

Exhaust Manifold Bolts - Sport Jet 120

MODELS AFFECTED:

1995 Sport Jet 120
S/N 0E093700 thru 0E125508

We are receiving sporadic reports from the field on Sport Jet 120's that have leaked water at cylinder and exhaust manifold parting line.

Investigation of this problem revealed reduced (low) clamp load on exhaust manifold gasket. This is caused by initial thermocycling of powerhead which reduced torque of stainless steel bolts.

CORRECTION:

Engineering has recognized this as an area which needed improvement and developed a new bolt. This bolt has capacity for higher torque and significantly increased clamp loads.

Part numbers and quantities for bolts are as follows:

Qty. 21 of 10-828824 300 bolt (1/4-20x3")

Qty. 4 of 10-828824 400 bolt (1/4-20x4")

FACTORY CORRECTION:

Powerheads that have been reworked at factory are identified by green dot sticker on exhaust manifold.

DEALER INVENTORY

It is recommended that all Sport Jet 120's in dealer inventory that are within serial numbers listed on this bulletin, have exhaust manifold bolts replaced to prevent potential problem of water leaks at parting line. It is also recommended that manifold bolts be replaced as consumer boats with Sport Jet 120's are being scheduled for service work.

Procedure for bolt replacement is as follows:

NOTE: It is very important to oil bolt threads and underside of head prior to installation to achieve proper and uniform clamp load.

1. Remove bolt #1 per Figure 1. Install new bolt and existing washer. Torque bolt to 115 lb/in (13.0 N-m). Then, follow same procedure for bolt #2 and so on until all bolts have been replaced and torqued following the sequence in Figure 1.

NOTE: Replacement of the exhaust gasket is not necessary when using this procedure.

2. After all bolts have been replaced and torqued, retorque bolts #1 thru #8 (center bolts) per Figure 1.

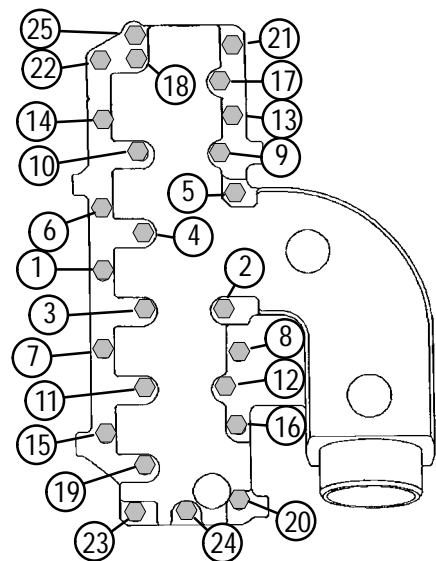


Figure 1

WARRANTY

Complete warranty claim listing:

Engine serial number

Qty. 21 P/N 10-828824 300 Bolt 1/4-20x3.0"

Qty. 4 P/N 10-828824 400 Bolt 1/4-20x4.0"

One (1) hour labor

Warranty labor rate code: NJC

Failure code: 505-00