

A. Pre 1984 Merc 18 & 25 Lower Units Below The Following Serial Numbers:

U.S. 6414333

Canada 7207738

Belgium 9378151

B. 1984 Merc 18XD & 25XD Electric (E& EL) Models

CIRCULATE TO:
SERVICE MANAGER
PARTS MANAGER
MECHANICS
"Place in a Service
Bulletin Binder"

A. PRE 1984 MERC 18 & 25 LOWER UNITS BELOW THE FOLLOWING SERIAL NUMBERS:

U.S. 6414333 Canada 7207738 Belgium 9378151

As indicated in the Parts Lists, Merc 18 and 25 lower units (within the above serial number group) were built with either a .080" thick thrust washer or a .234" thick thrust washer above the pinion gear. The .234" thick thrust washer was then superseded with bushing 98861A1. Due to an oversight, the bushing was not listed in the parts lists. They will be corrected. To clarify:

1. If a replacement bushing is required, order 98861A1 to receive the bushing and installation instructions.
2. When .234" thick thrust washer is ordered, it will be superseded by bushing 98861A1 and installation instructions.
3. DO NOT install bushing in a gear housing equipped with .080" thick thrust washer or gear damage will occur.

Bushing Installation**⚠ CAUTION**

DO NOT install this bushing in a gear housing that is equipped with .080" (2.03mm) thick thrust washer (12-94056) above pinion gear or gear housing damage may result.

Refer to appropriate "Service Manual" for removal, disassembly, reassembly and reinstallation of gear housing assembly.

IMPORTANT: This bushing replaces .234" (5.94mm) thick Thrust Washer (96524), lower Driveshaft Bearing (31-85559), and Thrust Bearing (31-85560) in Merc 18 and 25 HP gear housing assemblies equipped with .234" (5.94mm) thick thrust washer.

Gear Housing With .234" (5.94mm) Thick Thrust Washer (96524) Above Pinion Gear

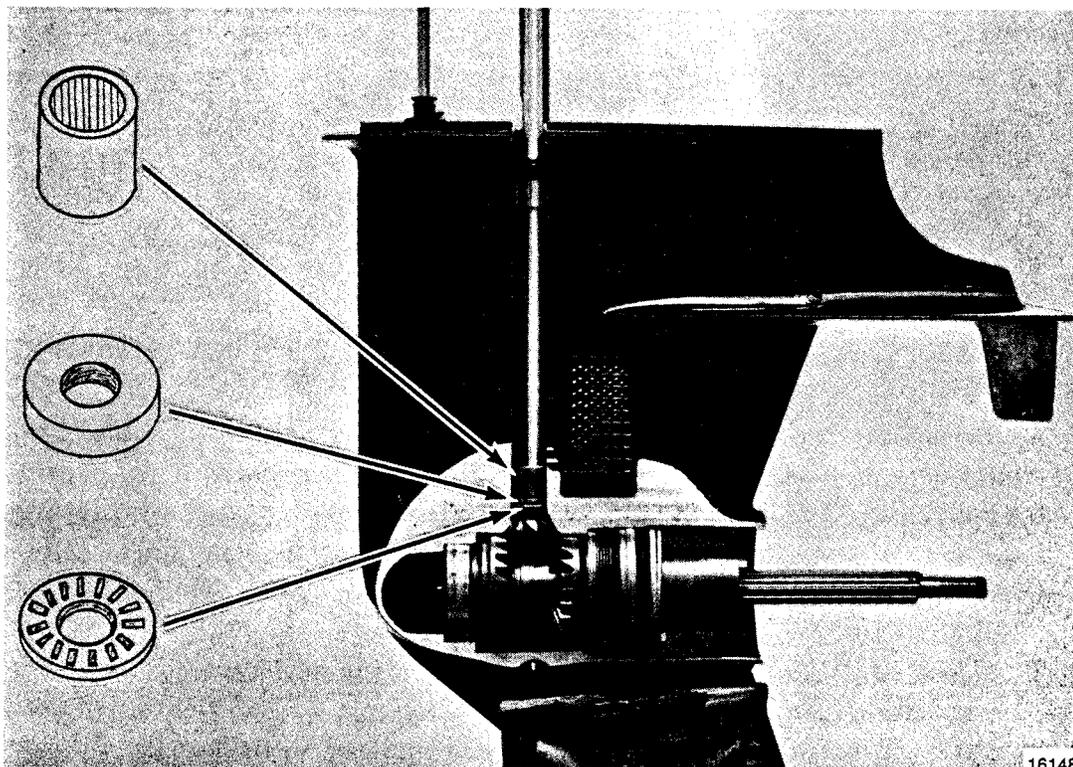
1. Refer to Step 1 for component removal.
2. Refer to Step 2 for bushing installation.

Gear Housing With Bushing

1. Remove bushing from gear housing by driving bushing down into propeller shaft cavity using a punch and hammer (or suitable mandrel and driver rod).
2. See Step 2 for installation of new bushing.

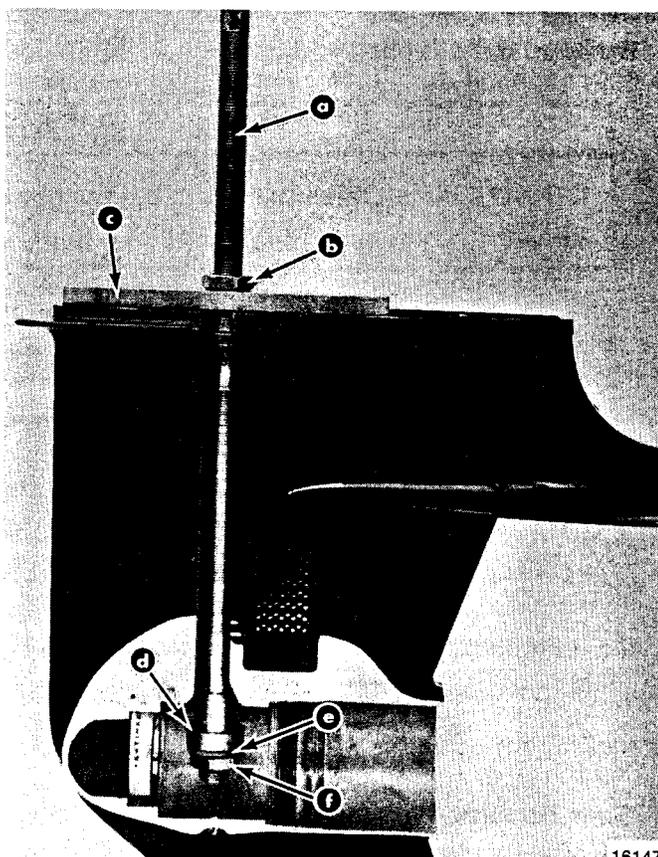
STEP 1 Component Removal

Remove and discard thrust bearing, thrust washer, and lower driveshaft bearing.



STEP 2 Install Bushing as Shown

- Hold threaded rod so that it will not rotate, then tighten upper nut against metal plate, to pull bushing into drive shaft bore.
- Tighten nut until large shoulder of bushing is firmly seated against gear housing.



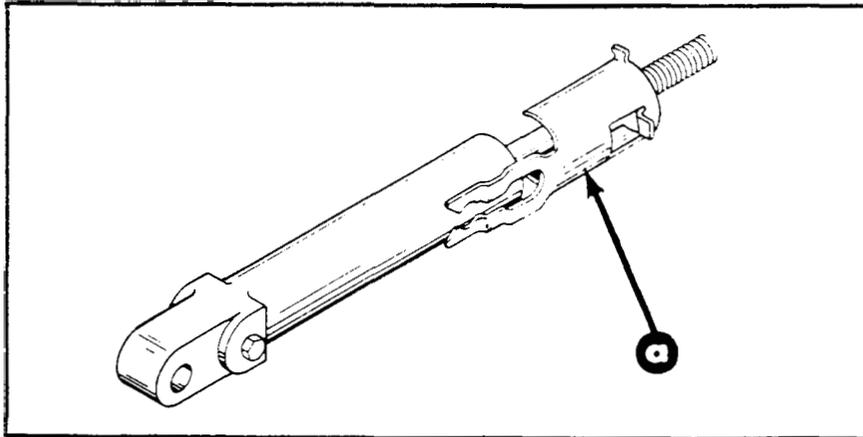
- a - 5/8" O.D. Threaded Rod (or Puller Shaft 91-31229)
- b - Nut (Upper)
- c - Metal Plate (or Puller Plate 91-29310)
- d - Bushing (Small O.D. Beveled Edge Toward Top of Gear Housing)
- e - Washer (1-3/16" O.D. x 5/8" I.D.) or Mandrel
- f - Nut (Lower)

B. 1984 MERC 18XD & 25XD ELECTRIC (E & EL) MODELS

Some competitive remote control cables cannot be used on the 1984 electric models.

The reason is that quick connect cable retainers were specifically designed to fit the round cable guides used on Quicksilver remote control cables. (Figure 1)

Some competitive remote control cables have cable guides with different contours and the quick connect cable retainers cannot be easily adapted. This is another reason to use only genuine Quicksilver parts and accessories.



a - Cable Retainer

Figure 1.