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Supercharger Removal and Installation Procedure

Models Affected

Models Covered	Serial Number
200/225/250/300/350 SCi Verado L6	2B138811-2B144595

⚠ WARNING

The exposed moving flywheel can cause serious injury. Keep your hands, hair, clothing, tools, and other objects away from engine when starting or running the engine. Do not attempt to reinstall the flywheel cover or top cowl when engine is running.

Scope

Worldwide

Situation

On affected engines, a Three Bond 1217F sealant was used to help seal the O-ring on the oil feed side of the supercharger.

Correction

When servicing the supercharger on any of the affected engines, the Three Bond 1217F sealant must be applied if missing or reapplied if present when installing the supercharger back on the engine per the following procedure.

Supercharger Removal and Installation

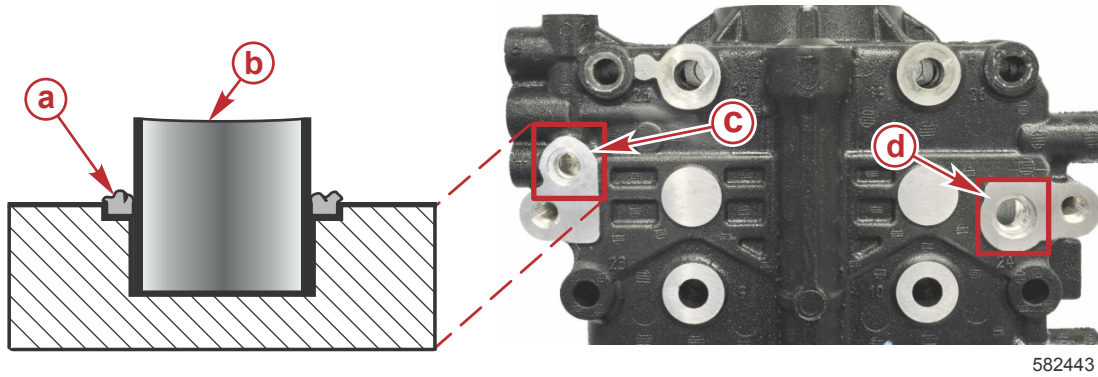
Refer to the appropriate service manual for detailed instructions on the removal and installation of the supercharger.

1. Remove the supercharger and intake components.
2. Remove the O-rings from the oil feed side and oil return side and discard.
3. Carefully clean all sealing surfaces including the O-ring grooves with an appropriate cleaner. Ensure there is no residual Three Bond 1217F sealant left on any sealing surfaces of the crankcase cover or supercharger.
4. Apply an adequate amount of Three Bond 1217F sealant into the O-ring groove on the oil feed side only.
IMPORTANT: Use caution when applying the Three Bond 1217F sealant into the O-ring groove, any sealant inside the dowel pin could cause an oil flow restriction and could cause damage to the engine.

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IMPORTANT: Steps 4 and 5 must be done quickly as the Three Bond 1217F sealant will cure fast and could cause an insufficient seal if cured or partially cured.

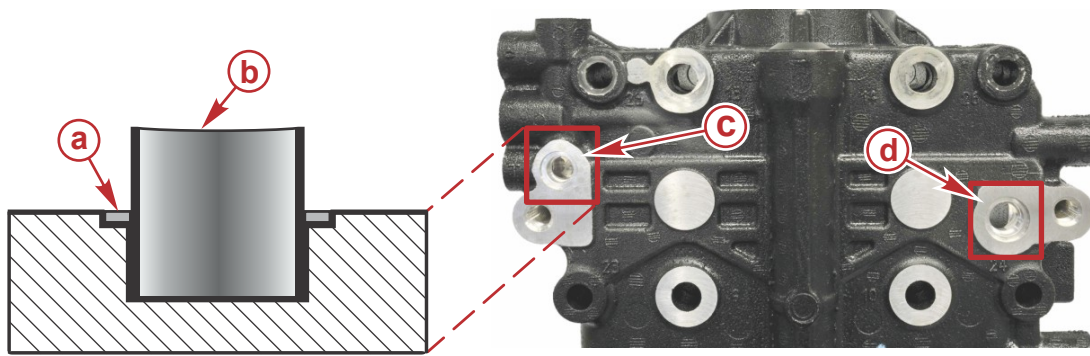


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- a - Three Bond 1217F sealant applied in O-ring groove
- b - Dowel pin in crankcase cover
- c - Oil feed side location
- d - Oil return side location

Tube Ref No.	Description	Where Used	Part No.
 135	Three Bond 1217F	Oil feed side O-ring groove	92-858005K02

5. Evenly distribute the Three Bond 1217F sealant around the O-ring groove and remove excess sealant as needed. Ensure the sealant is flush with the machined surface.



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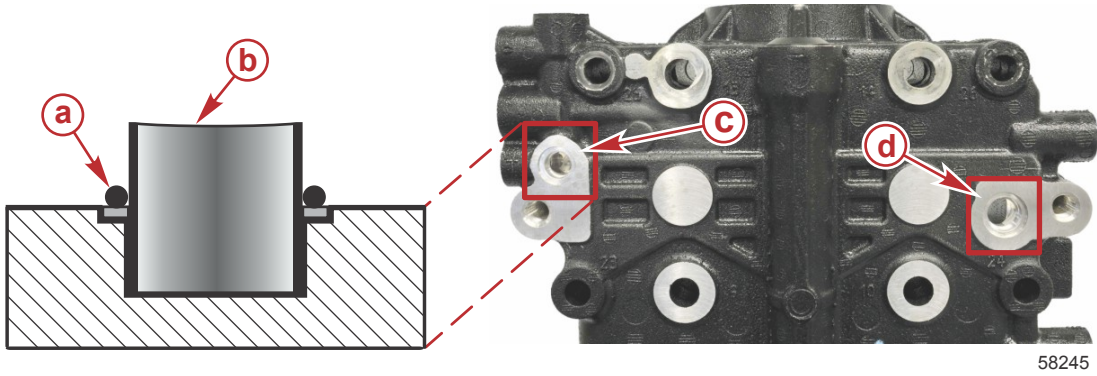
- a - Three Bond 1217F sealant flush with machined surface
- b - Dowel pin in crankcase cover
- c - Oil feed side location
- d - Oil return side location

6. Install the new O-rings on the oil feed side and oil return side.

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IMPORTANT: Do not push the O-ring into the Three Bond 1217F sealant and ensure the O-rings are not twisted.



- a - O-ring is placed on top of Three Bond 1217F sealant
- b - Dowel pin in crankcase cover
- c - Oil feed side location
- d - Oil return side location

7. Align the supercharger on the dowel pins.
8. Apply Loctite 242 Threadlocker to the supercharger mounting screws.

Tube Ref No.	Description	Where Used	Part No.
66	Loctite 242 Threadlocker	Supercharger mounting screws	92-809821

9. Tighten the supercharger mounting screws to the specified torque.

Description		Nm	lb-in.	lb-ft
Supercharger mounting screws	First	15	132.7	-
	Final	43	-	31.7

10. Install the remaining intake components on the engine.
11. Run the engine for approximately five minutes or until normal operating temperature is achieved and check for leaks.

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