

# MERCURY

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

## TWO-CYLINDER MODELS

Year Produced	Model
1970-1971	400
1972-1978	402
1978-1983	40
1984-1985	35

## CONDENSED SERVICE DATA

### TUNE-UP

Horsepower:	
Model 35	35/5400-6000
Models 40, 400 & 402	40/5000-5500
Bore	2.870 in. (72.9 mm)
Stroke	2.562 in. (65.1 mm)
Displacement	33.3 cu. in. (546 cc)
Compression At Cranking Speed	*
Spark Plug:	
AC	V40FPFX†
Champion	L76V
Electrode Gap	Surface Gap
Ignition:	
Type	Solid State
Trigger Gap (Model 400)	0.050-0.060 in. (1.27-1.52 mm)
Carburetor Pickup Timing	See Text
Maximum Advance	See Text
Fuel-Oil Ratio	See Text

\*Not more than 15 psi (103.5 kPa) variations between cylinders.

†AC type M40FPFX 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	*
Piston Skirt Clearance	*

### SIZES - CLEARANCES CONT.

Crankshaft Bearings:	
Top Main Bearing	Roller or Ball Bearing
Center Main Bearing	Pushing With Reed Valve
Lower Main Bearing	Ball Bearing
Crankpin	Caged Rollers
Piston Pin Bearing In Rod	Loose Rollers
Number of Rollers Per Rod	29

\*Publication not authorized by manufacturer.

### TIGHTENING TORQUES

Connecting Rod	180 in.-lbs. (20.3 N·m)
Crankcase Screws	200 in.-lbs. (22.6 N·m)
Cylinder Cover:	
35 HP*	100 in.-lbs. (11.3 N·m)
40 HP*	70 in.-lbs. (7.9 N·m)
Exhaust Cover	200 in.-lbs. (22.6 N·m)
Flywheel Nut	70-75 ft.-lbs. (95.2-102 N·m)
Reed Screws	25 in.-lbs. (2.8 N·m)
Spark Plugs	240 in.-lbs. (27.1 N·m)
Transfer Port Cover:	
35 HP	50 in.-lbs. (5.6 N·m)
40 HP	60 in.-lbs. (6.8 N·m)

# Mercury 40 2 Stroke Manual

**IM Harris**



## **Mercury 40 2 Stroke Manual:**

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## **Table of Contents Mercury 40 2 Stroke Manual**

1. Understanding the eBook Mercury 40 2 Stroke Manual
  - The Rise of Digital Reading Mercury 40 2 Stroke Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Mercury 40 2 Stroke Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Mercury 40 2 Stroke Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Mercury 40 2 Stroke Manual
  - Personalized Recommendations
  - Mercury 40 2 Stroke Manual User Reviews and Ratings
  - Mercury 40 2 Stroke Manual and Bestseller Lists
5. Accessing Mercury 40 2 Stroke Manual Free and Paid eBooks
  - Mercury 40 2 Stroke Manual Public Domain eBooks

- Mercury 40 2 Stroke Manual eBook Subscription Services
- Mercury 40 2 Stroke Manual Budget-Friendly Options
- 6. Navigating Mercury 40 2 Stroke Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Mercury 40 2 Stroke Manual Compatibility with Devices
  - Mercury 40 2 Stroke Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Mercury 40 2 Stroke Manual
  - Highlighting and Note-Taking Mercury 40 2 Stroke Manual
  - Interactive Elements Mercury 40 2 Stroke Manual
- 8. Staying Engaged with Mercury 40 2 Stroke Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Mercury 40 2 Stroke Manual
- 9. Balancing eBooks and Physical Books Mercury 40 2 Stroke Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Mercury 40 2 Stroke Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Mercury 40 2 Stroke Manual
  - Setting Reading Goals Mercury 40 2 Stroke Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mercury 40 2 Stroke Manual
  - Fact-Checking eBook Content of Mercury 40 2 Stroke Manual
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks

#### 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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