



CIRCULATE TO:

SERVICE MGR.

PARTS MGR.

MECHANICS

Place in Your "Service Bulletins" Binder

- A. New Sealers and Sealing Crankcase to Cylinder Block Recommendations
- B. New Gear Housing Cover Torque Tool - 6-Cyl. and 4-Cyl. Merc 850-800-650
- C. Replacement Light Bulb for Micro-Card Viewer
- D. Ride-Guide Installation - 1975 Merc 200 Model

A. NEW SEALERS and SEALING CRANKCASE to CYLINDER BLOCK RECOMMENDATIONS

(Attach Service Bulletin Sticker on Page 9-27 of Your Service Manual.)

To improve crankcase to cylinder block sealing, Mercury Service has made 2 new sealers available:

1. Sealer C-92-72592-1 is used on Merc 402 thru 1500 Outboards that contain a gasket strip between the crankcase and cylinder block.
2. Sealer C-92-73061-1 is used on crankcase and cylinder blocks without a gasket; i.e., Merc 45 thru 200 models and also older 4 and 6-cylinder powerheads. This sealer must be used in conjunction with Loctite Primer "T" (C-92-59327-1), as follows:
 - a. Surfaces must be clean for best results.
 - b. Apply continuous bead. If a void occurs in the bead during application, either remove the bead with a clean rag or apply additional bead parallel to the void and overlapping the previously applied bead.
 - c. Assemble mating parts without lateral movement. DO NOT break continuous bead.
 - d. Bead should be applied toward the inside of all mounting holes, as shown in Figure 1.
 - e. Wipe off excess sealer that remains soft outside the assembly.

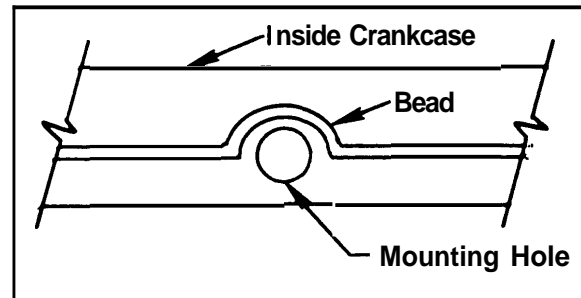


Figure 1. Bead Location

When using either sealer, cleanliness is most important. Both surfaces must be cleaned before sealer is applied. Use only the necessary amount to properly seal the crankcase to cylinder block, as any excess, that squeezes out, is waste. Follow directions on containers.

- C-92-72592-1 Sealer - Models with Gasket Strip between CC and Cyl. Block
- C-92-73061-1 Sealer - Models without Gasket between CC and Cyl. Block

B. NEW GEAR HOUSING COVER TORQUE TOOL - 6-Cyl. and 4-Cyl. Merc 850-800-650

(Attach Service Bulletin Sticker on Page 9-8 of Your Service Manual.)

Torque recommendation is 210 ft. lbs. (29mkg) on 6-cylinder and 4-cylinder Merc 850-800-650 gear housing covers. Use Torque Wrench Adaptor C-91-73688 to measure this torque.

C-91-73688

Torque Wrench Adaptor

C. REPLACEMENT LIGHT BULB for MICRO-CARD VIEWER

(Attach Service Bulletin Sticker on Page 9-21 of Your Service Manual.)

To replace a burned-out light bulb in your Micro-Card Viewer, order Replacement Light Bulb C-88-65158.

D. RIDE-GUIDE INSTALLATION - 1975 Merc 200 Model

(Attach Service Bulletin Sticker on Page 7A-9 of Your Service Manual.)

A quantity of 1975 model Merc **200** Outboards were built with cap nuts over the ends of the tilt tube. When installing a Ride-Guide Attaching Kit, it will be necessary to cut the nylon caps off the nuts with a hack saw;