MERCURY Racing parts bulletin MERCURY MerCruiser

MERCURY Precision Parts

No. 2001-3

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454/502 cid Replacement Parts

Backplate Gasket Kit for V8 454/502 cid Gen VI and L29 Engines That Use P/N 850454 Circulating Water Pump

This new Gasket Kit can be used on all GM circulating pumps used on the engines with the pump listed above. Now you can repair any circulating pumps that have a leaking gasket instead of replacing the complete pump. The kit contains the backplate gasket plus the 2 pump mounting gaskets and an instruction sheet for the torquing the backplate fasteners.

P/N 27-803192A 2 Backplate Gasket Kit.

Rocker Arm Stud Kit for V8 454/502 cid Gen V, VI and L29 Engines

These engines use a net lash or non-adjustable rocker arm system. Torquing the rocker arm bolt to a specified torque sets the valve lash. When rebuilding engines with a net lash system, machining of the cylinder block deck surface, cylinder head surface, grinding the valve seats or valves may cause an incorrect valve lash condition. The most common problem that happens is the valve not closing completely after the bolt is torqued.

Before reconditioning the cylinder head, measure how high the valve stem end is above the machined valve spring seat in the cylinder head. After the valve and valve seat are ground, re-measure this dimension again to determine how much higher the valve stem is. Add to this amount, how much material was removed from the cylinder head and/or cylinder block deck surface. Example Before grinding – after grinding = .045 in. (1.143 mm) + .020 in. (0.508 mm) removed from cylinder head re-surfacing = .065 in. (1.651 mm).

If the total is .060 in. (1.52 mm) or more than the original measurement, adjustable rocker arm studs can be used. A Rocker Arm Stud Kit is available from Mercury Parts. By using the rocker arms and ball units from the original engine along with this kit, the engine can be converted from a non-adjustable to an adjustable valve lash engine like the older Mark IV engines. There are 8 studs and 8 nuts in each kit.

The valve lash is 1 turn down from ‘0’ lash. Follow Mark IV engine ‘Valve Adjustment’ procedure as outlined in Number 15 service manual.

P/N 16-803785A 1 Rocker Arm Stud Kit.

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