

TO: SERVICE MANAGER MECHANICS
PARTS MANAGER

REVISED
12-94

No. 92-4

A. HI-PERFORMANCE PISTON MEASUREMENT AND CLEARANCE

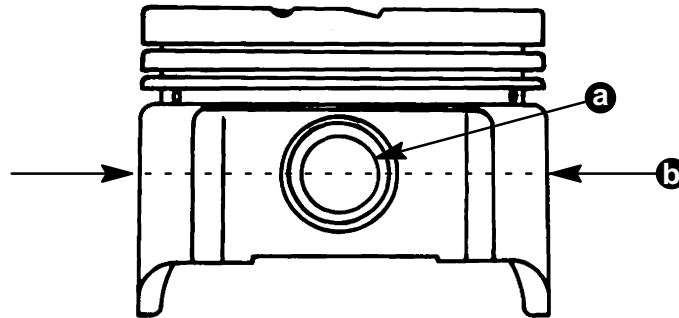
MODELS: HP425, HP450, HP465, HP500 (Bulldog), HP500(502), HP575, HP525SC, HP600SC, AND HP800SC

⚠ CAUTION

CORRECT PISTON MEASUREMENT OF MERCURISER HI-PERFORMANCE ENGINES IS CRITICAL TO ENGINE PERFORMANCE AND SERVICE LIFE. WHEN FITTING PISTONS, BE SURE TO FOLLOW MEASURING GUIDELINES IN THIS BULLETIN.

Piston measurement of HP425/450 and HP525SC

Measure piston at the wrist pin center line and 90 degrees from the wrist pin bore.



a - Wrist Pin Bore

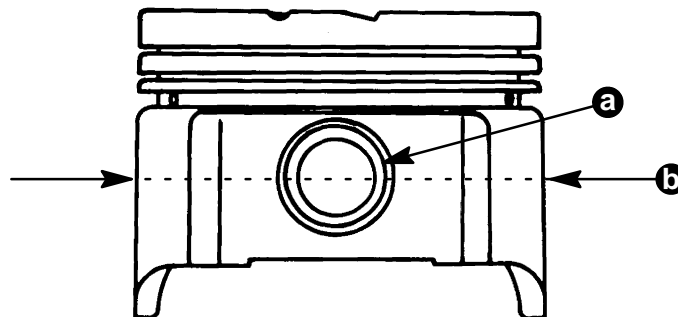
b - Measure Piston at Wrist Pin Centerline

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Piston to Cylinder Wall Clearance: **HP425** - .0035-.0055 (.089-.140 mm), **HP525SC** - .005-.007 in. (.127-.178mm)

Piston measurement of HP 465/500 (502 CID)

Measure piston at the wrist pin center line and 90 degrees from the wrist pin bore.



a - Wrist Pin Bore

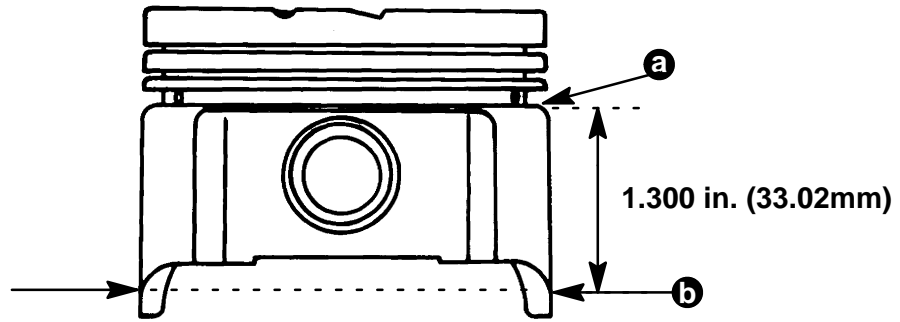
b - Measure Piston at Wrist Pin Centerline

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Piston to Cylinder Wall Clearance: .004 - .006 in. (.102 - .152mm)

Piston measurement of HP500 (Bulldog) and HP575 (Wiseco Piston)

Measure piston 1.300 in. (33.02mm) from the bottom of the oil ring groove and 90 degrees from the wrist pin bore.



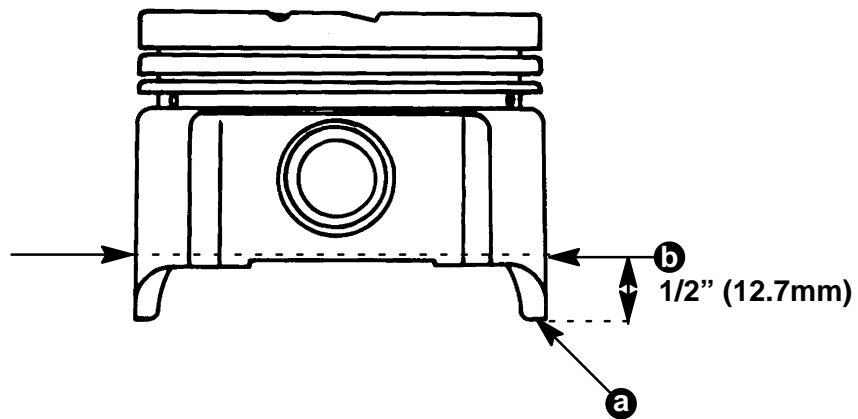
- a - Bottom of Oil Ring Groove
- b - Measure Piston Here

Piston to Cylinder Wall Clearance: .0045 - .0065 in. (.114 - .165mm)

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Piston measurement of HP600SC and HP800SC

Measure piston .5" (12.7mm) from bottom of piston skirt and 90 degrees from the wrist pin bore.



- a- Bottom of Piston Skirt
- b - Measure Piston .5" (12.7mm) From Bottom of Skirt

Piston to Cylinder Wall Clearance: .0045 - .0065 in. (.114-.165mm)

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