



CIRCULATE TO:	SERVICE MGR.	PARTS MGR.	MECHANICS	Place in Your "Service Bulletins Binder"
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CRANKCASE COVER/CYLINDER BLOCK SEALING PROCEDURE - All Models

(Attach Service Bulletin Sticker to PP 6B-16, 6C-14, 6D-18 and 6E-24 in Your Service Manual.)

Supersedes ALL Information Previously Published on Crankcase Cover/Cylinder Block Sealing in the Mercury Outboard Service Manual and Service Bulletins.

IMPORTANT: When sealing crankcase cover/cylinder block, the mating surfaces **MUST BE** thoroughly cleaned before sealer is applied. Cleanliness is of utmost importance. Clean mating surfaces with Loquic Primer T, lacquer thinner or Acetone (or similar product) and a broad, flat scraper. **DO NOT** use solvents or cleaners, which have an oil or petroleum base, and use scraper carefully to prevent surface nicks or gouges.

Two (2) types of sealers are recommended, depending upon whether or not a strip gasket is used between the crankcase cover/cylinder block mating surfaces.

WITH Gasket Strip

Use C-92-72592 (Permatex #2 Form-a-Gasket) Sealer, as follows:

1. Apply sealer on crankcase cover in a thin, even coat, covering entire mating surface.
2. Place crankcase cover in position on cylinder block and proceed with reassembly procedures.
3. After securing crankcase cover, wipe off excess sealer along the crankcase cover/cylinder block splitline.

NO Gasket Strip

Use C-92-75505 (Loctite 514 Sealant) Sealer, as follows:

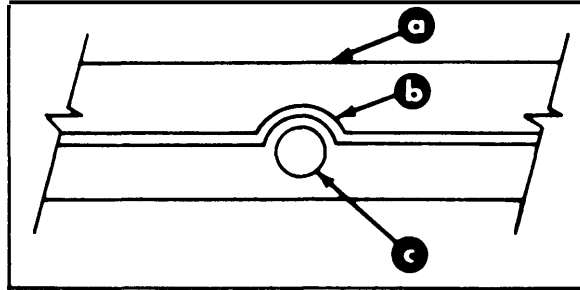
IMPORTANT: **DO NOT**, under any circumstances, continue to use C-91-73061 (Loctite ~~504~~ Sealant) as a crankcase cover/cylinder block sealer for Mercury Outboards.

1. Apply sealer on crankcase cover in a continuous, 1/16" (1.6mm) diameter bead. The bead should be toward the inside of all crankcase cover mounting holes (see sketch, over).

(OVER)

NOTE: If a void occurs in the bead, fill in the void, overlapping the original bead.

2. Carefully place crankcase cover in position on cylinder block (DO NOT break continuous bead of sealer) and proceed with reassembly procedures.
3. After securing crankcase cover, wipe off excess sealer along the crankcase cover/cylinder block splitline.



a - Inside Crankcase b - Bead
c - Mounting Hole

C-92-72592

Sealer (WITH Gasket Strip)

C-92-75505

Sealer (NO Gasket Strip)