



CIRCULATE TO:	SERVICE MGR.	PARTS MGR.	MECHANICS	Place in Your "Service Bulletins" Binder
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- A. Stainless Steel Covered Hydraulic Hoses
- B. Bellows/Tube Ground Clips
- C. External Continuity Springs
- D. Transom Assembly Serial Number Location
- E. Gimbal Housing Water Tube

## A. STAINLESS STEEL COVERED HYDRAULIC HOSES

*(Attach Bulletin Reference Sticker to PP 2A-4 and 2C-6 of Your Service Manual.)*

The 4 plastic covered hydraulic hoses (B-32-79431), located between trim cylinders and gimbal housing hydraulic connector, will be replaced on MerCruiser I, II-TR and II-TRS Drives with 4 braided stainless steel covered hydraulic hoses (B-32-86036).

The change will ensure electrical continuity to the Power Trim cylinders. The hose will be available also as a service replacement.

## B. BELLOWS/TUBE GROUND CLIP

*(Attach Bulletin Reference Sticker to PP 2A-1 and 2C-1 of Your Service Manual.)*

The purpose of this new clip (B-54-86049) is to prevent corrosion of the stainless steel clamps (clamp location listed, following) by establishing electrical continuity between the clamps and the aluminum housing.

One grounding clip is required per clamp. The clip will be available as a service replacement.

### GROUNDING CLIP USAGE LOCATION

Clamp Part No.	Location	Model
B-54-31765	U-Joint Bellows	MC I
B-54-32533	Exhaust Bellows/Tube	MC I
B-54-31765	U-Joint Bellows	TR/TRS
B-54-38889	Exhaust Bellows/Tube	TR/TRS

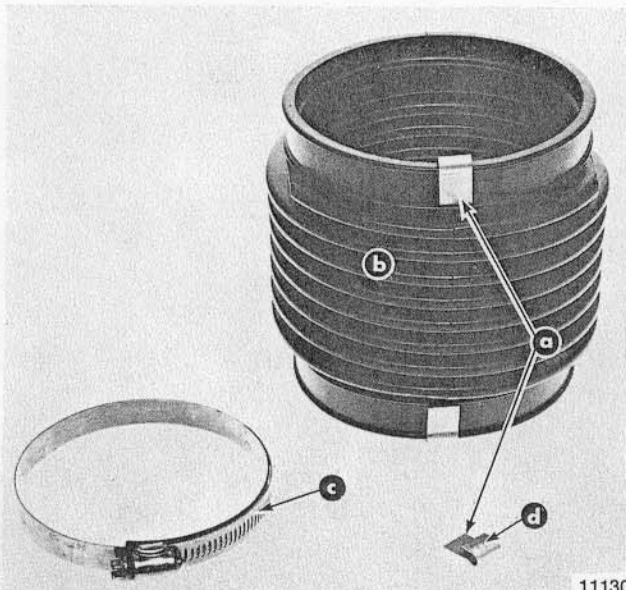
Installation of grounding clip as a service item is achieved by loosening desired bellows/tube clamp and inserting clip end (end with holes) under bellows. (Figure 1) Make sure that electrical continuity is obtained between clip and aluminum housing.

Reposition and tighten hose clamp securely. Check continuity between hose clamp and aluminum housing.

## C. EXTERNAL CONTINUITY SPRINGS

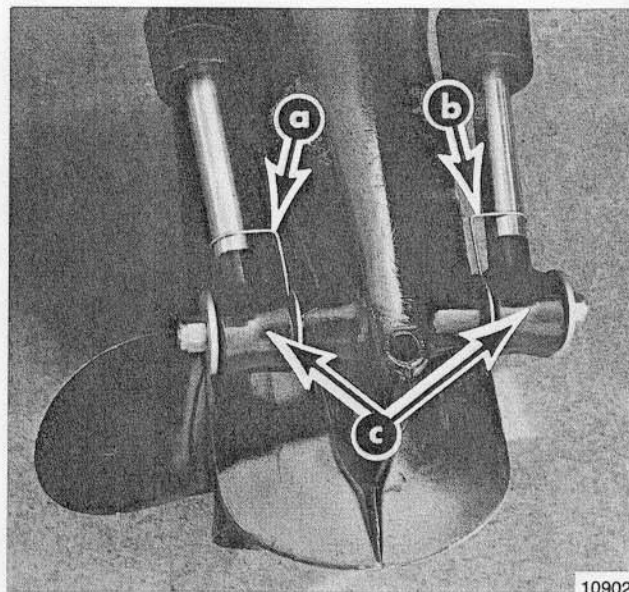
*(Attach Bulletin Reference Sticker to PP 2A-4, 2B-4 and 2C-6 of Your Service Manual.)*

External Continuity Springs (B-24-86687A1) will be included in stern drive unit shipping carton to be installed on trim cylinders (Figure 2) at time of stern drive installation. Make sure that the kits are installed on all I-Drive units.



11130  
 a - Grounding Clip    d - End of Clip Installed between  
 b - Typical Bellows    Bellows and Aluminum Housing  
 c - Hose Clamp

**Figure 1. Grounding Clip Installation (Bellows Removed for Clarity)**



10902  
 a - Continuity Spring (Port)  
 b - Continuity Spring (Starboard)  
 c - Trim Cylinder Rod End

**Figure 2. Continuity Spring Kit Installed**

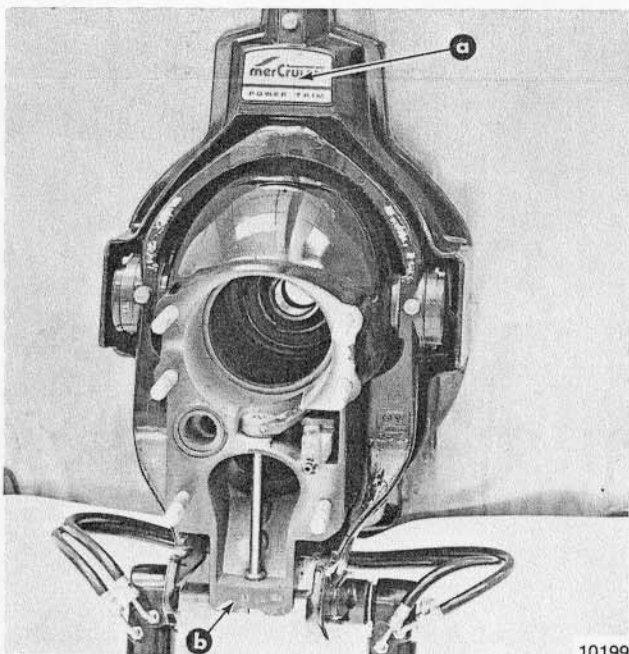
These springs will ensure electrical continuity to the trim cylinder piston rod assemblies (with aluminum rod end) along with the use of the 2 internal spiral springs (B-24-46312).

Trim cylinders with nylon coated rod ends (refer to Service Bulletin 77-11) still use Continuity Spring Kit B-24-79634A1. Installation instructions accompany both kits.

**D. TRANSOM ASSEMBLY SERIAL NUMBER LOCATION**

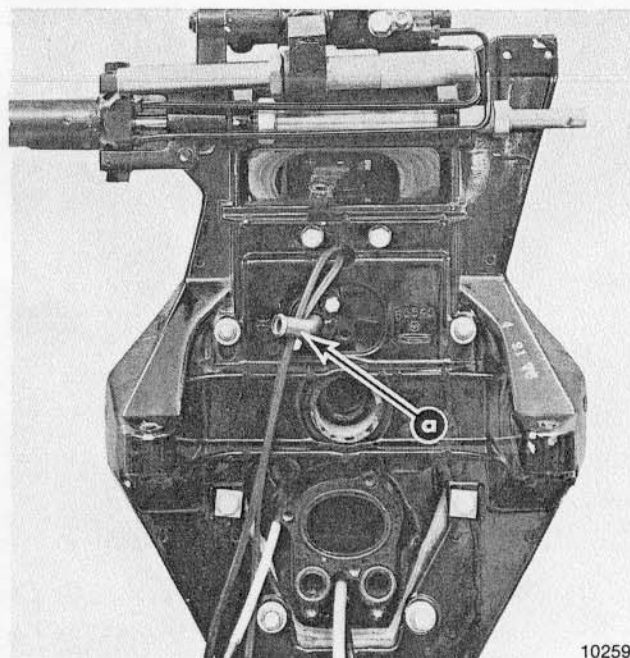
*(Attach Bulletin Reference Sticker to P. 1A-4 of Your Service Manual.)*

The transom assembly serial number location will be permanently stamped in bell housing gasket surface. (Figure 3) For quick reference, the serial number also will be located on gimbal housing



10199  
 a - Gimbal Housing Decal Location  
 b - Bell Housing Gasket Surface

**Figure 3. Transom Assembly Serial Number Location**



10259  
 a - Water Tube

**Figure 4. Typical Water Tube Location**

decal. (Figure 3) An additional decal (with matching serial number) will be placed in an envelope and taped to the inner transom plate which should be installed to engine rocker arm cover after the MerCruiser Package is installed in a boat.

The transom assembly serial number must be recorded on all Warranty Registration Cards.

#### **E. GIMBAL HOUSING WATER TUBE**

*(Attach Bulletin Reference Sticker to PP 2A-2, 2B-2 and 2C-3 of Your Service Manual.)*

Material of the water tube (located in gimbal housing, Figure 4) will be changed to a copper-nickel alloy. This alloy is more resistant to corrosion in salt and polluted water and should be used as a service replacement in corrosive water areas. Refer to part numbers, following:

<b>New Part No.</b>	<b>Old Part No.</b>	<b>Location - MerCruiser Transom Assembly</b>
B-32-86907	B-32-32631	In-Line
B-32-86908	B-32-60542	V-8