



# MERCUISER SERVICE BULLETIN

Section: XII (Bulletins)

Number: 68-18 14

Date : 9/6/68

Cut individual items along broken lines and attach in appropriate sections of your MerCruiser Service Manual.

- A. Exhaust System Installation - MerCruiser II and III (Sec. II)
- B. Alignment Rod Lengths - MerCruiser 250 and 325 (For Section III)
- C. Installing Aluminum Oil Pan - MerCruiser V-8's (Section II)
- D. Quadrajet Carburetor Fuel Inlet Filters (Section VII)

## A. EXHAUST SYSTEM INSTALLATION - MerCruiser II and III

(For Installation Section II)

The exhaust hose, which connects to the exhaust manifold elbows on MerCruiser 200, 225, 250 and 325 stern drive engines and on MerCruiser 250 and 325 inboard engines, should be connected so that it does not restrict the flow of discharge water from the elbow.

Hoses, which are connected as shown in Figures 1 and 2, will prevent discharge water from flowing around the entire inside diameter of the hose and will cause a hot spot which may burn thru.

Hoses must be connected as shown in Figures 3 and 4. It is recommended that these hoses be checked when servicing the model engines listed in the first paragraph.

If an exhaust hose has burned thru, both hoses should be removed from the elbows and water deflector length checked. If deflectors protrude from elbow over  $\frac{1}{2}$ " (12.7mm), remove material from deflector as shown in Figure 5. Install new hoses as shown in Figure 3 or 4.

**IMPORTANT:** The hoses contained in MerCruiser Exhaust Kits meet government specifications. Exhaust hoses must conform to military specifications No. ZZH-428, Type 2, Grade 3, Class 2, which provides a minimum of 3-ply, fabric reinforced, marine-exhaust hose. They must be oil and ozone resistant and be of a medium volume swell. They also must have a minimum tensile strength of 1000 PSI (70.31 kgs./sq. cm.) and must not burst when submitted to a 250 PSI (17.58 kgs./sq. cm.) minimum pressure check. Wall thickness must be not less than  $\frac{15}{64}$ " (6mm) nor more than  $\frac{9}{32}$ " (7mm). Rubber must be of a 55 to 80 Durometer hardness.

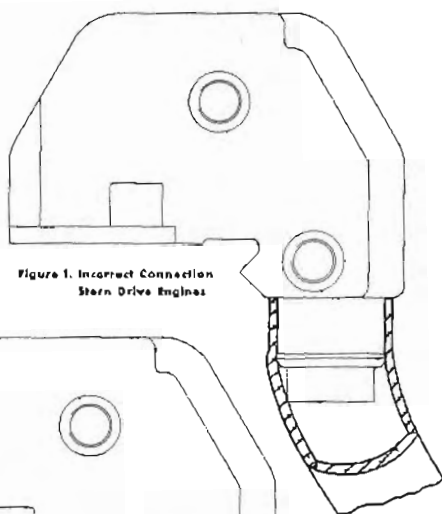


Figure 1. Incorrect Connection Stern Drive Engines

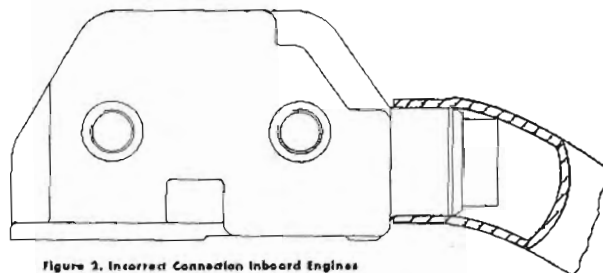


Figure 2. Incorrect Connection Inboard Engines

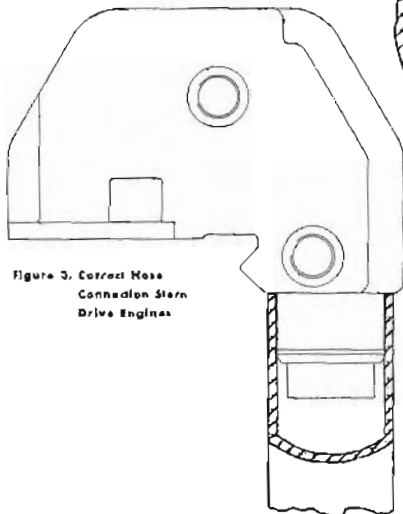


Figure 3. Correct Hose Connection Stern Drive Engines

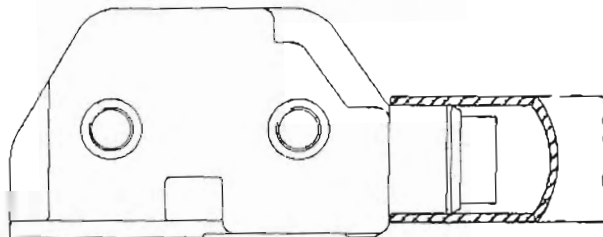


Figure 4. Correct Hose Connection Inboard Engines

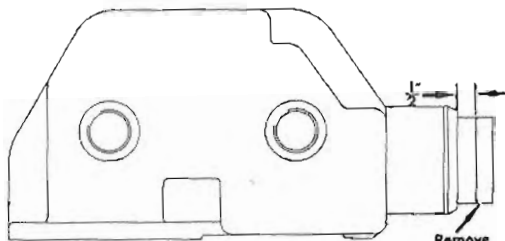


Figure 5. Water Deflector Modification

## B. ALIGNMENT ROD LENGTHS - MerCruiser 250 and 325 Models

*(For Installation Section II)*

It is extremely important that the correct engine alignment rod be used when aligning MerCruiser 250 and 325 Engines to the MerCruiser III Stern Drive Unit.

Align MerCruiser 250 Engines with Alignment Rod B-47457 (9.775±.010" [24.8cm±.254mm] long).  
Align MerCruiser 325 Engines with Alignment Rod B-47458 (10.712±.010" [27.2cm±.254mm] long).

The correct alignment rod is packaged with each engine at the factory. All installation personnel, however, should be notified of the different lengths of these rods, and installation procedures should be checked to be sure that the correct rod is used. The engine cannot be aligned properly if the wrong rod is used.

## C. INSTALLING ALUMINUM OIL PAN - MerCruiser V-8's

*(For Installation Section II)*

Before installing the aluminum oil pan on MerCruiser V-8 engines, coat the surfaces of the front and rear oil pan seals (Figure 6) with Oil Pan Sealant (C-92-52238-1).

C-92-52238-1

Oil Pan Sealant  
One 3-Oz. Tube

\$1.95 Net U.S.

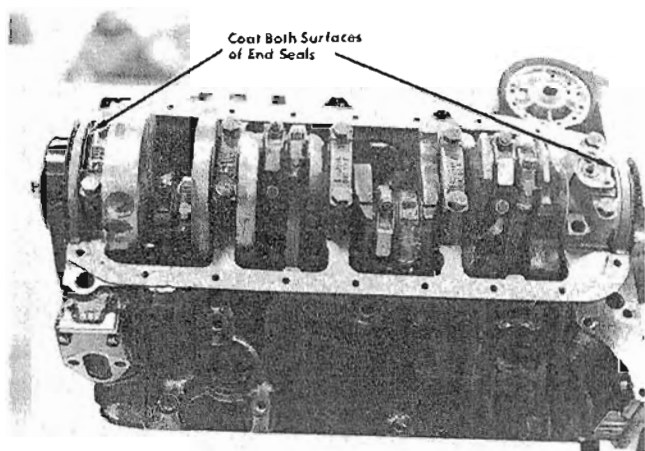


Figure 6. V-8 Oil Pan Seals

## D. QUADRAJET CARBURETOR FUEL INLET FILTERS

*(For Carburetion Section VII)*

It has been found in some cases that the fuel inlet filter, located inside Quadrajet Carburetors used on MerCruiser Engines with Serial No. 2314316 and below, does not allow sufficient fuel flow and may cause erratic engine operation. The filters on these engines should be replaced with a new filter (B-35-53386) if erratic engine operation is found and also when servicing these engines.

MerCruiser Engines, equipped with Quadrajet Carburetors and between Serial Nos. 2314317 and 2494935, do not have a fuel inlet filter installed in the carburetor. When servicing these engines, it is recommended that the new filter (B-35-53386) and spring (B-24-48143) be installed as shown in Figure 7.

MerCruiser Engines, Serial No. 2494936 and above, which are equipped with a Quadrajet Carburetor, have the new filter installed.

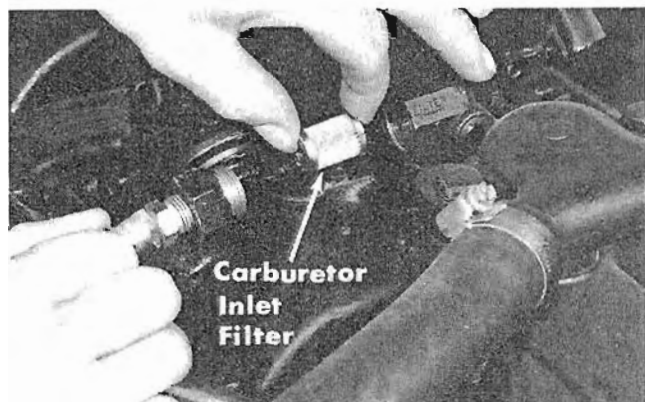


Figure 7. Quadrajet Fuel Inlet Filter