

# MERCURY

Mercury Marine  
Div. Brunswick Corp.  
Fond du Lac, Wisconsin 54935

## TWO-CYLINDER MODELS

| Year Produced | Model |
|---------------|-------|
| 1970-1971     | 400   |
| 1972-1978     | 402   |
| 1978-1983     | 40    |
| 1984-1985     | 35    |

## CONDENSED SERVICE DATA

### TUNE-UP

|                               |                                   |
|-------------------------------|-----------------------------------|
| Hp/rpm:                       |                                   |
| Model 35                      | 35/5400-6000                      |
| Models 40, 400 & 402          | 40/5000-5500                      |
| Bore                          | 2.870 in.<br>(72.9 mm)            |
| Stroke                        | 2.562 in.<br>(65.1 mm)            |
| Displacement                  | 33.3 cu. in.<br>(546 cc)          |
| Compression At Cranking Speed | *                                 |
| Spark Plug:                   |                                   |
| AC                            | V40FPX†                           |
| Champion                      | L76V                              |
| Electrode Gap                 | Surface Gap                       |
| Ignition:                     |                                   |
| Type                          | Solid State                       |
| Trigger Gap (Model 400)       | 0.050-0.060 in.<br>(1.27-1.52 mm) |
| Carburetor Pickup Timing      | See Text                          |
| Maximum Advance               | See Text                          |
| Fuel-Oil Ratio                | See Text                          |

\*Not more than 15 psi (103.5 kPa) variations between cylinders.

†AC type M40FPX spark plugs gapped at 0.030 inch (0.76 mm) are recommended for use on 1971 400 models if rough low speed operation is noted.

### SIZES - CLEARANCES

|                        |   |
|------------------------|---|
| Piston Rings:          |   |
| End Gap                | * |
| Side Clearance         | * |
| Piston Skirt Clearance | * |

### SIZES - CLEARANCES CONT.

|                           |                         |
|---------------------------|-------------------------|
| Crankshaft Bearings:      |                         |
| Top Main Bearing          | Roller or Ball Bearing  |
| Center Main Bearing       | Pushing With Reed Valve |
| Lower Main Bearing        | Ball Bearing            |
| Crankpin                  | Caged Rollers           |
| Piston Pin Bearing In Rod | Loose Rollers           |
| Number of Rollers Per Rod | 29                      |

\*Publication not authorized by manufacturer.

### TIGHTENING TORQUES

|                      |                                  |
|----------------------|----------------------------------|
| Connecting Rod       | 180 in.-lbs.<br>(20.3 N·m)       |
| Crankcase Screws     | 200 in.-lbs.<br>(22.6 N·m)       |
| Cylinder Cover:      |                                  |
| 35 HP*               | 100 in.-lbs.<br>(11.3 N·m)       |
| 40 HP*               | 70 in.-lbs.<br>(7.9 N·m)         |
| Exhaust Cover        | 200 in.-lbs.<br>(22.6 N·m)       |
| Flywheel Nut         | 70-75 ft.-lbs.<br>(95.2-102 N·m) |
| Reed Screws          | 25 in.-lbs.<br>(2.8 N·m)         |
| Spark Plugs          | 240 in.-lbs.<br>(27.1 N·m)       |
| Transfer Port Cover: |                                  |
| 35 HP                | 50 in.-lbs.<br>(5.6 N·m)         |
| 40 HP                | 60 in.-lbs.<br>(6.8 N·m)         |

# Mercury 40 2 Stroke Manual

**Mark Steyvers**



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## **Table of Contents Mercury 40 2 Stroke Manual**

1. Understanding the eBook Mercury 40 2 Stroke Manual
  - The Rise of Digital Reading Mercury 40 2 Stroke Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Mercury 40 2 Stroke Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Mercury 40 2 Stroke Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Mercury 40 2 Stroke Manual
  - Personalized Recommendations
  - Mercury 40 2 Stroke Manual User Reviews and Ratings
  - Mercury 40 2 Stroke Manual and Bestseller Lists
5. Accessing Mercury 40 2 Stroke Manual Free and Paid eBooks
  - Mercury 40 2 Stroke Manual Public Domain eBooks
  - Mercury 40 2 Stroke Manual eBook Subscription Services
  - Mercury 40 2 Stroke Manual Budget-Friendly Options

6. Navigating Mercury 40 2 Stroke Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Mercury 40 2 Stroke Manual Compatibility with Devices
  - Mercury 40 2 Stroke Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Mercury 40 2 Stroke Manual
  - Highlighting and Note-Taking Mercury 40 2 Stroke Manual
  - Interactive Elements Mercury 40 2 Stroke Manual
8. Staying Engaged with Mercury 40 2 Stroke Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Mercury 40 2 Stroke Manual
9. Balancing eBooks and Physical Books Mercury 40 2 Stroke Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Mercury 40 2 Stroke Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Mercury 40 2 Stroke Manual
  - Setting Reading Goals Mercury 40 2 Stroke Manual
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Mercury 40 2 Stroke Manual
  - Fact-Checking eBook Content of Mercury 40 2 Stroke Manual
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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