

MODEL	S3000
Cyl. Head Bolts	30 lb-ft (41 Nm) + 90° (1/4 turn) Light Oil
Exhaust Divider Plate	20 lb-ft (27 Nm)
Lower End Cap	100 lb-in. (11 Nm) 271 Loctite
Upper End Cap	20 lb-ft (27 Nm)
Air Inlet Housing	<i>1/4 in. bolts</i> - 120 lb-in. (14 Nm) 271 Loctite <i>5/16 in. bolts</i> - 240 lb-in. (27 Nm) 271 Loctite
Reed Adaptor Plate to Crankcase Hsg.	120 lb-in. (14 Nm) 271 Loctite
Reed Block to Reed Block Hsg.	120 lb-in. (14 Nm) 271 Loctite
Connecting Rods	40 lb-ft (54 Nm) (SPS bolts) 271 Loctite
Crankcase Cover to Block	<i>Top 2</i> - 45 lb-ft (61 Nm) Light Oil <i>Inner Middle 4</i> - 40 lb-ft (54 Nm) Light Oil <i>Inner Bottom 2</i> - 35 lb-ft (47 Nm) Light Oil <i>Outer 10</i> - 25 lb-ft (34 Nm) 271 Loctite
Injector Hold Down Nuts	60 lb-in. (7 Nm)
Stator Screws	40 lb-in. (5 Nm) 271 Loctite
Ign. Coil Screws	Tighten Securely 271 Loctite
Flywheel Nut	150 lb-ft (203 Nm)
Spark Plugs	20 lb-ft (27 Nm)
Exhaust Mega-phone	30 lb-ft (41 Nm) 271 Loctite
Powerhead to Drive Shaft Housing	35 lb-ft (47 Nm)
Gear Case to DSH	Tighten Securely

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Torque Specs On A 225 Mercury

Lei Shi



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