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Notice

Throughout this publication, “Dangers,” “Warnings” and “Cautions” are used to alert the mechanic to special instructions concerning a particular service or operation that may be hazardous if performed incorrectly or carelessly. Observe them carefully!

These “Safety Alerts” alone cannot eliminate the hazards that they signal. Strict compliance to these special instructions when performing the service, plus “common sense” operation, are major accident prevention measures.

⚠ DANGER

DANGER - Immediate hazards which will result in severe personal injury or death.

⚠ WARNING

WARNING - Hazards or unsafe practices which could result in severe personal injury or death.

⚠ CAUTION

CAUTION - Hazards or unsafe practices which could result in minor personal injury or product or property damage.

Notice to Users of This Manual

This service manual has been written and published by the service department of Mercury Marine to aid our dealers, mechanics and company service personnel when servicing the products described herein.

It is assumed that these personnel are familiar with the servicing procedures of these products, of like or similar products manufactured and marketed by Mercury Marine, and that they have been trained in the recommended servicing procedures for these products which include the use of mechanic’s common hand tools and the special Mercury Marine or recommended tools from other suppliers.

We could not possibly know of and advise the service trade of all conceivable procedures by which a service might be performed and of the possible hazards and/or results of each method. We have not undertaken any such wide evaluation. Therefore, anyone who uses a service procedure and/or tool, which is not recommended by the manufacturer, first must completely satisfy himself that neither his nor the product’s safety will be endangered by the service procedure selected.

All information, illustrations and specifications contained in this manual are based on the latest product information available at time of publication.

It should be kept in mind, while working on the product, that the electrical system and ignition system are capable of violent and damaging short circuits or severe electrical shocks. When performing any work where electrical terminals could possibly be grounded or touched by the mechanic, the battery cables should be disconnected at the battery.

Any time the intake or exhaust openings are exposed during service they should be covered to protect against accidental entrance of foreign material which could enter the cylinders and cause extensive internal damage when the engine is started.

It is important to note that, during any maintenance procedure, replacement fasteners must have the same measurements and strength as those removed, whether metric or customary. Numbers on the heads of the metric bolts and on surfaces of metric nuts indicate their strength. Customary bolts use radial lines for this purpose, while most customary nuts do not have strength markings. Mismatched or incorrect fasteners can result in damage or malfunction, or possible personal injury. Therefore, fasteners removed should be saved for re-use in the same locations whenever possible. Where the fasteners are not satisfactory for re-use, care should be taken to select a replacement that meets the same specifications as the original.

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Engine Mechanical Components

Many of the engine mechanical components are designed for marine applications. Unlike automotive engines, marine engines are subjected to extended periods of heavy load and wide-open-throttle operation and, therefore, require heavy-duty components. Special marine engine parts have design and manufacturing specifications which are required to provide long life and dependable performance. Marine engine parts also must be able to resist the corrosive action of salt or brackish water that will rust or corrode standard automotive parts within a short period of time.

Failure to use recommended Quicksilver service replacement parts can result in poor engine performance and/or durability, rapid corrosion of parts subjected to salt water and possibly complete failure of the engine.

Use of parts other than recommended service replacement parts, will void the warranty on those parts which are damaged as a result of the use of other than recommended replacement parts.

Replacement Parts

⚠ WARNING

Electrical, ignition and fuel system components on MerCruiser Engines and Stern Drives are designed and manufactured to comply with U.S. Coast Guard Rules and Regulations to minimize risks of fire or explosion.

Use of replacement electrical, ignition or fuel system components, which do not comply to these rules and regulations, could result in a fire or explosion hazard and should be avoided.

When servicing the electrical, ignition and fuel systems, it is extremely important that all components are properly installed and tightened. If not, any electrical or ignition component opening would permit sparks to ignite fuel vapors from fuel system leaks, if they existed.

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Models Covered in This Manual

MCM Alpha

MODEL	SERIAL NUMBER	MODEL YEAR
5.0L	OD832472 - OF601000	1993 - 1995
5.0LX	OD831003 - OF601000	
5.7L (4 Barrel)	OD830700 - OF601000	
5.7L (2 Barrel)	OF601000 and Above	1996 Thru 1997
5.7LX	OF601957 and Above	
5.7L EFI	OF286830 and Above	
5.7LX EFI	OF752400 and Above	
350 Magnum	OD830982 and Above	
350 Magnum EFI Gen+	OF800500 and Above	

MCM Bravo

MODEL	SERIAL NUMBER	MODEL YEAR
5.0L	OD833077 - OF601464	1993 - 1995
5.7L (4 Barrel)	OD831826 - OF605335	
5.7L (2 Barrel)	OF605336 and Above	1996 Thru 1997
5.7LX	OF601645 and Above	
5.7L EFI	OF225560 and Above	
5.7LX EFI	OF752408 and Above	
350 Magnum	OD800300 and Above	
350 Magnum EFI Gen+	OF800500 and Above	
350 Magnum EFI/MP	OF289431 - OF601999	1995
350 Magnum MPI Gen+	OF602000 and Above	1996 Thru 1997

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MIE Ski

MODEL	SERIAL NUMBER	MODEL YEAR
5.7L Competition (4 Barrel)	OD840220 - OF775199	1993 - 1995
5.7L Competition (2 Barrel)	OF775200 and Above	1996 Thru 1997
350 Magnum Tournanment Ski	OD840100 and Above	1993 Thru 1997
350 Magnum EFI Tournament Ski	OF225157 - OK000000	1994 - 1996
350 Magnum EFI Gen+ Tournament Ski	OK040006 and Above	1997
350 Magnum EFI/MP Tournament Ski	OF350583 - OF745536	1995
350 Magnum MPI Tournament Ski	OF745537 - OK000000	1996
350 Magnum MPI Gen+ Tournament Ski (Black Scorpion)	OF800000 and Above	1996

MIE Inboard

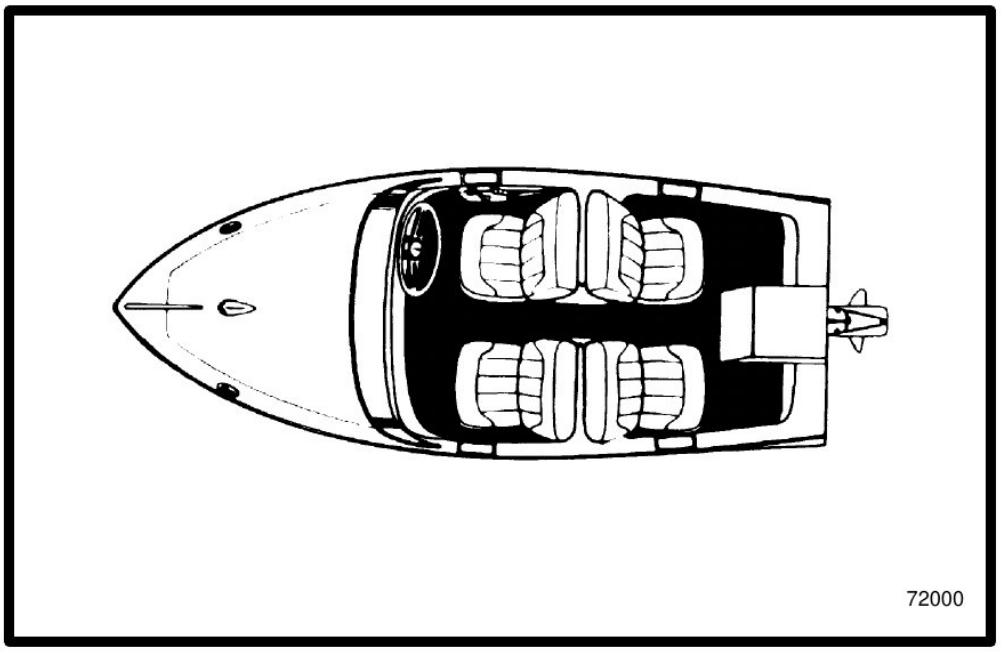
MODEL	SERIAL NUMBER	MODEL YEAR
5.7L	OD84000 and Above	1993 Thru 1997
5.7L EFI Gen+	OK040300 and Above	1997

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IMPORTANT INFORMATION

1

A



GENERAL INFORMATION

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NOTICE

For information and procedures on troubleshooting, refer to Section 1C.

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NOTICE

Refer to appropriate Stern Drive Service Manual for transom assembly and stern drive unit repair.

Introduction

This comprehensive overhaul and repair manual is designed as a service guide for the models previously listed. It provides specific information, including procedures for disassembly, inspection, assembly and adjustment to enable dealers and service mechanics to repair and tune these engines.

Before attempting repairs or tune-up, it is suggested that the procedure first be read through to gain knowledge of the methods and tools used and the cautions and warnings required for safety.

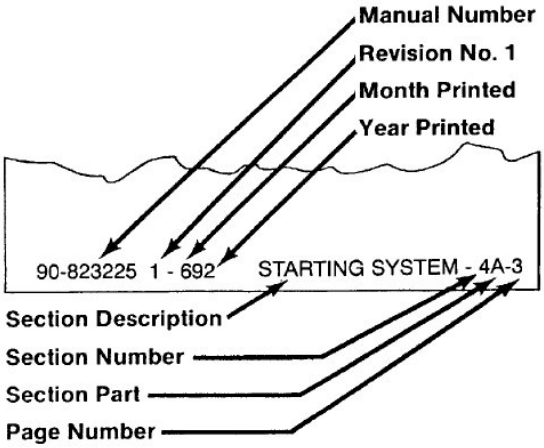
How to Use This Manual

This manual is divided into sections which represent major components and systems.

Some sections are further divided into parts which more fully describe the component.

Page Numbering

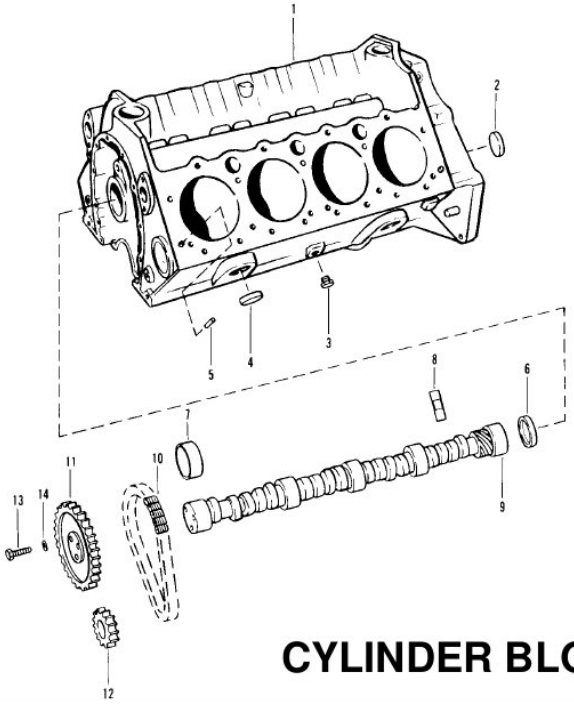
Two number groups appear at the bottom of each page. Following is an example and description.



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How to Read Parts Manual



CYLINDER BLOCK AND CAMSHAFT

M0033-**D8**

a PART NO.	b REF. NO.	c DESCRIPTION	d QUAN.
841-81631	1	CYLINDER BLOCK ASSEMBLY	1
N.S.S.	2	PLUG, expansion (1-1/4") (GM #3738306)	2
22-87238	3	DRAIN COCK, cylinder block	2
19-34270	4	PLUG, expansion - cylinder block (1-5/8" Diameter)	8
17-35465	5	PIN, dowel - block to head (5/16" Diameter)	4
22-72640	6	PLUG, expansion - camshaft bearing hole	1
23-85674	7	BEARING UNIT, camshaft (set)	1
72638	8	LIFTER, hydraulic valve	16
431-5943	9	CAMSHAFT	1
35378	10	CHAIN, camshaft timing	1
43-35338	11	SPROCKET, camshaft timing	1
43-48338	12	SPROCKET, crankshaft timing	1
10-34505	13	BOLT, camshaft timing sprockets (3/4")	3
12-39167	14	WASHER, camshaft timing sprocket bolt	3

e 841-8163 Cylinder Block Assembly includes only standard pistons, piston rings, crankshaft bearings and camshaft bearings.

A. **Part Number:** For part ordering - Note N.S.S. for Reference Number 2, Plug, expansion - that means Not Sold Separately by Mercury Marine however, in this case, the G.M. Part Number (for the plug) is given in the Description Column.

B. **Reference Number:** For part Shown on exploded parts view.

C. **Description:** This is the most important column because it gives:
1) Description of Part: Ref. No. 1 is a Cylinder Block Assembly, No. 9 is a Camshaft, etc.
2) What parts are included with a certain part: Notice how the Description of Part, for Ref. Nos. 1 and 8 thru 14, are at the left side of the column. Description of Part for Ref. Nos. 2 thru 7 are indented under "Cylinder Block Assembly". If Ref. No. 1 (Cylinder Block Assembly) was ordered, all indented parts (Ref. Nos 2thru 7) would come with the part. Ref. Nos. 8 thru 14 would not come with Ref. No. 1 and would have to be ordered separately. If 2 Cylinder Blocks were listed, both cylinder blocks would come with the indented parts. In some cases, an indented part will have another part indented under it. The second indented part will come with the first indented part.
3) Serial number break: If serial number information is listed, check product serial number to ensure that correct part is ordered.
4) Special information: Many times special information will be shown after description such as; L.H. Rotation, R. H. Rotation, Filter up, Filter Down, etc. This will help in selecting the correct part.

D. **Quantity:** Quantity that has to be ordered.

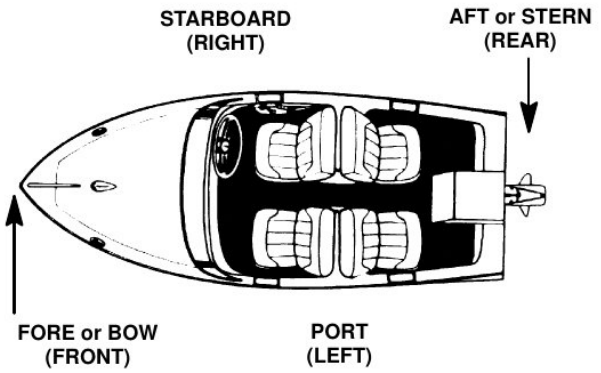
E. **Special Information Block:** Additional information, part numbers for gasket sets, etc.

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Directional References

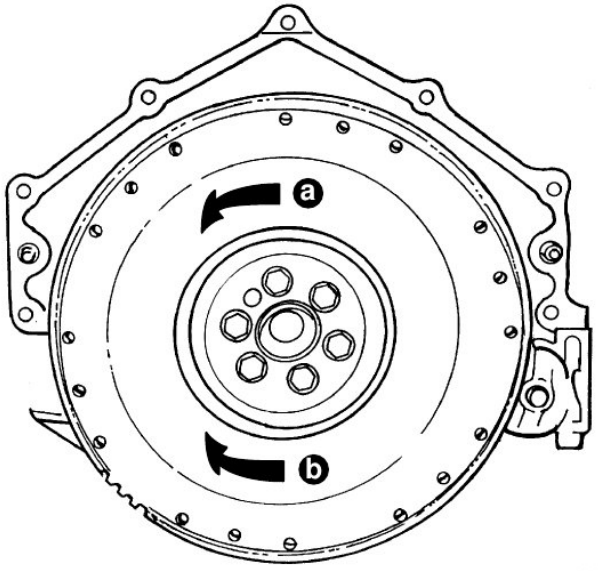
Front of boat is bow; rear is stern. Starboard side is right side; port side is left side. In this maintenance manual, all directional references are given as they appear when viewing boat from stern looking toward bow.



72000

Engine Rotation

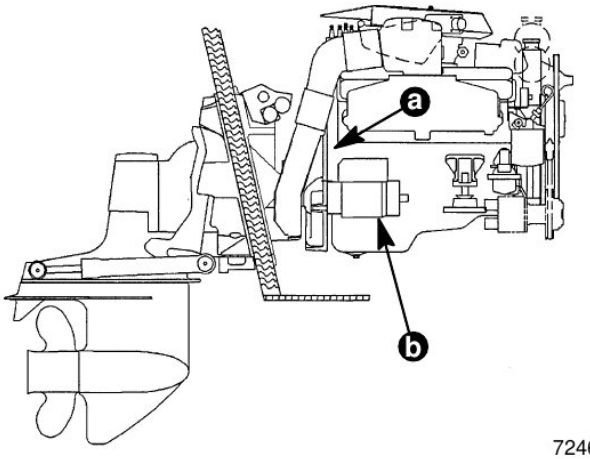
Engine rotation is determined by observing flywheel rotation from the rear (stern end) of the engine looking forward (toward water pump end). Propeller rotation is not necessarily the same as engine rotation. When ordering replacement engine, short blocks or parts for engine, be certain to check engine rotation. Do not rely on propeller rotation in determining engine rotation.



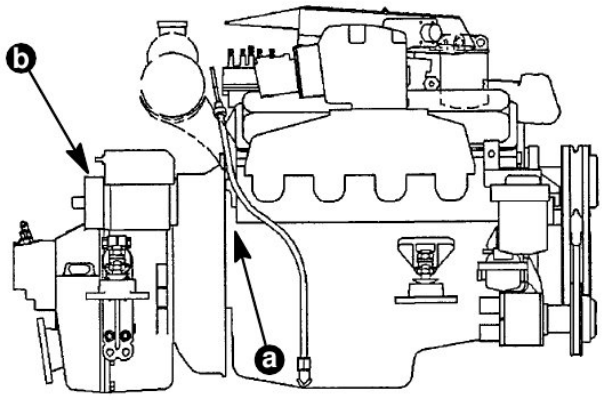
72001

a - Standard Left Rotation - All MCM Stern Drive Engines, MIE Inboard, Left Hand Rotation Engines.
b - Opposite Right Hand Rotation - MIE Inboard Right Hand Rotation Engines.

Engine Serial Number Locations



72468



72469

a - Serial Number
b - Starter Motor

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