

Mercury 44XS & Older 4 Cylinder Torque Chart:

Tighten in stages, 1/3, 2/3, then just below spec, then at spec.

Connecting Rod Screw (New Screws, do not reuse)	18 Ft. Lbs.	Red Loctite 271
Older motors, bolt & nut (new nut recommended)	18 Ft. Lbs.	Red Loctite 271
Center Main Bearing Retainer Screws	10 Ft. Lbs.	Red Loctite 271
Replace screws with Gr. 8 Allen & AN washer, Loctite Quickmetal Race to Retainer		
Reedcage Screws	Max. Hand Tighten w #3 Phillips	Red Loctite 271
Older motors, brass reedcages	Max. Hand Tighten w #2 Phillips	Red Loctite 271
Reed Mounting Screws	Max. Hand Tighten	Green Loctite 290
Older motors, brass reedcages	30 Inch Lbs.	Green Loctite 290
Crankcase Bolts:	18 Ft. Lbs.	No Loctite
Seal cover to block with extremely light coat of Loctite 518, ooze indicates too much		
Bearing Endcap Bolts	16 Ft. Lbs.	Blue Loctite 242
Center Main Bearing Bolt	18 Ft. Lbs.	Red Loctite 271
Reedcage Bolts	12 Ft. Lbs.	Red Loctite 271
Exhaust Cover Bolts, 5/16"	16 Ft. Lbs.	Blue Loctite 242
Older motors with 1/4" bolts	10 Ft. Lbs.	Blue Loctite 242
Port Cover Screws	10 Ft. Lbs.	Blue Loctite 242
Powerhead Nuts	16 Ft. Lbs.	Blue Loctite 242
Switchbox Mounting Plate Bolts	10 Ft. Lbs.	Red Loctite 271
Stator Screws*	60 Inch Lbs.	Red Loctite 271
Carb Nuts (New Gasket, do not reuse)	36 Inch Lbs.	Green Loctite 290
Coil Cover Screws	24 Inch Lbs.	Green Loctite 290
Switchbox Screws	30 Inch Lbs.	Green Loctite 290
Fuel Pump Screws, #12 screw	36 Inch Lbs.	Green Loctite 290
Older motors with #10 screws	24 Inch Lbs.	Green Loctite 290
Flywheel Nut**	75 Ft. Lbs.	Red Loctite 271
Throttle Linkage Bolts	16 Ft. Lbs.	Red Loctite 271
Mercury "D" gearcase cone nut	125 Ft. Lbs.	Anti Sieze

*Bed Stator to Flange with Loctite 518

** Spray Flywheel and Crank Taper with LPS 3, Mask Crank Threads