

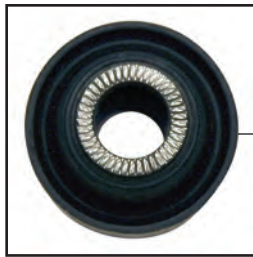
Instructions for Flywheel Housing Motor Mount Kit No. 21045

Alpha & Bravo

3.0L (181 cid), 4.3L (262 cid), 5.0L (305 cid), 5.7L (350 cid), 6.2L (377 cid)
7.4L (454 cid), 8.1L (496 cid), 8.2L (502 cid) & Bravo Sterndrive Diesel

All Serial Numbers & Years

New Style!
Knurled Bottom Edge



GLM No. 21045 OEM No. 865330A02				
Ref.	Description	GLM	OEM	Qty.
a	Rubber Mount Assembly	21043*	8653300	2
b	Mount Spacer	21050	23-99322	2
c	Fiber Washer	30020	12-32834	2
d	Stainless Steel Washer	19326	12-54012	2

For Complete Rear Motor
Mount Service Kit
See GLM No. 21813

* Mounts Not Sold Separately. Must order Kit No. 21045.

IMPORTANT!

When applicable, these new design flywheel housing mounts may supercede pervious mounts with minor changes to the mounting hardware on the inner transom plate. When using these new design mounts, proper engine and sterndrive unit alignment requires the **REMOVAL** of the double-wound lockwashers on the inner transom plate before the engine is installed.



Identification

⚠ CAUTION

Avoid product damage caused by improper engine alignment. Improper engine alignment can be caused by mismatched flywheel housing mounts and inner transom plate mounting hardware. Ensure that the flywheel housing mounts and the inner transom plate mounting hardware, port and starboard, are correct parts and match before installing engine.

Early style flywheel housing mounts have a smooth bottom edge (see Fig. A).

New design mounts have a knurled bottom edge (see Fig. B).

IMPORTANT:

If replacing an early style mount with a new design mount it will be necessary to replace both port and starboard flywheel housing mounts to avoid engine misalignment.

Removal

1. Refer to the appropriate Mercury, MerCruiser or Cummins MerCruiser Diesel Service Manual and remove the flywheel housing.
2. Remove the flywheel housing (rear engine) mounts and mount spacers using a suitable mandrel and press (see Fig. C).

Installation

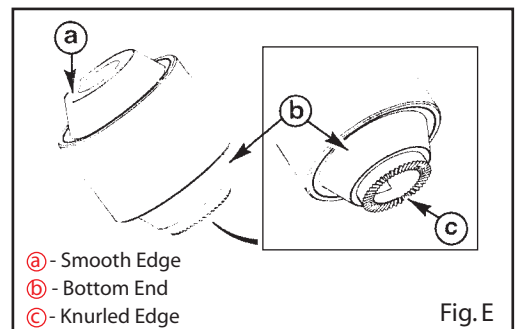
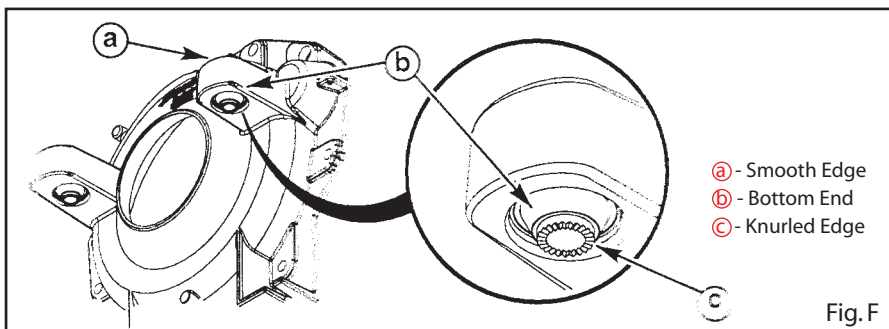
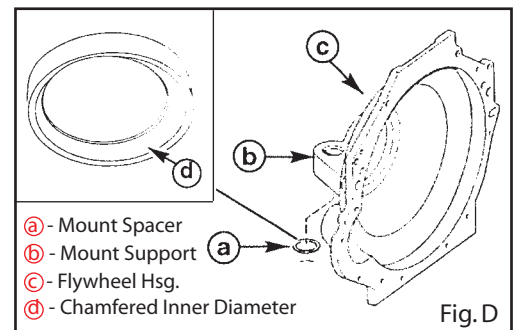
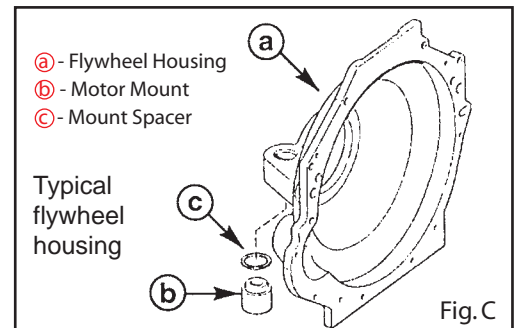
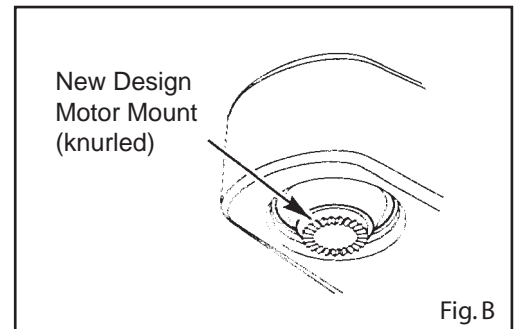
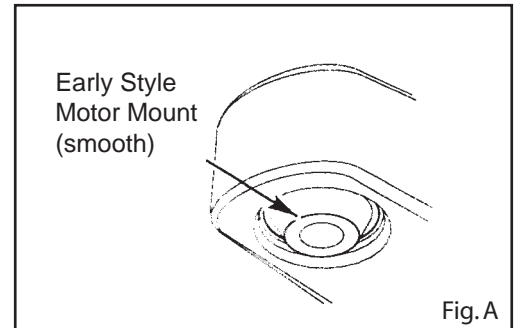
1. Install the mount spacers into the transom mounting supports of the flywheel housing. Ensure that the chamfered inner diameter faces the mount when installed (see Fig. D).
2. Press the mount into the flywheel housing with the knurled edge toward the bottom of the flywheel housing (see Fig. E & F).

IMPORTANT:

The bottom of the mount has the knurled edge.

CONTINUED ON NEXT PAGE...

Typical flywheel housing with New Design Mount installed, all similar.



Installation continued...

NOTE:

The double-wound lockwasher, if previously equipped, is no longer required because of the knurled bottom edge on these new design mounts.



On All Inner Transom Plates:

3. Remove and discard, if equipped, the double-wound lockwashers on the inner transom plate mounts (see Fig. G).
4. Remove & discard the old fiber washers (see Fig. G).

IMPORTANT:

Use fiber washers on the inner transom plate with all mounts.

5. Install the new fiber washers included with the mounts. (see Fig. H)

IMPORTANT:

The engine and sterndrive unit must be aligned after installation of the new design flywheel housing mounts and hardware.

6. After completing the mount installation, install and align the engine. Refer to the appropriate Mercury, MerCruiser or Cummins MerCruiser Diesel Service Manual.

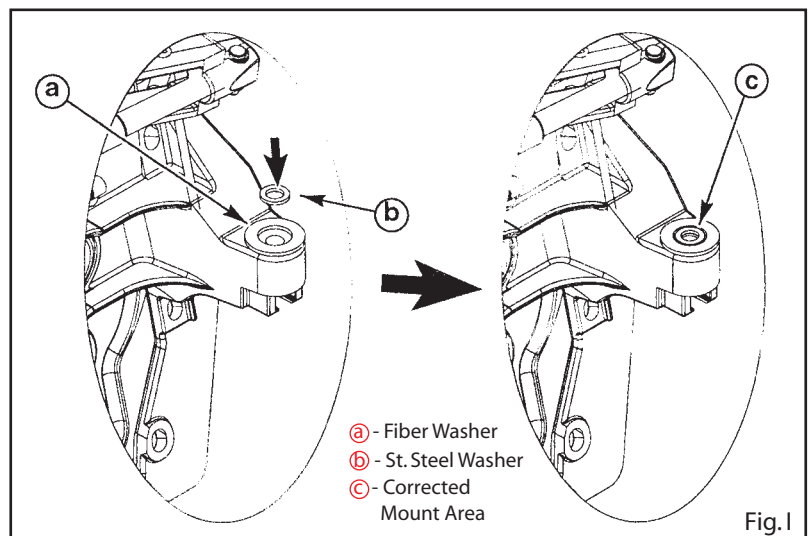
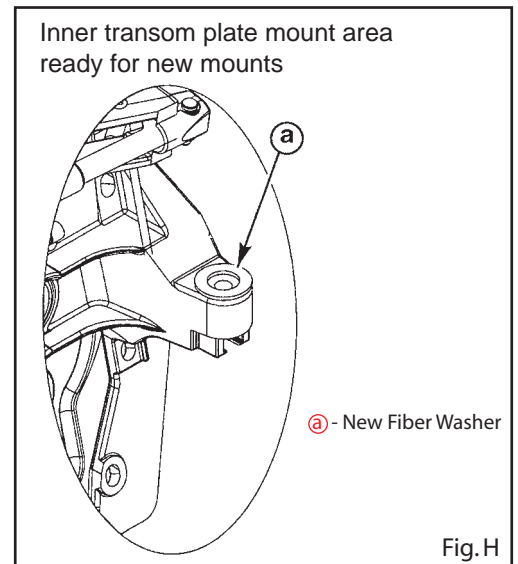
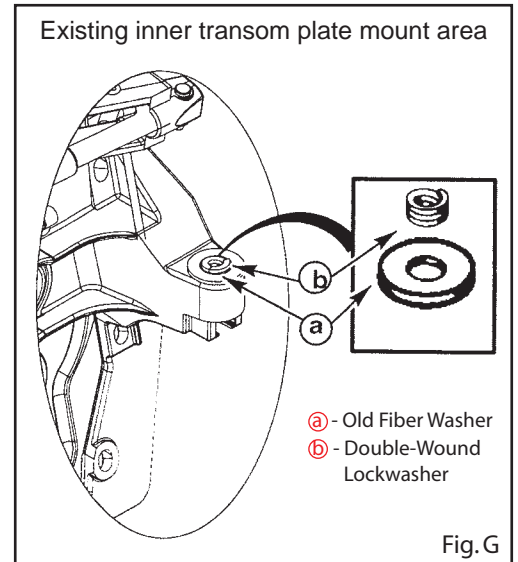
On installations where the front engine mounts cannot be lowered enough to allow for proper engine alignment.

7. Attach a suitable sling, and lifting arm if required, to the lifting eyes on the engine and adjust so that the engine will be level when suspended.
8. Remove the rear engine mounting bolts.
9. Using an overhead hoist, lift the engine slightly.

NOTE:

Positioning the stainless steel washers between the new engine mounts and the transom mounting supports will raise the engine slightly resulting in additional front mount adjustment.

10. Install the stainless steel washer inside the inner diameter of each fiber washer (see Fig. I).
11. After completing the stainless steel washer installation, install and align the engine. Refer to the appropriate Mercury, MerCruiser or Cummins MerCruiser Diesel Service Manual.



Typical inner transom plate mount with stainless steel washer