

Circulate to: Sales Manager Accounting Service Manager Technician Parts Manager

3.0L OptiMax Air Compressor Mounting Bolt Torque

Scope

Worldwide

Models Affected

Models Covered	Engine Model	Serial Number
Mercury/Mariner 3.0L OptiMax	1200D83EY	1B881799–1B884579
	1200P73EY	
	1225D73EY	
	1225D84EY	
	1225E83EY	
	1225P83ED	
	1250D83EY	
	1250D93EY	
	1200D73EY	
	1200D84EY	
	1225D83EY	
	1225E73EY	
	1225E84EY	
	1226P73ED	
	1250D84EY	
	1250P83ED	
1251P73ED		
7225D83IY		

Situation

The clamp load on the air compressor mounting bolts may be compromised because of a minor interference fit between the mounting boss on the cylinder block and the air compressor mounting flange radius.

Correction

The four bolts securing the air compressor to the cylinder block must be loosened and retightened to the specified torque.

Description	Nm	lb-in.	lb-ft
Bolts	27		20


Procedure

1. Remove the top cowl.
2. Remove the flywheel cover.
3. Secure the flywheel with a flywheel holding tool.

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3.0L OptiMax Air Compressor Mounting Bolt Torque

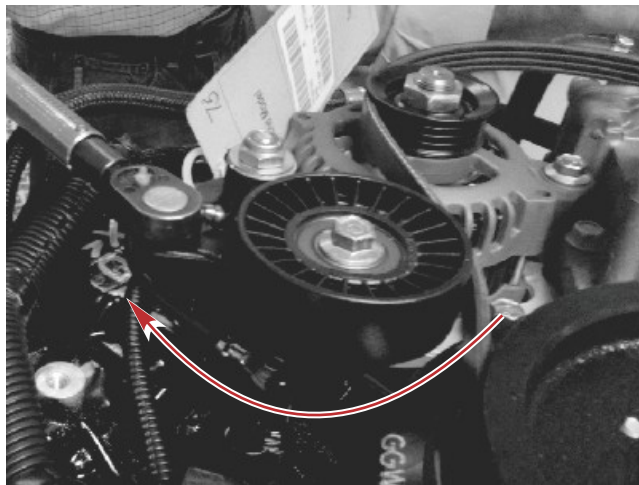
Flywheel Holding Tool	91- 52344
 <p>4738</p>	<p>Holds and/or turns the flywheel while making engine repairs, also used to torque the flywheel or the engine coupler.</p>

4. Loosen the air compressor pulley bolts. Do not remove them.



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5. Install a 3/8" drive breaker bar into the belt tensioner assembly.
6. Rotate the belt tensioner and remove the belt from the air compressor pulley.



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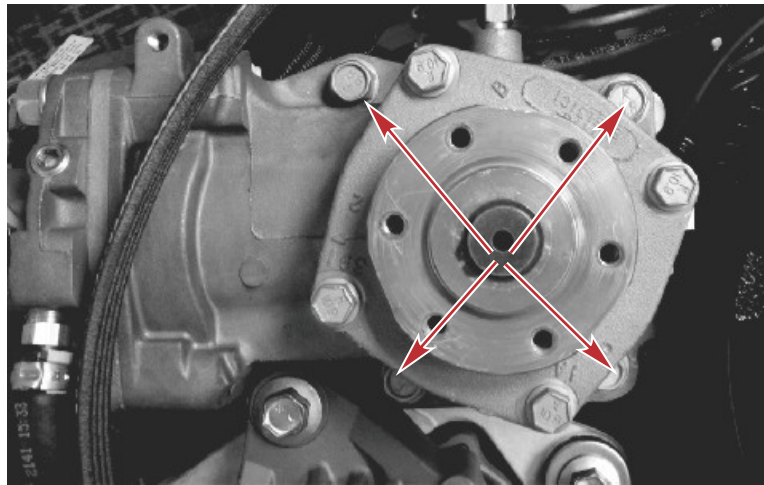
7. Remove the bolts, backing plate (if applicable), and pulley from the air compressor. Retain the components for reassembly.



- a - Backing plate
- b - Pulley
- c - Bolts

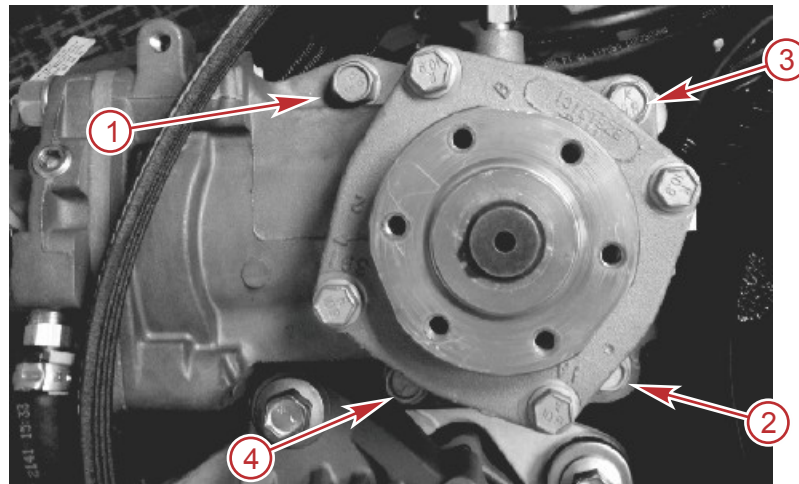
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8. Loosen the four bolts securing the air compressor to the cylinder block a minimum of one full turn.



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9. Tighten the air compressor mounting bolts to the specified torque in the sequence shown.



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Description	Nm	lb-in.	lb-ft
Air compressor mounting bolts	27		20

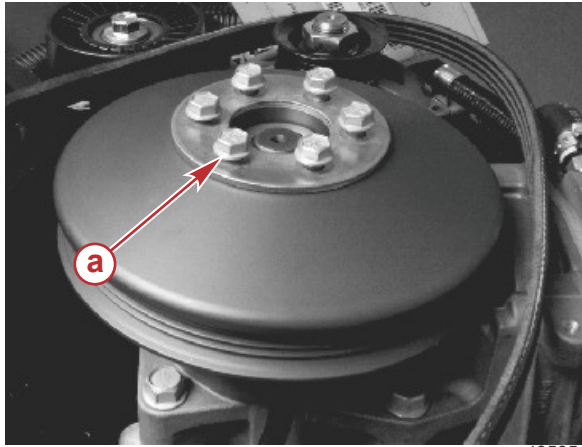
10. Install the pulley and backing plate (if applicable).

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- Apply Loctite 271 Threadlocker to the threads of the air compressor pulley bolts and install the bolts.

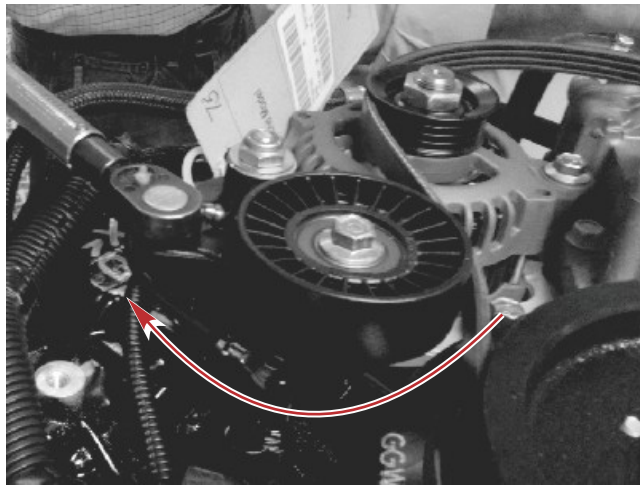


49595

a - Air compressor pulley bolts


Tube Ref No.	Description	Where Used	Part No.
 7	Loctite 271 Threadlocker	Air compressor pulley bolts	92-809819

- Install a 3/8" drive breaker bar into the belt tensioner assembly.
- Rotate the belt tensioner and install the belt onto the air compressor pulley.



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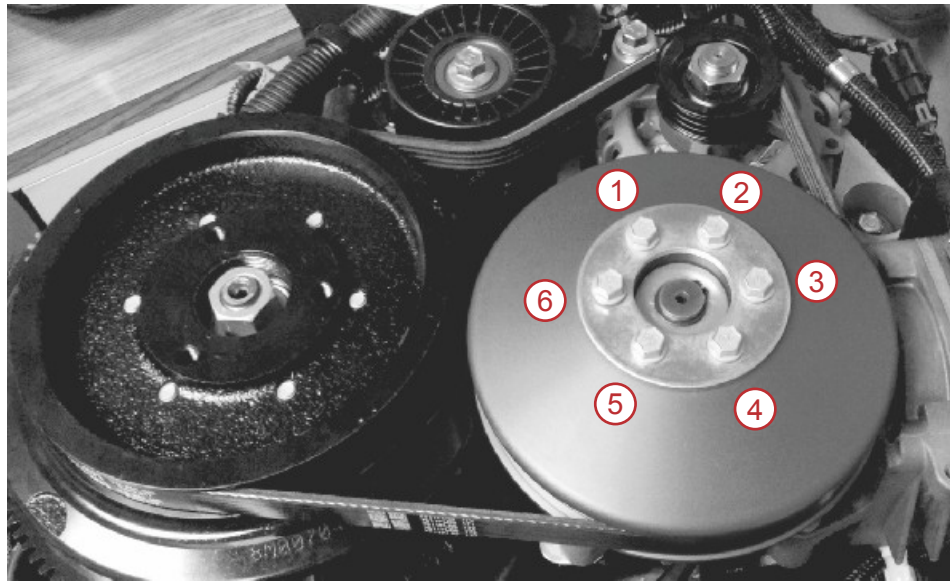
- Secure the flywheel with a flywheel holding tool.

Flywheel Holding Tool	91- 52344
 <p>4738</p>	Holds and/or turns the flywheel while making engine repairs, also used to torque the flywheel or the engine coupler.

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15. Tighten the air compressor pulley bolts in a clockwise rotation to the specified torque.



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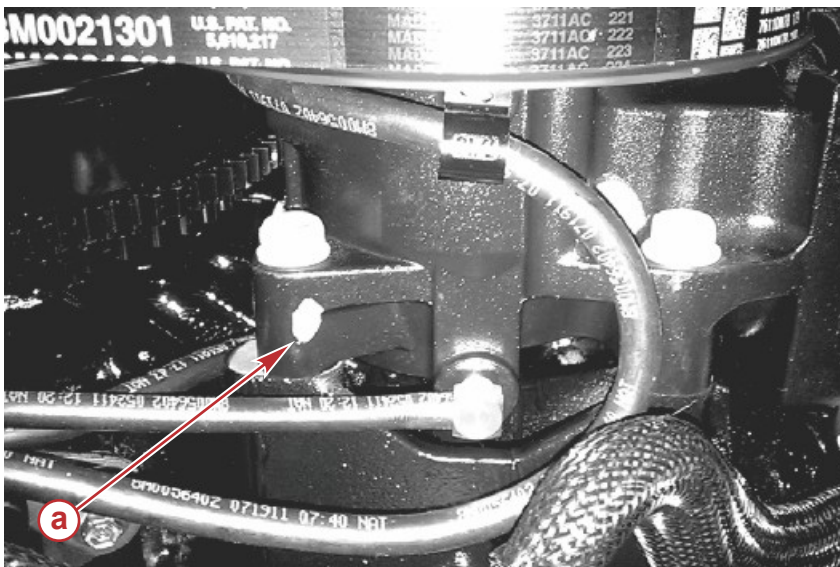
Description	Nm	lb-in.	lb-ft
Air compressor pulley bolts	19	168	

16. Apply a blue or white dot of paint on the air compressor mounting flange to identify the work has been completed.

Repair Identification

Product that was reworked at the factory will have a blue dot on an unpainted compressor and a white dot on an EDP compressor.

Product that was corrected at the dealership will have a blue or white dot on the air compressor mounting flange to identify the work has been completed.



49597

a - Dot on the air compressor mounting flange

Owner Notification

A customer letter has been sent to customers within the affected engine serial number range for the retorquing of the compressor mounting bolts.

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As the OEM installing the engine, the selling or servicing dealer, contact your customers to make them aware of this recall and to schedule an appointment for this repair.

A copy of the customer letter is attached.

Warranty

Complete a warranty claim listing:

Refer to outboard bulletin 2011-16/OEM 2011-12

- Outboard engine serial number
- Labor: 0.5 hour
- Warranty flat rate code: SB05
- Part code: 761
- Failure code: 00

Mercury Marine will credit the dealer for the cost of parts and labor during the engine warranty period.

US and Canada

Complete and process the claim via MercNET or return a warranty claim form.

International

Follow instructions issued by the Marine Power International office or by an authorized Marine Power Distributor.

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Dear Mercury Outboard Owner

Thank you for your purchase of a Mercury Outboard engine. Mercury Marine is dedicated to providing superior product reliability and customer satisfaction. As part of our commitment to superior customer satisfaction, we have determined that your air compressor relating to your engine's fuel system may need servicing for correct mounting bolt torque.

What is the condition?

Mercury Marine has determined that the air compressor mounting bolt torque may be incorrect. This may cause damage to the components of the motor. Mercury Marine has identified the cause of this condition and made the appropriate changes to the installation of the air compressor assembly.

What will Mercury Marine do?

Our dealers will perform an inspection of your air compressor to see if the unit is in need of repair. Mercury Marine has provided instructions to our dealers on the proper method of repairing the air compressor mounting torque if required.

What should you do?

Please contact your Mercury dealer and mention Outboard Service Bulletin 2011-16 to schedule an appointment for inspecting and possible repair of the air compressor assembly.

Your dealer will be able to determine how long this inspection/correction will take.

Please present this notice to your dealer when you bring your boat in for your service appointment.

What if you have other questions or if you no longer own this engine?

Please contact your Mercury Outboard dealer or call Mercury Outboard Customer Service at 1-920-929-5040 between 7:30 AM and 5:30 PM CST.

We have sent this notice in the interest of your continued satisfaction with our product and we sincerely regret any inconvenience this may cause you.

Thank you for boating with Mercury Marine.

Mercury Marine Service