

CYLINDER HEAD CORE PLUG REPLACEMENT

On MerCruiser 215 and 888 Engines

Cylinder head core plugs may erode on MerCruiser and Inboard 215 and MerCruiser 888 Engines, which are OPERATED CONTINUOUSLY IN SALT WATER and not fresh water cooled, thus allowing water to be taken into the engine. This problem applies to rigs which are kept in a salt water environment and not those which are trailered to salt water areas.

Three of these threaded core plugs are located in each cylinder head. All new 215 and 888 engines, which are installed in boats, must be reworked to incorporate new cast iron core plugs to replace the original equipment mild steel plugs.

All factory-registered owners of 215 and 888 engines AFFECTED will be notified by registered mail to have the inspection and replacement performed on their engines.

Replace core plugs as follows:

CAUTION: Drain water from block before removing core plugs, or water will run into cylinder head and be difficult to clean out.

1. Remove rocker covers.
2. Remove old plugs from cylinder heads with 9/16" driver from C-91-60699 Hex Driver Kit. If driver kit is not available, use suitable hardened 9/16" hex bar stock and wrench.
3. Coat threads on new plugs (C-22-63028) with Sealer (C-92-34227-1) and install in cylinder heads. Torque to 28-30 ft. lbs.
4. Clean rocker cover gasket surfaces and install new gaskets.
5. Install rocker covers and torque rocker cover screws to 48 in. lbs.

After engine has been reworked, stamp an "X" (with screw driver or chisel) on a boss on the intake manifold to identify that engine has been reworked. Looking at the front of the engine, this boss is located on the right hand side of the intake manifold in front of the carburetor and is approximately 1/2" wide and 3/4" long. This area is easily accessible. All engines, which are reworked at the factory or already equipped with the new plugs, will have this same identification mark.

If, due to corrosion, plugs cannot be removed, or if cylinder head is damaged during removal, a complete cylinder head is available for replacement. The complete cylinder head, which includes valves, springs, etc, is available for this campaign only and will not be stocked as a normal replacement item. If cylinder head replacement is necessary, order necessary gaskets and cylinder head part number listed, following.

(OVER)

All 215 and 888 complete engines (above Serial No. 3322952), short blocks and replacement cylinder heads will have the new cast iron plug already installed. Reworked short blocks are identified by the "X" stamped on the intake manifold. Cylinder heads are identified by an "X" stamped on a boss located near No. 1 or No. 8 exhaust port.

Labor Rate Time Allowance for installing new plugs or cylinder heads is as follows:

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| 1. Engine Installed in Boat | 0.8 hrs. |
| 2. R & R Complete Cylinder Head (One) | 2.2 hrs. |
| 3. R & R Complete Cylinder Head (Both) | 2.9 hrs. |

Part No.	Description	No. Req.
C-22-63028	Plug	6
C-27-56173	Rocker Cover Gasket	2
B-949-4876	Complete Cylinder Head	*
C-27-54566	Exhaust Manifold Gasket	*
C-27-56888A1	Intake Manifold Gasket (215)	*
C-27-56888A2	Intake Manifold Gasket (888)	*

** Order only if necessary to replace cylinder head.*