clean the outer bottom surface. Algae, grass, or dirt is easier to remove when alive or wet. Use a hard bristle brush to clean the surface.



CAUTION: To prevent damage to the fiberglass, do not sand the outer bottom surface of the boat.

If the outer bottom surface has been painted with anti-fouling paint, contact your dealer for recommended maintenance procedures.

Service Inspection

Contact the nearest S2 authorized dealer once a year for a maintenance inspection of the boat and to make any repairs. Use only genuine boat parts for repair.

When contacting your dealer or S2 Yachts, Inc. for parts or repair, make sure you give the hull number of the boat. The hull number is in the upper starboard area of the transom.

HOW TO PREPARE THE BOAT FOR LAY-UP

The Bilge Area

Make sure all water is removed from the bilge area. To remove the water, follow this procedure:

WARNING: Make sure the boat is out of the water before removing the hull drain plug.

1. Remove the hull drain plug. The plug is in the outside of the transom below the gimbal. See figure 27.

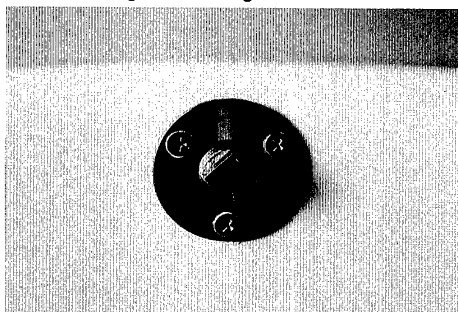


Figure 27

2. Pump out all water that does not drain from the compartment.
3. Use a sponge and wipe the bilge area until all water is gone.

The Engine

To prepare the engine and exhaust system for lay-up, read the owner's manual for the engine for the recommended preparation procedures.

The Battery

To prepare the battery for storage, follow this procedure:

1. Make sure the battery is fully charged.

WARNING: To prevent an explosion, charge the batteries only in an area with good ventilation.

2. Put the battery main switch in the "Off" position. See figure 28.



Figure 28

WARNING: Lead acid batteries generate gases which can cause an explosion. NO SMOKING. Always wear eye protection and protective clothing when working near batteries. Remove all jewelry. Do not put tools or other metal objects across the battery terminals or the tops of the batteries.

3. Disconnect the battery.
4. Clean the battery.
5. Add distilled water as needed to the battery.
6. Add a coat of petroleum jelly to the battery cable terminals.
7. Put the battery in a dry building with good ventilation. Make sure the battery is protected from freezing temperatures.

How To Support The Boat During Storage

Your trailer is the best support cradle for your boat during storage. Before you store the boat on a trailer for a long period of time, follow this procedure:

1. Make sure the rollers and pads support the hull of the boat.
2. Make sure the trailer hitch is level and there is support under the hitch.
3. Make sure the outdrive is in the down position.
4. Check the tires once each season. Add enough air for the correct amount of inflation for the tires.

NOTE: Read the owner's manual for the trailer for the correct amount of inflation for the tires.

Storage

Proper storage is very important to prevent serious damage to the boat. If the boat is to be stored indoors, make sure the building has enough ventilation. It is very important that there is enough ventilation both inside the boat and around the boat.

NOTE: If the boat is to be stored outdoors and a cover is to be used, build a frame over the boat to support the canvas or plastic cover. Make sure the frame is a few inches wider than the boat so that the canvas will clear the rails. Make sure the cover is fastened securely. A loose flapping cover will damage the gelcoat surface.

TO COMMISSION THE BOAT

⚠ WARNING: Do not operate the boat unless it is completely assembled. Keep all fasteners tight. Keep adjustments according to specifications.

To prepare the boat for commission, follow this procedure:

NOTE: It is important and recommended the fitting out procedure for the marine gear be done by a qualified service person. Read the owner's manual for the engine for the recommended procedure.

1. Install the battery.

⚠ WARNING: Before launching the boat, make sure the hull drain plug is installed.

2. Install the hull drain plug. See figure 29.

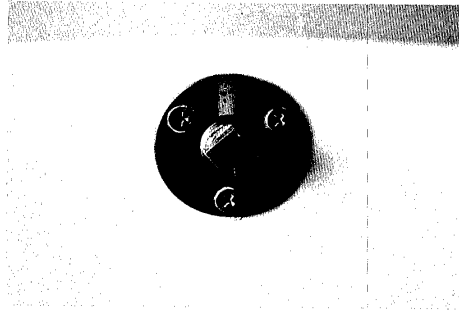


Figure 29

3. Clean and wax the boat.
4. Install all upholstery, mattresses and rugs.

MODEL 2550 CUDDY STERN DRIVE SPECIFICATIONS

Power Selection: Single I/O

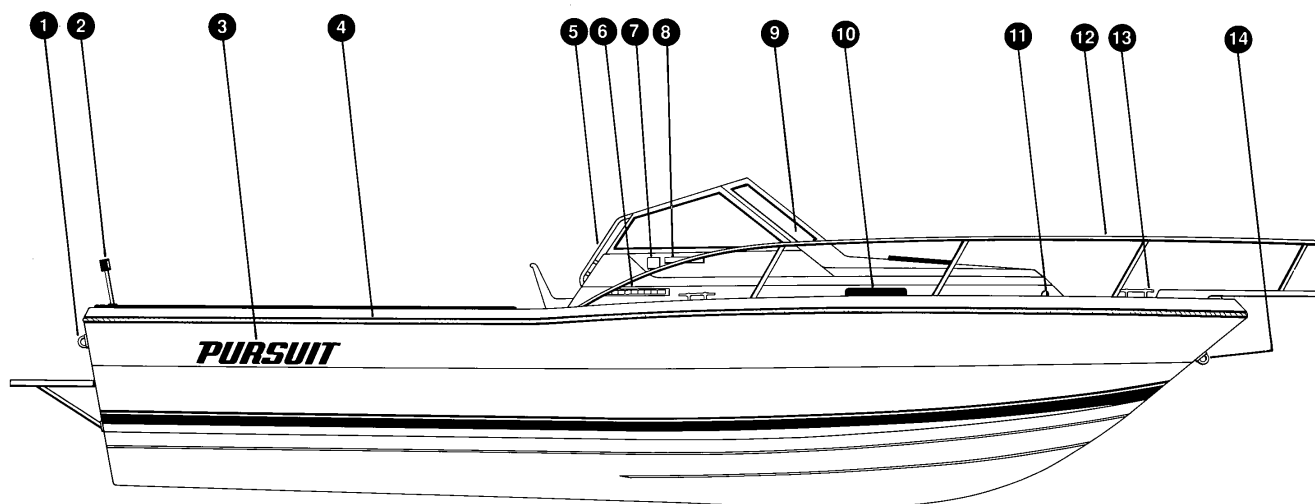
Specifications:

L.O.A. w/Pulpit	26'6"
L.O.A. w/o Pulpit	24'9"
Beam	8'6"
Hull Draft	1'4"
Approximate Dry Weight	4300 lbs.
Maximum Horsepower	260
Standard Fuel Capacity	149 U.S. gals.
Water Capacity	5 U.S. gals.
Sleeping Capacity	2
Cockpit Length	11'4"
Height Above Waterline	5'10"

NOTES:

This image shows a single sheet of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

MODEL 2550 CUDDY STERN DRIVE
REPLACEMENT PARTS — EXTERIOR PROFILE 11/89



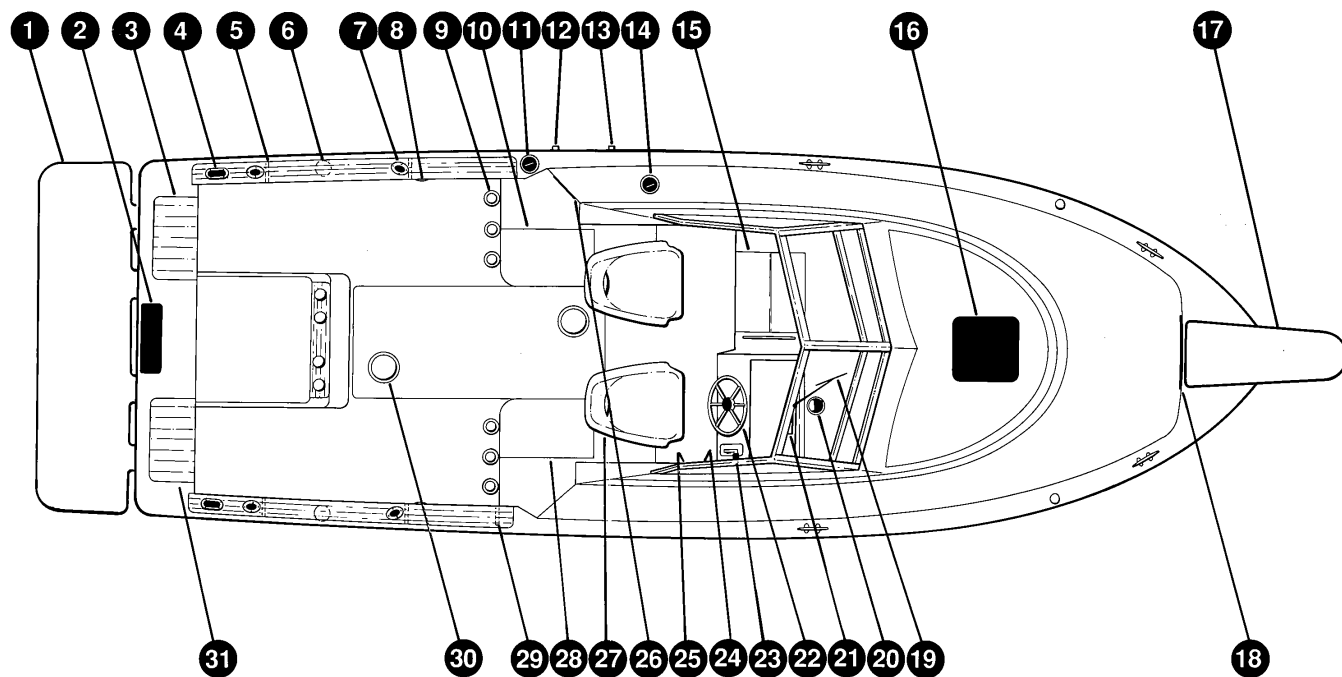
**MODEL 2550 CUDDY STERN DRIVE
REPLACEMENT PARTS — EXTERIOR PROFILE 11/89**

Ref. No.	Code No.	Description	No. Req'd
1	334133	Eye - Stern	2
2	327044	Light	1
3	543335	Logo - Pursuit	2
4	542044	Rubrail - Black	per ft.
	541025	Bar Aluminum - Flat	per ft.
	542073	Tubing - Vinyl	per ft.
	549005	Cap - Gunnel	1
5	534531	Handrail	1
6	534516	Vent - White	2

Ref. No.	Code No.	Description	No. Req'd
7	543207	Logo - 2" S2	2
	543208	Logo - 3" S2	1
8	543224	Logo - 2550	1
9	538080	Windshield	1
10	539120	Light - Port	2
11	327001	Light - Side	2
12	534166	Bowrail	1
13	534019	Cleat	6
14	334025	Eye - Bow	1

S2 reserves the right to make changes or improvements to its boats without notice.

**MODEL 2550 CUDDY STERN DRIVE
REPLACEMENT PARTS — EXTERIOR 11/89**



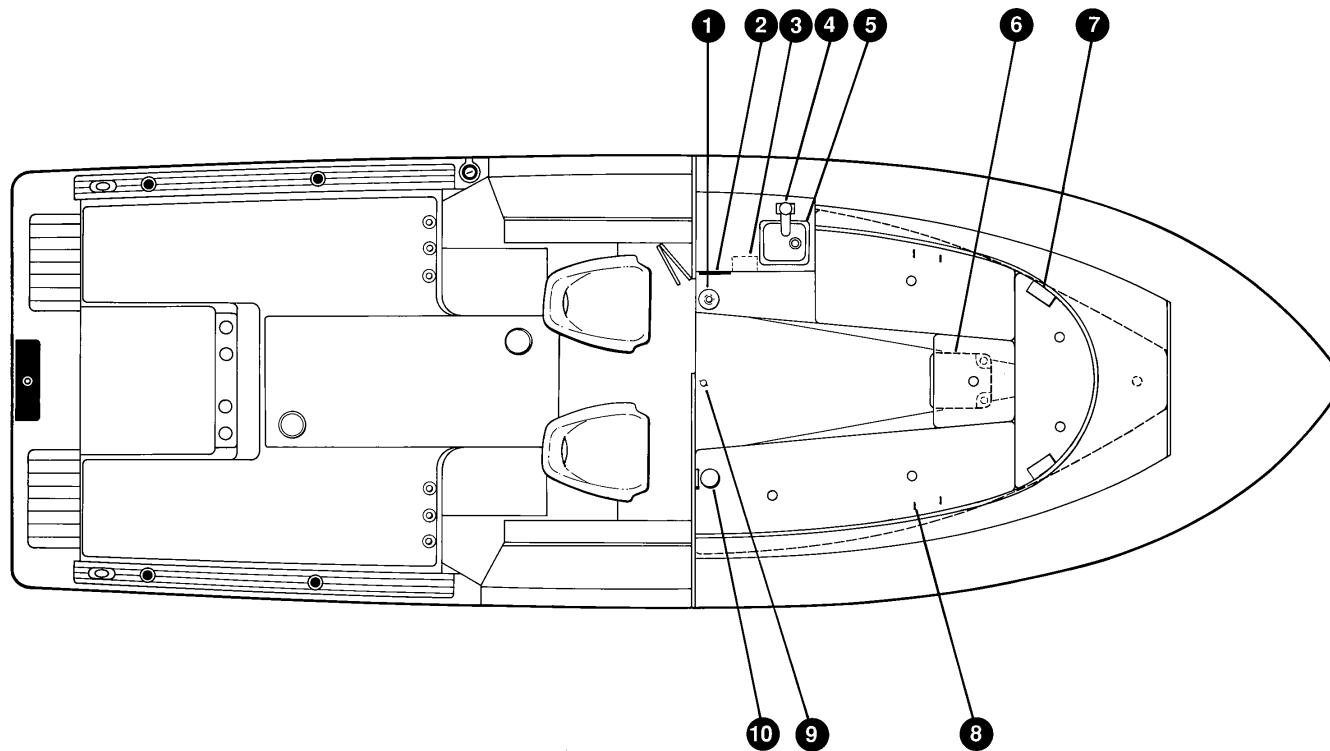
**MODEL 2550 CUDDY STERN DRIVE
REPLACEMENT PARTS — EXTERIOR 11/89**

Ref. No.	Code No.	Description	No. Req'd
1	504250	Platform - Swim Option	1
	549109	Bracket	4
	545022	Label - Warning	1
2	534049	Cover - Vent	1
3	842115	Hatch - Ice Chest Port	1
4	534032	Plate - Hawse Hole	2
5	534523	Rack - Rod	2
6	336020	Light - Courtesy	2
7	534031	Holder - Rod	2
8	335065	Speaker	2
9	746670	Holder - Rod	2
10	842025	Hatch - Fish Tank Port	1
11	334021	Cap - Fuel Fill	1
12	334022	Vent - Fuel	1
	534321	Shield - S.S.	1
13	334022	Vent - Water	1
	534321	Shield - S.S.	1
14	534077	Cap - Water Fill S.S. 1-1/2"	1
15	504022	Door - Companionway	1
16	747455	Hatch - Forward	1

Ref. No.	Code No.	Description	No. Req'd
17	753404	Pulpit - Bow	1
18	747449	Locker - Anchor	1
19	747463	Wiper - Windshield Assembly	ref.
	334034	Motor - Wiper	
	334035	Blade - 11"	
20	334036	Arm - Adjusting	1
21	325017	Compass	1
22	543224	Nameplate - "Pursuit"	1
23	315020	Steering Wheel	1
	313079	Control - Single Merc	1
24	313092	Handle And Bezel Kit - Volvo	1
	325230	Panel - Instrument And Switch	1
	325231	Panel - S/SD	1
25	708496	Radio - VHF	1
26	534081	Plate - Deck 4" White Smooth	1
27	747524	Seat - Companion And Helm	1 ea.
28	842026	Hatch - Fish Tank Stbd.	1
29	334069	Horn	1
30	534116	Plate - Inspection 6" Nonskid	2
31	842116	Hatch - Ice Chest	1

S2 reserves the right to make changes or improvements to its boats without notice.

**MODEL 2550 CUDDY STERN DRIVE
REPLACEMENT PARTS — INTERIOR 11/89**



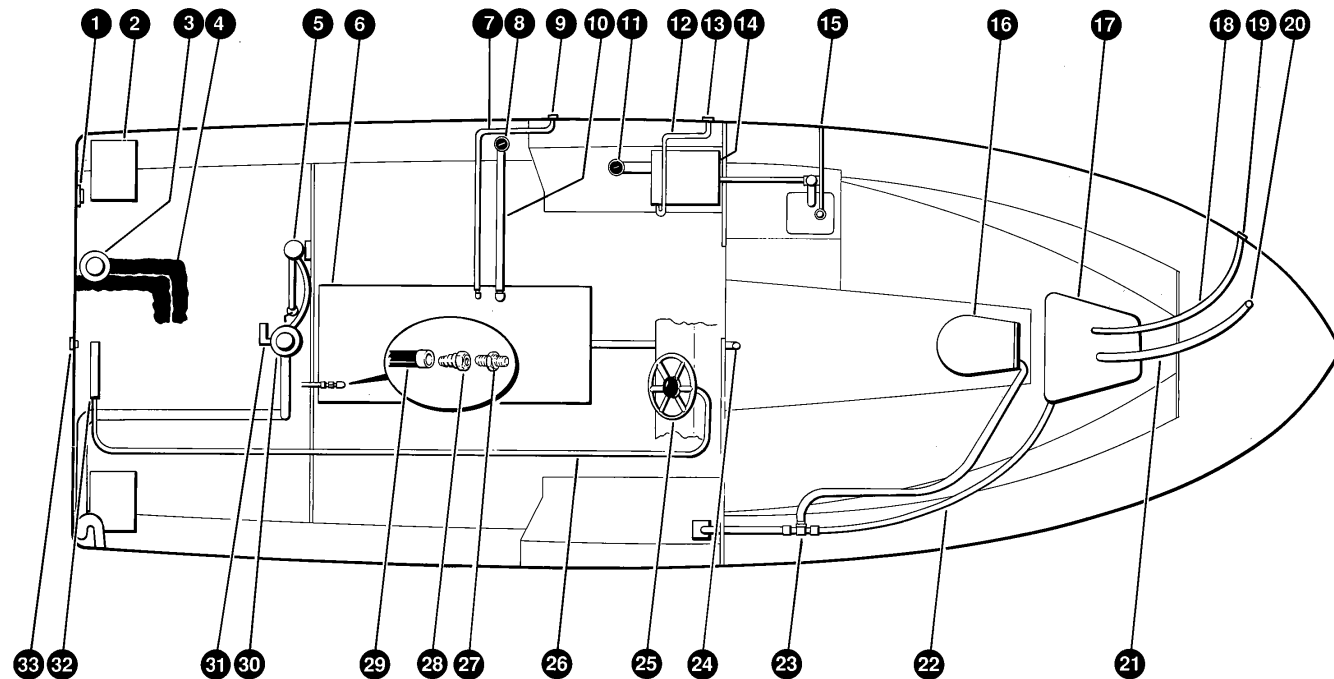
**MODEL 2550 CUDDY STERN DRIVE
REPLACEMENT PARTS — INTERIOR 11/89**

Ref. No.	Code No.	Description	No. Req'd
1	335001	Fire Extinguisher	1
2	335064	Stereo	1
3	336032	Light - Fluorescent	1
4	535207	Faucet	1
5	535002	Sink	1

Ref. No.	Code No.	Description	No. Req'd
6	535041	Head - Porta Potti	1
	535037	Head Option	1
7	335066	Speaker	2
8	534322	Rings - Rod Locking	4
9	334017	Plug - Bailer 1" w/8" Chain	1
10	327033	Light	1

S2 reserves the right to make changes or improvements to its boats without notice.

MODEL 2550 CUDDY STERN DRIVE
MECHANICAL, FUEL & PLUMBING 11/89



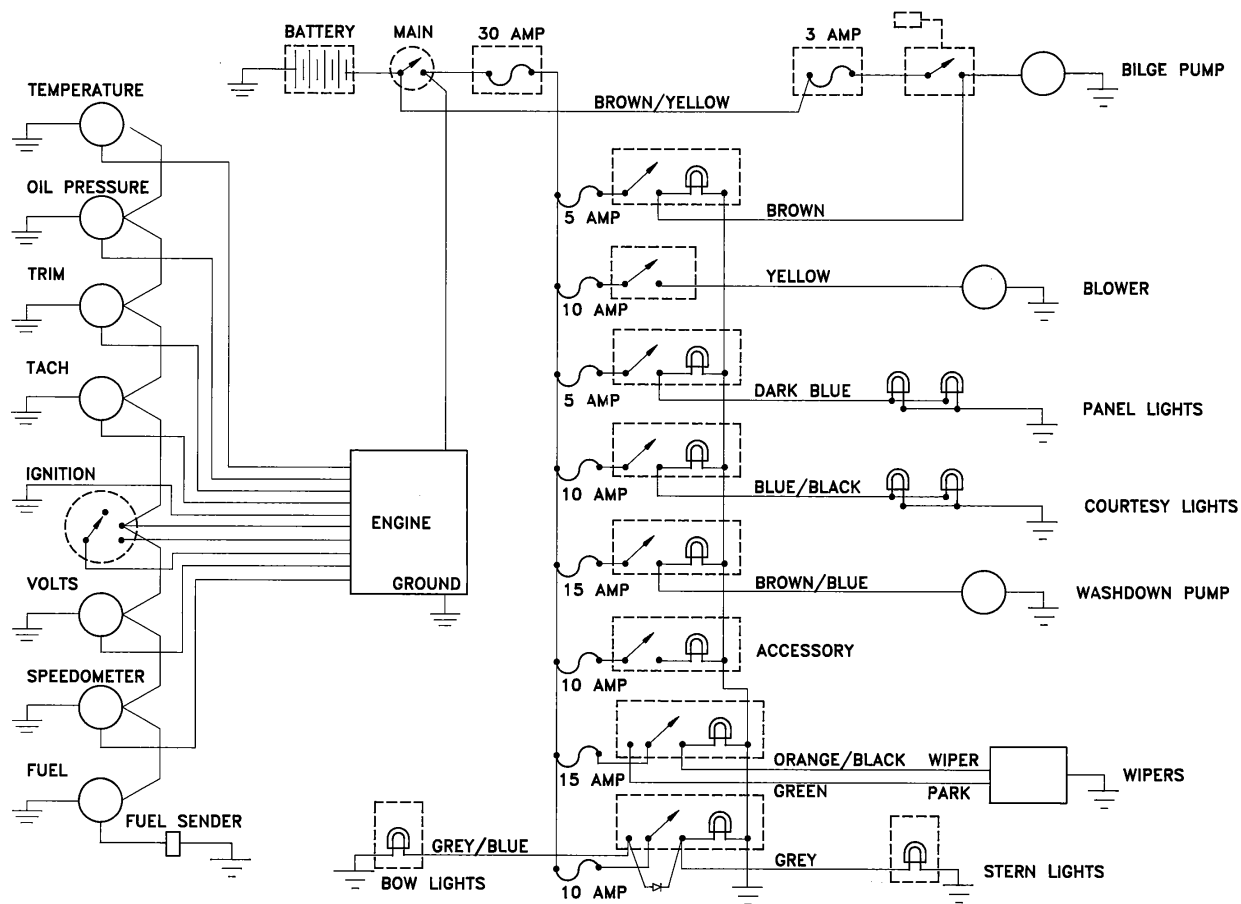
**MODEL 2550 CUDDY STERN DRIVE
MECHANICAL, FUEL & PLUMBING 11/89**

Ref. No.	Code No.	Description	No. Req'd
1	324011	Switch - Battery	1
2	335002	Box - Battery	2
3	345039	Blower	1
4	328153	Hose - Vent	kit
5	345010	Pump - Washdown	1
6	319107	Tank - Fuel 149 Gallon	1
7	328153	Hose - Fuel Vent	kit
8	334021	Cap - Fuel	1
9	334022	Vent - Fuel	1
	534321	Shield - Vent	1
10	328153	Hose - Fuel Fill	kit
11	534077	Cap - Water Fill	1
12	328153	Hose - Water Vent	kit
13	334022	Vent - Water	1
14	319108	Tank - Water 5 Gallon	1
15	328153	Hose - Sink Drain	kit
16	535041	Head - Porta Potti	1
	535037	Head - Option	1
17	708280	Tank - Holding	1
18	328004	Hose - Vent	1

Ref. No.	Code No.	Description	No. Req'd
19	334028	Vent - Waste	1
	534321	Shield - S.S.	1
20	534079	Cap - Waste	1
21	328140	Hose - Waste Pump-Out	1
22	328146	Hose - Water	per ft.
23	322014	"Y" Valve	1
24	747407	Tube - Keelson Drain	1
25	315020	Steering Wheel	1
26	316015	Cable - Steering	per ft.
27	326113	Adapter - 3/8 P x 3/8 T	ref.
28	326111	Adapter - 3/8 FM x 3/8 HB Brass	ref.
29	328153	Hose - Fuel Tank To Engine	per ft.
30	345071	Pump - Bilge	1
31	345070	Switch - Bilge	1
32		Cylinder	ref.
33	334130	Plug - Main Drain	1

S2 reserves the right to make changes or improvements to its boats without notice.

**MODEL 2550 CUDDY STERN DRIVE
ELECTRICAL SCHEMATIC 11/89**



WARNING: All electrical repairs must be performed by qualified personnel only.