

- A. MC 215E Special Clutch Replacement Parts and Repair Procedures
- B. MerCruiser Service Manual for Customers

A. MERCUISER 215E SPECIAL CLUTCH REPLACEMENT PARTS and REPAIR PROCEDURES

(Attach Bulletin Reference Sticker to PP 2G-4 & 5 and 6C-21 of Your Service Manual.)

SPECIAL CLUTCH REPLACEMENT PARTS LIST

These are new parts specifically designed to reduce clutch malfunctions which can result from corrosion under high moisture conditions.

Special Part No.	Description
B-52-66728A1	Pressure Plate
B-66527A1	Bearing Retainer and Throwout Bearing Assembly
C-92-66924-1	Special Silicone Lubricant (1 Oz.)

CLUTCH REPAIR PROCEDURES

NOTE: Refer to appropriate MerCruiser Service Manual Sections 2G and 6C for disassembly, reassembly, adjustment and installation procedures.

1. Disassemble clutch assembly and inspect clutch disc splines and universal joint end yoke splines. Clean with wire brush and solvent. Replace these parts if splines are severely rust-pitted.
2. Apply Special Silicone Lubricant (C-92-66924-1), as required, to each MerCruiser 215E clutch part. It is necessary to apply a thin, even coating on:
 - a. Clutch disc splines
 - b. Throwout bearing, shaft contact surfaces
 - c. Bearing retainer, bearing contact surface
 - d. Universal joint yoke splined end

IMPORTANT: To be effective, special Silicone Lubricant application instructions MUST BE followed. A soft-tooth brush is suggested for thorough coat of clutch plate and U-joint splines.

A small amount of lubricant will remain in the tube after proper application. It is to be used on the universal joint spline annually or when the universal joint cross bearings are lubricated with Universal Joint Lubricant (C-92-58229-1).

3. Reassemble clutch assembly and install shift actuator according to MerCruiser Service Manual procedure.

CAUTION: Do not connect red actuator lead to battery.

4. Rotate shift actuator safety clutch on output shaft manually into neutral, disengaging clutch disc.
5. Insert Clutch Alignment Tool (C-91-57795) to align clutch disc on flywheel.

(OVER)

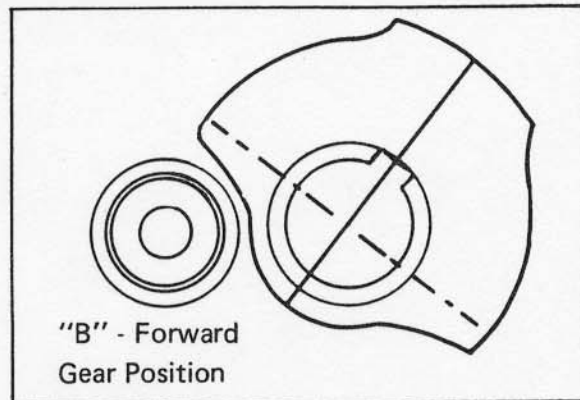
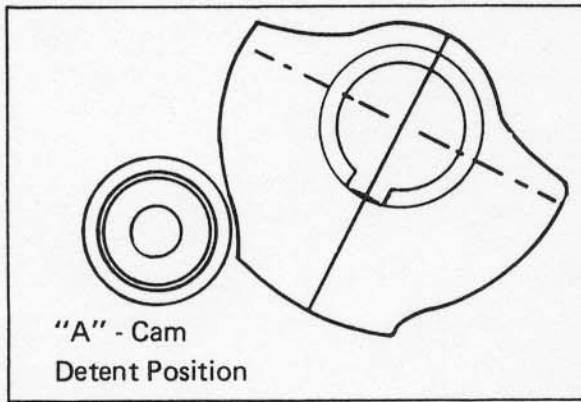
6. Rotate shift actuator safety clutch on output shaft manually into "Forward". This will hold clutch disc in its proper position. Remove clutch alignment tool and insert torquing tool (see "NOTE", immediately following).

NOTE: Fabricate a torquing tool from an unserviceable front "U" joint yoke by drilling and tapping the shaft centering hole for any short standard 3/16" to 3/8" bolt and secure in place with Loctite (C-92-32609-1). Or, order a Clutch Torquing Tool (C-91-68522).

7. Adjust clutch disc drag as follows:

NOTE: Clutch disc adjustment is necessary after reassembly to provide proper pressure plate drag before installing engine.

- a. Rotate shift actuator safety clutch on output shaft manually until clutch fork lever roller is in the cam detent position, as shown in "A" drawing, following.



- b. Use an inch/pound torque wrench on torquing tool. Rotate the clutch disc with torque wrench. Torque reading MUST BE 20 inch lbs. (23kg-cm) of clutch pressure plate drag. Loosen locknut on adjusting screw in clutch fork lever and turn adjusting screw in or out until 20 inch lbs. of torque is reached. Tighten locknut on adjusting screw.
 - c. Rotate shift actuator safety clutch manually into "Forward" gear position, as shown in "B" drawing above, to hold clutch disc and remove torquing tool.
8. Engine assembly is now ready for installation and alignment.
 9. Check stern drive shift mechanisms and repair as necessary.

B. MERCUISER SERVICE MANUAL for CUSTOMERS

(For Your Information)

A MerCruiser Service Manual (C-90-68648) is available to you to resell to customers who desire a personal service manual. This manual is complete and bound in a soft cover; however, it does not contain Service Bulletins, and the book is not updated by mailings of revised pages.

C-90-68648 MerCruiser Service Manual

(See Dealer "Master Price and Parts History Record" for Prices.)