

SERIAL NUMBERS:

Merc 400M	1286285 thru 1363797
Merc 400E	1280685 thru 1366647
Merc 400M-1	1384806 and up
Merc 400E-1	1391806 and up

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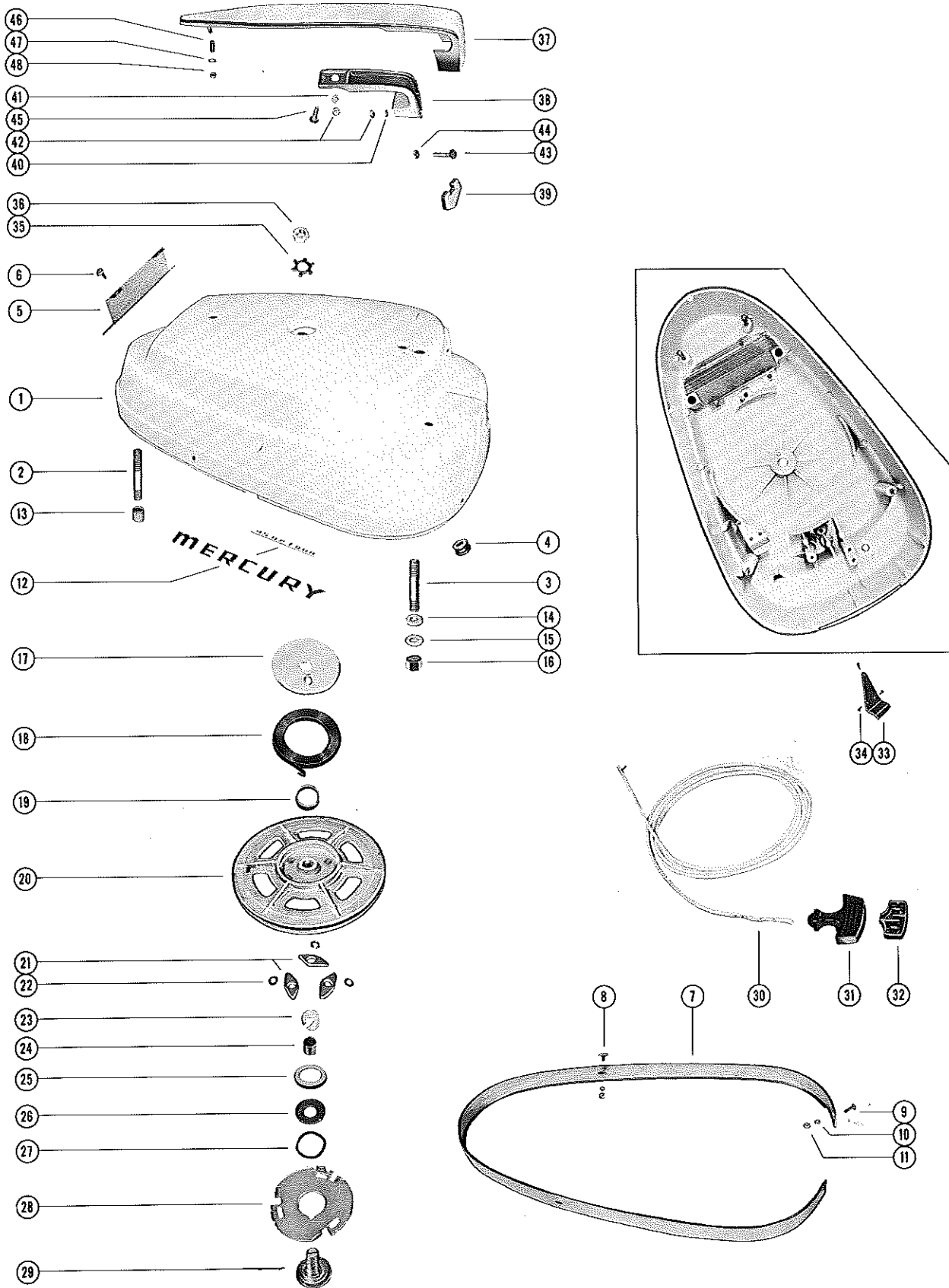
(See Page 16 for Merc 400ML, Merc 400EL, Merc 400S and Merc 400SL Parts List)

Battery	25221
Battery Box Assembly	28719A1
Decal Set (Merc 400M and 400E).	37-29834
Decal Set (Merc 400M-1 and 400E-1).	37-31008
Decal Solution (pint bottle)	92-25143
Flushing Assembly.	24789A1
Gasket & Packing Set (Carburetor KA-2A and KA-9A)	1399-1477
Gasket Set (motor overhaul).	27-28093
Gear Lubricant	92-29409
Glue (blanket adhesive)	92-25234
Repair Parts Kit (Carburetor KA-2A)	1399-1478
Repair Parts Kit (Carburetor KA-9A)	1399-1712
Shipping Carton (fuel tank)	29616
Shipping Carton (motor).	●31004
MERC 400 and MERC 400-1 Parts List, Complete.	90-29937

AR = As Required

NOTE: All Part numbers preceded by a (●) are new and listed for the first time.

TOP COWL AND STARTER ASSEMBLY



TOP COWL AND STARTER ASSEMBLY

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
177-1594A2	1	Top Cowl Assembly	1	1	1	1
16-20500	2	Stud, rear - top cowl to cover	2	2	2	2
16-20353	3	Stud, front - top cowl to crankcase	2	2	2	2
25-20116	4	Grommet, choke knob	1	1	1	1
28967	5	Screen, vent - top cowl	1	1	1	1
10-29221	6	Screw, vent screen to top cowl	4	4	4	4
29228A1	7	Trim Moulding Assembly, top cowl	1	1	1	1
10-29226	8	Screw, decorative - moulding to top cowl	2	2	2	2
10-29227	9	Screw, brass - moulding to top cowl	2	2	2	2
13-26995	10	Lockwasher, moulding fastening screw	4	4	4	4
11-26419	11	Nut, moulding fastening screw	4	4	4	4
37-29834	12	Decal Set, top cowl	1	1	-	-
●37-31008	12	Decal Set, top cowl	-	-	1	1
23-20326	13	Spacer, top cowl stud	2	2	2	2
12-20028	14	Washer, top cowl stud (1/16")	2	2	2	2
12-20346	15	Washer, top cowl stud (3/4" OD)	4	4	4	4
12-20583	--	Washer, top cowl stud (1/32")	4	4	4	4
11-20361	16	Nut, top cowl fastening	4	4	4	4
20155	17	Retainer, starter spring	1	1	1	1
24-23714	18	Spring, starter rewind	1	1	1	1
23-28912	19	Bushing, spring guide	1	1	1	1
50-28908	20	Sheave Assembly	1	1	-	1
●50-30994	20	Sheave Assembly	-	-	1	-
20162	21	Pawl, starter	3	3	-	3
●30596	21	Pawl, starter	-	-	3	-
13-29402	22	Washer, wave - starter pawl	3	3	-	3
●13-30597	22	Washer, wave - starter pawl	-	-	3	-
23-28919	23	Bushing, nylon - sheave shaft spacer	1	1	1	1
23-28911	24	Spacer, sheave shaft	1	1	1	1
26179	25	Retainer, wave washer	1	1	1	1
12-26180	26	Washer, wave washer retainer	1	1	1	1
13-20160	27	Washer, wave - retainer tension	1	1	1	1
20164	28	Plate, retainer - starter pawl	1	1	-	1
●30595	28	Plate, retainer - starter pawl	-	-	1	-
28913	29	Shaft, sheave	1	1	1	1
50-28985A1	30	Starter Cable Assembly	1	1	1	1
28747	31	Handle, starter cable	1	1	1	1
28748	32	Retainer, starter cable and handle	1	1	1	1
30045	33	Plate, rope guide	1	1	1	1
10-28642	34	Screw, drive, rope guide plate to top cowl	3	3	3	3
14-20165	35	Tab Washer, sheave shaft nut	1	1	1	1
11-20166	36	Nut, sheave shaft (left hand thread)	1	1	1	1
29274	37	Handle, chrome - top cowl	1	1	1	1
29276	38	Handle, inside - top cowl	1	1	-	-
31003	38	Handle, inside - top cowl	-	-	1	1
29413	39	Button, bumper - top cowl handle	1	1	-	-
31119	39	Button, bumper - top cowl handle	-	-	1	1
12-20346	40	Washer, lower handle stud (3/4" OD)	1	1	1	1
12-29245	41	Washer, center handle stud (1/2" OD)	1	1	1	1
11-21825	42	Nut, inside handle to chrome handle studs	2	2	2	2
10-22421	43	Screw, front - handle to top cowl (1 1/4")	1	1	1	1
11-20361	44	Nut, front handle fastening screw	1	1	1	1
10-29199	45	Screw, center - handle to top cowl (1")	1	1	1	1
23-29561	46	Bushing, rear handle stud	1	1	1	1
13-26992	47	Lockwasher, rear handle stud	1	1	1	1
11-21825	48	Nut, rear handle stud	1	1	1	1

COWLING AND FRONT COVER

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
178-1645A2	1	Cowl Front Cover Assembly	1	1	-	-
●178-1645A3	1	Cowl Front Cover Assembly	-	-	1	1
26183A	2	Emblem, front cover (see note below)	1	1	-	-
26183A5	2	Emblem, front cover	-	-	1	1
10-29226	3	Screw, bracket to front cover	2	2	2	2
13-26995	4	Lockwasher, bracket fastening screw	2	2	2	2
11-26419	5	Nut, bracket fastening screw	2	2	2	2
29345	6	Bumper, rubber - front cover bracket	2	2	2	2
10-29552	7	Screw, cover fastening	1	1	-	-
12-26162	8	Washer, cover fastening screw (rubber)	1	1	-	-
12-27897	9	Washer, cover fastening screw (nylon)	1	1	-	-
30884	7A	Knob, cowl front cover fastening	-	-	1	1
12-26702	8	Washer, cover fastening knob (nylon)	-	-	1	1
12-26825	9	Washer, cover fastening knob (steel)	-	-	2	2
24-30772	10	Spring, tension - fastening knob	-	-	1	1
17-29077	11	Roll Pin, tension spring to knob	-	-	1	1
29343	12	Blanket, sound absorbing - front cover	1	1	-	-
31095	12A	Strip, rubber - cowl front cover	-	-	2	2
107-144A2	13	Wrap Around Cowl Assembly -----	1	1	1	1
21060	14	Handle, cowl latch (#8)	2	2	2	2
30412	14	Handle, cowl latch (#10)	-	-	2	2
53-21058	15	"E" Ring, cowl latch hinge pin	4	4	4	4
17-21057	16	Pin, hinge - cowl latch handle	4	4	4	4
25690	17	Swivel, cowl latch (#8)	2	2	2	2
30414	17	Swivel, cowl latch (#10)	-	-	2	2
25691	18	Hook, cowl latch fastening (#8)	2	2	2	2
30413	18	Hook, cowl latch fastening (#10)	-	-	2	2
24825	19	Blanket, sound absorbing - wrap around cowl	1	1	1	1
92-25234	--	Glue, adhesive - blanket fastening	1	1	1	1

NOTE: Emblems for replacement may be ordered in two (2) different color combinations as listed below. Be sure and specify color combination required by adding A1 or A2 suffix to emblem part number 26183:

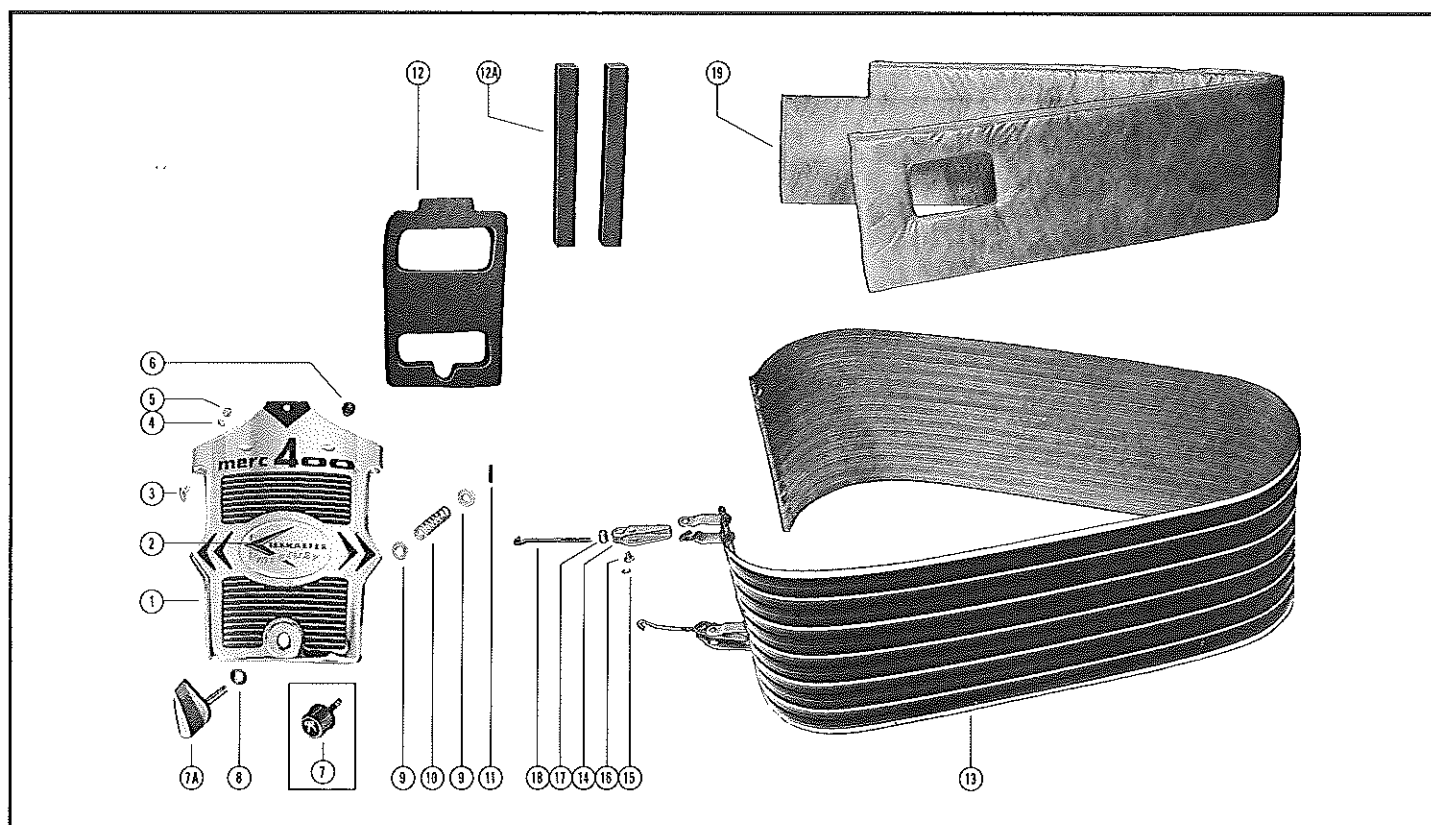
26183A1 Emblem (black background with red and aluminum lettering)
26183A2 Emblem (aluminum background with red and gold lettering)
92-27109 Adhesive Compound (3½ ounce kit) emblem fastening

FLYWHEEL ASSEMBLY AND STATOR

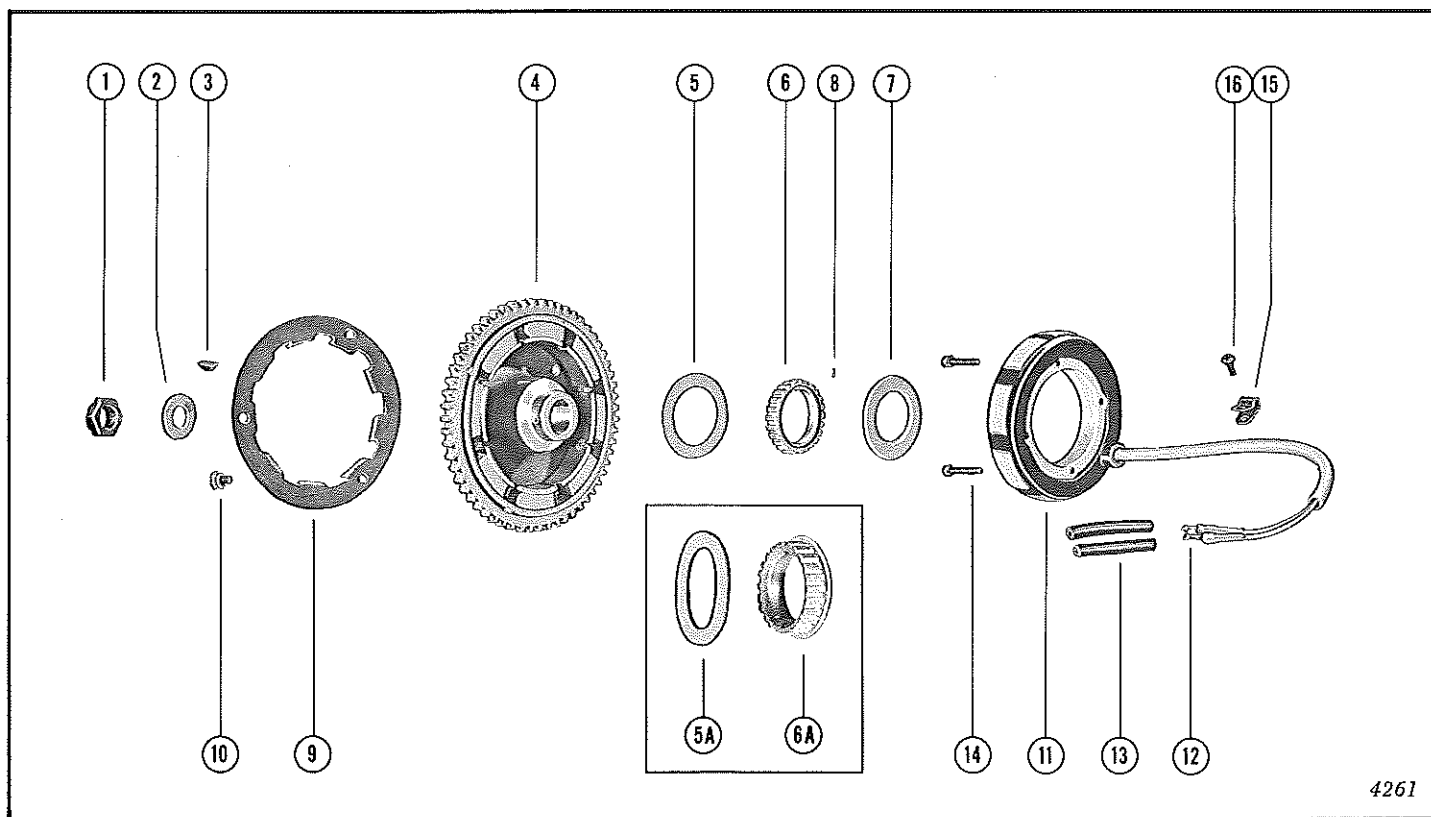
PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
11-22339	1	Nut, flywheel	1	1	1	1
12-26617	2	Washer, flywheel nut	1	1	1	1
28-20094	3	Key, flywheel drive	1	1	1	1
208-1385A1	4	Flywheel Assembly	1	-	1	-
211-1414A7	4	Flywheel Assembly	-	1	-	1
12-25293	5A	Washer, pulley to flywheel	1	1	-	-
22823	6A	Pulley, flywheel	1	1	-	-
29788	5	Flange, flywheel pulley	1	1	1	1
30306	6	Pulley, flywheel	1	1	1	1
29787	7	Hub, flange - flywheel pulley	1	1	1	1
17-26618	8	Dowel Pin, flywheel pulley	1	1	1	1
50-25263	9	Ratchet, flywheel	-	1	-	1
10-29238	10	Screw, ratchet to flywheel	-	3	-	3
398-1455	11	Stator, alternator - flywheel	-	1	-	1
22647	12	Disconnect, knife splice - stator lead wire	-	2	-	2
32-29267	13	Sleeve, rubber - stator lead wire	-	2	-	2
10-29249	14	Screw, stator to upper end cap	-	4	-	4
54-24836	15	Clip, stator lead to crankcase flange	-	1	-	1
10-30009	16	Screw, stator lead clip fastening	-	1	-	1

NOTE: On later production engines, the 22823 pulley and 12-25293 washer were replaced by a new 3 piece pulley for the flywheel. This new 3 piece combination can only be used on flywheels which have the 3/32" longer hub length required for new style pulley. Please adjust your ordering of replacement parts accordingly.

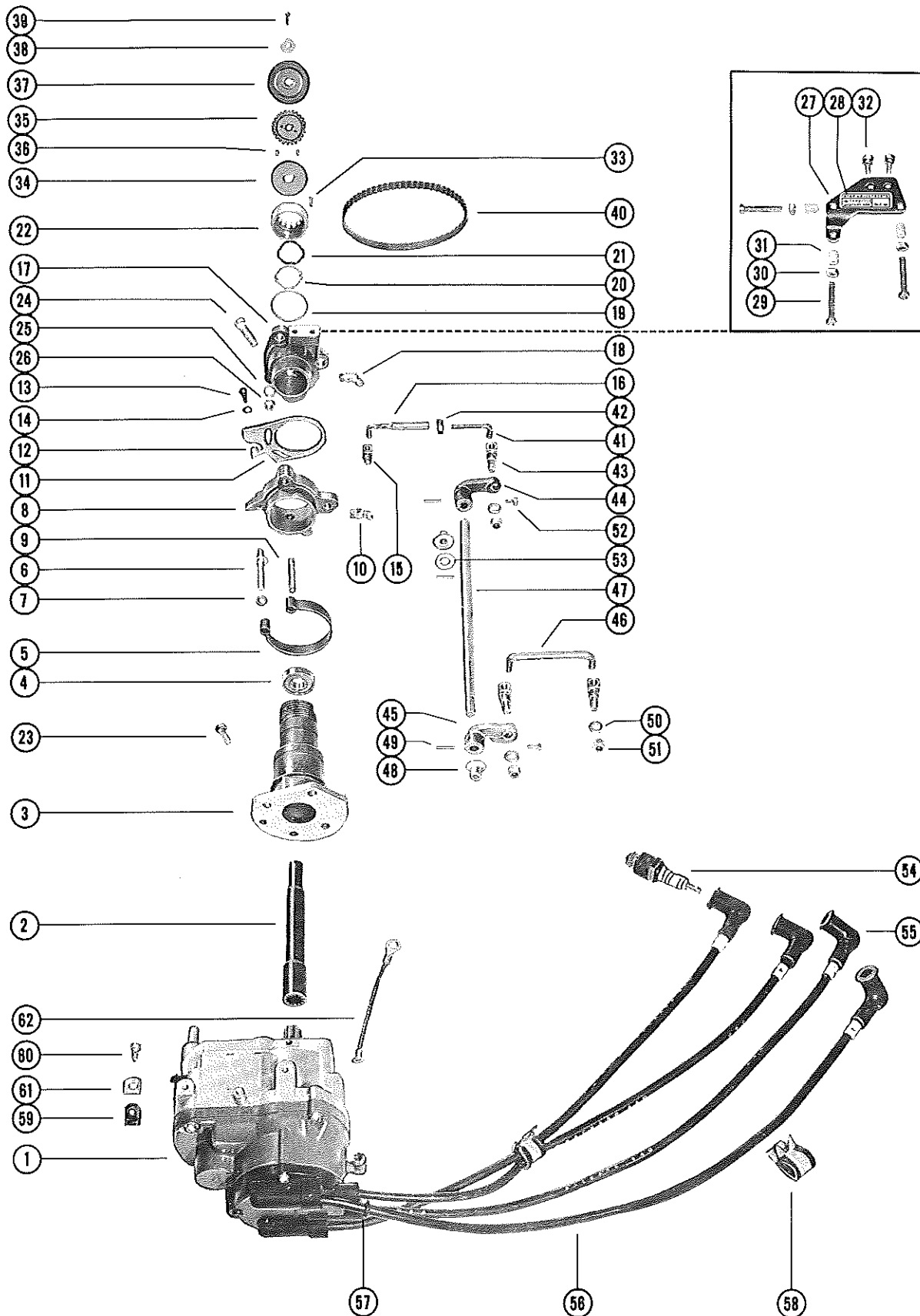
COWLING AND FRONT COVER



FLYWHEEL ASSEMBLY AND STATOR



MAGNETO ADAPTOR AND PILOT ASSEMBLY



MAGNETO ADAPTOR AND PILOT ASSEMBLY

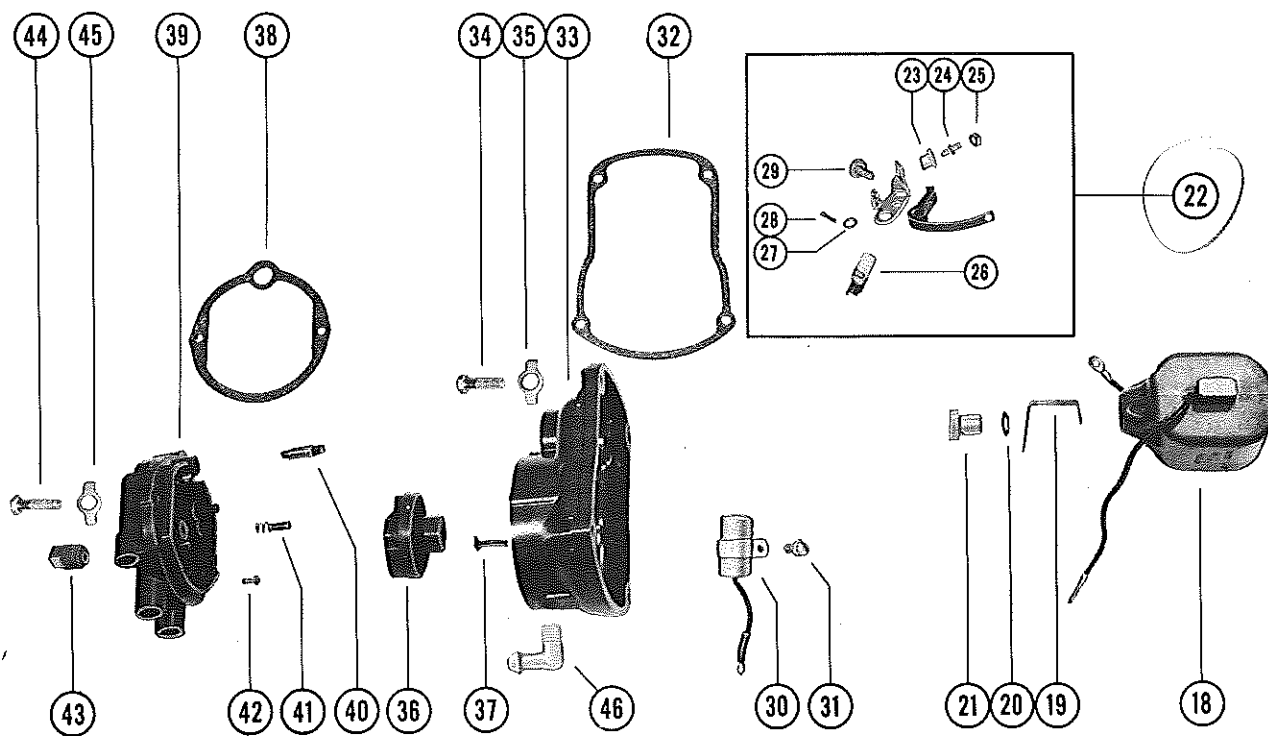
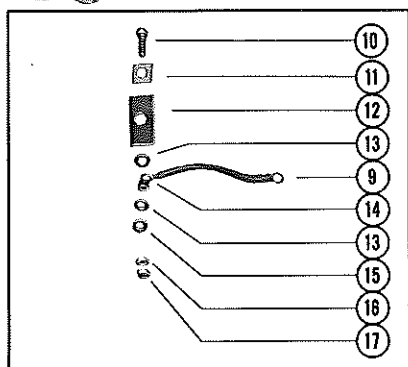
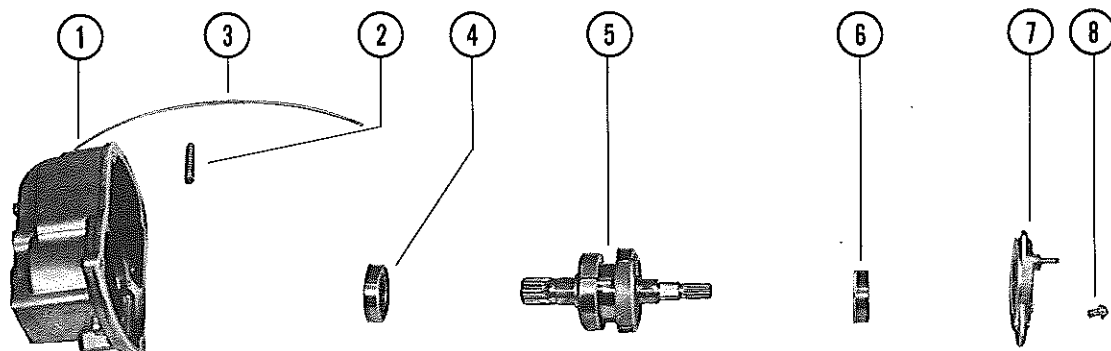
PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
394-1652A1	1	Magneto Assembly, Complete (4D-3)	1	1	1	1
45-27951	2	Shaft, magneto drive	1	1	1	1
29321A7	-	Magneto Adaptor and Pilot Assembly, Complete	1	1	1	1
29321A1	3	Magneto Pilot Assembly	1	1	1	1
30-20066	4	Bearing, ball - magneto pilot	1	1	1	1
24-27944	5	Spring, horseshoe - magneto pilot	1	1	1	1
17-27962	6	Pin, anchor - horseshoe spring to pilot	1	1	1	1
12-29245	7	Washer, horseshoe spring to anchor pin	1	1	1	1
27946A1	8	Economiser Collar and Pin Assembly	1	1	1	1
17-27961	9	Pin, economiser collar - spring retainer	1	1	1	1
22-25094	10	Fitting, grease - economiser collar	1	1	1	1
29557A1	11	Throttle Actuator Assembly	1	1	1	1
23-26602	12	Bushing, nylon - throttle actuator	1	1	1	1
10-20665	13	Screw, throttle actuator to economiser collar	2	2	2	2
12-20128	14	Washer, throttle actuator screw	2	2	2	2
27947	15	Swivel, linkage - economiser collar	1	1	1	1
25996A1	16	Swivel, and Link Rod Assembly	1	1	1	1
30043	17	Adaptor, magneto	1	1	1	1
22-25094	18	Fitting, grease - magneto adaptor	1	1	1	1
12-27939	19	Washer, magneto pilot	1	1	1	1
14-27960	20	Tab Washer, adaptor cap fastening	1	1	1	1
13-27959	21	Washer, wave - magneto ball bearing tension	1	1	1	1
27955	22	Cap, magneto adaptor and pilot fastening	1	1	1	1
10-30110	23	Screw, adaptor and pilot to magneto	4	4	4	4
10-22040	24	Screw, adaptor and pilot to crankcase	3	3	3	3
12-20084	25	Washer, adaptor and pilot to crankcase screw	3	3	3	3
11-20083	26	Nut, adaptor and pilot to crankcase screw	3	3	3	3
29277	27	Plate, throttle stop	1	1	1	1
37-29315	28	Decal, throttle stop plate (stop adjustments)	1	1	1	1
10-24933	29	Screw, throttle stop adjusting	3	3	3	3
11-20088	30	Nut, throttle stop adjusting screw	3	3	3	3
26852	31	Cap, nylon - adjusting screw	3	3	3	3
10-29197	32	Screw, throttle stop plate to adaptor	2	2	2	2
28-28657	33	Key, magneto driving	1	1	1	1
23-27957	--	Spacer, pulley to magneto adaptor cap	1	1	1	1
24807	--	Pulley, driven <i>old style</i>	1	1	1	1
20136	--	Flange, driven pulley	1	1	1	1
29784	34	Hub, driven pulley	1	1	1	1
29783A1	35	Driven Pulley Assembly <i>new style - see note below</i>	1	1	1	1
17-24873	36	Roll Pin, flange locating	2	2	2	2
29785	37	Flange, driven pulley	1	1	1	1
12-20138	38	Washer, pulley clamping screw	1	1	1	1
10-29240	39	Screw, pulley clamping	1	1	1	1
20140	40	Belt, timing	1	1	1	1
27949	41	Rod, link - upper	1	1	1	1
11-25168	42	Nut, upper link rod adjusting	1	1	1	1
27948	43	Swivel, upper and lower link rods	3	3	3	3
28061	44	Lever, linkage - upper	1	1	1	1
27941	45	Lever, linkage - lower	1	1	1	1
27950	46	Rod, link - lower	1	1	1	1
27940	47	Shaft, vertical	1	1	1	1
23-22981	48	Bushing, nylon - vertical shaft	2	2	2	2
17-25870	49	Roll Pin, vertical shaft and linkage levers	3	3	3	3
12-29245	50	Washer, upper and lower swivel	3	3	3	3
11-20361	51	Nut, upper and lower swivel to lever and bracket	3	3	3	3
10-25781	52	Screw, set - linkage lever	2	2	2	2
12-25866	53	Washer, vertical shaft - center	1	1	1	1
33-20127	54	Spark Plug	4	4	4	4
20119	55	Protector, spark plug	4	4	4	4
23564	56	Cable, high tension lead - spark plug	4	4	4	4
25-25429	57	"O" Ring, high tension lead cable to end cap cover	4	4	4	4
54-29425	58	Clip, high tension lead cable fastening	2	2	2	2
54-25231	59	Clip, mercury switch and harness leads to magneto	2	2	2	2
10-20401	60	Screw, lead clip to magneto	2	2	2	2
22789	61	"D" Washer, clip fastening screw	2	2	2	2
394-1134A1	62	Ground Strap Assembly, magneto to crankcase	1	1	1	1

NOTE: New style parts were used on later production engines and may be used as replacement parts on earlier engines if replaced as a unit. Also that 23-27957 spacer is not required with these new style parts.

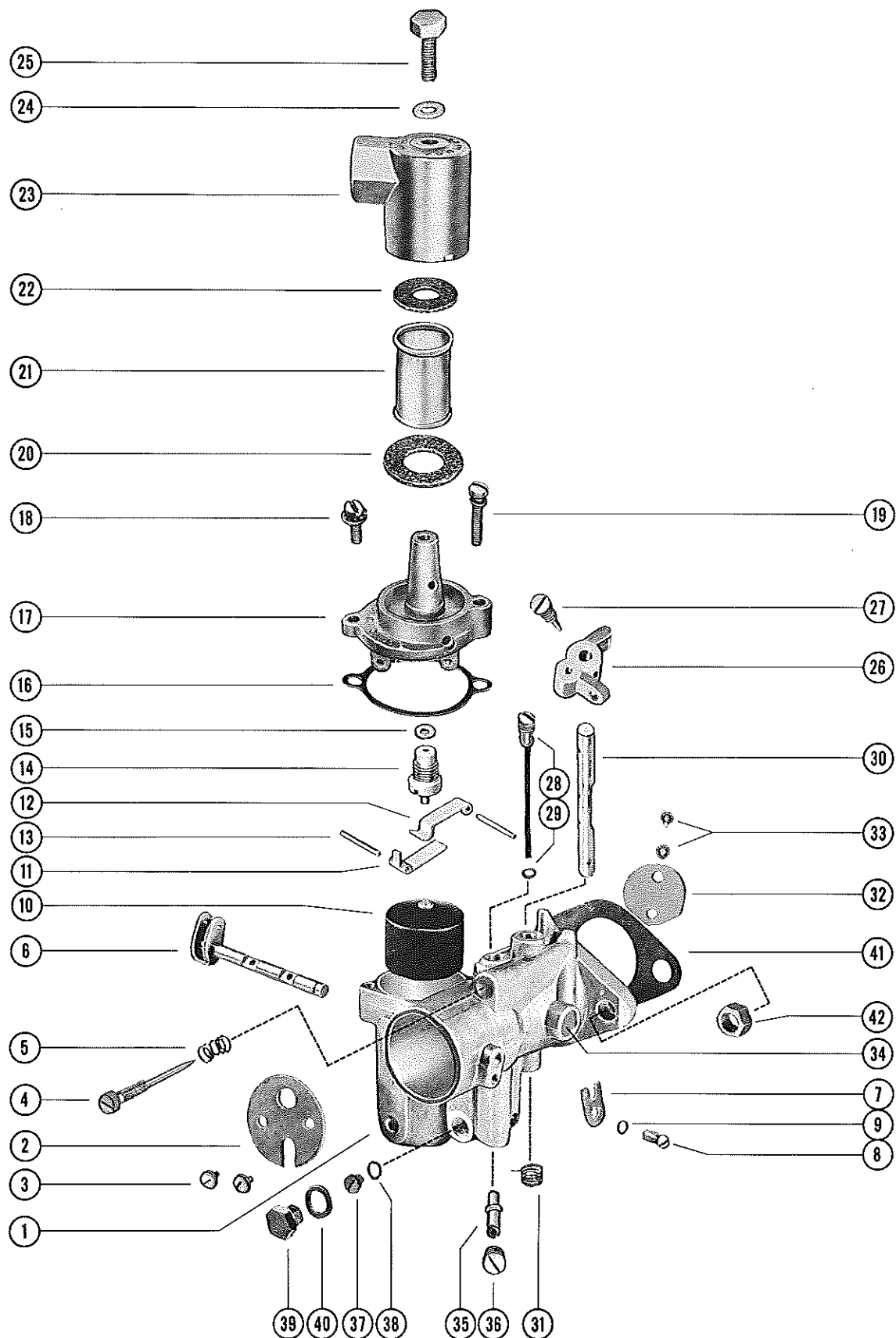
MAGNETO ASSEMBLY

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
394-1652A1	-	Magneto Assembly, Complete (4D-3)	1	1	1	1
394-1570	1	Frame, magneto housing	1	1	1	1
10-25510	2	Screw, set - coil bridge	2	2	2	2
394-1051	3	Lockwire, coil bridge set screw	1	1	1	1
30-24998	4	Bearing, ball (drive end)	1	1	1	1
394-1067	5	Magnetic Rotor and Shaft	1	1	1	1
30-24997	6	Bearing, ball (opposite drive end)	1	1	1	1
394-1637	7	Support, ball bearing	1	1	1	1
10-25509	8	Screw and Lockwasher, support to frame	3	3	3	3
394-1053A1	9	Wire Assembly, primary ground lead	1	1	1	1
10-29182	10	Screw, primary ground (#10)	1	1	1	1
12-30267	11	Washer, primary ground terminal holding	1	1	1	1
394-1579	12	Insulator, primary ground terminal	1	1	1	1
12-29099	13	Washer, insulating - primary ground screw	1	1	1	1
23-29101	14	Bushing, insulating - housing frame	1	1	1	1
12-26014	15	Washer, primary ground screw	1	1	1	1
11-24656	16	Nut, lock - primary ground screw	1	1	1	1
11-20645	17	Nut, primary ground screw	1	1	1	1
394-1128A1	18	Coil Assembly	1	1	1	1
394-1050	19	Clip, coil - high tension	1	1	1	1
13-23836	20	Lockwasher, coil terminal	1	1	1	1
394-1131	21	Nut, coil clip fastening	1	1	1	1
393-1504A6	22	Breaker Assembly	1	1	1	1
393-1586	23	Grommet, plastic - breaker bracket	1	1	1	1
16-29230	24	Stud, primary lead and tension spring fastening	1	1	1	1
11-29236	25	Nut, primary lead fastening	1	1	1	1
394-1106A1	26	Holder and Cam Wick Assembly	1	1	1	1
12-26439	27	Washer, breaker pivot pin	1	1	1	1
18-26953	28	Cotter Pin, breaker to pivot pin	1	1	1	1
10-20597	29	Screw, breaker holder to housing	1	1	1	1
394-1130	30	Condenser	1	1	1	1
10-25509	31	Screw and Lockwasher, condenser fastening	1	1	1	1
27-29166	32	Gasket, magneto cover	1	1	1	1
394-1577	33	Cover, magneto	1	1	1	1
10-29418	34	Screw, cover to frame	4	4	4	4
14-29157	35	Tab Washer, cover fastening screw	4	4	4	4
394-1671A1	36	Magneto Rotor Assembly	1	1	1	1
394-1110	37	Clip, spring	1	1	1	1
27-25725	38	Gasket, end cap cover	1	1	1	1
394-1561A1	39	End Cap Cover Assembly	1	1	1	1
394-1065A1	40	Lead Assembly, high tension	1	1	1	1
394-1056A1	41	Brush and Spring Assembly	1	1	1	1
10-25517	42	Screw, high tension cable fastening	4	4	4	4
29121	43	Pipe Plug, end cap cover	1	1	1	1
10-29418	44	Screw, end cap cover to magneto cover	2	2	2	2
14-29157	45	Tab Washer, cover fastening screw	2	2	2	2
22-25885	46	Elbow, plastic - magneto cover vent	1	1	1	1

MAGNETO ASSEMBLY



CARBURETOR ASSEMBLY



CARBURETOR ASSEMBLY

PART NO.	REF. NO.	DESCRIPTION	MERC 400M & 400E		MERC 400M-1	MERC 400E-1
			KA-2A	KA-9A		
1333-1387	1	Carburetor Assembly, Complete (KA-2A)	#2	-	-	-
1333-1700	1	Carburetor Assembly, Complete (KA-9A)	-	@2	2	2
1399-1470	2	Shutter, choke	2	2	2	2
10-23035	3	Screw and Lockwasher, choke shutter	4	4	4	4
1399-1629	4	Screw, idle adjustment	2	2	2	2
24-27160	5	Spring, idle adjustment screw	2	2	2	2
1399-1469	6	Choke Shaft and Lever	2	2	2	2
54-28407	7	Clip, choke shaft retaining	2	2	2	2
10-28408	8	Screw, retaining clip to lower carburetor	2	2	2	2
13-26995	9	Lockwasher, retaining clip screw	2	2	2	2
1399-110A1	10	Float Assembly	2	2	2	2
1399-102	11	Lever, float (lower)	2	2	2	2
1399-101	12	Lever, float (upper)	2	2	2	2
17-20853	13	Pin, float lever pinion	4	4	4	4
1399-1473	14	Inlet Needle, Seat and Gasket	2	2	2	2
27-25033	15	Gasket, inlet seat	2	2	2	2
1399-99	16	Gasket, float bowl cover	2	2	2	2
1399-1133	17	Cover, float bowl	2	2	2	2
10-20854	18	Screw, float bowl cover (short)	2	2	2	2
10-25850	19	Screw, float bowl cover (long)	2	2	2	2
27-25851	20	Gasket, strainer cover (large)	2	2	2	2
1399-1754	21	Screen, filter	2	2	2	2
27-25849	22	Gasket, strainer cover (small)	2	2	2	2
1399-1135	23	Cover, strainer	2	2	2	2
27-25848	24	Gasket, strainer cover screw	2	2	2	2
10-25822	25	Screw, strainer cover fastening	2	2	2	2
1399-97	26	Lever, throttle stop <i>(see note below)</i>	1	1	1	1
10-20847	27	Screw, throttle stop lever	2	2	2	2
1399-1472	28	Tube, idle	2	-	-	-
1399-1710	28	Tube, idle	-	2	2	2
27-23180	29	Gasket, idle tube	2	2	2	2
1399-1475	30	Shaft, throttle	2	2	2	2
24-20869	31	Spring, throttle shaft return <i>(upper carburetor)</i>	1	1	1	1
24-26890	31	Spring, throttle shaft return <i>(lower carburetor)</i>	1	1	1	1
1399-1476	32	Shutter, throttle	2	-	-	-
1399-1711	32	Shutter, throttle	-	2	2	2
10-23035	33	Screw and Lockwasher, throttle shutter	4	4	4	4
19-20011	34	Welch Plug, body channel	2	2	2	2
1399-1474	35	Nozzle, main	2	2	2	2
10-23178	36	Screw, plug - main nozzle	2	2	2	2
1399-1655	37	Jet, main fuel (.055)	-	Opt.	Opt.	Opt.
1399-1457	37	Jet, main fuel (.057)	Opt.	Opt.	Opt.	Opt.
1399-1459	37	Jet, main fuel (.059)	Opt.	Opt.	Opt.	Opt.
1399-1461	37	Jet, main fuel (.061)	Opt.	2	2	2
1399-1463	37	Jet, main fuel (.063)	2	Opt.	Opt.	Opt.
1399-1465	37	Jet, main fuel (.065)	Opt.	-	-	-
1399-1467	37	Jet, main fuel (.067)	Opt.	-	-	-
27-28409	38	Gasket, main fuel jet	2	2	2	2
10-28405	39	Screw, plug - body channel	2	2	2	2
27-28406	40	Gasket, body channel plug screw	2	2	2	2
1399-1477	--	Gasket and Packing Set (1 per carburetor)	2	2	2	2
1399-1478	--	Repair Parts Kit (1 per carburetor)	2	-	-	-
1399-1712	--	Repair Parts Kit (1 per carburetor)	-	2	2	2
27-26891	41	Gasket, carburetor flange	2	2	2	2
11-29250	42	Nut, carburetor mounting stud	4	4	4	4

NOTE: Use on lower carburetor only--replaced with 27917 cluster on upper carburetor.

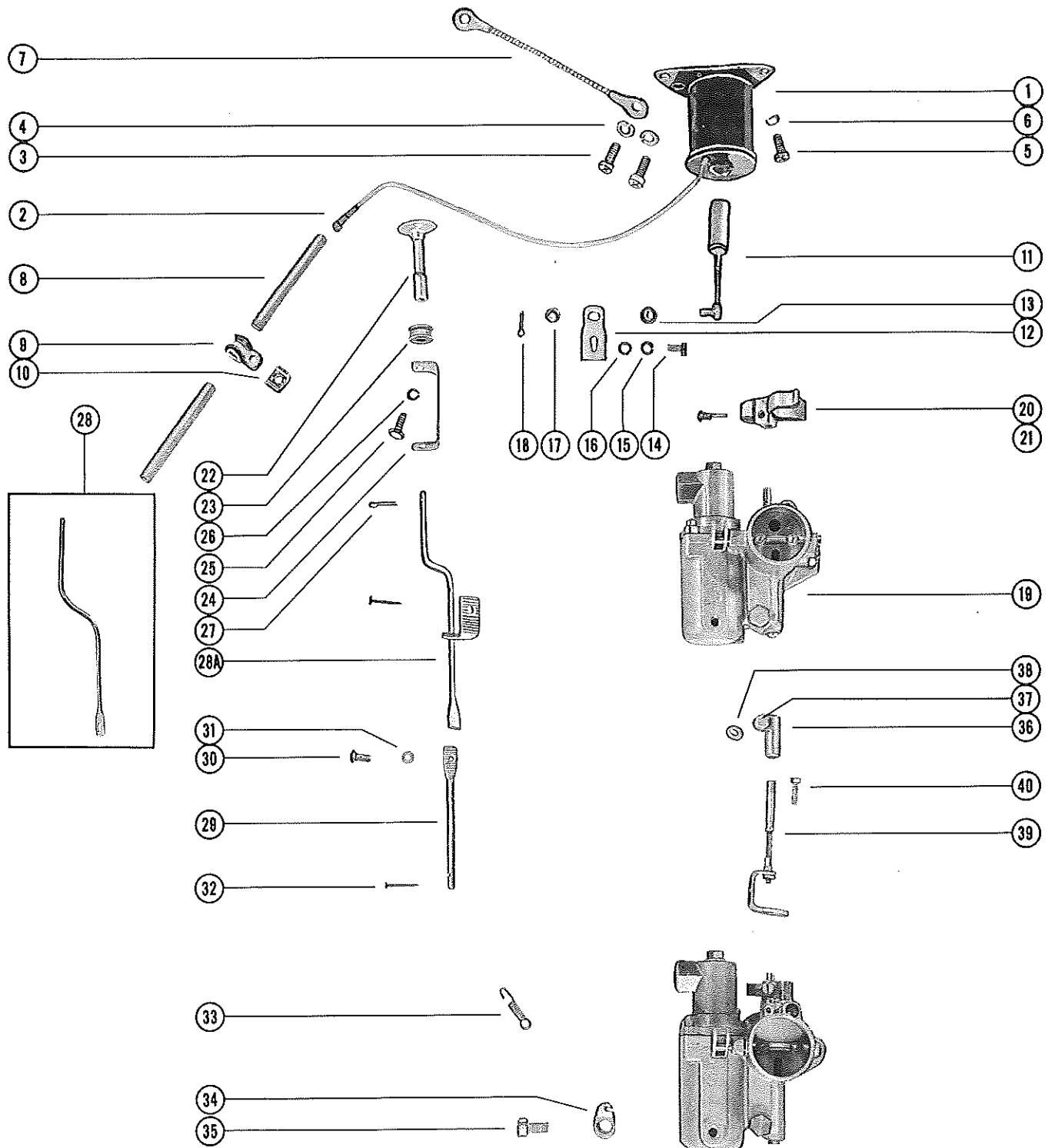
* Use thru Serial # 1307410.

@ Started with Serial #1307411.

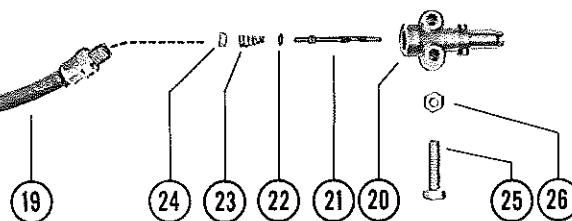
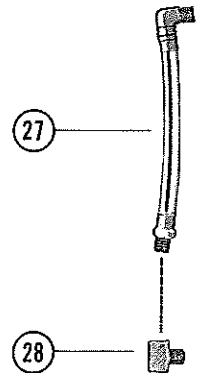
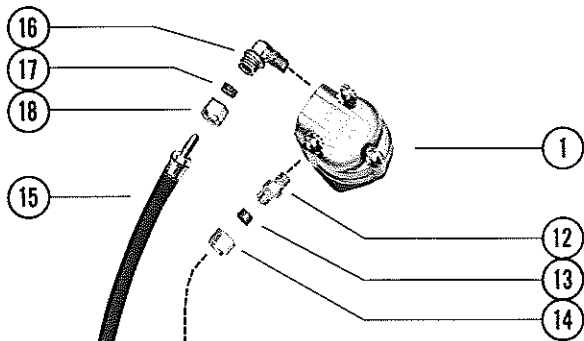
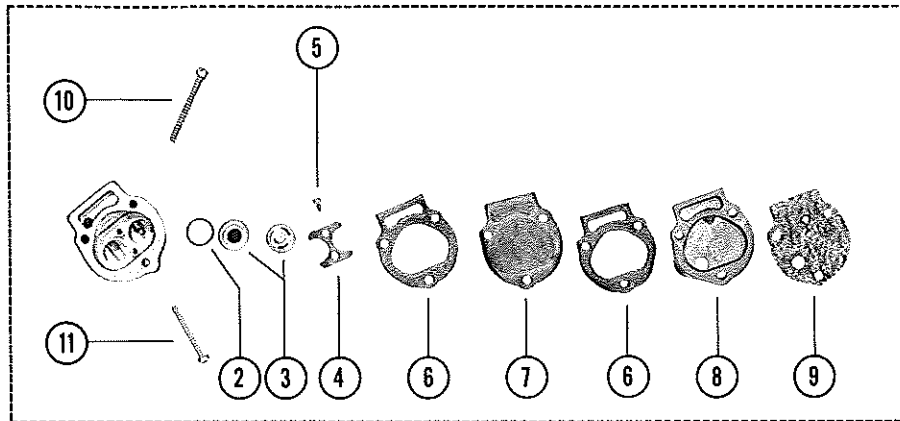
CARBURETOR LINKAGE AND CHOKE SOLENOID

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
27921	1	Choke Solenoid, top cowl	-	1	-	1
22647	2	Disconnect, knife splice - choke solenoid	-	1	-	1
10-20540	3	Screw, choke solenoid to top cowl	-	2	-	2
13-26992	4	Lockwasher, choke solenoid screw	-	2	-	2
10-24773	5	Screw, choke solenoid to top cowl	-	1	-	1
13-26991	6	Lockwasher, choke solenoid screw	-	1	-	1
26716A1	7	Ground Strap Assembly, choke solenoid to adaptor	-	1	-	1
32-26693	8	Sleeve, choke solenoid wire and harness wire	-	2	-	2
54-24836	9	Clamp, choke wire to starter solenoid	-	1	-	1
22789	10	"D" Washer, choke wire clamp	-	1	-	1
27031A1	11	Plunger Assembly, choke solenoid	-	1	-	1
27710	12	Adaptor Plate, choke plunger	-	1	-	1
25-26633	13	Grommet, adaptor plate	-	1	-	1
10-20055	14	Screw, adaptor plate to choke rod bracket	-	1	-	1
13-26996	15	Lockwasher, adaptor plate fastening screw	-	1	-	1
12-26014	16	Washer, adaptor plate fastening screw	-	1	-	1
12-26014	17	Washer, choke solenoid link	-	1	-	1
18-26953	18	Cotter Pin, choke solenoid link fastening	-	1	-	1
1333-1387	19	Carburetor Assembly, Complete (Use thru Serial # 1307410)	2	2	-	-
1333-1700	19	Carburetor Assembly, Complete (Started with Serial # 1307411)	2	2	2	2
27917	20	Cluster, throttle lever (upper carburetor)	1	1	1	1
10-20847	21	Screw, set - cluster to throttle lever	1	1	1	1
20663	22	Knob, choke rod	1	-	1	-
22463	22	Knob, choke rod	-	1	-	1
25-20116	23	Grommet, choke rod	1	1	1	1
22462	24	"U" Link, choke knob to choke rod	-	1	-	1
10-20100	25	Screw, "U" Link to choke knob	-	1	-	1
13-26996	26	Lockwasher, "U" link fastening screw	-	1	-	1
18-26953	27	Cotter Pin, choke lever and rod fastening	-	1	-	1
28977	28	Choke Rod - upper	1	-	1	-
28972A1	28A	Choke Rod and Bracket Assembly - upper	-	1	-	1
27918	29	Choke Rod - lower	1	1	1	1
10-30096	30	Screw, upper choke rod to lower choke rod	1	1	1	1
12-27882	31	Washer, upper choke rod fastening screw	1	1	1	1
17-25391	32	Rivet, choke rod to throttle shaft	2	2	2	2
24-20649	33	Spring, choke rod to retainer	1	-	1	-
24-28965	33	Spring, choke rod to retainer	-	1	-	1
28651	34	Retainer, choke rod spring	1	-	1	-
27711	34	Retainer, choke rod spring	-	1	-	1
10-28713	35	Screw, retainer to lower carburetor	1	1	1	1
27870	36	Clamp, throttle pickup bracket	1	1	1	1
10-20100	37	Screw, clamp to throttle pickup bracket	1	1	1	1
12-30164	38	Washer, throttle pickup bracket clamping screw	1	1	1	1
28007A1	39	Bracket Assembly, throttle pickup	1	1	1	1
10-29239	40	Screw, throttle bracket mounting	1	1	1	1

CARBURETOR LINKAGE AND CHOKE SOLENOID



FUEL PUMP ASSEMBLY



FUEL PUMP ASSEMBLY

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
29178A2	1	Fuel Pump Assembly (<i>use thru serial #1362197</i>)	1	1	-	-
27-23005	2	Gasket, check valve to housing	2	2	-	-
21-20963	3	Valve, check	2	2	-	-
23004	4	Retainer, check valve	1	1	-	-
10-20037	5	Screw, retainer to housing	2	2	-	-
27-24863	6	Gasket, fuel pump	2	2	-	-
23014	7	Diaphragm, fuel pump	1	1	-	-
22-29380	-	Plug, pipe - fuel pump	1	1	-	-
30269A2	1	Fuel Pump Assembly (<i>started with serial #1362198</i>)	1	1	1	1
27-23005	2	Gasket, check valve to housing	2	2	2	2
21-30430	3	Valve, check	2	2	2	2
23004	4	Retainer, check valve	1	1	1	1
10-20037	5	Screw, retainer to housing	2	2	2	2
27-24863	6	Gasket, fuel pump	2	2	2	2
23014	7	Diaphragm, fuel pump	1	1	1	1
23008	8	Cover, fuel pump	1	1	1	1
27-30276	9	Gasket, fuel pump cover	1	1	1	1
10-29126	10	Screw, fuel pump mounting (1 3/4")	2	2	2	2
10-29029	11	Screw, fuel pump mounting (1 1/2")	1	1	1	1
22-22949	12	Connector, pump inlet to fuel line	1	1	1	1
22-22946	13	Sleeve, rubber - connector	1	1	1	1
11-22948	14	Nut, connector to fuel line	1	1	1	1
32-30035	15	Fuel Line, fuel pump to lower filter	1	1	1	1
22-22995	16	Elbow, fuel pump inlet	1	1	1	1
22-22946	17	Sleeve, rubber	1	1	1	1
11-22948	18	Nut, elbow	1	1	1	1
32-30036	19	Fuel Line, fuel pump to adaptor	1	1	1	1
22833	20	Adaptor, check unit (fuel line)	1	1	1	1
23069	21	Stem, check unit adaptor	1	1	1	1
25-20415	22	"O" Ring, adaptor stem	1	1	1	1
24-23067	23	Spring, adaptor stem	1	1	1	1
23068	24	Cup Washer, adaptor	1	1	1	1
10-20784	25	Screw, adaptor to bottom cowl	2	2	2	2
11-24652	26	Nut, adaptor screw	2	2	2	2
22-25443	--	Elbow, upper filter to fuel line	1	1	-	-
32-29194	--	Fuel Line, upper to lower filter	1	1	-	-
32-30038	27	Fuel Line, upper to lower filter	1	1	1	1
22-25956	28	Tee Assembly, lower filter	1	1	1	1

NOTE: The following parts are required to fasten 50-29105 Starter Motor Assembly to crankcase flange:

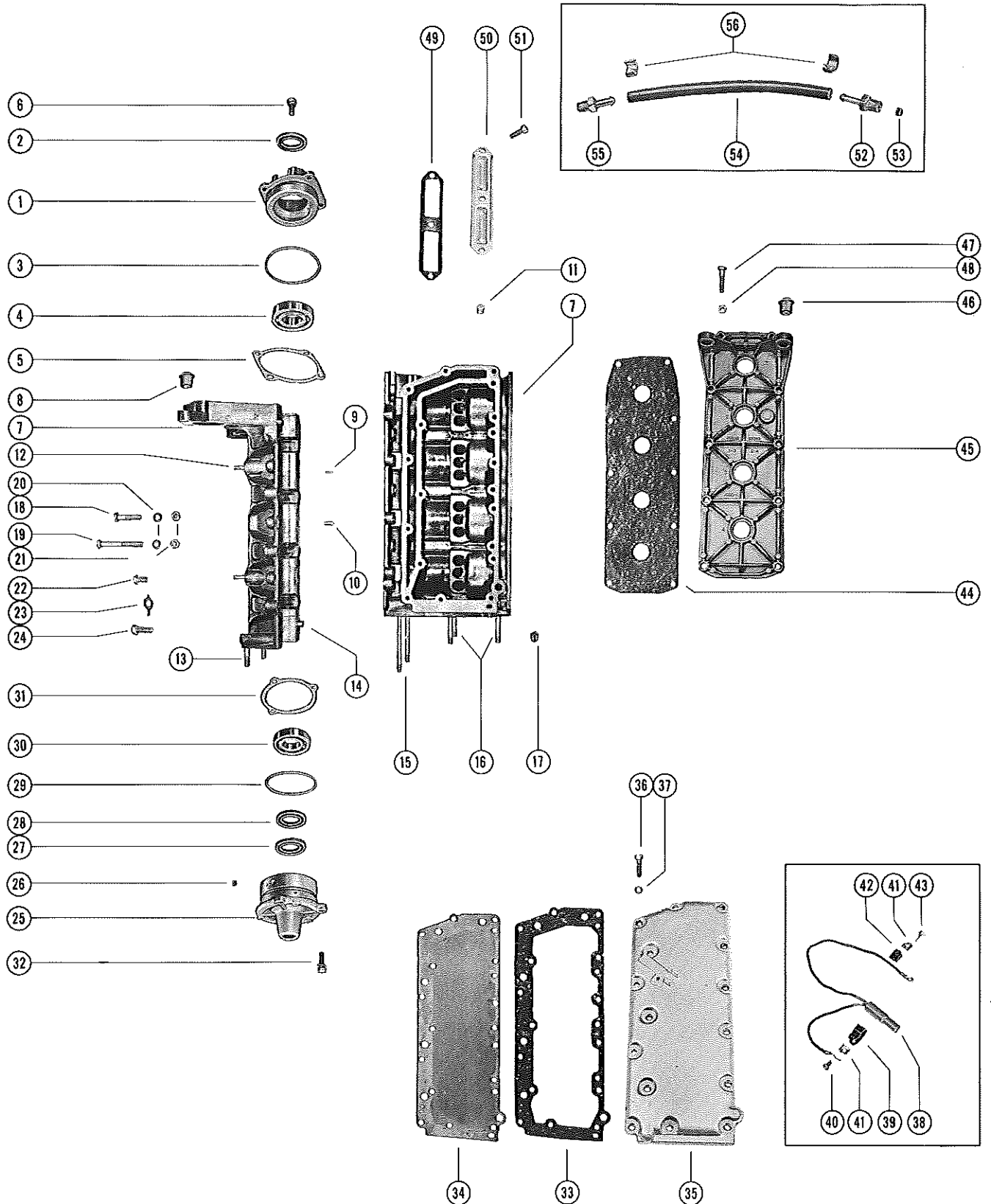
10-22698	Screw, starter motor to crankcase	2
13-26993	Lockwasher, starter motor fastening screw	2
25596	Wire, starter motor to starter solenoid	1
10-29197	Screw, ground wire to starter motor	1
13-26992	Lockwasher, ground wire fastening screw	1

CYLINDER BLOCK AND CRANKCASE ASSEMBLY

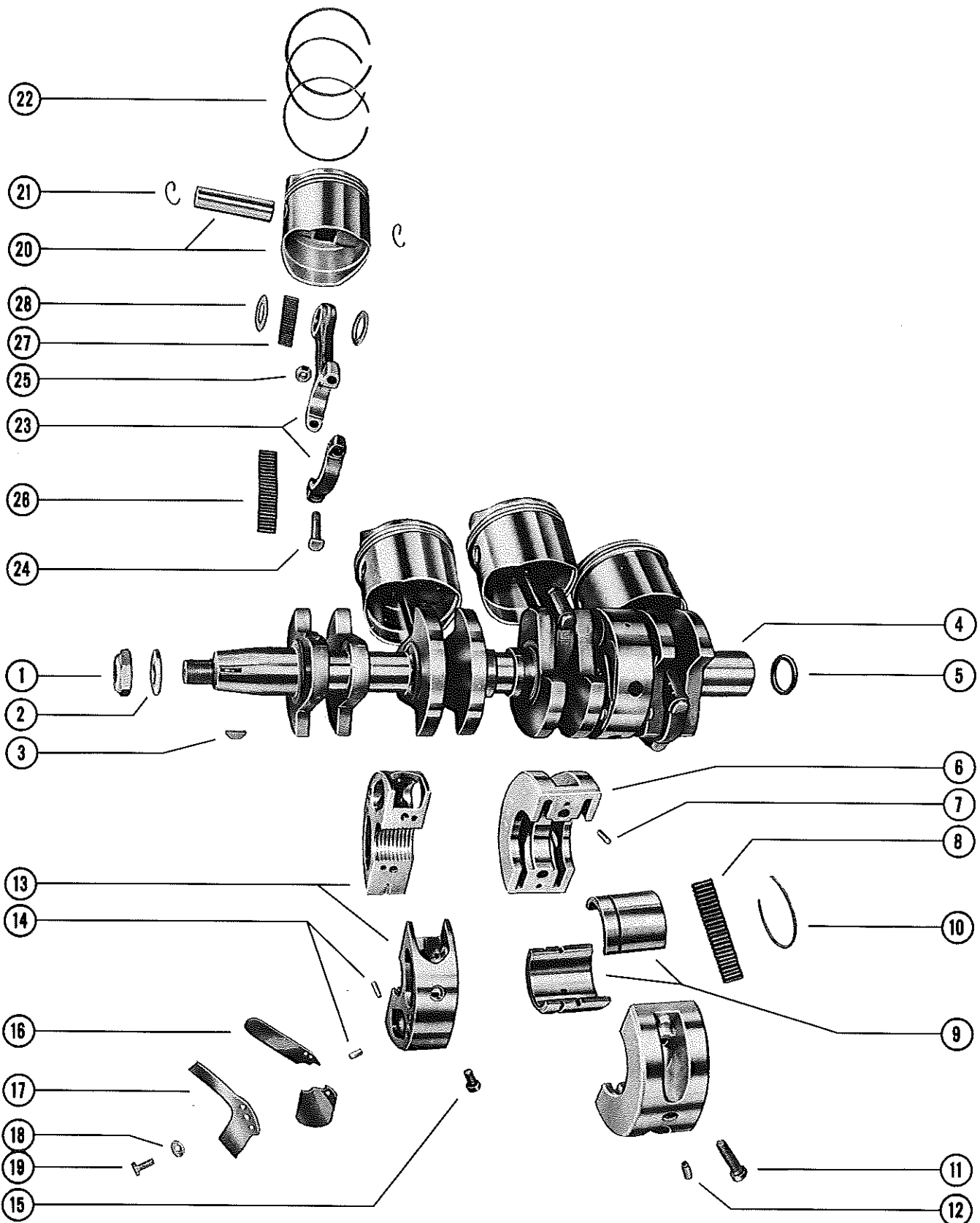
PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
1100-339A1	1	End Cap Assembly, upper	1	1	1	1
26-29476	2	Oil Seal	1	1	1	1
25-20081	3	"O" Ring, upper end cap	1	1	1	1
30-20080	4	Ball Bearing, upper end cap	1	1	1	1
15-20082	5	Shim, upper end cap to crankcase and block (.002-3-5-10)	AR	AR	AR	AR
10-29198	6	Screw, upper end cap mounting	4	4	4	4
831-1410A4	7	Cylinder Block and Crankcase Assembly (see note below)	1	1	1	1
23-26348	8	Bushing, crankcase	2	2	2	2
17-20032	9	Dowel Pin, cylinder block to main bearing	2	2	2	2
17-20323	10	Dowel Pin, cylinder block to center main bearing	1	1	1	1
22-30139	11	Plug, pipe - water pressure hole	1	1	1	1
16-21831	12	Stud, carburetor mounting (1 1/4")	4	4	4	4
16-29988	13	Stud, crankcase to drive shaft housing (1 5/8")	2	2	2	2
17-20033	14	Dowel Pin, crankcase to cylinder block	2	2	2	2
16-29990	15	Stud, cylinder block to drive shaft housing (3 7/16")	2	2	2	2
16-29989	16	Stud, cylinder block to drive shaft housing (1 15/16")	4	4	4	4
22-21290	17	Plug, pipe - upper or lower bleed hole	1	1	1	1
10-22040	18	Screw, crankcase to cylinder block (1 1/2")	14	14	14	14
10-22039	19	Screw, crankcase to cylinder block (2 3/4")	4	4	4	4
12-20084	20	Washer, crankcase screw	2	2	2	2
11-29250	21	Nut, crankcase fastening screw	18	18	18	18
10-20089	22	Screw, main bearing locking	2	2	-	-
10-26801	22	Screw, main bearing locking	-	-	2	2
14-20091	23	Tab Washer, bearing locking screw	3	3	3	3
10-20359	24	Screw, center main bearing locking	1	1	1	1
1102-1484A1	25	End Cap Assembly, lower	1	1	1	1
21-28481A1	26	Check Valve Assembly, lower end cap	1	1	1	1
26-29477	27	Oil Seal, lower	1	1	1	1
26-29476	28	Oil Seal, upper	1	1	1	1
25-20081	29	"O" Ring, lower end cap	1	1	1	1
30-20080	30	Ball Bearing, lower end cap	1	1	1	1
15-20085	31	Shim, lower end cap to crankcase and block (.002-3-5-10)	AR	AR	AR	AR
10-29198	32	Screw, lower end cap mounting	3	3	3	3
27-26923	33	Gasket, cylinder block to manifold plate	1	1	1	1
26922	34	Plate, exhaust manifold	1	1	1	1
27-26923	33	Gasket, manifold plate to exhaust cover	1	1	1	1
28240	35	Cover, exhaust manifold	1	1	1	1
10-28668	36	Screw, manifold cover to cylinder block	13	13	13	13
10-28666	36	Screw, manifold cover and high tension lead clip mounting	2	2	2	2
12-20028	37	Washer, manifold cover and high tension lead clip screws	2	2	2	2
28060	38	Switch, mercury - exhaust manifold cover	1	1	1	1
54-22875	39	Clamp, mercury switch to manifold cover	1	1	1	1
10-20401	40	Screw, mercury switch clamp fastening	1	1	1	1
22789	41	"D" Washer, clamp and clip fastening screw	2	2	2	2
54-25231	42	Clip, mercury switch lead wire to magneto	1	1	1	1
10-20401	43	Screw, lead wire clip fastening	1	1	1	1
27-22333	44	Gasket, cylinder block cover	1	1	1	1
1000-1A1	45	Cylinder Block Cover Assembly (see note below)	1	1	1	1
23-26348	46	Bushing, cylinder block cover	2	2	2	2
10-20653	47	Screw, cylinder block cover mounting	10	10	10	10
11-24652	48	Nut, cover mounting screw	10	10	10	10
27-27936	49	Gasket, transfer port cover	2	2	2	2
27935	50	Cover, transfer port	2	2	2	2
10-20540	51	Screw, transfer port cover mounting	6	6	6	6
21-28483A1	52	Check Valve Assembly, bleed hose (upper)	1	1	1	1
21-28481A1	53	Check Valve Assembly, bleed hose valve	1	1	1	1
32-28654	54	Hose, cylinder bleed (6 1/2")	1	1	1	1
22-20445	55	Connector, cylinder bleed hose (lower)	1	1	1	1
54-20387	56	Clamp, bleed hose to check valve and connector	2	2	2	2

NOTE: On later production engines, the water pressure hole was removed from the cylinder block cover and added to the cylinder block. The same pipe plug (22-30139) fits both water pressure holes.

CYLINDER BLOCK AND CRANKCASE ASSEMBLY



CRANKSHAFT, PISTON AND CONNECTING ROD



CRANKSHAFT, PISTON AND CONNECTING ROD

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
11-22339	1	Nut, flywheel	1	1	1	1
12-26617	2	Washer, flywheel nut	1	1	1	1
28-20094	3	Key, flywheel drive	1	1	1	1
400-1650	4	Crankshaft (use thru serial #1365967)	1	1	-	-
400-1730	4	Crankshaft (started with serial #1365968)	1	1	1	1
25-29619	5	"O" Ring, drive shaft spline	1	1	1	1
500-1030A1	6	Center Main Bearing Assembly	1	1	1	1
17-20032	7	Dowel Pin, center main bearing	2	2	2	2
29-20046	8	Bearing, needle	@56	@56	28	28
20047	9	Race, outer	1	1	1	1
53-20048	10	Ring, snap - outer race clamping	1	1	1	1
10-20482	11	Screw, center main bearing clamping	2	2	2	2
17-20379	12	Dowel Pin (stepped)	1	1	1	1
526-1436A1	13	Main Bearing Assembly (valve type)	2	2	-	-
17-20032	14	Dowel Pin, main bearing	20	20	-	-
10-20049	15	Screw, main bearing clamping	4	4	-	-
527-1619A1	13	Main Bearing Assembly (valve type)	-	-	2	2
17-20032	14	Dowel Pin, main bearing	-	-	20	20
10-26184	15	Screw, main bearing clamping	-	-	4	4
11-24652	--	Nut, main bearing clamping screw	-	-	4	4
34-20888	16	Reed Set, matched - main bearing	2	2	2	2
34-20053	17	Reed Stop, main bearing reed valves	8	8	8	8
12-26014	18	Washer, reed stop mounting screw	8	8	-	-
10-20055	19	Screw, reed stop mounting	8	8	-	-
10-29465	19	Screw, reed stop mounting	-	-	8	8
11-29469	--	Nut, reed stop mounting screw	-	-	8	8
724-1631A2	20	Piston and Piston Pin Assembly	4	4	4	4
40-20057	21	Lock Ring, piston pin	8	8	8	8
39-27841	22	Ring, piston	12	12	12	12
600-7A4	23	Connecting Rod and Cap Assembly (see note below)	4	4	4	4
10-20060	24	Screw, cap to connecting rod	8	8	8	8
11-20061	25	Nut, connecting rod screw	8	8	8	8
29-20046	26	Bearing, needle - crankpin	100	100	100	100
29-20063	27	Bearing, needle - piston pin	88	88	88	88
12-28121	28	Washer, needle locating	8	8	8	8

© With 400-1730 crankshaft only 28 of 29-20046 needle bearings are required.

Oversize Piston and Ring

724-1663A1	--	Piston and Piston Pin Assembly (.015)	4	4	4	4
39-28616	--	Ring, piston (.015)	12	12	12	12

NOTE: 600-7A1, 600-7A3 and 600-7A4 Connecting Rod and Cap Assemblies are identical to each other except for thickness of needle locating washers. The connecting rods can be made interchangeable by removing washers from one assembly and using the washers of another thickness depending on which model engine they are to be used. Consult parts list for correct washer part number. See chart below.

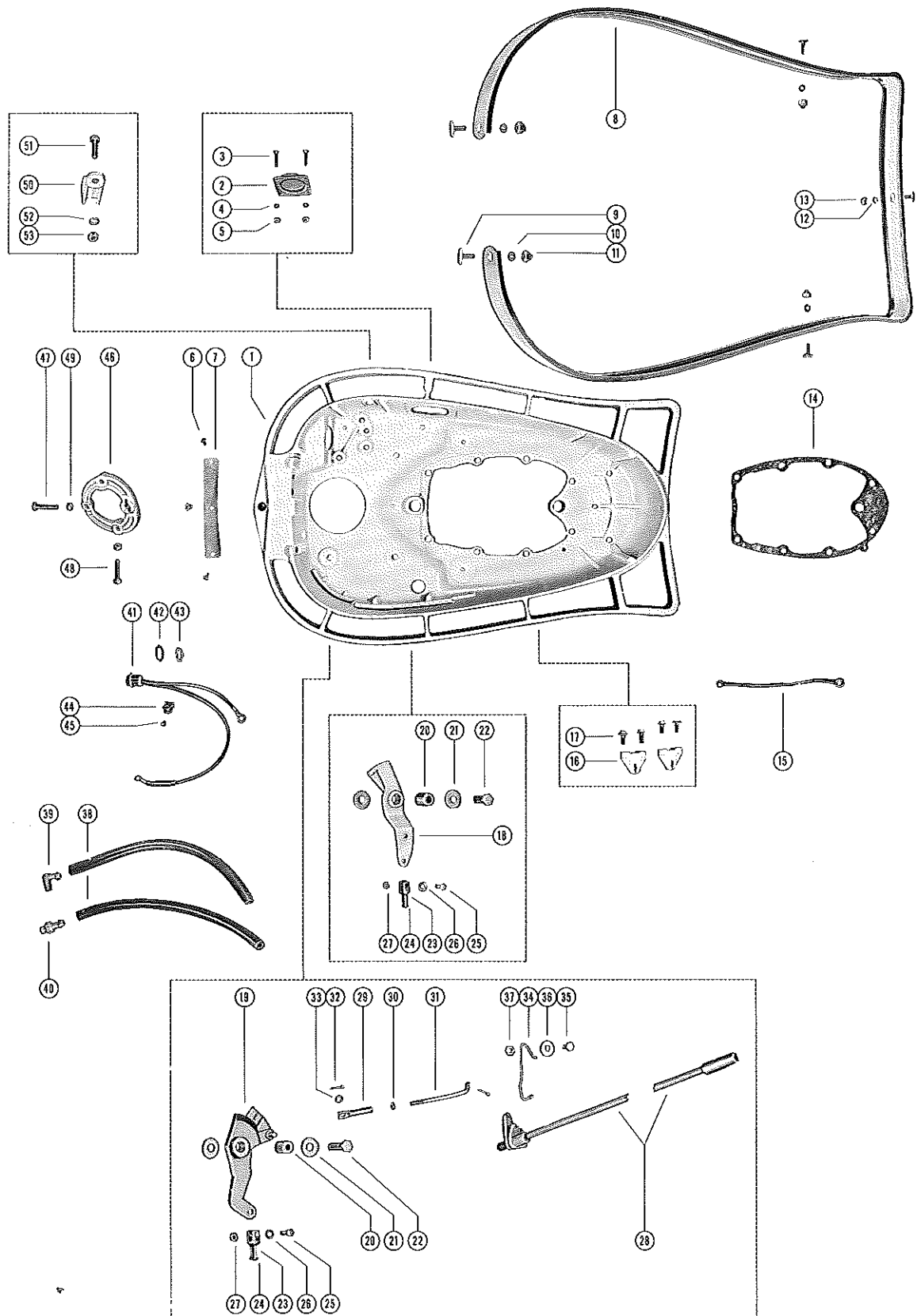
Connecting Rod & Cap Assembly	Washer	Washer Thickness
600-7A1	12-20064	1/4"
600-7A3	12-26178	1/32"
600-7A4	12-28121	1/16"

BOTTOM COWL ASSEMBLY

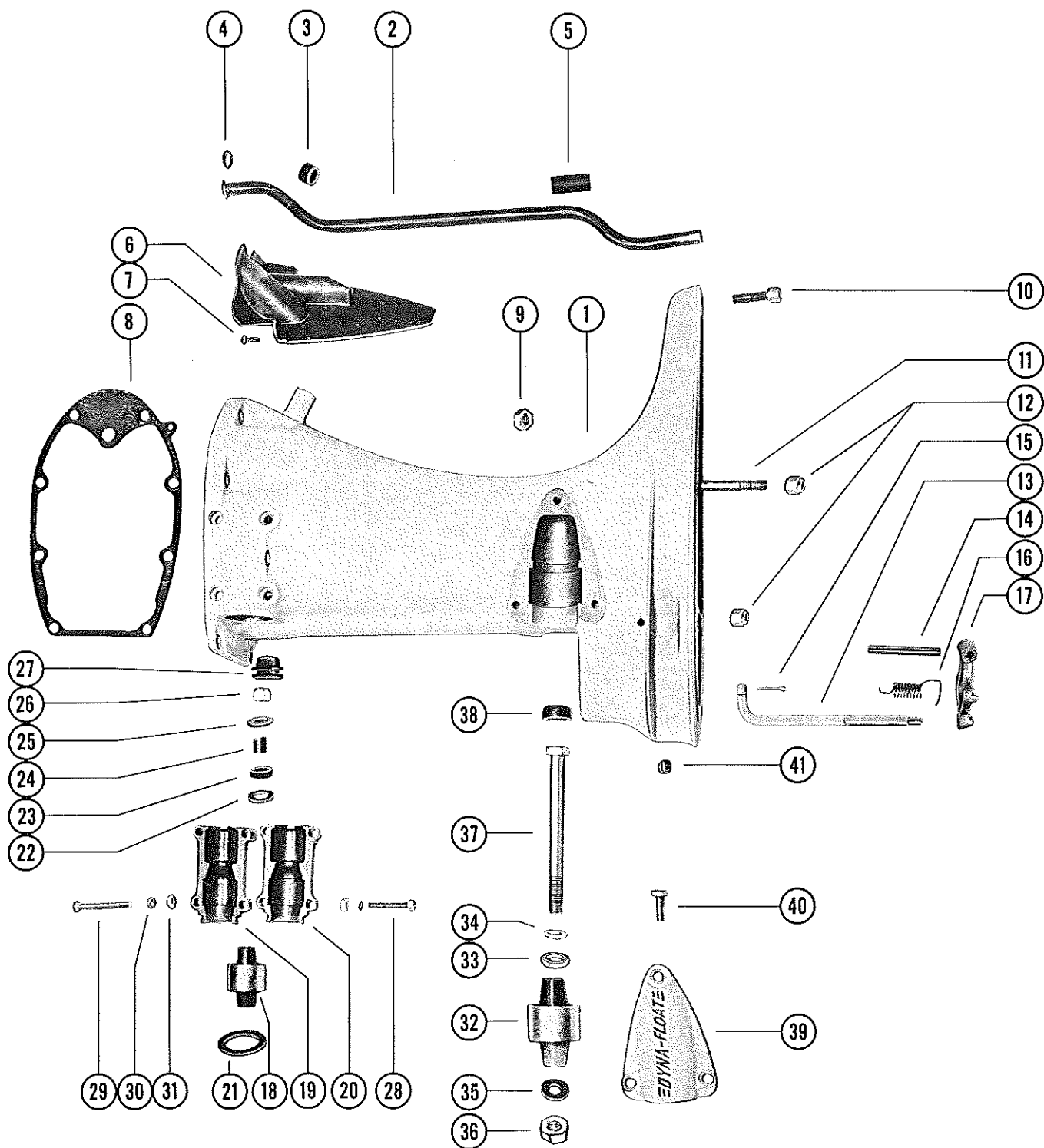
PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
103-1597A3	1	Bottom Cowl Assembly - <i>not as shown</i>	1	1	-	-
103-1838A1	1	Bottom Cowl Assembly	-	-	1	1
21041	-	Insert, top lock - bottom cowl	1	1	-	-
29206	2	Cover, plug - bottom cowl harness hole	1	*	1	*
10-26128	3	Screw, plug cover to bottom cowl	4	*	4	*
13-26995	4	Lockwasher, plug cover fastening screw	4	*	4	*
11-26419	5	Nut, plug cover fastening screw	4	*	4	*
23760	6	Baffle, bottom cowl	1	1	1	1
10-21106	7	Screw, baffle to bottom cowl	3	3	3	3
29229A1	8	Trim Moulding Assembly (chrome)	1	1	1	1
10-29226	9	Screw, decorative - moulding to bottom cowl	5	5	5	5
12-24671	10	Washer, fibre - moulding fastening screw	4	4	4	4
11-29225	11	Nut, nylon cap - moulding fastening screw	4	4	4	4
13-26995	12	Lockwasher, moulding fastening screw	1	1	1	1
11-26419	13	Nut, brass - moulding fastening screw	1	1	1	1
27-20390	14	Gasket, powerhead to bottom cowl	1	1	1	1
30109	15	Ground Strap, cylinder block to bottom cowl	1	1	1	1
20557	16	Bracket, cable end anchor	2	2	2	2
10-29200	17	Screw, anchor bracket to bottom cowl	4	4	4	4
29532	18	Lever, throttle control	1	1	1	1
29824	19	Lever, shift control	1	1	1	1
23-29529	20	Bushing, throttle and shift lever	2	2	2	2
12-29395	21	Washer, throttle and shift lever fastening screw	4	4	4	4
10-26632	22	Screw, throttle and shift lever fastening	2	2	2	2
17-30978A1	23	Pin Assembly, clevis yoke	2	2	2	2
17-23928	24	Roll Pin, clevis yoke pin	2	2	2	2
10-20584	25	Screw, clevis yoke pin to lever	2	2	2	2
13-29402	26	Washer, wave - clevis pin fastening screw	2	2	2	2
11-29488	27	Nut, clevis pin fastening screw	2	2	2	2
25180	28	Shift Shaft Assembly, upper	1	1	1	1
27714	29	Rod (sleeve), shift control end	1	1	1	1
11-25168	30	Nut, adjusting - shift shaft end	1	1	1	1
25134	31	Rod, link - shift shaft end	1	1	1	1
18-20180	32	Cotter Pin, link rod to shift shaft	2	2	2	2
12-20583	33	Washer, shift control end rod	1	1	1	1
24-25065	34	Spring, detent - shift shaft	1	1	1	1
10-20776	35	Screw, detent spring to bottom cowl	1	1	1	1
12-20346	36	Washer, detent spring screw	1	1	1	1
11-20184	37	Nut, detent spring fastening screw	1	1	1	1
32-29164	38	Tube, vent - magneto outlet (10 1/2")	2	2	2	2
22-25885	39	Elbow, magneto vent tube	1	1	1	1
22-29111	40	Nipple, magneto vent tube	1	1	1	1
21104A2	41	Connector Base Assembly	1	-	1	-
13-21972	42	Lockwasher, connector base	1	-	1	-
11-21971	43	Nut, connector base to bottom cowl	1	-	1	-
54-25231	44	Clip, connector base lead wire	1	-	1	-
10-21106	45	Screw, lead wire clip to bottom cowl	1	-	1	-
30999	46	Bracket, lock knob - cowl front cover	-	-	1	1
10-21091	47	Screw, bracket to bottom cowl (1 1/8")	-	-	1	1
12-28927	--	Washer, bracket fastening screw	-	-	1	1
10-22421	48	Screw, bracket to bottom cowl (1 1/4")	-	-	2	2
11-20184	49	Nut, bracket fastening screw	-	-	3	3
26552	50	Support, external wiring harness	-	1	-	1
10-20639	51	Screw, harness support to bottom cowl	-	1	-	1
12-20084	52	Washer, harness support fastening screw	-	1	-	1
11-29250	53	Nut, harness support fastening screw	-	1	-	1
38-28230	--	Plate, trade mark - bottom cowl	1	1	-	-
53-25539	--	Fastener, trade mark plate to bottom cowl	2	2	-	-

(* remove - not required on electric engines)

BOTTOM COWL ASSEMBLY



DRIVE SHAFT HOUSING ASSEMBLY



DRIVE SHAFT HOUSING ASSEMBLY

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
1522-1567	1	Drive Shaft Housing	1	1	1	1
32-25187	2	Tube, water inlet	1	1	1	1
25-24961	3	Ring, rubber - water inlet tube	1	1	1	1
26-25192	4	Seal, water inlet tube	1	1	1	1
23-23651	5	Sleeve, water inlet tube	1	1	1	1
24945	6	Baffle, exhaust relief	1	1	1	1
10-25255	7	Screw, baffle to drive shaft housing	2	2	2	2
27-24899	8	Gasket, drive shaft housing to bottom cowl	1	1	1	1
11-25594	9	Nut, powerhead studs	8	8	8	8
10-25093	10	Screw, gear housing to drive shaft housing	1	1	1	1
16-29103	11	Stud, drive shaft housing to gear housing	1	1	1	1
11-22178	12	Nut, gear housing and drive shaft housing studs	3	3	3	3
28470	13	Rod, push - reverse lock	1	1	1	1
17-24887	14	Pin, reverse lock lever	1	1	1	1
18-25191	15	Cotter Pin, push rod	1	1	1	1
24-25122	16	Spring, tension - push rod	1	1	1	1
25140	17	Lever, reverse lock	1	1	1	1
24926	18	Mount, rubber - upper	2	2	2	2
24935	19	Cover, upper mount - outside half	2	2	2	2
24936	20	Cover, upper mount - inside half	2	2	2	2
24929	21	Packing, "U" cup	2	2	2	2
12-24889	22	Washer, upper mount stud (17/32 ID)	2	2	2	2
12-24891	23	Washer, rubber - upper mount stud	2	2	2	2
23-24892	24	#Spacer, upper mount stud	2	2	-	-
23-30474	24	@Spacer, upper mount stud	2	2	2	2
12-24890	25	#Washer, upper mount stud (13/32 ID)	2	2	-	-
12-30473	25	@Washer, upper mount stud (25/64 ID)	2	2	2	2
11-23161	26	Nut, upper mount stud	2	2	2	2
25305	27	Cap, rubber - upper mount	2	2	2	2
10-28772	28	Screw, upper mount cover (1 1/2")	4	4	4	4
10-29389	29	Screw, upper mount cover (1 7/8")	4	4	4	4
12-29245	30	Washer, mounting cover screw	8	8	8	8
11-29322	31	Nut, mounting cover screw	8	8	8	8
24925	32	Mount, rubber - lower	2	2	2	2
12-28053	33	Washer, rubber - lower mount	2	2	2	2
12-28051	34	Washer, lower mount	2	2	2	2
12-24872	35	Washer, mounting screw (1/16") (Use with 28028 bottom yoke)	2	2	-	-
12-30119	35	Washer, mounting screw (1/8") (Use with 30133A1 and 30462A1 bottom yoke)	2	2	2	2
11-25096	36	Nut, mounting screw	2	2	2	2
10-24874	37	Screw, lower mount (5 1/2") (use thru serial #1365072)	2	2	-	-
10-30452	37	Screw, lower mount (5 1/2") (started with serial #1365073)	2	2	2	2
25067	38	Bumper, rubber - mounting screw	2	2	2	2
28241	39	Cover, lower mount (port side)	1	1	1	1
28242	39	Cover, lower mount (starboard side)	1	1	1	1
10-29256	40	Screw, lower mount cover fastening	6	6	6	6
22-21290	41	Plug, grease - reverse lock hole	1	1	1	1

Use thru serial #1363346

@ Started with serial #1363347

CLAMP AND SWIVEL BRACKET

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
1440-1466A1	1	Clamp Bracket Assembly (See note (1) below)	2	2	2	2
28403A3	2	Thumb Screw Assembly	2	2	2	2
12-28404	3	Washer, thumb screw	2	2	2	2
28122	4	Tube, tilt - clamp bracket to swivel bracket	1	1	1	1
15-25600	5	Shim, clamp bracket to swivel bracket	2	2	2	2
11-25599	6	Nut, tilt tube	2	2	2	2
25606	7	Cap, plastic - tilt tube	2	2	2	2
16-20221	8	Stud, clamp bracket	1	1	1	1
23-20222	9	Spacer, clamp bracket stud	1	1	1	1
13-26993	10	Lockwasher, clamp bracket stud	2	2	2	2
11-20083	11	Nut, clamp bracket stud	2	2	2	2
17-29219A1	12	Tilt Lock Pin Assembly	1	1	1	1
32-28052	13	Sleeve, rubber - tilt lock pin bumper	1	1	1	1
30200A1	14	Tilt Stop Lever Assembly	1	1	1	1
10-28339	15	Screw, tilt stop lever anchor	2	2	2	2
13-20846	16	Washer, wave - lever anchor screw	2	2	2	2
11-24652	17	Nut, lever anchor screw	2	2	2	2
26903A3	18	Reverse Lock Assembly	1	1	1	1
18-20209	19	Cotter Pin, reverse lock to shaft	1	1	1	1
24-29821	20	Spring, reverse lock tension	1	1	1	1
17-25598	21	Pin, reverse lock spring attaching	1	1	1	1
20208	22	Shaft, reverse lock to swivel bracket	1	1	1	1
1444-1421A1	23	Swivel Bracket Assembly	1	1	1	1
22-23612	24	Fitting, grease - swivel bracket	1	1	1	1
26-26209	25	Oil Seal (2 oil seals required on later production engines)	(2)1	(2)1	2	2
29359	26	Lubricap, swivel bracket grease fitting	1	1	1	1
55-28415	27	Pin, upper shock mounting	1	1	1	1
23-28024	28	Spacer, upper bushing to clamp bracket	2	2	2	2
12-28025	29	Washer, upper bushing retainer (inner)	2	2	2	2
12-28420	30	Washer, upper bushing retainer (outer)	2	2	2	2
10-28449	31	Bolt, nylock - upper shock mounting pin	2	2	2	2
55-28413	32	Pin, lower shock mounting	2	2	2	2
23-28032	33	Spacer, lower bushing to swivel bracket	2	2	2	2
12-28420	34	Washer, lower bushing retainer (outer)	2	2	2	2
10-28449	35	Bolt, nylock - lower shock mounting pin	2	2	2	2
55-28054	36	Shock Absorber	2	2	2	2
23-28055	37	Bushing, rubber - shock absorber	8	8	8	8
17-28418A2	38	#Swivel Pin and Top Yoke Assembly	1	1	-	-
11-28202	39	Nut, swivel pin retaining	1	1	-	-
17-28418A4	40	@Swivel Pin and Top Yoke Assembly	1	1	1	1
11-28202	39	Nut, swivel pin retaining	1	1	1	1
10-30266	41	Bolt, upper mounts to swivel pin	2	2	2	2
28066	42	Bumper, top yoke	1	1	-	-
30711	43	Bumper, top yoke	-	-	1	1
30133A1	44	Bottom Yoke Assembly (See note (2) below - use thru serial #1365072)	1	1	-	-
30462A1	44	Bottom Yoke Assembly (Started with serial #1365073)	1	1	1	1
12-25176	45	Washer, swivel pin to bottom yoke	1	1	1	1
38-29534	46	Serial Plate	1	1	1	1
10-25612	47	Screw, drive - serial plate to swivel bracket	4	4	4	4
10-28009	48	Bolt, carriage - clamp bracket to boat transom	2	2	2	2
12-28008	49	Washer, carriage bolt	2	2	2	2
11-28010	50	Nut, carriage bolt	2	2	2	2

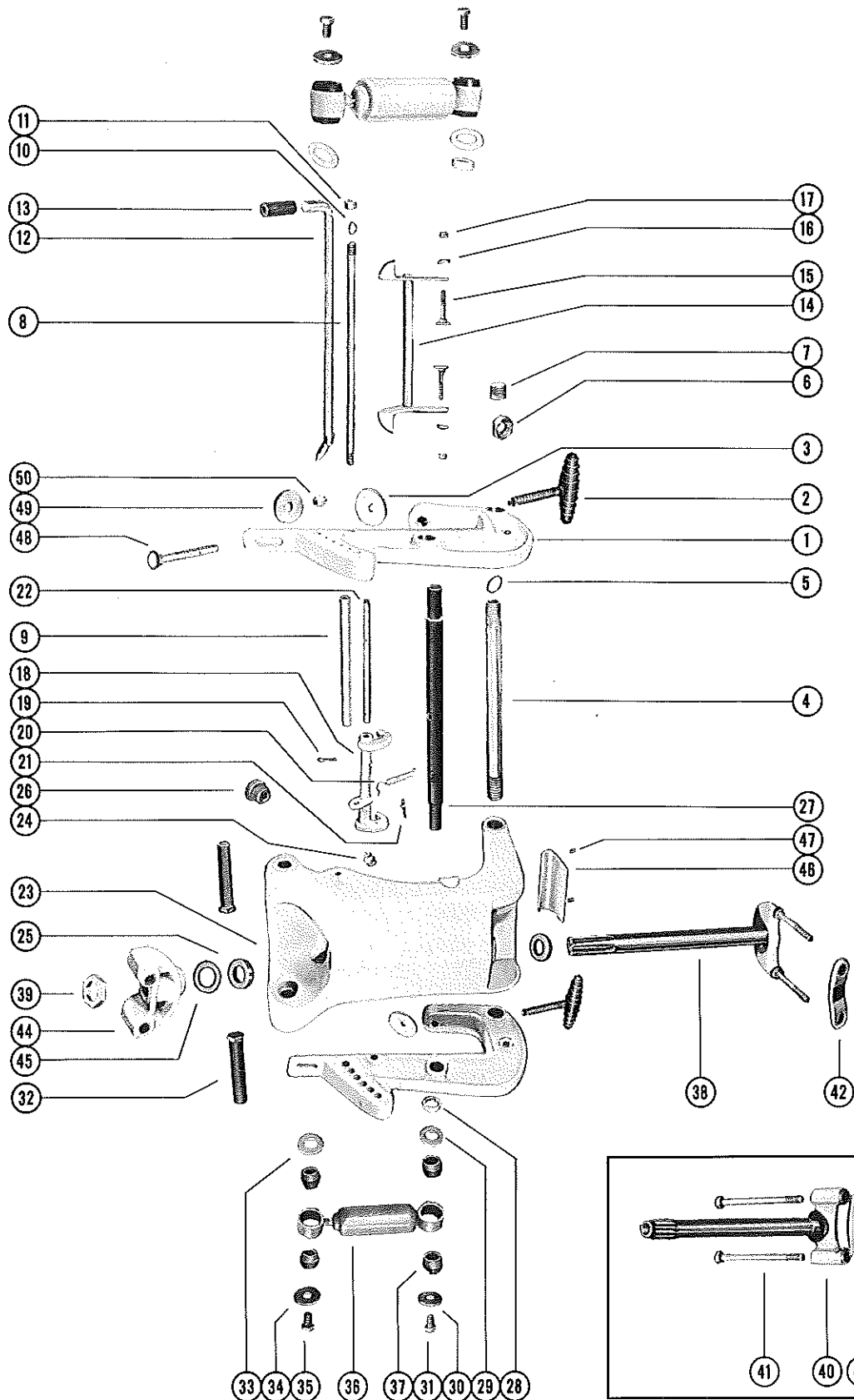
Use thru serial #1363346

@ Started with serial #1363347

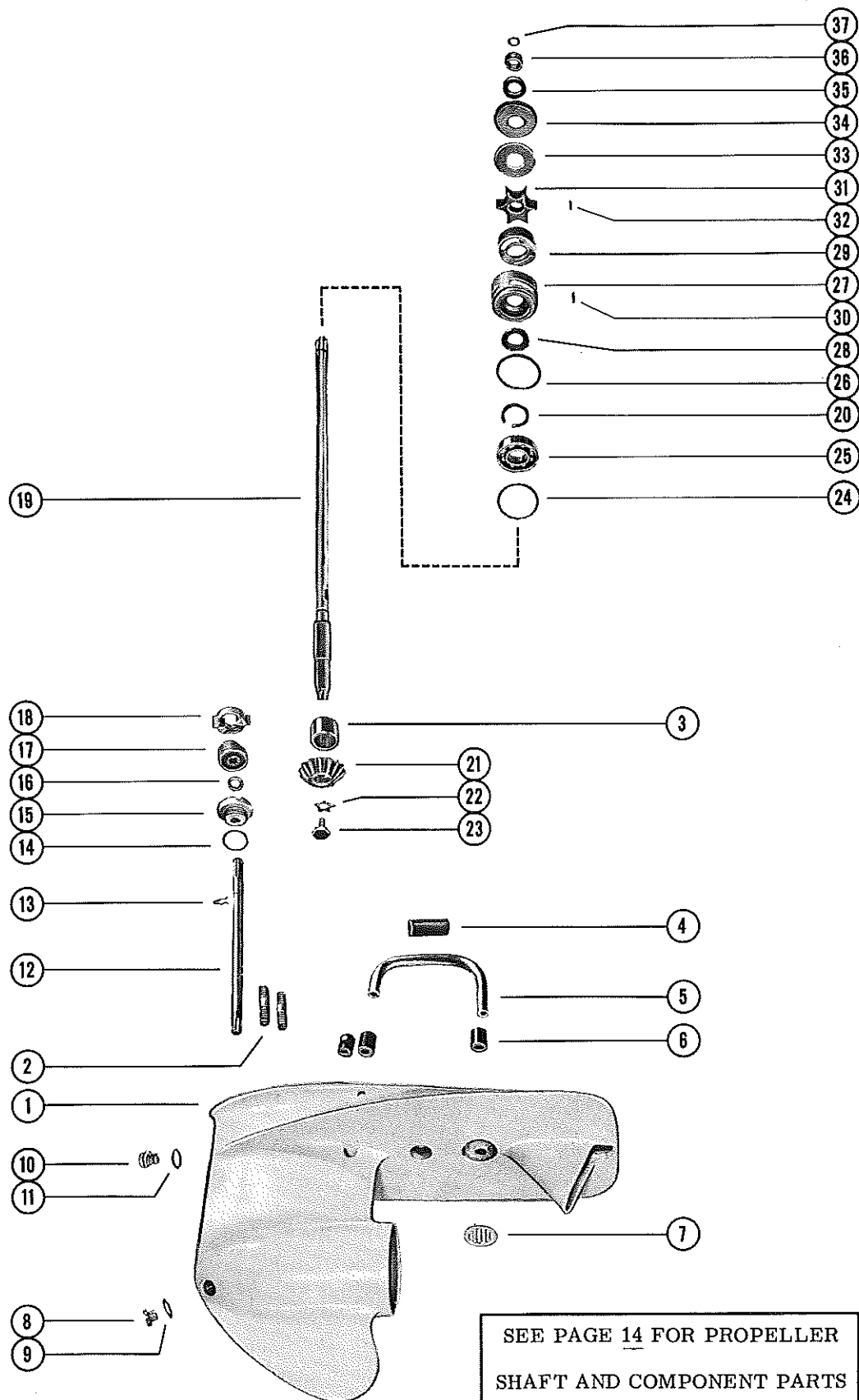
NOTE (1): When replacing clamp brackets which incorporate a bushing pressed in upper shock pin mounting hole, a 23-28024 spacer must also be ordered.

NOTE (2): The 28028 Bottom Yoke is no longer available and is replaced by 30133A1 Bottom Yoke Assembly. Only difference being in thickness of washer used. See page 11, reference #35.

CLAMP AND SWIVEL BRACKET



GEAR HOUSING ASSEMBLY, COMPLETE



GEAR HOUSING ASSEMBLY, COMPLETE

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
1603-1568A8	-	Gear Housing Assembly, Complete - <i>see note below</i>	1	1	1	1
1603-1568A3	1	Gear Housing Assembly	1	1	1	1
16-29078	2	Stud, gear housing to drive shaft housing	2	2	2	2
31-20231	3	Bearing, roller - drive shaft	1	1	1	1
23-23651	4	Sleeve, water inlet tube	1	1	1	1
32-23652	5	Tube, water inlet - lower	1	1	1	1
26-20232	6	Seal, water tube	3	3	3	3
35-23654	7	Screen, water intake - gear housing	1	1	1	1
●27-31367	-	#Gasket, water intake screen to housing	-	-	1	1
10-28634	8	Screw, grease filler and flushing hole	2	2	2	2
12-20260	9	Washer, grease filler and flushing hole screw	2	2	2	2
10-28653	10	Screw, gear housing vent	1	1	1	1
12-20262	11	Washer, gear housing vent screw	1	1	1	1
25136	12	Shaft, shift - lower	1	1	1	1
18-20233	13	Clip, retaining - shift shaft	1	1	1	1
25-25439	14	"O" Ring, shift shaft bushing	1	1	1	1
23-28374A1	15	Bushing Assembly, shift shaft	1	1	1	1
26-31249	16	Oil Seal	1	1	1	1
25138	17	Cam, lower - reverse locking	1	1	1	1
29823	18	Cam, upper - reverse locking	1	1	1	1
45-29617A1	19	Drive Shaft Assembly	1	1	1	1
53-29116	20	Ring, retaining - ball bearing	1	1	1	1
43-20834	21	Gear, pinion	1	1	1	1
14-29163	22	Tab Washer, pinion gear screw	1	1	1	1
10-20925	23	Screw, pinion gear to drive shaft	1	1	1	1
15-20929	24	Shim, drive shaft bearing to housing (.002-3-5-10)	AR	AR	AR	AR
30-20861	25	Bearing, ball - drive shaft	1	1	1	1
25-20266	26	"O" Ring, water pump cartridge	1	1	1	1
46-29117A1	27	Water Pump Cartridge Assembly	1	1	1	1
26-23300	28	Oil Seal	1	1	1	1
28091	29	Insert, water pump cartridge	1	1	1	1
28-28657	30	Key, water pump cartridge	1	1	1	1
47-20268	31	Impeller, water pump	1	1	1	1
17-23733	32	Pin, impeller drive	1	1	1	1
20272	33	Plate, outlet - water pump cover	1	1	1	1
20270A2	34	Water Pump Cover Assembly	1	1	1	1
26-23517	35	Oil Seal	1	1	1	1
25-20273	36	Ring, rubber - centrifugal slinger	1	1	1	1
25-29619	37	"O" Ring, upper - drive shaft	1	1	1	1

NOTE: 1603-1568A8 Gear Housing Assembly, Complete includes all parts from reference #1 thru reference #59 as listed on pages 13 and 14.

Started with Serial #1385792 on Merc 400M-1 and Serial #1391806 on Merc 400E-1.

GEAR HOUSING ASSEMBLY, COMPLETE

PART NO.	REF. NO.	DESCRIPTION	MERC 400M	MERC 400E	MERC 400M-1	MERC 400E-1
1603-1568A8	-	Gear Housing Assembly, Complete - see note below	1	1	1	1
1603-1568A3	1	Gear Housing Assembly. (see page 13 for parts breakdown)	1	1	1	1
30147	38	Cam, shift	1	1	1	1
20930	39	Follower, cam	1	1	1	1
20843	40	Slide, cross pin	1	1	1	1
24-20254	41	Spring, cam follower pin	1	1	1	1
15-20928	42	Shim, ball bearing to gear housing (.002-3-5-10)	AR	AR	AR	AR
43-20975A1	--	Forward Gear Assembly, Complete	1	1	1	1
30-20840	43	Bearing, ball - forward gear	1	1	1	1
43-20975	44	Forward Gear Assembly	1	1	1	1
31-20249	45	Bearing, roller - forward gear	1	1	1	1
20835	46	Ratchet, sliding clutch	1	1	1	1
17-20841	47	Pin, cross - ratchet to propeller shaft	1	1	1	1
53-20842	48	Ring, retaining - cross pin	1	1	1	1
44-25254	49	Shaft, propeller	1	1	1	1
43-20975A2	--	Reverse Gear Assembly, Complete	1	1	1	1
43-20975	50	Reverse Gear Assembly	1	1	1	1
20864	51	Ring, adaptor - ball bearing	1	1	1	1
30-20839	52	Bearing, ball - reverse gear	1	1	1	1
15-20927	53	Shim, adaptor ring to gear housing (.002-3-5-10)	AR	AR	AR	AR
20862A1	54	Bearing Carrier Assembly	1	1	1	1
31-20249	55	Bearing, roller	1	1	1	1
26-23300	56	Oil Seal	1	1	1	1
25-20863	57	"O" Ring, bearing carrier	1	1	1	1
12-22970	58	Washer, gear housing cover	1	1	1	1
20865	59	Cover, gear housing	1	1	1	1
12-25251	60	Washer, backing (1/8)	AR	AR	AR	AR
48-22914A2	61	Propeller Assembly (2 blade - aluminum)	1	1	1	1
12-25252	62	Washer, backing (1/32)	1	1	1	1
14-25250	63	Tab Washer, propeller nut	1	1	1	1
11-20837	64	Nut, propeller (aluminum)	1	1	1	1
11-29825	64	Nut, propeller (nylon)	Opt.	Opt.	Opt.	Opt.

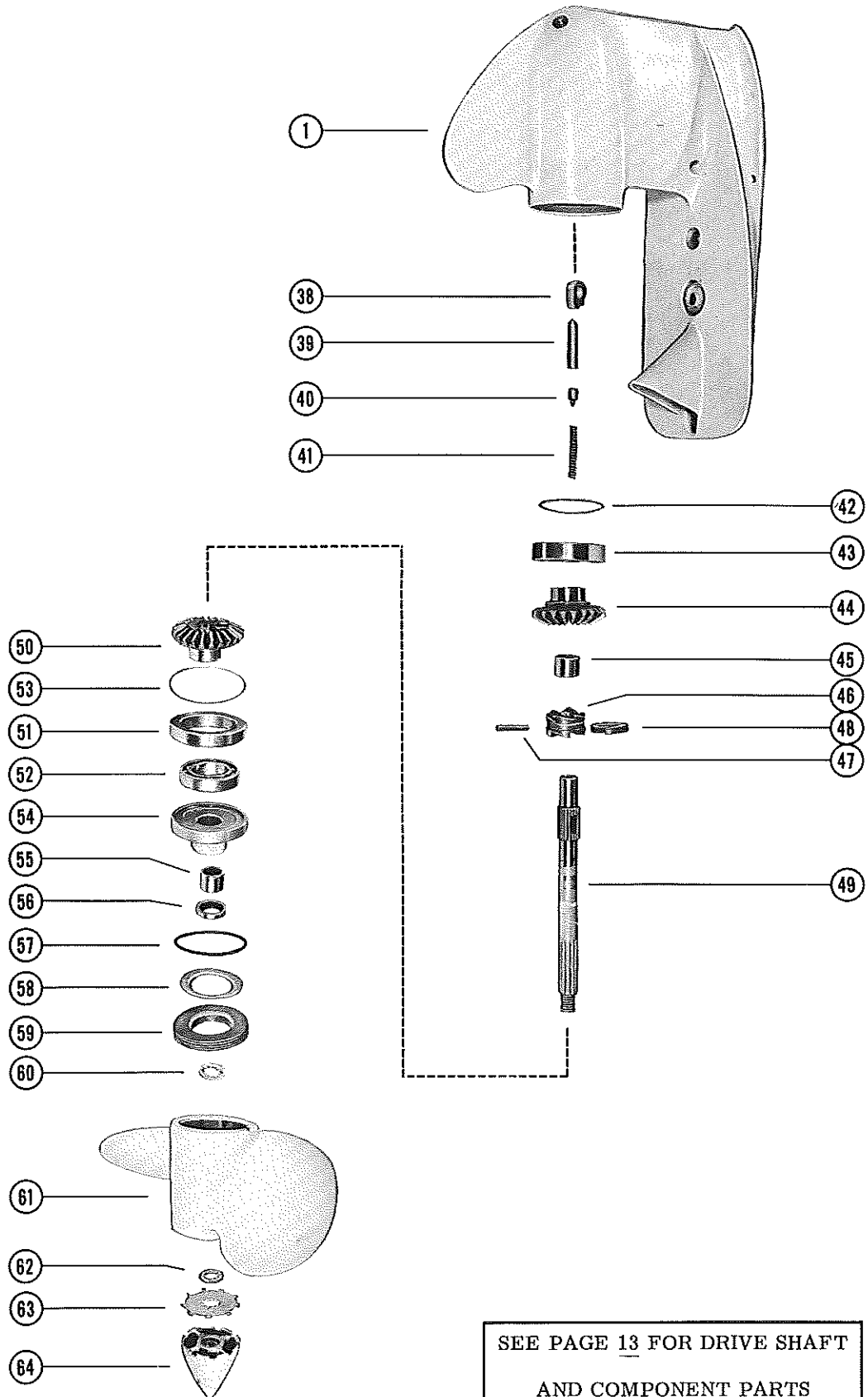
NOTE: 1603-1568A8 Gear Housing Assembly, Complete includes all parts from reference #1 thru reference #59 as listed on pages 13 and 14.

PROPELLERS

PART NO.	DESCRIPTION	MATERIAL	PITCH	, BLADES
48-22814A2	Propeller Assembly	Bronze	8"	3
48-25773A2	Propeller Assembly	Bronze	9"	2
48-29985A2	Propeller Assembly	Aluminum	10"	2
48-26666A2	Propeller Assembly	Bronze	10"	2
48-22105A2	Propeller Assembly	Bronze	10"	3
48-29296A2	Propeller Assembly	Aluminum	11"	2
48-23586A2	Propeller Assembly	Bronze	11"	2
48-22914A2	#Propeller Assembly	Aluminum	12"	2
48-22636A2	Propeller Assembly	Bronze	12"	2
48-29986A2	Propeller Assembly	Aluminum	13"	2
48-23587A2	Propeller Assembly	Bronze	13"	2
48-27028A2	Propeller Assembly	Bronze	14"	2
48-28765A2	Propeller Assembly	Bronze	15"	2

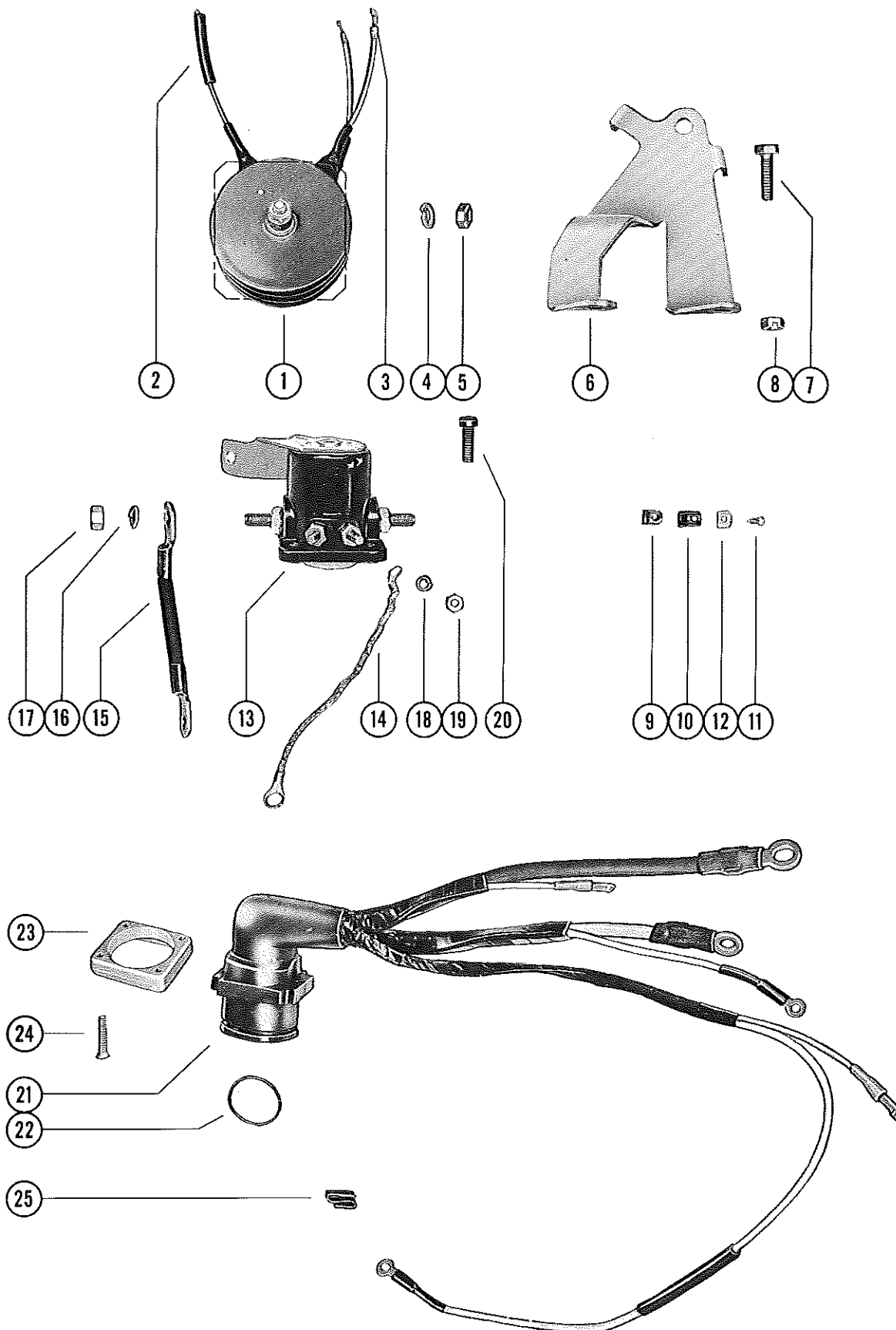
(# Shipped with engine from factory)

GEAR HOUSING ASSEMBLY, COMPLETE



SEE PAGE 13 FOR DRIVE SHAFT
AND COMPONENT PARTS

RECTIFIER, STARTER SOLENOID AND WIRING HARNESS



RECTIFIER, STARTER SOLENOID AND WIRING HARNESS

PART NO.	REF. NO.	DESCRIPTION	MERC 400E	MERC 400E-1
25571A2	1	Rectifier Assembly	1	1
32-29267	2	Sleeve, rectifier lead (red)	1	1
22647	3	Disconnect, knife splice - rectifier lead wires	3	3
13-26993	4	Lockwasher, rectifier mounting screw	1	1
11-21929	5	Nut, rectifier mounting screw	1	1
28597	6	Bracket, rectifier mounting	1	1
10-21091	7	Screw, rectifier bracket to bottom cowl	2	2
11-24652	8	Nut, bracket mounting screw	2	2
54-24836	9	Clamp, lead wire to rectifier bracket - upper (1/4)	1	1
54-22740	10	Clamp, lead wire to rectifier bracket - lower (3/8)	1	1
10-30009	11	Screw, lead wire clamp to bracket	2	2
22789	12	"D" Washer, clamp fastening screw	2	2
28062	13	Solenoid, starter	1	1
28016A1	14	Ground Strap Assembly, solenoid to starter	1	1
25596	15	Wire, starter to starter solenoid	1	1
13-26993	16	Lockwasher, solenoid terminal (5/16)	2	2
11-20083	17	Nut, solenoid terminal - inside (5/16)	1	1
11-26062	17	Nut, cap - solenoid terminal - outside (5/16)	1	1
13-26996	18	Lockwasher, solenoid terminal (#10)	2	2
11-20645	19	Nut, solenoid terminal (#10)	2	2
10-29238	20	Screw, solenoid to starter motor	2	2
28370	21	Wiring Harness (Internal)	1	1
24-28975	22	Spring, garter - internal wiring harness	1	1
26079	23	Plate, backing - wiring harness	1	1
10-26128	24	Screw, backing plate to bottom cowl	4	4
54-22783	25	"S" Clip, wiring harness leads to bottom cowl	2	2

REMOTE CONTROL, STARTER MOTOR AND FUEL TANK

For reference to Remote Control, Starter Motor, Fuel Tank, Etc. not shown in this parts list, please refer to the section in your Accessory Parts List as indicated below:

		<u>Refer to Section</u>
1225-1529A5	Fuel Tank Assembly	"D"
29564-__S	Remote Control Cable Assembly	"B"
30063A1	Remote Control Housing Assembly (standard)	"B"
30062A__	Remote Control Assembly (electric)	"B"
29649A__	Shorting Switch Assembly	"B"
50-29105	Starter Motor Assembly (Delco-Remy)	"E"
29822A1	Steering Handle Assembly	"C"

MERC 400ML AND MERC 400EL PARTS LIST

All parts listed below are for the Merc 400ML and Merc 400EL engines and are used in place of the corresponding parts as shown. For reference to any other corresponding part in the Merc 400ML and Merc 400EL, please refer to preceding pages of this parts list.

SERIAL NUMBERS:

Merc 400ML 1319411 thru 1319910
 Merc 400EL 1285285 thru 1363197
 Merc 400ML-1 1389056 and up
 Merc 400EL-1 1389556 and up

PART NO.	DESCRIPTION	REPLACES	MERC 400ML 400EL	MERC 400ML-1 400EL-1
1535-1566	Housing, drive shaft	1522-1567	1	1
32-25076	Tube, water inlet	32-25187	1	1
45-29618A1	Drive Shaft Assembly	45-29617A1	1	1
25163	Shaft, shift - upper	25180	1	1
28593	Rod, push - reverse lock	28470	1	1
1448-1449A1	Swivel Bracket Assembly	1444-1421A1	1	1
17-28419A2	#Swivel Pin and Top Yoke Assembly	17-28418A2	1	-
17-28419A4	@Swivel Pin and Top Yoke Assembly	17-28418A4	1	1
27898	Baffle, exhaust relief	24945	1	1
1603-1568A9	Gear Housing Ass'y, Comp.	1603-1568A8	1	1

Use thru serial #1367174

@ Started with serial #1367175

MERC 400S AND MERC 400SL PARTS LIST

When ordering replacement parts for Merc 400S and Merc 400SL engines, please order from the preceding pages of this Merc 400E and Merc 400EL parts list with the following exception:

SERIAL NUMBERS:

Merc 400S and 400SL 1279685 thru 1367697
 Merc 400S-1 and 400SL-1 1386806 and up

PART NO.	DESCRIPTION	REPLACES	QUAN.
211-1483A4	Flywheel Assembly, Complete	211-1414A7	1