MERCURY

Mercury Marine Div. Brunswick Corp. Fond du Lac, Wisconsin 54935

TWO-CYLINDER MODELS

Year Produced										
	C									
-1984 - 1986		. 345								

CONDENSED SERVICE DATA

TUNE-UP
Hp/rpm.
Model 35
Models 40, 400 & 402
Bore
(72.9 mm)
Stroke
(65.1 mm)
Displacement
(5-66 cc)
Compression At Cranking Speed
AC
Champion L76V
Electrode Gap Surface Gap
Ignition:
Type
Tragger Gap (Model 400) 0.050-0.060 in.
(1.27-1.52 mm)
Carburetor Pickup Timing See Text
Maximum Advance
Fuel:0il Ratio See Text
*Not more than 15 psi (103.5 kPa) variations between cylinders.
†AC type M40FFX spark plugs gapped at 0.030 inch (0.76
mm) are recommended for use on 1971 400 models if rough
low speed operation is noted.
SIZES-CLEARANCES
Piston Rings:
End Gap
Side Clearance

Crankshaft Bearings:	the later was the first two contracts
Top Main Bearing	Rushing With Reed Valve Ball Bearing
Cranlepin Piston Pin Bearing In Rod Number of Rollers Per Rod	Loose Rollers
*Publication not authorized by may	nufacturer.
TIGHTENING TORQUES	
Connecting Rod	
	(200.3 N+m)
Crankcase Screws	
CONTRACTOR	(22.6 N·m)
Cylinder Cover: 35 HP	7.000 (m. 10m)
20 HF	(11.3 N·m)
40 HP	
	1977 (4) NO a least V
Exhaust Cover	
	1900 St. March V.
Flywheel Nut	
	(95.2-102 N·m)
Reed Screws	
Spark Plags	(2.8 N·m)
Spark raigs	(27.1 N·m)
Tennelor Doet Corner	Carron 14 1002
	50 in albs
	(5.6 N·m)
40 HP	
	(6.8 N·m)
Transfer Port Cover: 25 HP	.50 inlbs (5.6 N·m 60 inlbs

SIZES-CLEARANCES CONT.

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