

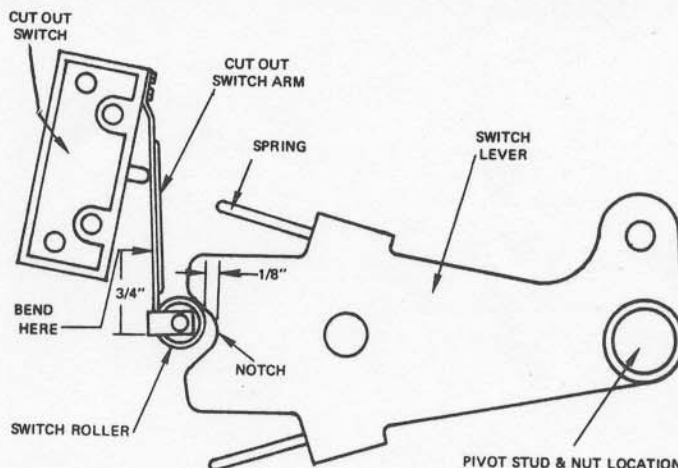
- A. MCM 120-thru-888 Shift Cutout Switch Adjustment
- B. MCM 120-thru-888 Shift Improvement Kit (B-65037A1)
- C. MCM 120-140-165 Shift Cable Damage Prevention
- D. MCM 215E and 215H Bell Housing Gasket Installation
- E. MCM 215E Shift Actuator Assembly (B-54240A5) Exchange - Reprint

**A. MCM 120-thru-888 SHIFT CUTOUT SWITCH ADJUSTMENT**

*(Attach Bulletin Reference Sticker to PP 2B-14, 2B-15, 2H-8 of Your Service Manual.)*

The shift cutout switch MUST BE operating and adjusted to cut out the ignition momentarily during stern drive unit shifting. This relieves the torque load on the sliding clutch in the gear housing. The lever that actuates the switch senses the control shift cable movement to accomplish this action. If a shifting problem exists after the shift cable installation and adjustment procedures (outlined in the MerCruiser Service Manual) had been properly accomplished, adjust cutout switch as follows:

1. Clean and lubricate the cutout switch assembly.
2. Loosen pivot nut (if tight) and lubricate shift lever pilot stud with Multi-purpose Lubricant (C-92-49588) to ensure that the switch arm roller returns freely to center of notch.
3. Connect switch leads to continuity meter.
4. Move switch lever slowly by hand and note roller position in lever notch when circuit is closed. (Figure 1) Switch roller should not be more than



**Figure 1. Cutout Switch Adjustment**

1/8" (3.2mm) from bottom of notch. If more than 1/8", bend switch arm at a point approximately 3/4" (19mm) from end toward the bottom of the notch to obtain a closed circuit within 1/8" from bottom of notch.

**B. MCM 120-thru-888 SHIFT IMPROVEMENT KIT (B-65037A1)**

*(Attach Bulletin Reference Sticker to P. 2H-7 of Your Service Manual.)*

MerCruiser 120-thru-888 Shift Improvement Kit (B-65037A1) contains a new gear housing shift shaft, a bell housing shift fork and procedures to correct a shifting problem. The new parts have closer tolerances which improve efficiency of the shifting linkage. Use this kit only when a shifting problem is still present after performing the recommended shift cable installation and adjustment procedures.

Labor rate allowance  
is 1.2 hours.

Quan.	Part No.	Description	U.S. List
1	B-65037A1	Shift Improvement Kit	\$ 6.45

(OVER)

### C. MCM 120-140-165 SHIFT CABLE DAMAGE PREVENTION

(Attach Bulletin Reference Sticker to P. 2B-14 of Your Service Manual.)

Under certain conditions during severe boat operation, the MCM 120-140-165 stern drive shift cable could become damaged between the gimbal housing exhaust elbow and the engine flywheel housing, making it inoperative. As a precaution, keep the shift cable away from this area. Install clamp (C-54-52923) on the engine flywheel housing cover and route the shift cable through the clamp. (Figure 2) Remove screw from the bottom left side of the flywheel cover and replace it with screw C-10-26065, fastening the clamp (C-54-52923) in a vertical position. The stern drive unit shift cable **MUST BE** routed through the clamp horizontally.

Part No.	Description	U.S. List
C-54-52923	Clamp	@5 \$ .20
C-10-26065	Screw	@5 \$ .20

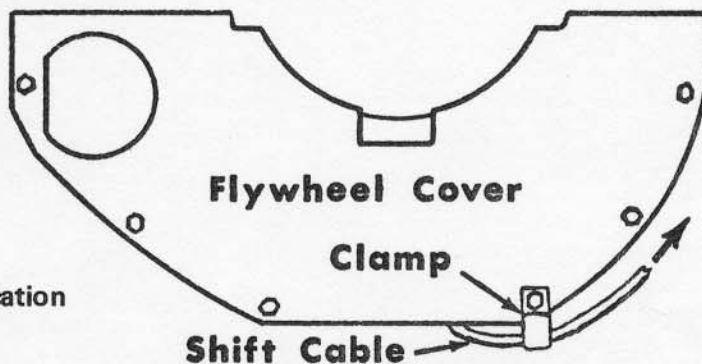


Figure 2. Flywheel Clamp Location

### D. MCM 215E and 215H BELL HOUSING to DRIVE SHAFT HOUSING GASKET INSTALLATION

(Attach Bulletin Reference Sticker to PP 2F-3, 2G-3 of Your Service Manual.)

Both insufficient torque on the drive mounting nut and incorrect (reversed) installation of the gasket will allow water to enter the drive unit oil and shifter gear assembly. Water in the oil will cause oil to foam through the reservoir. Water on the 215E shifter gear assembly will corrode and bind it, thus causing it to damage the shifter cable assembly. If either of these conditions is found, pack the gear cavity with Anti-Corrosion Grease (C-92-45134). Also properly install two gaskets (C-27-54014), instead of one, and torque to 80 ft. lbs. (11mkg) to prevent recurrence of these conditions after performing repairs.

Part No.	Description	U.S. List
C-27-54014	Bell Housing to Drive Shaft Housing Gasket	@3 \$ .20

### E. MERCUISER 215E SHIFT ACTUATOR ASSEMBLY (B-54240A5) EXCHANGE - REPRINT

(Attach Bulletin Reference Sticker to P. 6C-24 of Your Service Manual.)

Inoperative MerCruiser 215E shift actuator assembly (B-54240A5), which requires repair, will be exchanged by the factory for \$75.00 net U.S. Failures within the warranty period will be exchanged no-charge. Immediately return all inoperative units which you have replaced. Retain the reverse lock valve and safety clutch.

Only malfunctioning shift actuators will be accepted for this exchange. Units, which have been externally damaged or damaged from water entry, will not be exchanged.