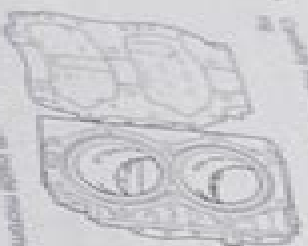
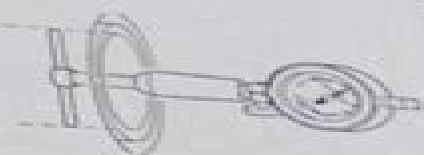


• **Check crankshaft for excessive wear.**  
If cylinder walls are scored, the crankshaft should be replaced.



- Measure piston pins with inside micrometer or calipers.
- Measure 14 in. (35 mm) down from the top of the cylinder.
- Measure 14 in. (35 mm) up from exhaust port.
- Measure 14 in. (35 mm) down from intake port.
- Measure 318 in. (14.78 mm) down from intake port.



• **Measure again at 90° from first set.**  
The gap or difference between the largest and smallest measurement must not be more than .005 mm.

• **Measure block if wear is more than 0.002 in. (0.05 mm) or if cylinder is out of round.**  
Measure pistons and rings are available in .002 in. (0.05 mm) increments. If damage exceeds 0.002 in. (0.05 mm), the block must be replaced.

• **Measure block wear is within tolerance, but scored, hone cylinder with a fine stone.**

• **Check cylinder walls for scoring.**  
If cylinder walls are scored, the crankshaft should be replaced.



- 7. Check cylinder for scoring.
- Inspect threads on top of the cylinder.
- Inspect top of the cylinder for scoring.
- Check upper main bearing for scoring, cracks, and wear.



- 8. Inspect crankshaft main and connecting rod bearings.
- Check lower bearing for scoring, cracks, and wear.
- Replace lower crankshaft bearing.



- 9. Measure crankshaft rod pins.

**NOTE:** Refer to specifications for replacement.

• **Check upper and lower main bearings for scoring and pitting.**



- Check connecting rod for scoring.
- Inspect top of the connecting rod and top of the cylinder for scoring.
- Measure top ends of connecting rods.
- Refer to specifications for replacement.



- 10. Inspect pistons for wear and scoring at top and bottom.

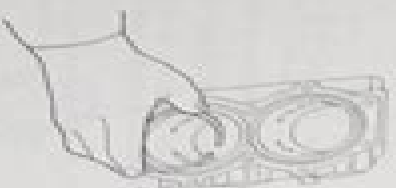


- 11. Measure piston pin bore with inside micrometer.

**NOTE:** Refer to manual for torque and torque sequence.



- 12. Measure piston ring and gap.
- Inspect new piston ring on cylinder and across the block gap.



- 13. Measure ring end gap with beam gauge.
- Inspect ring end gap (0.010 - 0.020 in. (0.25 - 0.50 mm)).
- **NOTE:** If gap is too small, when it sets in the block, the ring will not seal properly.
- **NOTE:** If gap is too wide, the ring will not seal properly.
- **NOTE:** Be sure to use the proper torque sequence for the block and lower bore.



- 14. Inspect bearing alignment pins.

# Mercury Force 40 Hp Service Manual

**Jicheng Xie**



## **Mercury Force 40 Hp Service Manual:**

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