

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

Hp/rpm:	
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	V40FPX†
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 M40FPX 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

United States. Patent Office



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