



PARTS CATALOG

25 XS

SERIAL NUMBER

MERC 25XS 85A001 AND UP

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NOTE: Indented description indicate that these parts are included in preceding assembly.

AR = As Required

NSS = Not Sold Separate

OPT = Optional

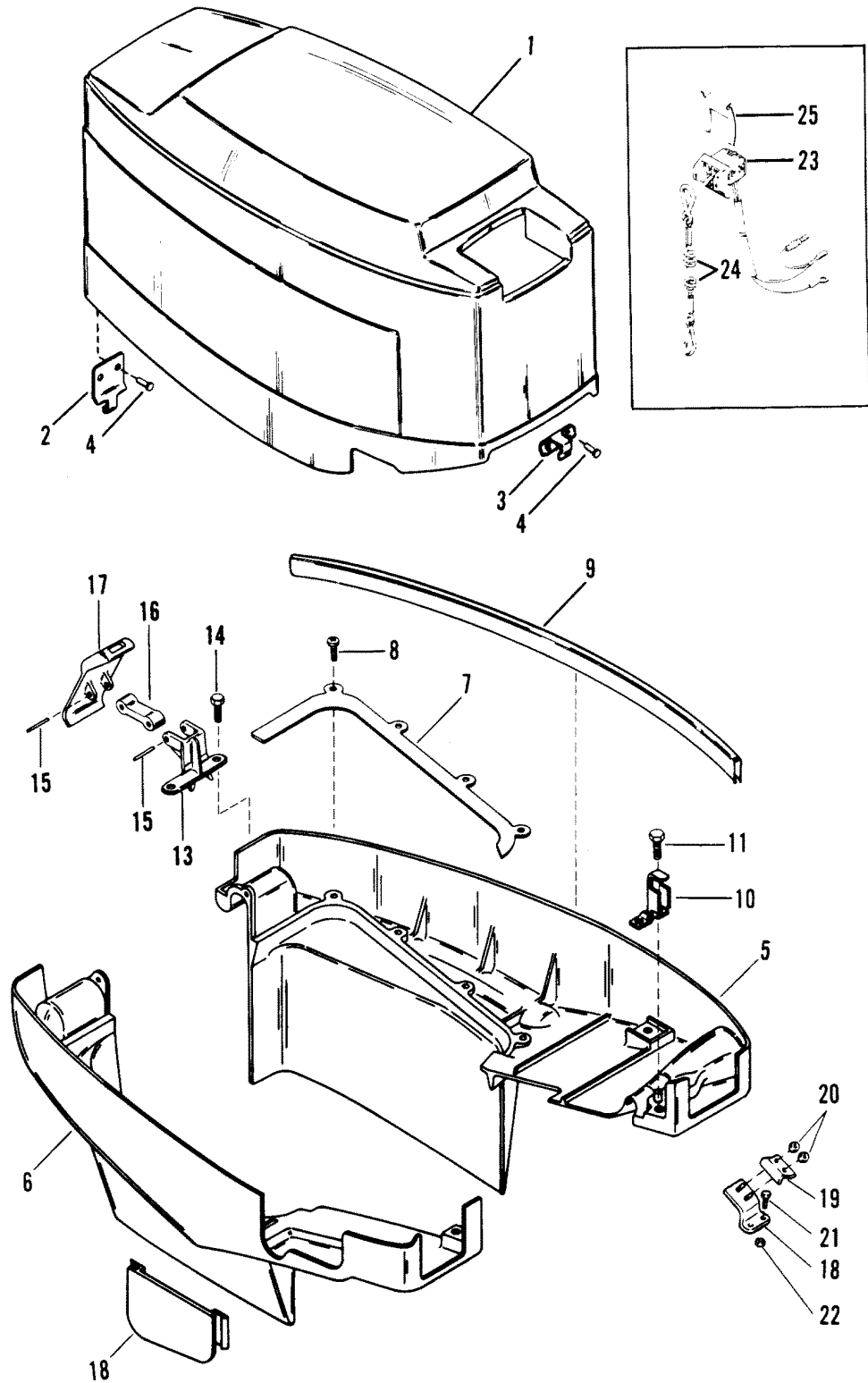
NS = Not Shown

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MISCELLANEOUS PARTS/ACCESSORIES

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
-	90-13767		0	MERC 25 XS PARTS LIST
-	27-14539A86		0	GASKET SET (SHORT SHAFT)
-	27-41499A84		0	GASKET SET (LONG SHAFT)
-	37-12622A1		0	DECAL SET
-	90-12745		0	OWNER'S GUIDE

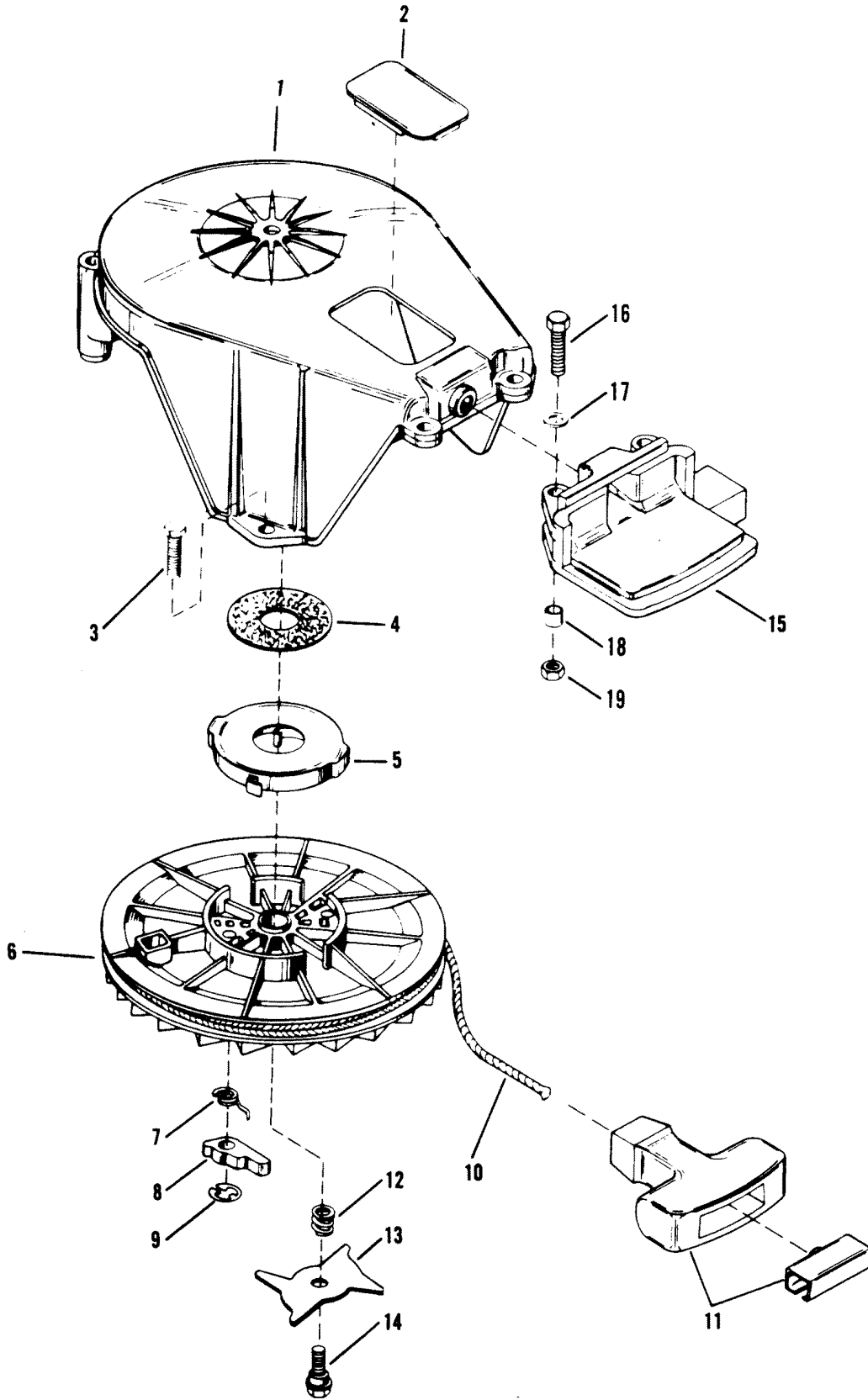
COWLS



COWLS

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	2177-8869A8		1	TOP COWL ASSEMBLY (WITHOUT DECALS)
2	43515		1	HINGE, COWL LATCH
3	43555		1	BRACKET, TOP COWL
4	10-40001--8		4	SCREW, HINGE TO TOP COWL
5	2176-9541A1		1	BOTTOM COWL (PORT) SHORT SHAFT
6	2176-9540A2		1	BOTTOM COWL (STBD.) SHORT SHAFT
5	2176-9419A1		1	BOTTOM COWL (PORT) LONG SHAFT
6	2176-9418A2		1	BOTTOM COWL (STBD.) LONG SHAFT
7	85982		2	PLATE, BOTTOM COWL
8	10-70332		8	SCREW, PLATE TO BOTTOM COWL (1/2")
9	44149-67		2	SEAL, BOTTOM COWL
10	43514		1	LATCH, BOTTOM COWL
11	10-40001--8		2	SCREW, LATCH TO BOTTOM COWL
12	25-41604--1		1	PLATE, BOTTOM COWL
13	87308		1	BRACKET, COWL LATCH
14	10-40001--8		2	SCREW, BRACKET TO BOTTOM COWL (12MM)
15	17-25870		2	ROLL PIN, LINK
16	89583		1	LINK, COWL LATCH
17	43554--1		1	LATCH, COWL - REAR
18	12764A2		1	BRACKET ASSEMBLY, THROTTLE CABLE
19	25788		1	PLATE, CLAMPING
20	11-20190		2	NUT, PLATE TO BRACKET
21	10-40001-74		1	SCREW, BRACKET TO BOTTOM COWL
22	11-40063--4		1	NUT, BRACKET SCREW
23	87-11083A6		1	STOP SWITCH ASSEMBLY
24	86352A54		1	LAYNARD ASSEMBLY
25	12044		1	RETAINER, STOP SWITCH

STARTER ASSEMBLY



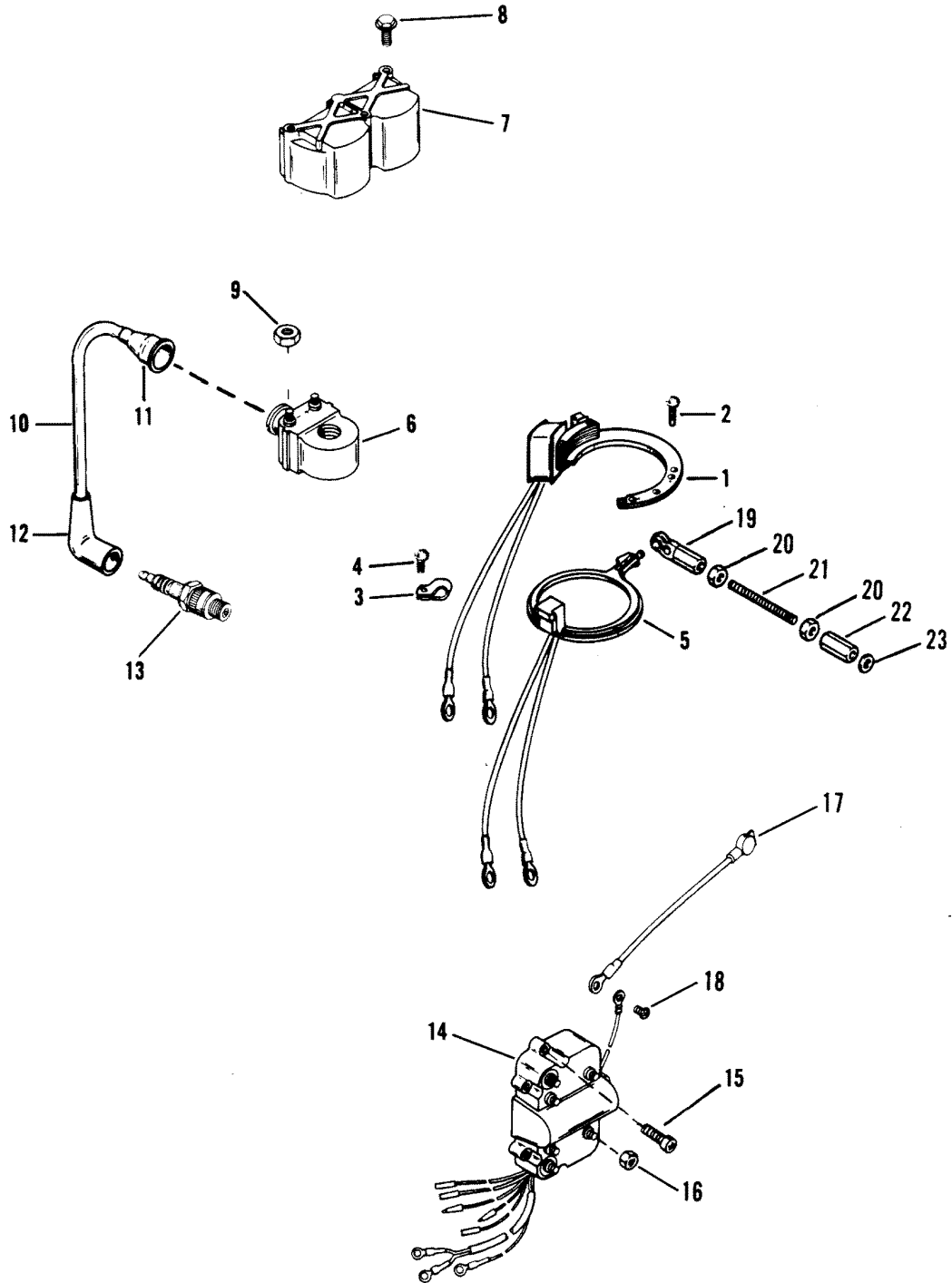
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REVISED APRIL 1986

STARTER ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	42712A1		1	HOUSING, STARTER
2	86971		1	COVER, STARTER HOUSING
3	10-40001-74		2	SCREW, STARTER HOUSING ATTACHING (20MM)
	10-40001-83		1	SCREW, STARTER HOUSING ATTACHING (35MM)
4	90478		1	PAD, FELT
5	24-86857		1	SPRING, STARTER
6	50-42566		1	SHEAVE, STARTER
7	24-86851		2	SPRING, CAM
8	86850		2	CAM
9	53-86849		2	RETAINING RING, CAM
10	50-12066A9		1	ROPE, STARTER
11	85174A1		1	HANDLE ASSEMBLY, STARTER ROPE
12	24-86852		1	SPRING, CAM
13	86853		1	CAM
14	10-97516		1	SCREW, CAM TO STARTER SHEAVE
15	42626		1	SUPPORT, STARTER HANDLE
16	10-40057111		2	SCREW, SUPPORT TO STARTER HOUSING (35MM)
17	12-40022-13		2	WASHER, SUPPORT SCREW
18	23-30977		4	SPACER, SUPPORT SCREW
19	11-40063--3		2	NUT, SUPPORT SCREW

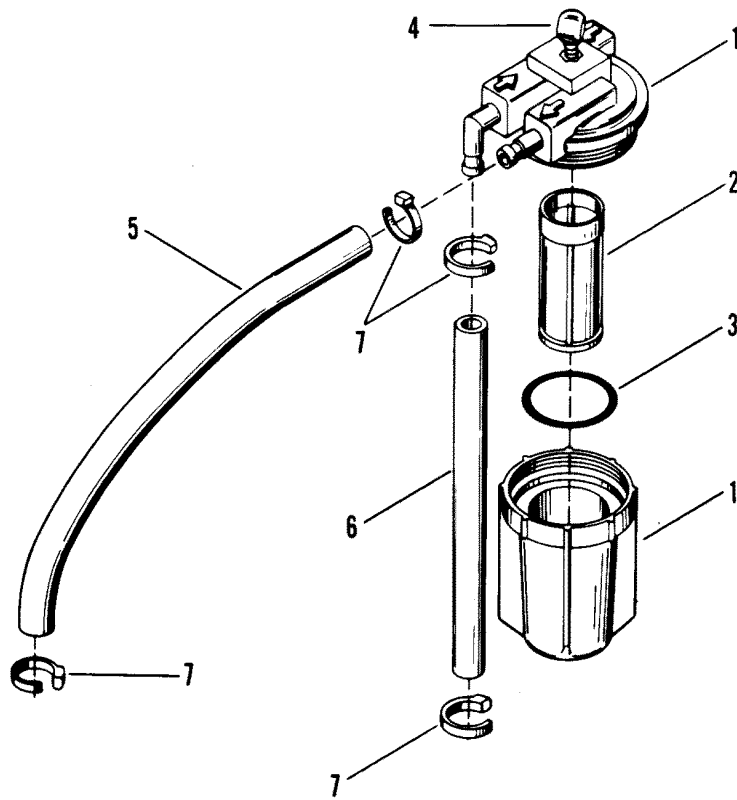
IGNITION COMPONENTS



IGNITION COMPONENTS

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	86617A13		1	STATOR ASSEMBLY
2	10-40001-20		2	SCREW, STATOR ATTACHING (25)
	10-40001--5		2	SCREW, STATOR ATTACHING (10MM)-MANUAL
3	54-24836		1	CLIP, STATOR LEADS
4	10-40057108		1	SCREW, CLIP TO SWITCH BOX (20MM)
5	98450A5		1	TRIGGER ASSEMBLY
6	339-7370A13		2	IGNITION COIL ASSEMBLY
7	99762		1	COVER, IGNITION COIL
8	10-40007115		3	SCREW, IGNITION COIL COVER
9	11-45076		4	NUT, COIL TERMINAL
10	84-99215A25		2	LEAD ASSEMBLY, HIGH TENSION
11	85-70674		2	BOOT, COIL
12	85-63709A1		2	BOOT ASSEMBLY, SPARK PLUG
13	33-97180		2	SPARK PLUG, (NGK-BUHW)
	33-14103570		2	SPARK PLUG, (NGK-BUHW-2)-CANADA AND BELGIUM
14	339-7452A9		1	SWITCH BOX (WITH BULLET CONNECTIONS)
15	10-40057108		3	SCREW, SWITCH BOX TO CYLINDER BLOCK (22MM)
16	11-45076		6	NUT, SWITCH BOX TERMINALS
17	84-88807A10		2	WIRE ASSEMBLY, GROUND
18	10-43394		1	SCREW, GROUND WIRE
19	98465		2	BALL SOCKET
20	11-68219		2	JAM NUT
21	16-55422		1	STUD, TIMING LINK
22	10-12720		1	BALL SCREW
23	12-40023-14		1	WASHER, BALL SCREW

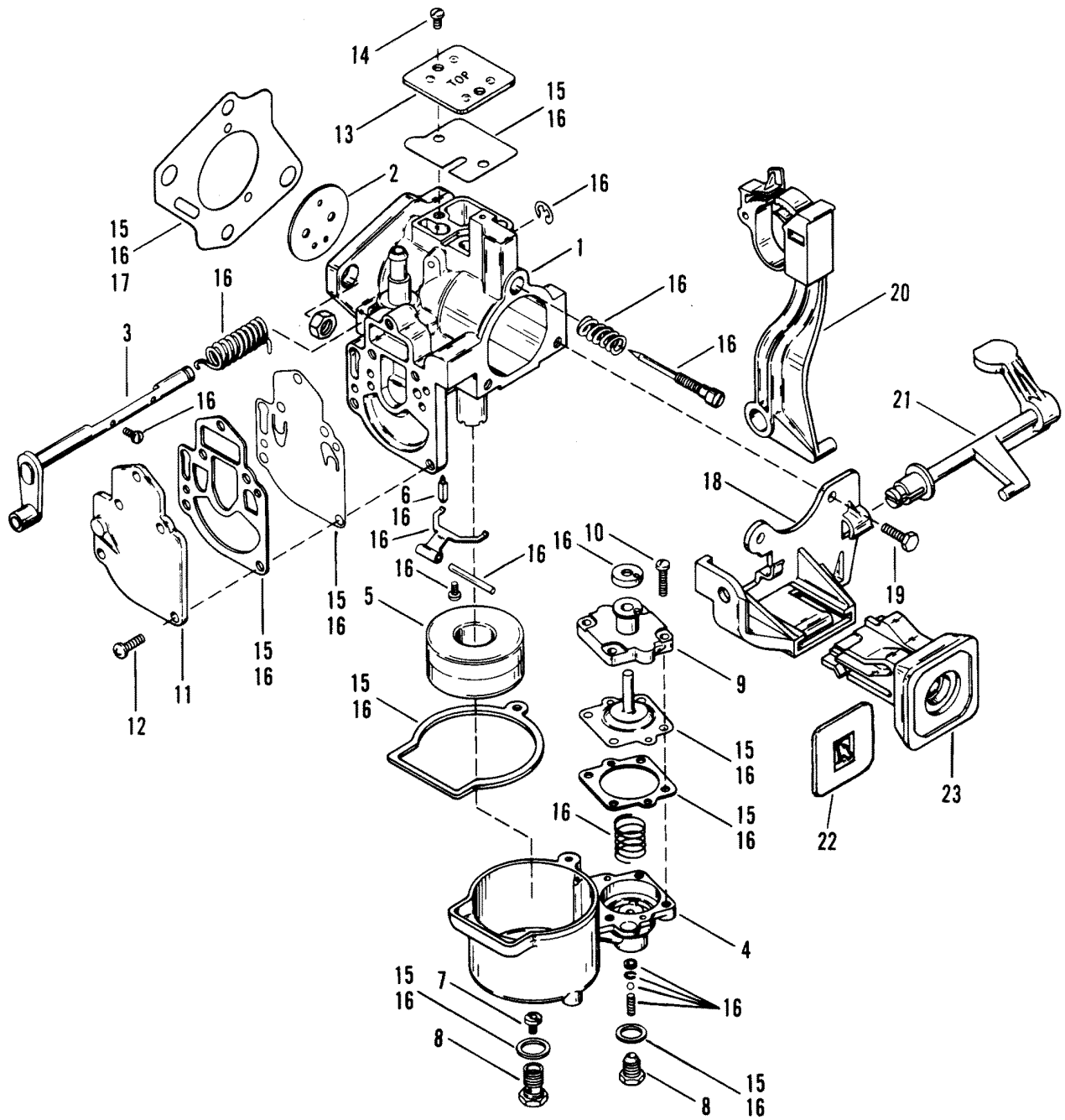
FUEL FILTER ASSEMBLY



FUEL FILTER ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	35-87946A13		1	FUEL FILTER ASSEMBLY
2	35-87946A3		1	FILTER ASSEMBLY
3	25-98277		1	SEAL, FUEL FILTER
4	91935		1	BALL, FUEL FILTER
5	32-99127109		1	FUEL LINE, FILTER TO CARBURETOR (5-1/4")
6	32-99127109		1	FUEL LINE, FILTER TO ADAPTOR (7-1/2")
7	54-68424		4	CLAMP, FUEL LINE

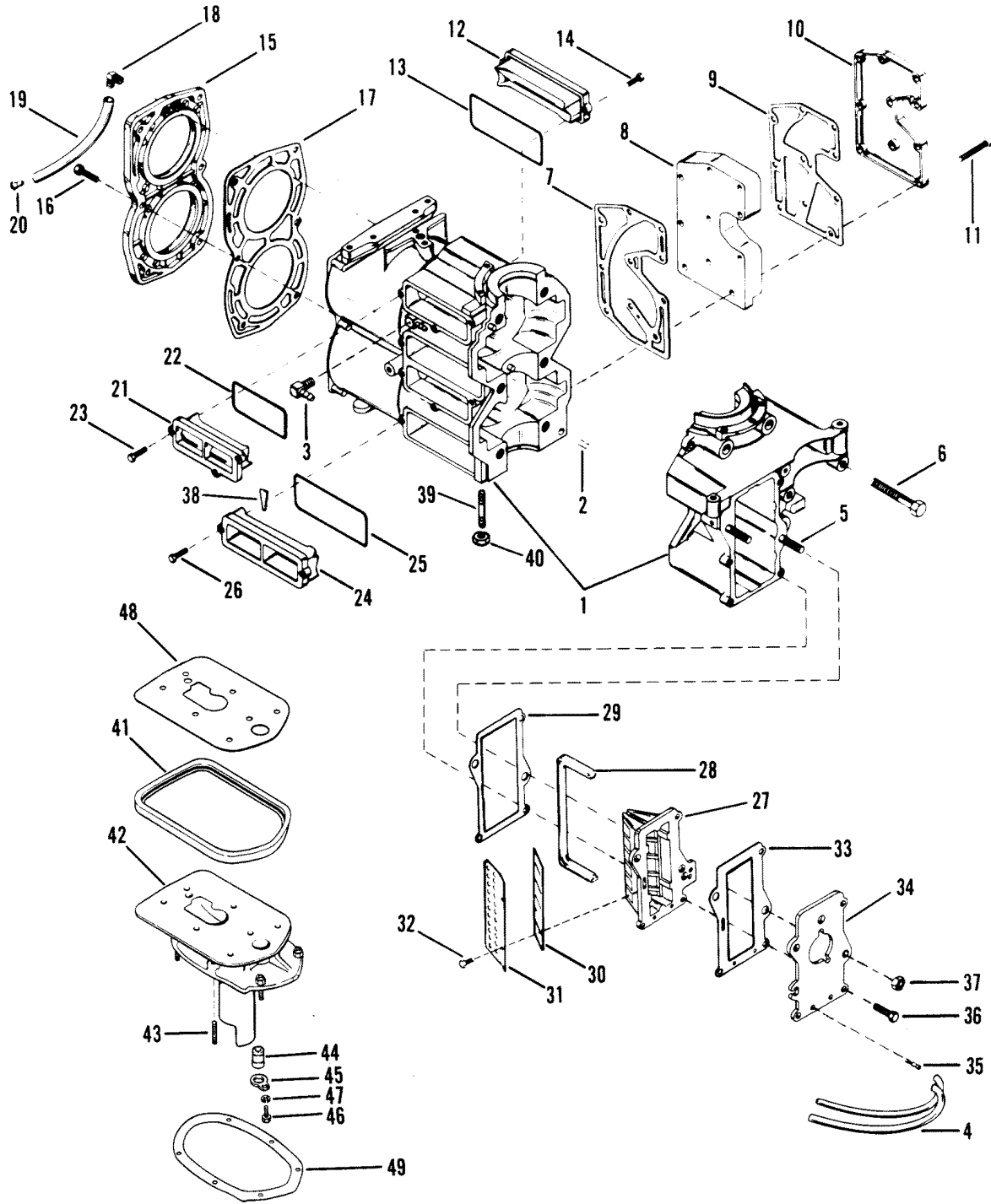
CARBURETOR ASSEMBLY



CARBURETOR ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	1390-8889A5		1	CARBURETOR ASSEMBLY
2	1395-9180		1	THROTTLE VALVE
3	1395-9167		1	THROTTLE SHAFT
4	1395-9164		1	FUEL BOWL
5	1395-9169		1	FLOAT
6	1395-9170		1	VALVE, INLET NEEDLE
7	1395-6201		1	JET, MAIN FUEL (.080)
8	1395-9171		1	PLUG, JET RETAINER
9	1395-9165		4	COVER, DIAPHRAGM
10	1395-9174		4	SCREW, DIAPHRAGM COVER
11	1395-9375		1	COVER, FUEL PUMP
12	1395-9173		5	SCREW, FUEL PUMP COVER
13	1395-9177		1	PLATE, COVER (MANUAL)
14	1395-9172		2	SCREW, COVER PLATE
15	1395-9377		1	GASKET/DIAPHRAGM KIT
16	1395-9376		1	REPAIR PARTS KIT
17	27-41449		1	GASKET, CARBURETOR
18	41717		1	BRACKET, PRIMER
19	10-40001--8		2	SCREW, BRACKET TO CARBURETOR
20	42515A1		1	LEVER ASSEMBLY, FAST IDLE
21	41703		1	LEVER, PRIMER
22	12654		1	CHOKE PLATE
23	11024--1		1	ACTUATOR, PRIMER

CYLINDER BLOCK AND COVERS

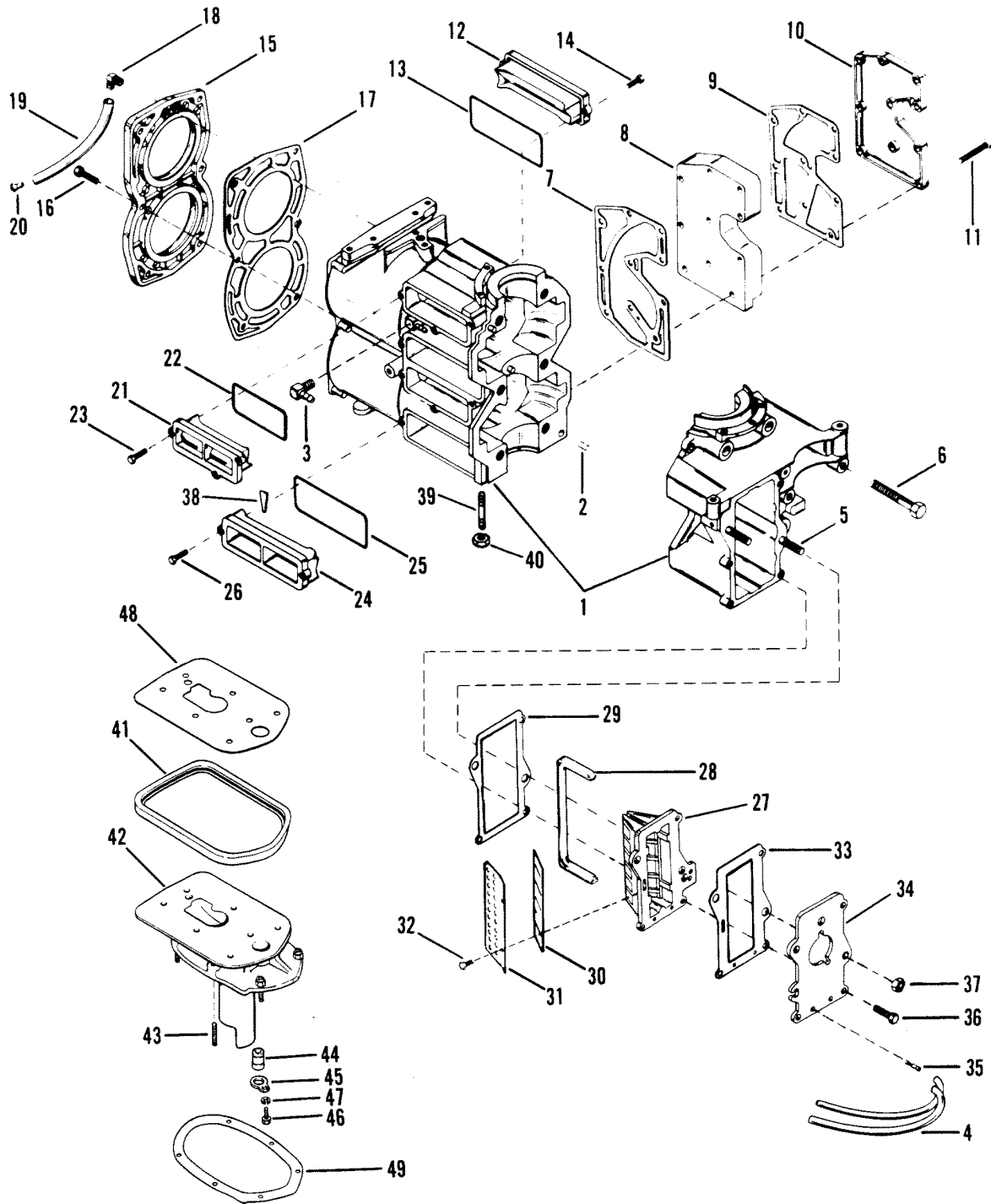


CYLINDER BLOCK AND COVERS

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	872-9077A4		1	CYLINDER BLOCK/CRANKCASE ASSEMBLY
2	17-85171		3	DOWEL PIN, CYLINDER BLOCK
3	22-71191		2	ELBOW, BLEED HOSE (45 DEGREES)
4	32-99130122		2	HOSE, BLEED (12-1/4")
5	16-42917		2	STUD, CARBURETOR
6	10-40001209		6	SCREW, CRANKCASE TO CYLINDER BLOCK (60MM)
7	27-41475--1		1	GASKET, EXHAUST MANIFOLD
8	92329		1	EXHAUST MANIFOLD
9	27-41499--1		1	GASKET, EXHAUST COVER
10	92330		1	COVER, EXHAUST
11	10-40003-33		10	SCREW, EXHAUST COVER TO CYLINDER BLOCK (40MM)
12	92349		2	COVER, TRANSFER PORT
13	25-30503		2	"O" RING, TRANSFER PORT COVER
14	10-40057107		4	SCREW, COVER TO CYLINDER BLOCK (16MM)
15	1028-8283A1		1	COVER ASSEMBLY, CYLINDER BLOCK
16	10-40003-31		6	SCREW, COVER ATTACHING (30MM)
17	27-86389		1	GASKET, CYLINDER BLOCK COVER
18	22-99664		1	ELBOW , TELL TALE HOSE
19	32-34395A1		1	HOSE, TELL TALE (8")
20	22-94848		1	FITTING, TELL TALE HOSE - BOTTOM COWL
21	92351		2	COVER, TRANSFER PORT
22	25-86391		2	"O" RING, TRANSFER PORT COVER
23	10-40057107		6	SCREW, COVER TO CYLINDER BLOCK (16MM)
24	92350		2	COVER, TRANSFER PORT
25	25-26722		2	"O" RING, TRANSFER PORT COVER
26	10-40057107		4	SCREW, COVER TO CYLINDER BLOCK (16MM)
27	42471		1	REED BLOCK
28	85977		1	SEAL, REED BLOCK - RUBBER
29	27-41417		1	GASKET, REED BLOCK
30	34-99319		2	REED
31	34-89793		2	REED STOP
32	10-40057-85		4	SCREW, REED ATTACHING (10MM)
33	27-41418		1	GASKET, ADAPTOR PLATE
34	41420A1		1	PLATE, ADAPTOR - CARBURETOR
35	22-56759		2	FITTING, ADAPTOR PLATE - BLEED HOSE
36	10-40057108		3	SCREW, PLATE TO REED BLOCK (20MM)
37	11-40021--3		2	NUT, CARBURETOR STUD
38	11646		2	SEAL, TRANSFER PORT COVER
39	16-14803		6	STUD, CYLINDER BLOCK (SHORT SHAFT)
	16-42463		5	STUD, CYLINDER BLOCK (LONG SHAFT)
	16-12981		1	STUD, CYLINDER BLOCK (LONG SHAFT)
40	11-40063--5		6	NUT, CYLINDER BLOCK STUD
41	87357		1	SEAL, ADAPTOR PLATE LONG SHAFT

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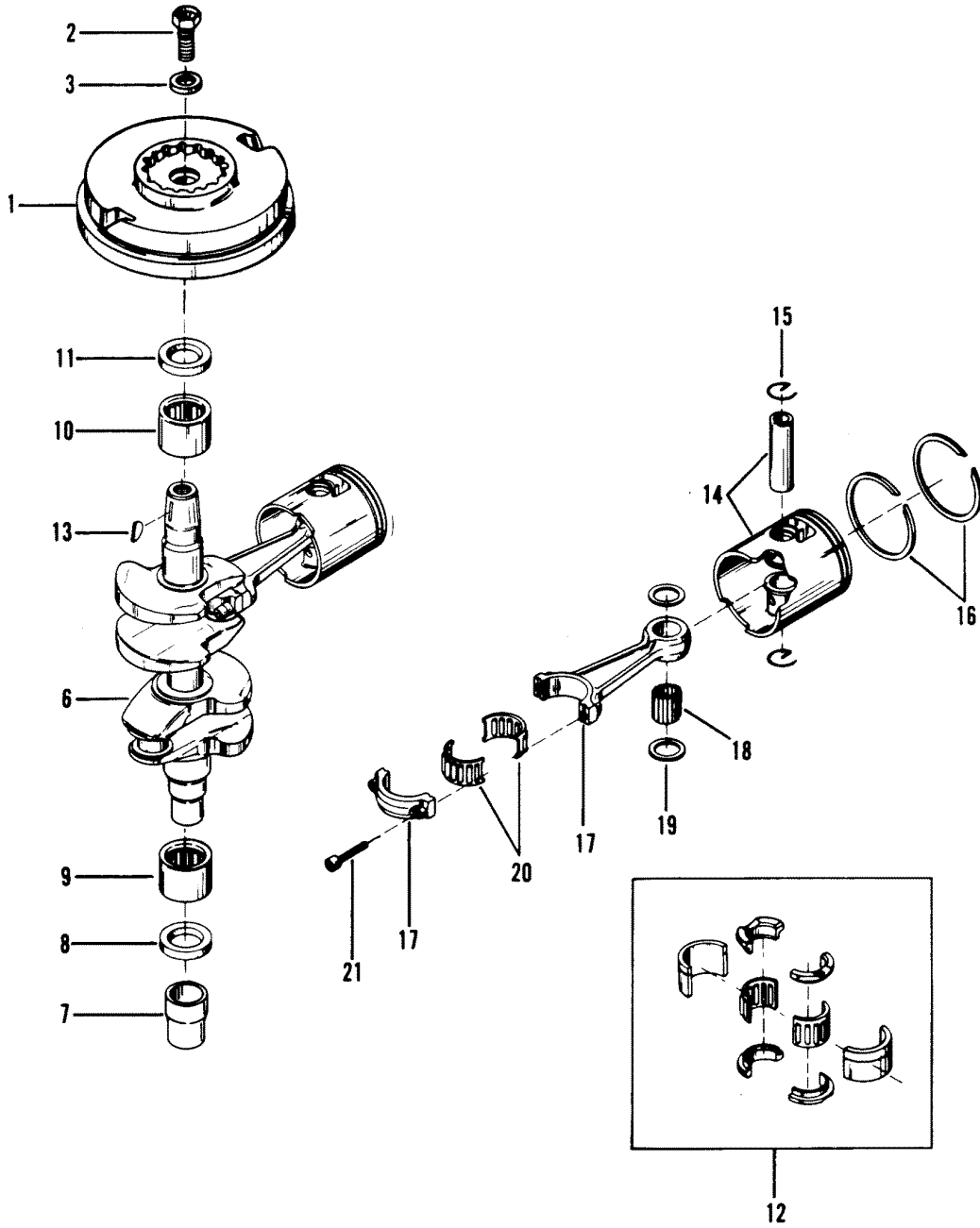
CYLINDER BLOCK AND COVERS



CYLINDER BLOCK AND COVERS

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
42	12640A3		1	ADAPTOR ASSEMBLY LONG SHAFT
43	16-42463		4	STUD, ADAPTOR LONG SHAFT
	16-12981		2	STUD, ADAPTOR (1-1/4") LONG SHAFT
44	26-85090		1	SEAL, ADAPTOR LONG SHAFT
45	44260		1	RETAINER, WATER TUBE SEAL LONG SHAFT
46	10-40010127		1	SCREW, RETAINER TO ADAPTOR LONG SHAFT
47	13-26992		1	LOCKWASHER, RETAINER SCREW LONG SHAFT
48	27-41670		1	GASKET, POWERHEAD LONG SHAFT
49	27-65820		1	GASKET, ADAPTOR TO DRIVE SHAFT HOUSING LONG SHAFT

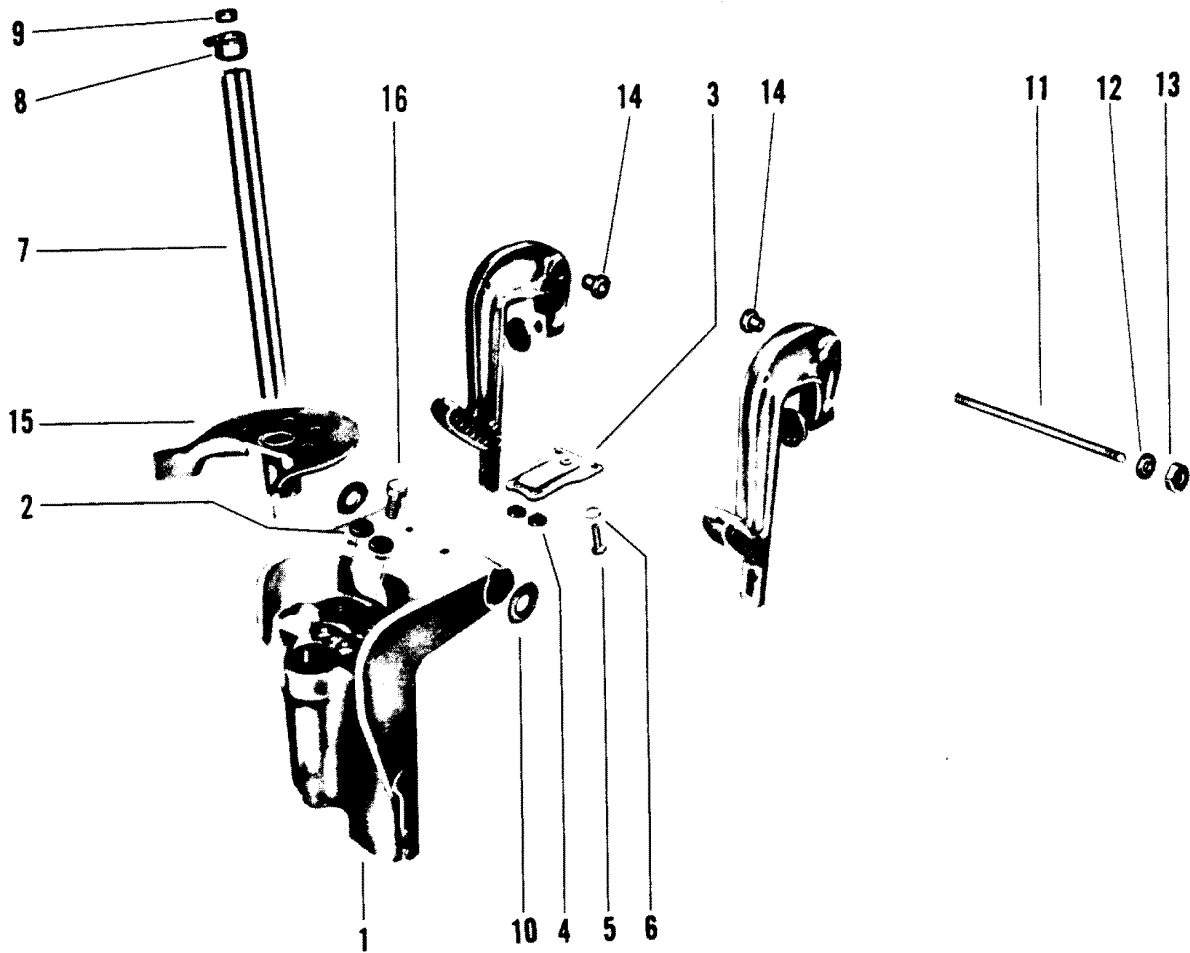
CRANKSHAFT, PISTONS AND FLYWHEEL



CRANKSHAFT, PISTONS AND FLYWHEEL

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	258-9542A4		1	FLYWHEEL ASSEMBLY (SHORT SHAFT)
	258-8274A6		1	FLYWHEEL ASSEMBLY (LONG SHAFT)
2	10-97359A1		1	SCREW, FLYWHEEL TO CRANKSHAFT
3	12-86496		1	WASHER, FLYWHEEL SCREW
6	464-8978A2		1	CRANKSHAFT ASSEMBLY
7	26-43507		1	SEAL, CRANKSHAFT
8	26-85107		1	OIL SEAL, CRANKSHAFT-LOWER
9	31-85113		1	ROLLER BEARING, CRANKSHAFT - LOWER
10	31-85114		1	ROLLER BEARING, CRANKSHAFT - UPPER
11	26-85974		1	OIL SEAL, CRANKSHAFT - UPPER
12	86992A2		1	BEARING ASSEMBLY, CENTER MAIN
13	28-20094		1	KEY, FLYWHEEL DRIVE
14	767-9104A3		2	PISTON AND PIN ASSEMBLY
15	40-47276		4	LOCK RING, PISTON PIN
16	39-12810A12		1	PISTON RING ASSEMBLY
17	630-8835A2		2	CONNECTING ROD ASSEMBLY
18	29-98295		54	NEEDLE BEARING, PISTON END
19	42025		4	BEARING, LOCATING - NEEDLE BEARING
20	31-41620A1		2	ROLLER BEARING ASSEMBLY
21	10-40082-25		4	SCREW, CONNECTING ROD (25MM)

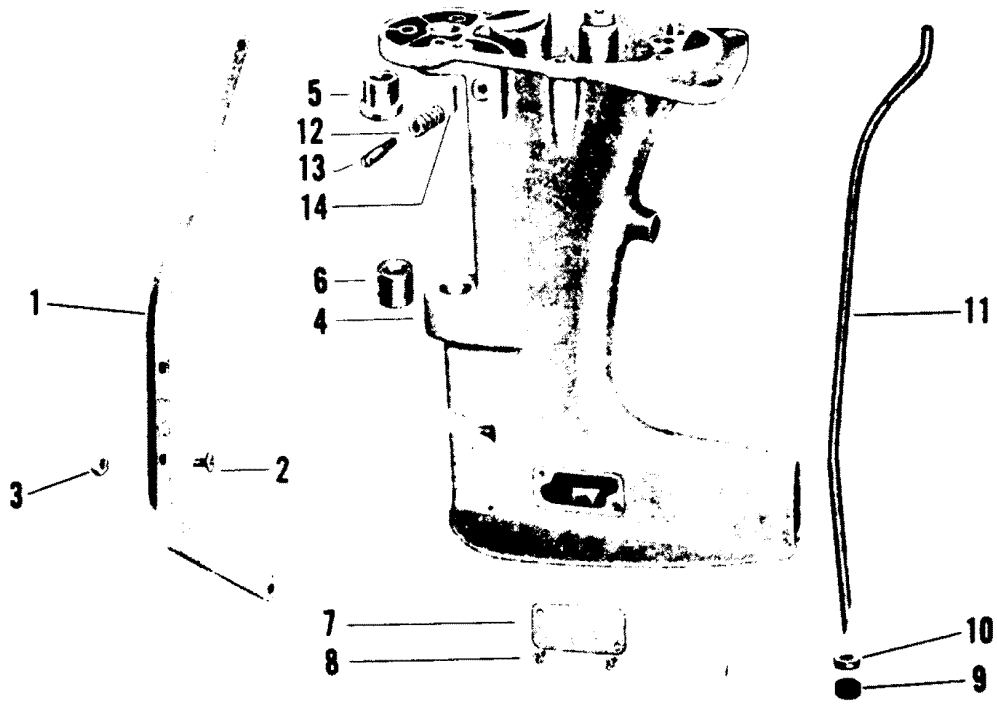
SWIVEL BRACKET ASSEMBLY



SWIVEL BRACKET ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	1402-134A1		1	SWIVEL BRACKET ASSEMBLY
2	20203		2	DISC, FRICTION
3	20701A1		1	CLAMP PLATE ASSEMBLY
4	20203		2	DISC, FRICTION
5	10-60300		2	SCREW, CLAMP PLATE MOUNTING
6	13-26992		2	LOCKWASHER, CLAMP PLATE MOUNTING SCREW
7	17-20891		1	SWIVEL PIN, CO-PILOT DISC
8	19-69316		1	CAP, SWIVEL PIN
9	23-13049		1	PLUG, SWIVEL PIN
10	15-20695		2	SHIM, CLAMP BRACKET TO SWIVEL BRACKET (.010)
11	16-78582		1	STUD, CLAMP BRACKET TO SWIVEL BRACKET
12	12-22248		1	WASHER, CLAMP BRACKET STUD
13	11-20696		2	NUT, CLAMP BRACKET STUD
14	23-F78544		1	BUSHING, CLAMP BRACKET STUD
15	20951		1	CO-PILOT DISC ASSEMBLY
16	10-47277		1	SCREW, CO-PILOT ADJUSTING

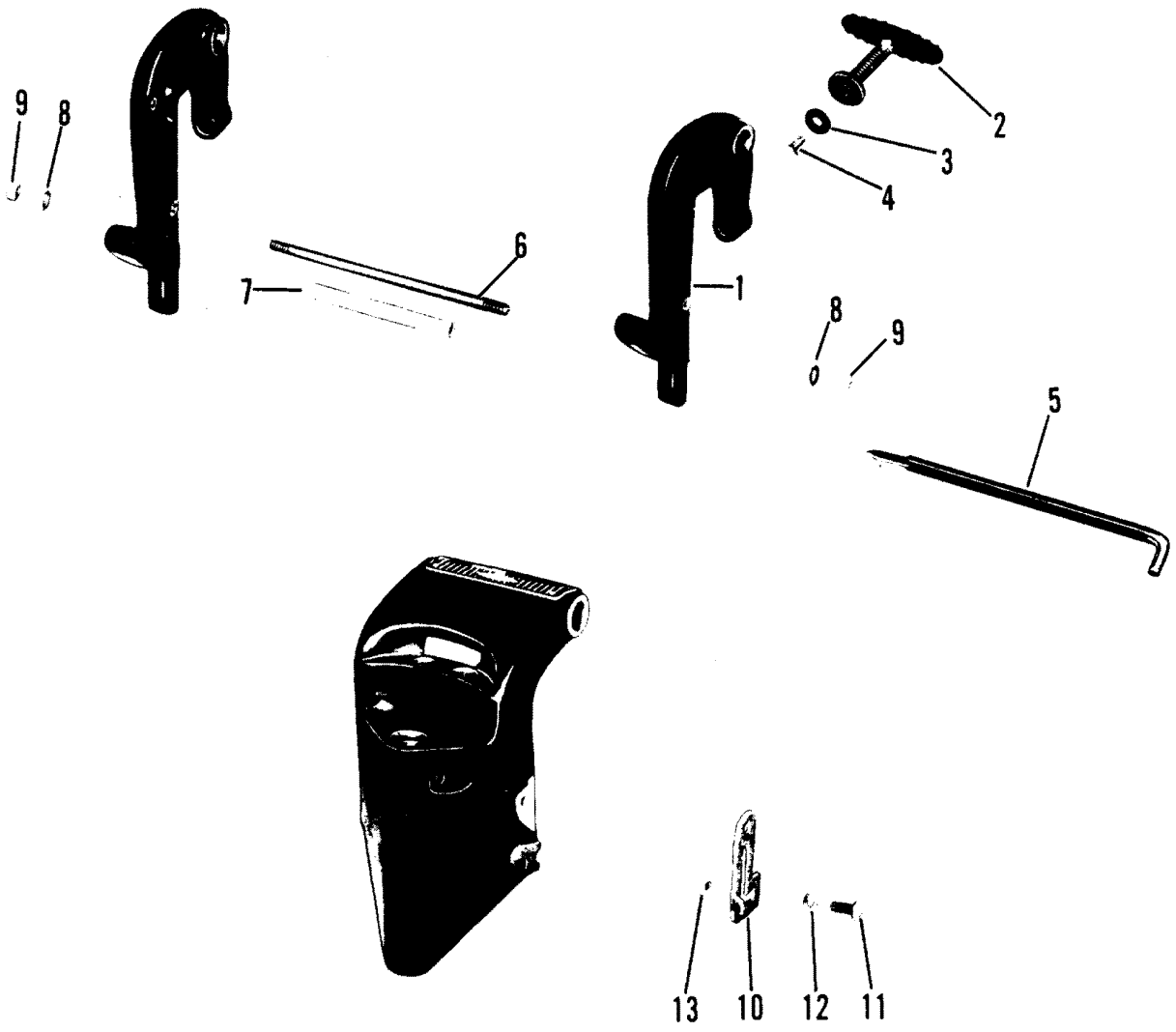
DRIVE SHAFT HOUSING ASSEMBLY(LONG SHAFT)



DRIVE SHAFT HOUSING ASSEMBLY(LONG SHAFT)

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	65823A1		1	STEERING BAR ASSEMBLY
2	10-20639		2	SCREW, STEERING BAR TO DRIVE SHAFT HOUSING
3	11-35814		2	NUT, STEERING BAR SCREW
4	1577-5153A7		1	DRIVE SHAFT HOUSING ASSEMBLY
5	23-29669		1	BUSHING, UPPER
6	23-29670		1	BUSHING, LOWER
7	20682		1	COVER PLATE, DRIVE SHAFT HOUSING
8	10-20681		2	SCREW, COVER PLATE TO DRIVE SHAFT HOUSING
9	12-20684		1	SEAL, WATER TUBE - LOWER
10	12-20683		1	WASHER, WATER TUBE SEAL - LOWER
11	32-86292		1	TUBE, WATER INLET
12	24-20229		2	SPRING, CO-PILOT TO DRIVE SHAFT HOUSING
13	10-21070		2	SCREW, CO-PILOT SPRING GUIDE
14	18-21071		2	COTTER PIN, CO-PILOT SPRING GUIDE SCREW

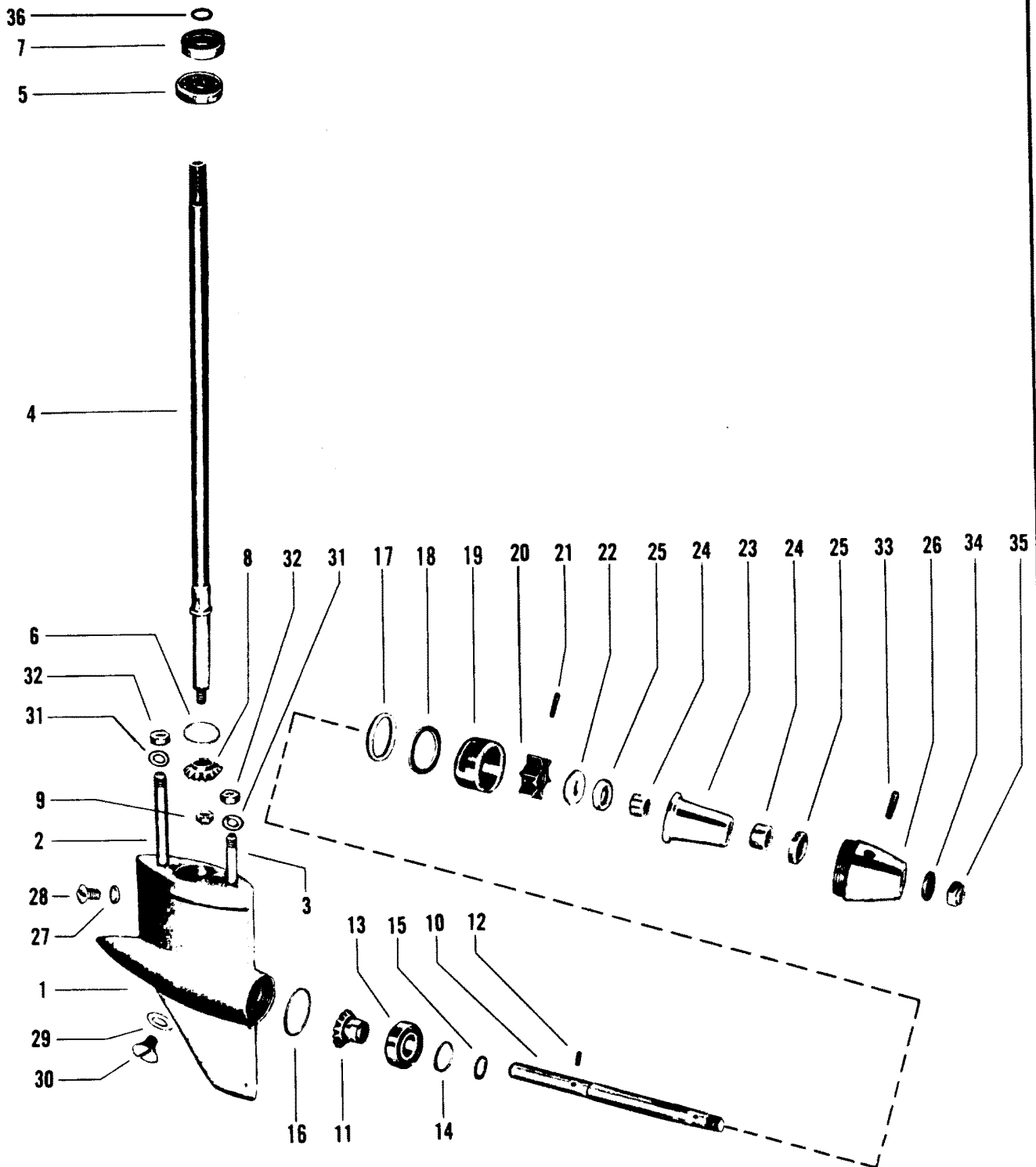
CLAMP BRACKET ASSEMBLY



CLAMP BRACKET ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	1427-5632A3		2	CLAMP BRACKET ASSEMBLY
2	10-77190A3		2	THUMB SCREW ASSEMBLY
3	12-73719		2	WASHER, THUMB SCREW
4	10-76804		2	SCREW, THUMB SCREW
5	17-56373A2		1	TILT LOCK PIN ASSEMBLY
6	16-59620		1	STUD, CLAMP BRACKET (8")
7	23-59621		1	SPACER, CLAMP BRACKET STUD
8	13-26993		2	LOCKWASHER, CLAMP BRACKET STUD
9	11-22053		2	NUT, CLAMP BRACKET STUD
10	63310A1		1	LEVER ASSEMBLY, TILT STOP
11	10-41433		2	SCREW, RETAINING-LEVER TO SWIVEL BRACKET
12	13-31030		2	WASHER, WAVE-TILT STOP LEVER SCREW
13	11-36069		2	NUT, TILT STOP LEVER SCREW

GEAR HOUSING ASSEMBLY

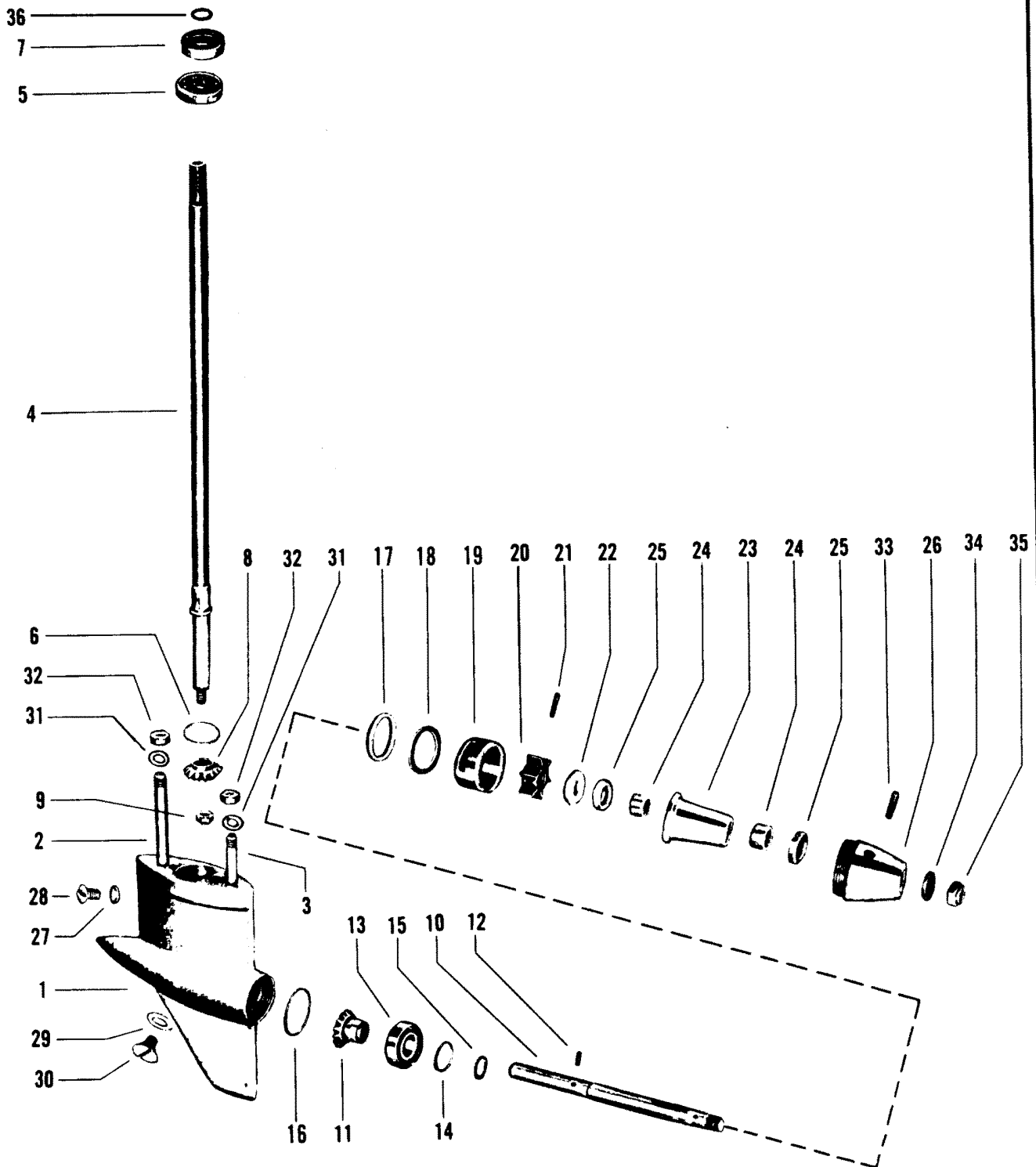


GEAR HOUSING ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
-	1604-1116A17		1	GEAR HOUSING, COMPLETE (SHORT SHAFT)
-	1604-1116A14		1	GEAR HOUSING, COMPLETE (LONG SHAFT)
1	1604-1116A2		1	GEAR HOUSING ASSEMBLY
-	31-20904		1	BEARING, ROLLER-PROPELLER SHAFT
-	31-20908		1	BEARING, ROLLER-DRIVE SHAFT
-	10-21048		1	PLUG, HEADLESS
2	16-52606		1	STUD, GEAR HOUSING (LONG)
3	16-20313		1	STUD, GEAR HOUSING (SHORT)
4	45-14544		1	DRIVE SHAFT (SHORT SHAFT)
	45-12639		1	DRIVE SHAFT (LONG SHAFT)
5	30-25728		1	BEARING, BALL-DRIVE SHAFT
6	15-20919A1		AR	SHIM, BALL BEARING TO GEAR HOUSING
7	47947A1		1	PILOT AND OIL SEAL ASSEMBLY
-	26-20070		1	OIL SEAL
8	43-29490		1	GEAR, PINION
9	11-65562		1	NUT, PINION GEAR LOCKING
10	44-20923		1	SHAFT, PROPELLER
11	43-29491		1	GEAR, PROPELLER SHAFT
12	17-20937		1	PIN, PROPELLER GEAR TO SHAFT
13	30-20938		1	BEARING, BALL-PROPELLER SHAFT
14	15-20939A1		AR	SHIM, BALL BEARING TO SNAP RING
15	53-20940		1	RING, SNAP
16	15-20941A1		AR	SHIM, BALL BEARING TO GEAR HOUSING
17	12-20942		1	WASHER, SEALING-WATER PUMP CARTRIDGE
18	25-20812		1	SEAL, RUBBER-WATER PUMP CARTRIDGE
19	46-20943A1		1	WATER PUMP CARTRIDGE ASSEMBLY
-	26-20903		1	OIL SEAL
20	47-20945		1	IMPELLER, WATER PUMP
21	17-20946		1	PIN, IMPELLER DRIVE
22	20947		1	PLATE, WATER PUMP COVER
23	46-20905A1		1	WATER PUMP COVER ASSEMBLY
24	31-20904		2	BEARING, ROLLER
25	26-20903		2	OIL SEAL, WATER PUMP COVER
26	20902		1	COVER, GEAR HOUSING
27	12-20262		1	WASHER, GEAR HOUSING VENT SCREW
28	10-28653		1	SCREW, GEAR HOUSING VENT
29	12-20260		1	WASHER, GREASE FILLER HOLE SCREW
30	10-79953		1	SCREW, GREASE FILLER HOLE
31	12-20086		2	WASHER, GEAR HOUSING STUDS

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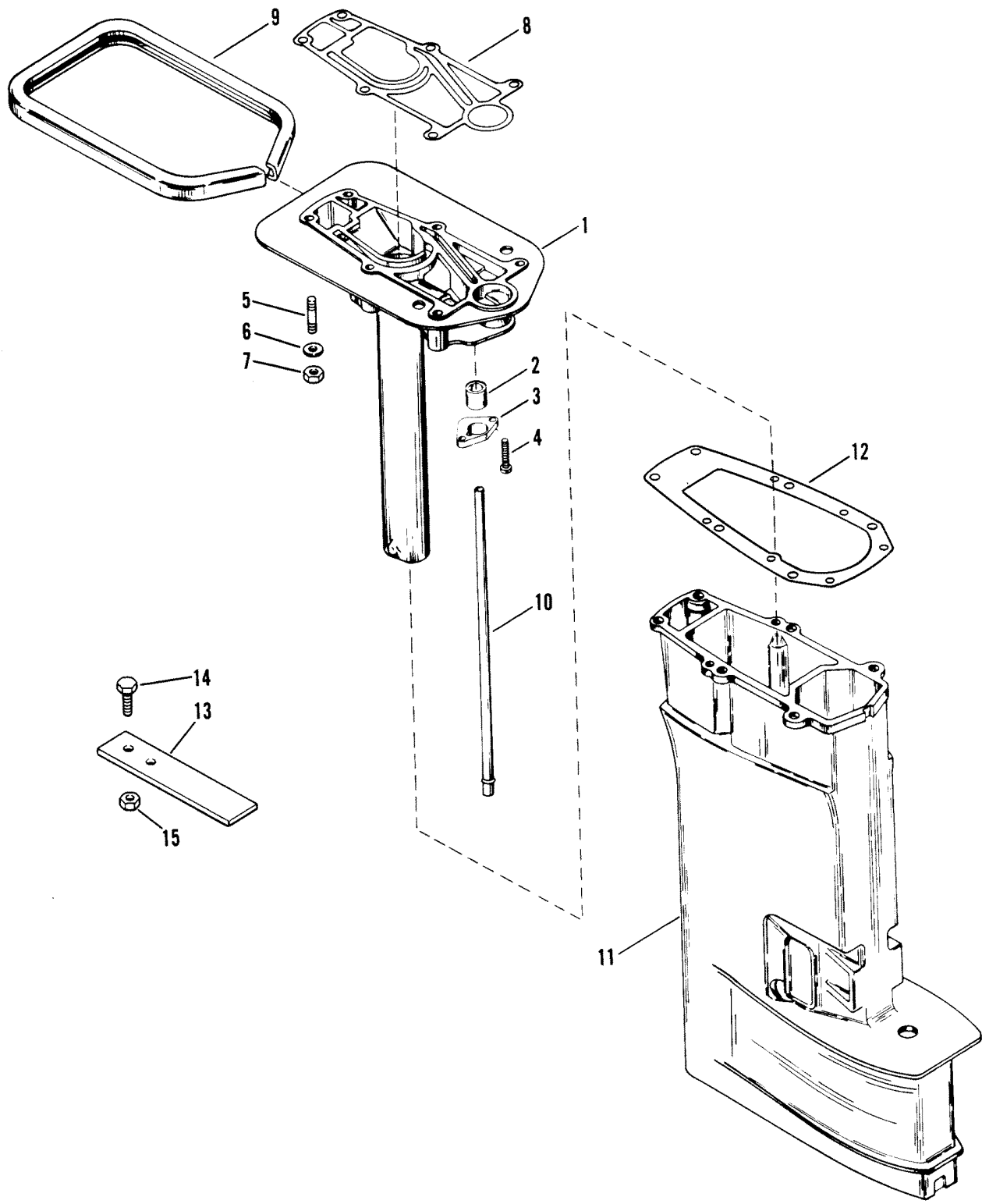
GEAR HOUSING ASSEMBLY



GEAR HOUSING ASSEMBLY

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
32	11-34932		2	NUT, GEAR HOUSING STUD
33	17-25971		1	PIN, SHEAR
34	12-20959		1	WASHER, PROPELLER NUT
35	11-20958		1	NUT, PROPELLER
36	25-99691		1	"O" RING

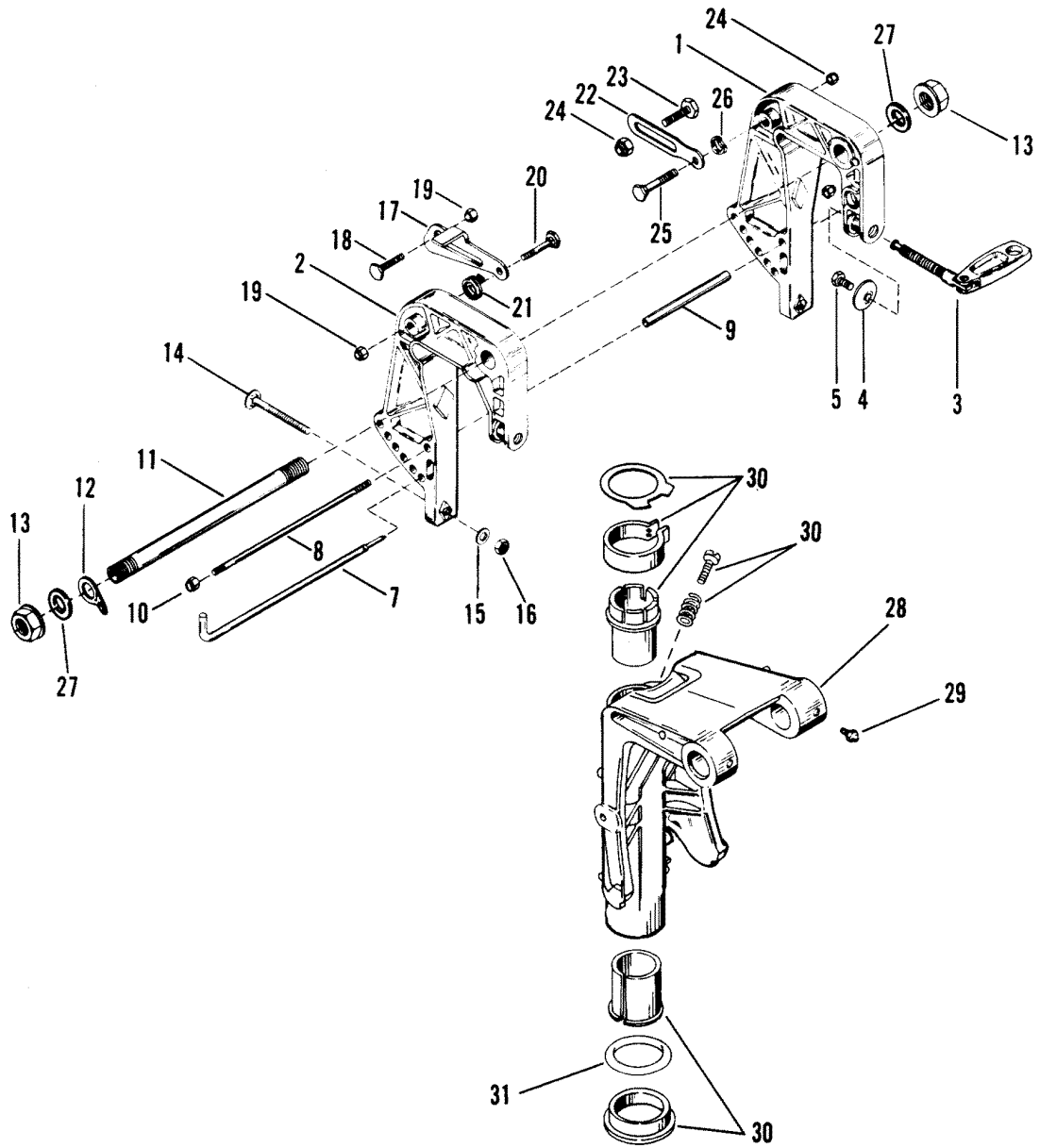
DRIVE SHAFT HOUSING ASSEMBLY(SHORT SHAFT)



DRIVE SHAFT HOUSING ASSEMBLY(SHORT SHAFT)

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	14546A2		1	ADAPTOR PLATE ASSEMBLY
2	26-85090		1	SEAL, WATER TUBE
3	44260		1	RETAINER
4	10-40010127		1	SCREW, RETAINER
5	16-42984		2	STUD
6	12-40023-15		2	WASHER
7	11-40063--4		2	NUT
8	27-41670		1	GASKET, ADAPTOR PLATE
9	87357		1	SEAL, ADAPTOR PLATE
10	32-85116--1		1	WATER TUBE
11	3501-9544A5		1	HOUSING ASSEMBLY
12	27-14539		1	GASKET, DRIVE SHAFT HOUSING
13	14540A1		1	STEERING BAR ASSEMBLY
14	10-13402		4	SCREW
15	11-40063--5		4	NUT

CLAMP BRACKET/SWIVEL BRACKET



CLAMP BRACKET/SWIVEL BRACKET

REF. NO.	PART NO.	SYM.	QTY.	DESCRIPTION
1	1497-8794A1		1	CLAMP BRACKET (PORT)
2	1497-8796A1		1	CLAMP BRACKET (STARBOARD)
3	10-92767A1		2	THUMB SCREW ASSEMBLY
4	12-73719		2	WASHER, THUMB SCREW
5	10-76804		2	SCREW, WASHER ATTACHING
7	17-99929A1		1	TILT PIN ASSEMBLY
8	16-99928		1	STUD, CLAMP BRACKET
9	23-41041		1	SPACER, CLAMP BRACKET STUD
10	11-40063--5		2	NUT,CLAMP BRACKET STUD
11	41171		1	TILT TUBE
12	54-30954		1	CLIP, SAFETY
13	11-93164		2	NUT, TILT TUBE
14	10-69064		2	BOLT, CLAMP BRACKET TO TRANSOM
15	12-67981		2	WASHER, CLAMP BRACKET BOLT
16	11-67980		2	NUT, CLAMP BRACKET BOLT
17	96965		1	LEVER, TILT STOP-STARBOARD SIDE
18	10-41523		1	SCREW, LEVER TO SWIVEL BRACKET
19	11-36069		2	NUT, TILT STOP LEVER SCREW
20	10-41524		1	SCREW, LEVER TO CLAMP BRACKET
21	24-44581		1	SPRING, TILT STOP LEVER SCREW
22	90901		1	STRAP, TILT STOP-PORT SIDE
23	10-41523		1	SCREW, STRAP TO SWIVEL BRACKET
24	11-36069		2	NUT, TILT STOP STRAP SCREW
25	10-41524		1	SCREW, STRAP TO CLAMP BRACKET
26	13-31030		2	WAVE WASHER, TILT STOP STRAP SCREW
27	12-71421		2	WASHER, TILT TUBE
28	1487-9543A2		1	SWIVEL BRACKET
29	22-74036		3	GREASE FITTING
30	54-11139A1		1	CLAMP ASSEMBLY
31	25-86993		1	"O" RING

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Part Number	Description	Pg.	Ref. No.	Part Number	Description	Pg.	Ref. No.
11024--1	ACTUATOR, PRIMER	11	23	87357	SEAL, ADAPTOR PLATE . . .	13	41
11646	SEAL, TRANSFER PORT COVER	13	38	87357	SEAL, ADAPTOR PLATE . . .	29	9
12044	RETAINER, STOP SWITCH . .	3	25	89583	LINK, COWL LATCH	3	16
12640A3	ADAPTOR ASSEMBLY	15	42	90478	PAD, FELT	5	4
12654	CHOKE PLATE	11	22	90901	STRAP, TILT STOP-PORT SIDE	31	22
12764A2	BRACKET ASSEMBLY, THROTTLE CABLE	3	18	91935	BALL, FUEL FILTER	9	4
14540A1	STEERING BAR ASSEMBLY	29	13	92329	EXHAUST MANIFOLD	13	8
14546A2	ADAPTOR PLATE ASSEMBLY	29	1	92330	COVER, EXHAUST	13	10
20203	DISC, FRICTION	19	2	92349	COVER, TRANSFER PORT . .	13	12
20203	DISC, FRICTION	19	4	92350	COVER, TRANSFER PORT . .	13	24
20682	COVER PLATE, DRIVE SHAFT HOUSING	21	7	92351	COVER, TRANSFER PORT . .	13	21
20701A1	CLAMP PLATE ASSEMBLY . .	19	3	96965	LEVER, TILT STOP- STARBOARD SIDE	31	17
20902	COVER, GEAR HOUSING . .	25	26	98450A5	TRIGGER ASSEMBLY	7	5
20947	PLATE, WATER PUMP COVER	25	22	98465	BALL SOCKET	7	19
20951	CO-PILOT DISC ASSEMBLY	19	15	99762	COVER, IGNITION COIL . . .	7	7
25788	PLATE, CLAMPING	3	19	10-12720	BALL SCREW	7	22
41171	TILT TUBE	31	11	10-13402	SCREW	29	14
41420A1	PLATE, ADAPTOR - CARBURETOR	13	34	10-20639	SCREW, STEERING BAR TO DRIVE SHAFT HOUSING . .	21	2
41703	LEVER, PRIMER	11	21	10-20681	SCREW, COVER PLATE TO DRIVE SHAFT HOUSING . .	21	8
41717	BRACKET, PRIMER	11	18	10-21048	PLUG, HEADLESS	25	-
42025	BEARING, LOCATING - NEEDLE BEARING	17	19	10-21070	SCREW, CO-PILOT SPRING GUIDE	21	13
42471	REED BLOCK	13	27	10-28653	SCREW, GEAR HOUSING VENT	25	28
42515A1	LEVER ASSEMBLY, FAST IDLE	11	20	10-40001--5	SCREW, STATOR ATTACHING (10MM)- MANUAL	7	2
42626	SUPPORT, STARTER HANDLE	5	15	10-40001--8	SCREW, BRACKET TO BOTTOM COWL (12MM) . .	3	14
42712A1	HOUSING, STARTER	5	1	10-40001--8	SCREW, BRACKET TO CARBURETOR	11	19
43514	LATCH, BOTTOM COWL . . .	3	10	10-40001--8	SCREW, HINGE TO TOP COWL	3	4
43515	HINGE, COWL LATCH	3	2	10-40001--8	SCREW, LATCH TO BOTTOM COWL	3	11
43554--1	LATCH, COWL - REAR	3	17	10-40001--8	SCREW, STATOR ATTACHING (25)	7	2
43555	BRACKET, TOP COWL	3	3	10-40001-74	SCREW, BRACKET TO BOTTOM COWL	3	21
44149-67	SEAL, BOTTOM COWL	3	9	10-40001-74	SCREW, STARTER HOUSING ATTACHING (20MM)	5	3
44260	RETAINER	29	3	10-40001-83	SCREW, STARTER HOUSING ATTACHING (35MM)	5	3
44260	RETAINER, WATER TUBE SEAL	15	45	10-40001209	SCREW, CRANKCASE TO CYLINDER BLOCK (60MM)	13	6
47947A1	PILOT AND OIL SEAL ASSEMBLY	25	7	10-40003-31	SCREW, COVER ATTACHING (30MM)	13	16
63310A1	LEVER ASSEMBLY, TILT STOP	23	10	10-40003-33	SCREW, EXHAUST COVER TO CYLINDER BLOCK (40MM)	13	11
65823A1	STEERING BAR ASSEMBLY	21	1	10-40007115	SCREW, IGNITION COIL COVER	7	8
85174A1	HANDLE ASSEMBLY, STARTER ROPE	5	11	10-40010127	SCREW, RETAINER	29	4
85977	SEAL, REED BLOCK - RUBBER	13	28				
85982	PLATE, BOTTOM COWL . . .	3	7				
86352A54	LAYNARD ASSEMBLY	3	24				
86617A13	STATOR ASSEMBLY	7	1				
86850	CAM	5	8				
86853	CAM	5	13				
86971	COVER, STARTER HOUSING	5	2				
86992A2	BEARING ASSEMBLY, CENTER MAIN	17	12				
87308	BRACKET, COWL LATCH . .	3	13				

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Part Number	Description	Pg.	Ref. No.	Part Number	Description	Pg.	Ref. No.
10-40057-85	SCREW, REED ATTACHING (10MM)	13	32	11-36069	NUT, TILT STOP LEVER SCREW	31	19
10-40057107	SCREW, COVER TO CYLINDER BLOCK (16MM)	13	14	11-36069	NUT, TILT STOP STRAP SCREW	31	24
10-40057107	SCREW, COVER TO CYLINDER BLOCK (16MM)	13	23	11-40021--3	NUT, CARBURETOR STUD	13	37
10-40057107	SCREW, COVER TO CYLINDER BLOCK (16MM)	13	26	11-40063--3	NUT, SUPPORT SCREW ...	5	19
10-40057108	SCREW, CLIP TO SWITCH BOX (20MM)	7	4	11-40063--4	NUT	29	7
10-40057108	SCREW, PLATE TO REED BLOCK (20MM)	13	36	11-40063--4	NUT, BRACKET SCREW ...	3	22
10-40057108	SCREW, SWITCH BOX TO CYLINDER BLOCK (22MM)	7	15	11-40063--5	NUT	29	15
10-40057111	SCREW, SUPPORT TO STARTER HOUSING (35MM)	5	16	11-40063--5	NUT, CYLINDER BLOCK STUD	13	40
10-40082-25	SCREW, CONNECTING ROD (25MM)	17	21	11-40063--5	NUT, CLAMP BRACKET STUD	31	10
10-41433	SCREW, RETAINING-LEVER TO SWIVEL BRACKET ...	23	11	11-45076	NUT, COIL TERMINAL	7	9
10-41523	SCREW, LEVER TO SWIVEL BRACKET	31	18	11-45076	NUT, SWITCH BOX TERMINALS	7	16
10-41523	SCREW, STRAP TO SWIVEL BRACKET	31	23	11-65562	NUT, PINION GEAR LOCKING	25	9
10-41524	SCREW, LEVER TO CLAMP BRACKET	31	20	11-67980	NUT, CLAMP BRACKET BOLT	31	16
10-41524	SCREW, STRAP TO CLAMP BRACKET	31	25	11-68219	JAM NUT	7	20
10-43394	SCREW, GROUND WIRE ...	7	18	11-93164	NUT, TILT TUBE	31	13
10-47277	SCREW, CO-PILOT ADJUSTING	19	16	12-20086	WASHER, GEAR HOUSING STUDS	25	31
10-60300	SCREW, CLAMP PLATE MOUNTING	19	5	12-20260	WASHER, GREASE FILLER HOLE SCREW	25	29
10-69064	BOLT, CLAMP BRACKET TO TRANSOM	31	14	12-20262	WASHER, GEAR HOUSING VENT SCREW	25	27
10-70332	SCREW, PLATE TO BOTTOM COWL (1/2")	3	8	12-20683	WASHER, WATER TUBE SEAL - LOWER	21	10
10-76804	SCREW, THUMB SCREW ..	23	4	12-20684	SEAL, WATER TUBE - LOWER	21	9
10-76804	SCREW, WASHER ATTACHING	31	5	12-20942	WASHER, SEALING-WATER PUMP CARTRIDGE	25	17
10-77190A3	THUMB SCREW ASSEMBLY	23	2	12-20959	WASHER, PROPELLER NUT	27	34
10-79953	SCREW, GREASE FILLER HOLE	25	30	12-22248	WASHER, CLAMP BRACKET STUD	19	12
10-92767A1	THUMB SCREW ASSEMBLY	31	3	12-40022-13	WASHER, SUPPORT SCREW	5	17
10-97359A1	SCREW, FLYWHEEL TO CRANKSHAFT	17	2	12-40023-14	WASHER, BALL SCREW ...	7	23
10-97516	SCREW, CAM TO STARTER SHEAVE	5	14	12-40023-15	WASHER	29	6
11-20190	NUT, PLATE TO BRACKET .	3	20	12-67981	WASHER, CLAMP BRACKET BOLT	31	15
11-20696	NUT, CLAMP BRACKET STUD	19	13	12-71421	WASHER, TILT TUBE	31	27
11-20958	NUT, PROPELLER	27	35	12-73719	WASHER, THUMB SCREW .	23	3
11-22053	NUT, CLAMP BRACKET STUD	23	9	12-73719	WASHER, THUMB SCREW .	31	4
11-34932	NUT, GEAR HOUSING STUD	27	32	12-86496	WASHER, FLYWHEEL SCREW	17	3
11-35814	NUT, STEERING BAR SCREW	21	3	13-26992	LOCKWASHER, CLAMP PLATE MOUNTING SCREW	19	6
11-36069	NUT, TILT STOP LEVER SCREW	23	13	13-26992	LOCKWASHER, RETAINER SCREW	15	47
				13-26993	LOCKWASHER, CLAMP BRACKET STUD	23	8
				13-31030	WASHER, WAVE-TILT STOP LEVER SCREW	23	12
				13-31030	WAVE WASHER, TILT STOP STRAP SCREW	31	26
				15-20695	SHIM, CLAMP BRACKET TO SWIVEL BRACKET (.010) .	19	10

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Part Number	Description	Pg.	Ref. No.	Part Number	Description	Pg.	Ref. No.
15-20939A1	SHIM, BALL BEARING TO SNAP RING	25	14	24-86857	SPRING, STARTER	5	5
15-20941A1	SHIM, BALL BEARING TO GEAR HOUSING	25	16	25-20812	SEAL, RUBBER-WATER PUMP CARTRIDGE	25	18
16-12981	STUD, ADAPTOR (1-1/4")	15	43	25-26722	"O" RING, TRANSFER PORT COVER	13	25
16-12981	STUD, CYLINDER BLOCK (LONG SHAFT)	13	39	25-30503	"O" RING, TRANSFER PORT COVER	13	13
16-14803	STUD, CYLINDER BLOCK (SHORT SHAFT)	13	39	25-41604--1	PLATE, BOTTOM COWL	3	12
16-20313	STUD, GEAR HOUSING (SHORT)	25	3	25-86391	"O" RING, TRANSFER PORT COVER	13	22
16-42463	STUD, ADAPTOR	15	43	25-86993	"O" RING	31	31
16-42463	STUD, CYLINDER BLOCK (LONG SHAFT)	13	39	25-98277	SEAL, FUEL FILTER	9	3
16-42917	STUD, CARBURETOR	13	5	25-99691	"O" RING	27	36
16-42984	STUD	29	5	26-20070	OIL SEAL	25	-
16-52606	STUD, GEAR HOUSING (LONG)	25	2	26-20903	OIL SEAL	25	--
16-55422	STUD, TIMING LINK	7	21	26-20903	OIL SEAL, WATER PUMP COVER	25	25
16-59620	STUD, CLAMP BRACKET (8")	23	6	26-43507	SEAL, CRANKSHAFT	17	7
16-78582	STUD, CLAMP BRACKET TO SWIVEL BRACKET	19	11	26-85090	SEAL, ADAPTOR	15	44
16-99928	STUD, CLAMP BRACKET	31	8	26-85090	SEAL, WATER TUBE	29	2
17-20891	SWIVEL PIN, CO-PILOT DISC	19	7	26-85107	OIL SEAL, CRANKSHAFT- LOWER	17	8
17-20937	PIN, PROPELLER GEAR TO SHAFT	25	12	26-85974	OIL SEAL, CRANKSHAFT - UPPER	17	11
17-20946	PIN, IMPELLER DRIVE	25	21	27-14539	GASKET, DRIVE SHAFT HOUSING	29	12
17-25870	ROLL PIN, LINK	3	15	27-14539A86	GASKET SET (SHORT SHAFT)	1	-
17-25971	PIN, SHEAR	27	33	27-41417	GASKET, REED BLOCK	13	29
17-56373A2	TILT LOCK PIN ASSEMBLY	23	5	27-41418	GASKET, ADAPTOR PLATE	13	33
17-85171	DOWEL PIN, CYLINDER BLOCK	13	2	27-41449	GASKET, CARBURETOR	11	17
17-99929A1	TILT PIN ASSEMBLY	31	7	27-41475--1	GASKET, EXHAUST MANIFOLD	13	7
18-21071	COTTER PIN, CO-PILOT SPRING GUIDE SCREW	21	14	27-41499--1	GASKET, EXHAUST COVER	13	9
19-69316	CAP, SWIVEL PIN	19	8	27-41499A84	GASKET SET (LONG SHAFT)	1	-
22-56759	FITTING, ADAPTOR PLATE - BLEED HOSE	13	35	27-41670	GASKET, ADAPTOR PLATE	29	8
22-71191	ELBOW, BLEED HOSE (45 DEGREES)	13	3	27-41670	GASKET, POWERHEAD	15	48
22-74036	GREASE FITTING	31	29	27-65820	GASKET, ADAPTOR TO DRIVE SHAFT HOUSING	15	49
22-94848	FITTING, TELL TALE HOSE - BOTTOM COWL	13	20	27-86389	GASKET, CYLINDER BLOCK COVER	13	17
22-99664	ELBOW, TELL TALE HOSE	13	18	28-20094	KEY, FLYWHEEL DRIVE	17	13
23-13049	PLUG, SWIVEL PIN	19	9	29-98295	NEEDLE BEARING, PISTON END	17	18
23-29669	BUSHING, UPPER	21	5	30-20938	BEARING, BALL-PROPELLER SHAFT	25	13
23-29670	BUSHING, LOWER	21	6	30-25728	BEARING, BALL-DRIVE SHAFT	25	5
23-30977	SPACER, SUPPORT SCREW	5	18	31-20904	BEARING, ROLLER	25	24
23-41041	SPACER, CLAMP BRACKET STUD	31	9	31-20904	BEARING, ROLLER- PROPELLER SHAFT	25	-
23-59621	SPACER, CLAMP BRACKET STUD	23	7	31-20908	BEARING, ROLLER-DRIVE SHAFT	25	-
23-F78544	BUSHING, CLAMP BRACKET STUD	19	14	31-41620A1	ROLLER BEARING ASSEMBLY	17	20
24-20229	SPRING, CO-PILOT TO DRIVE SHAFT HOUSING	21	12	31-85113	ROLLER BEARING, CRANKSHAFT - LOWER	17	9
24-44581	SPRING, TILT STOP LEVER SCREW	31	21	31-85114	ROLLER BEARING, CRANKSHAFT - UPPER	17	10
24-86851	SPRING, CAM	5	7	32-34395A1	HOSE, TELL TALE (8")	13	19
24-86852	SPRING, CAM	5	12				

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Part Number	Description	Pg.	Ref. No.	Part Number	Description	Pg.	Ref. No.
32-85116--1	WATER TUBE	29	10	1028-8283A1	COVER ASSEMBLY, CYLINDER BLOCK	13	15
32-86292	TUBE, WATER INLET	21	11				
32-99127109	FUEL LINE, FILTER TO ADAPTOR (7-1/2")	9	6	1390-8889A5	CARBURETOR ASSEMBLY	11	1
32-99127109	FUEL LINE, FILTER TO CARBURETOR (5-1/4")	9	5	1395-6201	JET, MAIN FUEL (.080)	11	7
32-99130122	HOSE, BLEED (12-1/4")	13	4	1395-9164	FUEL BOWL	11	4
33-14103570	SPARK PLUG, (NGK-BUHW- 2)-CANADA AND BELGIUM	7	13	1395-9165	COVER, DIAPHRAGM	11	9
33-97180	SPARK PLUG, (NGK-BUHW)	7	13	1395-9167	THROTTLE SHAFT	11	3
34-89793	REED STOP	13	31	1395-9169	FLOAT	11	5
34-99319	REED	13	30	1395-9170	VALVE, INLET NEEDLE	11	6
35-87946A13	FUEL FILTER ASSEMBLY	9	1	1395-9171	PLUG, JET RETAINER	11	8
35-87946A3	FILTER ASSEMBLY	9	2	1395-9172	SCREW, COVER PLATE	11	14
37-12622A1	DECAL SET	1	-	1395-9173	SCREW, FUEL PUMP COVER	11	12
39-12810A12	PISTON RING ASSEMBLY	17	16	1395-9174	SCREW, DIAPHRAGM COVER	11	10
40-47276	LOCK RING, PISTON PIN	17	15	1395-9177	PLATE, COVER (MANUAL)	11	13
43-29490	GEAR, PINION	25	8	1395-9180	THROTTLE VALVE	11	2
43-29491	GEAR, PROPELLER SHAFT	25	11	1395-9375	COVER, FUEL PUMP	11	11
44-20923	SHAFT, PROPELLER	25	10	1395-9376	REPAIR PARTS KIT	11	16
45-12639	DRIVE SHAFT (LONG SHAFT)	25	4	1395-9377	GASKET/DIAPHRAGM KIT	11	15
45-14544	DRIVE SHAFT (SHORT SHAFT)	25	4	1402-134A1	SWIVEL BRACKET ASSEMBLY	19	1
46-20905A1	WATER PUMP COVER ASSEMBLY	25	23	1427-5632A3	CLAMP BRACKET ASSEMBLY	23	1
46-20943A1	WATER PUMP CARTRIDGE ASSEMBLY	25	19	1487-9543A2	SWIVEL BRACKET	31	28
47-20945	IMPELLER, WATER PUMP	25	20	1497-8794A1	CLAMP BRACKET (PORT)	31	1
50-12066A9	ROPE, STARTER	5	10	1497-8796A1	CLAMP BRACKET (STARBOARD)	31	2
50-42566	SHEAVE, STARTER	5	6	1577-5153A7	DRIVE SHAFT HOUSING ASSEMBLY	21	4
53-20940	RING, SNAP	25	15	1604-1116A14	GEAR HOUSING, COMPLETE (LONG SHAFT)	25	-
53-86849	RETAINING RING, CAM	5	9	1604-1116A17	GEAR HOUSING, COMPLETE (SHORT SHAFT)	25	-
54-11139A1	CLAMP ASSEMBLY	31	30	1604-1116A2	GEAR HOUSING ASSEMBLY	25	1
54-24836	CLIP, STATOR LEADS	7	3	2176-9418A2	BOTTOM COWL (STBD.) LONG SHAFT	3	6
54-30954	CLIP, SAFETY	31	12	2176-9419A1	BOTTOM COWL (PORT) LONG SHAFT	3	5
54-68424	CLAMP, FUEL LINE	9	7	2176-9540A2	BOTTOM COWL (STBD.) SHORT SHAFT	3	6
84-88807A10	WIRE ASSEMBLY, GROUND	7	17	2176-9541A1	BOTTOM COWL (PORT) SHORT SHAFT	3	5
84-99215A25	LEAD ASSEMBLY, HIGH TENSION	7	10	2177-8869A8	TOP COWL ASSEMBLY (WITHOUT DECALS)	3	1
85-63709A1	BOOT ASSEMBLY, SPARK PLUG	7	12	3501-9544A5	HOUSING ASSEMBLY	29	11
85-70674	BOOT, COIL	7	11				
87-11083A6	STOP SWITCH ASSEMBLY	3	23				
90-12745	OWNER'S GUIDE	1	-				
90-13767	MERC 25 XS PARTS LIST	1	-				
258-8274A6	FLYWHEEL ASSEMBLY (LONG SHAFT)	17	1				
258-9542A4	FLYWHEEL ASSEMBLY (SHORT SHAFT)	17	1				
339-7370A13	IGNITION COIL ASSEMBLY	7	6				
339-7452A9	SWITCH BOX (WITH BULLET CONNECTIONS)	7	14				
464-8978A2	CRANKSHAFT ASSEMBLY	17	6				
630-8835A2	CONNECTING ROD ASSEMBLY	17	17				
767-9104A3	PISTON AND PIN ASSEMBLY	17	14				
872-9077A4	CYLINDER BLOCK/CRANKCASE ASSEMBLY	13	1				