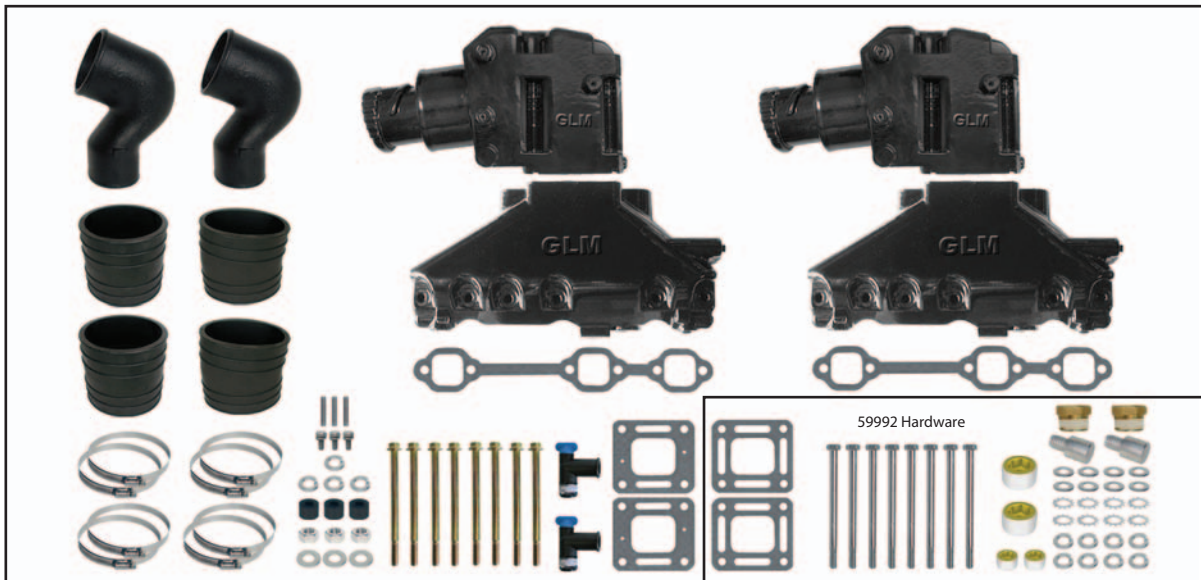


Congratulations on your purchase of **GLM's V6 Conversion Kit for MERC 4.3L (GM 262 CID)**

**1996 to 2000 with Raw Water Cooling
From the Single-Piece Manifolds to the Center Rise Manifolds**



GLM No. 58992 - Cast Iron V6 Conversion Kit			
Qty.	Description	GLM	OEM
8	Hose Clamp	01100	54-815504372
3	Nut	21175	11-64015
4	Lockwasher	21492	N/A
3	Washer	21679	12-35462
3	Spacer-Nylon	22198	23-806981
3	Stud	22336	10-24323
3	Screw	22369	N/A
2	Elbow Tube	50750	14478T01
1	Exhaust Manifold Kit - Cast Iron	58222	N/A
2	Exhaust Bellow 4" Upper	89120	32-44348T
2	Exhaust Bellow 4" Lower	89130	32-14358001

GLM No. 59992 - Aluminum V6 Conversion Kit			
Qty.	Description	GLM	OEM
8	Hose Clamp	01100	54-815504372
3	Nut	21175	11-64015
4	Lockwasher	21492	N/A
3	Washer	21679	12-35462
3	Spacer-Nylon	22198	23-806981
3	Stud	22336	10-24323
3	Screw	22369	N/A
2	Elbow Tube	50750	14478T01
1	Exhaust Manifold Kit - Aluminum	59225	N/A
2	Exhaust Bellow 4" Upper	89120	32-44348T
2	Exhaust Bellow 4" Lower	89130	32-14358001

**Does NOT contain original exhaust tube (OEM No. 32-807458T) to be used with original Y-pipe.
You may re-use original exhaust tube with this kit.**

Disassembly of Single-Piece Manifold

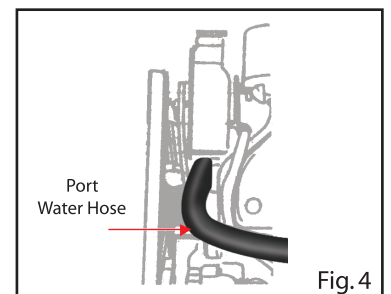
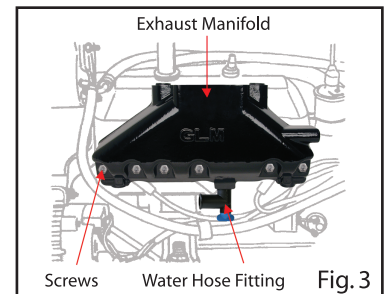
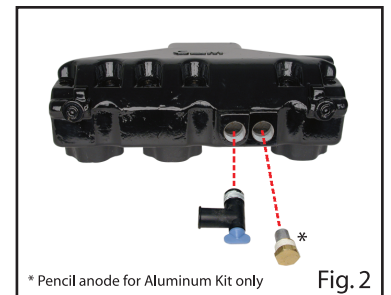
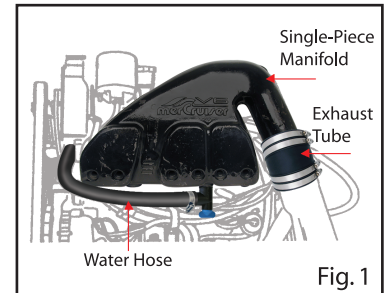
Note: Before beginning any procedures make sure the battery cables are removed from the battery!

IMPORTANT:

The installation of the two-piece exhaust manifold will result in the loss of 1/2 in. (12.7mm) of exhaust elbow height. Before removing the original exhaust manifold, it is strongly recommended that the exhaust elbow height above the waterline be checked. Refer to the appropriate Mercruiser Service Manual. If the current exhaust elbow height minus 1/2 in. (12.7mm) is not within the minimum exhaust elbow height spec. limits it will be necessary to install a exhaust elbow spacer kit and intermediate exhaust elbow.

Disassembly of the Single-Piece Manifold

1. Remove and retain the components mounted on the exhaust manifolds.
2. Disconnect the water hose from the fitting on the bottom of the manifold (see Fig. 1).
3. Remove and discard the single-piece manifolds.



Exhaust Manifold & Elbow Assembly

Note: Make sure all gasket surfaces are clean, free of grease and oil!

1. Install the new water hose fittings in exhaust manifolds. Tighten securely and position opening towards front of engine, facing slightly outboard (approx. 10-15 degrees).
* For the Aluminum Manifolds only, make sure to install the Pencil Anode Kit (see Fig. 2).
2. Install the new exhaust manifolds with the new gaskets. Torque the exhaust manifold screws to 33 ft.lbs. (45Nm) for both cast iron and aluminum manifolds (see Fig. 3).
3. Install the starboard water hose and tighten hose clamp securely.
4. Route the port water hose beneath the power steering pump and install on hose fitting. Tighten hose clamp securely (see Fig. 4)
5. Ensure the water shutters are in good condition and installed in the lower exhaust Y-pipe.
6. Install plugs in new exhaust elbows tighten securely.
7. Apply sealant to the threads of the exhaust elbow to exhaust manifold screws.
8. Install the exhaust elbows to the manifolds using the new gaskets and screws (see Fig. 5). Torque the screws to 33 ft.lbs. (45Nm) for cast iron and 25 ft.lbs. (34Nm) for aluminum elbows.
9. Connect the intermediate exhaust elbows to the exhaust elbows with the exhaust tubes and clamps included in the kit. Tighten clamps securely.

58992 - Cast Iron Torque Specs	59992 - Aluminum Torque Specs
The Riser to Manifold bolts or nuts MUST BE TORQUED to the following specification: 33 ft. lbs. / 45 Nm	The Riser to Manifold bolts or nuts MUST BE TORQUED to the following specification: 20-25 ft. lbs. / 27-34 Nm

Exhaust Alignment & Installation

Note: Make sure all gasket surfaces are clean, free of grease and oil!

IMPORTANT:

Due to the variation in transom thickness and transom angle, it will be necessary to measure the alignment of the intermediate exhaust elbow to the exhaust Y-pipe (see Fig. 6). If there is a forward overlap or rear overlap of the exhaust Y-pipe that exceeds 3/8 in. (9.52mm), it will be necessary to make adjustments using the following procedures to achieve proper alignment.

* Do not install lower exhaust tube at this time.

If the intermediate elbow overlaps the exhaust Y-pipe to the rear by more than 3/8 in. (9.52mm):

1. Remove the intermediate exhaust elbow from the upper exhaust tube.
2. Cut approximately 1/2 in. (12.7mm) off of the upper portion of the intermediate exhaust elbow (see Fig. 7).
3. Install the modified intermediate exhaust elbow into the upper exhaust tube.
4. Verify proper alignment of the intermediate exhaust elbow to the exhaust Y-pipe.
5. Remove the intermediate exhaust elbow.
6. Apply soapy water to the outer surface of the exhaust Y-pipe.
7. Slide the correct lower exhaust tube onto the exhaust Y-pipe (see Fig. 8) as low as possible.
8. Reinstall the modified intermediate exhaust elbow into the upper exhaust tube. Tighten hose clamps securely.

If the intermediate exhaust elbow has an overlap forward of the exhaust Y-pipe that exceeds 3/8 in. (9.52mm):

1. Loosen the upper exhaust tube hose clamps at the intermediate exhaust elbow.
2. Pull the intermediate exhaust elbow away from the exhaust elbow to eliminate the forward overlap and achieve proper alignment with the exhaust Y-pipe.
3. Verify proper alignment of the intermediate exhaust elbow to the exhaust Y-pipe.
4. Remove intermediate exhaust elbow.
5. Apply Soapy water to the outer surface of the exhaust Y-pipe.
6. Slide the correct lower exhaust tube onto the exhaust Y-pipe as low as possible.
7. Reinstall the intermediate exhaust elbow into the upper exhaust tube. Tighten hose clamps securely.
8. Pull the lower exhaust tubes up onto the lower portion of the intermediate exhaust elbows. Tighten hose clamps securely.
9. Reinstall the components previously removed from the exhaust manifolds.

