

- WARRANTY INFORMATION SERVICE INFORMATION
 PARTS INFORMATION

Sterndrive No. 2002-03

Circulate to: Sales Manager Accounting Service Manager Technician Parts Manager

Mercury Racing 500 EFI & 575 SCi Cylinder Head Torque

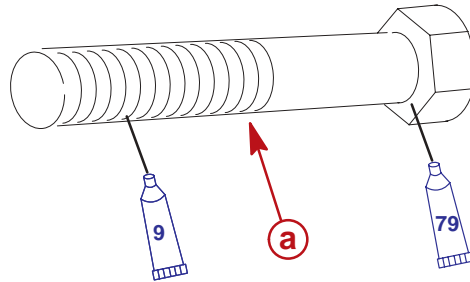
Models Affected

All Mercury Racing 500 EFI and 575 SCi Sterndrive products. This information supercedes all other bulletins or service manual information on cylinder head torquing procedures in regard to these two engine models.


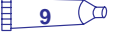
Prior to Installing the Cylinder Head

CYLINDER HEAD BOLT PREPARATION

1. All fasteners should be thoroughly cleaned.
2. Apply sealant to threads of bolt and oil under the head of the bolt.



a - Cylinder head bolt

	Description	Where Used	Part Number
	4 Cycle 25W40 Engine Oil	Under the head of the cylinder head bolt	92-802837A1
	Loctite 567 PST Pipe Sealant	Thread of cylinder head bolts	92-809822

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BLOCK AND HEAD PREPARATION

1. The deck surface on the block and the cylinder head surface must be clean, dry, and flat.
2. The threaded holes for the head bolts in the block should be level with the deck surface and the hole should be clean and free of debris.
3. Check the new head gasket for any damage.

Cylinder Head Installation

⚠ CAUTION

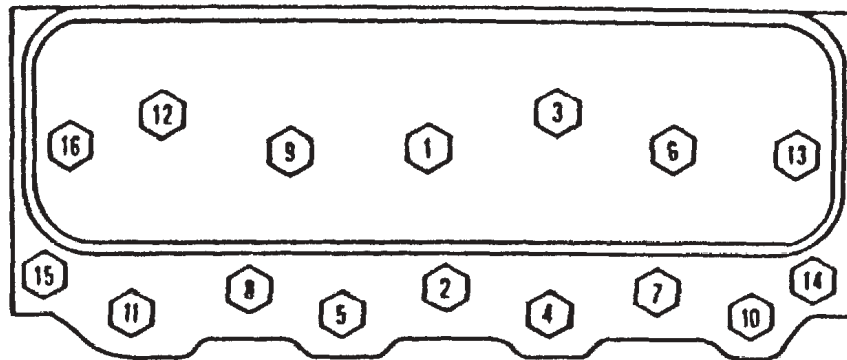
Avoid gasket failure. Do not use any sealer on the cylinder head gaskets.

1. Place the clean head gasket in position over the dowel pins.
2. Carefully set the cylinder head in place over the dowel pins.
3. Install the prepared head bolts hand tight.
4. To ensure gasket sealing, torque the head bolts in three steps, following the torque sequence for each step.

	Step 1	Step 2	Step 3
Nm	81	95	108
lb-ft	60	70	80

5. Repeat **Step 3** final torque.

Torque Sequence



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