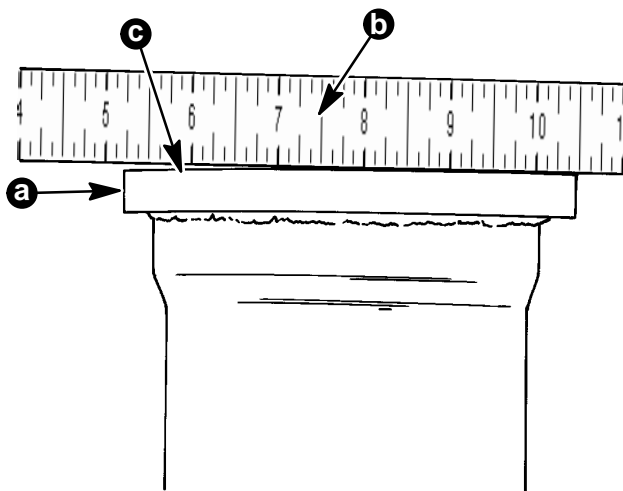


TO: SERVICE MANAGER TECHNICIANS
PARTS MANAGER

No. 87-4

MCM 420 Exhaust Pipe Repair and Installation

MerCruiser Service has received some reports of water entering the engine on MCM 420 engines. After investigation into the problem it was found that the mounting flanges on the stainless steel exhaust pipes may be warped. If this surface is warped water can leak into the exhaust system from between the exhaust pipe and exhaust elbow. All MCM 420 engines in the following serial number ranges should have the exhaust pipes removed and the mounting flange checked for warpage. (Figure 1)



21360

- a - Flange
- b - Straight Edge
- c - Gasket Surface (Must Be Flat Within .010" (.25mm))

Figure 1. Checking Exhaust Pipe Flange

Engines in these serial number brackets must be checked for warped exhaust pipe flanges.

A398941 thru A398958	A399001 thru A399063
A399065 thru A399066	A399068 thru A399131
A399133 thru A399138	A399140 thru A399146
A399148 thru A399163	A399165
A399167 thru A399168	A399170 thru A399179
A399181 thru A399185	A399189 thru A399191
A399193 thru A399208	A399210 thru A399212
A399215	A399217
A399219 thru A399221	A399223 thru A399229
A399233 thru A399243	A399245 thru A399246
A399248 thru A399249	A399252 thru A399255
A399258 thru A399269	A399271 thru A399272
A399274 thru A399277	A399279
A399281	A399283
A399288	A399293
A399296	A399305
	A399307 thru A399308
	A399315
	A399327
A399322	
A399334	
	A399345
	A399351
A399356	A399402 thru A399403
A399405	A399407 thru A399412

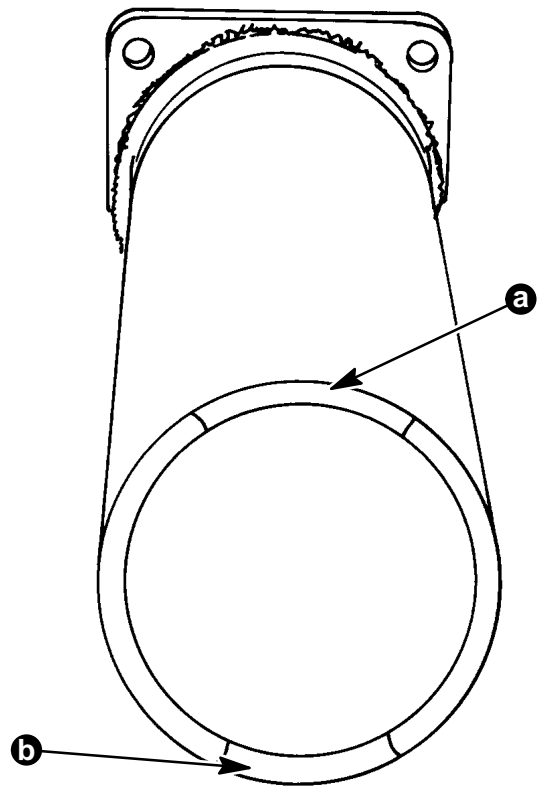
If the exhaust pipe flange is found to be warped the pipes should be sent to:

Mercury Marine
1939 Pioneer Road
Fond du Lac, WI 54935
ATTN: Dave Christie

Order one new exhaust pipe kit (part no. 13851A11) per engine to replace pipes with warped flanges. This kit part no. will only be in affect for the term of this fix program.

When installing the 420 exhaust pipes it is imperative the pipes be installed properly or exhaust hose burning may be experienced. The exhaust pipe must be installed with a water discharge slot at the 12 o'clock position and a weld at the 6 o'clock position. (Figure 2) Failure to do so may cause hot spots on the upper half of the exhaust hose. Future exhaust pipes will be stamped "top" on the mounting flange for ease of correct installation. After installing the pipes properly if they are not marked "top" place an "X" on the top surface of the exhaust flange.

When the replacement pipes are installed, submit a warranty claim for 1.0 hours labor per engine to your Regional Service Center.



- a - Water Discharge Slot at 12 O'clock
- b - Weld at 6 O'clock

Figure 2. Proper Exhaust Pipe Installation

21167