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PRODUCT INTRODUCTION

Save time and money by using a longblock, cylinder head, driveshaft housing, gear housing assembly or Plus Series engine from Quicksilver Remanufacturing. Get your Customers back on the water faster with the assurance of a Quicksilver factory-backed limited warranty. Quicksilver Remanufacturing offers a tremendous value to you and your customers with our products and services that stand unique in the marine industry for good reason:

- ✓ The only Marine OEM who remanufactures
- ✓ Factory Warranty and Service Support
- ✓ Product available at 3,000+ Mercury and MerCruiser Dealers

The growth of Quicksilver Remanufacturing continues as the marine service industry realizes the benefits of utilizing quality remanufactured products from Mercury Marine. Quicksilver Remanufacturing continues to expand our family of products and Dealers will find even more ways to save money and time. We'll continue to look for products that offer the quality, durability and dependability that Dealers expect from Mercury Marine.

Another significant advantage to products from Quicksilver Remanufacturing is the **One-Year Factory Warranty** that includes parts and labor.

MERCRUISER STERNDRIVE AND INBOARD PRODUCTS:

- Plus-Series Engines
- Accessory kits for PLUS-Series Engines
- Engine Headers
- Racing series Longblock Engines
- Pro-Series Longblock Engines
- New Longblock Engines
- Cylinder Head Assemblies (Remanufactured)
- Sterndrive Assemblies – Transoms – Inboard Transmissions (New)
- Driveshaft -and gear housing assemblies (Remanufactured)

Visit us at www.mercurymercruiser.com or via **Extranet** for inventory, special promotions, seasonal programs and much more!

WARRANTY STATEMENT

ONE YEAR STANDARD LIMITED WARRANTY STATEMENT

Quicksilver Remanufacturing Products and Accessories Limited Warranty Europe, Middle-East and Africa

- A. **Mercury Marine** warrants each Remanufactured product and or accessory (not those made for high performance purposes) manufactured or sold by it to be free from defects in material and workmanship; but only when the consumer sale is made in the country to which distribution is authorized by us, and then only after the pre-delivery inspection process specified by **Mercury Marine** is completed and documented.
- B. The warranty shall remain in effect for a period of one year from the date of retail purchase.
- C. This warranty does not cover normally worn parts, adjustments, tune-ups, or damage caused by:
1) Neglect, lack of maintenance, accident, abnormal operation or improper installation or service;
2) Use of any product or accessory not manufactured or sold by us; 3) Operation with fuels, oil or lubricants which are not suitable for use with the products or accessories; 4) Participating in or preparing for racing or other competitive activity or operating with a racing type or modified lower unit; 5) Water entering engine cylinder(s) through exhaust system, carburetion, or fuel injection system; 6) Failure or damage caused by fuel deterioration or phase separation, fuel formulation, contamination, varnishing, or gumming.
- D. Our obligation under the warranty is limited to repairing a defective part, or refunding purchase price, or at our option replacing such part or parts with either new or **Mercury** factory certified remanufactured parts as shall be necessary to remedy defects in materials or workmanship as covered by this warranty. The repair or replacement of parts, or the performance of service, under this warranty, does not extend the period of this warranty beyond its original expiration date. We reserve the right to improve the design of any **Quicksilver Remanufacturing** product or accessory without assuming any obligation to modify any *Mercury* product or accessory previously remanufactured.
- E. Claims shall be made under this warranty by delivering the product or accessory for inspection to a Mercury Marine dealer authorized to service the product. If purchaser cannot deliver product or accessory to such authorized dealer, he may give notice in writing to the company. We shall then arrange for the inspection and repair, provided such service is covered under this warranty. Purchaser shall pay for all related transportation charges and/or travel time. If the service is not covered by this warranty, purchaser shall pay for all related labor and materials, and any other expenses associated with that service. Any product or accessory shipped by purchaser for inspection or repair must be shipped with transportation charges prepaid. The purchaser must provide a valid invoice listing the product and/or accessory showing date of purchase from one of Mercury Marine's authorized dealers.
- F. Reasonable access must be provided to the product for warranty service. This warranty will not apply to: 1) Haul-out, launch, towing and storage charges; telephone or rental charges of any type, inconvenience, or loss of time or income; or other consequential damages; or 2) Removal and/or replacement of boat partitions or material because boat design for necessary access to the product.
- G. Parts which, upon inspection, have been found to be not failed or not required to complete repairs, or were replaced without proper authorization will be returned.

THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS ARE EXPRESSLY DISCLAIMED TO THE FULLEST EXTENT PERMITTED BY LAW. TO THE EXTENT THAT THEY CANNOT BE DISCLAIMED, THE IMPLIED WARRANTIES ARE LIMITED IN DURATION TO THE LIFE OF THE **Quicksilver Remanufacturing** LIMITED WARRANTIES. ALL INCIDENTAL AND CONSEQUENTIAL DAMAGES ARE EXCLUDED FROM COVERAGE UNDER THIS WARRANTY.

WARRANTY PROCEDURE

Limited Warranty Procedure

- For limited warranty work and fulfillment, customers are encouraged to contact their selling dealer or nearest authorized Mercury Service dealer concerning any product issues due to material or workmanship
- Registration, Retail Invoice & Pre-Delivery Inspection (PDI) forms
 - These documents are required for fulfillment of the limited warranty
 - Serialized products must be registered
 - Copies of the original invoice and PDI forms are acceptable as hardcopy, by fax, or in an electronic format
 - A proof of limited warranty statement offers the reminder that the invoice and PDI form are the required for limited warranty, but by itself does not fulfill these requirements
- Transfer of Coverage – The original retail invoice and PDI form are required for fulfillment of the limited warranty. Unexpired warranty coverage can be transferred from one recreational use customer to a subsequent recreational use customer with a copy of the original invoice and PDI form.
- If a product return is in order, the following should accompany any and all product returns to help provide timely processing of warranty claims:
 - A copy of the retail invoice
 - A copy of the PDI form
 - Warranty claim
- For product returns, all parts should be returned for full credit

ELIGIBILITY FOR LIMITED WARRANTY

Eligibility for Limited Warranty

IMPORTANT: When replacing a longblock, the following requirements must be met in order to ensure eligibility for the Mercury/Quicksilver Remanufacturing Limited Warranty.

- ☐ If the engine is equipped with an oil cooler, the oil cooler must be replaced in order to prevent the probability of a premature internal engine failure.
NOTE: If the cooler is not replaced, the longblock will not be eligible for warranty consideration. If an internal engine failure should occur that is eligible for warranty consideration, a copy of the invoice indicating the purchase of an original type OEM oil cooler is required.
- ☐ All oil lines and oil filter adapters must be flushed with a clean solvent to eliminate the probability of bearing damage to the engine.
- ☐ Clean the intake manifold induction runners to ensure that they are free of debris.
- ☐ Replace or clean fuel system components (carburetor or injectors) to ensure proper operation. Verify fuel system pressures to ensure proper flow.
- ☐ Clean cooling system component passages to ensure that they are free of pieces of seawater pump impellers and other types of debris. Verify the condition of the thermostat housing, and install a new thermostat.
- ☐ Inspect exhaust system components.
 - Disassemble manifolds, risers, and elbows to ensure that gasket surfaces are flat and sealable.
 - Leak-test manifolds for internal leaks.
 - Use new gaskets in reassembly.
 - Verify the integrity of exhaust shutters for sterndrive applications.
- ☐ In the dress assembly process of a longblock, use new gaskets and o-rings as required.
- ☐ Refer to the appropriate Mercury MerCruiser Service Manual for proper assembly instructions and torque specifications.
- ☐ When replacing a transmission, the transmission oil cooler must also be replaced in order to prevent the probability of a premature transmission failure.
NOTE: A copy of the invoice for an oil cooler or transmission/cooler assembly is required for warranty authorization for the transmission. If the cooler has not been replaced, the transmission will not be eligible for warranty consideration.
- ☐ Prime the engine's oiling system before installing the distributor. Refer to **Oil System Priming for Remanufactured Engines and Longblocks**.
- ☐ Before installing the engine in the boat:
 - Connect the engine to a water supply, battery power, fuel, and 3-ft exhaust hoses (connected to the exhaust elbows).
 - Start the engine; verify oil pressure and ignition timing; examine for fuel, oil, and water leaks; and inspect for loose components.
 - Verify the engine is ready to be installed in the boat.
- ☐ After the engine is fully installed in the boat, complete the Predelivery Inspection worksheet and place a copy in the customer file and another with the invoice.
NOTE: The Predelivery Inspection worksheet is required for warranty authorization.

PREDELIVERY CHECK LIST

PREDELIVERY INSPECTION—REPOWER

Predelivery Inspection Checklist

Not Applicable	Check / Adjust	Task	Not Applicable	Check / Adjust	Task
Check Before Running:			On-Water Testing:		
<input type="checkbox"/>	<input type="checkbox"/>	Drain plug in and petcocks closed	<input type="checkbox"/>	<input type="checkbox"/>	Engine alignment (inboards only)
<input type="checkbox"/>	<input type="checkbox"/>	Seawater inlet valve open	<input type="checkbox"/>	<input type="checkbox"/>	Starter neutral safety switch operation
<input type="checkbox"/>	<input type="checkbox"/>	Engine mounts tight	<input type="checkbox"/>	<input type="checkbox"/>	Water pump operation
<input type="checkbox"/>	<input type="checkbox"/>	Engine alignment	<input type="checkbox"/>	<input type="checkbox"/>	Instruments operation
<input type="checkbox"/>	<input type="checkbox"/>	Drive unit fasteners torqued	<input type="checkbox"/>	<input type="checkbox"/>	Fuel leaks
<input type="checkbox"/>	<input type="checkbox"/>	Power trim cylinders fasteners tight	<input type="checkbox"/>	<input type="checkbox"/>	Oil leaks
<input type="checkbox"/>	<input type="checkbox"/>	Battery fully charged and secured	<input type="checkbox"/>	<input type="checkbox"/>	Water leaks
<input type="checkbox"/>	<input type="checkbox"/>	All electrical connections tight	<input type="checkbox"/>	<input type="checkbox"/>	Exhaust leaks
<input type="checkbox"/>	<input type="checkbox"/>	Exhaust system hose clamps tight	<input type="checkbox"/>	<input type="checkbox"/>	Ignition timing
<input type="checkbox"/>	<input type="checkbox"/>	All fuel connections tight	<input type="checkbox"/>	<input type="checkbox"/>	Idle _____ RPM, within specifications
<input type="checkbox"/>	<input type="checkbox"/>	Correct rotation propeller (installed and torqued)	<input type="checkbox"/>	<input type="checkbox"/>	Forward - Neutral - Reverse gear operation
<input type="checkbox"/>	<input type="checkbox"/>	Throttle, shift and steering system fasteners tightened properly	<input type="checkbox"/>	<input type="checkbox"/>	Steering operation throughout range
<input type="checkbox"/>	<input type="checkbox"/>	Throttle plates open and close completely	<input type="checkbox"/>	<input type="checkbox"/>	Acceleration from idle RPM
<input type="checkbox"/>	<input type="checkbox"/>	Crankcase oil level	<input type="checkbox"/>	<input type="checkbox"/>	WOT _____ RPM within specifications (in forward gear)
<input type="checkbox"/>	<input type="checkbox"/>	Power trim oil level	<input type="checkbox"/>	<input type="checkbox"/>	Power trim operation
<input type="checkbox"/>	<input type="checkbox"/>	Sterndrive unit oil level	<input type="checkbox"/>	<input type="checkbox"/>	Trim tab adjustment/Boat handling
<input type="checkbox"/>	<input type="checkbox"/>	Power steering fluid level	After On-Water Testing:		
<input type="checkbox"/>	<input type="checkbox"/>	Closed cooling level	<input type="checkbox"/>	<input type="checkbox"/>	Propeller nut torque
<input type="checkbox"/>	<input type="checkbox"/>	Transmission fluid level	<input type="checkbox"/>	<input type="checkbox"/>	Fuel, oil, coolant, water, and fluid leaks
<input type="checkbox"/>	<input type="checkbox"/>	Alternator belt tension	<input type="checkbox"/>	<input type="checkbox"/>	Oil and fluid levels
<input type="checkbox"/>	<input type="checkbox"/>	Seawater pickup pump belt tension	<input type="checkbox"/>	<input type="checkbox"/>	Apply Quicksilver Corrosion Guard to engine package
<input type="checkbox"/>	<input type="checkbox"/>	Power assisted steering pump belt tension	<input type="checkbox"/>	<input type="checkbox"/>	Verify presence of operation and maintenance manual
<input type="checkbox"/>	<input type="checkbox"/>	Audio warning system operation	For boats registered to residents of California:		
			<input type="checkbox"/>	<input type="checkbox"/>	CARB hang tag in boat
			<input type="checkbox"/>	<input type="checkbox"/>	CARB decal properly affixed to boat hull

Notes:

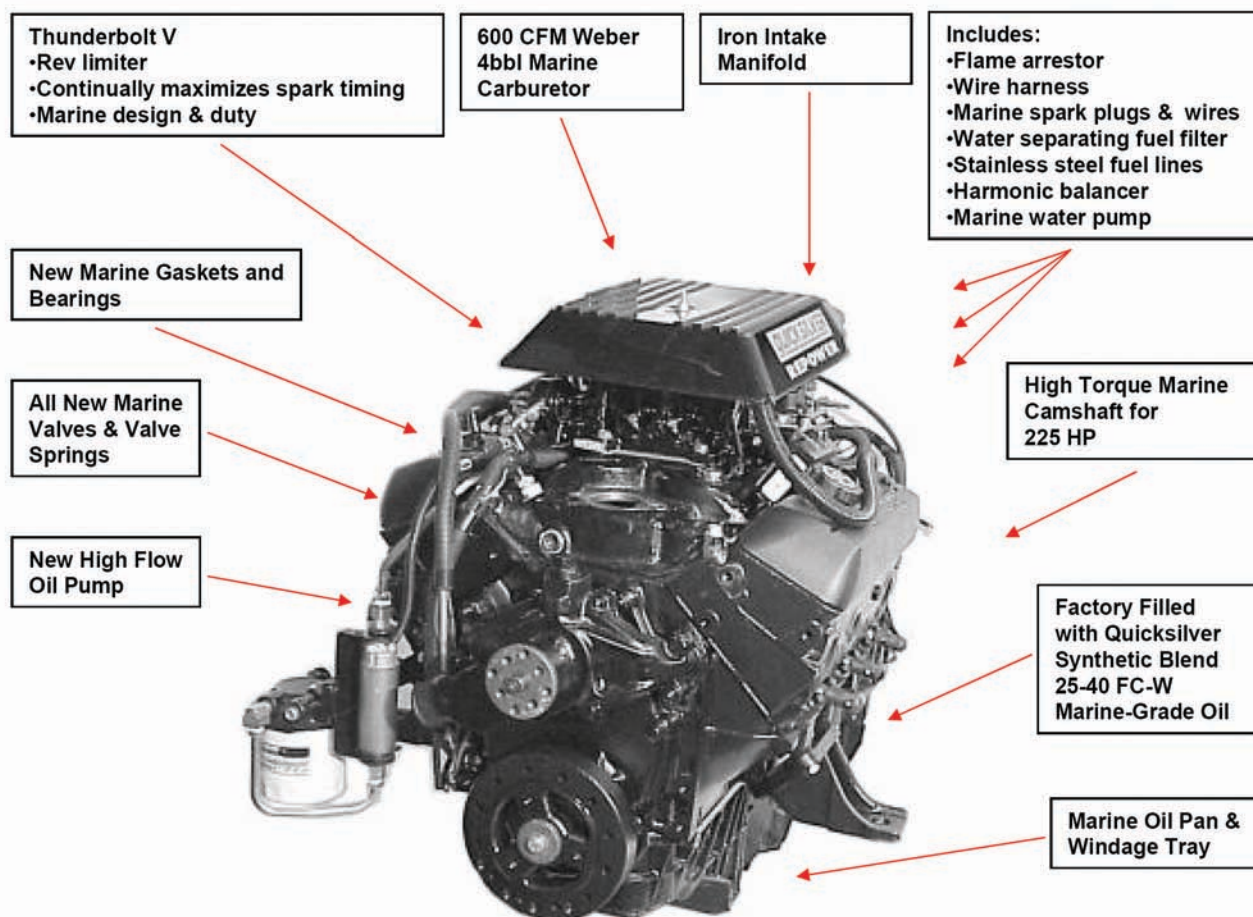
PLUS SERIES ENGINES - PARTIALLY DRESSED ENGINE FEATURES

QUICKSILVER®

Remanufacturing

4.3L Gen+ (V6) Partially dressed Engine

- Remanufactured to offer the best repower value
- Ultimate in flexibility
- 225 HP
- 1 Year Limited Factory Warranty
- Fits any brand not just MerCruiser



PLUS SERIES ENGINES

PLUS SERIES ENGINES

QUICKSILVER[®]

Remanufacturing

Plus-Series Engines

- Remanufactured to offer the best repower value
- Many new Marine parts included
- 1 Year Limited Factory Warranty
- 100% Hot tested & pressure checked for quality

All New Stainless Steel
Valves & Marine Valve
Springs

Custom Flame Cover

CNC machined
Remanufactured
GM Vortec Marine Block
•Line Bored Cam & Mains
•Max 0.040" CNC Overbore
•CNC Honed
•CNC Deck Machining

383 use 1.6:1
Full Roller
Rocker Arms

Hypereutectic
Pistons –
Stronger than
Cast Pistons

New Marine
Water Pump

Complete
Accessory
Drive System
Included

Some Blocks
Machined for
Mechanical
Fuel Pump

383 uses 4340 Forged Crank,
Others use Nodular Iron

Marine Oil Pan & Windage Tray



Marine Duty
Cylinder Heads

Hardened
Valve Seats

New Marine
Spark Plugs

Factory Filled with
Quicksilver 25-40
FC-W Marine-
Grade Oil

Exclusive
357 & 383 Camshaft
Profiles

New High Flow
Oil Pump ----
383 use 100 psi
Oil Pump

Exhaust System
Includes Intermediate
Pipes –
No Y-pipes Included

PLUS-SERIES ENGINES

The PLUS-SERIES line from Quicksilver Remanufacturing is made up of unique engines that offer value performance for your next repower. Based on our popular MerCruiser products, these are fully remanufactured engines that are fitted with marine-grade performance valve train, pistons, induction system and (in some cases) marine headers to deliver factory reliability at an affordable price.

Each PLUS-SERIES engine is "Hot Tested" by supplying fuel and coolant so technicians can perform a series of live-running tests for quality assurance. All PLUS-SERIES engines are completely remanufactured and include exhaust manifolds, fuel, electrical and ignition systems so they are ready to rig into a boat.

PLUS-SERIES engines from Quicksilver Remanufacturing come with a One-Year Factory Limited Warranty.

CONSIDERATIONS FOR THE 4.3L PARTIALLY DRESSED ENGINE:

- To avoid the expense of a fully-dressed complete engine, the following items (if in good condition) need to be transferred from the original engine over to the replacement engine: exhaust manifolds, risers, starter motor, alternator, pulleys hoses and belts.
- Installing a partially dressed engine into a 1981 or earlier application would not be recommended. Due to the shift bracket that contains a reverse lock mechanism, it would be extremely difficult and expensive to accomplish this upgrade.

4.3L GEN+ / PARTIALLY DRESSED ENGINE

4.3L GEN+ ENGINE ONLY



807736R51

225 HP @ 4800 RPM - Standard / Left-Hand Rotation - Remanufactured 4.3L Partially Dressed Marine Engine Assembly. Features Include: New 600 cfm 4bbl Carburetor, Electric Fuel Pump, Nodular Iron Crankshaft, Roller Camshaft, Vortec Cast Iron Cylinder Heads, Stainless Steel Valves, 9.4:1 Hypereutectic Pistons, Full Roller Rocker Arms and Thunderbolt V Ignition. Includes: Flame Arrestor, Harmonic Balancer, Oil Pan, 10-Pin Harness, Water Pump, Spark Plugs and Wires. Runs on 86 Octane Fuel.

This Remanufactured Crate Engine is a universal power upgrade for V6 MerCruiser Alpha Sterndrive Applications and adaptable to other brands of sterndrives regardless of make.

350 MPI ALPHA - ENGINE ONLY

350 MPI ALPHA - ENGINE ONLY



8M0064799

350 MPI Alpha Sterndrive Engine Only. 300 HP @ 5000 RPM, 355 Cubic Inch Fully Dressed Marine Engine. Engine Features: Special Flame Graphics, Multi-Port Fuel Injection Using Cool Fuel II, Dry Joint Exhaust, Nodular Iron Crankshaft, Roller Camshaft, Vortec Cast Iron Cylinder Heads, Stainless Steel Valves, 9.4:1 Hypereutectic Pistons. It uses ECM 555 with Engine Guardian and is SmartCraft ready, 10-Pin Harness. Runs on 87 Octane Fuel.

NOTE: If used with an Alpha One (GEN II) drive, this engine requires a Seawater pump kit 46-807151A5 (sold separately) for proper cooling.

300 HP Remanufactured Sterndrive Engine.

Replaces 5.0L, 5.0L EFI/MPI, 5.7L, 5.7L EFI/MPI and 350 Mag MPI sterndrive engines.

PLUS-SERIES ENGINES

8.1L HORIZON - ENGINE ONLY

8.1L HORIZON - V-DRIVE ENGINE ONLY



8M0052317

8.1L Horizon - V-Drive Engine Only. 370 HP @ 4600 RPM, 8.1L Fully Dressed Marine Engine. Engine Features: Multi-Port Fuel Injection using Cool Fuel 3, Dry Joint Exhaust with 316 Stainless Steel Exhaust Elbows, +2" Risers Standard, Closed Cooling, Oil Cooler, PCM 555, Engine Guardian, Smart Craft Ready, Mechanical Throttle and Shift, Premium Dual-Stage Driveplate, Inboard High Mount Starter, Aluminum Oil Pan, 14-Pin Harness. Runs on 87 Octane Fuel.

370 HP Remanufactured Inboard Engine

Replaces all makes of big block inboard engines: 7.4L, 454, 8.1L & 502

8.1L HORIZON - DOWN-ANGLE ENGINE ONLY

8M0052318

8.1L Horizon - Down Angle Engine Only. 370 HP @ 4600 RPM, 8.1L Fully Dressed Marine Engine. Engine Features: Multi-Port Fuel Injection using Cool Fuel 3, Dry Joint Exhaust with 316 Stainless Steel Exhaust Elbows, +2" Risers Standard, Closed Cooling, Oil Cooler, PCM 555, Engine Guardian, Smart Craft Ready, Mechanical Throttle and Shift, Premium Dual-Stage Driveplate, Inboard High Mount Starter, Aluminum Oil Pan, 14-Pin Harness. Runs on 87 Octane Fuel. NOTE: Dealer must change driveplate if used with in-line transmissions.

370 HP Remanufactured Inboard Engine

Replaces all makes of big block inboard engines: 7.4L, 454, 8.1L & 502

ACCESSORY KITS FOR PLUS-SERIES ENGINES

EXHAUST RISER KITS

RISER KIT



93320A13

3 in. (76 mm)

Fits MCM V-6 carb & TBI engines with 2 piece exhaust manifolds (s/n 0M614999 & below).

Fits MCM/MIE/Tow Sports V-8 (305, 350, 377, 454 & 502 cid) engines with cast iron elbows (s/n 0M299999 & below); MCM V-8 (305 & 350 cid) carb engines (s/n 0M300000-0M599999) and MIE & Tow Sports carb engines (s/n 0M300000-0M316999).

RISER KIT



93322A12

6 in. (152 mm)

Fits MCM V-6 carb & TBI engines with 2 piece exhaust manifolds (s/n 0M614999 & below).

Fits MCM/MIE/Tow Sports V-8 (305, 350, 377, 454 & 502 cid) engines with cast iron elbows (s/n 0M299999 & below); MCM V-8 (305 & 350 cid) carb engines (s/n 0M300000-0M599999) and MIE & Tow Sports carb engines (s/n 0M300000-0M316999).

RISER KIT



864908A 1

6 in. (152 mm) for standard cooling and dry joint exhaust manifolds.

Fits 2004 and newer MCM V-6 (s/n 0W310000 and up); 2002 and newer MCM V-8 (305, 350 & 377 cid) non-EC engines (s/n 0M615000 and up) & MIE V-8 (350 & 377 cid) non-EC engines (s/n 0M390000 and up).

EXHAUST ELBOW/RISER KIT - 6 IN.(152 MM)



862354A04

Order this kit if the engine has a 2 in.(51 mm) elbow already installed on it, but only needs an additional 4 in.(102 mm) rise. The 2 in.(51 mm) elbow is removed and replaced with the standard rise elbows and a 6 in.(152 mm) riser kit which are included in kit.

Fits MCM/MIE 8.1L & 8.2L non-EC engines

RISER KIT - 6 IN.(152 MM)



863124A02

This riser will raise the elbow an additional 6 in.(152 mm). If the engine has a 2 in.(51 mm) elbow already on engine, but only needs an additional 4 in.(102 mm) rise, this kit will not work. Order 862354A 1 Exh. Elbow/Riser kit instead.

Fits MCM/MIE 8.1L & 8.2L non-EC engines

INTERMEDIATE ELBOW KIT



14865A02

Only required on sterndrive engines that have the exhaust going through the prop.

Fits MCM V-6 with 2 piece exhaust manifolds and 3 in. (76 mm) risers - s/n 0W309999 and below

ACCESSORY KITS FOR PLUS-SERIES ENGINES

INTERMEDIATE ELBOW KIT



14865A 1

Only required on sterndrive engines that have the exhaust going through the prop. Fits MCM V-6 with 2 piece exhaust manifolds and 6 in. (152 mm) risers - s/n 0W309999 and below

REMOTE OIL KIT

REMOTE OIL FILTER KIT

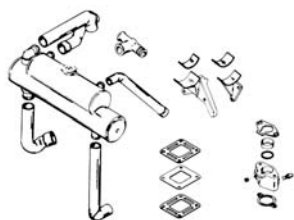


807459A 3

Fits 1996-2002 MCM V-6 (Gen+) Carb & TBI engines (s/n 0F803000-0M614999). Also fits the 4.3L Plus-Series engine.

CLOSED COOLING KITS

CLOSED COOLING KIT



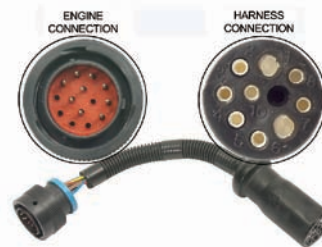
860427A 4

Front mounted kit.

Fits MCM V-6 & V-8 (350 cid) engines w/ serpentine belt.

14-10 PIN HARNESS ADAPTOR

ADAPTER - NON DTS 14 PIN TO 10 PIN



84-866337T01

Adapter that allows you to connect engines that have the newer 14 pin engine harness to the older 10 pin helm harness

MCM/MIE engines that have the 14 pin engine harness. Also used on Race product (outboards only) that have a 14 pin engine harness being connected to a 10 pin helm harness.

ENGINE HEADERS

MARINE EXHAUST HEADER ASSEMBLY - PORT**879288019**

Port-Side Custom 316L Ceramic Coated Polished Marine Header Assembly.
Production item on 383 Stroker Scorpion Bravo applications shown in photo.
Fits MerCruiser 5.0L, 5.7L, 350, 6.2L, 377, and 383 small block applications.

MARINE EXHAUST HEADER ASSEMBLY - STARBOARD**879288020**

Starboard-Side Custom 316L Ceramic Coated Polished Marine Header Assembly.
Production item on 383 Stroker Scorpion Bravo applications shown in photo.
Fits MerCruiser 5.0L, 5.7L, 350, 6.2L, 377, and 383 small block applications.

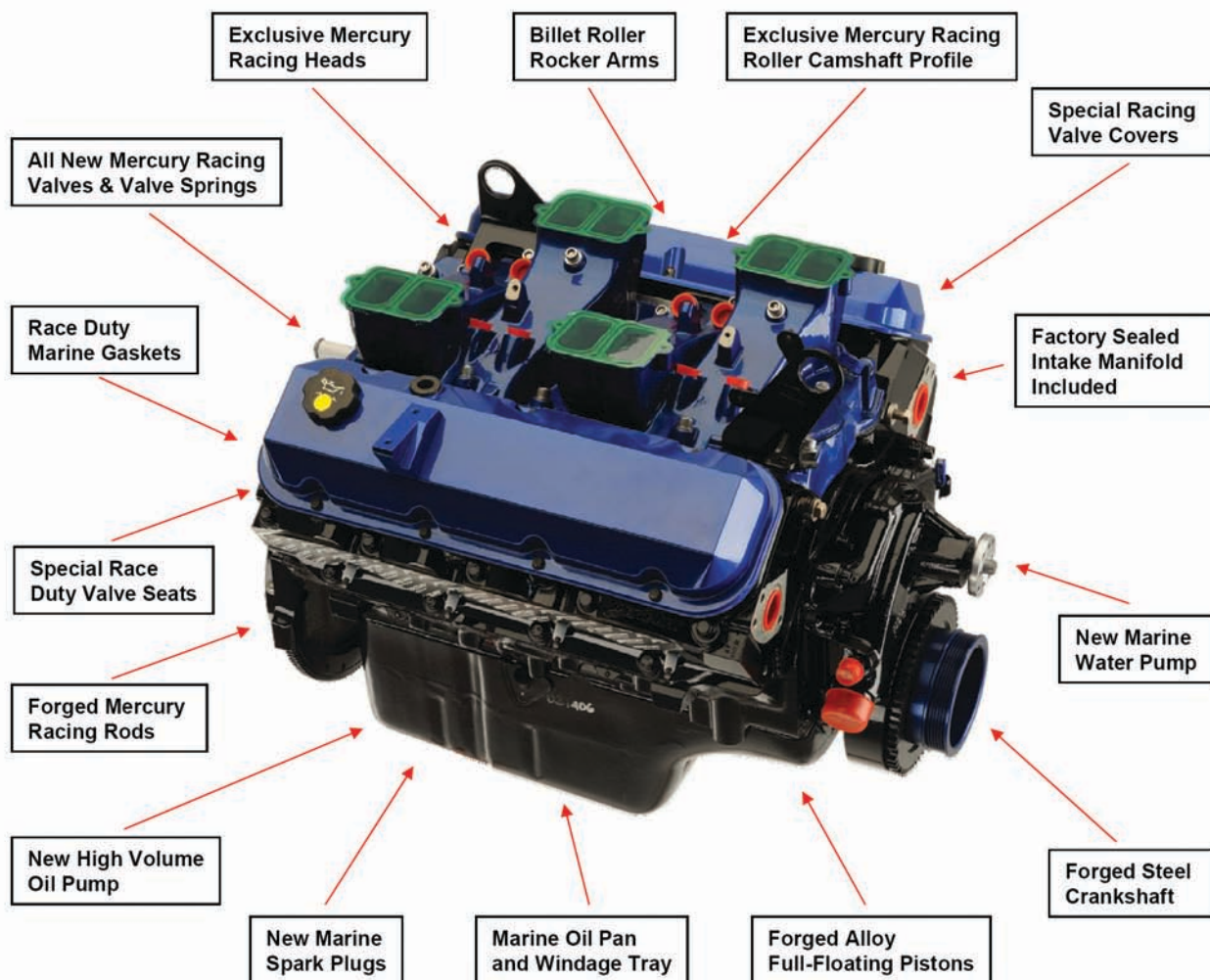
RACING SERIES ENGINE FEATURES

RACING SERIES ENGINE FEATURES



Racing Series Longblocks

- Remanufactured back to factory specifications
- Less expensive than rebuilding
- Many new parts included
- 1 Year Limited Factory Warranty
- Automotive engines lack essential Marine Parts for Marine Race Duty
- 100% Hot tested & pressure checked for reliability



RACING SERIES LONGBLOCK ASSEMBLY

Starting with premium Racing engine core, every unit is produced under very strict guidelines and specifications to meet the expectations of the high performance customer. Mercury customers no longer need to send their marine race engines off to a performance automotive engine rebuilder. Racing Series longblocks from Quicksilver Remanufacturing come with a 1-Year Factory Limited Warranty.

500 CARB RACING SERIES



848170R09

Remanufactured Racing Longblock Assembly. Built to MerCruiser Racing specifications. Dyno tested for product integrity. Includes completely remanufactured longblock and cylinder heads, valve covers, oil pan, front timing cover, harmonic balancer, flywheel, water circulating pump, and intake manifold installed.

480-HP MerCruiser Racing engines designed for carbureted applications.

500 EFI RACING SERIES



844500R09

Remanufactured Racing Longblock Assembly. Built to MerCruiser Racing specifications. Dyno tested for product integrity. Includes completely remanufactured longblock and cylinder heads, valve covers, oil pan, front timing cover, harmonic balancer, flywheel, water circulating pump, and intake manifold installed.

500-HP MerCruiser Racing engines designed for EFI applications.

525 EFI B RACING SERIES

841178R02

Remanufactured Racing Long block Assembly. Built to MerCruiser Racing specifications. Dyno tested for product integrity. Includes completely remanufactured long block and cylinder heads, valve covers, oil pan, front timing cover, harmonic balancer, flywheel, water circulating pump, and intake manifold installed.

525-HP MerCruiser Racing engines designed for EFI applications with a rear mounted cam position sensor. Serial number 0M953619 and below.

525 EFI F RACING SERIES

841178R06

Remanufactured Racing long block Assembly. Built to MerCruiser Racing specifications. Dyno tested for product integrity. Includes completely remanufactured long block and cylinder heads, valve covers, oil pan, front timing cover, harmonic balancer, flywheel, water circulating pump, and intake manifold installed.

525-HP MerCruiser Racing engines designed for EFI applications with a front mounted camshaft position sensor. Serial number 0M953620 and up.

575 SCI RACING SERIES

Image not Available.

844575R08

Remanufactured Racing Longblock Assembly. Built to MerCruiser Racing specifications. Dyno tested for product integrity. Includes completely remanufactured longblock and cylinder heads, valve covers, oil pan, front timing cover, harmonic balancer, flywheel, water circulating pump, and intake manifold installed.

575-HP MerCruiser Racing engines designed for SCI (super-charger injected) applications.

600 SCI RACING SERIES

844200R09

Remanufactured Racing Longblock Assembly. Built to MerCruiser Racing specifications. Dyno tested for product integrity. Includes completely remanufactured longblock and cylinder heads, valve covers, oil pan, front timing cover, harmonic balancer, flywheel, water circulating pump, and intake manifold installed.

600-HP MerCruiser Racing engines designed for SCI (super-charger injected) applications.

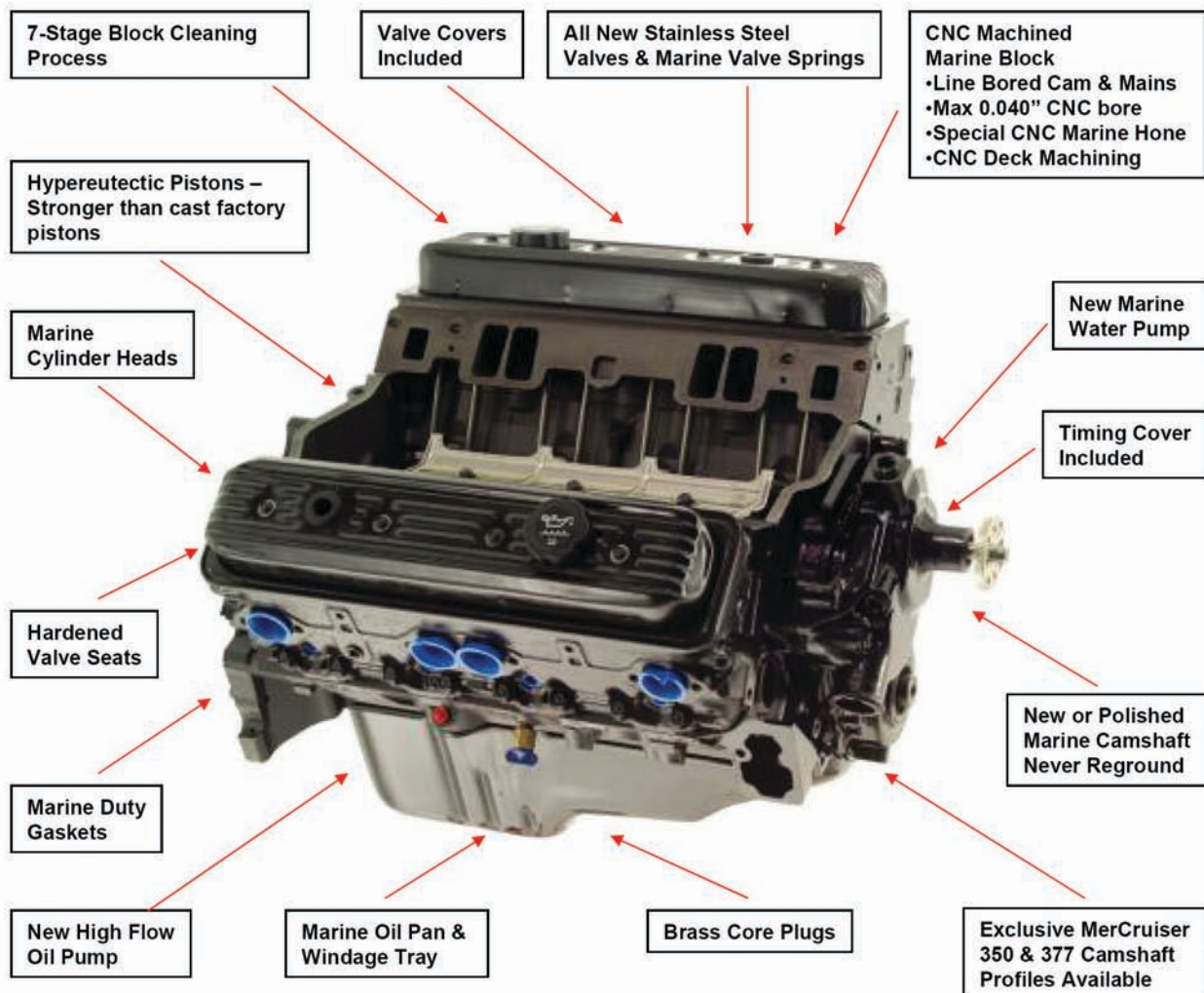
PRO-SERIES LONGBLOCK FEATURES

PRO-SERIES LONGBLOCK FEATURES



Pro-Series Longblocks

- Remanufactured to factory specifications
- More included content = Lower overall job cost
- 1 Year Limited Factory Warranty
- Automotive engines lack essential Marine Parts for Marine Duty
- 100% Hot tested & pressure checked for reliability



MERCUISER PRO-SERIES LONGBLOCK ASSEMBLY

3.0 LITER/4 CYLINDER LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



8M0062850

Remanufactured Pro-Series Longblock
GM 4 Cyl., 3.0 Liter 181 cid I/L 4
(Left-Hand Rotation)

Replaces 1990-1994 3.0L and 1990-1995 3.0LX sterndrive engines. (SN# 0C856559-0F603999)

863814R07

Remanufactured Pro-Series Longblock
GM 4 Cyl, 3.0L - 181 cid - For Volvo or MerCruiser applications.
(Left-Hand Standard Rotation) with remanufactured cylinder heads.
This longblock is packaged in a one-way container. No core or container charges apply. This engine provides a machined pilot hole in the crankshaft for Volvo drive couplers. Please check the Volvo/OMC Cross Reference Chart for specific model compatibility. This engine can be used in MerCruiser 3.0L applications.

Replaces Volvo models 3.0 GLM-C, 3.0 GLP-C, 3.0 GSP-A, 3.0 GSM-A, 3.0 GSP-B, 3.0 GSP-C, 3.0 GSM-B, 3.0 GSM-C, 3.0 GLP-A, 3.0 GLP-B, 3.0 GLM-A, 3.0 GLM-B, 3.0 GLP-D, 3.0 GLP-E, 3.0 SBY, 3.0 SPBY, 3.0 MEFS, 3.0 SPEFS, 3.0 SMLKD, 3.0 SPLKD, 3.0 SMNCA, 3.0 SMNCS, 3.0 SPNCA, 3.0 SPNCS, 3.0 SMWTR, 3.0 SMWTS, 3.0 SPWTR, 3.0 SPWTS

4.3 LITER V-6 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



14149R50

Remanufactured Pro-Series Longblock
GM 4.3 Liter Non-Gen.+ 262 V/6
(Left-Hand Standard Rotation)

Replaces 1986-1992 4.3L non balance-shaft sterndrive marine engines with mechanical fuel pump.

806347R50

Remanufactured PRO Series Longblock
GM 4.3 Liter Non-Gen.+ 262 V/6
(Left-Hand Standard Rotation) with remanufactured cylinder heads.
Replaces 1993-1996 4.3L balance-shaft marine engines.

LONGBLOCK ASSEMBLY



807736R50

Remanufactured Pro Series Longblock
GM 4.3 Liter Gen.+ 262 V/6
(Left-Hand Standard Rotation)with brand new cylinder head assemblies.
Replaces 1996 -1999 GM 4.3L balance-shaft marine engines with electric fuel pumps. If metric fasteners are required for installation, order fastener kit # 56-861937A 1.

8M0063328

Remanufactured PRO-Series Longblock
GM 6 Cyl., 4.3 Liter Gen+ 262 V6
(Left-Hand Standard Rotation) with remanufactured Vortec cylinder heads.
Replaces 2001-2007 GM 4.3L balance-shaft marine engines with electric fuel pumps, roller rocker-arms

5.0 LITER V-8 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



805636R50

Remanufactured PRO Series Longblock
GM 5.0 Liter Non-Gen.+ 305 V/8
(Left-Hand Standard Rotation)
Replaces 1987-1995 5.0L flat-tappet sterndrive marine engines.

MERCURISER PRO-SERIES LONGBLOCK ASSEMBLY

5.7 LITER V-8 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



883944R50

Remanufactured - PRO Series Longblock
GM 5.7 Liter Non-Gen.+ 350 V/8
(Left-Hand / Standard Rotation) with brand new cylinder heads.
Replaces 1987-1995 Sterndrive or Inboard 5.7L flat-tappet marine engines.

807447R50

Remanufactured - PRO Series Longblock
GM 5.7 Liter Non-Gen.+ 350 V/8
(Left-Hand / Standard Rotation) with brand new cylinder heads.
Replaces 1991-1997 Sterndrive or Inboard 5.7L roller-lifter marine engines.

LONG BLOCK ASSEMBLY



807449R50

Remanufactured - PRO Series Longblock
GM 5.7 Liter Gen.+ 350 V/8
(Left-Hand Standard Rotation) with remanufactured cylinder heads.
Replaces 1996 and newer 5.7L Carbureted or Throttle Body Injected EFI sterndrive or inboard engines. This block is designed to replace those engines NOT requiring a CPS (crank positioning sensor) or reluctor.

860186R50

Remanufactured PRO-Series Longblock
GM 5.7 Liter Gen.+ 350 V/8
(Left-Hand Standard Rotation)
Replaces 1996 (only) 5.7L EFI Gen.+ and 350 Mag MPI multi-port injected marine engines with a mechanical fuel pump.

LONGBLOCK ASSEMBLY

8M0052529

Remanufactured PRO-Series Longblock
GM 8 Cyl., 5.7 Liter Vortec 350 V8
(Left-Hand Standard Rotation) with remanufactured Vortec cylinder heads. This longblock is packaged in a one-way container. No core or container charges apply. This engines replaces 1999 and newer Volvo 5.7GX, GSi, & OXi MPI models only using 1.6:1 roller rocker arms. This block has provisions for a CPS (Crank Position Sensor). There are no provisions for a mechanical fuel pump.

6.2 LITER V-8 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



862760R01

Remanufactured PRO-Series Longblock
GM 8 Cyl., 6.2 Liter Gen+ 377 V8
(Left-Hand Standard Rotation) with remanufactured Vortec cylinder heads.

Replaces 2000-2001 GM 6.2L Gen+ MPI Multi-Port Fuel Injected engines.
(SN# 0L680003-0M299999) without CPS (Crank Position Sensor)

383 MAG V-8 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



865108R01

Remanufactured PRO-Series Longblock
GM 8 Cyl., 6.3 Liter Gen+ 383 V8
(Left-Hand Standard Rotation) with remanufactured Vortec cylinder heads.
This engines is used to service 2005 thru 2007 Mercury Remanufacturing 383 Mag Stroker Multi-Port Fuel Injected marine engines, 865108R10, 865108R11 & 865108R80. This block has provisions for a CPS (Crank Position Sensor). There are NO provisions for a mechanical fuel pump. It uses a proprietary 383 roller camshaft profile, 1.6:1 roller rocker arms and 100 PSI oil pump.

879147R55

Remanufactured PRO-Series Longblock
GM 8 Cyl., 6.3 Liter Gen+ 383 V8
(Left-Hand Standard Rotation)
This engine is used to service the Mercury Remanufacturing 383-Stroker Scorpion sterndrive and tow sports engines.

7.4 LITER V-8 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



806351R50

Remanufactured PRO Series Longblock
GM 7.4 Liter V/8 GEN-V Block
(Left-Hand Standard Rotation)
Replaces 1992-1996 GM 7.4L sterndrive and inboard marine engines with oval ports and flat-tappets.

LONGBLOCK ASSEMBLY



883281R50

Remanufactured PRO Series Longblock
GM 7.4 Liter MPI V/8 L-29 Block
(Left-Hand Standard Rotation)
Replaces 1998 and newer GM 7.4L MPI L-29 Standard sterndrive and inboard marine engines with oval ports and roller-lifters.

8.1 LITER 496 V-8 LONGBLOCK ASSEMBLY

LONGBLOCK ASSEMBLY



8M0062848

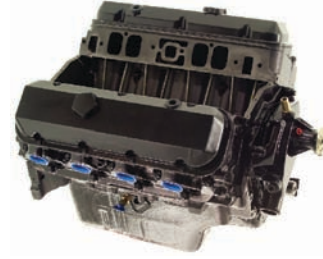
Remanufactured PRO-Series Longblock
GM 8 Cyl., 8.1 Liter 496 V8
(Left-Hand Standard Rotation)
Replaces 2001 and newer GM 496 Mag. And 2001 and newer GM 8.1S Horizon

8M0062849

Remanufactured PRO-Series Longblock
GM 8 Cyl., 8.1 Liter 496 V8
(Left-Hand Standard Rotation)
Replaces 2001 and newer GM 496 Mag H.O.(High-Output). And 2001 and newer GM 8.1S Horizon H.O.(High-Output).

8.2 LITER 502 V-8 LONGBLOCK ASSEMBLY

LONG BLOCK ASSEMBLY



883282R50

Remanufactured PRO Series Longblock
GM 8.2 Liter 502 V/8 GEN-V Block
(Left-Hand Standard Rotation)
Replaces 1992-1996 GM 502 MAGNUM sterndrive and MIE 8.2L inboard marine engines with flat-tappets. Please double check serial number and application chart prior to ordering.

LONGBLOCK ASSEMBLY



8M0062846

Remanufactured PRO-Series Longblock
GM 8 Cyl., 8.2 Liter 502 V8 GEN-VI Block
(Left-Hand Standard Rotation)
Replaces 1996-2002 GM 502 MAGNUM sterndrive and MIE 8.2L inboard marine engines with high flow rectangle ports and roller-lifters.
Will also backfit 1992-1996 GM 502 MAGNUM sterndrive and MIE 8.2L inboard GEN-V marine engines with flat-tappets, but will require replacing the harmonic balancer with newer version p/n 845625T2 or by scribing timing marks on the original harmonic balancer. Please double check the serial number and application chart prior to ordering.

MERCRUISER *NEW* LONGBLOCKS

LONGBLOCK ASSEMBLY



864626A01

Brand *NEW* Longblock
GM 4 cyl., 3.0 Liter 181 cid I/L 4
Replaces 1990-1997 3.0LX engines (s/n 0C856559-ok999999). Also 1998 and newer 3.0L carb engines (0L010042 and up).

MERCUISER PRO-SERIES LONGBLOCK ASSEMBLY

864626A02

Brand *NEW* Longblock
GM 4 cyl., 3.0 Liter 181 cid I/L 4
Replaces 2008 & newer MCM 3.0L MPI engines.

LONGBLOCK ASSEMBLY



879150A31

Brand *NEW* Longblock
GM 6 Cyl., 4.3 Liter Gen+ 262 V6
Replaces 2002 and newer 4.3L Gen+ engines.
NOTE: Please see MerCruiser Service Bulletin 2007-11 for additional components which may be required when replacing 4.3L engines with s/n 1A063239 and below.

LONGBLOCK ASSEMBLY



864651A01

Brand *NEW* Longblock
GM 8 Cyl., 5.0 Liter Gen+ 305 V8
Replaces 1998 and newer 5.0L Carbureted or Throttle Body Injected EFI sterndrive engines. It also replaces the 5.0L Multi-Port Injected MPI engines without CPS (Crank Position Sensor). Will NOT service a 5.0L engine with a CPS (Crank Position Sensor).

863660A 2

Brand *NEW* Longblock
GM 8 Cyl., 5.0 Liter Gen+ V8
Replaces 2002 and newer GM 5.0L MPI marine engines with CPS (Crank Position Sensor). (SN# 0M300000 and up)

LONGBLOCK ASSEMBLY



864652A01

Brand *NEW* Longblock
GM 8 Cyl., 5.7 Liter Gen+ 350 V8
Replaces 1996 and newer 5.7L Gen+ Carbureted or Throttle Body Fuel Injected EFI sterndrive and inboard engines.

863661A 2

Brand *NEW* Longblock
GM V-8, 350 cid (Gen +)
Replaces 2001-2004 MCM 350 Mag MPI engines (s/n 0M300000-0W309999) & 2001-2004 MIE 350 Mag MPI engines (s/n 0M300000-0W389999).

800-866138A03

Brand *NEW* Longblock
GM 8 Cyl., 5.7 Liter Gen+ 350 V-8
Replaces 2008 & newer Scorpion 350 EC Tow Sports engines (s/n 0W698433 and up)

800-866138A05

Brand *NEW* Longblock
GM 8 Cyl., 5.7 Liter Gen+ 350 V-8
Replaces 2005 & newer MCM/MIE 350 Mag & 5.7L MPI engines (s/n 0W310000 and up)

LONG BLOCK ASSEMBLY



865108A02

Brand *NEW* Longblock
GM 8 Cyl., 6.2 Liter Gen+ 377 V8
Replaces 2002-2009 MCM 6.2L Gen+ MPI engines (s/n 0M300000-1A345479); also 2002-2009 MIE 6.2L Gen+ MPI engines (s/n 0M300000-1A091825)

879288A06

Brand *NEW* Longblock
GM 8 Cyl., 6.2 Liter Gen+ 377 V8
Replaces 2009 & newer MCM 6.2L Gen+ MPI engines (s/n 1A345480 and up); also 2009 & newer MIE 6.2L Gen+ MPI engines (s/n 1A091826 and up)

LONGBLOCK ASSEMBLY



8M0074038

Brand *NEW* Longblock
GM 8 Cyl., 8.2 Liter 502 V8 GEN-VI Block
Replaces 2010 & newer MCM/MIE 8.2L engines

LONGBLOCK ASSEMBLY - RACING SERIES



841178A05

Brand *NEW* Longblock
GM 8 Cyl., 8.2 Liter 502 V8 GEN-VI Block
Replaces 2006 & newer MCM Racing 525 EFI engines (s/n 0M953620 and up)

LONG BLOCK CROSS REFERENCE CHARTS

Long Block Cross Reference

All long blocks include:

Engine block, crankshaft, connecting rods, pistons, rings, engine bearings, oil pump, marine gaskets, marine camshaft, lifters, timing components, brass core plugs, complete head assemblies, timing cover, oil pan, valve covers, marine water pump and a one year Quicksilver limited warranty.

New long blocks also include flywheels and harmonic balancers. New longblocks may include intake manifolds. See reference chart below.

Remanufactured long blocks DO NOT include intake manifolds, flywheels, harmonic balancers or gasket sets required for assembly.

Model	Cyl/CID/Litre	Year Range	Serial # Range	New Part Number	New P/N Status	Reman Pro-Series P/N
110	2.5L 153 CID I/L 4	1963 - 1966	1537370 - 2044033	87956A 1	N.L.A.	N.L.A.
120	2.5L 153 CID I/L 4	1964 - 1986	1666601 - 0B531853	87956A 1	N.L.A.	N.L.A.
2.5L	2.5L 153 CID I/L 4	1987 - 1989	0B531854 - 0C853255	87956A 1	N.L.A.	N.L.A.
140	3.0L 181 CID I/L 4	1968 - 1986	2508261 - 0B450800	87959A 1(2)	N.L.A.	N.L.A.(2)
3.0L	3.0L 181 CID I/L 4	1989	0B450801 - 0C856558	87959A 1(2)	N.L.A.	N.L.A.(2)
3.0L	3.0L 181 CID I/L 4	1990 - 1994	0C856451 - 0F603999	805047A 1	N.L.A.	N.L.A.(14)
3.0L	3.0L 181 CID I/L 4	1998 - 2013	0L010042 and up	864626A01	Active	N/A
3.0L MPI	3.0L 181 CID I/L 4	2008 - 2013	1A072812 and up	864626A02	Active	N.L.A.
3.0LX	3.0L 181 CID I/L 4	1990 - 1995	0C856559 - 0F603999	864626A01	Active	8M0062850
3.0LX	3.0L 181 CID I/L 4	1996 - 1997	0F604000 - 0K999999	864626A01	Active	N/A
165	3.7L 224 CID I/L 4	1987	0B434941 - 0B774251	72775A16	N.L.A.	N.L.A.
170	3.7L 224 CID I/L 4	1985 - 1986	6916779 - 0B434940	72775A16	N.L.A.	N.L.A.
180	3.7L 224 CID I/L 4	1987 - 1986	0B436391 - 0B775248	72775A16	N.L.A.	N.L.A.
190	3.7L 224 CID I/L 4	1985 - 1986	6916779 - 0B436390	72775A16	N.L.A.	N.L.A.
3.7L	3.7L 224 CID I/L 4	1988 - 1989	0B774252 - 0C762299	72775A16	N.L.A.	N.L.A.
3.7LX	3.7L 224 CID I/L 4	1988 - 1989	0B775249 - 0C762299	72775A16	N.L.A.	N.L.A.
470	3.7L 224 CID I/L 4	1976 - 1984	4208730 - 6916778	72775A16	N.L.A.	N.L.A.
485	3.7L 224 CID I/L 4	1980 - 1982	5685394 - 6218036	72775A16	N.L.A.	N.L.A.
488	3.7L 224 CID I/L 4	1983 - 1984	6170297 - 6916778	72775A16	N.L.A.	N.L.A.
185 (4 bbl.)	3.8L 229 CID V-6	1983 - 1984	6330183 - 6919655	9848	N.L.A.	N.L.A.
175	4.3L 262 CID V-6	1987	0B527955 - 0B773242	14149A 1	N.L.A.	14149R50(1)
185 (2 bbl.)	4.3L 262 CID V-6	1985 - 1986	0A331455 - 0B527954	12178A 1	N.L.A.	14149R50(1)
205	4.3L 262 CID V-6	1985 - 1986	0A331455 - 0B527954	12179A 1	N.L.A.	14149R50(1)
205	4.3L 262 CID V-6	1987	0B527955 - 0B775129	14149A 1	N.L.A.	14149R50(1)
262 Mag EFI (Gen+)	4.3L 262 CID V-6	1996 - 1997	0F803800 - 0K999999	864256A 1(13)	N.L.A.	807736R50
4.3L (2bbl.)	4.3L 262 CID V-6	1988 - 1992	0B773243 - 0D714106	14149A 1	N.L.A.	14149R50
4.3L (Gen II) (2 bbl.)	4.3L 262 CID V-6	1992 - 1993	0D714107 - 0F000877	805613A 1	N.L.A.	N.L.A.(5)
4.3L (Gen II) (2 bbl.)	4.3L 262 CID V-6	1993 - 1996	0F000878 - 0F802999	806346A 1	N.L.A.	806347R50(6)

MERCUISER PRO-SERIES LONGBLOCK ASSEMBLY

Model	Cyl/CID/Litre	Year Range	Serial # Range	New Part Number	New P/N Status	Reman Pro-Series P/N
4.3L (Gen +) (2 bbl.)	4.3L 262 CID V-6	1998 - 1999	0L010044 - 0L603999	864256A 1(13)	N.L.A.	807736R50
4.3L (Gen +) (2 bbl.)	4.3L 262 CID V-6	2000 - 2001	0L604000 - 0M324697	864256A 1(13)	N.L.A.	8M0063328
4.3L (Gen +) (2 bbl.)	4.3L 262 CID V-6	2002 - 2007	0M324698 - 1A063239	879150A31(13)	Active	8M0063328
4.3L (Gen +) (2 bbl.)	4.3L 262 CID V-6	2007 - 2013	1A063240 and up	879150A31	Active	N/A
4.3L EFI (Gen+) (4 bbl.)	4.3L 262 CID V-6	1998 - 1999	0L012009 - 0L603999	864256A 1(13)	N.L.A.	807736R50
4.3L EFI (Gen+) (4 bbl.)	4.3L 262 CID V-6	2000 - 2001	0L604000 - 0M299999	864256A 1(13)	N.L.A.	8M0063328
4.3L MPI	4.3L 262 CID V-6	2002	0M300000 - 0M324697	864256A 2(13)	N.L.A.	8M0063328
4.3L MPI	4.3L 262 CID V-6	2002 - 2007	0M324698 - 1A063239	879150A31(13)	Active	8M0063328
4.3L MPI	4.3L 262 CID V-6	2007 - 2013	1A063240 and up	879150A31	Active	N/A
4.3LH (Gen+) (4 bbl.)	4.3L 262 CID V-6	1998 - 1999	0L010044 - 0L603999	864256A 1(13)	N.L.A.	807736R50
4.3LH (Gen+) (4 bbl.)	4.3L 262 CID V-6	2000 - 2002	0L604000 - 0M614999	864256A 1(13)	N.L.A.	8M0063328
4.3LX (4 bbl.)	4.3L 262 CID V-6	1988 - 1992	0B775130 - 0D714106	14149A 1(1)	N.L.A.	14149R50(1)
4.3LX (Gen II) (4 bbl.)	4.3L 262 CID V-6	1992 - 1993	0D714370 - 0F001219	805614A 1(5)	N.L.A.	N.L.A.(5)
4.3LX (Gen II) (4 bbl.)	4.3L 262 CID V-6	1993 - 1996	0F001220 - 0F802999	806347A 1(6)	N.L.A.	806347R50(6)
4.3LX (Gen+) (2 bbl.)	4.3L 262 CID V-6	1996 - 1997	0F803000 - 0K999999	864256A 1(13)	N.L.A.	807736R50
4.3LXH (Gen+) (4 bbl.)	4.3L 262 CID V-6	1996 - 1997	0F803114 - 0K999999	864256A 1(13)	N.L.A.	807736R50
198 MIE (LH)	5.0L 305 CID V-8	1977	4776402 - 4931099	78787A 3	N.L.A.	N.L.A.
198 MIE (RH)	5.0L 305 CID V-8	1977	4776402 - 4931099	78832A 3	N.L.A.	N.L.A.
200	5.0L 305 CID V-8	1985	6899058 - 0A482026	87968A 1 (2)	N.L.A.	N.L.A.(2)
200	5.0L 305 CID V-8	1986	0A482027 - 0B525981	13412A 1	N.L.A.	N.L.A.
200	5.0L 305 CID V-8	1987	0B525982 - 0B774444	805636A 1 (1)	N.L.A.	805636R50(1)
228	5.0L 305 CID V-8	1977 - 1984	4765100 - 6899268	87968A 1	N.L.A.	N.L.A.
228 MIE (LH)	5.0L 305 CID V-8	1977 - 1980	4765100 - 5907057	87977A 1	N.L.A.	N.L.A.
228 MIE (RH)	5.0L 305 CID V-8	1977 - 1980	4765100 - 5907057	87980A 1	N.L.A.	N.L.A.
230 MIE (LH)	5.0L 305 CID V-8	1981 - 1987	5907058 - 0B522505	87977A 1	N.L.A.	N.L.A.
230 MIE (RH)	5.0L 305 CID V-8	1981 - 1987	5907058 - 0B522505	87980A 1	N.L.A.	N.L.A.
230 MIE (LH)	5.0L 305 CID V-8	1987	0B522506 - 0B788151	14153A 1	N.L.A.	805636R50
230 MIE (RH)	5.0L 305 CID V-8	1987	0B522506 - 0B788151	14154A 1	N.L.A.	N.L.A.
230	5.0L 305 CID V-8	1985 - 1986	6899268 - 0A482026	87968A 1 (2)	N.L.A.	N.L.A.(2)
230	5.0L 305 CID V-8	1986	0A482027 - 0B525981	13412A 1	N.L.A.	N.L.A.
230	5.0L 305 CID V-8	1987	0B525982 - 0B773739	805636A 1(1)	N.L.A.	805636R50(1)
5.0L	5.0L 305 CID V-8	1988 - 1995	0B774445 - 0F600999	805636A 1	N.L.A.	805636R50
5.0L (Gen+)	5.0L 305 CID V-8	1998 - 2013	0L015751 and up	864651A01	Active	N.L.A.
5.0L EFI (Gen+)	5.0L 305 CID V-8	1998 - 2001	0L012052 - 0M299999	864651A01	Active	N.L.A.
5.0L MIE (LH)	5.0L 305 CID V-8	1998	0B788152 - 0C396832	14153A 1	N.L.A.	805636R50
5.0L MIE (RH)	5.0L 305 CID V-8	1998	0B788152 - 0C396832	14154A 1	N.L.A.	N/A
5.0L MPI	5.0L 305 CID V-8	2002 - 2013	0M300000 and up	863660A 2	Active	N/A
5.0LX	5.0L 305 CID V-8	1988 - 1995	0B773740 - 0F600999	805636A 1	N.L.A.	805636R50
898	5.0L 305 CID V-8	1977 - 1984	4762210 - 6899057	87965A 1	N.L.A.	N/A
250	5.7L 350 CID V-8	1977	4768000 - 4908849	87971A 1	N.L.A.	N.L.A.
255	5.7L 350 CID V-8	1975 - 1976	4175500 - 4767999	87971A 1	N.L.A.	N.L.A.
255 MIE (LH)	5.7L 350 CID V-8	1975 - 1980	4175500 - 5907057	87983A 3	N.L.A.	N.L.A.
255 MIE (RH)	5.7L 350 CID V-8	1975 - 1980	4175000 - 5907057	87986A 1	N.L.A.	N/A
260	5.7L 350 CID V-8	1978 - 1986	4908850 - 0A474502	87971A 1(2)	N.L.A.	N.L.A.(2)
260	5.7L 350 CID V-8	1986	0A474503 - 0B525981	13415A 1	N.L.A.	N/A
260	5.7L 350 CID V-8	1987	0B525982 - 0B773304	14152A 1(1)	N.L.A.	883944R50(1)
260 MIE (LH)	5.7L 350 CID V-8	1981 - 1987	5907058 - 0B522505	87983A 3	N.L.A.	N.L.A.(2)
260 MIE (RH)	5.7L 350 CID V-8	1981 - 1987	5097058 - 0B522505	87986A 1	N.L.A.	N/A
260 MIE (LH)	5.7L 350 CID V-8	1987	0B522506 - 0B788151	14155A 1	N.L.A.	883944R50(1)
260 MIE (RH)	5.7L 350 CID V-8	1987	0B522506 - 0B788151	14156A 1	N.L.A.	N.L.A.(1)
350 Mag Alpha	5.7L 350 CID V-8	1986 - 1987	0A635178 - 0B525981	13415A 1	N.L.A.	N/A
350 Mag Alpha	5.7L 350 CID V-8	1987 - 1992	0B525982 - 0D617327	14152A 1(7)	N.L.A.	883944R50(1)

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Model	Cyl/CID/Litre	Year Range	Serial # Range	New Part Number	New P/N Status	Reman Pro-Series P/N
350 Mag Alpha	5.7L 350 CID V-8	1992 - 1995	0D617328 - 0F600999	821151A 1(8)	N.L.A.	807447R50(8)
350 Mag Alpha	5.7L 350 CID V-8	1996 - 1997	0F601000 - 0K999999	807447A 1	N.L.A.	807447R50
350 Mag Alpha EFI (Gen+)	5.7L 350 CID V-8	1996	0F800300 - 0K001508	860186A 2	N.L.A.	860186R50
350 Mag Alpha EFI (Gen+)	5.7L 350 CID V-8	1997	0K001509 - 0K999999	864652A01	Active	807449R50
350 Mag Bravo EFI	5.7L 350 CID V-8	1995	0F415189 - 0F600199	806801A 1	N.L.A.	807447R50
350 Mag Bravo MPI (Gen+)	5.7L 350 CID V-8	1996	0F602000 - 0K001500	860186A 2	N.L.A.	860186R50
350 Mag Bravo MPI (Gen+)	5.7L 350 CID V-8	1997	0K001501 - 0K999999	864652A01	Active	807449R50
350 Mag EFI Ski	5.7L 350 CID V-8	1994 - 1996	0F215561 - 0F820706	821151A 1	N.L.A.	807447R50
350 Mag EFI Ski (Gen+)	5.7L 350 CID V-8	1996 - 1997	0F820707 - 0K999999	864652A01	Active	807449R50
350 Mag MPI (Gen+)	5.7L 350 CID V-8	1998 - 2001	0L010019 - 0M299999	864652A01	Active	807449R50
350 Mag MPI (Gen+)	5.7L 350 CID V-8	2002 - 2004	0M300000 - 0W309999	863661A 2	Active	N/A
350 Mag MPI (Gen+)	5.7L 350 CID V-8	2005 - 2013	0W310000 and up	800-866138A03	Active	N/A
350 Mag MPI Horizon (Gen+)	5.7L 350 CID V-8	2002 - 2004	0M300000 - 0W309999	863661A 2	Active	N/A
350 Mag MPI Horizon (Gen+)	5.7L 350 CID V-8	2005 - 2007	0W310000 - 1A299999	800-866138A03	Active	N/A
350 Mag MPI Horizon MIE (Gen+)	5.7L 350 CID V-8	1999 - 2001	0L304700 - 0M299999	864652A01	Active	807449R50
350 Mag MPI Horizon MIE (Gen+)	5.7L 350 CID V-8	2002 - 2004	0M300000 - 0W389999	863661A 2	Active	N/A
350 Mag MPI Horizon MIE (Gen+)	5.7L 350 CID V-8	2005 - 2007	0W390000 - 1A089999	800-866138A03	Active	N/A
350 Mag MPI MIE (Gen+)	5.7L 350 CID V-8	1998 - 2001	0L002008 - 0M299999	864652A01	Active	807449R50
350 Mag MPI MIE (Gen+)	5.7L 350 CID V-8	2002 - 2004	0M300000 - 0W389999	863661A 2	Active	N/A
350 Mag MPI MIE (Gen+)	5.7L 350 CID V-8	2005 - 2007	0W390000 - 1A089999	800-866138A03	Active	N/A
350 Mag MPI Ski	5.7L 350 CID V-8	1995 - 1996	0F350583 - 0F799999	806801A 1	N.L.A.	807447R50
350 Mag MPI Ski (Gen+)	5.7L 350 CID V-8	1998 - 2001	0L002600 - 0M299999	864652A01	Active	807449R50
350 Mag MPI Ski (Gen+)	5.7L 350 CID V-8	2002 - 2004	0M300000 - 0W309999	863661A 2	Active	N/A
350 Mag Ski	5.7L 350 CID V-8	1991 - 1995	0D505450 - 0F621699	821151A 1	N.L.A.	807447R50
350 Mag Ski	5.7L 350 CID V-8	1996 - 1997	0F621700 - 0K999999	807447A 1	N.L.A.	807447R50
5.7L - Alpha	5.7L 350 CID V-8	1988 - 1996	0B773305 - 0K001526	14152A 1	N.L.A.	883944R50
5.7L - Alpha	5.7L 350 CID V-8	1997	0K001527 - 0K999999	807447R 2	N.L.A.	807447R50
5.7L - Bravo	5.7L 350 CID V-8	1989 - 1991	0C407810 - 0D617327	14152A 1(7)	N.L.A.	883944R50(7)
5.7L - Bravo	5.7L 350 CID V-8	1992 - 1995	0D617328 - 0F600999	821151A 1(8)	N.L.A.	807447R50(8)
5.7L - Bravo	5.7L 350 CID V-8	1996	0F601000 - 0K001526	807315A 1(7)	N.L.A.	883944R50(7)
5.7L - Bravo	5.7L 350 CID V-8	1997	0K001527 - 0K999999	860183A 1(8)	N.L.A.	807447R50(8)
5.7L (Gen+)	5.7L 350 CID V-8	1998 - 2013	0L010037 and up	864652A01	Active	807449R50
5.7L EFI (TBI)	5.7L 350 CID V-8	1995	0F225560 - 0F752399	821151A 1(8)	N.L.A.	807447R50(8)
5.7L EFI (TBI)	5.7L 350 CID V-8	1996	0F752400 - 0K001505	807315A 1(7)	N.L.A.	883944R50(7)
5.7L EFI (TBI)	5.7L 350 CID V-8	1997	0K001506 - 0K999999	860183A 1(8)	N.L.A.	807447R50(8)
5.7L EFI (Gen+)	5.7L 350 CID V-8	1998 - 2001	0L010035 - 0M299999	864652A01	Active	807449R50
5.7L EFI MIE (Gen+)	5.7L 350 CID V-8	1997	0K040300 - 0K999999	864652A01	Active	N/A
5.7L MIE (LH)	5.7L 350 CID V-8	1988 - 1995	0B788152 - 0F622099	14155A 1	N.L.A.	883944R50
5.7L MIE (RH)	5.7L 350 CID V-8	1988 - 1995	0B788152 - 0F746099	14156A 1	N.L.A.	N.L.A.
5.7L MIE (LH)	5.7L 350 CID V-8	1995	0F622151 - 0F746099	14155A 1(7)	N.L.A.	883944R50(7)
5.7L MIE (LH)	5.7L 350 CID V-8	1996	0F622100 - 0F622150	807448A 1(8)	N.L.A.	807447R50(8)
5.7L MIE (LH)	5.7L 350 CID V-8	1996 - 1997	0F746100 - 0K999999	807448A 1(8)	N.L.A.	807447R50(8)
5.7L MIE (Gen+)	5.7L 350 CID V-8	1998 - 2013	0L002003 and up	864652A01	Active	807449R50
5.7L MPI Horizon MIE	5.7L 350 CID V-8	2008 - 2013	1A090000 and up	800-866138A03	Active	N/A
5.7L MPI MIE	5.7L 350 CID V-8	2008 - 2013	1A090000 and up	800-866138A03	Active	N/A
5.7L MPI Ski	5.7L 350 CID V-8	2008 - 2013	1A090000 and up	863661A 2	Active	N/A
5.7L Ski (LH)	5.7L 350 CID V-8	1985 - 1987	0A338553 - 0B514626	13415A 1(11)	N.L.A.	N/A
5.7L Ski (RH)	5.7L 350 CID V-8	1985 - 1987	0A338553 - 0B514626	87986A 1(11)	N.L.A.	N/A
5.7L Ski (LH)	5.7L 350 CID V-8	1987 - 1995	0B514627 - 0F775199	14152A 1	N.L.A.	883944R50
5.7L Ski (RH)	5.7L 350 CID V-8	1987 - 1995	0B514627 - 0F775199	14156A 1	N.L.A.	N.L.A.
5.7L Ski	5.7L 350 CID V-8	1996 - 1997	0F775200 - 0K040003	807315A 1(7)	N.L.A.	883944R50(7)
5.7L Ski	5.7L 350 CID V-8	1997	0K040004 - 0K999999	860183A 1(8)	N.L.A.	807447R50(8)
5.7L Ski (2 bbl)	5.7L 350 CID V-8	1998 - 2013	0L002005 and up	864652A01	Active	807449R50
5.7L Ski (4 bbl)	5.7L 350 CID V-8	2007 - 2013	0W694844 and up	800-866138A03	Active	N/A

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Model	Cyl/CID/Litre	Year Range	Serial # Range	New Part Number	New P/N Status	Reman Pro-Series P/N
5.7LX	5.7L 350 CID V-8	1996 - 1997	0F601000 - 0K999999	807447A 1	N.L.A.	807447R50
5.7LX Bravo EFI (Gen+)	5.7L 350 CID V-8	1996	0F800300 - 0K001508	860186A 2	N.L.A.	860186R50
5.7LX Bravo EFI (Gen+)	5.7L 350 CID V-8	1997	0K001509 - 0K999999	864652A01	Active	807449R50
5.7LX EFI (TBI)	5.7L 350 CID V-8	1996 - 1997	0F752400 - 0K999999	807447A 1	N.L.A.	807447R50
Black Scorpion Ski	5.7L 350 CID V-8	1996 - 2001	0F800000 - 0M136999	864652A01	Active	807449R50
Black Scorpion Ski	5.7L 350 CID V-8	2003 - 2007	0M391600 - 0W698432	863661A 2	Active	N/A
Scorpion 350	5.7L 350 CID V-8	2008 - 2013	0W698433 and up	863661A 2	Active	N/A
Scorpion 350 EC	5.7L 350 CID V-8	2008 - 2013	0W698433 and up	800-866138A05	Active	N/A
377 Mag	6.2L 377 CID V-8	2008 - 2009	1A300000 - 1A345479	865108A02	Active	N/A
377 Mag	6.2L 377 CID V-8	2009	1A345480 - 1A345492	879288A06	Active	N/A
377 Mag	6.2L 377 CID V-8	2009	1A345493 - 1A345765	865108A02	Active	N/A
377 Mag	6.2L 377 CID V-8	2009	1A345766 - 1A345767	879288A06	Active	N/A
377 Mag	6.2L 377 CID V-8	2009	1A345768 - 1A346789	865108A02	Active	N/A
377 Mag	6.2L 377 CID V-8	2009 - 2013	1A346790 and up	879288A06	Active	N/A
383 Mag Stroker	6.2L 377 CID V-8	1996 - 2013	All and up	N/A		865108R01
MX 6.2L MPI	6.2L 377 CID V-8	2000 - 2001	0L680003 - 0M299999	865108A01	N.L.A.	862760R01
MX 6.2L MPI	6.2L 377 CID V-8	2002 - 2007	0M300000 - 1A299999	865108A02	Active	N/A
MX 6.2L MPI Horizon	6.2L 377 CID V-8	2002 - 2007	0M300000 - 1A299999	865108A02	Active	N/A
MX 6.2L MPI Horizon MIE	6.2L 377 CID V-8	2002 - 2009	0M300000 - 1A091825	865108A02	Active	N/A
MX 6.2L MPI Horizon MIE	6.2L 377 CID V-8	2009 - 2013	1A091826 and up	879288A06	Active	N/A
MX 6.2L MPI MIE	6.2L 377 CID V-8	1999 - 2001	0L670000 - 0M299999	865108A01	N.L.A.	862760R01
MX 6.2L MPI MIE	6.2L 377 CID V-8	2002 - 2013	0M300000 and up	865108A02	Active	N/A
MX 6.2L MPI Ski	6.2L 377 CID V-8	2002 - 2009	0M317000 - 1A091825	865108A02	Active	N/A
MX 6.2L MPI Ski	6.2L 377 CID V-8	2009 - 2013	1A091826 and up	879288A06	Active	N/A
MX 6.2L Black Scorpion Ski	6.2L 377 CID V-8	2001	0L670015 - 0L679130	865108A01	N.L.A.	862760R01
MX 6.2L Black Scorpion Ski	6.2L 377 CID V-8	2001 - 2007	0L679131 - 0W698432	865108A02	Active	N/A
Scorpion 377	6.2L 377 CID V-8	2008 - 2009	0W698433 - 1A091825	865108A02	Active	N/A
Scorpion 377	6.2L 377 CID V-8	2009 - 2013	1A091826 and up	879288A06	Active	N/A
Scorpion 377 HO EC	6.2L 377 CID V-8	2009 - 2013	1A091488 - 1A092170	800-866138A06	Active	N/A
330	7.4L 454 CID V-8	1977 - 1981	4623115 - 6083144	18706A 1	N.L.A.	N/A
330	7.4L 454 CID V-8	1982 - 1987	6083145 - 0B816540	87989A 1	N.L.A.	N/A
330 MIE (LH)	7.4L 454 CID V-8	1977 - 1980	4623100 - 5889913	87989A 1	N.L.A.	N/A
330 MIE (RH)	7.4L 454 CID V-8	1977 - 1980	4623100 - 5889913	87992A 1	N.L.A.	N/A
340 MIE (LH)	7.4L 454 CID V-8	1981 - 1987	5889914 - 0B788365	87989A 1	N.L.A.	N/A
340 MIE (RH)	7.4L 454 CID V-8	1981 - 1987	5889914 - 0B788365	87992A 1	N.L.A.	N/A
454 Mag Alpha	7.4L 454 CID V-8	1986 - 1988	0A631894 - 0B785148	18706A 1	N.L.A.	N/A
454 Mag Bravo	7.4L 454 CID V-8	1988 - 1992	0B721206 - 0D805068	44575A 1	N.L.A.	N.L.A.
454 Mag Bravo (Gen V)	7.4L 454 CID V-8	1992 - 1996	0D805069 - 0F801699	806352A 1	N.L.A.	N.L.A.
454 Mag Bravo (Gen VI)	7.4L 454 CID V-8	1996 - 1997	0F801700 - 0K999999	807744A3	N.L.A.	N.L.A.
454 Mag EFI (Gen V)	7.4L 454 CID V-8	1994 - 1996	0F115700 - 0F802349	806352A 1	N.L.A.	N.L.A.
454 Mag EFI Ski (Gen V)	7.4L 454 CID V-8	1995 - 1996	0F215800 - 0F820099	806352A 1	N.L.A.	N.L.A.
454 Mag MPI (Gen VI)	7.4L 454 CID V-8	1996 - 2001	0F802350 - 0M024999	807744A3	N.L.A.	N.L.A.
454 Mag MPI Horizon MIE	7.4L 454 CID V-8	1998 - 2001	0L002200 - 0L674000	807744A3	N.L.A.	N.L.A.
454 Mag Ski (MPI) (Gen VI)	7.4L 454 CID V-8	1996 - 1997	0F820100 - 0K999999	807744A3	N.L.A.	N.L.A.
7.4L Bravo	7.4L 454 CID V-8	1988 - 1991	0B771113 - 0D603117	18706A 1	N.L.A.	N/A
7.4L Bravo I & II (Gen V)	7.4L 454 CID V-8	1992 - 1996	0D603118 - 0F800699	806351A 1	N.L.A.	806351R50
7.4L Bravo III (Gen V)	7.4L 454 CID V-8	1993 - 1996	0D603118 - 0F800699	806359A 1	N.L.A.	806351R50
7.4L Bravo (Gen VI)	7.4L 454 CID V-8	1996 - 1997	0F800700 - 0K999999	807739A 1	N.L.A.	N.L.A.
7.4L EFI MIE (Gen VI) (LH)	7.4L 454 CID V-8	1996 - 1997	0F874815 - 0K999999	807739A 1	N.L.A.	N.L.A.
7.4L MIE (LH)	7.4L 454 CID V-8	1988 - 1992	0B788366 - 0D715493	87989A 1	N.L.A.	N/A
7.4L MIE (RH)	7.4L 454 CID V-8	1988 - 1992	0B788366 - 0D715493	87992A 1	N.L.A.	N/A
7.4L MIE (Gen V)	7.4L 454 CID V-8	1992 - 1996	0D715494 - 0F820141	806351A 1	N.L.A.	806351R50

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Model	Cyl/CID/Litre	Year Range	Serial # Range	New Part Number	New P/N Status	Reman Pro-Series P/N
7.4L MIE (Gen VI)	7.4L 454 CID V-8	1996 - 1997	0F820142 - 0K999999	807739A 1	N.L.A.	N.L.A.
7.4L MPI (Gen VI)	7.4L 454 CID V-8	1998 - 2001	0L010033 - 0M024330	861097A 2	N.L.A.	883281R50
7.4L MPI MIE (Gen V)	7.4L 454 CID V-8	1995 - 1996	0F563052 - 0F802103	806351A 1	N.L.A.	806351R50
7.4L MIE MPI (Gen VI)	7.4L 454 CID V-8	1996 - 1997	0F802104 - 0K999999	807739A 1	N.L.A.	N.L.A.
7.4L MIE MPI (Gen VI)	7.4L 454 CID V-8	1998 - 2001	0L002006 - 0M025999	861097A 2	N.L.A.	883281R50
7.4LX Bravo EFI (Gen VI)	7.4L 454 CID V-8	1996 - 1997	0F820000 - 0K999999	807739A 1	N.L.A.	N.L.A.
7.4LX Bravo MPI (Gen V)	7.4L 454 CID V-8	1996	0F602101 - 0F801999	807161A 1	N.L.A.	806351R50
7.4LX Bravo MPI (Gen V)	7.4L 454 CID V-8	1996 - 1997	0F802000 - 0K999999	807739A 1	N.L.A.	N.L.A.
496 Mag & 8.1S	8.1L 496 CID V-8	2001 - 2013	0M025000 and up	865752A01	N.L.A.	8M0062848
496 Mag HO & 8.1S HO	8.1L 496 CID V-8	2001 - 2013	0M025000 and up	865754A01	Active	8M0062849
500	8.2L 502 CID V-8	1992 - 1997	0F213293 - 0L001772	848170A 8	N.L.A.	N/A
500 EFI	8.2L 502 CID V-8	1999 - 2005	0L001477 - 0M907127	844500A 8	Active	N/A
502 Mag Bravo	8.2L 502 CID V-8	1990 - 1992	0C878221 - 0D824588	816287A 1	N.L.A.	N.L.A.
502 Mag Bravo (Gen V)	8.2L 502 CID V-8	1992 - 1993	0D842589 - 0F114528	807745A05	N.L.A.	883282R50
502 Mag EFI (Gen V)	8.2L 502 CID V-8	1993 - 1995	0D840650 - 0F802599	807745A05	N.L.A.	883282R50
502 Mag MPI (Gen VI)	8.2L 502 CID V-8	1996 - 2001	0F802600 - 0M024999	807745A05	N.L.A.	8M0062846
525 EFI	8.2L 502 CID V-8	2003 - 2005	0M900146 - 0M953619	841178A 1	Active	N/A
525 EFI	8.2L 502 CID V-8	2006 - 2013	0M953620 and up	841178A05	Active	N/A
575 SCi	8.2L 502 CID V-8	2001 - 2005	0L306696 - 0M950526	844575A7	N.L.A.	N/A
600 SCi	8.2L 502 CID V-8	2005 - 2013	0M952908 and up	844200A08	Active	N/A
8.2L Mag EC	8.2L 502 CID V-8	2010 - 2013	1A350340 and up	8M0074038	Active	N/A
8.2L MIE EC	8.2L 502 CID V-8	2010 - 2013	1A350802 and up	8M0074038	Active	N/A
8.2L MIE	8.2L 502 CID V-8	1990 - 1992	0C878221 - 0D857199	815875A 1	N.L.A.	N/A
8.2L MIE (Gen V)	8.2L 502 CID V-8	1993 - 1996	0D857200 - 0F819619	807745A05	N.L.A.	883282R50
8.2L MIE MPI (Gen VI) (LH)	8.2L 502 CID V-8	1996 - 2001	0F819620 - 0L674200	807745A05	N.L.A.	8M0062846

(1) 1 pc. Rear main seal

(2) 2 pc. Rear main seal

(5) Gen II w/o balance shaft

(6) Gen II w/balance shaft

(7) Flat Tappet & camshaft

(8) Roller Lifter & camshaft

(11) See MCM S.B. 86-22

(12) w/o crank position sensor

(13) See MerCruiser Service Bulletin 2007-11

(14) Order 8M0062850

(15) This longblock can be used to backfit 1992-1995 Gen-V engines, but will require replacing the harmonic balancer with a newer version harmonic balancer p/n 845625T2 or scribing the timing marks on the original harmonic balancer.

Volvo/OMC Longblock Cross Reference

Model	Model Notes	Longblock	Starter	Exhaust Manifold Gasket	Thermostat Gasket	Intake Gasket	Fuel Pump Gasket
COBRA/JV, Volvo 1993							
432APLJVB		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
432APLJVN		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
432APRJVB		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
432APRJVN		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
434APLJVB		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
434APLJVN		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
434APRJVB		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
434APRJVN		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	

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Model	Model Notes	Longblock	Starter	Exhaust Manifold Gasket	Thermostat Gasket	Intake Gasket	Fuel Pump Gasket
COBRA/JV, Volvo 1994 MD							
432ACMMDA		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
432ACPMDA		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
432AGMMDA		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
432AGPMDA		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
COBRA/JV, Volvo 1995 HU							
43APHUB		806347R50	50-863007A 1	27- 99757	8M2021920	27-824326	
COBRA/JV, Volvo 1996 NC							
432APNCA		806347R50(1)	50-863007A 1	27- 99757	8M2021920	27-824326(2)	
432BPNCs		806347R50(1)	50-863007A 1	27- 99757	8M2021920	27-824326(2)	
434APNCA		806347R50(1)	50-863007A 1	27- 99757	8M2021920	27-824326(2)	
434BPNCs		806347R50(1)	50-863007A 1	27- 99757	8M2021920	27-824326(2)	
43FAPNCA		806347R50(1)	50-863007A 1	27- 99757	8M2021920	27-824326(2)	
43FBPNCs		806347R50(1)	50-863007A 1	27- 99757	8M2021920	27-824326(2)	
COBRA/JV, Volvo 1997 LK							
432BPLKD		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
434BPLKD		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
43FBPLKD		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
COBRA/JV, Volvo 1998 BY							
432BPBYC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
434BPBYC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
43FBPBYC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
Volvo 3.0L, 1999 & newer							
3.0GLM-A		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLM-B		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLM-C		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLP-A		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLP-B		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLP-C		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLP-D		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLP-E		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GLP-J		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GSM-A		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GSM-B		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GSM-C		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GSP-A		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GSP-B		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
3.0GSP-C		863814R07	50-863007A 1	27-815528	27-814680 1	27-815528	27- 34213
Volvo 4.3L, 1999 & newer							
430A		14149R50	N.L.A.	27- 99757	8M2021920	27- 11977	27- 34213
430B		14149R50	N.L.A.	27- 99757	8M2021920	27- 11977	27- 34213
431A		14149R50	N.L.A.	27- 99757	8M2021920	27- 11977	27- 34213
431B		14149R50	N.L.A.	27- 99757	8M2021920	27- 11977	27- 34213
432A		14149R50	N.L.A.	27- 99757	8M2021920	27- 11977	27- 34213
434A		14149R50	N.L.A.	27- 99757	8M2021920	27- 11977	27- 34213
4.3GIJWTR		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPBYCCE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPEFS		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPHUSCE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPLKDCE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPLKECE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPNCACA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPNCBCE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	

MERCURISER PRO-SERIES LONGBLOCK ASSEMBLY

MERCURISER

Model	Model Notes	Longblock	Starter	Exhaust Manifold Gasket	Thermostat Gasket	Intake Gasket	Fuel Pump Gasket
4.3GIPWTC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GIPWTR		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GKOHUB		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-A		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-B		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-C		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-D		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-E		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-EF		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-G		N/A	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GL-J		879150A31	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLMMDA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPBYC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPEFS		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPLKD		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPLKE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPMDA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPNCA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPNCB		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPNCS		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPWTC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GLPWTR		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSJBYA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSJLKD		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSJWTR		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPBYC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPHUB		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPHUS		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPLKD		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPLKE		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPMDA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPNCA		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPNCB		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPNCM		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPNCS		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPWTC		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GSPWTR		807736R50	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-A		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-B		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-BF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-C		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-CF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-D		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-DF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-E		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-F		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-G		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3GXI-J		879150A31	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGI-JF		879150A31	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-E		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-EF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-F		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-FF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	

MERCUISER PRO-SERIES LONGBLOCK ASSEMBLY

Model	Model Notes	Longblock	Starter	Exhaust Manifold Gasket	Thermostat Gasket	Intake Gasket	Fuel Pump Gasket
4.3OGSI-G		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-GF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-J		879150A31	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGSI-JF		879150A31	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-E		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-EF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-F		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-FF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-G		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-GF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OGXI-J		879150A31	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OSI-B		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OSI-BF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OSI-C		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OSI-CF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OSI-D		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
4.3OSI-DF		8M0063328	50-863007A 1	27- 99757	8M2021920	27-824326002	
Volvo 5.0L, 1999 & newer							
5.0GL-A		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-B		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-C		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-D		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-E		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-F		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-FF		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-H		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GL-HF		864651A01	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-A		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-B		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-BF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-C		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-CF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-D		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-DF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-E		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-EF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-F		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-FF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-G		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-GF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0GXI-J		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-B		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-BF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-C		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-CF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-D		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-DF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-E		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-EF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-F		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-FF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-G		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.0OSI-GF		863660A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	

MERCRUISER PRO-SERIES LONGBLOCK ASSEMBLY

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Model	Model Notes	Longblock	Starter	Exhaust Manifold Gasket	Thermostat Gasket	Intake Gasket	Fuel Pump Gasket
Volvo 5.7L, 1999 & newer							
5.7 OSI - A		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - AF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - B		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - BF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - C		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - CF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - D		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - DF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - E		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - EF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - G		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7 OSI - GF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - A		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - B		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - BF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - C		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - CF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - D		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - DF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - E		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - EF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - F		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - FF		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - G		863661A 2	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI - GF		800-866138A03	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GI-300-J		800-866138A03	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - A		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - B		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - C		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - D		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - E		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - F		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7Gil - G		863661A 2	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7GL-A		807449R50	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GL-B		807449R50	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GL-C		807449R50	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GL-D		807449R50	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GL-E		807449R50	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7GSil - ANY		8M0052529	50-808011R04	27- 33395	27- 53045 1	27-807473A 1	
5.7GXl - ANY		8M0052529	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
5.7OXl - ANY		8M0052529	50-863007A 1	27- 33395	27- 53045 1	27-807473A 1	
Volvo 8.1L, 1999 & newer							
8.1G-BF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-A		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-B		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-C		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-CF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-D		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-DF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-E		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-EF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-F		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	

MERCUISER PRO-SERIES LONGBLOCK ASSEMBLY

Model	Model Notes	Longblock	Starter	Exhaust Manifold Gasket	Thermostat Gasket	Intake Gasket	Fuel Pump Gasket
8.1GI-FF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-G		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-GF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-H		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GI-HF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GII-A		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-B		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-C		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-D		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-E		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-F		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-G		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GII-H		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GSI-A		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GSI-A		8M0062848	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXI-A		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-AF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-B		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-BF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-C		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-CF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-D		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-DF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-E		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-EF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-F		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-FF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-G		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXI-GF		8M0062849	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1GXII-A		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXII-B		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXII-C		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXII-D		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXII-E		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXII-F		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1GXII-G		8M0062849	50-808011R04	27- 46820	27-881620001	27-895235	
8.1OSI-A		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-AF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-B		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-BF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-C		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-CF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-D		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	
8.1OSI-DF		8M0062848	50-863007A 1	27- 46820	27-881620001	27-895235	

(1) Inspect original engine in boat to verify ordering the correct replacement block. The 806347R50 listed is a non-Gen+ engine and can be identified by the 12 bolts securing the intake manifold. If the intake manifold on the original engine is secured by 8 bolts, then order 807736R50 Gen+ longblock instead.

(2) Inspect original engine in boat to verify ordering the correct intake manifold gasket. The 27-824326 listed is for use on non-Gen+ engines which can be identified by the 12 bolts securing the intake manifold. If the intake manifold on the original engine is secured by 8 bolts, then order 27-824326002 Gen+ intake manifold gasket instead.

INTAKE AND EXHAUST GASKET CROSS REFERENCE CHART

INTAKE AND EXHAUST GASKET CROSS REFERENCE CHART

Intake and Exhaust Gasket Cross Reference

Engine Applications	Description		
MerCruiser 3.0 Liter 4 - Cylinder		Intake Gasket #	Exhaust Gasket #
N/A	GM 4 cyl., 3.0L - 181 cid 1990-1994 L-series	27- 96429	N/A
8M0062850	GM 4 cyl., 3.0 L - 181 cid 1990-1995 LX-series	27-815528	N/A
N/A	GM 4 cyl., 3.0L - 181 cid 1996 & newer LX-series	27-815528	N/A
MerCruiser 3.7 Liter 4 - Cylinder		Intake Gasket #	Exhaust Gasket #
N.L.A.	Mercury 4 cyl., 3.7L - 224 cid 1976-1989	27- 70905	27- 68715
MerCruiser 4.3 Liter V-6		Intake Gasket #	Exhaust Gasket #
14149R50	GM V-6, 4.3L - 262 cid 1986-1992	27- 11977	27- 99757
806347R50	GM V-6, 4.3L - 262 cid 1993-1996	27-824326	27- 99757
807736R50	GM V-6, 4.3L - 262 cid (Gen +) 1996-99	27-824326002	27- 99757
N/A	GM V-6, 4.3L - 262 cid (Gen +) (w/o CPS) 2000-up	27-824326002	27- 99757
8M0063328	GM V-6, 4.3L - 262 cid (Gen +) (with CPS) 2002-up	27-824326002	27- 99757
MerCruiser 5.0 Liter V-8		Intake Gasket #	Exhaust Gasket #
805636R50	GM V-8, 5.0L - 305 cid 1987-1995	27- 17145	27- 33395
N.L.A.	GM V-8, 5.0L - 305 cid (Gen +) 1998 & newer	27- 17145	27- 33395
N/A	GM V-8, 5.0L - 305 cid (Gen +) 2002 & newer	807473A 1	33395
MerCruiser 5.7 Liter V-8		Intake Gasket #	Exhaust Gasket #
14156R50	GM V-8, 5.7L - 350 cid (RH) 1987-1995	27- 17145	27- 33395
N.L.A.	GM V-8, 5.7L - 350 cid (LH) (2-pc RM seal) 1987-95	27- 17145	27- 33395
807447R50	GM V-8, 5.7L - 350 cid 1992-95	27- 17145	27- 33395
807449R50	GM V-8, 5.7-L 350 cid (Gen +) (with CPS) 1996-up	27-807473A 1	27- 33395
N.L.A.	GM V-8, 5.7-L 350 cid (Gen +) 1996	27-807473A 1	27- 33395
N/A	GM V-8, 5.7-L 350 cid (Gen +) 2002-2004	27-807473A 1	27- 33395
883944R50	GM V-8, 5.7L - 350 cid 1987-95	27- 17145	27- 33395
MerCruiser 6.2 Liter V-8		Intake Gasket #	Exhaust Gasket #
862760R01	GM V-8, 6.2-L 377 cid (Gen+) 2000-01 w/o CPS	27-807473A 1	27- 33395

Engine Applications	Description		
N/A	GM V-8, 6.2-L 377 cid (Gen+) 2002-up with CPS	27-807473A 1	27- 33395
MerCruiser 7.4 Liter V-8		Intake Gasket #	Exhaust Gasket #
N.L.A.	GM V-8, 454 cid (Mark IV) 1977-1992	27-8M0050224	27- 46820
806351R50	GM V-8, 454 cid (Gen V) 1992-1996	27-8M0050225	27- 46820
N.L.A.	GM V-8, 454 cid (Gen V) MAG 1992-1996	27-805722A 1	27- 46820
N.L.A.	GM V-8, 454 cid (Gen VI) 1996-1997	27-8M0050225	27- 46820
N.L.A.	GM V-8, 454 cid (Gen VI) MAG 1996 and newer	27-805722A 1	27- 46820
N.L.A.	GM V-8, 454 cid (Mark IV) (RH - Opp. Rot.) 1977-92	27-8M0050224	27- 46820
883281R50	GM V-8, 454 cid (L29) 1998 and newer	27-803184	27- 46820
MerCruiser 8.1 Liter V-8		Intake Gasket #	Exhaust Gasket #
8M0062848	GM V-8, 8.1-L 496 cid 2001and newer	27-881633T01	27- 46820
8M0062849	GM V-8, 8.1-L 496 cid H.O.(High-Output) 2001-up	27-881633T01	27- 46820
MerCruiser 8.2 Liter V-8		Intake Gasket #	Exhaust Gasket #
883282R50	GM V-8, 502 cid (Gen V) carb 1992-1996	27-805722A 1	27- 46820
883282R50	GM V-8, 502 cid (Gen V) MPI 1992-1996	27-805403A 1	27- 46820
8M0062846	GM V-8, 502 cid (Gen VI) 1996 and newer	27-805403A 1	27- 46820

DARE TO COMPARE

DARE TO COMPARE

PARTS



QUICKSILVER®
Remanufacturing

DARE TO COMPARE?

When evaluating the features and benefits of any product it is human nature to put price at the top of the consideration list. Here, at *Quicksilver Remanufacturing* we do too. However, it is our obligation to provide a product that will withstand the rigors of marine use and live-up to the expectations of the customer. With that being said, we are willing to share the very essence of the value we put into each and every engine.

THE PARTS

When searching for a replacement engine, marine dealers sometimes turn to their local machine shop to rebuild a marine engine. Most of these local shops are accustomed to building automotive type engines that utilize components that are lower in price but not suitable for the demands of a marine environment. This results in an engine that may be lower in price but not built to the same quality standards as a Mercury Marine remanufactured engine.

The table below shows the retail prices obtained from a US competitive auto parts chain. Here we compare the high-quality marine parts utilized by *Quicksilver Remanufacturing* and the same parts that would normally be used to rebuild an automotive engine. A 1995 5.7L V-8 was used for this example.

COMPONENT	MARINE	PRICE	AUTOMOTIVE	PRICE
PISTONS	Hypereutectic Teflon Coated Skirt	\$37.99 Each \$303.92 Set	Cast - Std. OEM Truck	\$19.99 Each \$159.92 Set
TIMING SET	Premium Double Roller	\$79.99 Set	Single Roller OEM	\$14.99 Set
VALVES	Stainless Oversize Stem	\$19.99 Each \$319.84 Set	Standard OEM *SEE NOTE - 1	\$6.99 Each \$111.84
VALVE SPRINGS	Heavy Duty	\$97.99 Set	Standard OEM *SEE NOTE - 2	\$36.99 Set
ROD BEARINGS	Premium Grade High Load	\$7.99 Each \$63.92	Standard Automotive	\$2.69 Each \$21.52
MAIN BEARINGS	Premium Grade High Load	\$51.99 Set	Standard Automotive	\$21.99 Set
RING SET	Premium Grade Ductile Iron	\$99.99 Set	Standard Cast Automotive	\$24.99
OIL PUMP	NEW High Volume	\$59.99	Standard OEM * SEE NOTE - 3	\$16.99
HEAD GASKET SET	Marine Quality Stainless rings	\$54.99	Standard OEM Automotive	\$14.99
HEAD BOLTS	NEW	\$49.99 Set	USED	See
ROD BOLTS	NEW	\$49.99 Set	USED	Note – 4
MAIN BOLTS	NEW	\$25.99 Set	USED	
TOTAL RETAIL PRICE	Equivalent to the parts used to build a Mercury Remanufactured Engine.	\$1,258.59	Parts cost to build a comparable automotive engine.	\$424.22

NOTES AND PROCESS

NOTES

1. Most machine shops grind the valves, they don't replace them. At *Quicksilver Remanufacturing*, we replace all the valves - 100%.
2. Most machine shops don't replace the valve springs. Automotive valve springs are not suitable for constant high RPM operation. Again, we replace every valve spring and lock.
3. Some machine shops don't replace the oil pump. Here, all oil pumps are replaced with brand new "high-volume" pumps to make sure the engine receives the best possible interior lubrication.
4. Most machine shops reuse all of the fasteners. At *Quicksilver Remanufacturing*, we replace all critical fasteners.

Interesting Observation:

In the remanufacturing process, additional parts are used to build the total engine. As the previous parts comparison shows, if a local machine/repair shop were to use the same quality parts as *Quicksilver Remanufacturing*, the cost of their engines would be **\$834.37 higher** than the average rebuild price.

THE PROCESS

Remanufacturing an engine to *Mercury Marine's* standards requires a significant investment in specialized equipment, documented process systems, and properly trained employees to consistently bore, hone, machine, clean, assemble, paint, and live-run every engine to provide the quality expected of an original equipment manufacturer. Local machine shops rarely have the necessary equipment or process systems in place to remanufacture a marine engine to this level of quality. These important differences are often overlooked or unknown when comparing engine prices.

Teardown – Cleaning – Inspection:

- Each core engine is completely disassembled, then baked in an oven to burn off the oil, grease and corrosion.
- Next, the castings go through a "hot" high pressure wash to clean the material to a like-new condition. Older methods of shot or bead blasting are no longer utilized as part of the cleaning process, primarily to reduce the possibility of metal debris adhering to the block.
- Then, every component is inspected for cracks and erosion. Cracked or damaged crankshafts, blocks or heads are scrapped, not welded or repaired!
- Each engine goes through a total of four washing procedures throughout the engine-building process.

Machining Blocks:

- Each block is bored to a maximum of 40 thousandths oversize and honed to OEM specifications.
- The deck is machined to ensure a flat sealing surface.
- Crankshaft mains are line-honed.
- Cam bores are also line-honed to eliminate bearing distortion. This important step is often avoided by other engine remanufacturers due to equipment cost and process time.

Cylinder Heads:

- The head surface is machined to ensure a flat sealing surface.
- Hardened exhaust seats are replaced as required and all seats are three-angle ground.
- Valve guides are machined to accept an oversize valve stem. This is a critical process to eliminate stem-to-guide leakage. In an attempt to reduce cost, most competitors and machine shops knurl the valve guides which by Mercury's standards is an unacceptable process. Knurled guides wear quickly and lead to oil consumption and poor performance.

Crankshafts:

- All crankshafts are ground to a maximum of .020 undersize. Crankshafts are never welded to repair damage, they are scrapped.

Connecting Rods:

- All rods are checked for straightness and twist.
- All pin and bearing bores are honed

DARE TO COMPARE

COMPONENTS AND ASSEMBLY

COMPONENTS

- Components are stored on plastic covered racks and containers protected from airborne contamination.
- All purchased components are inspected for contamination and washed prior to assembly. This cleaning process rarely found at any competitor or machine shop.
- All machined components also receive a final wash prior to assembly.

ASSEMBLY

The Environment

- The engine assembly area is located in a separate room away from the machining room. This separation and filtered air circulation reduces the possibility of airborne contamination during the assembly process.

Brass Freeze Plugs

- New brass freeze plugs are installed in the block with a special hydraulic press so that the plugs seat perfectly in the block.

Crankshaft Installation

- The main bearing caps are torqued with a programmed air tool that tightens all bolts on each cap at the same. This is a critical process since it applies equal torque to both sides of the bearing at the same time.
- Both rod bearing studs are also tightened at the same time, to the maximum torque specified.
- The air tool also applies a paint dot to each bolt so it identifies that the part was correctly installed.

Inspection

- During the assembly process blocks are randomly selected to inspect for particulate contamination.
- The block and components are washed and the rinse solution is inspected for contaminant particle count. Complete batches of engines may be rejected if the particle count is beyond acceptable limits.
- Blocks, heads and crankshafts are randomly selected for measurement. The components are place on a computer controlled fixture and automatically measured to ensure that each part meets the OEM specification. A coordinate measuring machine (CMM) accurately measures every dimension and then compares it to the OEM specification.

Final Assembly

- All stages of the final assembly are closely monitored so each engine meets the strict quality standards.
- Each station is equipped with a complete set of documents describing each operation.
- The platforms that carry each engine during assembly are washed after each engine is completed.
- Automated tools are recalibrated regularly and tested to provide accurate installation.

Final Testing

- Every Mercury Marine remanufactured engine is **HOT TESTED** prior to shipment.
- Each engine is fully assembled with a fuel and electrical system. This process is costly and time consuming, but ensures that each engine actually operates properly.
- The engine is placed in a test stand and run up to operating temperature, allowing the gaskets and fasteners to properly seat.
- Oil pressure and flow is checked and documented.
- Each cylinder is compression tested.
- The cooling system is pressurized to operating pressure. Special lighting and a dye is used to check for coolant leaks.
- For future reference computer records are maintained for each engine.

HOT-TEST VS. SPIN-TEST

The value of a HOT-TEST vs. SPIN-TEST!

The majority of engine rebuilders utilize a spin-test to evaluate the quality of their engines. A spin-test simply rotates a cold engine (by the crankshaft) at or near idle speed to check oil pressure and look for gasket leaks. The process is fast and simple, but it lacks several other important aspects of determining engine quality. By running the engine "live," we are certain that the coolant is flowing properly through the block and oil is getting up to the bearings, rocker-arms, and camshaft. Experience has taught us that gaskets will not show evidence of leaking until the engine is up to full operating temperature. A spin-test will not raise the oil temperature high enough to truly determine if the gaskets and seals are doing the job. The majority of local machine shops are not equipped to perform either test.

Like high performance race-engine builders, we perform a hot-test on each and every remanufactured engine to assure the installer and the boat owner that the replacement engine they have selected will be a dependable performer. Very few remanufacturing operations have the ability to actually Hot-Test a longblock engine assembly, but we do!!

At ***QUICKSILVER REMANUFACTURING*** we are proud to be one of the few!

ENGINE IDENTIFICATION SHEET

ENGINE IDENTIFICATION SHEET

4.3L ENGINE IDENTIFICATION

QUICKSILVER®
Remanufacturing



“Identification Tips” for MerCruiser 4.3L Longblocks

1986 – 1992 14149R5

Non-balance shaft, with a mechanical fuel pump, a roller camshaft, and one piece rear seal.

- A. Easily identified by metal 10 bolt short front cover similar to 5.7L.
- B. Some non-balance shaft engines were produced without a manual fuel pump. This engine will fit either application with a fuel pump cover if manual fuel pump is not needed.
- C. All 12 intake manifold bolts are at 90 degree angle to cylinder head machined surface.

1993– 1995 806347R5

Balance shaft, no mechanical fuel pump, roller camshaft one piece rear seal.

- A. Easily identified by tall metal 10 bolt front cover different from 5.7L.
- B. All 12 intake manifold bolts are at 90 degree angle to cylinder head machined surface.

1996– 1998 807736R5

Balance shaft, no mechanical fuel pump, roller camshaft, one piece rear seal, “Vortec” cylinder heads with rocker ball & stud valve train.

- A. “Vortec” heads are easily identified. Only 2 bolts per corner on intake manifold. (8-total).
- B. The older crankshafts rear-flange are 0.123” longer, and have a small pilot bushing hole on the back side.
- C. Plastic 6 bolt front cover.

1999– 2002 864256R05 (MPI) or 862757R01 (Carb/TBI)

Balance shaft, no mechanical fuel pump, roller camshaft, one piece rear seal, “Vortec” cylinder heads with roller rocker arm valve train.

- A. “Vortec” heads are easily identified. Only 2 bolts per corner of intake manifold. (8-total).
- B. The cylinder head actually went to the “roller rocker arm” in 2000. Quicksilver Remanufacturing has elected to change coverage to coincide with the 1998/1999 crankshaft change as the customer would have to change flywheels to coincide with the crankshaft used. The 1999 customers will actually get a product improvement with the roller rocker arms and will not have to make any changes to their current parts.
- C. The crankshaft has a 0.123” shorter rear flange and larger pilot bushing than previous versions.
- D. Plastic 6 bolt front cover.

5.0 / 5.7L ENGINE IDENTIFICATION



“Identification Tips” for MerCruiser 5.0L & 5.7L Longblocks

Over the years there have been several changes to the GM 5.0-Liter and 5.7-Liter engine blocks. Often making it difficult to positively identify which version a technician is working on, and the appropriate parts required to complete any necessary repairs. Hopefully, this will help to take some of the mystery out of the identification process.

1986 & Earlier

- A. All 12 of the intake manifold bolts are installed at a 90-degree angle to the block.
- B. The valve cover bolts are installed at the perimeter of the head.
- C. Crankshafts utilize a 2-piece rear-main seal.
- D. These blocks are machined to operate a mechanical fuel pump.

Note: In 1986 there was a limited production run with a one-piece rear-main seal, perimeter valve-cover bolts, and 90-degree bolt pattern for the intake manifold.

1987 thru 1995

- A. 8 of the 12 intake manifold bolts are installed at a 90-degree angle to the block. The other 4 bolts are installed at a 72-degree angle.
- B. The valve cover bolts are installed in the center of the head.
- C. Crankshafts utilize a 1-piece rear-main seal.
- D. These blocks are machined to operate a mechanical fuel pump.

Note: During 1996 and 1997 the 350-Magnum (carb) and a limited production of the 5.7-Liter EFI throttle body utilized this (non-Gen+) designed roller-cam engine.

1996 & Newer (Gen+)

- A. All 8 intake manifold bolts are installed vertically. (Straight-up and down)
See MerCruiser Service Bulletin # 97-1 for proper torque procedures and specification.
- B. The valve cover bolts are installed in the center of the head.
- C. Crankshafts utilize a 1-piece rear-main seal.
- D. Timing covers are plastic.
- E. Engines are fit with electric fuel pumps.

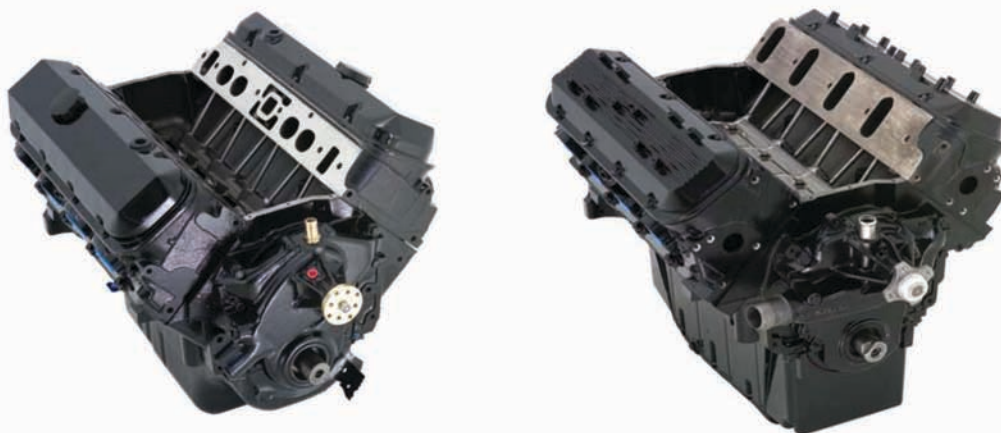
Note 1: During 1996 and 1997 the 350-Magnum (carb) and a limited production of the 5.7-Liter EFI throttle body utilized the 1987 thru 1995 engine block as stated above.

Note 2: During 1996 the 5.7-Liter MPI (multi-port fuel injected) engines were produced with a vapor separator and a mechanical fuel pump. For these applications we recommend installing a **MERCURY** Pro-Series longblock # **860186R50**.

ENGINE IDENTIFICATION SHEET

BIG BLOCK ENGINE IDENTIFICATION

Identification tips for MerCruiser Big Block Engines.

**1991 and earlier Mark IV 454/7.4L**

Two piece rear main seal on crankshaft, $\frac{3}{4}$ in pipe plug in the front and rear of each cylinder head, stamped steel 10 bolt front cover. Stamped Steel valve covers, flat tappet camshaft

1991-1996 Gen V 454/7.4L & 502/8.2L

One piece rear main seal, 10 bolt stamped steel front cover, flat tappet camshaft, cast aluminum valve covers.

1996-2002 Gen VI 454/7.4L & 502/8.2L

One piece rear main seal, 6 bolt cast aluminum front cover, roller camshaft, cast aluminum valve covers

2002-2008 496/8.1L

One piece rear main seal, cast aluminum valve covers with coil bracket mounts, crankshaft position sensor at rear of crankcase, roller camshaft, cast aluminum oil pan.

OIL PRIMING INSTRUCTIONS



Oil System Priming for Remanufactured Engines and Longblocks

All MerCruiser remanufactured 4-cycle engines and longblocks are temporarily fit with electrical, cooling, and fuel systems to perform a series of "Hot-Test" validations for quality control purposes. After the tests, the engine oil drains back into the pan and loses its lubrication value for the bearings, valve-train, and cylinder walls. As shipped, the remanufactured engine or longblock is therefore presumed to be dry.

IMPORTANT: This oil priming procedure is required for all remanufactured engines (including longblocks) prior to initial engine start-up to reduce the potential for premature bearing failures. Evidence of non-compliance could result in the denial of a warranty claim.

There are two methods to prime an engine prior to ignition. Although one is preferred, either may be used.

1. Prime using an engine oil priming tool (available at automotive parts stores; obtain locally). This is the preferred method.
2. Prime using a remote starter switch.

Remote Starter Switch	91- 52024A 1
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Using an Engine Oil Priming Tool

1. Fill the engine crankcase to the proper level with the recommended synthetic blend engine oil.

Qty.	Description	Part Number
AR	Synthetic Blend MerCruiser Engine Oil, FC-W Certified, SAE 25W40	858055QE01

2. Remove the complete distributor assembly, being certain to mark it for proper reinstallation. Refer to the applicable MerCruiser Service Manual for details.
3. Install the oil priming tool into the distributor bore and onto the oil pump shaft.
4. Rotate the oil pump with an electric drill until oil pressure registers on an oil pressure gauge. Oil pressure will typically register within two minutes of running the drill.
5. Remove the priming tool and reinstall the distributor according to instructions provided in the applicable MerCruiser Service Manual.

Using a Remote Starter Switch

1. Fill the engine crankcase to the proper level with the recommended synthetic blend engine oil.

Qty.	Description	Part Number
AR	Synthetic Blend MerCruiser Engine Oil, FC-W Certified, SAE 25W40	858055QE01

2. Remove all spark plugs.
NOTE: Tag spark plug wires with temporary labels, as necessary to ensure that they are reconnected correctly.
3. Disconnect the coil wire from the distributor and connect it to a good ground.
IMPORTANT: Ensure that the ignition key is in the OFF position.
4. Connect the remote starter switch to the large, 12 V terminal (typically a red battery cable) and the small terminal (yellow/red cable) on the starter motor.
IMPORTANT: It is possible to perform this procedure using the boat's key switch instead of a remote starter switch. Should you choose this option, make certain that you disconnect the purple wire from the coil before turning the key. Protect the purple wire's connector with electrical tape to avoid accidentally grounding the wire.
5. Prime the oil pump and passages:
 - a. Crank the engine for approximately 15-18 seconds.
 - b. Let the starter motor cool down for one minute before cycling again.
 - c. Repeat this process until oil pressure registers on an oil pressure gauge. Oil pressure will typically register within six or seven cycles of cranking and cooling the starter motor.
6. Remove the remote starter switch (or reconnect the purple wire to the ignition coil, if using the boat's key switch).
7. Install the spark plugs and plug wires.
NOTE: Ensure that all plug wires are connected to the proper cylinders and that they are correctly routed. Remove any temporary labels.
8. Supply the seawater pump with cooling water.
9. Start the engine to verify oil pressure.

ENGINE BREAK-IN PROCEDURES

**"Break-In" Procedures for 4-cycle MerCruiser Engines**

IMPORTANT: The first 20-hours of operation will have a dramatic affect relative to overall engine performance and expected engine life. Proper break-in practices reduce the potential for excessive oil consumption. It also helps to achieve better engine performance levels for a longer period of time.

FIRST 20-HOURS:

1. Do **NOT** operate the engine below 1500 rpm for extended periods of time. Shift into gear as soon as possible after starting the engine. Advance the throttle above 1500 rpm **if conditions permit safe operation.**
2. Do **NOT** operate at one continuous speed for extended periods of time. Vary the throttle position every ten to fifteen minutes.
3. Do **NOT** exceed $\frac{3}{4}$ throttle during the first 10 hours of operation. During the next 10 hours you may occasionally operate at full throttle for no more than 5-minutes as a time.
4. Do **NOT** operate at full throttle until the engine reaches normal operating temperatures.
5. Avoid full throttle acceleration from an IDLE speed.

AFTER FIRST 20-HOURS:

To help extend the engine life for a remanufactured MerCruiser engine, consider the following recommendations.

1. Install and maintain the correct propeller for the application. Make sure the prop allows the engine to operate at (or near) the top of its specified Wide-Open-Throttle rpm range. Refer to the Owner's Manual, or consult with your marine dealer to determine the correct prop for the application.
2. Refrain from extended periods of Wide-Open-Throttle. We recommend cruising at $\frac{3}{4}$ throttle or below for longer term operation.
3. Change the oil and filter regularly. Refer to the Specifications and Maintenance section of the MerCruiser Owners Guide for recommendations.

MERCRUISER CYLINDER HEADS

INLINE 4-CYLINDER HEADS

CYLINDER HEAD ASSEMBLY



966- 9451R 2

Fully Assembled Remanufactured Cylinder Head.
Assemblies include a freshly machined cylinder head, new stainless steel valves, guides, keepers, and springs. Ready for installation.
Fits MCM 3.7L engine (1976-1989)

CYLINDER HEAD ASSEMBLY



938-884739R01

Fully Assembled Remanufactured Cylinder Head.
Starting with A NEW head casting this assembly includes a new set of stainless steel valves, guides, keepers, and springs. Ready for installation.
Fits MCM 3.0L - 181 cid Non-LX (1990 - 1994)
Fits MCM 3.0LX (1990 - 1997) & MCM 3.0L (1998 & Up)
Note: Can be used to replace the 2.5-Litre head.
Requires use of 27-815528 exhaust manifold gasket.

V-6 CYLINDER HEADS

CYLINDER HEAD ASSEMBLY



938-884740R

Fully Assembled Remanufactured Cylinder Head.
Assembly includes a freshly machined cylinder head, new stainless steel valves, guides, keepers, and springs. Ready for installation.
Fits MCM 4.3L engines (1985-1993)

CYLINDER HEAD ASSEMBLY



938-883296R 1

Fully Assembled Remanufactured Cylinder Head.
Assembly includes a freshly machined cylinder head, new stainless steel valves, guides, keepers, and springs. Ready for installation.
Fits MCM 4.3L Gen II engines w/ balanced shaft(1993-1996)

CYLINDER HEAD ASSEMBLY



938-827178R 1

Fully Assembled Remanufactured Cylinder Head.
Assembly includes a freshly machined cylinder head, new stainless steel valves, guides, keepers, and springs. Ready for installation.
(Special Note: Do not order this head assembly if the engines original cylinder heads included roller-rocker arms.)
Fits(1996-1999) MCM 4.3L Gen+ engines with non-roller rocker arms.

V-8 SMALL-BLOCK CYLINDER HEADS

CYLINDER HEAD ASSEMBLY



938-883490R 1

Fully Assembled Remanufactured Cylinder Head
(Brand new head casting)
Fits MCM/MIE (1987-1996) 5.7L (non-Gen +) engines.

MERCURISER CYLINDER HEADS

CYLINDER HEAD ASSEMBLY



938-883297R 1

Fully Assembled Remanufactured Cylinder Head
Fits 1996 & newer MCM/MIE 5.7L Gen+ engines.
Fits 2000-2009 MCM/MIE 6.2L non-EC engines

V-8 BIG-BLOCK CYLINDER HEADS

CYLINDER HEAD ASSEMBLY



938-883492R 1

Fully Assembled Remanufactured Cylinder Head
Fits (1992-1998) MCM/MIE 7.4L Gen. V & VI engines w/ oval port.

938-884742R

Fully Assembled Remanufactured Cylinder Head
Fits (1998-2001) MCM/MIE 7.4L - L29 engines with D-port exhaust.

CYLINDER HEAD ASSEMBLY



938-883493R 1

Fully Assembled Remanufactured Cylinder Head
Rectangle Port Design.
Fits (1993-2001) MCM 454/502 Mag & MIE 8.2L engines.

CYLINDER HEAD ASSEMBLY

Image not
Available.

938-881684R01

Fully Assembled Remanufactured Cylinder Head
Starboard side

Fits (2001-2010) MCM/MIE 8.1L engines

938-881685R01

Fully Assembled Remanufactured Cylinder Head
Port side
Fits (2001-2010) MCM/MIE 8.1L engines

MERCUISER STERNDRIVES - NEW

STERNDRIVES - ALPHA ONE

NOTE: When using the Alpha One Sterndrive Assembly as a replacement on earlier (pre 1983) 4 & 6 cylinder inline models, it will be necessary to replace the standard yoke with a short U-joint yoke. This yoke is not included and must be removed from the old unit.

ALPHA ONE STERNDRIVE


5-5010130CP

Alpha One
1.30 ratio
Standard Rotation (RH)

5-5010147CP

Alpha One
1.47 ratio
Standard Rotation (RH)

5-5010162CP

Alpha One
1.62 ratio
Standard Rotation (RH)

5-5000162CP

Alpha One
1.62 ratio
Counter Rotation (LH)

5-5010181CP

Alpha One
1.81 ratio
Standard Rotation (RH)

5-5010194CP

Alpha One
1.94 ratio
Standard Rotation (RH)

5-5000194CP

Alpha One
1.94 ratio
Counter Rotation (LH)

STERNDRIVES - ALPHA ONE GEN II

ALPHA ONE GEN II STERNDRIVE


5-5121200TP

Alpha One Gen II
1.47 ratio
Standard Rotation (RH)

5-5111200TP

Alpha One Gen II
1.47 ratio
Counter Rotation (LH)

5-5121300TP

Alpha One Gen II
1.62 ratio
Standard Rotation (RH)

5-5111300TP

Alpha One Gen II
1.62 ratio
Counter Rotation (LH)

5-5121400TP

Alpha One Gen II
1.81 ratio
Standard Rotation (RH),

5-5111400TP

Alpha One Gen II
1.81 ratio
Counter Rotation (LH)

5-5121600TP

Alpha One Gen II
2.00 ratio
Standard Rotation (RH)

5-5111600TP

Alpha One Gen II
2.00:1 Ratio
Counter Rotation (LH)
(s/n 0W535509 and below)

5-5121700TP

Alpha One Gen II
2.40 ratio
Standard Rotation (RH)

MERCUISER STERNDRIVES - NEW

STERNDRIVES - BRAVO ONE (CLASSIC)

Brand new and fresh from the factory, the classic Bravo sterndrive look is still available on selected p/n's. They feature all of the latest improvements to the cone clutch and machining improvements that make Bravo sterndrives best in class for shift smoothness and durable performance.

If the specific drive you are looking for is not listed, please refer to MerCruiser Service Bulletin 2005-11 for alternate options.

BRAVO ONE STERNDRIVE



5-5231100NP

Bravo One
1.36 ratio
with dual water pickup
(s/n 0W249999 and below)

5-5231200NP

Bravo One
1.50 ratio
with dual water pickup
(s/n 0W249999 and below)

5-5231300NP

Bravo One
1.65 ratio
with dual water pickup
(s/n 0W249999 and below)

STERNDRIVES - BRAVO ONE

BRAVO ONE STERNDRIVE



5-5231100TP

Bravo One
1.36 ratio with dual water pickup
(s/n 0W250000 & up)

5-5231200TP

Bravo One
1.50 ratio with dual water pickup
(s/n 0W250000 and up)

5-5231300TP

Bravo One
1.65 ratio with dual water pickup
(s/n 0W250000 and up)

5-5237100TP

Bravo One X
1.36 ratio with dual water pickup
(s/n 0W250000 and up)

5-5237200TP

Bravo One X
1.50 ratio with dual water pickup
(s/n 0W250000 and up)

5-5237300TP

Bravo One X
1.65 ratio with dual water pickup
(s/n 0W250000 and up)

5-5E31900TP

Bravo One XR
1.35 ratio with dual water pickup
(s/n 0W240000 and up)

5-5E31200TP

Bravo One XR
1.50 ratio with dual water pickup
(s/n 0W240000 and up)

STERNDRIVES - BRAVO ONE (SEACORE)

BRAVO ONE STERNDRIVE



5-5J31100TP

Bravo One - SeaCore
1.36 ratio with dual water pickup

5-5J31200TP

Bravo One - SeaCore
1.50 ratio with dual water pickup

5-5J31300TP

Bravo One - SeaCore
1.65 ratio with dual water pickup

5-5J37100TP

Bravo One X - SeaCore
1.36 ratio with dual water pickup

5-5J37200TP

Bravo One X - SeaCore
1.50 ratio with dual water pickup

5-5J37300TP

Bravo One X - SeaCore
1.65 ratio with dual water pickup

STERNDRIVES - BRAVO TWO (CLASSIC)

Brand new and fresh from the factory, the classic Bravo sterndrive look is still available on selected p/n's. They feature all of the latest improvements to the cone clutch and machining improvements that make Bravo sterndrives best in class for shift smoothness and durable performance.

If the specific drive you are looking for is not listed, please refer to MerCruiser Service Bulletin 2005-11 for alternate options.

BRAVO TWO STERNDRIVE



5-5331600LP

Bravo Two
2.00 ratio
(s/n 0W249999 and below)

5-5331500LP

Bravo Two
2.20 ratio
(s/n 0W249999 and below)

STERNDRIVES - BRAVO TWO

BRAVO TWO STERNDRIVE



5-5331200TP

Bravo Two
1.50 ratio
(s/n 0W250000 and up)

5-5331300TP

Bravo Two
1.65 ratio
(s/n 0W250000 and up)

5-5331400TP

Bravo Two
1.81 ratio
(s/n 0W250000 and up)

5-5331600TP

Bravo Two
2.00 ratio
(s/n 0W250000 and up)

5-5331500TP

Bravo Two
2.20 ratio
(s/n 0W250000 and up)

5-5337400TP

Bravo Two X
1.81 ratio
(s/n 0W250000 and up)

5-5337600TP

Bravo Two X
2.00 ratio
(s/n 0W250000 and up)

5-5337500TP

Bravo Two X
2.20 ratio
(s/n 0W250000 and up)

STERNDRIVES - BRAVO TWO (SEACORE)

BRAVO TWO STERNDRIVE



5-5K31400TP

Bravo Two - SeaCore
1.81 ratio

5-5K31600TP

Bravo Two - SeaCore
2.00 ratio

5-5K31500TP

Bravo Two - SeaCore
2.20 ratio

5-5K37400TP

Bravo Two X - SeaCore
1.81 ratio

5-5K37600TP

Bravo Two X - SeaCore
2.00 ratio

MERCUISER STERNDRIVES - NEW

STERNDRIVES - BRAVO THREE (CLASSIC)

Brand new and fresh from the factory, the classic Bravo sterndrive look is still available on selected p/n's. They feature all of the latest improvements to the cone clutch and machining improvements that make Bravo sterndrives best in class for shift smoothness and durable performance.

If the specific drive you are looking for is not listed, please refer to MerCruiser Service Bulletin 2005-11 for alternate options.

BRAVO THREE STERNDRIVE



5-5441400LP

Bravo Three
1.81 ratio
(s/n 0W249999 and below)

5-5441600LP

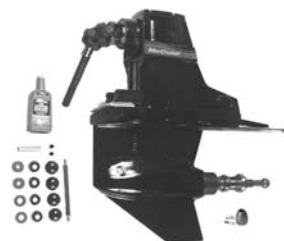
Bravo Three
2.00 ratio
(s/n 0W249999 and below)

5-5441500LP

Bravo Three
2.20 ratio
(s/n 0W249999 and below)

STERNDRIVES - BRAVO THREE

BRAVO THREE STERNDRIVE



5-5441100TP

Bravo Three
1.36 ratio
(s/n 0W250000 and up)

5-5441200TP

Bravo Three
1.50 ratio
(s/n 0W250000 and up)

5-5441300TP

Bravo Three
1.65 ratio
(s/n 0W250000 and up)

5-5441400TP

Bravo Three
1.81 ratio
(s/n 0W250000 and up)

5-5441600TP

Bravo Three
2.00 ratio
(s/n 0W250000 and up)

5-5441500TP

Bravo Three
2.20 ratio
(s/n 0W250000 and up)

5-5441700TP

Bravo Three
2.43 ratio
(s/n 0W250000 and up)

5-5447400TZ

Bravo Three X, dual water pickup
1.81 ratio
(s/n 0W250000 and up)

5-5447600TZ

Bravo Three X, dual water pickup
2.00 ratio
(s/n 0W250000 and up)

5-5447500TZ

Bravo Three X, dual water pickup
2.20 ratio
(s/n 0W250000 and up)

5-5H41300TZ

Bravo Three XR, dual water pickup
1.65 ratio
(s/n 0W240000 and up)

5-5H41400TZ

Bravo Three XR, dual water pickup
1.81 ratio
(s/n 0W240000 and up)

5-5H41600TZ

Bravo Three XR, dual water pickup
2.00 ratio
(s/n 0W240000 and up)

STERNDRIVES - BRAVO THREE (SEACORE)

BRAVO THREE STERNDRIVE



5-5L41300TP

Bravo Three - SeaCore
1.65 ratio

5-5L41400TP

Bravo Three - SeaCore
1.81 ratio

5-5L41600TP

Bravo Three - SeaCore
2.00 ratio

5-5L41500TP

Bravo Three - SeaCore
2.20 ratio

5-5L41700TP

Bravo Three - SeaCore
2.43 ratio

5-5L47400TP

Bravo Three X - SeaCore
1.81 ratio

5-5L47600TP

Bravo Three X - SeaCore
2.00 ratio

5-5L47500TP

Bravo Three X - SeaCore
2.20 ratio

5-5M41600TP

Bravo Three XR - SeaCore
2.00 ratio

DRIVESHAFT HOUSINGS - COMPLETE

NOTE: When using the Alpha One Driveshaft Housing Assembly as a replacement on earlier (pre 1983) 4 & 6 cylinder inline models, it will be necessary to replace the standard yoke with a short U-joint yoke (p/n 39385A 1). This yoke is not included and must be removed from the old unit or ordered separately.

ALPHA ONE DRIVESHAFT HOUSING - COMPLETE

1547- 9412A19

1.32 ratio
Fits MC-I, R, MR & Alpha One

1547- 9412A20

1.50 ratio
Fits MC-I, R, MR & Alpha One

1547- 9412A21

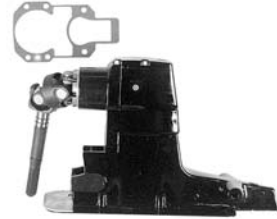
1.65 ratio
Fits MC-I, R, MR & Alpha One

1547- 9412A22

1.84 ratio
Fits MC-I, R, MR & Alpha One

1547- 9412A23

1.98 ratio
Fits MC-I, R, MR & Alpha One

ALPHA ONE GEN II DRIVESHAFT HOUSING - COMPLETE

1547-861063A12

1.47 ratio
Fits Alpha One Gen II

1547-861063A10

1.62 & 2.00 ratios
Fits Alpha One Gen II

1547-861063A 8

1.81 ratio
Fits Alpha One Gen II

1547-861063A 6

1.94 & 2.40 ratio
Fits Alpha One Gen II

BRAVO DRIVESHAFT HOUSING - COMPLETE

1589-863836A50

Fits Bravo I & Perf. (1.36), II (1.50 & 1.81) & III (1.36 & 1.81) (s/n OD469909-0W249999)

1589-863836A51

Fits Bravo I & Perf. (1.50), II (1.65 & 2.00) & III (1.50, 1.65 & 2.00) (s/n OD469920-0W249999)

1589-863836A52

Fits Bravo I & Perf. (1.65), II (2.20) & III (2.20 & 2.43 ratio) (s/n 0W249999 & below)

1589-863836A66

Fits Bravo I X & XZ (1.36), II X (1.50 & 1.81) & III X (1.36 & 1.81) (s/n OM100001-0W249999)

1589-863836A67

Fits Bravo I X & XZ (1.50), II X (1.65 & 2.00) & III X (1.50, 1.65 & 2.00) (s/n OM100001-0W249999)

1589-863836A68

Fits Bravo I X (1.65), II X (2.20) & III X (2.20 & 2.43) (s/n OM100001-0W249999)

MERCUISER STERNDRIVES - NEW

1589-863836A56

Fits Bravo I XR (s/n 0M100001-0W239999)

BRAVO DRIVESHAFT HOUSING - COMPLETE



1589-865440H50

Fits Bravo I (1.36), II (1.50) & III (1.36) (s/n 0W250000 and up)

1589-865440H51

Fits Bravo I (1.50), II (1.65 & 2.00) & III (1.65 & 2.00) (s/n 0W250000 and up)

1589-865440H52

Fits Bravo I (1.65), II (2.20) & III (2.20 & 2.43 ratio) (s/n 0W250000 and up)

1589-865440H01

Fits Bravo II (1.81) & III (1.81) (s/n 0W250000 and up)

1589-865440H02

Fits Bravo III (1.50) (s/n 0W250000 and up)

BRAVO SEACORE DRIVESHAFT HOUSING - COMPLETE

1500-866458J01

SeaCore

Fits Bravo I (1.36), II (1.81) & III (1.36)

1500-866458J02

SeaCore

Fits Bravo I (1.50), II (2.00) & III (1.65 & 2.00)

1500-866458J03

SeaCore

Fits Bravo I (1.65), II (2.20) & III (2.20 & 2.43 ratio)

1500-866458J04

SeaCore

Fits Bravo II (1.81) & III (1.81)

BRAVO X DRIVESHAFT HOUSING - COMPLETE



1589-865440H66

Fits Bravo I X (1.36), II X (1.50 & 1.81) & III X (1.36 & 1.81) (s/n 0W250000 and up)

1589-865440H67

Fits Bravo I X (1.50), II X (1.65 & 2.00) & III X (1.50, 1.65 & 2.00) (s/n 0W250000 and up)

1589-865440H68

Fits Bravo I X (1.65), II X (2.20) & III X (2.20 & 2.43) (s/n 0W250000 and up)

1589-865440H56

Fits Bravo I XR (s/n 0W240000 and up)

1589-865440H73

Fits Bravo I XR with integrated transom (s/n 0W240000 and up)

BRAVO X SEACORE DRIVESHAFT HOUSING - COMPLETE

1500-866459J01

SeaCore

Fits Bravo I X (1.36), II X (1.50 & 1.81) & III X (1.36 & 1.81)

1500-866459J02

SeaCore

Fits Bravo I X (1.50), II X (1.65 & 2.00) & III X (1.50, 1.65 & 2.00)

1500-866459J03

SeaCore

Fits Bravo I X (1.65), II X (2.20) & III X (2.20)

1500-866459J04

SeaCore

Fits Bravo III XR (2.00)

GEAR HOUSINGS - COMPLETE

ALPHA ONE GEAR HOUSING - COMPLETE



1623- 8951A43

Standard Rotation (RH)

Fits R, MR & Alpha One

1623- 8951A33

Counter Rotation (LH)

Fits MR & Alpha One

ALPHA ONE GEN II GEAR HOUSING - COMPLETE



1623-815822A53

1.47, 1.62, 1.81 & 1.94 ratio
Standard Rotation (RH)

Fits Alpha One Gen II

1623-815822A47

1.47, 1.62, 1.81 & 1.94 ratio
Counter Rotation (LH)

Fits Alpha One Gen II

1623-815822A55

2.00 & 2.40 ratio
Standard Rotation (RH)
Fits Alpha One Gen II

1623-815822A52

2.00 ratio
Counter Rotation (LH)
Fits Alpha One Gen II

VAZER GEAR HOUSING - COMPLETE



1623-815822V03

Fits Vazer

BRAVO ONE GEAR HOUSING - COMPLETE



1656- 8866A63

With dual water pickup
1.36, 1.50 & 1.65 ratio
Fits Bravo I (s/n 0D649909 & up) & I X drives

1656- 8866J01

SeaCore
With dual water pickup
1.36, 1.50 & 1.65 ratio
Fits Bravo I & I X drives

1656- 8866A82

With heavy duty propshaft and dual water pickup
Fits Bravo I XR (1.26)

1656- 8866A83

With heavy duty propshaft and dual water pickup
Fits Bravo I XR (1.35)

1656- 8866A62

With heavy duty propshaft and dual water pickup
Fits Bravo I XR (1.50) & XZ (1.36 & 1.50)

BRAVO ONE GEAR HOUSING - COMPLETE



1656- 8866A55

1.36, 1.50 & 1.65 ratio
with low water pickup
Fits Bravo I Performance

1656- 8866A80

With heavy duty propshaft and low water pickup
Fits Bravo I XR (1.26)

1656- 8866A81

With heavy duty propshaft and low water pickup
Fits Bravo I XR (1.35)

1656- 8866A61

With heavy duty propshaft and low water pickup
Fits Bravo I XR (1.50) & XZ (1.36 & 1.50)

BRAVO TWO GEAR HOUSING - COMPLETE



1641- 8294A19

1.50 & 1.65 ratio
Fits Bravo II (s/n 0D469920 & up) & II X

1641- 8294A16

1.81, 2.00 & 2.20 ratio
Fits Bravo II (s/n 0D469920 & up) & II X

1641- 8294J02

SeaCore
1.65 ratio
Fits Bravo II X

1641- 8294J01

SeaCore
1.81, 2.00 & 2.20 ratio
Fits Bravo II & IIX

MERCUISER STERNDRIVES - NEW

BRAVO THREE GEAR HOUSING - COMPLETE



1656- 8866G02

1.36 & 1.50 ratio

Fits Bravo III (s/n 0D784124 and up) & III X

1656-8M0046733

1.36 & 1.50 ratio, dual water pickup

Fits Bravo III X (s/n 0W240000 & up)

1656- 8866G08

1.65 ratio

Fits Bravo III (s/n 0D784124 and up) & III X. Also fits Bravo III XR - 1.65 ratio (0W240000 & up)

1656-8M0046735

1.65 ratio, dual water pickup

Fits Bravo III X/XR (s/n 0W240000 & up)

1656- 8866G09

1.81, 2.00 & 2.20 ratio

Fits Bravo III (s/n 0D784124 and up) & III X. Also fits Bravo III XR - 2.00 ratio (0W240000 & up)

1656-8M0046738

1.81, 2.00 & 2.20 ratio, dual water pickup

Fits Bravo III X (s/n 0W240000 & up). Also fits Bravo III XR - 2.00 ratio (0W240000 & up)

1656- 8866G10

2.43 ratio

Fits Bravo III (s/n 0D784124 and up) & III X

1656-8M0046682

2.43 ratio, dual water pickup

Fits Bravo III X (s/n 0W0240000 & up)

1656- 8866G06

1.81 ratio

Fits Bravo III XR (s/n 0W240000 and up)

1656-8M0046831

1.81 ratio, dual water pickup

Fits Bravo III XR (s/n 0W240000 and up)

1656- 8866J02

SeaCore

1.36 & 1.50 ratio

Fits Bravo III X

1656- 8866J03

SeaCore

1.65 ratio

Fits Bravo III & III X

1656- 8866J09

SeaCore

1.81, 2.00 & 2.20 ratio

Fits Bravo III & III X. Also fits Bravo III XR - 2.00 ratio

1656- 8866J07

SeaCore

1.81ratio

Fits Bravo III XR - 1.81 ratio

1656- 8866J05

SeaCore

2.43 ratio

Fits Bravo III

DRIVESHAFT HOUSINGS - BRAVO (I, II, III)

BRAVO DRIVESHAFT HOUSING ASSEMBLY



1589-863836R50

Remanufactured Bravo I, II, or III Upper
Fits Bravo-One Standard & High Performance (1.36:1 Gear Ratio)
Fits Bravo-Two (1.50:1 & 1.81:1 Gear Ratio(s))
Fits Bravo-Three (1.36:1 & 1.81:1) Gear Ratio(s)
(s/n 0D469909 -0W249999)

1589-863836R51

Remanufactured Bravo I, II, or III Upper
Fits Bravo-One Standard & High Performance (1.50:1 Gear Ratio)
Fits Bravo-Two (1.65:1 & 2.00:1 Gear Ratio(s))
Fits Bravo-Three (1.50:1, 1.65:1 & 2.00:1 Gear Ratio(s))
(s/n 0D469920 -0W249999)

1589-863836R52

Remanufactured Bravo I, II, or III Upper
Fits Bravo-One Standard & High Performance. (1.65:1 Gear-Ratio)
Fits Bravo-Two (2.20:1 Gear-Ratio)
Fits Bravo-Three (2.20:1 & 2.43:1 Gear Ratio(s))
(s/n 0W249999 & below)

1589-863836R67

Remanufactured Bravo Upper
Fits Bravo One- X & XZ (1.50:1 Gear-Ratio)
Fits Bravo Two- X (1.65:1 & 2.00:1 Gear-Ratio(s))
Fits Bravo Three- X (1.50:1, 1.65:1 & 2.00:1 Gear-Ratio(s))
(s/n 0M100001-0W249999)

1589-863836R56

Remanufactured Bravo-One XR Upper
(s/n 0M100001-0W239999)

MERCUISER GEAR HOUSING

MERCUISER GEAR HOUSING

GEAR HOUSING - BRAVO ONE

BRAVO ONE GEAR HOUSING ASSEMBLY



1656- 8866R63

Remanufactured Bravo-One Lower
Standard (right-hand) Rotation
Fits Bravo I Driveshaft Housings with 1.36:1, 1.50:1, 1.65:1 Gear Ratio's.
With dual water pick-up. (s/n 0D469909 & up)

GEAR HOUSING - BRAVO THREE

BRAVO THREE GEAR HOUSING ASSEMBLY



1656- 8866R04

Remanufactured Bravo-Three Lower
Dual Rotation
Fits Bravo Three Driveshaft Housings with 1.81:1, 2.00:1, 2.20:1 Gear Ratio(s)
(SN: 0D784124 and Above)

GEAR HOUSING - BRAVO TWO

BRAVO TWO GEAR HOUSING ASSEMBLY



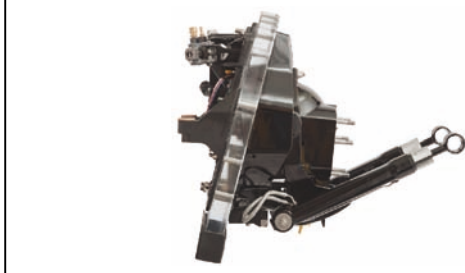
1641- 8294R16

Remanufactured Bravo-Two Lower
Standard (right-hand) Rotation
Fits Bravo II Driveshaft Housings with 1.81:1, 2.00:1, 2.20:1 Gear Ratio(s)
(SN: 0D469920 & Above)

MERCRUISER TRANSOMS - NEW

TRANSOM ASSEMBLY - ALPHA (NEW)

TRANSOM ASSEMBLY



6-601000CP

1990 & older Alpha One

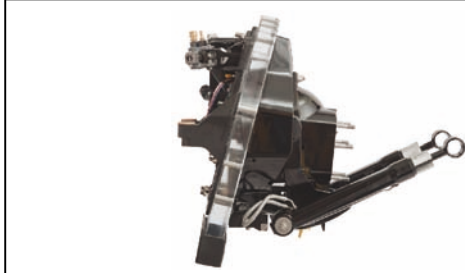
TRANSOM ASSEMBLY

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601000DP

1991-1993 Alpha One Gen II

TRANSOM ASSEMBLY

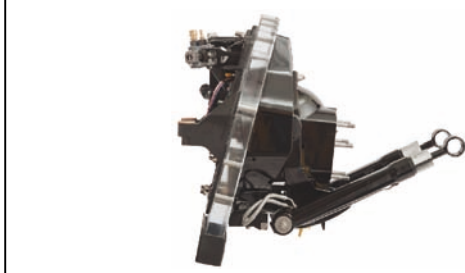


6-6111002LP

1994 & newer Alpha One Gen II

TRANSOM ASSEMBLY - BRAVO (NEW)

TRANSOM ASSEMBLY



6-6211002NZ

Bravo, Standard

6-6311002NZ

Bravo, Magnum

6-6315002TP

Bravo, SmartCraft

TRANSOM ASSEMBLY



6-6511002NZ

Bravo, Heavy Duty

6-6511102NZ

Bravo, Heavy Duty w/ digital sender

TRANSOM ASSEMBLY - BRAVO (SEACORE)-NEW

TRANSOM ASSEMBLY



6-6911002TP

Bravo, Magnum - Seacore

6-6A15002TP

Bravo, SmartCraft - Seacore

TRANSOM ASSEMBLY

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Available.

6-6345002TP

Bravo, Magnum - SeaCore Axis

MERCUISER TRANSOMS - NEW**TRANSOM ADAPTER / STERNDRIVE****TRANSOM ADAPTER KIT****827691A 1**

For use when replacing a Volvo or BMW sterndrive with a standard MerCruiser Alpha or Bravo sterndrive assembly. This kit provides a rugged mounting support that seals the competitors' larger transom cutouts and eliminates costly rework to fiberglass, aluminum, or steel transoms.

INBOARD TRANSMISSION - NEW
ZF/HURTH 630A DOWN ANGLE TRANSMISSION - NEW
TRANSMISSION ASSEMBLY

896346701

Completely dressed, brand new Down-Angle Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Standard (right-hand) Rotation
Replaces ZF / Hurth HSW630A 1 Transmission with 1.50:1 Gear Ratio.

896346702

Completely dressed, brand new Down-Angle Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Standard (right-hand) Rotation
Replaces ZF / Hurth HSW630A 1 Transmission with 2.00:1 Gear Ratio.

896346703

Completely dressed, brand new Down-Angle Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Standard (right-hand) Rotation
Replaces ZF / Hurth HSW630A 1 Transmission with 2.50:1 Gear Ratio.

ZF/HURTH 630 V-DRIVE TRANSMISSION -NEW
TRANSMISSION ASSEMBLY

896346707

Completely dressed, brand new V-Drive Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Standard (right-hand) Rotation
Replaces ZF / Hurth HSW630V1 Transmission with 1.50:1 Gear Ratio.

896346708

Completely dressed, brand new V-Drive Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Standard (right-hand) Rotation
Replaces ZF / Hurth HSW630V1 Transmission with 2.00:1 Gear Ratio.

896346709

Completely dressed, brand new V-Drive Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Standard (right-hand) Rotation
Replaces ZF / Hurth HSW630V1 Transmission with 2.50:1 Gear Ratio.

BORG WARNER / VELVET DRIVE DOWN ANGLE - NEW
TRANSMISSION ASSEMBLY

896346736

Completely dressed, brand new Down-Angle Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Replaces Borg Warner 5000A Series Transmission with 1.25:1 Gear Ratio.

BORG WARNER / VELVET DRIVE DIRECT-ACROSS -NEW
TRANSMISSION ASSEMBLY

896346729

Completely dressed, brand new Direct-Across Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Replaces Borg Warner 71C Series Direct DriveTransmission with 1.00:1 Gear Ratio.

896346731

Completely dressed, brand new Direct-Across Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Replaces Borg Warner 72C Series Direct DriveTransmission with 1.00:1 Gear Ratio.

896346732

Completely dressed, brand new Direct-Across Inboard Transmission. Includes oil cooler, hoses and mounting hardware.
Replaces Borg Warner 72C Series Direct DriveTransmission with 1.50:1 Gear Ratio.

CROSS REFERENCE CHARTS

CROSS REFERENCE CHARTS

ENGINE LONGBLOCK CROSS REFERENCE CHARTS

MerCruiser 3.0L / 181 Longblock

New Quicksilver P/N	Reman Pro-Series
87956A 1	N/A
87959A 1	N/A
805047A 1	N.L.A.
815510A 1	8M0062850
805052A 1	8M0062850
855401A 1	N/A
861633A 1	N/A
862065A 1	N/A
862755A 1	N/A
862755A 2	N/A
863814A 1	N/A
864626A01	N/A
864626A02	N/A

MerCruiser 3.7L / 470 Longblock

New Quicksilver P/N	Reman Pro-Series
72775A 3	N.L.A.
72775A10	N.L.A.
72775A14	N.L.A.
72775A16	N.L.A.

MerCruiser 4.3L / 262 Longblock

New Quicksilver P/N	Reman Pro-Series
9556	14149R50
9690	14149R50
12178A 1	14149R50
12179A 1	14149R50
13409A 1	14149R50
13410A 1	14149R50
14148A 1	14149R50
14149A 1	14149R50
807735A 1	807736R50
861730A 1	807736R50
862756A 1	807736R50
862757A 1	N/A
864256A 1	8M0063328
806346A 1	806347R50
806347A 1	806347R50
879150A31	N/A

MerCruiser 5.0L / 305 Longblock

New Quicksilver P/N	Reman Pro-Series
14153A 1	805636R50
805636A 1	805636R50
861447A 1	N.L.A.

New Quicksilver P/N	Reman Pro-Series
862068A 1	N.L.A.
862758A 1	N.L.A.
863660A 1	N.L.A.
863660A 2	N/A
864651A01	N.L.A.

MerCruiser 5.7L / 350 Longblock

New Quicksilver P/N	Reman Pro-Series
70867A 4	N.L.A.
73131A 3	N.L.A.
76211A 4	N.L.A.
78757A 3	N.L.A.
85400A 1	N.L.A.
87971A 1	N.L.A.
13415A 1	N.L.A.
14152A 1	883944R50
14155A 1	883944R50
14156A 1	N.L.A.
860186A 2	N.L.A.
864652A01	807449R50
821151A 1	807447R50
807447A 1	807447R50
806801A 1	807447R50
807449A 1	807449R 5
862070A 2	807449R50
862760A 2	807449R50
863661A 1	807449R50
807315A 1	883944R50
860183A 1	807447R50
807448A 1	807447R50
863661A 2	N/A
864652A01	807449R50
866138A03	N/A
866138A05	N/A

MerCruiser 6.2L / 377 Longblock

New Quicksilver P/N	Reman Pro-Series
862760A 5	862760R01
862760A 4	862760R01
865108A01	862760R01
863851A 3	N/A
865108A02	N/A
879288A06	N/A

MerCruiser 7.4L / 454 Longblock

New Quicksilver P/N	Reman Pro-Series
78764A 4	N.L.A.
85403A 1	N.L.A.
87974A 1	N.L.A.

New Quicksilver P/N	Reman Pro-Series
15891A 1	N.L.A.
18706A 1	N.L.A.
76279A 3	N.L.A.
78526A 3	N.L.A.
85420A 1	N.L.A.
87989A 1	N.L.A.
76280A 3	N.L.A.
78527A 3	N.L.A.
85423A 1	N.L.A.
87992A 1	N.L.A.
818243A 1	N.L.A.
806352A 1	N.L.A.
806360A 1	N.L.A.
807744A 1	N.L.A.
807744A 3	N.L.A.
818242R 1	806351R50
806351A 1	806351R50
807162A 1	N.L.A.
807739A 1	N.L.A.
861097A 1	883281R50
861097A 2	883281R50
807161A 1	806351R50
805540A 1	806351R50
806359A 1	806351R50

MerCruiser 8.1L / 496 Longblock

New Quicksilver P/N	Reman Pro-Series
862762A 1	8M0062848
863815A 1	8M0062848
863815A02	8M0062848
865273A01	8M0062848
865519A01	8M0062848
865752A01	8M0062848
862764A 1	8M0062849
863817A 1	8M0062849
863817A02	8M0062849
865275A01	8M0062849
865521A01	8M0062849
865754A01	8M0062849

MerCruiser 8.2L / 502 Longblock

New Quicksilver P/N	Reman Pro-Series
805539A 1	883282R50
806353A 1	883282R50
806361A 1	883282R50
807745A 1	8M0062846
807745A 3	8M0062846
807745A05	8M0062846
841178A 1	841178R02
841178A05	841178R06
844200A08	844200R09
844500A 8	844500R09
844575A 7	844575R08

New Quicksilver P/N	Reman Pro-Series
848170R09	848170R09
8M0045344	N/A

DRIVESHAFT HOUSING CROSS REFERENCE CHARTS**MerCruiser Driveshaft Housings**

New P/N	Reman P/N
5523A 2	N.L.A.
8265A15	N.L.A.
9412A20	N.L.A.
9412A22	N.L.A.
861063A10	N.L.A.
815930A15	N.L.A.
815930A 5	N.L.A.
861063A 8	N.L.A.
815930A14	N.L.A.
815930A 4	N.L.A.
861063A 6	N.L.A.
815930A13	N.L.A.
815930A 3	N.L.A.
863836A50	1589-863836R50
8868G93	1589-863836R50
8868G63	1589-863836R50
863836A51	1589-863836R51
8868G19	1589-863836R51
8868G11	1589-863836R51
863836A52	1589-863836R52
8868H88	1589-863836R52
8868G17	1589-863836R52
863836A67	1589-863836R67
863836A54	1589-863836R67
8868H82	1589-863836R67
863836A56	N.L.A.
8868H80	N.L.A.

MERCURISER GEAR HOUSING CROSS REFERENCE CHART**MerCruiser Gear Housing Assembly**

New P/N	Reman P/N
4110A 4	N.L.A.
4110A 6	N.L.A.
815822A 5	N.L.A.
815822A 7	N.L.A.
815822A32	N.L.A.
815822A33	N.L.A.
815822A43	N.L.A.
815822A47	N.L.A.
815822A53	N.L.A.

CROSS REFERENCE CHARTS

New P/N	Reman P/N
8294A16	1641- 8294R16
8866A15	1656- 8866R63
8866A20	1656- 8866R04
8866A35	1656- 8866R04
8866A63	1656- 8866R63
8866A67	1656- 8866R04
8866G04	1656- 8866R04
8951A23	N.L.A.
8951A26	N.L.A.
8951A33	N.L.A.
8951A43	N.L.A.

New P/N	Reman P/N
807481A 6	807481R56
807481A 7	807481R57

INBOARD TRANSMISSION CROSS REFERENCE CHARTS

MerCruiser Inboard Transmissions

New P/N	Reman P/N
ZF-Hurth Down Angle Transmissions	
18900A 1	N.L.A.
18901A 1	863744R03
18902A 1	863744R04
862220A 1	863744R05
863744T 3	863744R04
863744T 4	863744R04
863744T 5	863744R05
ZF-Hurth V-Drive Transmissions	
814437A 1	863745R02
814438A 1	863745R03
814439A 1	863745R04
863745T 2	863745R02
863745T 3	863745R03
863745T 4	863745R04
Borg-Velvet / Direct Across Transmission	
47805	879317004
47806	47806R07
47810	N.L.A.
47811	47811R07
47805A 7	879317004
47806A 7	47806R07
47810A19	N.L.A.
47811A 7	47811R07
Borg-Velvet / Down Angle Transmission	
805495A 4	805495R58
805495A 5	805495R59
805495A 6	805495R57
805495A 7	805495R60
Borg-Velvet / V-Drive Transmission	
807481A 5	807481R55

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1641- 8294A19	43	5 -5010162CP	37
1641- 8294J01	43	5 -5010181CP	37
1641- 8294J02	43	5 -5010194CP	37
1641- 8294R16	46, 52	5 -5111200TP	37
1656- 8866A55	43	5 -5111300TP	37
1656- 8866A61	43	5 -5111400TP	37
1656- 8866A62	43	5 -5111600TP	37
1656- 8866A63	43	5 -5121200TP	37
1656- 8866A80	43	5 -5121300TP	37
1656- 8866A81	43	5 -5121400TP	37
1656- 8866A82	43	5 -5121600TP	37
1656- 8866A83	43	5 -5121700TP	37
1656- 8866G02	44	5 -5231100NP	38
1656- 8866G06	44	5 -5231100TP	38
1656- 8866G08	44	5 -5231200NP	38
1656- 8866G09	44	5 -5231200TP	38
1656- 8866G10	44	5 -5231300NP	38
1656- 8866J01	43	5 -5231300TP	38
1656- 8866J02	44	5 -5237100TP	38
1656- 8866J03	44	5 -5237200TP	38
1656- 8866J05	44	5 -5237300TP	38
1656- 8866J07	44	5 -5331200TP	39
1656- 8866J09	44	5 -5331300TP	39
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1623- 8951A33	42	5 -5331500TP	39
1623- 8951A43	42	5 -5331600LP	39
1547- 9412A19	41	5 -5331600TP	39
1547- 9412A20	41	5 -5337400TP	39
1547- 9412A21	41	5 -5337500TP	39
1547- 9412A22	41	5 -5337600TP	39
1547- 9412A23	41	5 -5441100TP	40
966- 9451R 2	35	5 -5441200TP	40
27 - 11977	20, 25	5 -5441300TP	40
14149R50	11, 15, 16, 20, 25, 50	5 -5441400LP	40
14156R50	25	5 -5441400TP	40
14865A 1	6	5 -5441500LP	40
14865A02	5	5 -5441500TP	40
27 - 17145	25	5 -5441600LP	40
27 - 33395	22, 23, 25	5 -5441600TP	40
27 - 34213	20	5 -5441700TP	40
27 - 46820	23, 24, 25	5 -5447400TZ	40
47806R07	52	5 -5447500TZ	40
47811R07	52	5 -5447600TZ	40
27 - 53045 1	22, 23	5 -5E31200TP	38
27 - 68715	25	5 -5E31900TP	38
27 - 70905	25	5 -5H41300TZ	40
93320A13	5	5 -5H41400TZ	40
93322A12	5	5 -5H41600TZ	40
27 - 96429	25	5 -5J31100TP	38
27 - 99757	19, 20, 21, 22, 25	5 -5J31200TP	38
5 -5000162CP	37	5 -5J31300TP	38
5 -5000194CP	37	5 -5J37100TP	38
5 -5010130CP	37	5 -5J37200TP	38

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5 -5K31500TP	39	827691A 1	48
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6 -6111002LP	47	1547-861063A10	41
6 -6211002NZ	47	1547-861063A12	41
6 -6311002NZ	47	862354A04	5
6 -6315002TP	47	862760R01	12, 18, 25, 50
6 -6345002TP	47	50 -863007A 1	19, 20, 21, 22, 23, 24
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6 -6511102NZ	47	863660A 2	14, 16, 22
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6 -6A15002TP	47	863744R03	52
27 -803184	25	863744R04	52
27 -805403A 1	25	863744R05	52
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27 -805722A 1	25	1589-863836A51	41
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27 -814680 1	20	864652A01	14, 17, 18
27 -815528	20, 25	864908A 1	5
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