MERCURY Diesel

Service Bulletin

Bulletin No. 2013-70
OEM No. 2013-68

Circulate to: ☐ Sales Manager ☐ Accounting ☑ Service Manager ☑ Technician ☐ Parts Manager

Zeus Pod Interface Ring Inspection Criteria

Models Affected

Models Covered
All Zeus 3000 Series Pods

Scope

Worldwide

Situation

When inspecting the Zeus pod interface ring at the OEM or dealer level, the following criteria for visual inspection is provided. This information defines the physical and manufacturing characteristics of the bolted-in interface ring.

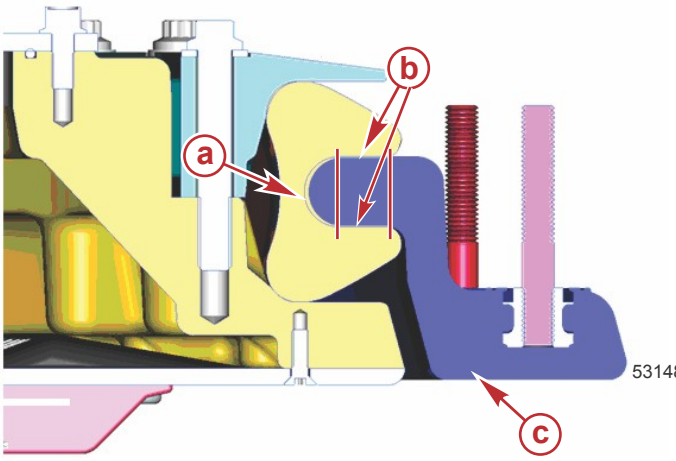
Part Number

Qty.	Description	Part Number
1	Interface ring assembly	8M8021167

Inspection

Sealing surfaces: As shown below, the grommet seals on the top and bottom surfaces of the interface ring when the clamp load is applied. The inside radius has clearance and does not provide any sealing benefits.

Surface imperfections: Surface imperfections are often noted on the interface ring inside edges of the bullnose radius due to the manufacturing cleanup and flash removal process. In addition, sealing surface imperfections may consist of craters or voids caused by the extreme high glass content and vinyl ester material.



View 1

- a - Bullnose inside radius
- b - Bullnose sealing surfaces approximately 15.2 mm (0.6 in.)
- c - Interface ring

Guidelines for Acceptable Interface Ring

Sealing surface visual inspection: Visually inspect the interface ring top and bottom sealing surfaces as shown in View 1 above. These areas should be free of any material flaws or defects that span across the entire surface. (Note that ejector pin marks are not considered flaws or defects.) Periodically there may be conditions on the ring surfaces which may have minor craters or voids which can be rough in appearance, caused by the extreme high glass content and vinyl ester material. As long as these blemishes are minor in depth and do not span across the entire sealing surface, these conditions will not affect the integrity of the part. Acceptable surface imperfections are shown in View 2 below.


54225

View 2

Inside radius visual inspection: Visually inspect the interface ring inside radius as shown previously in View 1. This area can have minor material nicks or flaws, due to the manufacturing cleanup and flash removal process. Acceptable flaws are shown in View 3 below.


53139

View 3

Acceptable interface ring: When field repair is being performed and any flaws similar to those shown above are noticed, there is no reason to replace the interface ring.

Uncertain if acceptable: If unsure, please take close-up pictures of suspect area and forward to Mercury Diesel Product Support for review.

Unacceptable Defect

Defect example: Here is an example of an unacceptable hairline crack of delamination which carries into the top sealing surface. This is an example of a manufacturing material layup defect which is not acceptable. If this type of defect is noticed anywhere on the ring including on the bolting flange and transition from bolting flange to bullnose, it should be deemed as unacceptable and be returned to Mercury Marine.

53141

View 4