



EVINRUDE[®]
Johnson[®]

Exhaust Filler Block Kit Part Number 392001

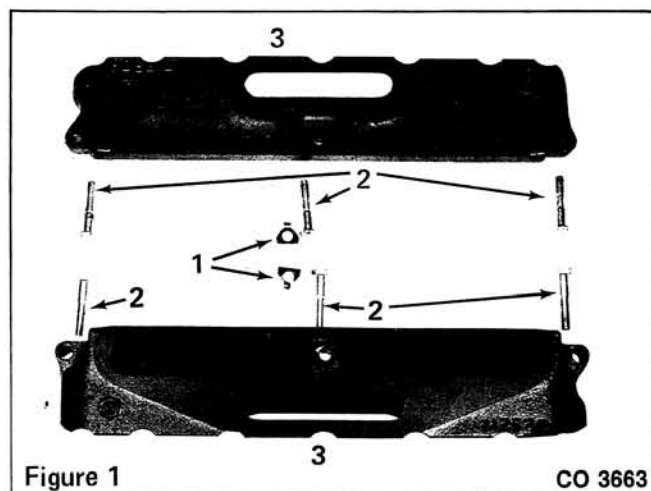
Installation Instructions

Preface

This kit enables replacement of exhaust filler blocks on 1978 and later 235 model Johnson[®] and Evinrude[®] outboard motors.

Contents of Kit

Ref. No.	Part No.	Description	Qty.
1	309577	Lock Plates	2
2	324565	Screws (Brass)	6
3	323212	Filler Blocks	2



1. Use correct year Service Manual instructions to remove and disassemble powerhead.

2. Bend lock tabs away from screw heads and remove screws holding exhaust filler blocks to cylinder and crankcase assembly. Discard screws and lock plates.

3. Remove filler blocks from cylinder and crankcase assembly.

4. Clean old sealer, gasket material and carbon from gasket surfaces and exhaust passages. Gel Seal and Gasket Remover P/N 390928 will effectively clean these areas. Read label on can for cautions and instruction for use. See Figure 2.

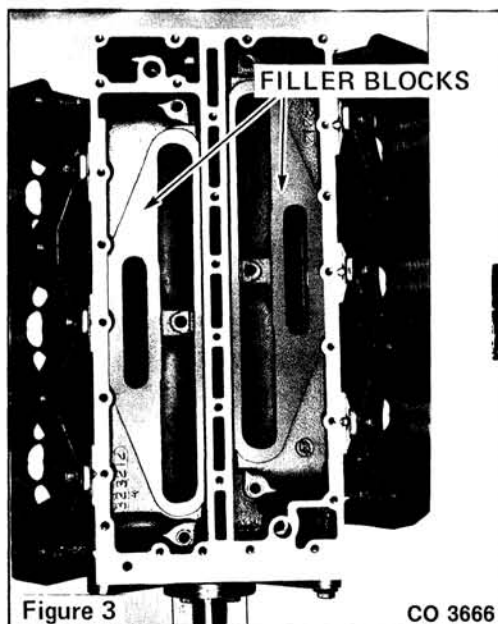


5. Position new filler blocks (Item 3) in cylinder and crankcase assembly. See Figure 3.

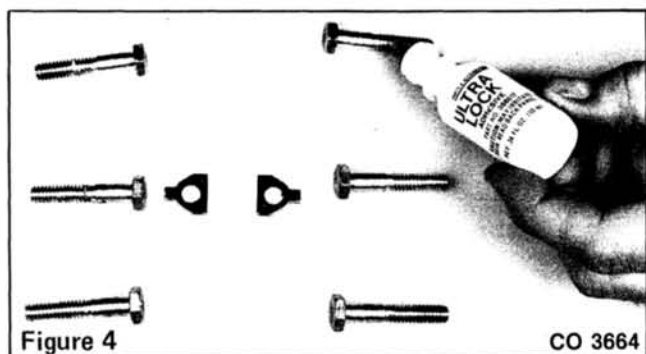
Product Reference & Illustration

When reference is made to a brand name, product or specific tool, an equivalent product may be used in place of the referred to product unless specifically stated otherwise. Equivalent products which are used must meet all current U.S. Coast Guard Safety Regulations and ABYC-BIA Standards to avoid hazards.

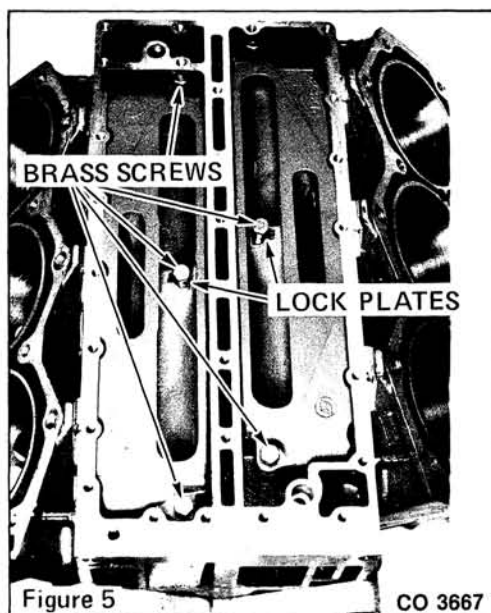
All photographs, illustrations, and specifications used may not necessarily depict actual models or equipment, but are intended for reference only based on the latest product information available at the time of publication.



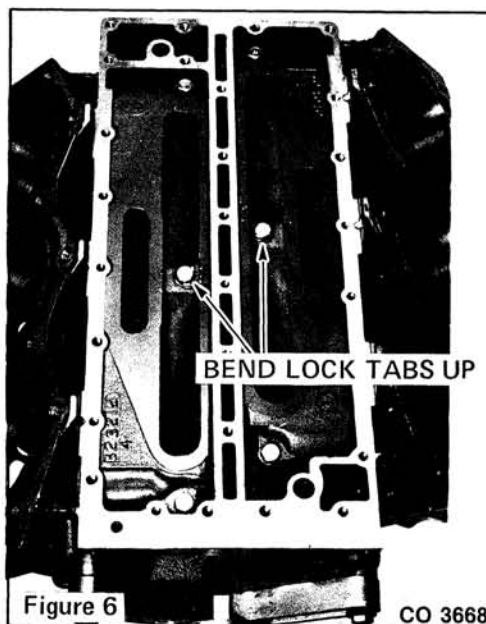
6. Install new lock plates (Item 1) on new center screws. Apply Ultra Lock™ to threads of new screws. See Figure 4.



7. Install six screws (Item 2) in filler blocks. Tighten screws to 30-54 in. lbs. (3.4 - 6.1 N.M.). See Figure 5.



8. Bend lock tabs up against screw heads. See Figure 6.

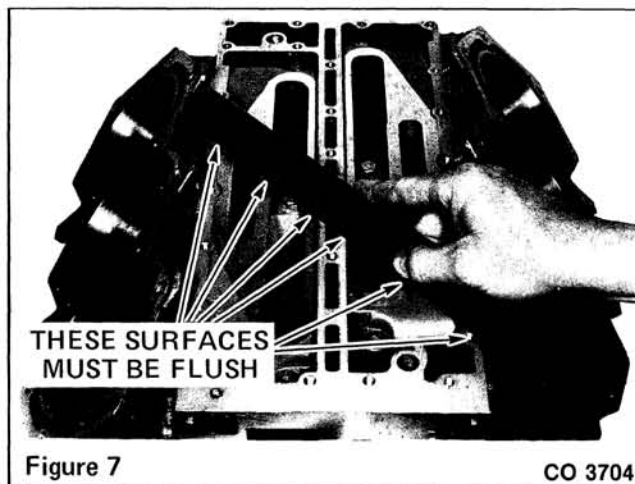


9. Exact machining of filler blocks is required so that filler blocks are flush with machined surfaces on cylinder and crankcase assembly. See Figure 7.

Note



Filler block and cylinder surfaces must be flush to insure proper sealing of exhaust and water passages.



10. Reassemble powerhead using Service Manual instructions.