

NUMBER: 83-4

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MECHANICS
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A. ROLLER ROCKER ARM KIT - MCM 370

MCM 370 Power Packages and replacement partial engines, serial number 5670299 and above, will have roller rocker arms installed as standard equipment. (Serial Number is stamped into the front end of the cylinder block, near port cylinder head mating surface.)

A Roller Rocker Arm Kit is available from Hi-Performance Products. This kit has all the necessary parts and instruction sheet for the conversion on MCM 370 below Serial Number 5670299.

Roller Rocker Arm Kit 95820A1
Order from: Hi-Performance Products
2521 Bowen St.
Oshkosh, WI 54901
(414) 231-9180

B. VALVE ADJUSTMENT ON MCM 370 ENGINES EQUIPPED WITH ROLLER ROCKER ARMS

Valves must be adjusted when hydraulic lifter is on low part of camshaft.

1. Rotate engine (in normal direction of rotation) until timing mark on crankshaft balancer lines up with "0" (TDC) mark on timing tab and engine is in #1 firing position. This may be determined by placing fingers on #1 push rods as mark on balancer comes near the "0" (TDC) mark. If push rods move as timing mark comes up on "0", engine is in #6 firing position. Rotate crankshaft one more complete revolution to reach #1 firing position.

2.

⚠ CAUTION

**Make sure push rods are centered in sockets of rocker arm BEFORE tightening.
This must be done for each valve.**

To obtain correct valve lash, turn 9/16" locking nut down on rocker arm until there is zero clearance between rocker arm and valve stem. Turn locking nut an additional 1/2 turn and snug allen screw onto top of rocker arm stud. DO NOT let locking nut turn. Remove allen wrench and box wrench and torque locking nut to 30 lbs. ft. (41 N.m).

3. With engine crankshaft positioned as outlined in Step 1, adjust valves on the following cylinders:

Exhaust Valves

#1 - #3

#4 - #8

Intake Valves

#1 - #2

#5 - #7

4. Rotate crankshaft one complete (360°) revolution until timing mark on balancer is aligned with "0" mark on timing tab. Adjust valves on the following cylinders:

Exhaust Valves

#2 - #5

#6 - #7

Intake Valves

#3 - #4

#6 - #8

5. Use new gasket and reinstall valve rocker arm covers. Torque nuts to 50 lbs in. (5.6 N.m).

C. TUNE-UP SPECIFICATIONS FOR HI-PERFORMANCE STERN DRIVE (MCM) ENGINES - 400 CYCLONE AND 475 TURBO (CORRECTED)

The MCM 400 Cyclone and MCM 475 Turbo tune-up specifications are listed below. Disregard specifications in Service Bulletin 82-6.

**STERN DRIVE (MCM) HI-PERFORMANCE MODELS
TUNE-UP SPECIFICATION CHART**

MCM Model	Serial Number	Cu. In. Displacement	Spark Plugs			Plug Gap
			AC	Champion	Autolite	
400 Cyclone	All	454	MR43T	RBL8	144	.035" (.89mm)
475 Turbo	All	454	MR41T	BL3	143	.028" (.71mm)

Point Gap	Point Dwell	Timing	Fuel Pressure	Oil Pressure @ 2000 RPM	Idle RPM (in Gear)	WOT RPM
.016 - .019 (.41-.48mm)	28° 31°	10° BTDC	3-7 psi (21-48kPa)	30-70 psi (207-483 kPa)	800-850	4800-5200
.016 - .019 (.41-.48mm)	28° 31°	NOTE 1	3-7 psi (21-48kPa)	30-70 psi (207-483 kPa)	800-850	4800-5200

NOTE 1: 16° BTDC @ 900 RPM; 28° BTDC @ 3500 RPM. Timing must be checked at both RPM. If timing does not fall within limits, replace distributor. Order from Hi-Performance Products.