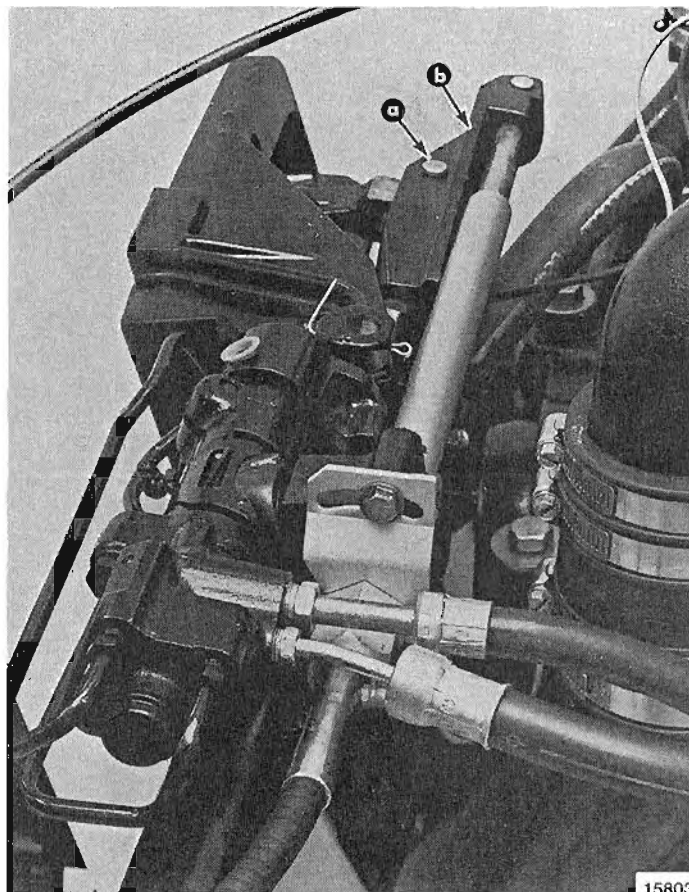


NUMBER: 84-5

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

**Subject: IMPROPER CLEVIS PIN INSTALLATION ON MERCUISER
120R-thru-260R MODELS WITH POWER STEERING**

It has come to our attention that the clevis pin, that secures the Power Steering unit end clevis to the steering lever, may have been installed incorrectly on some Power Packages. Clevis pin **MUST BE** installed with the head (shouldered end) upward (Figure 1), as indicated in the installation manuals. Installation of the clevis pin with the head downward could allow the pin to fall out if the cotter pin (securing clevis pin) should become detached.

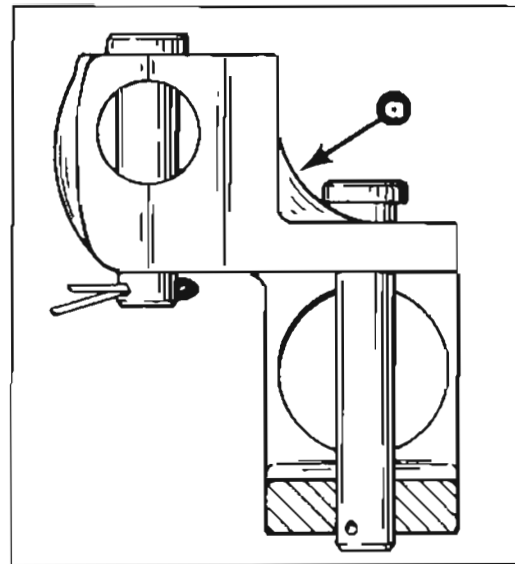


a - Clevis Pin
b - Power Steering End Clevis

Figure 1. Clevis Pin Properly Installed

Whenever you are servicing one of these models, inspect the clevis pin for proper installation. If you find one that is not installed correctly, reinstall pin properly, using a **NEW** cotter pin (18-46950). **BE SURE TO SPREAD BOTH ENDS OF PIN.**

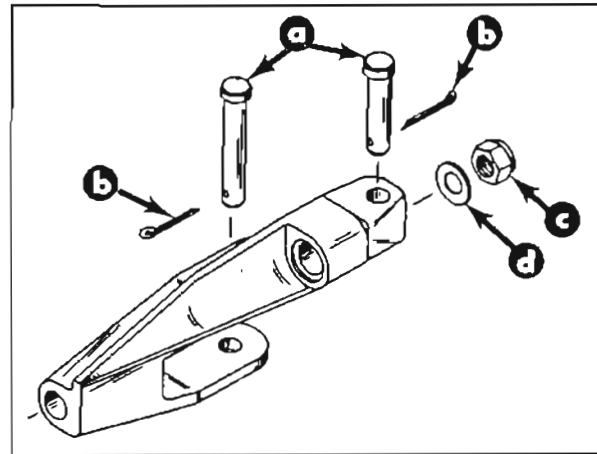
A number of Power Steering unit end clevises were manufactured that will not allow clevis pin to be installed with the head upward. (Figure 2) If you encounter one of these units, modify the clevis end to allow proper installation of pin, as explained following.



a - Casting Radius Will Not Allow Clevis Pin to Enter End Clevis Far Enough to Install Cotter Pin

Figure 2. Power Steering Unit End Clevis With Large Casting Radius

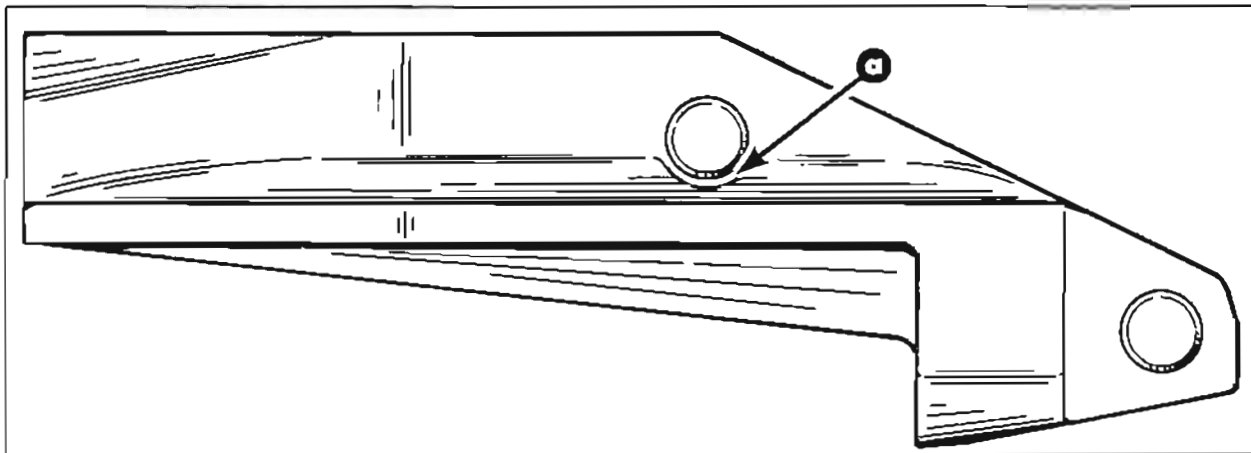
1. Remove end clevis from Power Steering unit piston rod. (Figure 3)



a - Clevis Pins
 b - Cotter Pin (2 Req'd)
 c - Nut (Clevis to Piston Rod)
 d - Washer

Figure 3. Clevis End Attaching Parts

2. Grind away casting radius (in area shown in Figure 4) to allow installation of clevis pin.



a - Grind Away Casting Radius In This Area Only

Figure 4. Grinding End Clevis End

3. Prime and paint modified area of clevis to inhibit corrosion.
4. Reinstall end clevis being sure to do the following:
 - Use new end clevis attaching nut (11-49197). Torque nut to 20-25 lbs. ft. (27-34 N.m).
 - Apply 2-4-C Multi-Lube to clevis pins before reinstalling.
 - Use 2 new cotter pins (18-46950) to secure clevis pins. BE SURE TO SPREAD BOTH ENDS OF COTTER PINS.