



Service Bulletin

Bulletin No. 2013-13

Circulate to: Sales Manager Accounting Service Manager Technician Parts Manager

Tilt Pin Spiral Retaining Ring Inspection – 200/225/250/300/350 SCi Verado L6

Models Affected

Models Covered	Serial Number Or Year
200/225/250/300 Verado L6	USA - 1B768046–2B029431
200/225/250/300 Verado L6	Belgium - 0P559709–0P587065
350 SCi Verado L6	USA - 1B920381–2B029431

Scope

Worldwide

Situation

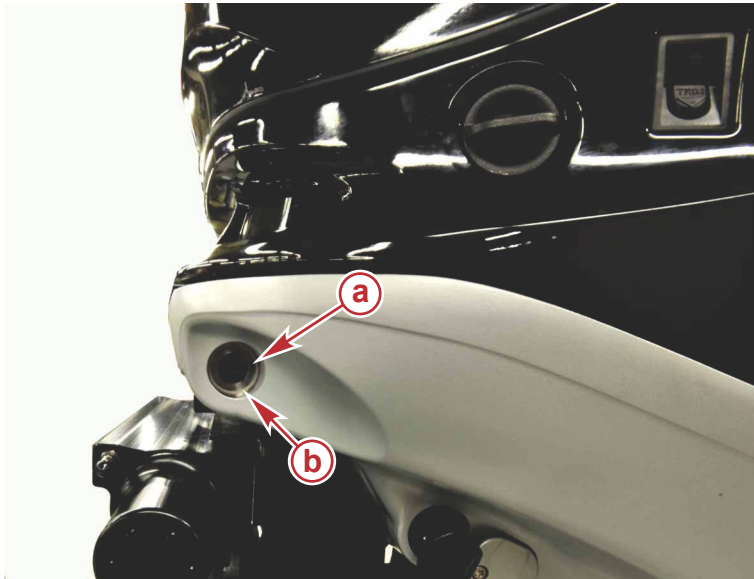
Mercury Marine has been informed of a small number of instances where the tilt pin spiral retaining ring which secures the tilt pin into the mount cradle bore has not been fully installed. If the tilt pin spiral retaining ring is not fully seated into the ring groove in the tilt pin bore (port side of mount cradle) there is the potential for the tilt pin spiral retaining ring to become dislodged which could allow the tilt pin to move out of position. Mercury Marine has taken steps to assure that the tilt pin spiral retaining ring is fully seated into the tilt pin bore groove on all new products. Affected outboards will need to be inspected and, if necessary, corrected following the procedures outlined in this service bulletin.

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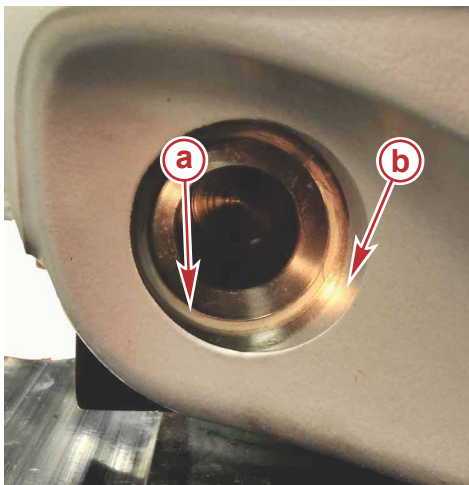
Inspection

Visually confirm that the tilt pin spiral retaining ring is fully seated into the groove in the tilt pin bore located on the port side of the mount cradle.



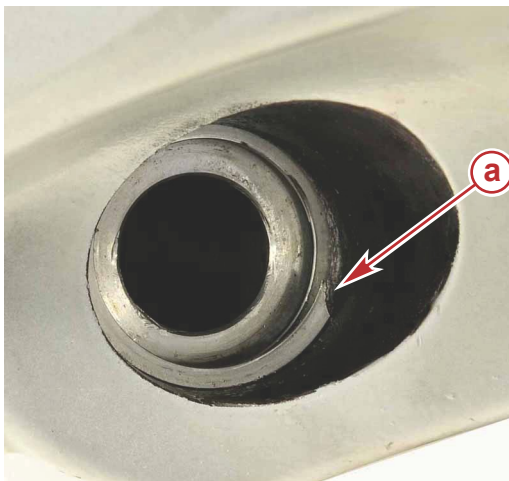
53971

- a** - Tilt tube (port side of mount cradle)
- b** - Tilt pin spiral retaining ring



53972

- a** - Properly seated tilt pin spiral retaining ring
- b** - Tilt pin bore



53973

- a** - Tilt pin spiral retaining ring not fully seated

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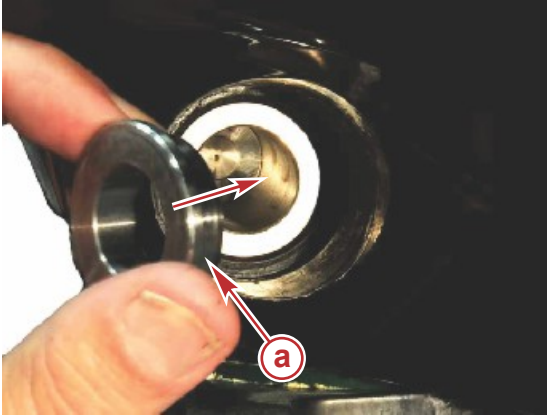
Correction

TILT PIN SPIRAL RETAINING RING NOT FULLY SEATED

Use a small screwdriver or punch to push any unseated portions of the tilt pin spiral retaining ring into the groove in the tilt pin bore.

TILT PIN SPIRAL RETAINING RING MISSING

1. If out of position, push the tilt tube into the tilt pin bore from the port side of the mount cradle to expose the groove in the tilt pin bore.
2. 350 SCi models: Verify that the tilt pin spacer is in position. Install a new spacer if it is missing.



54029

a - Tilt pin spacer (350 SCi only)

3. Install a new tilt pin spiral retaining ring into the groove in the tilt pin bore.
 - a. Separate the inner end of the tilt pin spiral retaining ring and start (push) it into the tilt pin bore in the mount cradle.
 - b. Continue to push the inner end of the tilt pin spiral retaining ring into the tilt tube bore so that it begins to wrap into the groove in the tilt tube.



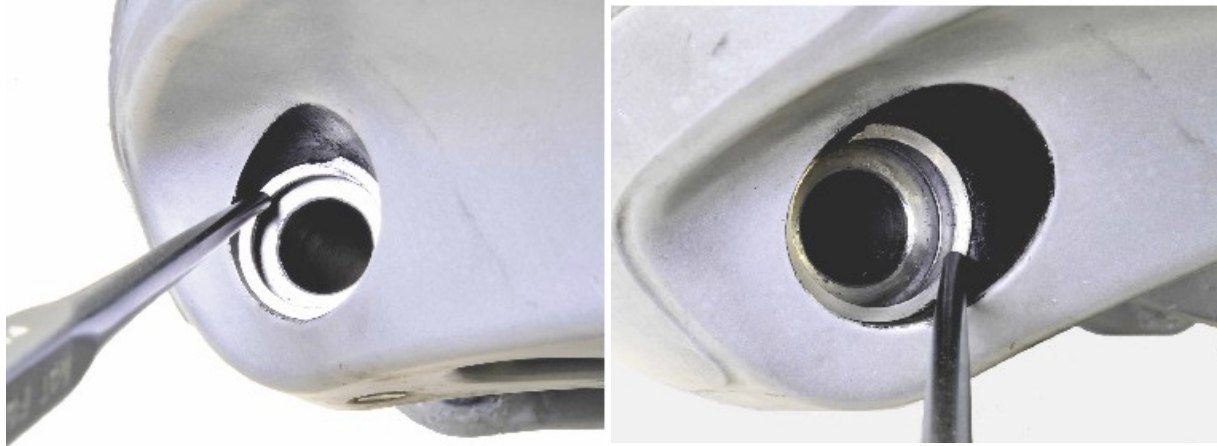
54031

a - Inner end of tilt pin spiral retaining ring

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- Use a small screwdriver or punch to push the remaining tilt pin spiral retaining ring completely into the groove in the tilt pin bore.



Parts Required – Missing Tilt Pin Spiral Retaining Ring or Tilt Pin Spacer

Qty.	Description	Part Number
1	Tilt pin spiral retaining ring (200/225/250/300 Verado L6)	8M0038931
1	Tilt pin spiral retaining ring (350 SCi Verado L6)	8M6000694
1	Tilt pin spacer (350 SCi Verado L6)	25-8M0032468

Dealer Outboard Inventory

Affected outboards in dealer inventory should be inspected for proper installation of the tilt pin spiral retaining ring prior to customer delivery.

Customer Outboards

Within Warranty

Outboards brought in for other service/maintenance work that are within warranty may be inspected and/or corrected as required.

Out of Warranty

Outboards brought in for other service/maintenance work that are out of warranty should be inspected and/or corrected as part of routine maintenance and it will not be covered under warranty.

Warranty

Mercury Marine will credit the dealer for the cost of parts and labor.

Complete a warranty claim listing:

- Outboard serial number

FOR INSPECTION ONLY, NO CORRECTION REQUIRED

- Labor: 0.3 hour
- Warranty flat rate code: SB03
- Part code: 117
- Failure code: 00

FOR INSPECTION AND INSTALLATION OF A TILT PIN SPIRAL RETAINING RING

- Labor: 0.5 hours
- Warranty flat rate code: SB05

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- Qty. 1, Tilt pin spiral retaining ring, P/N 8M0038931, 200/225/250/300 Verado L6
- Qty. 1, Tilt pin spiral retaining ring, P/N 8M6000694, 350 SCi Verado L6
- Qty. 1, Tilt pin spacer, P/N 25-8M0032468, 350 SCi Verado L6
- Part code: 117
- Failure code: 00

United States and Canada: Complete and process the claim via MercNET or return a warranty claim form.

International: Follow instructions issued by Marine Power International office or by an authorized Marine Power Distributor.

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