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Power Steering Pump and Pulley Availability

NOTICE
Revised June 2018. This bulletin supersedes the previous bulletin number 2017-10 September 2017.

Scope

Worldwide

Models Affected

1.6 L, 4.5 L, 6.2 L, 8.2 L, and 496 Sterndrives with the following serial numbers:

Serial Number Table

Model	Serial Number
Sterndrive 1.6 L	All
Sterndrive 4.5 L	2A576202 and below
Sterndrive 6.2 L 300/350 HP Mercury V8	2A576202 and below
Sterndrive 8.2 L	2A575986 and below
Sterndrive 496	All

Situation

Mercury MerCruiser has resourced the power steering pumps and pulleys to a different supplier due to availability issues.

Correction

When ordering a replacement pump or pulley of the current design, you will be directed to see this bulletin to order the new replacement part number for your engine model shown in the following tables. The new pump shaft diameter is 16.89 mm (0.665 in.), whereas the older design pump shaft diameter was 19.05 mm (0.75 in.), so the pulley will have to be replaced on some models. The pulley is included in the kit in the following table. Follow the installation press depth specifications for the pulley as described in this bulletin, as the press depths have changed.

IMPORTANT: If 8M0110722 kit (pump and pulley) is used to replace the older design pump connected to a Compact Hydraulic Cylinder (CHS) the orifice in the power steering pump has to be changed using P/N 8M6003533.

Components Contained in Kit 8M0110722—For 4.5 L, 6.2 L, and 8.2 L Sterndrive Models

Qty.	Description	Part Number
1	Power steering pump	8M0110923
1	Power steering pulley	8M0111943
1	Orifice used to replace the older design pump connected to a Compact Hydraulic Cylinder (CHS)	8M6003533

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Components Contained in Kit 8M0135211—For 1.6 L and 496 Sterndrive Models

Qty.	Description	Part Number
1	Power steering pump	8M0135211

Installation

Power-Assisted Steering Pump Pulley—Removal

NOTE: The design of the power-assisted steering pump pulley may allow the pulley to be installed onto the pump prior to installing the pump onto the engine. Also, the power-assisted steering pump pulley may be removed and installed while the power-assisted steering pump assembly is mounted to the engine. Examine the engine-to-boat interface to determine the best method for your application.

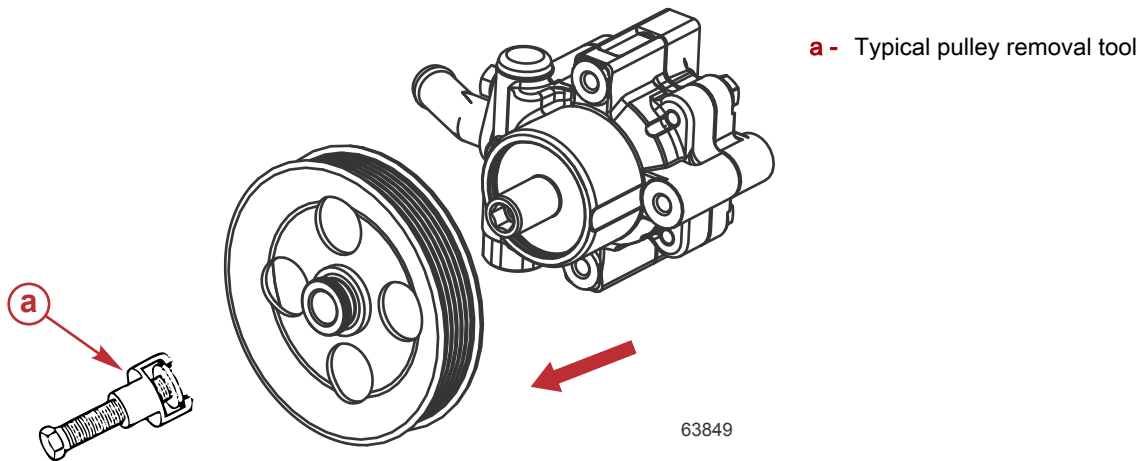
⚠ WARNING

Performing service or maintenance without first disconnecting the battery can cause product damage, personal injury, or death due to fire, explosion, electrical shock, or unexpected engine starting. Always disconnect the battery cables from the battery before maintaining, servicing, installing, or removing engine or drive components.

⚠ CAUTION

Disconnecting or connecting the battery cables in the incorrect order can cause injury from electrical shock or can damage the electrical system. Always disconnect the negative (-) battery cable first and connect it last.

- Starting with the negative (-) cable, disconnect both battery cables from the battery.
- Remove the serpentine belt. Refer to the appropriate service manual.
- Install the pulley removal tool onto the end of the power-assisted steering pulley and the shaft.



Power Steering Pump Pulley Remover	Kent-Moore Tools J-25034-C
<p>18598</p>	Removes the pulley on the power steering pump.


- While holding the pulley removal tool with a suitable wrench, turn the threaded bolt until the power-assisted steering pump pulley is removed.

Power-Assisted Steering Pump Pulley—Installation


Install the power-assisted steering pump pulley using the pulley pusher installer.

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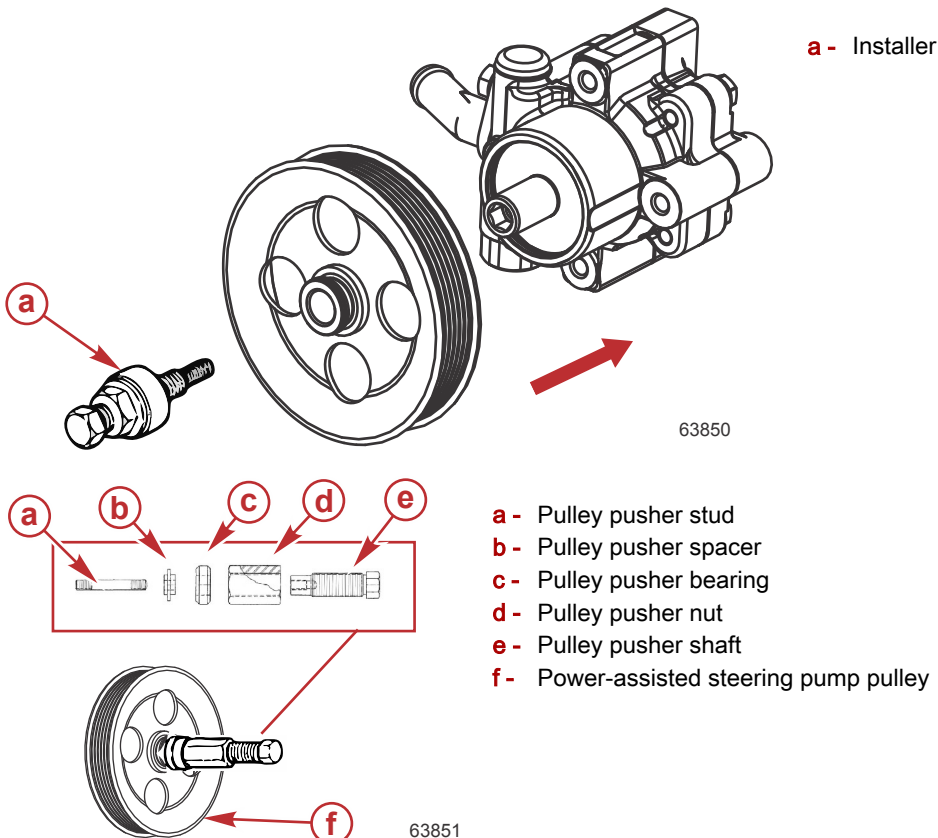
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Pulley Pusher Installer	91- 93656A 1
 <p style="text-align: center;">10047</p>	Installs the pulley onto the power steering pump.

- Lubricate the power-assisted steering pump shaft with Power Trim and Steering Fluid.

Tube Ref No.	Description	Where Used	Part No.
 114	Power Trim and Steering Fluid	Power-assisted steering pump shaft	92-858074K01

- Start the pulley onto the steering pump shaft.

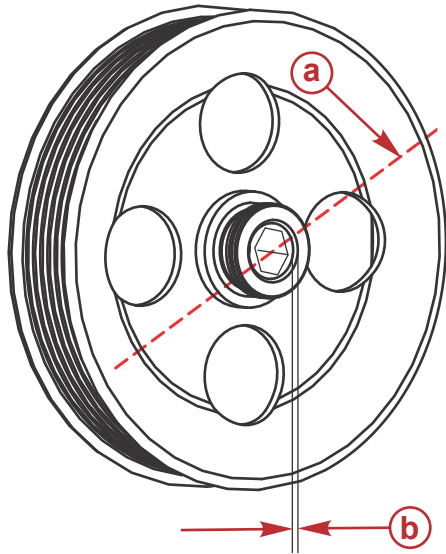


- Thread the stud from the pulley pusher completely into the power-assisted steering pump shaft.
 - Place the spacer onto the pulley.
 - Place the spacer and the bearing over the pulley pusher stud so that the spacer is against the pulley.
 - Thread the pulley pusher nut onto the pulley pusher shaft.
- NOTE:** The spacer is designed to keep the bearing centered on the tool.
- Thread the pulley pusher shaft and nut onto the pulley pusher stud (threaded into the power-assisted steering pump shaft).

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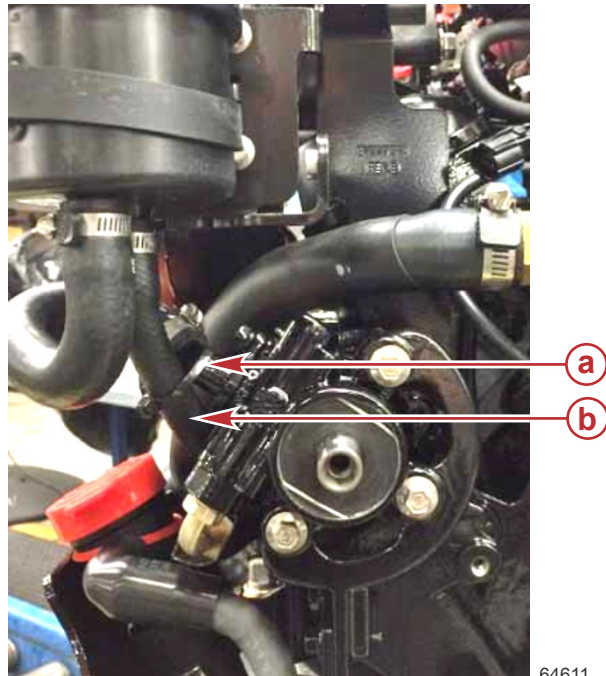
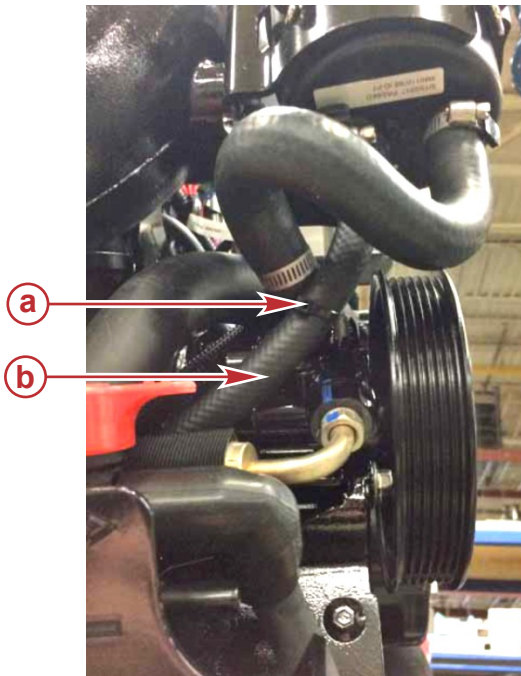
- f. Turn the pulley pusher nut until the face of the power-assisted steering pulley is 1.14–1.65 mm (0.045–0.065 in.) from the end of the shaft.



- a - Pulley hub face (straightedge)
- b - Pump shaft depth 1.14–1.65 mm (0.045–0.065 in.)

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- 3. Remove the tool and install the serpentine drive belt. Refer to the appropriate engine service manual.
- 4. **For 4.5/6.2 sterndrive models**—Install a cable tie to secure the power steering return hose to the power steering pump. This will ensure that the return hose will not contact the power steering pulley.




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- a - Cable tie
- b - Return hose

- 5. Starting with the positive (+) lead, connect the battery cables to their terminals.
- 6. Fill the power steering fluid reservoir with Power Trim and Steering Fluid.

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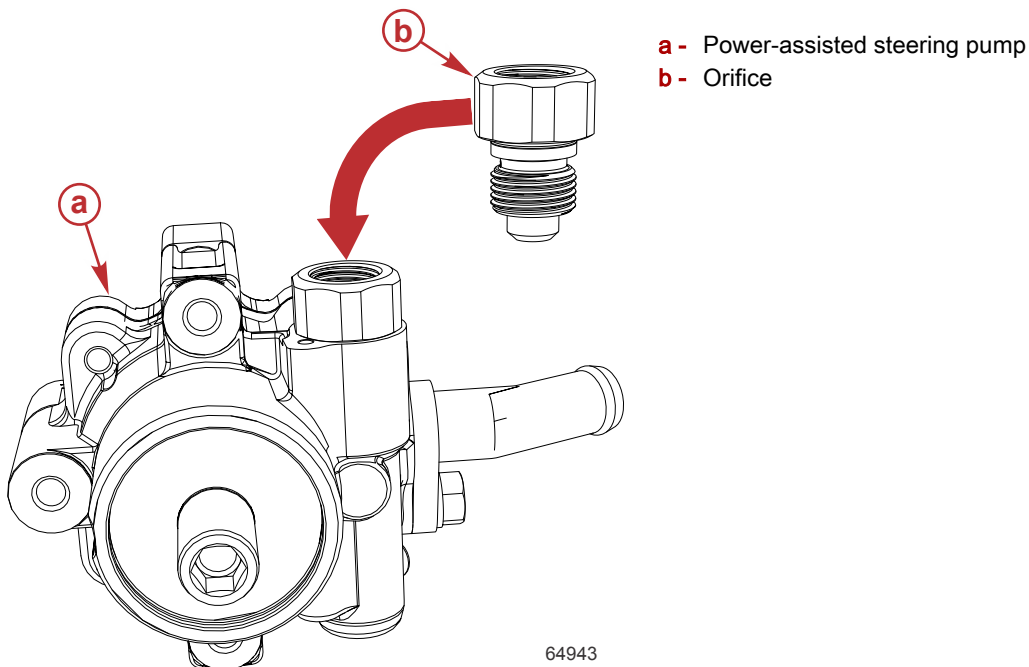
Tube Ref No.	Description	Where Used	Part No.
 114	Power Trim and Steering Fluid	Power steering fluid reservoir	92-858074K01

7. Start the engine.
8. Top off the power steering fluid reservoir and check for leaks.

Changing Orifice in the Power Steering Pump

IMPORTANT: If 8M0110722 kit (pump and pulley) is used to replace the older design pump connected to a Compact Hydraulic Cylinder (CHS) the orifice in the power steering pump has to be changed using P/N 8M6003533.

1. With power-assisted steering pump and pump pulley removed, refer to **Power-Assisted Steering Pump Pulley—Removal** and **Power-Assisted Steering Pump Pulley—Installation**.
2. Remove power-assisted steering pump orifice.



3. Install new orifice. Tighten to the specified torque.

Description	Nm	lb-in.	lb-ft
Orifice	54-63	-	40-47

4. Install the power-assisted steering pump pulley. Refer to **Power-Assisted Steering Pump Pulley—Installation**.

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