

TO: PARTS MANAGER   
SERVICE MANAGER

▲ = Revised February 24, 1993

**No. 91-5**

## A. Converting Cast Iron 3 in. (76mm) O.D. and 4 in. (102mm) O.D. Exhaust Elbow to Stainless Steel 4 in. (102mm) Exhaust Elbows

### MODELS

MCM V6 175, 185 (except 229 CID), 205, 4.3L and 4.3LX  
MCM V8 898, 200, 228, 230, 260, 350 Magnum Alpha, 5.0L, 5.0LX, 5.7L and 5.7L Bravo (1983 and Newer)  
MCM V8 330 (B-W) TR/TRS, 7.4L Bravo, 454 Magnum Alpha, 454 Magnum Bravo and 502 Magnum Bravo (1983 and Newer)  
MIE V8 230, 260, 340, 5.0L, 5.7L and 7.4L (1981 and Newer)

### CONVERSION

We could not possibly try this conversion on all older model engines. Because of this, you may have to make some slight modifications to hoses to make conversion fit. V6 262 CID engines with Closed Cooling System does not have any hoses that fit the S.S. elbows. The hoses listed are from the 5.0L/5.7L Closed Cooling System. Some slight modifications may have to be made to make hoses fit properly.

If MCM R or MR Stern Drive Engine has thru prop exhaust with 15°, 3 in. (76mm) O.D. exhaust elbows, as shown in Figure 1, order new collector pipe kit and elbow pipe from chart.

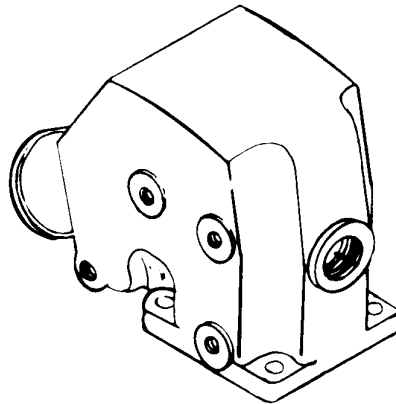


Figure 1.

Qty.		Part Numbers	Description
V6 262 CID	V8 305/350 CID		
1	1	44266A6	Exhaust Pipe Kit
2	0	14478T	Elbow
0	1	11086T	Elbow (Port)
0	1	14343T	Elbow (Stbd.)
If the engine has a 3 in. (76mm) Riser or a 6 in. (152mm) Riser between the Manifold and Exhaust Elbow, order one of the following also.			
1	0	14865A1	Exhaust Riser Installation Kit
0	1	14801A1	Exhaust Riser Installation Kit

If MCM 330 (B-W) TR/TRS Stern Drive Engine has thru prop exhaust with 15°, 3 in. (76mm) O.D. exhaust elbows, as shown in Figure 1, order new elbow pipes and bellows from chart. This is for models with the 10-17 series transmission. There is nothing available for the 10-18 series transmission.

Qty.	Part Number	Description
2	44391A1	Exhaust Pipe Kit
2	32-44348T	Tube, Exhaust
4	54-815504372	Clamp
If the engine has a 3 in. (76mm) Riser or a 6 in. (152mm) Riser between the Manifold and Exhaust Elbow, order one of the following also.		
2	32-62364A1	3 in. Exhaust Riser Installation Kit
2	32-59077A1	6 in. Exhaust Riser Installation Kit

If MCM V6 or V8 Stern Drive Engine has thru transom exhaust with 15°, 3 in. (76mm) O.D. exhaust elbows, as shown in Figure 1, other items might have to be ordered to match the thru transom Exhaust Tips. The reason for this is the Stainless Steel Exhaust Elbows are 7° with a 4 in. (102mm) O.D. Order as required.

Qty.	Part Number	Description
1	44349A1	Reducer Kit (4 in. to 3 in.)
1	93320A7	3 in. (76mm) Riser Kit
1	93322A5	6 in. (152mm) Riser Kit
2 (1)	17833A1	1-1/4 in. (32mm) Riser
1 (2)	12648A2	4 in. (102mm) O.D. Thru Transom Exhaust Kit

(1) Studs, Nuts, Washers and Gaskets for this 1-1/4 in. (32mm) Riser are listed with the respective engines.

(2) 4 in. (102mm) I.D. Exhaust Hose has to be purchased locally.

## ORDERING PARTS

Select the correct MCM Stern Drive Engine on the following pages and order the required parts to make the conversion from Cast Iron Exhaust Elbows to Stainless Steel Exhaust Elbows. MIE Inboard Engine parts lists follow the MCM Stern Drive Engine lists.

**MCM V6 262 CID (4.3L), V8 305 CID (5.0L)/350 CID (5.7L) Stern Drive Engine with Exhaust Elbows Mounted on Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow (Port)
1	1	1	816900A9	Exhaust Elbow (Stbd.)
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Shift Plate
6	6	6	12-35044	Washer - Ign. Module and Shift Plate Attaching
6	6	6	11-64015	Nuts - Ign. Module and Shift Plate Attaching
2 (1)	2 (1)	0	27-41813	Gaskets - Between Elbow and Manifold (Holes Fore and Aft)
0	0	2 (1)	27-41811	Gaskets - Between Elbow and Manifold
8 (1)	6 (1)	A or B	10-12244	Screws - 1 in. (25mm) Long, Elbow Attaching
0 (1)	2 (1)	A or B	10-66863	Screws - 2-1/2 in. (64mm) Long, Elbow/Filter Bracket Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
0	1	0	32-817435	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1 (2)	22-55133T	Tee Fitting
0	0	1 (2)	32-817437	Hose - Heat Exchanger to Tee Fitting
0	0	1 (2)	32-817439--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1 (2)	32-817440	Hose - Tee Fitting to Exhaust Elbow
(1) If engine has 1-1/4 in. (32mm) Riser between Exhaust Elbow and Manifold order the following instead.				
8	6	A or B	16-818595	Studs - 3 in. (76mm) Long, Elbow/Riser Attaching
0	2	A or B	16-97520	Studs - 5 in. (127mm) Long, Elbow/Riser/Bracket Attaching
8	8	8	12-46132	Washers - Elbow Attaching
8	8	8	11-46335	Nuts - Elbow Attaching
2	2	0	27-41813	Gasket - Between Riser and Elbow (Holes Fore and Aft)
2	2	0	27-818832	Gasket - Between Riser and Manifold
0	0	2	27-41811	Gasket - Between Riser and Manifold
0	0	2	27-818832	Gasket - Between Riser and Elbow

(2) 305 CID (5.0L)/350 CID (5.7L) Engines Only. If engine has Tee Fitting, for seawater discharge (from Heat Exchanger), threaded into starboard exhaust elbow, order these additional parts.

262 CID (4.3L) Engines: Must order these parts.

**MCM V6 262 CID (4.3L), V8 305 CID (5.0L)/350 CID (5.7L) Stern Drive Engine with 3 in. (76mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow (Port)
1	1	1	816900A9	Exhaust Elbow (Stbd.)
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Shift Plate
6	6	6	12-35044	Washers - Ign. Module and Shift Plate Attaching
6	6	6	11-64015	Nuts - Ign. Module and Shift Plate Attaching
2 (1)	2 (1)	0	27-818832	Gaskets - Between Riser and Manifold
2	2	0	27-41813	Gaskets - Between 3 in. Riser and Elbow (Holes Fore and Aft)
0	0	2 (1)	27-818832	Gaskets - Between 3 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between Riser and Manifold
8 (2)	6 (2)	A or B	16-97520	Studs - 5 in. (127mm) Long, Elbow/Riser Attaching
0	2 (2)	A or B	16-34713	Studs - 6-1/2 in. (165mm) Long, Elbow/Riser/Bracket Attaching
8	8	8	12-46132	Washers - Elbow/Riser Attaching
8	8	8	11-46335	Nuts - Elbow/Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
0	1	0	32-817435	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1 (3)	22-55133T	Tee Fitting
0	0	1 (3)	32-817437	Hose - Tee Fitting to Heat Exchanger
0	0	1 (3)	32-817439--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1 (3)	32-817440	Hose - Tee Fitting to Exhaust Elbow
If engine also has a 1-1/4 in. (32mm) Riser as well as a 3 in. (76mm) Riser, order:				
(1) The following gaskets to go between the two risers.				
(2) The following Stud Kit instead of studs listed before.				
2	2	2	27-818832	Gaskets
1	1	1	17833A5	Stud Kit

(3) 305 CID (5.0L)/350 CID (5.7L) Engines Only. If engine has Tee Fitting, for seawater discharge (from Heat Exchanger), threaded into starboard exhaust elbow, order these additional parts.

262 CID (4.3L) Engines: Must order these parts.

**MCM V6 262 CID (4.3L), V8 305 CID (5.0L)/350 CID (5.7L) Stern Drive Engine with 6 in. (152mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow (Port)
1	1	1	816900A9	Exhaust Elbow (Stbd.)
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Shift Plate
6	6	6	12-35044	Washers - Ign. Module and Shift Plate Attaching
6	6	6	11-64015	Nuts - Ign. Module and Shift Plate Attaching
2 (1)	2 (1)	0	27-818832	Gaskets - Between Riser and Manifold
2	2	0	27-41813	Gaskets - Between 6 in. Riser and Elbow (Holes Fore and Aft)
0	0	2 (1)	27-818832	Gaskets - Between 6 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between Riser and Manifold
8 (2)	6 (2)	A or B	16-49545	Studs - 1-3/4 in. (44mm) Long, Riser Attaching
0	2 (2)	A or B	16-52988	Studs - 3-1/4 in. (83mm) Long, Riser/Bracket Attaching
8	8	8	13-35048	Lockwashers - Riser Attaching
8	8	8	11-46335	Nuts - Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
8	8	8	10-12244	Screws - Elbow to 6 in. Riser Attaching
1	1	0	32-33220-70	Hose - Thermostat Housing to Elbow
0	0	1 (3)	22-55133T	Tee Fitting
0	0	1 (3)	32-817437	Hose - Tee Fitting to Heat Exchanger
0	0	1 (3)	32-817439--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1 (3)	32-817440	Hose - Tee Fitting to Exhaust Elbow
If engine also has a 1-1/4 in. (32mm) Riser as well as a 6 in. (152mm) Riser, order:				
(1) The following gaskets to go between the two risers.				
(2) The following Stud Kit instead of studs listed before.				
2	2	2	27-818832	Gaskets
1	1	1	17833A6	Stud Kit

(3) 305 CID (5.0L)/350 CID (5.7L) Engines Only. If engine has Tee Fitting, for seawater discharge (from Heat Exchanger), threaded into starboard exhaust elbow, order these additional parts.  
262 CID (4.3L) Engines: Must order these parts.

**MCM V8 454 CID (7.4L), 502 CID (8.2L) Stern Drive Engines [except 330 (B-W)  $\Delta$  and 370] with Exhaust Elbow Mounted on Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow (Port)
1	1	1	816900A9	Exhaust Elbow (Stbd.)
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Shift Plate
6	6	6	12-35044	Washers - Ign. Module and Plate Attaching
6	6	6	11-64015	Nuts - Ign. Module and Plate Attaching
2 (1)	2 (1)	0	27-41813	Gaskets - Between Elbow and Manifold (Holes Fore and Aft)
0	0	2 (1)	27-41811	Gaskets - Between Elbow and Manifold
8 (1)	6 (1)	A or B	10-12244	Screws - 1 in. (25mm) Long, Elbow Attaching
0	2 (1)	A or B	10-66863	Screws - 2-1/2 in. (64mm) Long, Elbow/Filter Bracket Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
0	1	0	32-817433	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow
(1) If engine has 1-1/4 in. (32mm) Riser between Exhaust Elbow and Manifold, order the following instead.				
8	6	A or B	16-818595	Studs - 3 in. (76mm) Long, Elbow/Riser Attaching
0	2	A or B	16-97520	Studs - 5 in. (127mm) Long, Elbow/Riser/Bracket Attaching
8	8	8	12-46132	Washers - Elbow Attaching
8	8	8	11-46335	Nuts - Elbow Attaching
2	2	0	27-41813	Gasket - Between Riser and Elbow (Holes Fore and Aft)
2	2	0	27-818832	Gasket - Between Riser and Manifold
0	0	2	27-41811	Gasket - Between Riser and Manifold
0	0	2	27-818832	Gasket - Between Riser and Elbow

$\Delta$  MCM 330 (B-W) TR/TRS: See MIE 454 CID (7.4L)

**MCM V8 454 CID (7.4L), 502 CID (8.2L) Stern Drive Engines [except 330 (B-W)  $\Delta$  and 370] with 3 in. (76mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow (Port)
1	1	1	816900A9	Exhaust Elbow (Stbd.)
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Shift Plate
6	6	6	12-35044	Washers - Ign. Module and Shift Plate Attaching
6	6	6	11-64015	Nuts - Ign. Module and Shift Plate Attaching
2 (1)	2 (1)	0	27-818832	Gaskets - Between Riser and Manifold
2	2	0	27-41813	Gaskets - Between 3 in. Riser and Elbow (Holes Fore and Aft)
0	0	2 (1)	27-818832	Gaskets - Between 3 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between Riser and Manifold
8 (2)	6 (2)	A or B	16-97520	Studs - 5 in. (127mm) Long, Elbow/Riser Attaching
0	2 (2)	A or B	16-34713	Studs - 6-1/2 in. (165mm) Long, Elbow/Riser/Bracket Attaching
8	8	8	12-46132	Washers - Elbow/Riser Attaching
8	8	8	11-46335	Nuts - Elbow/Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
0	1	0	32-817433	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow
If engine also has a 1-1/4 in. (32mm) Riser as well as a 3 in. (76mm) Riser, order:				
(1) The following gaskets to go between the two risers.				
(2) The following Stud Kit instead of studs listed before.				
2	2	2	27-818832	Gaskets
1	1	1	17833A5	Stud Kit

$\Delta$  MCM 330 (B-W) TR/TRS: See MIE 454 CID (7.4L)

**MCM V8 454 CID (7.4L), 502 CID (8.2L) Stern Drive Engines [except 330 (B-W)  $\Delta$  and 370] with 6 in. (152mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow (Port)
1	1	1	816900A9	Exhaust Elbow (Stbd.)
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Shift Plate
6	6	6	12-35044	Washers - Ign. Module and Shift Plate Attaching
6	6	6	11-64015	Nuts - Ign. Module and Shift Plate Attaching
2 (1)	2 (1)	0	27-818832	Gaskets - Between Riser and Manifold
2	2	0	27-41813	Gaskets - Between 6 in. Riser and Elbow (Holes Fore and Aft)
0	0	2	27-41811	Gaskets - Between Riser and Manifold
8 (2)	6 (2)	A or B	16-49545	Studs - 1-3/4 in. (44mm) Long, Riser Attaching
0	2 (2)	A or B	16-52988	Studs - 3-1/4 in. (83mm) Long, Riser/Bracket Attaching
8	8	8	13-35048	Lockwashers - Riser Attaching
8	8	8	11-46335	Nuts - Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
8	8	8	10-12244	Screws - Elbow to 6 in. Riser
1	1	0	32-33220-70	Hose - Thermostat Housing to Elbow
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow
If engine also has a 1-1/4 in. (32mm) Riser as well as a 6 in. (152mm) Riser, order:				
(1) The following gaskets to go between the two risers.				
(2) The following Stud Kit instead of studs listed before.				
2	2	2	27-818832	Gaskets
1	1	1	17833A6	Stud Kit

$\Delta$  MCM 330 (B-W) TR/TRS: See MIE 454 CID (7.4L)



**MIE V8 305 CID (5.0L), 350 CID (5.7L) Inboard Engine with Exhaust Elbow Mounted on Manifolds**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow
1	1	1	816900A7	Exhaust Elbow
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Electrical Bracket
6	6	6	12-35044	Washers - Ign. Module and Electrical Bracket Attaching
6	6	6	11-64015	Nuts - Ign. Module and Electrical Bracket Attaching
2	2	0	27-41813	Gaskets - Between Elbow and Manifold (Holes Fore and Aft )
0	0	2	27-41811	Gaskets - Between Elbow and Manifold
8	6	A or B	10-12244	Screws - 1 in. (25mm) Long, Elbow Attaching
0	2	A or B	10-66863	Screws - 2-1/2 in. (64mm) Long, Elbow Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
Required hoses for engines with elbows pointing toward transmission.				
0	1	0	32-817435	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1 (1)	32-817438--2	Hose - Tee Fitting to Exhaust Elbow
0	0	1 (1)	32-817439--2	Hose - Tee Fitting to Exhaust Elbow
(1) Engines with front mounted Heat Exchanger Only: If engine has Tee Fitting, for seawater discharge (from Heat Exchanger), threaded into starboard exhaust elbow, order these parts instead.				
0	0	1	22-55133T	Tee Fitting
0	0	1	32-817437	Hose - Heat Exchanger to Tee Fitting
0	0	1	32-817439--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817440	Hose - Tee Fitting to Exhaust Elbow
Required hoses for V-Drive engines with elbows pointing toward pulleys.				
2	2	0	32-817436	Hose - Thermostat Housing to Exhaust Elbows
0	0	1	32-817438--2	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--2	Hose - Tee Fitting to Exhaust Elbow

**MIE V8 305 CID (5.0L), 350 CID (5.7L) Inboard Engine with 3 in. (76mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow
1	1	1	816900A7	Exhaust Elbow
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Electrical Bracket
6	6	6	12-35044	Washers - Ign. Module and Electrical Bracket Attaching
6	6	6	11-64015	Nuts - Ign. Module and Electrical Bracket Attaching
2	2	0	27-818832	Gaskets - Between 3 in. Riser and Manifold
2	2	0	27-41813	Gaskets - Between 3 in. Riser and Elbow (Holes Fore and Aft )
0	0	2	27-818832	Gaskets - Between 3 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between 3 in. Riser and Manifold
8	6	A or B	16-97520	Studs - 5 in. (127mm) Long, Elbow/Riser Attaching
0	2	A or B	16-34713	Studs - 6-1/2 in. (165mm) Long, Elbow/Riser/Bracket Attaching
8	8	8	12-46132	Washers - Elbow/Riser Attaching
8	8	8	11-46335	Nuts - Elbow/Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
Required hoses for engines with elbows pointing toward transmission.				
0	1	0	32-817435	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1 (1)	32-817438--2	Hose - Tee Fitting to Exhaust Elbow
0	0	1 (1)	32-817439--2	Hose - Tee Fitting to Exhaust Elbow
(1) Engines with front mounted Heat Exchanger Only: If engine has Tee Fitting, for seawater discharge (from Heat Exchanger), threaded into starboard exhaust elbow, order these parts instead.				
0	0	1	22-55133T	Tee Fitting
0	0	1	32-817437	Hose - Heat Exchanger to Tee Fitting
0	0	1	32-817439--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817440	Hose - Tee Fitting to Exhaust Elbow
Required hoses for V-Drive engines with elbows pointing toward pulleys.				
2	2	0	32-817436	Hose - Thermostat Housing to Exhaust Elbows
0	0	1	32-817438--2	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--2	Hose - Tee Fitting to Exhaust Elbow

**MIE V8 305 CID (5.0L), 350 CID (5.7L) Inboard Engine with 6 in. (152mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow
1	1	1	816900A7	Exhaust Elbow
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Electrical Bracket
6	6	6	12-35044	Washers - Ign. Module and Electrical Bracket Attaching
6	6	6	11-64015	Nuts - Ign. Module and Electrical Bracket Attaching
2	2	0	27-818832	Gaskets - Between 6 in. Riser and Manifold
2	2	0	27-41813	Gaskets - Between 6 in. Riser and Elbow (Holes Fore and Aft )
0	0	2	27-818832	Gaskets - Between 6 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between 6 in. Riser and Manifold
8	6	A or B	16-49545	Studs - 1-3/4 in. (44mm) Long, Riser Attaching
0	2	A or B	16-52988	Studs - 3-1/4 in. (83mm) Long, Riser/Bracket Attaching
8	8	8	13-35048	Lockwasher - Riser Attaching
8	8	8	11-46335	Nuts - Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
8	8	8	10-12244	Screws - Elbow to 6 in. Riser Attaching
Required hoses for engines with elbows pointing toward transmission.				
1	1	0	32-33220-70	Hose - Thermostat Housing to Elbow
0	0	1 (1)	32-817438--2	Hose - Tee Fitting to Exhaust Elbow
0	0	1 (1)	32-817439--2	Hose - Tee Fitting to Exhaust Elbow
(1) Engines with front mounted Heat Exchanger Only: If engine has Tee Fitting, for seawater discharge (from Heat Exchanger), threaded into starboard exhaust elbow, order these parts instead.				
0	0	1	22-55133T	Tee Fitting
0	0	1	32-817437	Hose - Heat Exchanger to Tee Fitting
0	0	1	32-817439--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817440	Hose - Tee Fitting to Exhaust Elbow
Required hoses for V-Drive engines with elbows pointing toward pulleys.				
2	2	0	32-817436	Hose - Thermostat Housing to Exhaust Elbow
0	0	1	32-817438--2	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--2	Hose - Tee Fitting to Exhaust Elbow

**MIE 454 CID (7.4L) Inboard Engine and MCM 330 (B-W) TR/TRS Stern Drive Engine with Exhaust Elbow Mounted on Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow
1	1	1	816900A7	Exhaust Elbow ▲
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Electrical Bracket
6	6	6	12-35044	Washers - Ign. Module and Electrical Bracket Attaching
6	6	6	11-64015	Nuts - Ign. Module and Electrical Bracket Attaching
2	2	0	27-41813	Gaskets - Between Elbow and Manifold (Holes Fore and Aft )
0	0	2	27-41811	Gaskets - Between Elbow and Manifold
8	6	A or B	10-12244	Screws - 1 in. (25mm) Long, Elbow Attaching
0	2	A or B	10-66863	Screws - 2-1/2 in. (64mm) Long, Elbow/Filter Bracket Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
Required hoses for engines with elbows pointing toward transmission.				
0	1	0	32-817433	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow
Required hoses for V-Drive engines with elbows pointing toward pulleys.				
2	2	0	32-817434	Hoses - Thermostat Housing to Exhaust Elbows
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow

**MIE 454 CID (7.4L) Inboard Engine and MCM 330 (B-W) TR/TRS Stern Drive Engine with 3 in. (76mm) Risers Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow
1	1	1	816900A7	Exhaust Elbow
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Electrical Bracket
6	6	6	12-35044	Washers - Ign. Module and Electrical Bracket Attaching
6	6	6	11-64015	Nuts - Ign. Module and Electrical Bracket Attaching
2	2	0	27-818832	Gaskets - Between 3 in. Riser and Manifold
2	2	0	27-41813	Gaskets - Between 3 in. Riser and Elbow (Holes Fore and Aft )
0	0	2	27-818832	Gaskets - Between 3 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between 3 in. Riser and Manifold
8	6	A or B	16-97520	Studs - 5 in. (127mm) Long, Elbow/Riser Attaching
0	2	A or B	16-34713	Studs - 6-1/2 in. (165mm) Long, Elbow/Riser/Bracket Attaching
8	8	8	12-46132	Washers - Elbow/Riser Attaching
8	8	8	11-46335	Nuts - Elbow/Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
Required hoses for engines with elbows pointing toward transmission.				
0	1	0	32-817433	Hose - Thermostat Housing to Elbow with Oil Filter
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow
Required hoses for V-Drive engines with elbows pointing toward pulleys.				
2	2	0	32-817434	Hoses - Thermostat Housing to Exhaust Elbow
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow

**MIE 454 CID (7.4L) Inboard Engine and MCM 330 (B-W) TR/TRS Stern Drive Engine with 6 in. (152mm) Riser Between Exhaust Elbow and Manifold**

A = Engines without Remote Oil Filter Bracket on exhaust elbow.

B = Engines with Remote Oil Filter Bracket on exhaust elbow.

C = Engines with Closed Cooling System.

Qty.			Part Numbers	Description
A	B	C		
1	1	1	816900A5	Exhaust Elbow
1	1	1	816900A7	Exhaust Elbow
6	6	6	23-92152	Spacers - Between Elbow and Ign. Module and Electrical Bracket
6	6	6	12-35044	Washers - Ign. Module and Electrical Bracket Attaching
6	6	6	11-64015	Nuts - Ign. Module and Electrical Bracket Attaching
2	2	0	27-818832	Gaskets - Between 6 in. Riser and Manifold
2	2	0	27-41813	Gaskets - Between 6 in. Riser and Elbow (Holes Fore and Aft )
0	0	2	27-818832	Gaskets - Between 6 in. Riser and Elbow
0	0	2	27-41811	Gaskets - Between 6 in. Riser and Manifold
8	6	A or B	16-49545	Studs - 1-3/4 in. (44mm) Long, Riser Attaching
0	2	A or B	16-52988	Studs - 3-1/4 in. (83mm) Long, Riser/Bracket Attaching
8	8	8	13-35048	Lockwasher - Riser Attaching
8	8	8	11-46335	Nuts - Riser Attaching
0	1	A or B	817403A2	Bracket - Oil Filter
8	8	8	10-12244	Screws - Elbow to 6 in. Riser Attaching
Required hoses for engines with elbows pointing toward transmission.				
1	1	0	32-33220-70	Hose - Thermostat Housing to Elbow
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439--3	Hose - Tee Fitting to Exhaust Elbow
Required hoses for V-Drive engines with elbows pointing toward pulleys.				
2	2	0	32-817434	Hoses - Thermostat Housing to Exhaust Elbow
0	0	1	32-817438--1	Hose - Tee Fitting to Exhaust Elbow
0	0	1	32-817439 --3	Hose - Tee Fitting to Exhaust Elbow