



18SP643 – Series 60[®] Marine Exhaust Manifold Service Kit P/N: E23537867

KIT DESCRIPTION

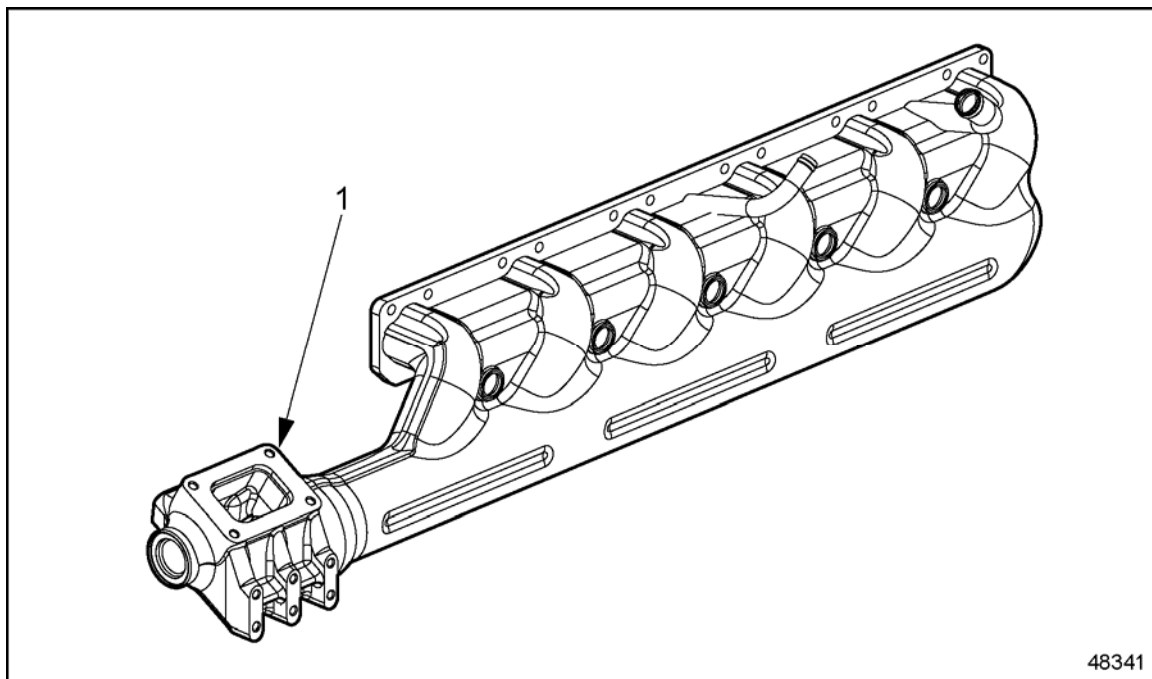
Service kit (P/N: E23537867) contains an improved design for the exhaust manifold and all related parts to address a possible coolant flow issue at the exhaust turbocharger flange of the former exhaust manifold. See Figure 1. The improved exhaust manifold design now incorporates a boss at the turbo flange for the attachment of a vent line that routes to the thermostat housing.

KIT CONTENTS

The new service kit contains the following parts listed in Table 1.

Level	Part Number	Quantity	Description
1	23537770	1	Marine Exhaust Manifold
1	23507438	4	Stud, M10 x 1.5
1	08924140	1	Cock, Drain ¼ NPTF
1	23525090	3	Gasket, Exhaust Manifold
1	11506101	4	Nut, M10 x 1.5
1	08929169	4	Washer
1	08929529	1	Gasket, Turbocharger
1	23537804	1	Hose, #4 X 38.00
1	02488022	1	Clip, Hose 0.562 DIA 3/8 Bolt
1	08924147	1	Fitting, Straight ¼ FLDTUB 1/8 NPTF
1	23537818	1	Fitting, T Male 7/16 FLDTUB ¼ NPTF
1	11504986	1	Bolt, M8 1.25 X 14.0
1	18SP643	1	Installation Instructions

**Table 1 S60 Marine Exhaust Manifold Service Kit Contents
(P/N: E23537867)**



1. Vent Boss

Figure 1 Improved S60 Marine Exhaust Manifold (P/N: 23537770)

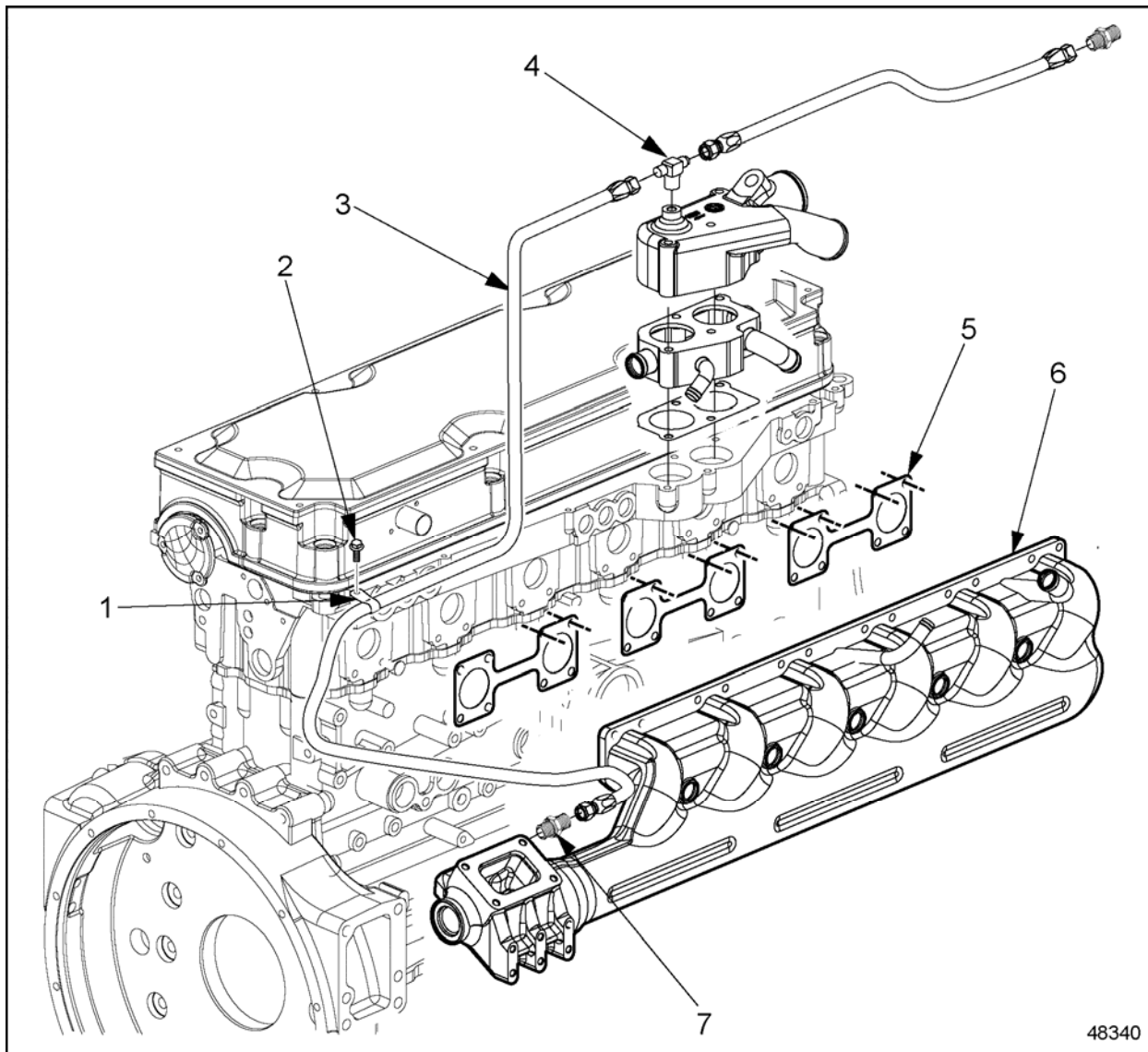
INSTALLATION PROCEDURE

Install the improved exhaust manifold as follows (see Figure 2):

1. Install the new exhaust manifold gaskets (P/N: 23525090) and the improved exhaust manifold (P/N: 23537770).
2. Install the straight fitting (P/N: 08924147) into the exhaust manifold turbocharger flange boss. Replace the elbow fitting in the top of the thermostat housing with the T-fitting (P/N: 23537818). Connect the vent hose (P/N: 23537804) to the two fittings. Route vent line using hose clip (P/N: 02488022) with bolt (P/N: 11504986) installed at the top right-rear corner of the engine head.
3. Install new M10 x 1.5 studs (P/N: 23507438) and turbocharger gasket (P/N: 08929529).
4. Use the new washers (P/N: 08929169) and M10 x 1.5 nuts (P/N: 11506101) to install the turbocharger.

NOTE:

To install the remaining components and to complete the installation of this service kit, refer to the *Series 60 Service Manual* (6SE483).



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| 1. Clip, Hose 0.562 DIA 3/8 Bolt (P/N: 02488022) | 5. Gasket, Exhaust Manifold (P/N: 23525090) |
| 2. Bolt, M8 1.25 x 14.0 (P/N: 11504986) | 6. Exhaust Manifold (P/N: 23537770) |
| 3. Hose, #4 x 38.00 (P/N: 23537804) | 7. Fitting, Straight (P/N: 08924147) |
| 4. Fitting, T Male (P/N: 23537818) | |

NOTE: Not all kit parts are shown in Figure 2.

Figure 2 S60 Marine Exhaust Manifold Service Kit (P/N: E23537867)



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