

Maxi Models

Fastener Location	Merc 800 Merc 850 Merc 850XS		Merc 900 Merc 1150 Merc 1400		Merc 1500 Merc 1500XS		Merc 1500 (V-6's) Merc 1750 Merc 2000	
	Size	Torque	Size	Torque	Size	Torque	Size	Torque
	1 Flywheel Nut	5/8-18	100 Ft. Lbs. (13.83mkg)	5/8-18	100 Ft. Lbs. (13.83mkg)	5/8-18	100 Ft. Lbs. (13.83mkg)	5/8-18
2 Crankcase to Cylinder Block Screws	5/16-18 5/16-24	200 In. Lbs. (230kg-cm)	5/16-18 5/16-24	200 In. Lbs. (230kg-cm)	5/16-18 5/16-24	200 In. Lbs. (230kg-cm)	3/8-18	34 Ft. Lbs. (4.70mkg)
3 Crankcase to Cylinder Block Screws	---	---	---	---	---	---	5/16-18	210 In. Lbs. (242kg-cm)
4 Cylinder Block Cover	1/4-20 1/4-28	85 In. Lbs. (98kg-cm)	1/4-20 1/4-28	85 In. Lbs. (98kg-cm)	1/4-20 1/4-28	85 In. Lbs. (98kg-cm)	5/16-18	---
5 Cylinder Head Cover Mounting Screws	---	---	---	---	---	---	5/16-18	150 In. Lbs. (173kg-cm)
6 Cylinder Head Mounting Screws	---	---	---	---	---	---	3/8-16	30 Ft. Lbs. (4.15mkg)
7 Exhaust Manifold Cover Screws	5/16-18	250 In. Lbs. (288kg-cm)	5/16-18	250 In. Lbs. (288kg-cm)	5/16-18	250 In. Lbs. (288kg-cm)	5/16-18	180 In. Lbs. (207kg-cm)
8 Water Jacket Cover Screws	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	150 In. Lbs. (173kg-cm)	---	---
9 End Cap Screws (Upper and Lower)	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	150 In. Lbs. (173kg-cm)	---	---
10 End Cap Screws (Lower)	---	---	---	---	---	---	1/2-20	60 In. Lbs. (69kg-cm)
11 End Cap Screws (Upper)	---	---	---	---	---	---	5/16-18	150 In. Lbs. (173kg-cm)
12 Thermostat Cover Screws	---	---	---	---	---	---	5/16-18	150 In. Lbs. (173kg-cm)
13 Transfer Port Cover Screws	1/2-20	85 In. Lbs. (98kg-cm)	1/2-20	85 In. Lbs. (98kg-cm)	1/2-20	85 In. Lbs. (98kg-cm)	---	---
14 Connecting Rod Nuts □	1/2-28	180 In. Lbs. (207kg-cm)	1/2-28	180 In. Lbs. (207kg-cm)	1/2-28	180 In. Lbs. (207kg-cm)	5/16-24	30 Ft. Lbs. (4.15mkg) △
15 Reed Stop Retaining Screws	10-32	25 In. Lbs. (29kg-cm)	10-32	25 In. Lbs. (29kg-cm)	10-32	25 In. Lbs. (29kg-cm)	8-32	25 In. Lbs. (29kg-cm)
16 Reed Block Housing Mounting Screws	---	---	---	---	---	---	1/2-20	60 In. Lbs. (69kg-cm)
17 Reed Block Mounting Screws	---	---	---	---	---	---	1/2-20	60 In. Lbs. (69kg-cm)
18 Poppet Valve Cover Screws	---	---	---	---	---	---	5/16-18	150 In. Lbs. (173kg-cm)
19 Coil Terminal Nuts	10-32	20 In. Lbs. (23kg-cm)	10-32	20 In. Lbs. (23kg-cm)	10-32	20 In. Lbs. (23kg-cm)	10-32	20 In. Lbs. (23kg-cm)
20 Distributor Cap Clamp	8-32	60 In. Lbs. (69kg-cm)	8-32	60 In. Lbs. (69kg-cm)	8-32	60 In. Lbs. (69kg-cm)	---	---
21 Distributor Pulley Flange Screw	10-32	60 In. Lbs. (69kg-cm)	10-32	60 In. Lbs. (69kg-cm)	10-32	60 In. Lbs. (69kg-cm)	---	---
22 Distributor Shaft Nut	5/16-18	70 In. Lbs. (81kg-cm)	5/16-18	70 In. Lbs. (81kg-cm)	5/16-18	70 In. Lbs. (81kg-cm)	---	---
23 Stator Mounting Screws	10-24 10-32	60 In. Lbs. (69kg-cm)	10-24 10-32	60 In. Lbs. (69kg-cm)	10-24 10-32	60 In. Lbs. (69kg-cm)	10-24	30 In. Lbs. (35kg-cm)
24 Spark Plug	14mm	20 Ft. Lbs. (2.77mkg)	14mm	20 Ft. Lbs. (2.77mkg)	14mm	20 Ft. Lbs. (2.77mkg)	14mm	20 Ft. Lbs. (2.77mkg)
25 Starter Motor to Crankcase	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	150 In. Lbs. (173kg-cm)	5/16-18	180 In. Lbs. (207kg-cm)
26 Starter Motor to Mounting Bracket Nuts	1/2-20	85 In. Lbs. (98kg-cm)	---	---	---	---	---	---
27 Carburetor Mounting Nuts	5/16-18 5/16-24	100 In. Lbs. (115kg-cm)	5/16-24	150 In. Lbs. (173kg-cm)	---	150 In. Lbs. (173kg-cm)	1/2-28	180 In. Lbs. (207kg-cm)
28 Carburetor Interconnect Link Screws	10-32	35 In. Lbs. (40kg-cm)	10-32	35 In. Lbs. (40kg-cm)	10-32	35 In. Lbs. (40kg-cm)	---	---
29 Fuel Pump Attaching Screws	1/2-20	85 In. Lbs. (98kg-cm)	1/2-20	85 In. Lbs. (98kg-cm)	5/16-24	85 In. Lbs. (98kg-cm)	10-32	25 In. Lbs. (29kg-cm)
30 Powerhead to Drive Shaft Housing Plate	3/8-24	45 Ft. Lbs. (6.22mkg)	3/8-24	45 Ft. Lbs. (6.22mkg)	3/8-24	45 Ft. Lbs. (6.22mkg)	---	---
31 Powerhead to Exhaust Extension Plate	3/8-24	20 Ft. Lbs. (2.77mkg)	3/8-24	20 Ft. Lbs. (2.77mkg)	3/8-24	20 Ft. Lbs. (2.77mkg)	3/8-24	45 Ft. Lbs. (6.22mkg)

□ Clean nut and bolt in solvent, dry with compressed air and torque while dry.

△ Clean nut and bolt in solvent, dry with compressed air and torque, using Loctite.

Maxi Models

Fastener Location	Merc 800 Merc 850 Merc 850XS		Merc 900 Merc 1150 Merc 1400		Merc 1500 Merc 1500XS		(V-6's) Merc 1500 Merc 1750 Merc 200 ¹	
	Size	Torque	Size	Torque	Size	Torque	Size	Torque
32 Clamp Bracket Stud	5/16-24	80 In. Lbs. (92kg-cm)	5/16-24	80 In. Lbs. (92kg-cm)	5/16-24	80 In. Lbs. (92kg-cm)	----	----
33 Cylinder Block to Exhaust Extension Plate	3/8-24	20 Ft. Lbs. (2.77mkgl)	3/8-24	20 Ft. Lbs. (2.77mkgl)	3/8-24	20 Ft. Lbs. (2.77mkgl)	3/8-24	45 Ft. Lbs. (6.22mkgl)
34 Exhaust Extension Plate to Drive Shaft Housing Plate Screws	5/16-18	40 Ft. Lbs. (5.53mkgl)	5/16-18	40 Ft. Lbs. (5.53mkgl)	5/16-18	40 Ft. Lbs. (5.53mkgl)	5/16-18	20 Ft. Lbs. (2.77mkgl)
35 Lower Mount Cover Screws	5/16-18	160 In. Lbs. (184kg-cm)	5/16-18	160 In. Lbs. (184kg-cm)	5/16-18	160 In. Lbs. (184kg-cm)	----	----
36 Upper and Lower Shock Mounting Pin Screws	1/2-20	50 Ft. Lbs. (6.92mkgl)	1/2-20	50 Ft. Lbs. (6.92mkgl)	1/2-20	50 Ft. Lbs. (6.92mkgl)	----	----
37 Megaphone to Drive Shaft Housing Plate Screws	1/2-20	70 In. Lbs. (81kg-cm)	1/2-20	70 In. Lbs. (81kg-cm)	1/2-20	70 In. Lbs. (81kg-cm)	----	----
38 Cylinder Block to Drive Shaft Housing Plate	3/8-24	45 Ft. Lbs. (6.22mkgl)	3/8-24	45 Ft. Lbs. (6.22mkgl)	3/8-24	45 Ft. Lbs. (6.22mkgl)	----	----
39 Drive Shaft Housing Plate to Drive Shaft Housing Screws	5/16-24	40 Ft. Lbs. (5.53mkgl)	5/16-18 5/16-24	40 Ft. Lbs. (5.53mkgl)	5/16-18 5/16-24	40 Ft. Lbs. (5.53mkgl)	3/8-16	30 Ft. Lbs. (4.15mkgl)
40 Shock Mount to Bottom Yoke	----	----	----	----	----	----	1/2-20	50 Ft. Lbs. (6.92mkgl)
41 Shock Mount Clamp Casting (Lower) Mounting Screws	----	----	----	----	----	----	5/16-18	160 In. Lbs. (184kg-cm)
42 Shock Mount to Steering Arm (Upper) Nuts	----	----	----	----	----	----	7/16-20	50 Ft. Lbs. (6.92mkgl)
43 Manifold Cover Mounting Screw	----	----	----	----	----	----	10-24	25 In. Lbs. (29kg-cm)
44 Manifold Cover Mounting Screw	----	----	----	----	----	----	1/2-20	5 Ft. Lbs. (.69mkgl)
45 Trim Cylinder Pivot Screw	----	----	----	----	----	----	7/16-20	40 Ft. Lbs. (4.41mkgl)
46 Trim Cylinder Shaft Cover Screws	----	----	----	----	----	----	1/2-20	5 Ft. Lbs. (.69mkgl)
47 Hydraulic Line Fittings	----	----	----	----	----	----	3/8-24	60 In. Lbs. (69kg-cm)

GEAR HOUSING TORQUE SPECIFICATIONS

Mini Models

Fastener Location	Merc 200		Merc 45		Merc 75		Merc 110		Merc 40	
	Size	Torque	Size	Torque	Size	Torque	Size	Torque	Size	Torque
Water Pump Nuts	5/16-24	40 In. Lbs. (46kg-cm)	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)	10-32	20 In. Lbs. (23kg-cm)
Bearing Carrier Nut	2¼"-16	100 Ft. Lbs. (13.83mkg)	2¼"-16	60 Ft. Lbs. (8.30mkg)	2¼"-16	60 Ft. Lbs. (8.30mkg)	2¼"-16	60 Ft. Lbs. (8.30mkg)	2-1/8"-16	40 Ft. Lbs. (5.53mkg)
Pinion Nut	¼-28	115 In. Lbs. (132kg-cm)	12-28	90 In. Lbs. (104kg-cm)	12-28	90 In. Lbs. (104kg-cm)	12-28	90 In. Lbs. (104kg-cm)	----	----
Gear Housing to Drive Shaft Housing Nuts/Bolts	5/16-24	35 Ft. Lbs. (4.84mkg)	5/16-24	35 Ft. Lbs. (4.84mkg)	5/16-24	35 Ft. Lbs. (4.84mkg)	5/16-24	35 Ft. Lbs. (4.84mkg)	5/16-24	140 In. Lbs. (162kg-cm)
Gear Housing to Drive Shaft Housing Nuts	3/8-24	55 Ft. Lbs. (7.61mkg)	3/8-24	30 Ft. Lbs. (4.15mkg)	3/8-24	30 Ft. Lbs. (4.15mkg)	3/8-24	30 Ft. Lbs. (4.15mkg)	----	----
Sacrificial Plate Screw	5/16-18 7/16-14	130 In. Lbs. (150kg-cm)	----	----	----	----	----	----	----	----
Ball Bearing Retaining Nut	----	----	----	----	----	----	----	----	1-20	30 Ft. Lbs. (4.15mkg)
Propeller Locknut	----	----	----	----	----	----	----	----	5/16-24	60 In. Lbs. (69kg-cm)

Fastener Location	Merc 402		Merc 500		Merc 650/700	
	Size	Torque	Size	Torque	Size	Torque
Water Pump Nuts	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)
Water Pump Nuts	5/16-24	40 In. Lbs. (46kg-cm)	5/16-24	40 In. Lbs. (46kg-cm)	5/16-24	40 In. Lbs. (46kg-cm)
Bearing Carrier Nut	3-1/8"-12	110 Ft. Lbs. (15.21mkg)	3-1/8"-12	110 Ft. Lbs. (15.21mkg)	3-1/8"-12	110 Ft. Lbs. (15.21mkg)
Pinion Nut	¼-20	45 Ft. Lbs. (6.22mkg)	¼-20	45 Ft. Lbs. (6.22mkg)	¼-20	45 Ft. Lbs. (6.22mkg)
Gear Housing to Drive Shaft Housing Nuts and Bolt	3/8-24	55 Ft. Lbs. (7.61mkg)	3/8-24	55 Ft. Lbs. (7.61mkg)	3/8-24	55 Ft. Lbs. (7.61mkg)
Gear Housing to Drive Shaft Housing Nuts	7/16-20	65 Ft. Lbs. (8.99mkg)	7/16-20	65 Ft. Lbs. (8.99mkg)	7/16-20	65 Ft. Lbs. (8.99mkg)
Trim Tab Screw	7/16-14	25 Ft. Lbs. (3.46mkg)	7/16-14	25 Ft. Lbs. (3.46mkg)	7/16-14	25 Ft. Lbs. (3.46mkg)

Midi Models

Fastener Location	Merc 800 Merc 850 Merc 850XS		Merc 900 Merc 1150 Merc 1400		Merc 1500 Merc 1500XS		Merc 1500 (V-6) Merc 1750 Merc 2000	
	Size	Torque	Size	Torque	Size	Torque	Size	Torque
48 Water Pump Nuts	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)	¼-28	30 In. Lbs. (35kg-cm)
49 Water Pump Nuts	5/16-24	40 In. Lbs. (46kg-cm)	5/16-24	40 In. Lbs. (46kg-cm)	5/16-24	40 In. Lbs. (46kg-cm)	5/16-24	40 In. Lbs. (46kg-cm)
50 Water Pump Screw	¼-20	20 In. Lbs. (23kg-cm)	¼-20	20 In. Lbs. (23kg-cm)	¼-20	20 In. Lbs. (23kg-cm)	¼-20	20 In. Lbs. (23kg-cm)
51 Bearing Carrier Nut	4"-16	210 Ft. Lbs. (29.04mkg)	4"-16	210 Ft. Lbs. (29.04mkg)	4"-16	210 Ft. Lbs. (29.04mkg)	4-3/8"-16	210 Ft. Lbs. (29.04mkg)
52 Pinion Nut	5/8-18	70 Ft. Lbs. (9.68mkg)	5/8-18	70 Ft. Lbs. (9.68mkg)	5/8-18	70 Ft. Lbs. (9.68mkg)	5/8-18	70 Ft. Lbs. (9.68mkg)
53 Gear Housing to Drive Shaft Housing Nuts	3/8-16 3/8-24	55 Ft. Lbs. (7.61mkg)	3/8-16 3/8-24	55 Ft. Lbs. (7.61mkg)	3/8-16 3/8-24	55 Ft. Lbs. (7.61mkg)	3/8-16	55 Ft. Lbs. (7.61mkg)
54 Gear Housing to Drive Shaft Housing Nuts/Bolts	7/16-20	65 Ft. Lbs. (8.99mkg)	7/16-20	65 Ft. Lbs. (8.99mkg)	7/16-20	65 Ft. Lbs. (8.99mkg)	7/16-20	65 Ft. Lbs. (8.99mkg)
55 Trim Tab Screw	7/16-24	25 Ft. Lbs. (3.46mkg)	7/16-24	25 Ft. Lbs. (3.46mkg)	7/16-24	25 Ft. Lbs. (3.46mkg)	7/16-14	25 Ft. Lbs. (3.46mkg)

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