



CIRCULATE TO:	SERVICE MGR.	PARTS MGR.	MECHANICS	Place in Your "Service Bulletins" Binder
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- A. MerCruiser 250, 228TR, 330TR and 330TRS Transom Assembly Exhaust Tube
- B. MerCruiser I Drive Reverse Lock
- C. MerCruiser V-8 Engine Power Steering Dimension Change

A. MERCRUISER 250, 228TR, 330TR and 330TRS TRANSOM ASSEMBLY EXHAUST TUBE

(Attach Bulletin Reference Sticker to P. 2C-8 of Your Service Manual.)

The above listed MerCruiser models in current production will have exhaust bellows replaced by new exhaust tubes. (See chart and Figure 1, following.)

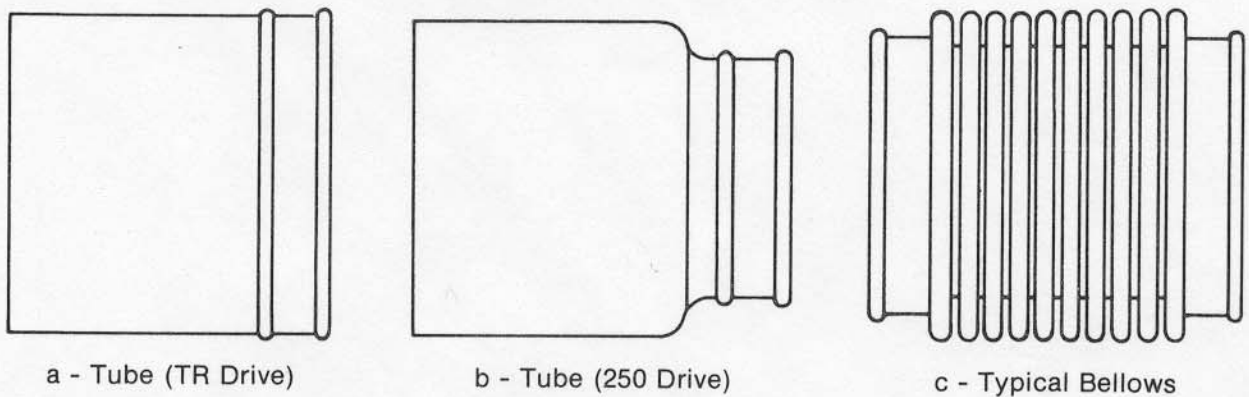


Figure 1. Bellows and Tube Identification

MerCruiser Model	Part Numbers	
	Bellows	Tube
250	B-32734	B-78458
TR and TRS	B-54406	B-78632

Some TR transom assemblies have been produced with exhaust bellows installed. These transom cartons are marked to be used with 228TR's only. When servicing these 228TR transom assemblies, bellows may be replaced by the tube B-78632. It is mandatory that the tube (B-78632) and NOT the bellows (B-54406) be used on transom assemblies for the 250 and 330TR & TRS models. This is an essential product improvement that will improve engine and reverse thrust performance in engines above 228 HP. The exhaust tube is attached to the gimbal housing only, NOT to the bell housing.

B. MERCRUISER I DRIVE REVERSE LOCK

(Attach Bulletin Reference Sticker to PP 2A-8 and 2B-10 of Your Service Manual.)

MerCruiser Models 120-140-165-470-898-228 and 250 transom assemblies, built after January 1, 1977, have the new Reverse Lock Valve (B-76812A4) installed.

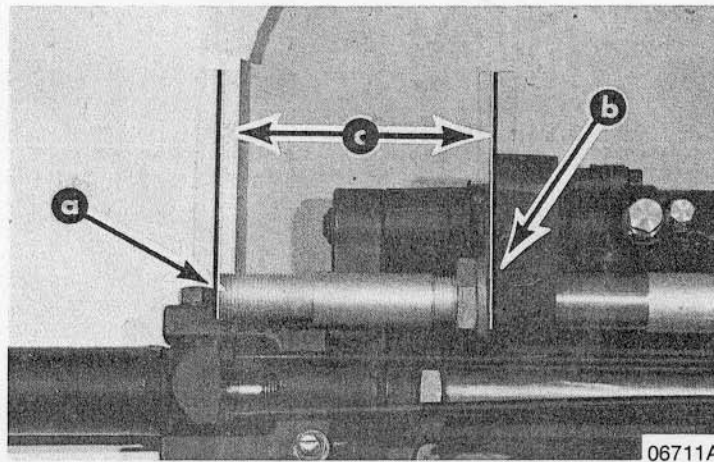
The new valve does not use a reverse interlock switch (B-46482A2); however, it does have a hydraulic bypass for Power Trim operation (when shifted into reverse gear) similar to the II-TR reverse lock assembly. Reverse lock valve adjustment (to keep drive unit from trailing out) is the same as the old style valve.

Old style valve assembly B-48165A5 is superseded by new valve assembly B-76813A4. The interlock switch will be discarded when service replacement is made. The Power Trim harness blue wire, however, must be rerouted from terminal block (located on trim pump) to trim solenoid. Refer to installation instructions which accompany reverse lock valve B-76813A4.

C. MERCURISER V-8 ENGINE POWER STEERING DIMENSION CHANGE

(Attach Bulletin Reference Sticker to P. 2C-9 of Your Service Manual.)

MerCruiser V-8 Engine Power Steering dimension (Figure 2) has been changed from $5\frac{1}{2}'' \pm \frac{1}{8}''$ to $6'' \pm \frac{1}{8}''$ ($13.97\text{cm} \pm 3.2\text{mm}$ to $15.24\text{cm} \pm 3.2\text{mm}$). This dimension change will affect the "MerCruiser 250 Stern Drive Installation Manual" (Page 5), "MerCruiser 228TR, 330TR and 330TRS Stern Drive Installation Manual" (Page 4) and "MerCruiser Service Manual" (Section 2 and Section 7). Make these changes in your manuals.



- a - Cable Guide Tube End
- b - Adaptor
- c - $6'' \pm \frac{1}{8}''$ ($15.24\text{cm} \pm 3.2\text{mm}$)

Figure 2. Power Steering Dimension