Hi-Performance MARINER OUTBOARDS

MERCURY PERFORMANCE OUTBOARDS

service bulletin

No. 96-5

Revised 3-14-1996

Replacement Cylinder Sleeves

NOTICE
This is a revision of Hi-Performance Outboard Service Bulletin 96-5. Destroy original Bulletin 96-5 and insert revised Bulletin 96-5. The only change to the Bulletin is in the part number of the sleeves.

Mercury Hi-Performance is now offering replacement cylinder sleeves for Nikasil® and Ni-Com® plated 2.5 litre cylinder blocks. The replacement sleeves are not plated.

The customer has two options:

a. Send the block to U.S. Chrome to be re-sleeved and plated.

b. Purchase and install the sleeves and then send the block to U.S. Chrome for plating.

See Hi-Performance Service Bulletin 96-4 for further details.

The sleeves are only available in an **outside** diameter oversize of 0.020 in. (0.508mm). Re-plating will bring the cylinder inside diameter back to original bore specifications. There will be no oversize pistons available. If a sleeve is damaged it must be removed and replaced.

Engine	P/N of 0.020" (0.508mm) Cylinder
2.5 EFI/2.5 EFI Offshore/2.5 EFI Offshore Race/ 2.5 Short Shaft	51-18594A9
S3000/2.5 Drag (1996 & Up)	51-18594A10

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