

NUMBER: 82-2

DATE: 3/5/82

## V-6 CHROME BORE BLOCKS - EXCHANGE PROGRAM

CIRCULATE TO:  
SERVICE MANAGER  
PARTS MANAGER  
MECHANICS

Mercury Marine has established an exchange program on Merc V-200 and V-225 outboard cylinder blocks which require rechroming of the cylinder bore/s.

Mercury Marine will exchange a cylinder block and crankcase assembly from its rechromed exchange bank at Fond du Lac. It will also provide a special service at no additional charge to rechrome the cylinders of a block which the dealer or customer desires to be returned.

### EXCHANGE CYLINDER BLOCKS

Exchange assemblies are sent out after receipt and inspection of the old cylinder block and crankcase. However, an exchange assembly can be shipped on order, prior to receipt of the old assembly. In this case, the dealer will be invoiced at dealer net for the exchange assembly and a credit less \$200 issued upon receipt of an acceptable exchange block.

Only cylinder blocks which are in good condition are acceptable for the exchange program. Cylinder block and crankcases which have damage or are corroded or in any other way unrepairable, will not be accepted for exchange. Cylinder bores with chrome peeled or scored to a maximum depth of .004" can be rechromed to original dimensions. Cylinders scored or damaged beyond this depth have to be resleeved.

### SPECIAL HANDLING CYLINDER BLOCKS

Hi-Performance blocks or assemblies on which a customer or dealer desires the same assembly to be returned, must be indicated on the order when it is shipped to us. Special handling is required in this case and may slightly delay the return due to the chroming plant production schedule.

Cylinder blocks and crankcase assemblies sent for rechroming of cylinder bores are to be shipped directly to:

**Mercury Marine  
Service Repair, Plant 10  
1939 Pioneer Road  
Fond du Lac, WI 54935**

Before shipping, remove the following parts:

1. All cylinder heads, exhaust covers and water jacket covers.
2. Starter mounting bracket.
3. Poppet valve insert and "O" ring.
4. Cylinder block to drive shaft housing mounting studs.

*NOTE: Studs are secured with Loctite. It may be necessary to heat base of stud to remove. (When replacing an exchange block, use Loctite "A" or "271", 92-32609-1 on threads before installing studs.)*

**Be sure to adequately pack the returned assembly to prevent shipping damage. If an assembly is received in a damaged condition, it will not be eligible for the exchange.**

The exchange price is \$200 net (U.S.) F.O.B. Fond du Lac, Wisconsin, U.S.A. Prices outside U.S. are subject to customs duties.