

INTERNAL ENGINE COMPONENTS

Lifters/Camshafts/Timing kits

 18-1400 HYDRAULIC ROLLER LIFTER Replaces: OMC & Volvo 3856127 Crusader 7231350 Mercruiser 17340 GM 4.3L/V-6 Late/5.0L/5.7L	 18-1401 HYDRAULIC LIFTER Replaces: Mercruiser 56153 OMC & Volvo 3853847 Ford 302/351 Ford 5.0L & 5.8L		
 18-1402 HYDRAULIC LIFTER Replaces: Crusader 7230500 OMC & Volvo 3854033 Mercruiser 72638 GM 2.5L/120 GM 3.0L, 4.3L, 5.0L & 5.7L	 18-1403 HYDRAULIC LIFTER Replaces: Crusader 7230500 OMC 5232700 Mercruiser 93722,93722T 7.4L/454/8.2L/502		
 18-1454 HI-PERFORMANCE TIMING KIT Replaces: Mercruiser 801871 4.3L/V-6 (Late)	 18-1450 HI-PERFORMANCE TIMING KIT Replaces: Crusader 30267, 30268, 30269 Volvo & OMC 3891518, 3891517, 3891519 Mercruiser 77531, 7.4L/454	 18-1455 HI-PERFORMANCE TIMING KIT Replaces: OMC 3909805, 3735402, 3735411 Mercruiser 17161A1 GM 5.0L/305/ 5.7L	
 18-1481 CAMSHAFT Replaces: Mercruiser 424-3864 3.0L/140 OMC & Volvo 3854262	 18-1486 CAMSHAFT Replaces: OMC 14095859 Mercruiser 431-9433 4.3L/V-6 (Early)	 18-1487 CAMSHAFT (ROLLER) Replaces: OMC & Volvo 3854328 Mercruiser 431-9691 4.3L/V-6 (Late)	 18-1484 CAMSHAFT Replaces: Mercruiser 431-5943 GM 5.7L/350 & 5.0L/305 (Early) OMC 340284

INTERNAL ENGINE COMPONENTS

Lifters/Camshafts/Timing Kits



MERCURISER LIFTER/CAMSHAFT/TIMING KIT APPLICATION

Model	Serial Number	Lifter	Camshaft	Timing Chain Kit	Model	Serial Number	Lifter	Camshaft	Timing Chain Kit
120	1666601 & Up	18-1402	—	N/A	280 GM	4176250 & Up	18-1402	—	18-1455
140	2508261 - 6229717	18-1402	18-1481	N/A	300 MR/TRS (GM)	6668677 & Up	18-1402	—	18-1455
140/3.0L	6229718 & Up	18-1402	18-1481	N/A	320 GM (EFI)	A543605 & Up	18-1402	—	18-1455
3.0L/3.0LX	C856559 & Up	18-1402	18-1481	N/A	320 GM (EFI)				
140 (6 cyl)	1538930 - 1725960	18-1402	N.L.A.	N/A	Bravo	B157603 & Up	18-1402	—	18-1455
150	166495 - 2048046	18-1402	N.L.A.	N/A	325 GM	2278747 & Up	18-1402	—	18-1450 ④
160	2048022 - 2770031	18-1402	—	N/A	330 GM	4623115 & Up	18-1402	—	18-1450 ④
165	2770032 & Up	18-1402	—	N/A	330 GM/W.B.W.	6083145 & Up	18-1402	—	18-1450 ④
175/4.3L (262 CID)	B527955 & Up	18-1400	18-1487	18-1454	340/7.4L GM (IB)	5889914 & Up	18-1402	—	18-1450 ④
4.3L Generation II	D714107 - F000877	—	—	18-1454	350 GM	3780450 & Up	18-1402	—	18-1450 ④
4.3L Generation II	F000878 & Up	—	—	18-1454	350 GM (Magnum)	A635178 - B525981	18-1402	18-1484	18-1455
185 (229 CID)	6330183 & Up	18-1402	—	N/A	350 GM (Magnum)	B525982 & Up	18-1400	—	18-1455
185 (262 CID)	A331455 & Up	18-1402	18-1486	N/A	350 (Magnum Tourney SKI)	D505450 & Up	18-1400	—	18-1455
190 GM	1564539 - 1730903	18-1402	—	18-1455	370 TRS GM	4179554 & Up	18-1402	—	18-1450 ④
200	2453769 - 2712072	18-1402	N.L.A.	N.L.A.	390 GM	2781129 - 2825059	18-1402	—	18-1450 ④
200 GM	6218462 & Up	18-1402	18-1484	18-1455	400 TRS GM	4179554 & Up	18-1403	—	18-1450 ④
200/5.0L	B525982 & Up	18-1402	—	18-1455	420 GM	A398941 & Up	18-1403	—	18-1450 ④
205 (262 CID)	A331455 & Up	18-1402	18-1486	—	425 GM	A398941 & Up	18-1403	—	18-1450 ④
205/4.3L-LX (262 CID)	B527955 & Up	18-1400	18-1487	18-1454	440 TRS GM	4179554 & Up	18-1402	—	18-1450 ④
4.3LX Generation II	D714370 - F01219	—	—	18-1454	454 GM (Magnum)	A631894 & Up	18-1402	—	18-1450 ④
4.3LX Generation II	F001220 & Up	—	—	18-1454	454 MAG.				
215 Ford	2781153 & Up	18-1401	—	—	Bravo (GM)	B840126 & Up	—	—	18-1450 ④
225 Ford	3385721 & Up	18-1401	—	—	454 MAG				
225 GM	1536920 & Up	18-1402	—	18-1455	Bravo (Gen V)	D805069 & Up	—	—	18-1450 ④
228 GM	4765100 & Up	18-1402	18-1484	18-1455	454 EFI	F115700 & Up	—	—	18-1450 ④
230 GM (IB)	5907058 & Up	18-1402	18-1484	18-1455	460 TRS GM	4179554 & Up	—	—	18-1450 ④
230/5.0L GM (IB)	B522506 & Up	18-1402	18-1484	18-1455	500	C577254 & Up	18-1403	—	18-1450 ④
230 GM	6218462 & Up	18-1402	18-1484	18-1455	502 MAG				
230/5.0L-LX (GM)	B525982 & Up	18-1402	—	18-1455	Bravo (GM)	C878221 & Up	—	—	18-1450 ④
233 Ford	4173000 - 4902304	18-1401	—	18-1457	502 MAG				
250 GM	2314301 - 2639854	18-1402	—	18-1455	Bravo (Gen V)	D824589 & Up	—	—	18-1450 ④
250 GM	4768000 - 4908849	18-1402	18-1484	18-1455	502 EFI	D840650 & Up	—	—	18-1450 ④
255 Ford	3258728 & Up	18-1401	—	—	575	A677429 & Up	—	—	—
255 GM	4175500 & Up	18-1402	18-1484	18-1455	888 Ford	3108723 & Up	18-1401	—	—
260 GM	4908850 - 6218461	18-1402	18-1484	18-1455	898/198 GM	4762210 & Up	18-1402	18-1484	18-1455
260/5.7L (GM)	B525982 & Up	18-1400	—	18-1455 ②	5.7 GM (SKI)	A338553 & Up	18-1402	18-1484	18-1455
260 GM (IB)	5907058 & Up	18-1402	18-1484	18-1455 ②	5.7L Bravo GM	B525982 & Up	18-1400	—	18-1455
260/5.7L GM (IB)	B522506 & Up	18-1402	18-1484	18-1455 ②	7.4L Bravo GM	B771113 & Up	18-1402	—	18-1450 ④
270 GM	2851074 - 3077735	18-1402	—	18-1455 ②	7.4L Bravo (Gen V)	D603118 & Up	—	—	18-1450 ④
② For Hi-Performance Timing Kit use 18-1452 ④ Hi-Performance ONLY N.L.A. No longer available N.A. Not applicable					7.4L W/ HURTH (IB)	C391564 & Up	18-1402	—	18-1450 ④
					7.4L (IB/LHR/GEN V)	D715494 & Up	—	—	18-1450 ④
					8.2L W/ HURTH (IB)	C878221 & Up	—	—	18-1450 ④
					8.2L (IB) (Gen V)	D857200 & Up	—	—	18-1450 ④

INBOARD

INTERNAL ENGINE COMPONENTS

Lifters/Camshafts/Timing Kits

Pistons/Piston Rings

LIFTER/CAMSHAFT/TIMING KIT APPLICATION							
Eng. Model	Lifter	Camshaft	Timing Chain Kit	Eng. Model	Lifter	Camshaft	Timing Chain Kit
OMC				VOLVO(Cont.)			
GM				GM			
2.5L/153 CID	18-1402	—	—	5.0L/305 CID	18-1402 ⑤	18-1484	18-1455 ②
3.0L/181 CID	18-1402	18-1481	—	5.7L/350 CID	18-1402 ⑤	18-1484	18-1455 ②
1-6/250 CID	18-1402	—	—	7.4L/454 CID	18-1403	—	—
4.3L/V-6	18-1402 ⑤	—	—	FORD			
5.0L/305 CID	18-1402 ⑤	18-1484	18-1455 ②	5.0L/302 CID	18-1401	—	—
5.7L/350 CID	18-1402 ⑤	18-1484	18-1455 ②	5.8L/351 CID	18-1401	—	—
7.4L/454 CID	18-1403	—	18-1450	CHRIS CRAFT/CRUSADER/PLEASURECRAFT			
FORD				GM			
5.0L/302 CID	18-1401	—	—	4.3L/V-6	18-1402 ⑤	—	—
5.8L/351 CID	18-1401	—	—	5.0L/305 CID	18-1402 ⑤	18-1484	18-1455 ②
VOLVO				5.7L/350 CID	18-1402 ⑤	18-1484	18-1455 ②
GM				7.4L/454 CID	18-1403	—	—
3.0L/181 CID	18-1402	18-1481	—	② For chain drive only			
4.3L/V-6	18-1402 ⑤	18-1486 ⑥	—	⑤ For roller camshafts use 18-1400			
				⑥ For roller camshafts use 18-1487			

ALL PISTONS
ARE SUPPLIED COMPLETE WITH PISTON RINGS, WRIST PIN AND CIRCLIPS.



RINGS				PISTONS			
STD	REPLACES MERCURUISER	OMC / VOLVO	CRUSADER	STD	REPLACES MERCURUISER	OMC / VOLVO	CRUSADER
18-3928	39-74381A1	—	—	18-4109	778-9441A3 759-80661A7	—	—
18-3937	39-17464	14089025	12370	18-4169	734-4858	—	—
18-3937	—	328506	—	18-4168	735-9430	—	—
18-3937	—	3853960	—	18-4171	737-6523	—	—
18-3937	—	914555	—	18-4173	735-6370	14077948	7080330 ①
18-3937	—	3853268	—	18-4173	735-9686	3911020	—
18-3940	39-67127	328536	30184	18-4173	735-808674 735-850097	—	—
18-3942	39-67132	—	—	18-4181	735-6538	364702	—
18-3944	39-75609	370409	33302	18-4168	735-9430	—	—
.020				18-4179	735-9716,T1	—	—
18-3929	—	—	—	18-4179	—	—	33706 ①
18-3939	39-66217	3854252	—	18-4176	749-4058	—	—
18-3939	—	914556	—	18-4171	737-6523	—	30246
18-3950	—	N/A	—	18-4162	734-4858	—	—
.030				.020			
18-3930	39-75423	—	—	18-4183	—	—	—
18-3938	39-17465	14089026	—	18-4160	733-3818	3853477	—
18-3938	—	328516	—	18-4184	—	—	—
18-3938	—	914557	—	18-4118	—	—	—
18-3938	—	—	12372	18-4188	—	N/A	—
18-3941	39-67128	328541	30185	18-4187	—	N/A	—
18-4180	736-2343	—	—	18-4185	—	—	—
18-4161	733-3819 733-803850T	3853340	—	18-4186	—	—	—
18-4169	734-4858	—	—	18-4177	749-4060	—	—
				18-4189	—	—	—
				.030			
				18-4166	733-2279	—	—
				18-4191	—	—	—
				18-4170	734-4860	—	—
				18-4134	778-9441A5 759-80661A8	—	—
				18-4164	735-6371	14077949	7080350 ①
				18-4164	735-9687 735-85009	3911023	—
				18-4182	735-6617	364704	—
				18-4164	435-6371	—	—
				18-4164	735-9687	—	—
				18-4178	735-9715	—	33708 ①
				18-4193	—	—	—
				18-4172	737-6615	—	30249
				18-4163	737-5537	—	—

① Piston & Pin only

INBOARD

INTERNAL ENGINE COMPONENTS

Pistons/Piston Rings



INT. ENG.

PISTON/RING APPLICATION								
MERCUISER		PISTONS			RINGS			Qty. Per Eng.
Model	Serial Number	Std.	.020	.030	Std.	.020	.030	
120/2.5L	1666601 & Up	18-4180	18-4183	18-4166	18-3942	-	-	4
140	2508261-3332137	18-4161	18-4160	18-4191	18-3937	18-3939	18-3938	4
140	3332138 - 5157668	18-4161	18-4160	18-4191	18-3937	18-3939	18-3938	4
140	5157669 - 6229717	18-4161	18-4160	18-4191	18-3937	18-3939	18-3938	4
140/3.0L	6229718 - C856558	18-4161	18-4160	18-4191	18-3937	18-3939	18-3938	4
3.0L/3.0LX	C856559 & Up	-	-	-	18-3937	18-3939	18-3938	6
150	1666495 - 2048046	18-4180	18-4183	18-4166	18-3942	-	-	6
160 (6cyl.)	2048022 - 2770031	N.L.A.	-	N.L.A.	18-3942	-	-	6
165 (6cyl.)	2770032 - & Up	-	-	-	18-3942	-	-	6
165/3.7L	6916779 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	4
170 (4cyl.)	6916779 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	6
175/4.3L (262 CID)	B527955 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
180/3.7LX (4cyl.)	6916779 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	4
4.3L Generation II	D714107 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
185 (229 CID)	6330183 - & Up	-	-	-	18-3944	-	-	6
185 (262 CID)	A331455 - & Up	18-4168	-	18-4164	18-3937	18-3939	18-3938	6
190 GM	1564539 - 1730903	18-4180	18-4183	18-4166	18-3942	-	-	6
190 (4cyl.)	6916779 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	4
200 GM	6218462 - & Up	-	-	-	18-3944	-	-	8
200/5.0L (GM)	B525982 - & Up	18-4179	-	18-4178	18-3944	-	-	8
205 (262 CID)	A331455 - & Up	18-4168	-	18-4164	18-3937	18-3939	18-3938	6
205/4.3LX (262 CID)	B527955 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
4.3LX Generation II	D714370 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
215 Ford	2781153 - & Up	-	-	-	18-3937	18-3939	18-3938	8
225 Ford	3385721 - & Up	-	-	-	18-3937	18-3939	18-3938	8
225 GM	1536920 - & Up	-	-	N.L.A.	18-3937	18-3939	18-3938	8
228 GM	4765100 - & Up	-	-	-	18-3944	-	-	8
230 GM	6218462 - & Up	-	-	-	18-3944	-	-	8
230 GM (IB)	5907058 - & Up	-	-	-	18-3944	-	-	8
230/5.0L GM (IB)	B522506 - & Up	18-4179	18-4156	18-4178	18-3944	-	-	8
230/5.0-LX (GM)	B525982 - & Up	18-4179	-	18-4178	18-3944	-	-	8
250 GM	2314301 - 2639854	-	N.L.A.	N.L.A.	18-3937	18-3939	18-3938	8
250 GM	4768000 - 4908849	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
255 GM	4175500 - 4498700	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
260 GM	4908850 - 6218461	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
260/5.7L (GM)	B525982 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
260-GM (IB)	5907058 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
270 GM	2851074 - 3077735	N.L.A.	N.L.A.	N.L.A.	18-3937	18-3939	18-3938	8
300 MR/TRS (GM)	6668677 - & Up	-	-	-	18-3937	18-3939	18-3938	8
320 GM (EFI)	A543605 - & Up	-	-	-	18-3937	18-3939	18-3938	8
320 GM (EFI) Bravo	B157603 - & Up	-	-	-	18-3937	18-3939	18-3938	8
325 GM	2278747 - & Up	N.L.A.	-	N.L.A.	18-3940	18-3950	18-3941	8
330 GM	4623115 - & Up	18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8
330 GM/W.B.W.	6083145 - & Up	18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8
340/7.4L-GM (IB)	5889914 - & Up	18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8
350 GM	3780450 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
350 GM Magnum	A635178 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
350 GM Magnum	B525982 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
350 Magnum Tourney SKI	D505450 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
370 TRS-GM	4179554 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
390-GM	2781129 - 2825059	N.L.A.	N.L.A.	N.L.A.	18-3940	18-3950	18-3941	8
400 TRS-GM	4179554 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
420-GM	A398941 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
425-GM	A398941 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
440 TRS-GM	4179554 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
454 GM Magnum	A631894 - & Up	18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8
454 Magnum Bravo (GM)	B840126 - & Up	18-4162	-	-	18-3940	18-3950	18-3941	8
N.L.A. No longer available from O.E. source								

INTERNAL ENGINE COMPONENTS

Pistons/Piston Rings

PISTON/ RING APPLICATION (Cont.)								
Mercruiser (Cont.)			PISTONS			RINGS		
Model	Serial Number	Std.	.020	.030	Std.	.020	.030	Qty. Per Eng.
470	4208730 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	4
485	5685394 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	4
488	6170297 - & Up	18-4109	18-4118	18-4134	18-3928	18-3929	18-3930	4
888	3108723 - & Up	18-4176	-	-	18-3937	18-3939	18-3938	8
898/198-GM	4762210 - & Up	18-4181	-	18-4182	18-3944	-	-	8
5.7 G.M (SKI)	A338553 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
5.7L Bravo - GM	B525982 - & Up	18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
7.4L Bravo GM	B771113 - & Up	18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8
7.4LW/HURTH (IB)	C391564 - & Up	18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8

OMC

GM

2.5L/153 CID		18-4180	18-4183	18-4166	18-3942	-	-	4
3.0L/181 CID		18-4161	18-4160	18-4191	18-3937	18-3939	18-3938	4
1-6/250 CID		18-4169	-	-	18-3942	-	-	6
4.3L/V-6		18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
5.0L/305 CID		18-4179	-	18-4178	18-3944	-	-	8
5.7L/350 CID		18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
7.4L/454 CID		18-4171 ②	18-4189	18-4172	18-3940	18-3950	18-3941	8

FORD

5.0L/302 CID		-	-	-	18-3937	18-3939	18-3938	8
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VOLVO

GM

2.5L/153 CID		18-4180	18-4183	18-4166	18-3942	-	-	4
3.0L/181 CID		18-4161	18-4160	18-4191	18-3937	18-3939	18-3938	4
4.3L/V-6		18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
5.0L/305 CID		18-4179	-	18-4178	18-3944	-	-	8
5.7L/350 CID		18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
7.4L/454 CID		18-4171	18-4189	18-4172	18-3940	18-3950	18-3941	8

FORD

5.0L/302 CID		-	-	-	18-3937	18-3939	18-3938	8
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CHRIS CRAFT/CRUSADER/PLEASURECRAFT

GM

4.3L/V6		18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	6
5.0L/305 CID		18-4179	-	18-4178	18-3944	-	-	8
5.7L/350 CID		18-4173	18-4188	18-4164	18-3937	18-3939	18-3938	8
7.4L/454 CID		18-4171 ②	18-4189	18-4172	18-3940	18-3950	18-3941	8

② For forged pistons use 18-4162 (use 18-3940 rings)



OIL PANS



Part No.	OE	OE No.	Application
18-0612	Mercruiser	809910	1 piece rear main seal
18-0613	Mercruiser	93476	2 piece rear main seal
18-0614	Mercruiser	845668T	-
18-0615	Mercruiser	93477T	-
18-0616	Mercruiser	14244T	1 piece rear main seal

INTERNAL ENGINE COMPONENTS

Bearings



ROD BEARINGS

Part #	Size	Replaces Mercruiser:
18-1133	.020	68704A3
18-1135	.002	68704A2
18-1136	.010	68704A4
18-1148	Std.	68704A1
18-1308	Std.	23-85701
18-1309	.010	23-85704
18-1327	Std.	23-11992
18-1329	Std.	23-85677
18-1330	.010	23-85680
18-1332	.020	23-85729
18-1333	.010	23-85691
18-1334	Std.	23-85726
18-1336	Std.	23-56116
18-1337	.010	23-811858
18-1338	.020	23-811859
18-1341	.020	23-85705

Rod bearings sold individually,
1 per rod



MAIN BEARINGS

Part #	Per Eng.	Size	Replaces Mercruiser:	Part #	Per Eng.	Size	Replaces Mercruiser:
18-1131	4	.010	74313A4	18-1311②		Std.	23-801793
18-1132	4	.020	74313A3	18-1312②		.010	23-801795
18-1137①	1	.020	15103-A3	18-1314②		.020	23-818477
18-1138①	1	.010	15103-A4	18-1315②		Std.	23-818473
18-1147	4	Std.	74313A1	18-1316②		.010	23-818471
18-1149①	1	Std.	15103A1	18-1317②		Std.	23-818469
18-1300②		Std.	23-818465	18-1321②		Std.	23-801801
18-1301②		.010	23-818467	18-1323②		Std.	23-801816
18-1302②		.020	23-818468	18-1335②		.010	23-818476

① Thrust bearing

② Complete engine set



CAM BEARINGS

Part #	Per Eng.	Replaces Mercruiser:
18-1305	1 ②	23-85684
18-1313	1 ②	23-85674
18-1331	1 ②	23-85720
18-1339	1 ②	23-43293
18-1340	5 ②	23-67484

Mercruiser Bearing Application

Model	Serial Number	ROD BEARING			MAIN BEARING			CAM BEARING
		Std.	.010	.020	Std.	.010	.020	
120/2.5L	1666601 & Up	18-1329	18-1330	-	18-1317	18-1316	-	18-1331 ①
140	2508261 - 3462607	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1331
140	3462608 - 5157668	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1339
140	5157669 - 6229717	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1339
140/3.0L	6229718 & Up	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1339
3.0/3.0LX	C856559 & Up	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1339
140 (6cyl)	1538930 - 1725960	18-1329	18-1330	-	N.L.A.	N.L.A.	N.L.A.	N.L.A.
150	1666495 - 2048046	18-1329	18-1330	-	N.L.A.	N.L.A.	N.L.A.	N.L.A.
160	2048022 - 2770031	18-1329	18-1330	-	-	-	-	-
165	2770032 & Up	18-1329	18-1330	-	-	-	-	-
165 (4 cyl.)	6916779 & Up	See specific application chart on page 470						18-1340
170 (4 cyl.)	6916779 & Up	See specific application chart on page 470						18-1340
180/3.7L-LX (4 cyl)	6916779 & Up	See specific application chart on page 470						18-1340
175/4.3L (262 CID)	B527955 & Up	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
4.3L Generation II	D714107 & Up	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
185 (229 CID)	6330183 & Up	-	-	-	18-1300	18-1301	18-1302	18-1313
185 (262 CID)	A331455 & Up	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
190 GM	1564539 - 1730903	18-1329	18-1330	18-1328	-	-	-	18-1313
190 (4 cyl)	6916779 & Up	See specific application chart on page 470						18-1340
200	2453769 - 2712072	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1331
200 GM	6218462 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
200/5.0L	B525982 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
205 (262 CID)	A331455 & Up	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
205/4.3L-LX (262 CID)	B527955 & Up	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
4.3LX Generation II	D714370 & Up	18-1327	18-1337	18-1338	18-1311	18-1312	-	-

① For S/N 4469865 and below only, for S/N 4469866 and above use **18-1339**.

INT. ENG.

INTERNAL ENGINE COMPONENTS

Bearings

Model	Serial Number	ROD BEARING			MAIN BEARING			CAM BEARING
		Std.	.010	.020	Std.	.010	.020	
215 Ford	2781153 & Up	18-1336	-	-	-	-	-	-
225 Ford	3385721 & Up	18-1329	18-1330	-	-	-	-	-
225 GM	1536920 - 2278646	18-1329	18-1330	-	-	-	-	18-1313
225 GM	2278647 - 2399397	18-1329	18-1330	-	18-1317	18-1316	-	18-1313
225 GM	2399398 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
228 GM	4765100 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
230 GM (IB)	5907058 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
230/5.0L GM (IB)	B522506 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
230 GM	6218462 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
230/5.0L-LX (GM)	B525982 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
233 Ford	4173000 - 4902304	-	-	-	-	-	N.L.A.	-
250 GM	2314301 - 2639854	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
250 GM	4768000 - 4908849	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
255 Ford	3258728 & Up	-	-	-	-	-	N.L.A.	-
255 GM	4175500 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
260 GM	4908850 - 6218461	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
260/5.7 (GM)	B525982 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
260 GM ((IB))	5907058 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
260/5.7L GM (IB)	B522506 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
270 GM	2851074 - 3077735	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
280 GM	4176250 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
300 MR/TRS (GM)	6668677 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
320 GM (EFI)	A543605 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
320 GM (EFI) Bravo	B157603 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
325 GM	2278747 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
330 GM	4623115 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
330 GM/W.B.W.	6083045 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
340/7.4LGM(IB)	5889914 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
350 GM	3780450 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
350 GM Magnum	A635178 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
350 (Magnum Tourney SKI)	D505450 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
370 TRS-GM	6721528 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
390 GM	2781129 - 2825059	18-1334	18-1333	18-1332	18-1315	-	-	-
420 GM	A398941 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
425 GM	A398941 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
454 GM Magnum	A631894 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
454 Magnum Bravo (GM)	B840126 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
454 Magnum Bravo Generation V)	D805069 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
454 EFI	F115700 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
470	4208730 & Up	See specific application chart on page 470						18-1340
485	5685394 & Up	See specific application chart on page 470						18-1340
488	6170297 & Up	See specific application chart on page 470						18-1340
502 Magnum Bravo (GM)	C878221 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
502 Magnum Bravo Generation V)	D824589 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
502 EFI	D840650 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
888 Ford	3108723 & Up	18-1336	18-1325	18-1326	18-1323	18-1324	-	-
898/198 GM	4762210 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
5.7 GM (SKI)	A338553 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
5.7 Bravo (GM)	B525982 & Up	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
7.4L Bravo GM	B771113 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
7.4L Bravo (GEN V)	D603118 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
7.4L W/HURTH (IB)	C391564 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
7.4L (IB/LHR/GENV)	D715494 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
8.2L W/HURTH (IB)	C878221 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-
8.2L (IB) (Generation V)	D857200 & Up	18-1334	18-1333	18-1332	18-1315	-	-	-

BEARING APPLICATION CONTINUED ON NEXT PAGE

INT. ENG.

INTERNAL ENGINE COMPONENTS

Bearings



MERCRUISER 3.7L BEARING APPLICATION

Model	Serial Number	ROD BEARINGS				MAIN BEARINGS			MAIN (THRUST BEARINGS)		
		Std.	.002	.010	.020	Std.	.010	.020	Std.	.010	.020
165\3.7 (4cyl)	6916779 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137
170 (4cyl)	6916779 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137
180\3.7L (4cyl)	6916779 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137
190 (4cyl)	6916779 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137
470	4208730 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137
485	5685394 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137
488	6170297 & Up	18-1148	18-1135	18-1136	18-1133	18-1147	18-1131	18-1132	18-1149	18-1138	18-1137

Model	ROD BEARING			MAIN BEARING			CAM Bearing
	Std.	.010	.020	Std.	.010	.020	

OMC

GM

2.5L/153 CID	18-1329	18-1330	18-1328	18-1317	18-1316	-	18-1339
3.0L/181 CID	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1339
I-6/230 CID	18-1329	18-1330	18-1328	18-1321	-	-	-
I-6/250 CID	18-1308	18-1309	18-1341	18-1321	-	-	-
4.3L/V-6	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
5.0L/305 CID	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
5.7L/350 CID	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
7.4L/454 CID	18-1334	18-1333	18-1332	18-1315	18-1335	18-1314	18-1305

FORD

5.0L/302 CID	18-1336	18-1325	18-1326	18-1323	-	-	-
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VOLVO

GM

3.0L/181 CID	18-1308	18-1309	18-1341	18-1317	18-1316	-	18-1339
4.3L/V-6	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
5.0L/305 CID	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
5.7L/350 CID	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
7.4L/454 CID	18-1334	18-1333	18-1332	18-1315	18-1335	18-1314	18-1305

FORD

5.0L/302 CID	18-1336	18-1325	18-1326	18-1323	-	-	-
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CHRIS CRAFT/CRUSADER/PLEASURECRAFT

GM

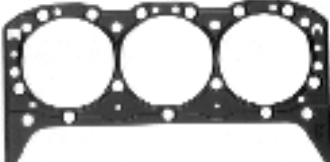
4.3L/V-6	18-1327	18-1337	18-1338	18-1311	18-1312	-	-
5.0L/305 CID	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
5.7L/350 CID	18-1308	18-1309	18-1341	18-1300	18-1301	18-1302	18-1313
7.4L/454 CID	18-1334	18-1333	18-1332	18-1315	18-1335	18-1314	18-1305



INT. ENG.

INTERNAL ENGINE COMPONENTS

Seals/Head Gaskets

PKG. OF 4  18-0518 AP# 792 VALVE STEM SEAL Replaces: Mercruiser 26-34217 OMC & Volvo 3854956 Crusader 7230530 For: most inline 4 and 6 cyl. GM (Early) and 305-350 CID GM	 18-4023 AP# 542 VALVE STEM SEAL Replaces: Mercruiser 26-75413 For: 165, 170, 180, 190 4 cyl. (224 CID) SN 6916779 & later	 18-4022 AP# 534 VALVE STEM SEAL Replaces: Mercruiser 26-75988 For: 330 (SN 4623115 & later), 340 (IB) (SN 5889914 & later), 454 Mag (SN A631894 & later)	 18-4024 INTAKE VALVE SEAL Replaces: Mercruiser 26-97664 Volvo & OMC 3853226 Crusader 7231090 For: Chevy 4.3L/5.0L/5.7L
PKG. OF 8  BRONZE FREEZE PLUGS 18-596118-5962 AP #13415AP # 13416 1 5/8"1 3/4" Mercruiser 19-34270Mercruiser 19-37478	  18-2736 HEAD GASKET Replaces: Mercruiser 27-86389 5 For: 15-25HP 2 cyl	 18-2946 AP# 1827 HEAD GASKET Replaces: Mercruiser 27-52364 OMC & Volvo 3853336, 908611 ChrisCraft 16.50-00204 For: GM 181 (3.0L) CID Eng.	 18-3873 HEAD GASKET Replaces: Mercruiser 27-811207 OMC 915927 PCM RM0226 Crusader 31004 For: 502 CID
 18-3874 HEAD GASKET Replaces: Mercruiser 27-811546 OMC 3853511 Crusader 31137 For: (8.2L) 502 CID / 7.4L	 18-3876 HEAD GASKET Replaces: Mercruiser 27-75611 OMC & Volvo 3853380, 914971 Volvo 841207-4, 856474-2 Crusader 7057500 ChrisCraft 16.50-00250 For: GM 305 (5.0L)/350 (5.7L) CID Eng.	 18-3877 AP# 533 HEAD GASKET Replaces: Mercruiser 27-13687 OMC 914849 Crusader 30266 ChrisCraft 16.50-00259 GM 6258714 For: GM 454 (7.4L) CID Eng.	
 18-3878 AP# 551 HEAD GASKET Replaces: Mercruiser 27-13709T OMC 912766 For: Mercruiser 224 (3.7L) CID Eng., Model 470	 18-3879 AP# 1469 HEAD GASKET Replaces: Mercruiser 27-11986, 27- 816460 OMC & Volvo 3854299, 912227, 914930 For: GM 262 (4.3L) CID Eng.	 18-3880 HEAD GASKET Replaces: Mercruiser 27-34273, Mercruiser 27-810841, OMC 311210 For: GM 153 (2.5L), (3.0L) CID Eng.	

INT. ENG.

INTERNAL ENGINE COMPONENTS

Head Gaskets/Crank Shaft/Timing Cover Seals



 18-3881 AP# 522 HEAD GASKET Replaces: Mercruiser 27-47453 Mercruiser 27-72622 OMC 908237 For: GM 250 (4.1L) CID (6 cyl) Eng.	 18-3883 HEAD GASKET Replaces: Mercruiser 27-75647 OMC & Volvo 3853732 For: Ford 302 (5.0L) 351 (5.8L) CID Eng.	 18-3887 AP# 2524 HEAD GASKET Replaces: Mercruiser 27-850470 Crusader 31136 OMC 915325 For: (7.4L) 454 CID GEN V
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 One Piece Rear Main Crankshaft Seals 18-1234 AP# 2497 Replaces: Mercruiser 26-811554 Crusader 7080030 OMC 3853528 18-0519 AP# 1806 Replaces: Mercruiser 26-14240 Crusader 7070400 OMC & Volvo 3852657 4.3L/3.0L/5.0L 5.7L	 Two Piece Rear Main Crankshaft Seals 18-1214 Replaces: Mercruiser 26-75980 18-0520 AP# 1074 Replaces: Mercruiser 26-14756 Crusader 30238 OMC 460571 18-1211 AP# 279 Replaces: Mercruiser 26-58203, 26-814622 OMC 473424 18-0528 AP# 2547 Replaces: Mercruiser 26-56868 OMC 913745 18-1216 Replaces: Mercruiser 27-35313	 Timing Cover Seals 18-1213 AP# 1055 Replaces: Mercruiser 26-79223, 26-97335, 26-59341 Crusader 7080310 OMC & Volvo 3853341 18-1230 AP# 2546 Replaces: Mercruiser 26-56866 OMC & Volvo 3853827 18-1233 AP# 2496 Replaces: Mercruiser 26-821947-1 OMC 3860095 Crusader 7080130
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MERCUISER SEAL APPLICATION

Model	Serial No.	Sierra Rear Main Crankshaft Seal	Sierra Timing Cover Seal
120/2.5L	1666601 & UP	—	18-1213
120/2.5L	2786857 & UP	18-1211	18-1213
140/3.0L & LX	2508261 & UP	—	18-1213
140/3.0L & LX	6229718 & UP	18-1211	18-1213
150/160/165/200 (I/L-6)	1666495 & UP	—	18-1213
150/160/165/200 (I/L-6)	2770032 & UP	18-1211	18-1213
175/185/205/262/4.3L (V-6)	6330183 & UP	18-1211	18-1213
200/228/225/230/250/255/260/270 280/300/320/5.0L/5.7L/898(V-8)	2453769 & UP	18-1211①	18-1213
233, 233 MIE / 255, 255 MIE, 351W	3258728 & UP	18-1223	18-1230
215	2781153 & UP	18-0528	18-1230
224I/L4	ALL	18-0864	18-0578
225 FORD	3885721 & UP	18-0528	18-1230
5.0L/5.7L, 4.3L, 3.0L Std. Rotation	"All" one piece seal	18-0519	18-1213
340 (7.4L)	4623115 & UP	18-0520	18-1233
370 TRS	5889914 & UP	18-0520	18-1233
400 TRS	4179554 & UP	18-0520	18-1233
420	A398941 & UP	18-0520	18-1233
440 TRS	4179554 & UP	18-0520	18-1233
454 MAGNUM	A631894 & UP	18-0520	18-1233
460 TRS	4179554 & UP	18-0520	18-1233
7.4L/8.2L/454/502 Std. Rotation	"All" one piece seal	18-1234	18-1233
7.4 BRAVO	B771113 & UP	18-0520	18-1233
888 (188)	3108723 & UP	18-0528	18-1230

① Lrg. Journal Crankshaft GM Engines

INT. ENG.



INTERNAL ENGINE COMPONENTS

Crank Shaft/Timing Cover Seals

OMC SEAL APPLICATION			
Engine Model	2 Piece Rear Main Crankshaft Seal Conv. Rotation (LH)	2 Piece Rear Main Crankshaft Seal Reverse Rotation (RH)	Timing Cover Seal
GM			
2.5L/153 CID	18-1211 ②	18-1216	18-1213
3.0L/181 CID	18-1211 ②	18-1216	18-1213
I-6/230CID	18-1211 ②	18-1216	18-1213
I-6/250CID	18-1211 ②	18-1216	18-1213
4.3L/V-6	18-1211 ②	18-1216	18-1213
5.0L/305 CID	18-1211 ① ②	18-1216	18-1213
5.7L/350 CID	18-1211 ① ②	18-1216	18-1213
7.4L/454 CID	18-0520 ③	18-1214	18-1233
FORD			
5.0L/302 CID	18-0528	-	18-1230
5.8L/351 CID	18-1223	-	18-1230
VOLVO SEAL APPLICATION			
Engine Model	2 Piece Rear Main Crankshaft Seal Conv. Rotation (LH)	2 Piece Rear Main Crankshaft Seal Reverse Rotation (RH)	Timing Cover Seal
GM			
3.0L/181 CID	18-1211 ②	18-1216	18-1213
4.3L/V-6	18-1211 ②	18-1216	18-1213
5.0L/305 CID	18-1211 ① ②	18-1216	18-1213
5.7L/350 CID	18-1211 ① ②	18-1216	18-1213
7.4L/454 CID	18-0520 ③	18-1214	18-1233
FORD			
5.0L/302 CID	18-0528	-	18-1230
5.8L/351 CID	18-1223	-	18-1230
CHRIS CRAFT/CRUSADER/PLEASURECRAFT SEAL APPLICATION			
Engine Model	2 Piece Rear Main Crankshaft Seal Conv. Rotation (LH)	2 Piece Rear Main Crankshaft Seal Reverse Rotation (RH)	Timing Cover Seal
GM			
4.3L/V-6	18-1211 ②	18-1216	18-1213
5.0L/305 CID	18-1211 ① ②	18-1216	18-1213
5.7L/350 CID	18-1211 ① ②	18-1216	18-1213
7.4L/454 CID	18-0520 ③	18-1214	18-1233
FORD			
5.0L/302 CID	18-0528	-	18-1230
5.8L/351 CID	18-1223	-	18-1230
① Lrg. Journal Crankshaft GM Engines ② For one piece seal (RH) models use 18-0519 (LH) models use 18-1215 ③ For one piece seal (RH) models use 18-1234			

INT. ENG.

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications



INT. ENG.

MODULAR GASKET KITS

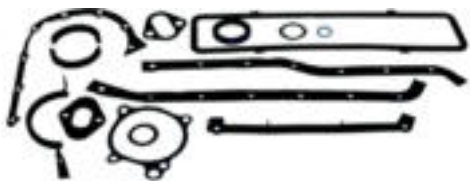
Easy to use Modular Gasket Kits for Ford & Chevrolet Marine Engines

- For most popular marine versions of: Chevrolet In-line 4 & 6 cylinder V6 & V8 Engines and Ford 5.0 L & 5.8L V8 Engines
- Minimizes inventory investment to cover most major engine applications
- Maximizes inventory utilizations via mix and match system
- Utilizes generic type gasket kits common among all engine brands., (i.e. a 350CID (5.7L) Crusader & Mercruiser would use the same short block & valve grind gasket sets, but would use different exhaust manifold gasket kits)

CHEVY 4 cyl. 153/2.5L 1965-88 ③

CHEVY 4 cyl. 181/3.0L 1973-84 ③

CHEVY 4 cyl. 181/3.0L 1985-89 (4 cyl. 181/3.0L HO 1990-98 ③)

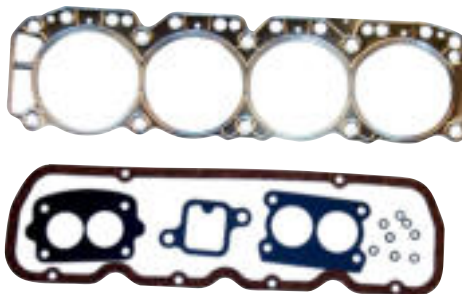


SHORT BLOCK KIT 18-1271 ③

AP# 2567 ①

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0466
Forward Crankshaft Seals	18-1213
Rear Crankshaft Seals	18-1211
Push Rod Cover	18-0328
Water Pump Gasket	18-0327
Fuel Pump Mounting Gasket	18-0889
Fuel Pump Mounting Gasket	NSS
Cam Gear Cover Gasket	18-0887
Distributor Mounting Gasket	18-0948
Distributor Mounting Gasket	18-0874

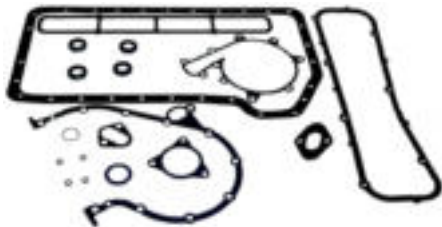


VALVE GRIND KIT 18-1274

— CONTAINS —

Description	Sierra #
Head Gasket	18-2946
Mercarb Mounting Gasket	18-0994
Carb. Mounting Gasket	18-0356
Thermostat Housing Gasket	18-0164
Valve Cover Gasket	18-0347
Valve Stem Seals (8)	18-0518

4 cyl. 3.7L Mercruiser 470

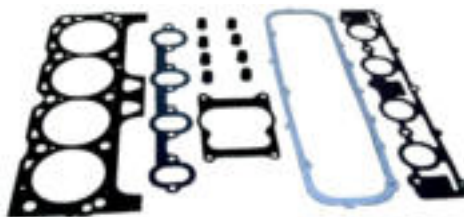


SHORT BLOCK KIT 18-1276

AP# 3646

— CONTAINS —

Description	Sierra #
Oil Seal	18-2014
Mounting Gasket	NSS
Distributor Mounting Gasket	18-0874
Fuel Pump Mounting Gasket	18-0889
O-Ring	NSS
Water Pump Seal	18-0172
O-Ring	18-7145
Oil Pan Gasket	18-4366
Water Pump Timer Cover Gasket	NSS



VALVE GRIND KIT 18-1277

AP# 3647

— CONTAINS —

Description	Sierra #
Intake Gasket	18-0158
Quadrajet Gasket	18-2848
Valve Grind Cover Gasket	NSS
Head Gasket	18-3878
Exhaust Manifold Mounting Gasket	18-0992
Valve Seal	NSS

① Except models with cast push rod cover

② Does not include intake/exhaust manifold gaskets

③ For models with 1 piece rear main seal use 18-1206

NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications

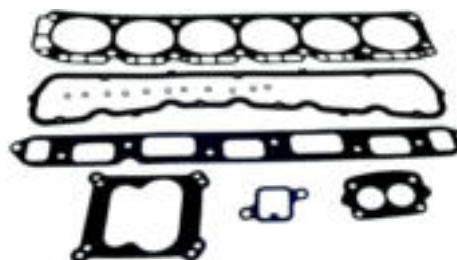
MODULAR GASKET KITS

CHEVY L-6 250/4.1L



SHORT BLOCK KIT 18-1255 AP# 2551 (24 Bolt Pan Only) — CONTAINS —

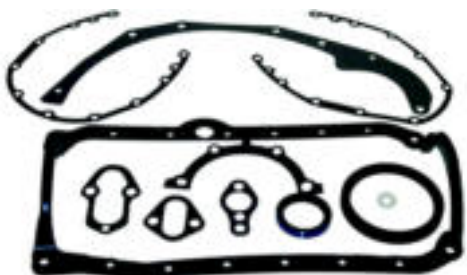
Description	Sierra #
Oil Pan Gasket	18-0340
Forward Crankshaft Seals	18-1213
Rear Crankshaft Seals	18-1211
Push Rod Cover	18-0329
Water Pump Gasket	18-0327
Fuel Pump Mounting Gasket	18-0889
Timing Gear Cover Gasket	18-0887
Distributor Mounting Gasket	18-0874



VALVE GRIND KIT 18-1264 AP# 2560 — CONTAINS —

Description	Sierra #
Head Gasket	18-3881
4BBL Carb Mounting Gasket	NSS
2BBL Carb Mounting Gasket	18-0356
Exhaust Manifold Gasket	18-2830
T-Stat Hsg. Mounting Gasket	18-0164
Valve Cover Gasket	18-0346
Valve Stem Seals (8)	18-0518

CHEVY V-6 229/3.8L AND 4.3L



SHORT BLOCK KIT 18-1270 AP# 2566* — CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0405
Oil Drain Screw Gasket	18-0905
Forward Crankshaft Seals	18-1213
Rear Crankshaft Seal	18-0519
Crankshaft Seal Retainer	18-0322
Water Pump Mounting Gasket	18-0891
Fuel Pump Plate Gasket	NSS
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0976
Timing Chain Cover Gasket	NSS

* Requires Rear Crankshaft Seal
(Not Included) in addition to short block kit



VALVE GRIND KIT 18-1275 AP# 2531^① — CONTAINS —

Description	Sierra #
Head Gasket	18-3879
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
Intake Manifold Gasket	18-4408
Valve Cover Gasket	18-0311
Valve Stem Seals (6)	18-4024
Valve Stem Seals (12)	18-0518
Distributor Mounting Gasket	18-0874

① Does not include oil pan gasket ② Does not include intake/exhaust manifold gaskets NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

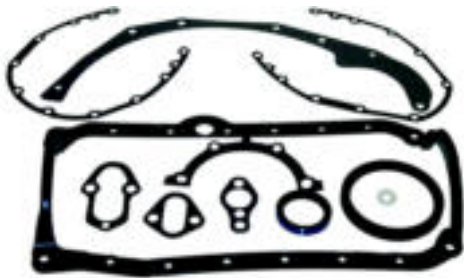
Modular Gasket Kit Applications



INT. ENG.

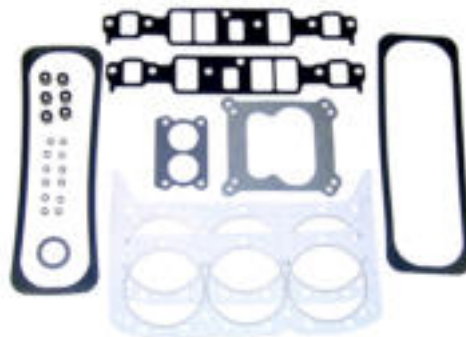
MODULAR GASKET KITS

CHEVY V-6 262/4.3L — 1 Piece Rear Seal CHEVY V-6 262/4.3L GEN II — 1 Piece Rear Seal



SHORT BLOCK KIT 18-1270 AP# 2566* — CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0405
Oil Drain Screw Gasket	18-0905
Forward Crankshaft Seals	18-1213
Rear Crankshaft Seal	18-0519
Crankshaft Seal Retainer	18-0322
Water Pump Mounting Gasket	18-0891
Fuel Pump Plate Gasket	NSS
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0976
Timing Chain Cover Gasket	NSS
* Requires Rear Crankshaft Seal (Not Included) in addition to short block kit	



VALVE GRIND KIT 18-1278 — CONTAINS —

Description	Sierra #
Head Gasket	18-3879
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
Valve Stem Seals (6)	18-4024
Valve Stem Seals (12)	18-0518
Distributor Mounting Gasket	18-0874
Intake Gasket Set	18-1238
Valve Cover Gasket (2)	18-0311

CHEVY V-8 305/5.0L 2 Piece Rear Seal



SHORT BLOCK KIT 18-1265 AP# 2561* — CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0153
Oil Drain Screw Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-1211
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0876
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0976
Vent Adapter Gasket	NSS
* Except Stbd Dip Stick models	



VALVE GRIND KIT 18-1266 AP# 2562② — CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket	18-0868
Valve Cover Gasket (2)	18-2845
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

① Does not include oil pan gasket

② Does not include intake/exhaust manifold gaskets

NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications

MODULAR GASKET KITS

CHEVY V-8 305/5.0L (Right Hand Rotation) 2 Piece Rear Seal



SHORT BLOCK KIT 18-1262 — CONTAINS —

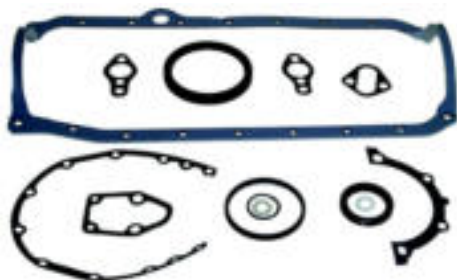
Description	Sierra #
Oil Pan Gasket	18-0153
Oil Drain Screw Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-1216
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0876
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0976
Vent Adapter Gasket	NSS



VALVE GRIND KIT 18-1266 AP# 2562^② — CONTAINS —

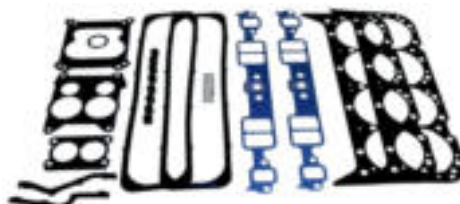
Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket	18-0868
Valve Cover Gasket (2)	18-2845
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

CHEVY V-8 305/5.0L GEN II 1 Piece Rear Seal



SHORT BLOCK KIT 18-1268 AP# 2564^① — CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-0519
Rear Main Bearing Gasket	18-0322
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0976
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0468



VALVE GRIND KIT 18-1267 AP# 2563^② — CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket Set	18-0868
Valve Cover Gasket (2)	18-0664
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

① Does not include oil pan gasket

② Does not include intake/exhaust manifold gaskets

NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

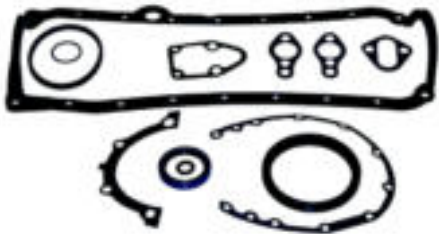
Modular Gasket Kit Applications



INT. ENG.

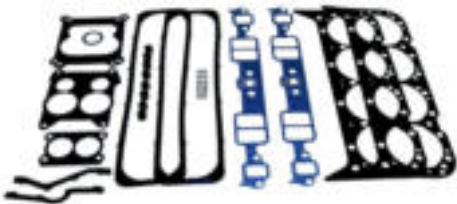
MODULAR GASKET KITS

CHEVY V-8 305/5.0L GEN II (Right Hand Rotation) 1 Piece Rear Seal



SHORT BLOCK KIT 18-1263 AP# 2559^① — CONTAINS —

Description	Sierra #
Oil Drain Screw Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-1215
Rear Main Bearing Gasket	18-0322
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0876
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0468



VALVE GRIND KIT 18-1267 AP# 2563^② — CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket Set	18-0868
Valve Cover Gasket (2)	18-0664
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

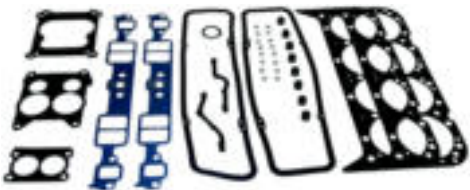
CHEVY V-8 350/5.7L 2 Piece Rear Seal



SHORT BLOCK KIT 18-1265 AP# 2561* — CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0153
Oil Drain Screw Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-1211
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0876
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0976
Vent Adapter Gasket	NSS

* Except Stbd Dip Stick models



VALVE GRIND KIT 18-1266 AP# 2562^② — CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket	18-0868
Valve Cover Gasket (2)	18-2845
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

① Does not include oil pan gasket

② Does not include intake/exhaust manifold gaskets

NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications

MODULAR GASKET KITS

CHEVY V-8 350/5.7L (Right Hand Rotation) 2 Piece Rear Seal



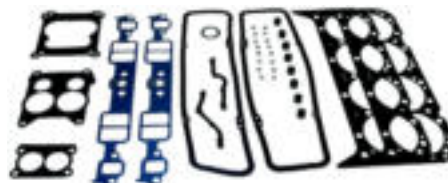
SHORT BLOCK KIT 18-1262

AP# 2558*

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0153
Oil Drain Screw Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-1216
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0876
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0976
Vent Adapter Gasket	NSS

* Except Stbd Dip Stick Models



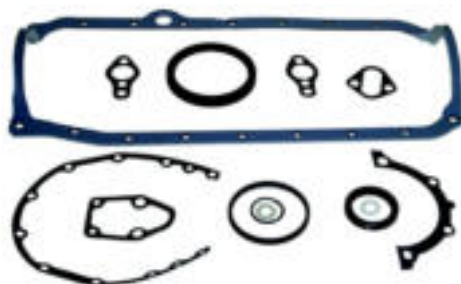
VALVE GRIND KIT 18-1266

AP# 2562②

— CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket	18-0868
Valve Cover Gasket (2)	18-2845
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

CHEVY V-8 350/5.7L GEN II 1 Piece Rear Seal

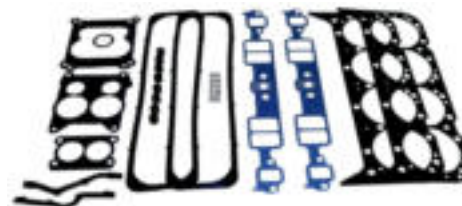


SHORT BLOCK KIT 18-1268

AP# 2564①

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Crankshaft Seal	18-0519
Rear Main Bearing Gasket	18-0322
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0976
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0468



VALVE GRIND KIT 18-1267

AP# 2563②

— CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket Set	18-0868
Valve Cover Gasket (2)	18-0664
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

① Does not include oil pan gasket

② Does not include intake/exhaust manifold gaskets

NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

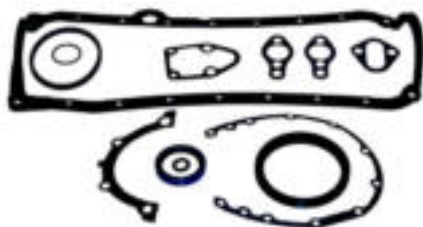
Modular Gasket Kit Applications



INT. ENG.

MODULAR GASKET KITS

CHEVY V-8 350/5.7L GEN II (Right Hand Rotation) 1 Piece Rear Seal

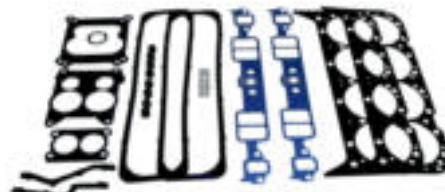


SHORT BLOCK KIT 18-1263

AP# 2559^①

— CONTAINS —

Description	Sierra #
Oil Drain Screw Gasket	18-0905
Oil Filter Gasket	18-0185
Forward Crankshaft Seal	18-1213
Rear Main Bearing Gasket	18-0322
Water Pump Mounting Gasket	18-0891
Water Pump Plate Gasket	NSS
Fuel Pump Plate Gasket	18-0876
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	18-0468



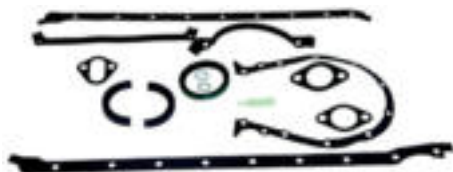
VALVE GRIND KIT 18-1267

AP# 2563^②

— CONTAINS —

Description	Sierra #
Head Gasket	18-3876
2BBL Carb Mounting Gasket	18-0994
4BBL Carb Mounting Gasket	18-0463
4BBL Carb Mounting Gasket	18-0462
Intake Manifold Gasket Set	18-0868
Valve Cover Gasket (2)	18-0664
Valve Stem Seals (8)	18-4024
Valve Stem Seals (16)	18-0518
Distributor Mounting Gasket	18-0874

CHEVY V-8 454/7.4L

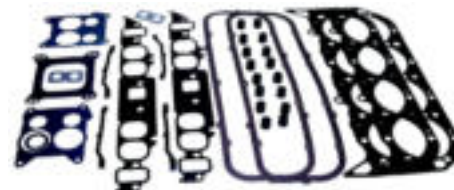


SHORT BLOCK KIT 18-1256

AP# 2552*

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0348
Oil Drain Screw Gasket	18-0905
Forward Crankshaft Seal	18-1233
Rear Crankshaft Seal	18-0520
Water Pump Mounting Gasket	18-0903
Fuel Pump Mounting Gasket	18-0889
Timing Cover Gasket	18-0980
* Right Hand Rotation Engines Require	
Rear Crankshaft Seal	18-1214



VALVE GRIND KIT 18-1257

AP# 2553^②

— CONTAINS —

Description	Sierra #
Head Gasket	18-3877
Carb Mounting Gasket	NSS
Carb Mounting Gasket	NSS
Carb Mounting Gasket	NSS
Intake Manifold Gasket Set	NSS
Valve Cover Gasket (2)	NSS
Valve Stem Seals (16)	NSS
Distributor Mounting Gasket	18-0874

^① Does not include oil pan gasket

^② Does not include intake/exhaust manifold gaskets

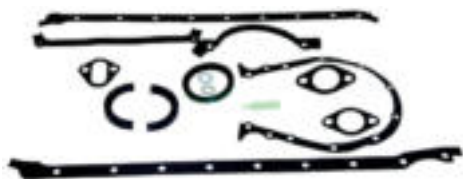
NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications

MODULAR GASKET KITS

CHEVY V-8 454/7.4L w/Square Ports

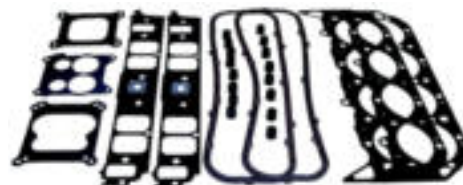


SHORT BLOCK KIT 18-1256

AP# 2552*

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0348
Oil Drain Screw Gasket	18-0905
Forward Crankshaft Seal	18-1233
Rear Crankshaft Seal	18-0520
Water Pump Mounting Gasket	18-0903
Fuel Pump Mounting Gasket	18-0889
Timing Cover Gasket	18-0980
* Right Hand Rotation Engines Require	
Rear Crankshaft Seal	18-1214



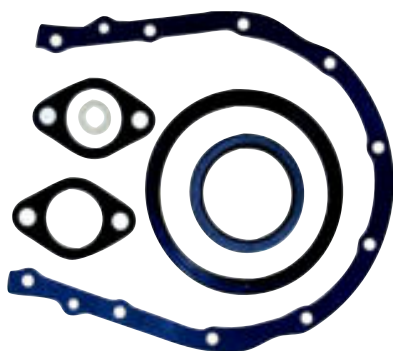
VALVE GRIND KIT 18-1259

AP# 2555^②

— CONTAINS —

Description	Sierra #
Head Gasket	18-3877
Carb Mounting Gasket	18-0467
Carb Mounting Gasket	18-0463
Carb Mounting Gasket	18-0462
Intake Manifold Gasket Set	18-1231
Valve Cover Gasket (2)	18-0464
Valve Stem Seals (16)	18-4024
Distributor Mounting Gasket	18-0874

CHEVY V-8 454/7.4L GEN V CHEVY V-8 454/7.4L GEN V (w/square ports)



SHORT BLOCK KIT 18-1261

AP# 2557^①

— CONTAINS —

Description	Sierra #
Oil Drain Screw Gasket	18-0905
Forward Crankshaft Seals	18-1233
Rear Crankshaft Seals	18-1234
Water Pump Mounting Gasket	18-0903
Timing Cover Gasket	18-0468



VALVE GRIND KIT 18-1258

AP# 2554^②

— CONTAINS —

Description	Sierra #
Head Gasket	18-3887
Carb Mounting Gasket	18-0467
Carb Mounting Gasket	18-0463
Carb Mounting Gasket	18-0462
Intake Manifold Gasket Set	18-1231
Valve Stem Seals (16)	NSS
Distributor Mounting Gasket	18-0874

① Does not include oil pan gasket

② Does not include intake/exhaust manifold gaskets

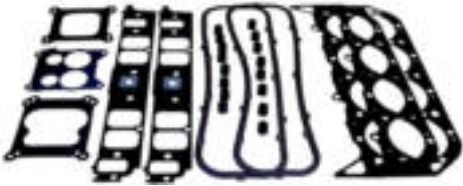
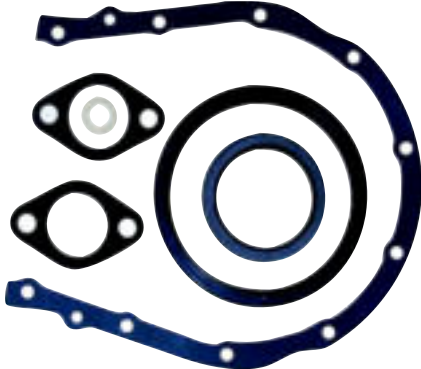
NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications



INT. ENG.

MODULAR GASKET KITS																																							
CHEVY V-8 502/8.2L																																							
																																							
SHORT BLOCK KIT 18-1256 AP# 2552* — CONTAINS — <table><tr><th>Description</th><th>Sierra #</th></tr><tr><td>Oil Pan Gasket</td><td>18-0348</td></tr><tr><td>Oil Drain Screw Gasket</td><td>18-0905</td></tr><tr><td>Forward Crankshaft Seal</td><td>18-1233</td></tr><tr><td>Rear Crankshaft Seal</td><td>18-0520</td></tr><tr><td>Water Pump Mounting Gasket</td><td>18-0903</td></tr><tr><td>Fuel Pump Mounting Gasket</td><td>18-0889</td></tr><tr><td>Timing Cover Gasket</td><td>18-0980</td></tr><tr><td colspan="2">* Right Hand Rotation Engines Require</td></tr><tr><td>Rear Crankshaft Seal</td><td>18-1214</td></tr></table>	Description	Sierra #	Oil Pan Gasket	18-0348	Oil Drain Screw Gasket	18-0905	Forward Crankshaft Seal	18-1233	Rear Crankshaft Seal	18-0520	Water Pump Mounting Gasket	18-0903	Fuel Pump Mounting Gasket	18-0889	Timing Cover Gasket	18-0980	* Right Hand Rotation Engines Require		Rear Crankshaft Seal	18-1214	VALVE GRIND KIT 18-1259 AP# 2555② — CONTAINS — <table><tr><th>Description</th><th>Sierra #</th></tr><tr><td>Head Gasket</td><td>18-3877</td></tr><tr><td>Carb Mounting Gasket</td><td>18-0467</td></tr><tr><td>Carb Mounting Gasket</td><td>18-0463</td></tr><tr><td>Carb Mounting Gasket</td><td>18-0462</td></tr><tr><td>Intake Manifold Gasket Set</td><td>18-1231</td></tr><tr><td>Valve Cover Gasket (2)</td><td>18-0464</td></tr><tr><td>Valve Stem Seals (16)</td><td>18-4024</td></tr><tr><td>Distributor Mounting Gasket</td><td>18-0874</td></tr></table>	Description	Sierra #	Head Gasket	18-3877	Carb Mounting Gasket	18-0467	Carb Mounting Gasket	18-0463	Carb Mounting Gasket	18-0462	Intake Manifold Gasket Set	18-1231	Valve Cover Gasket (2)	18-0464	Valve Stem Seals (16)	18-4024	Distributor Mounting Gasket	18-0874
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SHORT BLOCK KIT 18-1261 AP# 2557① — CONTAINS — <table><tr><th>Description</th><th>Sierra #</th></tr><tr><td>Oil Drain Screw Gasket</td><td>18-0905</td></tr><tr><td>Forward Crankshaft Seals</td><td>18-1233</td></tr><tr><td>Rear Crankshaft Seals</td><td>18-1234</td></tr><tr><td>Water Pump Mounting Gasket</td><td>18-0903</td></tr><tr><td>Timing Cover Gasket</td><td>18-0468</td></tr></table>	Description	Sierra #	Oil Drain Screw Gasket	18-0905	Forward Crankshaft Seals	18-1233	Rear Crankshaft Seals	18-1234	Water Pump Mounting Gasket	18-0903	Timing Cover Gasket	18-0468	VALVE GRIND KIT 18-1258 AP# 2554② — CONTAINS — <table><tr><th>Description</th><th>Sierra #</th></tr><tr><td>Head Gasket</td><td>18-3887</td></tr><tr><td>Carb Mounting Gasket</td><td>18-0467</td></tr><tr><td>Carb Mounting Gasket</td><td>18-0463</td></tr><tr><td>Carb Mounting Gasket</td><td>18-0462</td></tr><tr><td>Intake Manifold Gasket Set</td><td>18-1231</td></tr><tr><td>Valve Stem Seals (16)</td><td>NSS</td></tr><tr><td>Distributor Mounting Gasket</td><td>18-0874</td></tr></table>	Description	Sierra #	Head Gasket	18-3887	Carb Mounting Gasket	18-0467	Carb Mounting Gasket	18-0463	Carb Mounting Gasket	18-0462	Intake Manifold Gasket Set	18-1231	Valve Stem Seals (16)	NSS	Distributor Mounting Gasket	18-0874										
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INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications

MODULAR GASKET KITS

FORD V-8 302/5.0L 1977-93



SHORT BLOCK KIT 18-1272

AP# 2568*

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0407
Forward Crankshaft Seal	18-1230
Rear Crankshaft Seal	18-0528
Water Pump Mounting Gasket	NSS
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	NSS
Oil Pump Screen Gasket	NSS
* Right Hand Rotation Engines Require	
Forward Crankshaft Seal	18-1230



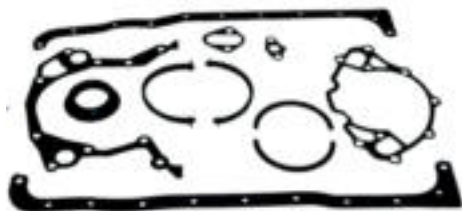
VALVE GRIND KIT 18-1273

AP# 2580②

— CONTAINS —

Description	Sierra #
Head Gasket (2)	18-3883
4BBL Carb Mounting Gasket	18-0357
2BBL Carb Mounting Gasket	18-0360
Intake Manifold Gasket Set	18-0366
Valve Cover Gasket (2)	18-0352
Valve Stem Seals (16)	18-4023

FORD V-8 351/5.8L 1977-93



SHORT BLOCK KIT 18-1269

AP# 2565*

— CONTAINS —

Description	Sierra #
Oil Pan Gasket	18-0611
Forward Crankshaft Seal	18-1230
Rear Crankshaft Seal	18-1223
Water Pump Mounting Gasket	NSS
Fuel Pump Mounting Gasket	18-0889
Timing Chain Cover Gasket	NSS
Oil Pump Screen Gasket	NSS
* Right Hand Rotation Engines Require	
Forward Crankshaft Seal	18-1230



VALVE GRIND KIT 18-1273

AP# 2580②

— CONTAINS —

Description	Sierra #
Head Gasket (2)	18-3883
4BBL Carb Mounting Gasket	18-0357
2BBL Carb Mounting Gasket	18-0360
Intake Manifold Gasket Set	18-0366
Valve Cover Gasket (2)	18-0352
Valve Stem Seals (16)	18-4023

① Does not include oil pan gasket

② Does not include intake/exhaust manifold gaskets

NSS Not Sold Separately

INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications



INT. ENG.

MODULAR GASKET APPLICATION				
Engine/Model	Years	Serial No.	Sierra Short Block	Sierra Valve Grind Kit
Chevy 153-2.5L	1965-85	3377341-6229717 ⑤ ②	18-1271	18-1274
Chevy 153/2.5L	1986-88	6229718 & Up ⑤ ②	18-1271	18-1274
Chevy 181/3.0L	1973-84	3332137-6229717 ⑤ ② ③	18-1271	18-1274
Chevy 181/3.0L	1985-96	6229718 & Later ⑤ ② ③	18-1271	18-1274
Chevy 181/3.0Lx	1990-97	C856559 & Later ① ⑤ ②	N/A	18-1274
Mercuriser 165/3.7L (4 Cyl.)	1987-89	6916779 & Later ⑦ ③	18-1276	18-1277
Mercuriser 170 (4 Cyl.)	1985-86	6916779 & Later ③	18-1276	18-1277
Mercuriser 180/3.7L-Lx (4 Cyl.)	1987-89	6916779 & Later ③	18-1276	18-1277
Mercuriser 190 (4 Cyl.)	1985-86	6916779 & Later ③	18-1276	18-1277
Mercuriser 470	1976-82	4208730-6218036 ③	18-1276	18-1277
Mercuriser 470	1983-84	6218037-6916778 ③	18-1276	18-1277
Mercuriser 485	1980-82	5685394-6218036 ③	18-1276	18-1277
Mercuriser 488	1983-84	6170297-6916778 ③	18-1276	18-1277
Chevy 229/3.8L	1983-84	6330183-6919655 ② ⑤	18-1270	18-1275
Chevy L6 250/4.1L	1970-81	2770032-5813433 ⑤	18-1255	18-1264
Chevy 262/4.3L (2Pc. Rm Seal)	1985	6919656-B455459 ⑤	N/A	18-1275
Chevy 262/4.3L (2Pc. Rm Seal)	1986-92	A483581 ① ⑤	18-1270	18-1275
Chevy 262/4.3L Gen II	1992	D714370-F802999 ① ⑤	18-1270	18-1278
Chevy 262/4.3L Gen II	1993-96	D714370-F802999 ① ⑤	18-1270	18-1278
Chevy 305/5.0L	1977-85	4762210-B525981 ③ ⑤	18-1265	18-1266
Chevy 305/5.0L (Rev. Rota.)	1977-85	4762210-B525981 ③ ⑤	18-1262	18-1266
Chevy 305/5.0L (1 Pc. Rm Seal)	1986	A482027-B525981 ① ⑤	18-1258	18-1266
Chevy 305/5.0L (Rev. Rota.)				
(1 Pc. Rm Seal)	1986	A482027-B525981 ① ⑤	18-1263	18-1266
Chevy 305/5.0L	1987-95	B525982 & Later ① ⑤ ⑧	18-1268	18-1267
Chevy 305/5.0L Inboard	1987-95	B522506 & Later ① ⑤ ⑧	18-1268	18-1267
Chevy 305/5.0L (Rev.Rota) Inboard	1987-95	B522506 & Later ① ⑤	18-1263	18-1267
Chevy 350/5.7L	1975-86	4175500-B525982 ③ ⑤ ④	18-1265	18-1266
Chevy 350/5.7 Inboard	1975-86	4498701-B522506 ③ ⑤	18-1265	18-1266
Chevy 350/5.7 (Rev.Rota) Inboard	1975-86	4498701-B522506 ③ ⑤	18-1262	18-1266
Chevy 350/5.7L (1Pc. Rm Seal)	1986	6218462-B522506 ① ⑤	18-1268	18-1266

- ① Full circle Rear Crankshaft Seal, one Piece Pan Gasket
- ② 3.8L models require 18-1211 Rear Crank Seal and 18-0362 Oil Pan Gasket
- ③ Starboard dip stick models require 18-0411 Pan Gasket
- ④ Four Piece Oil Pan Set
- ⑤ Head & valve cover gaskets included in valve grind kit
- ⑦ Intake/Exhaust Manifold Gasket included in kit

- ⑧ 18-1216 Rear Main Crankshaft Seal also required
- ⑩ 18-1214 Rear Main Crankshaft Seal also required
- ① Crankshaft Seals also required
- ② Models with cast push rod cover require 18-0328
- ③ Crankshaft Seals not included in short block kit
- ④ Use 18-4349 for serial no.6218462-B525981
- ⑤ For models with one piece rear main seal use 18-1206 Kit



INTERNAL ENGINE COMPONENTS

Modular Gasket Kit Applications

MODULAR GASKET APPLICATION (Cont.)				
Engine/Model	Years	Serial No.	Sierra Short Block	Sierra Valve Grind Kit
Chevy 350/5.7L (1Pc. Rm Seal) Inboard	1986	A492879-B522506 ① ⑤	18-1268	18-1266
Chevy 350/5.7L (Rev.Rota) (1 Pc. Rm Seal)	1986	A492879-B522506 ① ⑤	18-1263	18-1266
Chevy 350/5.7L	1987-95	B525982 & Later ① ⑤ ⑧	18-1268	18-1267
Chevy 350/5.7L	1996-97	B525982 & Later ① ⑤ ⑧	18-1268	18-1267
Chevy 350/5.7L Inboard	1987-95	B522506 & Later ① ⑤	18-1263	18-1267
Chevy 350/5.7L Inboard	1996-97	B522506 & Later ① ⑤	18-1263	18-1267
Chevy 350/5.7L (Rev.Rota.) Inboard	1987-95	B522506 & Later ① ⑤	18-1263	18-1267
Chevy 350/5.7L (Rev. Rota.) Inboard	1996-97	B522506 & Later ① ⑤	18-1263	18-1267
Chevy 454/7.4L	1977-92	4623115-D937001⑤	18-1256	18-1257
Chevy 454/7.4L Inboard	1977-92	4623110 & Later ⑤	18-1256	18-1257
Chevy 454/7.4L (Rev.Rota.) Inboard	1977-92	4623110 & Later ⑤ ⑩	18-1256	18-1257
Chevy 454/7.4L (Sq. Ports)	1988-91	B721206-D805068 ⑤	18-1256	18-1259
Chevy 454/7.4L Gen V	1992-94	D603118 & Later ⑤	18-1261	18-1258
Chevy 454/7.4L Gen V	1995-97	D603118 & Later ⑤	18-1261	18-1258
Chevy 454/7.4L Gen V Inboard	1992-94	D715494 & Later ⑤	18-1261	18-1258
Chevy 454/7.4L Gen V Inboard	1995-97	D715494 & Later ⑤	18-1261	18-1258
Chevy 454/7.4L Gen V (Sq. Ports)	1992-94	D805069 & Later ⑤	18-1261	18-1260
Chevy 454/7.4L Gen V (Sq. Ports)	1995-97	D805069 & Later ⑤	18-1261	18-1260
Chevy 502/8.2L	1990-92	C84992-F213244 ⑤	18-1256	18-1259
Chevy 502/8.2L Inboard	1990-92	C878221-D857199 ⑤	18-1256	18-1259
Chevy 502/8.2L Gen V	1993-97	D824589 & Later ⑤	18-1261	18-1260
Chevy 502/8.2L Gen V Inboard	1993-97	D857200 & Later ⑤	18-1261	18-1260
Ford 302/5.0L	1971-77	3108723-4887829 ④ ⑤	18-1272	18-1273
Ford 351/5.8L	1975-77	4173000-4902304 ④ ⑤	18-1269	18-1273
Ford 351/5.8L (Rev. Rota.)	1975-77	4173000-4902304 ④ ⑤ ①	18-1269	18-1273
① Full circle Rear Crankshaft Seal, one Piece Pan Gasket ② 3.8L models require 18-1211 Rear Crank Seal and 18-0362 Oil Pan Gasket ③ Starboard dip stick models require 18-0411 Pan Gasket ④ Four Piece Oil Pan Set ⑤ Head & valve cover gaskets included in valve grind kit ⑦ Intake/Exhaust Manifold Gasket included in kit ⑧ 18-1216 Rear Main Crankshaft Seal also required ⑩ 18-1214 Rear Main Crankshaft Seal also required ① Crankshaft Seals also required ② Models with cast push rod cover require 18-0328 ③ Crankshaft Seals not included in short block kit ④ Use 18-4349 for serial no.6218462-B525981 ⑤ For models with one piece rear main seal use 18-1206 Kit				

INT. ENG.

INTERNAL ENGINE COMPONENTS

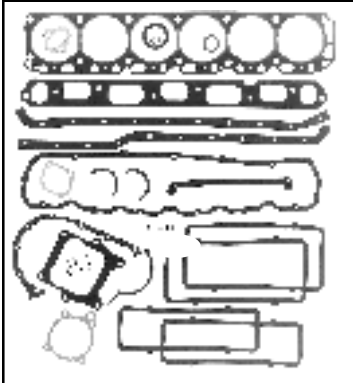
Gasket Sets



INT. ENG.

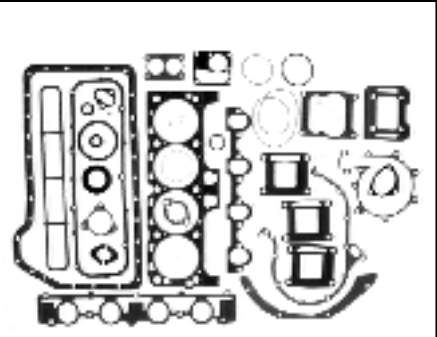
ENGINE OVERHAUL GASKET SETS

(Sets do not include Front and Rear Crankshaft Seals)



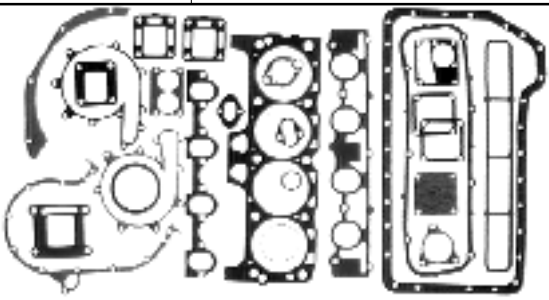
18-4358
Replaces: Mercruiser 27-801841
For: 250 CID Engines/ 160, 165 HP

— CONTAINS —			
Sierra #	Description	O.E. #	Qty.
18-0175	O-Ring	25-26543	4
18-0860	O-Ring	25-62700	1
18-0864	Seal	26-90925	1
18-0881	Exhaust Elbow Mtg Gasket	27-18272	1
18-0992	Exhaust Manifold Mounting Gasket	27-68715	1
18-0994	Carburetor Mounting Gasket	27-70143-1	1
18-0158	Intake Manifold Gasket	27-70905	1
18-0111	Exhaust Elbow Mounting Gasket	27-89657	2
18-0160	Lower Exhaust to Intake Manifold Gasket	27-94136	1
18-0113	Exhaust Elbow Mounting Gasket	27-97542	1
18-2843	Thermostat Cover Gasket	27-74830	1
18-2848	QuadraJet Base Gasket	27-52457-2	1
18-3878	Head Gasket	27-13709T	1
18-7121	O-Ring	25-35027	1
18-0874	Distributor Gasket	27-34486	1
18-0185	Seal	27-91892	1
18-2555	Thermostat Gasket	27-89656-1	1
18-0889	Fuel Pump Mounting Gasket	27-34213	1
18-4366	Oil Pan Gasket Set	27-72479A5	1
18-0387	Flywheel Cover Gasket	27-94976	1
18-0172	Oil Seal	26-97530	2

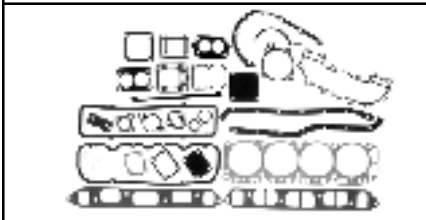


18-4381
AP# 1072
Replaces: Mercruiser 27-43186A1
For: 224 (3.7L) CID Eng; 165, 170, 180, 190 HP
S/N 6916779 & UP

— CONTAINS —			
Sierra #	Description	O.E. #	Qty.
18-0864	Seal	26-90925	1
18-0992	Exhaust Manifold Mounting Gasket	27-68715	1
18-0158	Intake Manifold Gasket	27-70905	1
18-0950	Impeller Cover Gasket	27-88046	1
18-0954	Exhaust Mounting Gasket	27-92720	1
18-0113	Exhaust Elbow Mounting Gasket	27-97542	1
18-2832	Manifold End Cap Gasket	27-48043-1	2
18-2833	Exhaust Elbow To Manifold Gasket	27-99777-2	2
18-2843	Thermostat Cover Gasket	27-74830	1
18-3878	Head Gasket	27-13709T	1
18-0175	O-Ring	25-26543	4
18-0889	Fuel Pump Mounting Gasket	27-34213	1
18-7121	O-Ring	25-35029	1
18-0874	Distributor Gasket	27-34486-3	1
18-0928	Manifold End Cap Gasket	27-73814	1
18-0994	Carb. Mounting Gasket	27-70143-1	1
18-2555	Thermostat Cover Gasket	27-89656-1	1
18-4366	Oil Pan Gasket Set	27-72479A5	1
18-0387	Flywheel Cover Gasket	27-94976	1



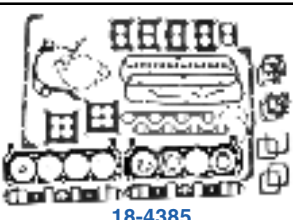
18-4382
AP# 1065
Replaces: Mercruiser 27-74830A3
For: 224 (3.7L) CID Eng; 470 S/N 4208730 & UP



18-4383
AP# 735
For: GM 153 (2.5L) CID Eng; S/N 2324347 & UP

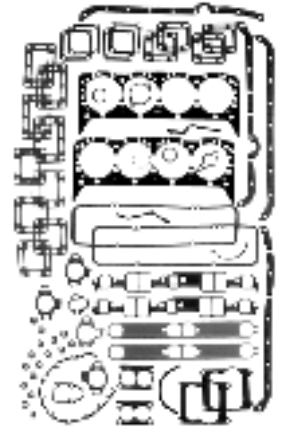


18-4384
AP# 745
For: GM 181 (3.0L) CID Eng; S/N 2508261 & UP
(Except 3.0LX)

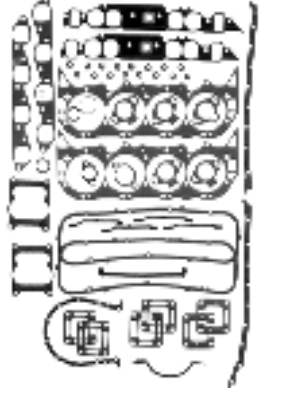


18-4385
AP# 550
For: Ford 302 (5.0L) CID Eng; 215, 225 & 888 (188 HP)
Includes 18-3883/AP# 540 Head Gasket

— CONTAINS —			
Sierra #	Description	O.E. #	Qty.
18-0976	Timing Chain Cover Gasket	27-14250	1
18-0868	Intake Manifold Gasket	27-17145	1
18-0872	Exhaust Manifold Gasket	27-33395	2
18-0897	Exhaust Elbow Mounting Gasket	27-41813	2
18-0885	Exhaust Elbow Mounting Gasket	27-48042	4
18-2917	Lower Thermostat Housing Gasket	27-53045-1	1
18-0153	Port Dip Gasket	27-85817A1	1
18-2848	Quadrajet Base Gasket	27-58457-2	2
18-2849	Exhaust Elbow To Manifold Gasket	27-87105-1, 27-818832	4
18-3876	Head Gasket	27-75611	2
18-2551	Thermostat Gasket	27-90556	2
18-2554	Thermostat Gasket	27-41812	1
18-2832	Manifold End Cap Gasket	27-48043-1	4
18-2553	Thermostat Gasket	27-47510	1
18-2833	Exhaust Elbow To Manifold Gasket	27-99777-2	4
18-2844	Thermostat Cover Gasket	27-48818-1	1
18-0889	Fuel Pump Housing Gasket	27-34213	1
18-0891	Water Pump Mounting Gasket	27-34897	1
18-0905	Oil Pan Drain Plug Gasket	27-49955	1
18-0876	Water Pump Mounting Gsk	27-34898	1
18-0994	Carb. Mtouting Gasket	27-70143-1	2
18-0518	Seal	26-34217	16
18-2845	Valve Cover Gasket	121-122	2



18-4386
For: GM 305 & 350 (5.0L & 5.7L) CID Eng;
With Heads (1987 & Earlier)



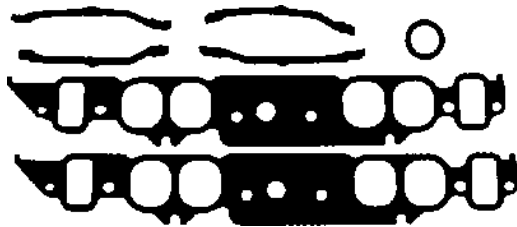
18-4387
AP# 538
Replaces: Mercruiser 27-801853
For: GM 454 (7.4L) CID Eng; Production Models
Oval Port
Includes 18-3877/AP# 533 Head Gasket

SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANTS

INTERNAL ENGINE COMPONENTS

Gasket Sets

CYLINDER HEAD AND INTAKE MANIFOLD GASKET SETS



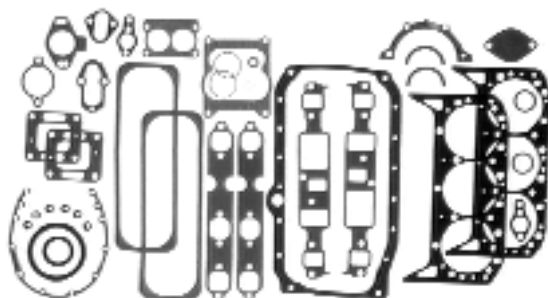
18-0465
AP# 535

Replaces: Mercruiser 27-65184
OMC 352670, 14024393
Crusader 31134
For: GM 454 CID Engines, 325, 330, 340, 350 HP
and 454 Magnums, 7.4L



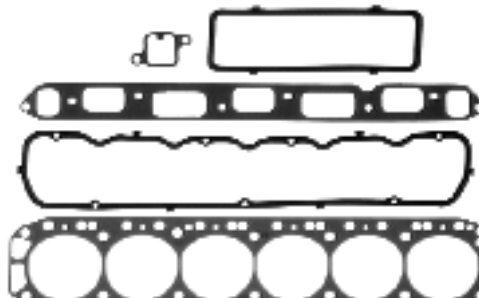
18-4365

Replaces: Mercruiser 27-801855
For: GM 454 (7.4L) CID Eng; Production Models
Rectangular Port
Includes 18-3877/AP# 533 Head Gasket



18-4388
AP# 1500

Replaces: Mercruiser 27-11977A88, A92
For: GM 262 CID Eng; 175, 185 & 205 HP, 4.3L
Includes 18-3879 Head Gasket



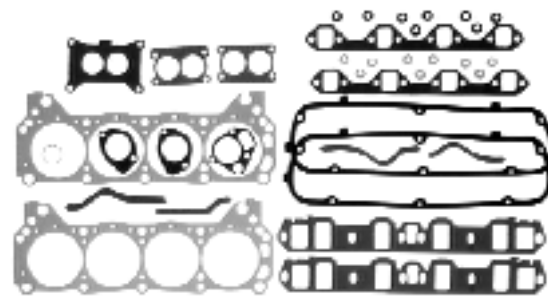
18-4389

Replaces: Mercruiser 27-47453A1
For: All GM 165 HP (S/N 270032 & UP) & Inline 6 cyl.
250 CID



18-4390

Replaces: Mercruiser 27-56110A1
For: Ford 302 CID Eng; 215, 225 HP, 888 (188 HP), 5.0L
S/N 4615129 & BELOW
Includes 18-3883/AP# 540 Head Gasket

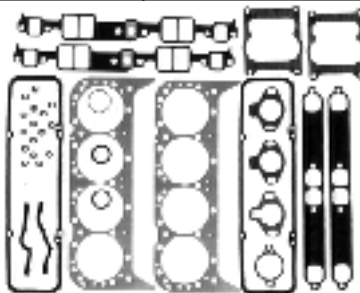


18-4391

Replaces: Mercruiser 27-64763A2
For: Ford 351 CID Eng; 233 HP S/N 4173000-4500860, 5.8L
Includes 18-3883/AP# 540 Head Gasket

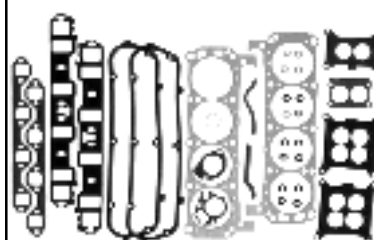
— CONTAINS —

Sierra#	Description	O.E.#	Qty.
18-0868	Intake Manifold Gasket	27-17145	1
18-0872	Exhaust Manifold Gasket	27-33395	2
18-2848	Quadrajet Base	27-52457-2	2
18-3876	Head Gasket	27-75611	2
18-2553	Thermostat Gasket	27-47510	1
18-2844	Thermostat Cover Gasket	27-48818-1	1
18-2554	Thermostat Gasket	27-41812	2
18-2917	Lower Thermostat Housing Gasket	27-53045-1	1
18-2845	Valve Cover Gasket	27-11999	2
18-0518	Seal	26-34217	16



18-4392
AP# 1040

Replaces: Mercruiser 27-75611A2
For: GM 305 & 350 CID Eng, 898 (198 HP) 200, 228,
230/260 (Inboard) 230, 250, 255, 260, 280 & 5.7L Ski



18-4393

Replaces: Mercruiser 27-75647A1
For: Ford 302 CID Eng; 888 5.0L (188 HP)
S/N 4615130 & UP
Includes 18-3883/AP# 540 Head Gasket, 5.0L

SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANTS

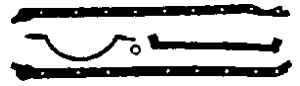
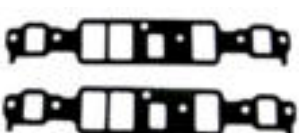
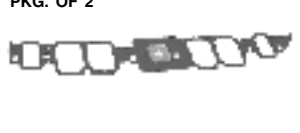
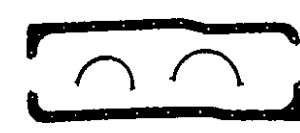
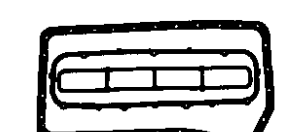
INT. ENG.

INTERNAL ENGINE COMPONENTS

Gasket Sets



INT. ENG.

MISCELLANEOUS GASKET SETS																							
 18-0153 AP# 1087 PORT DIP Replaces: Mercruiser 27-85817A1 OMC 3931599, 458625, 357159 For: GM 350 CID (5.7L)	 18-0340 AP# 521 OIL PAN GASKET SET Replaces: Mercruiser 27-49949 OMC 3930962, 3923440, 3929973 For: 160/165 (6 cyl.)	 18-1235 AP# 13040 OIL PAN For: Old style right hand dipstick SB Chevy	 18-1239 OIL PAN Replaces: Mercruiser 27-810846T Volvo 3853343 OMC 914820 For: 3.0LX (1990 & UP)																				
 18-1206 SHORT BLOCK GASKET For: 3.0 with 1 piece rear main seal	 18-0348 AP# 733 OIL PAN Replaces: Mercruiser 27-52550 OMC 3931593, 3909800, 3955115 Crusader 22048 For: GM 454/502 CID Eng; (7.4L and 8.2L)	 18-1237 AP # 1626 OIL PAN Replaces: Mercruiser 27-13865-1 Volvo 3856138 OMC 3856138 Crusader 7090380 For: Late model right hand small block Chevy	 18-0466 AP# 749 OIL PAN GASKET SET Replaces: Mercruiser 27-14901A1 OMC 3930961, 3923440, 3921473 For: GM 153/181 (2.5L & 3.0L)																				
 18-1238 AP# 1470 INTAKE GASKET SET Replaces: Mercruiser 27-11977 For: 4.3L Chevrolet	PKG. OF 2  18-1231 AP# 2527 INTAKE Replaces: Mercruiser 27-818188-1 OMC 3854095 For: Rectangular port high performance big block Chevy	 18-0405 AP# 1627 OIL PAN Replaces: Mercruiser 27-14247-1 Volvo 3852655 OMC 912955, 3852655 Crusader 7090190 For: GM 262 CID Eng. (4.3L)	 18-0407 AP# 734 OIL PAN Replaces: Mercruiser 27-64798 OMC C9JE-6722-A D30E-6722-AA C20E-6710-B, C20E-6711-B For: Ford 302 CID Models Mercruiser: 215, 225, 888																				
 18-0410 INTAKE MANIFOLD SET Replaces: Mercruiser 27-75648 Volvo 3853912, 3853913 OMC 988162/3854406 For: Ford 351 CID Eng; (233 HP) S/N 4500861 & UP, 5.0L/302	 18-0411 AP# 738 OIL PAN Replaces: Mercruiser 27-90458A1 OMC 14079398, 458625 357159 For: GM 350 CID (5.7L) Starboard Dipstick	 18-0611 AP# 1121 OIL PAN Replaces: Mercruiser 27-75483 For: Ford 351 CID Eng., (5.8L)	 18-1232 OIL PAN Replaces: Mercruiser 27-811566 OMC 3853510 Crusader 7090000 For: 454 & 502 CID Eng.																				
 18-0868 AP# 527 INTAKE MANIFOLD SET Replaces: Mercruiser 27-17145 Volvo 3854269 OMC 985630 Crusader 21005, 7151000 For: 305, 350	 18-4366 AP# 1528 OIL PAN GASKET SET Replaces: Mercruiser 27-72479A5 For: 224 CID (3.7L)	18-4375 AP# 747 Replaces: Mercruiser 27-34213A2 For: GM 153 & 181 CID Engs; 110, 120, 130, 140, 150, 160 & 165 HP; 2.5L & 3.0L — CONTAINS — <table> <thead> <tr> <th>Sierra#</th><th>Description</th><th>O.E. #</th><th>Qty.</th></tr> </thead> <tbody> <tr> <td>18-0889</td><td>Fuel Pump Mounting Gasket</td><td>27-34213</td><td>1</td></tr> <tr> <td>18-0887</td><td>Timing Cover Gasket</td><td>27-49953</td><td>1</td></tr> <tr> <td>18-0948</td><td>Distributor Gasket</td><td>27-87707</td><td>1</td></tr> <tr> <td>18-0327</td><td>Water Pump Gasket</td><td>27-33956</td><td>1</td></tr> </tbody> </table>	Sierra#	Description	O.E. #	Qty.	18-0889	Fuel Pump Mounting Gasket	27-34213	1	18-0887	Timing Cover Gasket	27-49953	1	18-0948	Distributor Gasket	27-87707	1	18-0327	Water Pump Gasket	27-33956	1	
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18-0327	Water Pump Gasket	27-33956	1																				

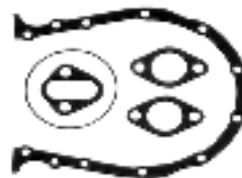
SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANTS

MISCELLANEOUS GASKET SETS (Cont.)



18-4377
AP# 1037

Replaces: Mercruiser 27-42457A1
For: GM 262 CID Eng; 175, 185 & 205 HP



18-4378
AP# 1071

Replaces: Mercruiser 27-54529A1
For: GM 454 CID Eng. 325, 330, 340 & 350 Inboards & 300TRS

— CONTAINS —

Sierra#	Description	O.E. #	Qty.
18-0889	Fuel Pump Mounting Gasket	27-34213	1
18-0903	Water Pump Gasket	27-49110	2
18-0980	Timing Chain Gasket	27-54529	1



18-4379
AP# 1070

Replaces: Mercruiser 27-56108A1
For: Ford 302 & 351 CID Engs. 215 (Inboard), 233 & 255 HP, 888 (188 HP)

— CONTAINS —

Sierra#	Description	O.E. #	Qty.
18-0898	Oil Pump Mtg. Gasket	27-56859	1
18-0889	Fuel Pump Mounting Gasket	27-34213	1
18-0147	Water Pump Gasket	27-56880	1
18-0125	Timing Chain Gasket	27-56108	1



18-4380
AP# 1450

Replaces: Mercruiser 27-68714A6
For: Mercruiser 224 CID Eng.
165, 170, 180, 190, 470, 485 & 488 HP

PKG. OF 2



18-0876
AP# 531
FUEL PUMP
MOUNTING

For GM 4.3L, 5.0L & 5.7L
Replaces: Mercruiser 27-34898
Volvo & OMC 3852113

PKG. OF 2



18-0889
AP# 348
FUEL PUMP
MOUNTING

For GM 4.3L, 5.0L & 5.7L
Replaces: Mercruiser 27-34213
Volvo 3852095-3

PKG. OF 2



18-0874
AP# 350
DISTRIBUTOR

For GM V6 & V8
Replaces: Mercruiser 27-34486-3
Volvo & OMC 3852109



18-2735
DIVIDER PLATE

Replaces: Mercruiser 27-19050-6
For: 140 Jet, 115-200HP (2.5L), XR-6



18-2713
DRIVESHAFT HOUSING
Replaces: Mercruiser 27-43337-4
For: 15-25 2 cyl



18-0317
EXHAUST
Replaces: Mercruiser 27-812866
For: 40-45 Jet, 50-60HP 3 cyl



18-2714
EXHAUST COVER
Replaces: Mercruiser 27-41499-5
For: 15-25 HP



18-2716
EXHAUST COVER
Replaces: Mercruiser 27-41499-1
For: 18XD, 20XD (2 cyl), 25XD

SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANTS

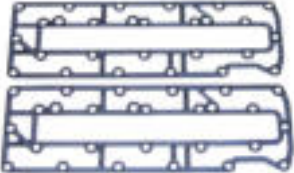
INT. ENG.

INTERNAL ENGINE COMPONENTS

Gasket Sets

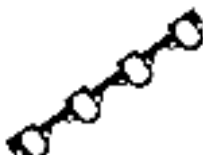
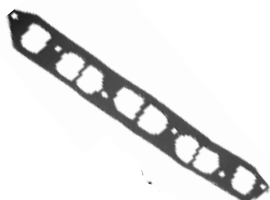
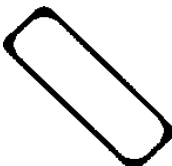


INT. ENG.

NEW  18-2741 EXHAUST COVER Replaces: Mercruiser 27-43004-7 For: 65 Jet, 75HP 3 cyl, 90HP 3 cyl	NEW  18-2717 EXHAUST MANIFOLD Replaces: Mercruiser 27-41475-8 For: 15-25HP 2 cyl	NEW  18-0319 EXHAUST PLATE Replaces: Mercruiser 27-828553 For: 30-60HP 2 cyl and 3 cyl
NEW  18-2610 EXHAUST PLATE Replaces: Mercruiser 27-812775-5 For: 81 Jet, 100HP, 115HP, and 125HP 4 cyl outboards	NEW  18-2738 EXHAUST PLATE Replaces: Mercruiser 27-832934-4 For: 250XS (3.0L DFI), 300X (3.0L EFI) Pro Max	NEW  18-2739 EXHAUST PLATE Replaces: Mercruiser 27-832933-5 For: 250XS (3.0L) DFI
NEW  18-2718 IDLE RELIEF COVER Replaces: Mercruiser 27-14621 For: 15-25 HP 2 cyl	NEW  18-2719 INDUCTION MANIFOLD Replaces: Mercruiser 27-812869 For: 30-60HP 3 cyl, 40-45 Jet	NEW  18-2942 INDUCTION MANIFOLD Replaces: Mercruiser 27-13461-2 For: 80 Jet, 100HP, 115HP, and 125HP 4 cyl outboards
NEW  18-2611 INNER EXHAUST PLATE Replaces: Mercruiser 27-812775-4 For: 80 Jet, 100HP, 115HP, and 125HP 4 cyl outboards	 18-0158 INTAKE MANIFOLD Replaces: Mercruiser 27-70905 For: 3.7L	PKG. OF 2  18-0160 AP# 390 LOWER EXHAUST TO INTAKE MANIFOLD Replaces: Mercruiser 27-94136
 18-0183 AP# 329 EXHAUST MANIFOLD MOUNTING Replaces: Mercruiser 27-73866 Volvo 3853742, 3852455 OMC 908717	 18-0680 AP# 2389 EXHAUST MANIFOLD MOUNTING Replaces: Mercruiser 27-815528 Volvo 3853256-0 OMC 385-3256	 18-0332 INTAKE MANIFOLD Replaces: Mercruiser 27-35898T 110 HP (S/N 1537370-2044033) 120 HP (S/N 1666601-6229717)

INTERNAL ENGINE COMPONENTS

Gaskets

 18-0418 AP# 740 MANIFOLD TO CYLINDER HEAD Replaces: Mercruiser 27-46820 OMC 909613 GM 3852472, Barr CHVA-47-0000	 18-0872 EXHAUST MANIFOLD Replaces: Mercruiser 27-33395 GM 5.0L & 5.7L	 18-0992 EXHAUST MANIFOLD MOUNTING Replaces: Mercruiser 27-68715 OMC 912405	 18-1203 AP# 325 MANIFOLD TO CYLINDER HEAD Replaces: Mercruiser 27-53354 OMC 908079																											
 18-1204 MANIFOLD TO CYLINDER HEAD Replaces: Mercruiser 27-96429 OMC 912164	 18-2830 AP# 332 EXHAUST MANIFOLD TO CYLINDER HEAD 6 in line Replaces: Mercruiser 27-46401 OMC 907932	 18-2896 AP# 324 EXHAUST MANIFOLD MOUNTING Replaces: Mercruiser 27-52546 OMC 311068	 18-2909 AP# 417 EXHAUST MANIFOLD TO CYLINDER HEAD GM V-6 Replaces: Mercruiser 27-99757 Volvo 856116-9 OMC 915025																											
 18-0468 AP# 2536 TIMING COVER GM 4.3L, 5.0L & 5.7L Replaces: Mercruiser 27-811572 Volvo 3852654, 38535-12-6 Crusader 7130240 OMC 3853512	 18-0311 AP# 1471 262 CID VALVE COVER Replaces: Mercruiser 27-11988 Volvo & OMC 3854942 For: 4.3 Litre	 18-0346 AP# 1125 VALVE COVER Replaces: Mercruiser 27-49936 OMC 3930912 For: GM 250 CID (4.1L), 160/165/200 (6cyl.)	 18-0347 AP# 357 VALVE COVER Replaces: Mercruiser 27-52145 Volvo & OMC 3852693 For: GM 153 & 181 CID (2.5L & 3.0L)																											
 18-0464 AP# 532 VALVE COVER Replaces: Mercruiser 27-49121 OMC 912768 For: GM 454/502 CID (7.4L & 8.2L) <table><thead><tr><th>Model</th><th>Year</th><th>S/N</th></tr></thead><tbody><tr><td>330</td><td>1977-81</td><td>4623115-6083144</td></tr><tr><td>7.4 Bravo</td><td>1988-91</td><td>B771113-D603117</td></tr><tr><td>454 Mag</td><td>1986-92</td><td>A631894-D805068</td></tr><tr><td>370 TRS</td><td>1978-87</td><td>4179554-B714586</td></tr><tr><td>400 TRS</td><td>1980-86</td><td>4179554-B457644</td></tr><tr><td>400 TRS</td><td>1983-86</td><td>4179554-B485220</td></tr><tr><td>460 TRS</td><td>1983-86</td><td>4179554-6181046</td></tr><tr><td>502 Mag Bravo</td><td>1990-92</td><td>C878221-D824588</td></tr></tbody></table>		Model	Year	S/N	330	1977-81	4623115-6083144	7.4 Bravo	1988-91	B771113-D603117	454 Mag	1986-92	A631894-D805068	370 TRS	1978-87	4179554-B714586	400 TRS	1980-86	4179554-B457644	400 TRS	1983-86	4179554-B485220	460 TRS	1983-86	4179554-6181046	502 Mag Bravo	1990-92	C878221-D824588	 18-0352 AP# 541 VALVE COVER Replaces: Mercruiser 27-56173 Volvo 3852818 OMC 913758 For: Ford 302/351 CID (5.0L & 5.8L)	
Model	Year	S/N																												
330	1977-81	4623115-6083144																												
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SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANT

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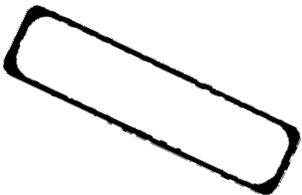
INT. ENG.

INTERNAL ENGINE COMPONENTS

Gaskets



INT. ENG.

 18-0664 AP# 1219 VALVE COVER Replaces: Mercruiser 27-17467 OMC 913270 OMC & Volvo 3852687 Crusader 7231330 For: GM305/350, 5.0 & 5.7L	 18-2845 AP# 1611 VALVE COVER V-8 GM 305/350 CID, 5.0 & 5.7L Replaces: Mercruiser 27-11999 OMC 912965	 18-0328 AP# 347 PUSH ROD COVER 153 & 181 CID, 120/140 (4 cyl.) with Cast Lifter Cover Replaces: Mercruiser 27-34208
 18-0329 AP# 1124 PUSH ROD COVER Replaces: Mercruiser 27-34209 For: 140/150/160/165 (6 cyl.)	 18-2815 AP# 2390 PUSH ROD COVER Replaces: Mercruiser 27-814703 Volvo & OMC 3852692 OMC 913276 For: 3.0L	 18-0147 WATER PUMP For Ford V-8 Replaces: Mercruiser 27-56880 Volvo & OMC 3852824
 18-0327 AP# 346 4 & 6 CYL. WATER PUMP Replaces: Mercruiser 27-33956 Volvo & OMC 3853342	 18-0891 AP# 352 WATER PUMP MOUNTING For GM 4.3L, 5.0L & 5.8L Replaces: Mercruiser 27-34897 Volvo & OMC 3852477	 18-0893 WATER PUMP GM 4.3L, 5.0L & 5.7L Replaces: Mercruiser 27-35380 Volvo & OMC 3850595

INTERNAL ENGINE COMPONENTS

Gaskets

 18-0891 AP# 352 WATER PUMP MOUNTING For GM 4.3L, 5.0L & 5.8L Replaces: Mercruiser 27-34897 Volvo & OMC 3852477	 18-0893 WATER PUMP GM 4.3L, 5.0L & 5.7L Replaces: Mercruiser 27-35380 Volvo & OMC 3850595	 18-0903 AP# 536 WATER PUMP 454 CID Replaces: Mercruiser 27-49110 OMC 3853361
 18-0950 AP# 386 IMPELLER COVER 224 CID Replaces: Mercruiser 27-88046	 18-0887 AP# 355 TIMING COVER 4 & 6 CYL. Replaces: Mercruiser 27-49953 OMC & Volvo 3852691	 18-0976 AP# 1129 TIMING CHAIN COVER Replaces: Mercruiser 27-14250
 18-0980 AP# 537 TIMING COVER GM 7.4L Replaces: Mercruiser 27-54529 OMC 3935449 Crusader 30240	 18-0864 AP# 1285 REAR CRANKSHAFT SEAL 3.7L Replaces: Mercruiser 26-90925	
 18-0322 AP# 1474 OIL PAN GM 5.0L & 5.7L Replaces: Mercruiser 27-14247 Volvo & OMC 3852656	 18-0898 OIL PUMP MOUNTING Replaces: Mercruiser 27-56859 OMC C20Z-6659-C For: Ford Engines	

SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANT

SEE PAGES 101-102 FOR OUR COMPLETE LINE OF GASKET SEALANT