

OEM No. 2004-03

Outboard No. 2004-03

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250XS OptiMax – Exhaust Adaptor Plate Information

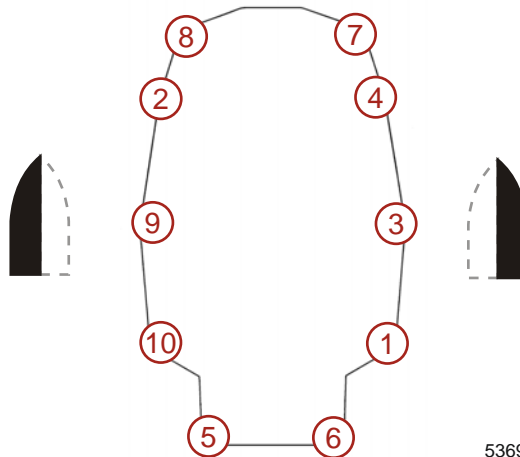
Situation

The 250XS OptiMax has a new exhaust adaptor plate, which provides mounting locations for rear-mounted steering rams or tie bars. This plate requires a new powerhead-to-mid section torque procedure.

250XS Powerhead Studs Torque Sequence

Torque the powerhead nuts in three progressive steps according to the following procedure:

1. Install the 10 flat washers and 10 locknuts that secure the powerhead to the exhaust extension plate/driveshaft housing by hand.
2. Sequentially torque all 10 locknuts in two progressive steps:



5369

Description		Nm	lb. In.	lb. ft.
Powerhead to Mid Section Locknuts (all nuts)	First	Snug tight in sequence.		
	Second	34		25

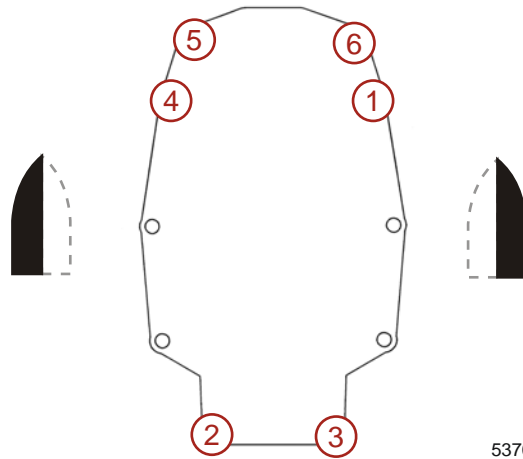
3. For the final torque step, sequentially torque the following six locknuts:

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⚠ CAUTION

Avoid engine damage. Four locknuts are not torqued in the final step, resulting in a different torque sequence. Tightening these four nuts beyond 34 Nm (25 lb. ft.) may cause cylinder distortion and premature engine failure.



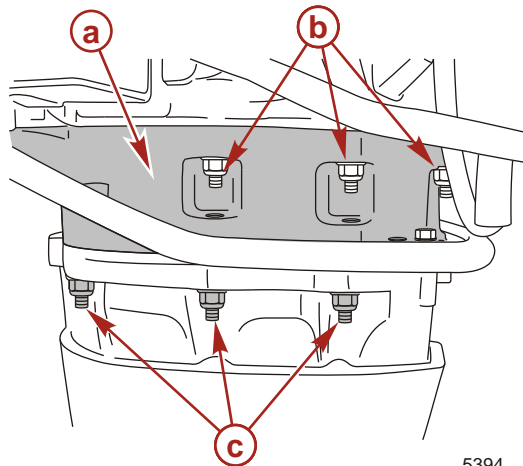
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Description		Nm	lb. In.	lb. ft.
Powerhead to Mid Section Locknuts (1-6)	Final	54		40

Installing Rear-Mounted Steering Rams or Tie Bars

⚠ CAUTION

Avoid possible engine damage. Do not attach steering brackets to the powerhead studs. Attaching rear-mounted steering rams or tie bars to the powerhead studs may cause cylinder distortion and premature engine failure.



5394

- a** - Exhaust adaptor plate
- b** - Powerhead studs - 3 per side
- c** - Steering bracket mounting locations (driveshaft housing mounting studs) - 3 per side

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Mercury Marine does not supply rear-mounted steering plates, rams, or tie bars. To install the proper components, contact the vendor or manufacturer supplying the components and install per manufacturer's instructions. Contact the Mercury Racing Service Department if any conflict exists between the manufacturer's instructions and those included with 250XS service literature.

Observe these guidelines when installing after-market rear-mounted steering plates, rams, or tie bars:

- Modify the bottom cowls as needed.
- Install the steering brackets to the driveshaft housing mounting studs (lower studs).
- Do not install steering brackets to the powerhead studs (upper studs).
- Do not install rear-mounted steering plates, rams, or tie bars on 250XS models S/N 0T997973 and below, unless updating to the new style adaptor plate.
- If updating to the new style adaptor plate on 250XS models S/N 0T997973 and below, follow the torque procedures described in this bulletin.

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