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# FLYWHEEL HOUSING MOUNT KIT

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## Models Covered

### ALPHA AND BRAVO - 865329A02

Model	Serial Number or Year
3.0 liter (181 cid), 4.3 liter (262 cid), 5.0 liter (305 cid), 5.7 liter (350 cid), 6.2 liter (377 cid)	All

### BRAVO - 865330A02

Model	Serial Number or Year
7.4 liter (454 cid), 8.1 liter (496 cid), 8.2 liter (502 cid)	All
Bravo sterndrive diesel	

## Notice

NOTICE
After completing installation, these instructions should be placed with the product for the owner's future use.

NOTICE ABOUT THIS DOCUMENT
This document is written to aid our dealers and company service personnel in the proper installation or service of our products. Persons who are not familiar with these or similar products produced by Mercury Marine, and who have not been trained in the recommended servicing or installation procedures should have the work performed by an authorized Mercury Marine dealer technician. Improper installation or servicing of the Mercury product could result in damage to the product or personal injury to the installer or persons operating the product.

## Parts List

**IMPORTANT:** When applicable, these new design flywheel housing mounts may supercede previous mounts with minor changes to the mounting hardware on the inner transom plate. When using these new design mounts, proper engine and sterndrive unit alignment requires the removal of the double-wound lockwashers on the inner transom plate before the engine is installed.

**NOTE:** Refer to Models Covered for application information.

### 865329A02

Description	Qty.	Part Number
Rubber mount assembly	2	865329
Mount spacer	2	23-99322
Fiber washer	2	12-32834
Stainless steel washer	2	12 54012

### 865330A02

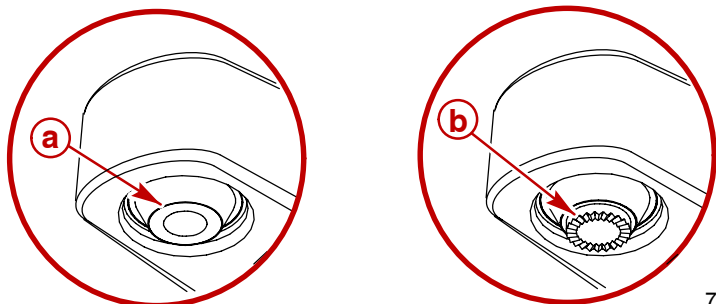
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## Identification

### ⚠ CAUTION

Avoid product damage caused by improper engine alignment. Improper engine alignment can be caused by mismatched flywheel housing mounts and inner transom plate mounting hardware. Ensure that the flywheel housing mounts and the inner transom plate mounting hardware, port and starboard, are the correct parts and match before installing the engine.

Early style flywheel housing mounts have a smooth bottom edge. New design mounts have a knurled bottom edge.



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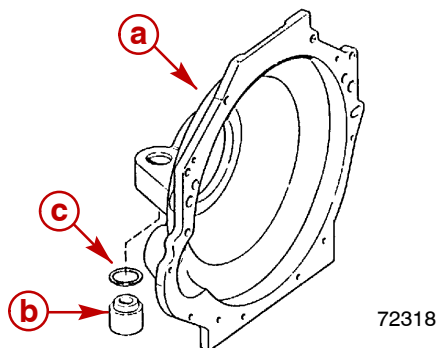
#### Typical flywheel housing transom mounting supports

- a** - Early style mount - smooth edge
- b** - New design mount - knurled edge

If replacing an early style mount with a new design mount it will be necessary to replace both port and starboard flywheel housing mounts to avoid engine misalignment.

## Removal

1. Refer to the appropriate Mercury MerCruiser or Cummins MerCruiser Diesel service manual and remove the flywheel housing.
2. Remove the flywheel housing (rear engine) mounts and mount spacers using a suitable mandrel and press.



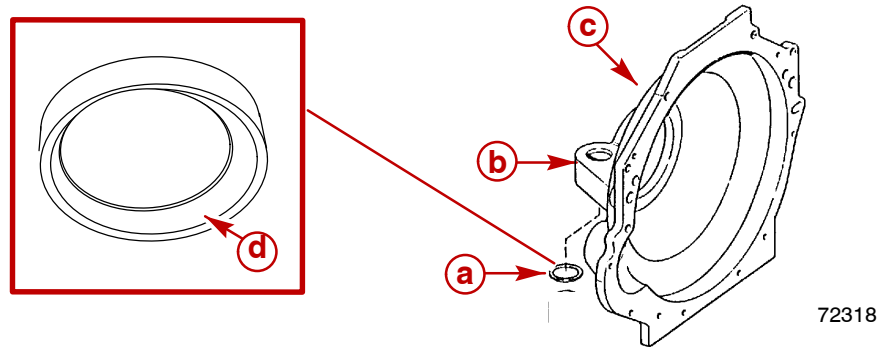
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#### Typical flywheel housing starboard side, port similar

- c** - Flywheel housing
- d** - Flywheel housing mount
- e** - Mount spacer

# Installation

1. Install the mount spacers into the transom mounting supports of the flywheel housing. Ensure that the chamfered inner diameter faces the mount when installed.

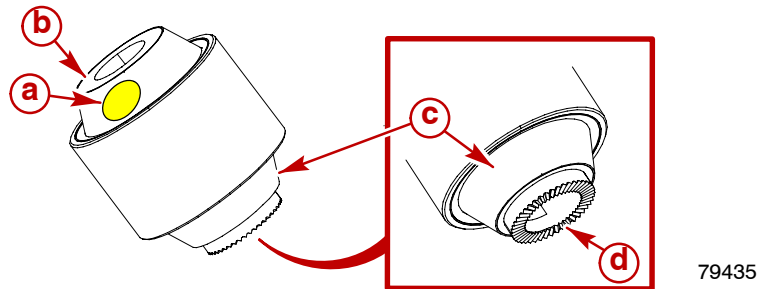


**Typical flywheel housing starboard side, port similar**

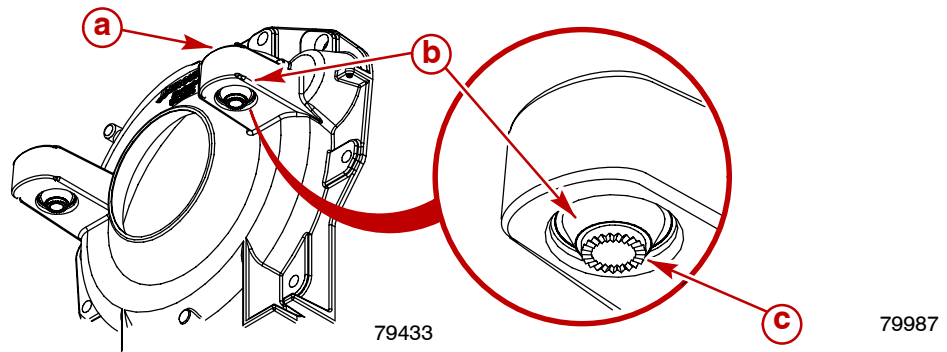
- a** - Mount spacer
- b** - Transom mounting support
- c** - Flywheel housing
- d** - Chamfered inner diameter

2. Press the mount into the flywheel housing with the painted end toward the top of the flywheel housing and the knurled edge toward the bottom of the flywheel housing.

**IMPORTANT: The white paint spot (on 865329) or yellow paint spot (on 865330) identify the top of the mount assembly. The bottom of the mount has a knurled edge.**



- a** - Painted end
- b** - Smooth edge
- c** - Bottom end
- d** - Knurled edge



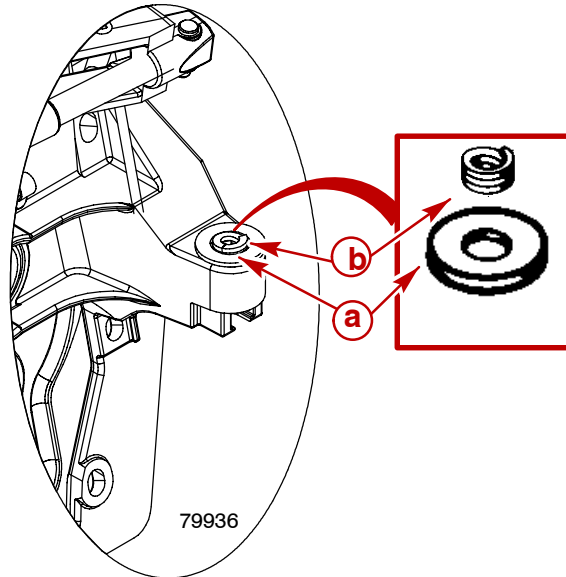
**Typical flywheel housing with new design mount installed, all similar**

- a** - Painted end (not shown)
- b** - Mount bottom
- c** - Knurled edge

**NOTE:** The double-wound lockwasher, if previously equipped, is no longer required because of the knurled bottom edge on these new design mounts.

**3. On All Inner Transom Plates:**

- a. Remove and discard, if equipped, the double-wound lockwashers on the inner transom plate mounts.
- b. Remove and discard the old fiber washers.

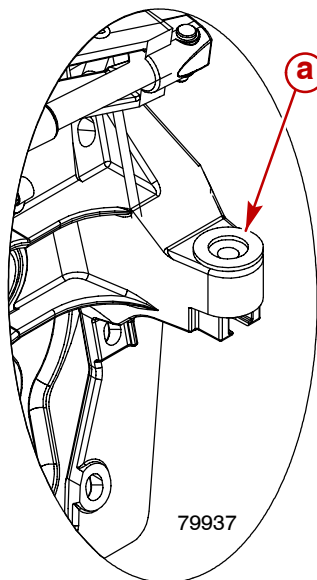


**Existing inner transom plate mount area**

- a** - Old fiber washer  
**b** - Double-wound lockwasher

**IMPORTANT: Use fiber washers on the inner transom plate with all mounts.**

- c. Install the new fiber washers included with the mounts.



**Inner transom plate mount area ready for new mounts**

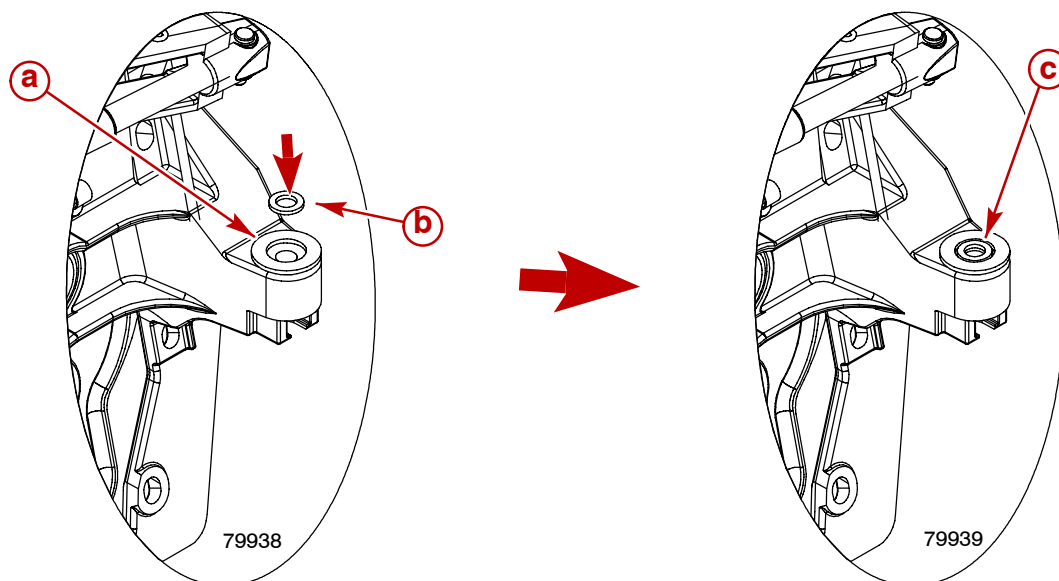
- a** - New fiber washer

**IMPORTANT:** The engine and sterndrive unit must be aligned after installation of the new design flywheel housing mounts and hardware.

4. After completing the mount installation, install and align the engine. Refer to the appropriate Mercury MerCruiser or Cummins MerCruiser Diesel service manual.
5. **On installations where the front engine mounts cannot be lowered enough to allow for proper engine alignment:**
  - a. Attach a suitable sling, and lifting arm if required, to the lifting eyes on the engine and adjust so that the engine will be level when suspended.
  - b. Remove the rear engine mounting bolts.
  - c. Using an overhead hoist lift the engine slightly.

**NOTE:** Positioning the stainless steel washers between the new engine mounts and the transom mounting supports will raise the engine slightly resulting in additional front mount adjustment.

- d. Install the stainless steel washer inside the inner diameter of each fiber washer.



**Typical inner transom plate mount with stainless steel washer**

- a** - Fiber washer
- b** - Stainless steel washer
- c** - Corrected mount area

- e. After completing the stainless steel washer installation, install and align the engine. Refer to the appropriate Mercury MerCruiser or Cummins MerCruiser Diesel service manual.