

Circulate to:  Sales Manager  Accounting  Service Manager  Technician  Parts Manager

## Rocker Arm Replacement Required

### Models Affected

Models Covered	Serial Number Or Year
8.2L EC and Non-EC Sterndrive and Inboard	Refer to the <b>Serial Numbers Affected</b> table at the end of this bulletin.

### Scope

Worldwide

### Situation

Mercury MerCruiser has detected the potential for needle bearing failures in the rocker arm assemblies on the specified engines. Affected engines must be inspected, and the rocker arm assemblies replaced with new components. If there is any indication of loss of material during inspection (missing cage material or needles), the longblock must be replaced. Continued use of the engine without this repair could lead to serious irreparable engine damage. Before beginning repairs, look for an open fix campaign in MercNET for this service bulletin; to ensure that the product has not been updated at the factory or by another dealer.

**IMPORTANT: Do not deliver any new boats until the inspection and rocker arm components are replaced and, if necessary, longblock replacement has been completed.**

### Rocker Arm Access

#### ⚠ WARNING

Performing service or maintenance without first disconnecting the battery can cause product damage, personal injury, or death due to fire, explosion, electrical shock, or unexpected engine starting. Always disconnect the battery cables from the battery before maintaining, servicing, installing, or removing engine or drive components.

#### ⚠ CAUTION

Disconnecting or connecting the battery cables in the incorrect order can cause injury from electrical shock or can damage the electrical system. Always disconnect the negative (-) battery cable first and connect it last.

Before removing any components, photograph the starting location of hoses, wire routings, dipstick position, etc., to reference during reassembly. Access the rocker arms as follows:

1. Disconnect the negative (-) battery cable from the battery.
2. Disconnect the positive (+) battery cable and MerCathode controller positive wire from the battery.
3. Disconnect the battery isolator wires, if equipped.
4. Drain the seawater system. Refer to **Section 1 - Draining the Seawater System** in Service Manual 8M0081787, 8.2 Liter Gasoline Engine.

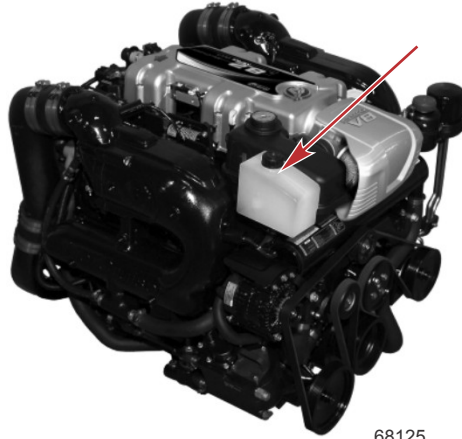
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**⚠ CAUTION**

To avoid the possibility of injury or component damage, use caution when lifting heavy objects. Use an appropriate lifting device or seek assistance.

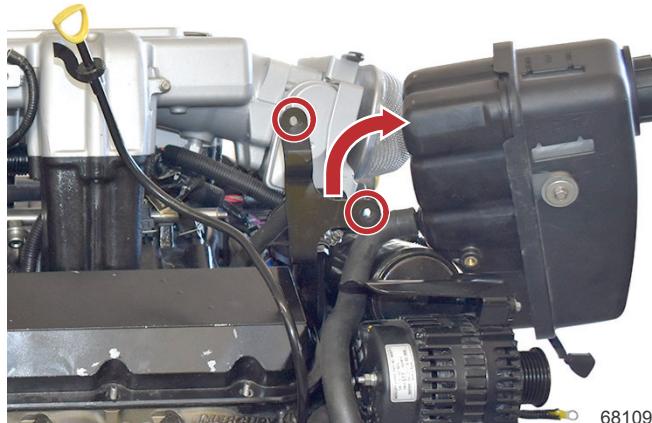
5. Remove the port side and starboard side exhaust manifold assemblies. Refer to **Section 7 - Exhaust Manifold Removal** in Service Manual 8M0081787, 8.2 Liter Gasoline Engine.
6. Remove the valve covers from the engine as follows:
  - a. Disconnect the crankcase ventilation hoses.
  - b. Remove the shift bracket assembly.
  - c. Remove the gear lube bottle from the bracket, if equipped.



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**Gear lube bottle**

- d. Disconnect the oxygen sensors, if equipped, and the EMCT sensors.
- e. Remove the valve cover attaching nuts.
- f. Remove the port side valve cover.
- g. Remove the starboard side valve cover as follows:
  - Disconnect the three screws for the coolant reservoir on the starboard side of the engine, and tip the reservoir forward, as shown. The third screw is on the back side of the reservoir, not shown in the image.

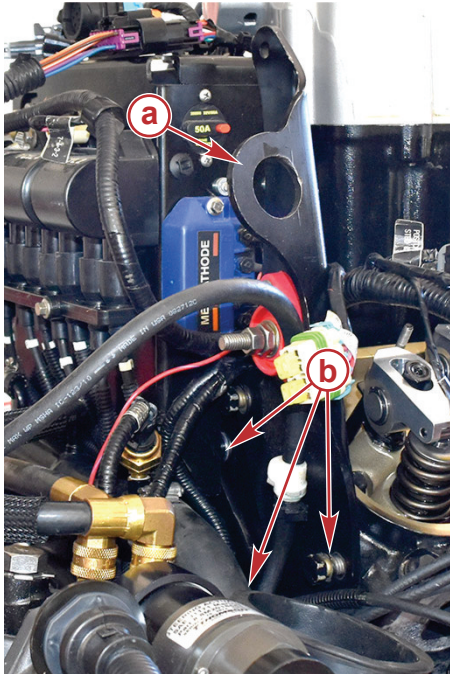


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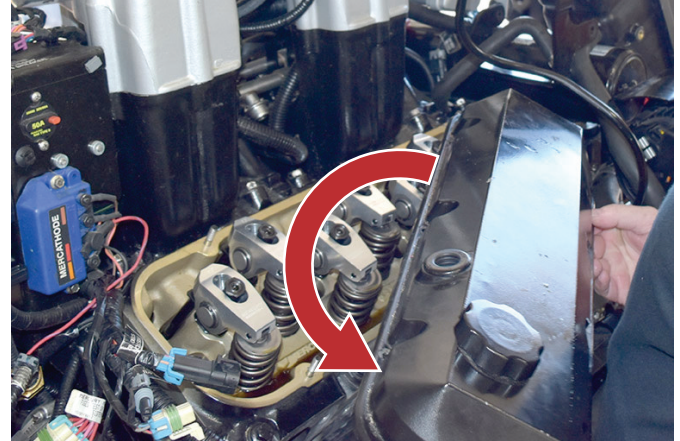
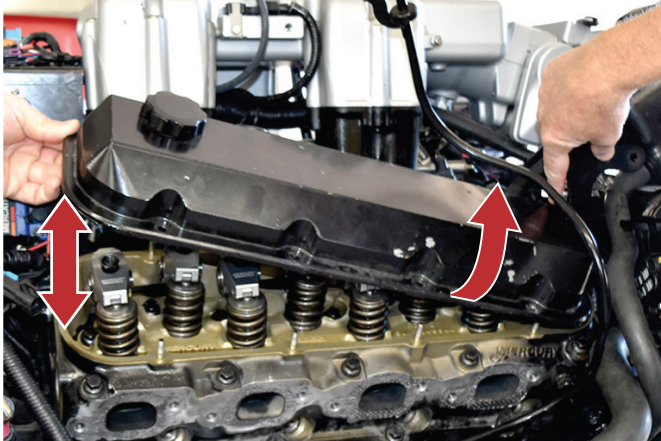
- Loosen the three bolts securing the rear lifting eye/hot stud bracket to the cylinder head. Slide the bracket toward the rear of the engine, to allow clearance for removal of the valve cover.



- a - Rear lifting eye/hot stud bracket
- b - Bolts (3)

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- Elevate the rear of the valve cover 10.2–12.7 mm (4–5 in.), as shown.
- Pivot the front side of the valve cover inward, then downward to free the cover from between the front valve cover studs and the coolant reservoir and drive lube bottle mounting bracket.
- Rotate the valve cover outward and lift the cover up and off of the engine.



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## Rocker Arm Inspection

Inspect for evidence of rocker arm damage before and during removal of the rocker arms. Look for loose needles and cage breakouts on the head surface and near the springs and rocker arms. Check both intake (top) and exhaust (bottom) areas. Any indication of material loss (missing cage material or needles) will result in the need to replace the longblock.

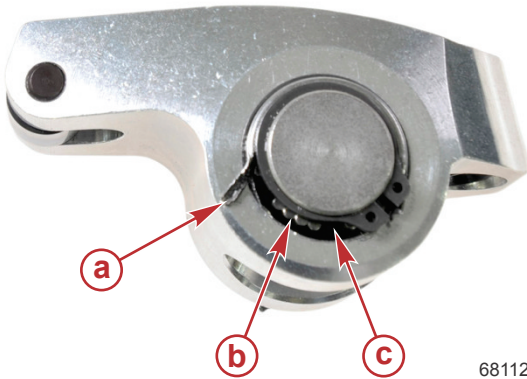
- If evidence of rocker arm damage exists, order a new longblock (refer to **Parts Required, Longblock Replacement**). Refer to Service Manual 8M0081787, 8.2 Liter Gasoline Engine for replacement instructions.

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## Rocker Arm Replacement Required

- If no material loss was observed, proceed to **Rocker Arm Replacement**.



### Damaged rocker arm

- a** - Cage material damaged/missing
- b** - Exposed needles
- c** - Missing needles

## Rocker Arm Replacement

- Remove and replace the rocker arm assemblies on both sides of the engine.  
**NOTE:** It is not necessary to remove the push rods for this procedure.  
**IMPORTANT:** When installing the rocker arm components, coat the bearing surfaces with engine oil. Ensure that the flat part of the rocker arm pivot is installed upward.
- Adjust the valves according to **Section 3A - Valve Adjustment** in Service Manual 8M0081787, 8.2 Liter Gasoline Engine.
- Replace the valve cover gaskets, and install the valve covers. Refer to **Section 3A - Valve Covers, Installation** in Service Manual 8M0081787, 8.2 Liter Gasoline Engine.
- Install the rear lifting eye/hot stud bracket into its original position. Tighten the three fasteners to the specified torque.

Description	Nm	lb-in.	lb-ft
Rear lifting eye/hot stud bracket fasteners	66.4	-	49

- Install the manifolds with the new gaskets. Refer to **Section 7 - Exhaust Manifold Installation** in Service Manual 8M0081787, 8.2 Liter Gasoline Engine.
- Install the drive lube bottle into its original position.
- Install the coolant reservoir into its original position. Tighten the screws to the specified torque.

Description	Nm	lb-in.	lb-ft
Coolant reservoir screws	10.8	95.6	-

### ⚠ CAUTION

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- Connect the battery isolator wires, if equipped.
- Connect the positive (+) battery cable and MerCathode controller positive wire to the battery.
- Connect the negative (-) battery cable to the battery.
- Run the engine and inspect for leaks.

## Parts Required

### Rocker Arm Replacement

Qty.	Description	Part Number
16	Rocker arms	8M0099002
2	Valve cover gasket	8M0092920
2	Exhaust manifold gasket	8M0065690

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## Longblock Replacement

Qty.	Description	Part Number
1	Longblock	8M0074038

## Owner Notification

A letter will be sent to every registered owner of an affected Mercury engine. The letter will reference Mercury MerCruiser Service Bulletin 2018-06 and will advise the owner to contact their selling dealer or a Mercury authorized dealer for repair. A copy of the customer letter is included with this service bulletin for your reference.

## Warranty

**United States and Canada:** Mercury Marine will credit the dealer for the cost of the parts and labor for engines with the specified serial numbers. Submit a warranty claim through your normal warranty processing channel.

**Outside the United States and Canada:** Follow the instructions issued by your local office or by your distributor.

## Rocker Arm Replacement

Procedure	Labor Hours	Labor Code
Rocker arm inspection	3.5	SB35
Rocker arm replacement	7.5	SB75

**NOTE:** If additional time is required, contact the Mercury Technical Service Department.

Use the following codes on the claim:

- Part code: 425
- Failure code: 00

Return the rocker arms to your normal warranty return address.

**NOTE:** A separate warranty claim will be required for each engine serial number in twin installations.

## Longblock Replacement

Procedure	Labor Hours	Labor Code
Rocker arm inspection	3.5	SB35
Longblock replacement	7.5	SB75
Longblock R&R of engine required		
R&R complete sterndrive engine	4	MA11
R&R complete inboard engine—open or Sportfish	9	MA13
R&R complete inboard engine—sedan cruiser	26.5	MA14
R&R complete inboard engine—double cruiser	16.5	MA15

**NOTE:** If additional time is required, contact the Mercury Technical Service Department.

Use the following codes on the claim:

- Part code: 425
- Failure code: 00

Return the longblock to your normal warranty return address.

**NOTE:** A separate warranty claim will be required for each engine serial number in twin installations.

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## Serial Numbers Affected

### Inboard Models

2A576374	2A576377
2A576375	2A581580
2A576376	2A582713

### Sterndrive Models

2A535695	2A576084	2A576302	2A576702	2A577117	2A577370
2A571654	2A576085	2A576303	2A576703	2A577118	2A577371
2A575966	2A576086	2A576338	2A576704	2A577129	2A577372
2A575967	2A576094	2A576339	2A576751	2A577130	2A577383
2A575968	2A576095	2A576492	2A576752	2A577131	2A577384
2A575976	2A576096	2A576493	2A576753	2A577136	2A577385
2A575977	2A576149	2A576494	2A576770	2A577137	2A577396
2A575978	2A576150	2A576495	2A576771	2A577138	2A577397
2A575982	2A576151	2A576496	2A576857	2A577139	2A577398
2A575983	2A576159	2A576497	2A576858	2A577140	2A577407
2A575984	2A576160	2A576505	2A576859	2A577141	2A577408
2A575985	2A576161	2A576506	2A576860	2A577164	2A577564
2A575986	2A576166	2A576507	2A576861	2A577165	2A577565
2A575987	2A576167	2A576523	2A576862	2A577223	2A577583
2A576019	2A576168	2A576524	2A576902	2A577224	2A577584
2A576020	2A576200	2A576552	2A576903	2A577225	2A577585
2A576021	2A576201	2A576553	2A576904	2A577237	2A577593
2A576032	2A576212	2A576554	2A576913	2A577238	2A577594
2A576033	2A576213	2A576567	2A576914	2A577239	2A577595
2A576034	2A576214	2A576568	2A576915	2A577247	2A577623
2A576041	2A576215	2A576569	2A576924	2A577248	2A577674
2A576042	2A576216	2A576592	2A576925	2A577249	2A577734
2A576044	2A576217	2A576594	2A576926	2A577339	
2A576046	2A576227	2A576677	2A576943	2A577340	
2A576077	2A576229	2A576678	2A576944	2A577341	
2A576078	2A576300	2A576679	2A576945	2A577355	
2A576079	2A576301	2A576701	2A577116	2A577356	

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Dear Mercury Marine Customer,

Mercury Marine is dedicated to providing superior products with outstanding quality and reliability. As part of our continuing efforts to achieve this goal, we have determined that your registered MerCruiser product may require service.

**What You Need to Know:**

We have identified an issue with an internal engine component (rocker arm) on some MerCruiser engines. The situation could lead to engine failure.

**What You Should Do:**

Contact your authorized Mercury dealer to schedule a service appointment. Be sure to mention Mercury MerCruiser Service Bulletin 2018-06 and present this notice at the time of service.

**Mercury Marine's Commitment to You:**

We have provided instructions to our authorized dealers for this service. The required service will be performed at NO COST to you.

If you have any questions, or no longer own this Mercury Marine product, please contact Mercury Marine Customer Service, at 1-920-929-5040, between 7:30 AM and 4:30 PM, Central Time.

We have sent this notice in the interest of your continued satisfaction with our product. We sincerely regret any inconvenience this may cause you.

Thank you,

Mercury Marine Customer Service