

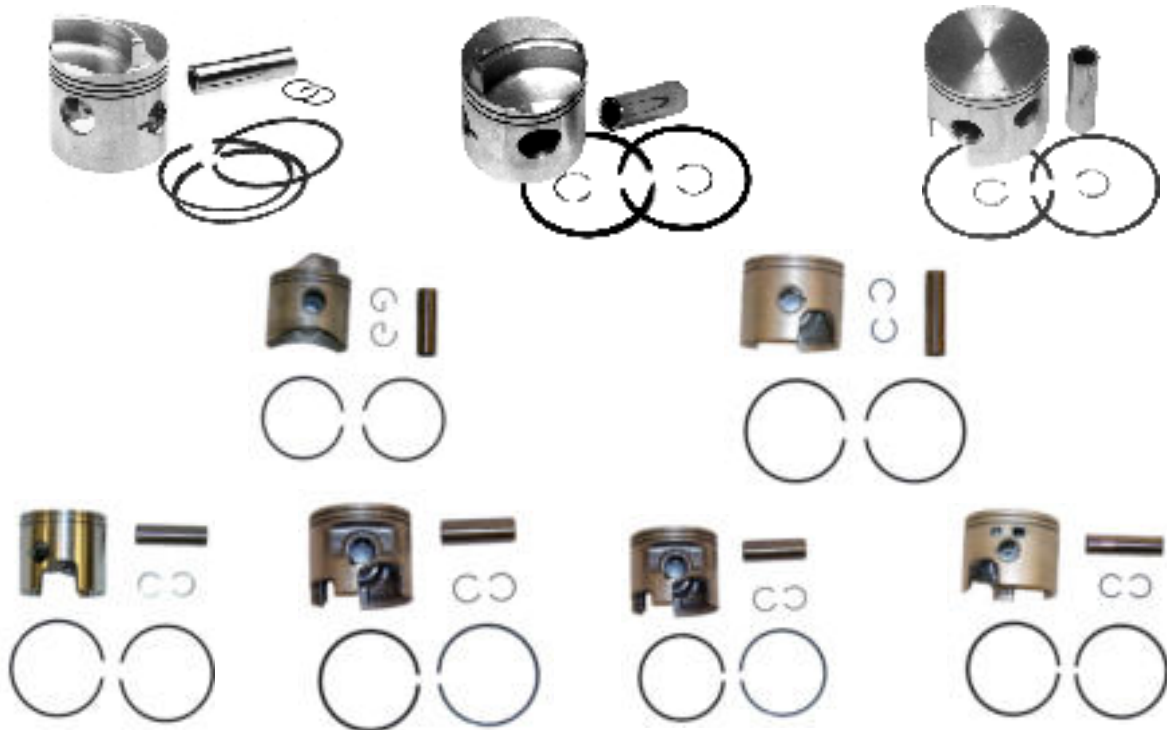


Features...

- ★ Exact replacement, high silicon content aluminum alloy with the same content and weight. Eliminates the need to replace all pistons unnecessarily. Replace only the piston(s) required for the repair.
- ★ Piston rings, bearings, wrist pins and circlips are all interchangeable with the OEM components. Makes repairs simpler, faster, and more economical.
- ★ Sierra pistons do not require additional piston to cylinder wall clearance like competitor's forged units. This allows Sierra pistons to use standard break-in and warm-up procedures, not long and complicated procedures like the competition.
- ★ No one warranties internal engine parts better than Sierra! That's because we're confident in our quality. Compare our quality, coverage and warranty to anyone and you will see why Sierra is the obvious choice for your next repair.

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

OUTBOARD



MERCURY/MARINER

Internal Engine System



SIERRA PISTON KIT CONTENTS — JAPANESE MODELS

(See Application Charts for Specific Applications)

Model / HP	Cyl.	Bore size	Piston	OEM Part #	Piston Ring	OEM Part #	Wrist Pins (included but not sold separately)	Circlips
9.9 / 15	2	std	18-4135	761-7982M, 761-7982T	18-3976	39-15230M	n.s.s	n.s.s
9.9 / 15	2	.25 mm OS	18-4136	761-8022M, 761-8022T	18-3977	39-18939M	n.s.s	n.s.s
9.9 / 15	2	.50 mm OS	18-4137	761-8023M, 761-8023T	18-3978	39-15322M	n.s.s	n.s.s
48	2	std	18-4138	761-8484M	—	—	n.s.s	n.s.s
48	2	.25 mm OS	18-4139	761-8485M, 761-8485T	—	—	n.s.s	n.s.s
48	2	.50 mm OS	18-4140	761-8486M, 761-8486T	—	—	n.s.s	n.s.s

MARINER PISTON RINGS — JAPANESE MODELS

STANDARD		.25mm O.S.		.50mm O.S.	
Part #	O.E. #	Part #	O.E. #	Part #	O.E. #
18-3954	39-14253M, 39-14235T	18-3977	39-18939M, 39-18939T	18-3978	39-15322M
18-3976	39-15320M	18-3986	39-81096M	18-3987	39-81097M, 39-81097T
18-3985	39-81095M, 39-81095T	18-3989	39-81261M	18-3990	39-81262M
18-3988	39-81260M	18-3992	39-83196M	18-3993	39-83197M
18-3991	39-83195M, 39-83195T	18-3995	39-92626M, 39-92626T	18-3996	39-92627M, 39-92627T
18-3994	39-92625M, 39-92625T				

MARINER PISTON AND RINGS APPLICATION — JAPANESE MODELS

Model	Ser# Code	Ser#	Standard Piston	.25mm Piston	.50mm Piston	Standard Rings	.25mm Rings	.50mm Rings	Qty. Req'd
9.9	682	ALL	18-4135	18-4136	18-4137	18-3976	18-3977	18-3978	2
15C	684	ALL	18-4135	18-4136	18-4137	18-3976	18-3977	18-3978	2
20C,25A	6A9	ALL	—	—	—	18-3985	18-3986	18-3987	2
25C	695	ALL	—	—	—	18-3985	18-3986	18-3987	2
28	664	ALL	—	—	—	18-3985	18-3986	18-3987	2
30A	689	ALL	18-4138	18-4139	18-4140	—	—	—	2
48	670	S-02440 & Below / L33131 & Below	—	—	—	18-3988	18-3989	18-3990	2
55 M, ML	663	ALL	—	—	—	18-3988	18-3989	18-3990	2
48	670	S-02441 & Up / L-33132 & Up	—	—	—	18-3991	18-3992	18-3993	2
W48	670	M 002731 & Up / ML 314101 & Up	—	—	—	18-3991	18-3992	18-3993	2
60	675	E 00101-001170 / EL 30101-304180	—	—	—	18-3991	18-3992	18-3993	2
W48	670	M 002730 & Below / ML 314100 & Below	—	—	—	18-3994	18-3995	18-3996	2
W48	670	M 007191 & UP / ML 334241 & UP	—	—	—	18-3994	18-3995	18-3996	2
55	663	E 004041 & UP / EL 315379 & UP	—	—	—	18-3994	18-3995	18-3996	2
W55	663	ML 578278 Up	—	—	—	18-3994	18-3995	18-3996	2
60 2 CYL	675	E 001171 Up / EL 304181 & Up	—	—	—	18-3994	18-3995	18-3996	2

Mariner (Japanese Models)

Sierra Piston Kit Contents (See Application Charts for Specific Applications)

Model / HP	Cyl.	Bore Size	Piston	OEM Part #	Piston Ring	OEM Part #	Wrist Pin (included but not sold separately)	Circlips
9.9 / 15	2	Std.	18-4135	761-7982M	18-3976	39-15230M	N.S.S.	N.S.S.
9.9 / 15	2	.25 mm OS	18-4136	761-8022M	18-3977	39-18939M	N.S.S.	N.S.S.
9.9 / 15	2	.50 mm OS	18-4137	761-8023M	18-3978	39-15322M	N.S.S.	N.S.S.
48	2	Std.	18-4138	761-8484M	18-3954	39-14235M	N.S.S.	N.S.S.
48	2	.25 mm OS	18-4139	761-8485M	18-3955	39-84747M	N.S.S.	N.S.S.
48	2	.50 mm OS	18-4140	761-8486M	18-3956	39-14236M	N.S.S.	N.S.S.

Mercury / Mariner

Sierra Piston Kit Contents (See Application Charts for Specific Applications)

Model / HP	Cyl.	Bore size	Piston	OEM Part #	Piston Ring	OEM Part #	Wrist Pin	Circlips	OEM Part #
2 Ring Pistons - High Dome									
35-140	2-6	2.875 / Std.	18-4505	774-9137A12	18-3918	39-817096A6	N.S.S.	18-4294	40-52035
35-140	2-6	2.890 / .015	18-4520	774-9137A13	18-3919	39-817096A16	N.S.S.	18-4294	40-52035
35-140	2-6	2.905 / .030	18-4535	774-9137A14	18-3920	39-817096A26	N.S.S.	18-4294	40-52035
2 Ring Pistons - Low Dome									
35-140	2-6	2.875 / Std.	18-4500	774-9137A9	18-3918	39-817096A6	N.S.S.	18-4294	40-52035
35-140	2-6	2.890 / .015	—	—	18-3919	39-817096A16	N.S.S.	18-4294	40-52035
35-140	2-6	2.905 / .030	18-4530	—	18-3920	39-817096A26	N.S.S.	18-4294	40-52035
3 Ring Pistons - High Dome									
35-140	2-6	2.875 / Std.	18-4505	776-8896A3	18-3902	39-78816A12	N.S.S.	18-4294	40-52035
35-140	2-6	2.890 / .015	18-4152	776-8897A2	18-3916	39-78811A12	N.S.S.	18-4294	40-52035
35-140	2-6	2.905 / .030	18-4535	776-8898A2	18-3917	39-88392A12	N.S.S.	18-4294	40-52035

APPLICATION CONTINUED ON NEXT PAGE

OUTBOARD



MERCURY/MARINER

Internal Engine System

Model / HP	Cyl.	Bore size	Piston	OEM Part #	Piston Ring	OEM Part #	Wrist Pin	Circlips	OEM Part #
3 Ring Pistons - Low Dome									
35-140	2-6	2.875 / Std.	18-4500	776-8600A9	18-3902	39-78816A12	N.S.S.	18-4294	40-52035
35-140	2-6	2.890 / .015	18-4530	776-9095A1	18-3916	39-78811A12	N.S.S.	18-4294	40-52035
35-140	2-6	2.905 / .030	18-4515	776-9096A1	18-3917	39-88392A12	N.S.S.	18-4294	40-52035
2 Ring Pistons - Crossflow									
40-50	4	2.565 / Std.	18-4620	780-9229A7	18-3966	39-18653A12	N.S.S.	18-4294	40-52035
40-50	4	2.580 / .015	18-4621	780-9229A10	18-3967	39-18653A1	N.S.S.	18-4294	40-52035
40-50	4	2.595 / .030	18-4622	780-9229A11	18-3968	39-18653A2	N.S.S.	18-4294	40-52035
50-60	3	2.875 / Std.	18-4016	783-9613A1	18-4019	39-19721A6	N.S.S.	18-4294	40-52035
50-60	3	2.890 / .015	18-4017	783-9613A2	18-4020	39-19721A1	N.S.S.	18-4294	40-52035
50-60	3	2.905 / .030	18-4018	783-9613A3	18-4021	39-19721A2	N.S.S.	18-4294	40-52035
70-115	3-4	3.375 / Std.	18-4623	777-815965T4	18-3979	39-96170A12	N.S.S.	18-4294	40-52035
70-115	3-4	3.390 / .015	18-4624	777-815965A5	18-3980	39-96170A3	N.S.S.	18-4294	40-52035
70-115	3-4	3.405 / .030	18-4625	777-815965A6	18-3981	39-96170A4	N.S.S.	18-4294	40-52035
75-125	3-4	3.375 / Std.	18-4626	2704-826191T4	18-3982	39-822321A12	N.S.S.	18-4294	40-52035
75-125	3-4	3.390 / .015	18-4627	2704-821896A3	18-3983	39-822321A1	N.S.S.	18-4294	40-52035
75-125	3-4	3.405 / .030	18-4628	2704-821896A4	18-3984	39-822321A2	N.S.S.	18-4294	40-52035

Sierra V-6 Piston Kit Contents (See Application Charts for Specific Applications)

Model / HP	Cyl.	Bore size	Piston	OEM Part #	Piston Ring	OEM Part #	Wrist Pin	Circlips
135, 150 2 Liter	V-6	3.125 / Std. (port)	18-4010	765-7442T32	18-3921	39-93481A12	18-4287	N.S.S.
135, 150 2 Liter	V-6	3.125 / Std. (stbd)	18-4011	765-7441T32	18-3921	39-93481A12	18-4287	N.S.S.
135, 150 2 Liter	V-6	3.140 / .015 (port)	18-4012	765-7444A11	18-3922	39-78918A4	18-4287	N.S.S.
135, 150 2 Liter	V-6	3.140 / .015 (stbd)	18-4013	765-7443A11	18-3922	39-78918A4	18-4287	N.S.S.
135, 150 2 Liter	V-6	3.155 / .030 (port)	18-4014	765-7446A11	18-3923	39-85636A4	18-4287	N.S.S.
135, 150 2 Liter	V-6	3.155 / .030 (stbd)	18-4015	765-7445T11	18-3923	39-85636A4	18-4287	N.S.S.
135-175	V-6	3.125 / Std. (port)	18-4510	765-7442A3, A36	18-3921	39-93481A12	18-4287	N.S.S.
135-175	V-6	3.125 / Std. (stbd)	18-4545	765-7441A3, A36	18-3921	39-93481A12	18-4287	N.S.S.
135-175	V-6	3.140 / .015 (port)	18-4525	765-7442A2, A12	18-3922	39-78918A4	18-4287	N.S.S.
135-175	V-6	3.140 / .015 (stbd)	18-4560	765-7443A2, A12	18-3922	39-78918A4	18-4287	N.S.S.
135-175	V-6	3.155 / .030 (port)	18-4540	N/A	18-3923	39-85636A4	18-4287	N.S.S.
135-175	V-6	3.155 / .030 (stbd)	18-4575	N/A	18-3923	39-85636A4	18-4287	N.S.S.
175-225	V-6	3.375 / Std. (port)	18-4600	—	18-3927	39-813011A12	18-4287	N.S.S.
175-225	V-6	3.375 / Std. (stbd)	18-4555	—	18-3927	39-813011A12	18-4287	N.S.S.
150 XR4/MAG II	V-6	3.375 / Std. (port)	18-4550	—	18-3924	39-18487A12	18-4287	N.S.S.
150 XR4/MAG II	V-6	3.375 / Std. (stbd)	18-4555	—	18-3924	39-18487A12	18-4287	N.S.S.
150 XR4/MAG II	V-6	3.390 / .015 (port)	18-4565	—	18-3925	39-815267A4	18-4287	N.S.S.
150 XR4/MAG II	V-6	3.390 / .015 (stbd)	—	—	18-3925	39-815267A4	18-4287	N.S.S.
150 XR4/MAG II	V-6	3.405 / .030 (port)	18-4580	N/A	—	N/A	18-4287	N.S.S.
150 XR4/MAG II	V-6	3.405 / .030 (stbd)	18-4585	N/A	—	N/A	18-4287	N.S.S.
140-200, XR6/MAG III	V-6	3.500 / Std. (port)	18-4635	785-9737T9	18-3982	39-822321A12	18-4287	N.S.S.
140-200, XR6/MAG III	V-6	3.500 / Std. (stbd)	18-4636	785-9738T9	18-3982	39-822321A12	18-4287	N.S.S.
140-200, XR6/MAG III	V-6	3.515 / .015 (port)	18-4637	785-9737A10	18-3983	39-822321A1	18-4287	N.S.S.
140-200, XR6/MAG III	V-6	3.515 / .015 (stbd)	18-4638	785-9738T10	18-3983	39-822321A1	18-4287	N.S.S.
225 (3.0L)	V-6	3.6265 / Std. (port)	18-4639	700-858294T1	18-4050	39-827179A12	18-4287	N.S.S.
225 (3.0L)	V-6	3.6265 / Std. (stbd)	18-4640	700-858295T1	18-4050	39-827179A12	18-4287	N.S.S.
225 (3.0L)	V-6	3.6415 / .015 (port)	18-4641	700-878571A2	18-4051	39-826293A12	18-4287	N.S.S.
225 (3.0L)	V-6	3.6415 / .015 (stbd)	18-4642	700-878572A2	18-4051	39-826293A12	18-4287	N.S.S.
225 (3.0L)	V-6	3.6565 / .030 (port)	18-4643	700-878573A2	18-4052	39-826297A12	18-4287	N.S.S.
225 (3.0L)	V-6	3.6565 / .030 (stbd)	18-4644	700-878574A2	18-4052	39-826297A12	18-4287	N.S.S.

- 4 of 18-3900 = 1 of 39-21665A12
 - 4 of 18-3902 = 1 of 39-78816A12
 - 4 of 18-3903 = 1 of 39-27841A12
 - 4 of 18-3916 = 1 of 39-78811A12
 - 4 of 18-3917 = 1 of 39-88392A12
 - 3 of 18-3918 = 1 of 39-817096A6
 - 3 of 18-3919 = 1 of 39-817096A16
 - 3 of 18-3920 = 1 of 39-817096A26
 - 6 of 18-3921 = 1 of 39-93481A12
 - 2 of 18-3922 = 1 of 39-78918A4
 - 2 of 18-3923 = 1 of 39-85636A4
 - 6 of 18-3924 = 1 of 39-18487A12
 - 2 of 18-3925 = 1 of 39-815267A4
 - 4 of 18-3966 = 1 of 39-18653A12
 - 4 of 18-3968 = 1 of 39-18653A2
 - 4 of 18-3967 = 1 of 39-18653A1
 - 3 of 18-4019 = 1 of 39-19721A6
 - 3 of 18-4020 = 1 of 39-19721A1
 - 3 of 18-4021 = 1 of 39-19721A2
 - 3 of 18-3982 = 1 of 39-822321A12
 - 3 of 18-3983 = 1 of 39-822321A1
 - 3 of 18-3984 = 1 of 39-822321A2
 - 6 of 18-4050 = 1 of 39-827179A12
 - 6 of 18-4051 = 1 of 39-826293A12
 - 6 of 18-4052 = 1 of 39-826297A12
 - 6 of 18-3927 = 1 of 39-813011A12
- (for chrome bore blocks)



PISTON SLEEVE

PART NO.	I.D.	O.D.	WALL	LENGTH
18-4710	3.125	3.3125	0.09375	5.520

Straight sleeve with ports cut in 121.9 CID, V-6 models

For: 135HP1986-92, 150HP1979-92, 150XR4HP1985-88, 175HP1978-81

OUTBOARD

APPLICATION CONTINUED ON NEXT PAGE

MERCURY/MARINER

Internal Engine System



3 RING INLINE PISTON AND RINGS APPLICATION

H.P.	Cyl.	Beginning Serial No.	Ending Serial No.	Std. Cyl. Dia. (Bore)	Std. Piston	.015 O.S. Piston	.030 O.S. Piston	Std. Rings	.015 O.S. Rings	.030 O.S. Rings
3.5	1	6202173	& UP	2.000	—	—	—	18-3900	—	—
3.6	1	5404657	& UP	2.000	—	—	—	18-3900	—	—
3.9	1	1655013	2498135	2.000	—	—	—	18-3900	—	—
4 (1CYL)	1	2498136	A809600	2.000	—	—	—	18-3900	—	—
4.5	1	4107220	& UP	2.000	—	—	—	18-3900	—	—
7.5	2	2529895	& UP	2.000	—	—	—	18-3900	—	—
9.8	2	1470349	& UP	2.000	—	—	—	18-3900	—	—
20	2	1922910	5942040	2.562	—	—	—	18-3903	—	—
25	2	1467499	149931	2.562	—	—	—	18-3903	—	—
30 Jet (40 HP)	4	OC159200	& UP	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
30 Jet (40 HP)	4	OC159200	& UP	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
35	2	6445653	& UP	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
40 (4 cyl)	4	1279085	1476509	2.562	—	—	—	18-3903	—	—
40	2	2045260	C159199	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
40, 402	2	3336258	6445652	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
40	4	OC159200	& UP	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
45	4	1476510	& UP	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
45	4	5531630	0B110788	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
45	4	0B110789	& UP	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
45 JET	3	D000750	G589999	2.955	18-4016	18-4017	18-4018	18-4019	18-4020	18-4021
50,500	4	2116318	6428680	2.562	18-4620	18-4621	18-4623	18-3966	18-3967	18-3968
50	3	6428681	B122929	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
50	3	B122930	D000749	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
50	3	D000750	G589999	2.955	18-4016	18-4017	18-4018	18-4019	18-4020	18-4021
55	3	6428681	0B122929	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
55	3	B122930	D000749	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
55	3	D000750	G589999	2.955	18-4016	18-4017	18-4018	18-4019	18-4020	18-4021
60	6	1303411	1542744	2.562	—	—	—	18-3903	—	—
60	3	6428681	B122929	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
60	3	B122930	D000749	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
60	3	D000750	G589999	2.955	18-4016	18-4017	18-4018	18-4019	18-4020	18-4021
65,650	3	3293184	4382056	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
65,650	3	4382057	4571651	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
70	3	4571652	A996141	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
70 (3 cyl.) w/Rod #646-818846	3	A996142	& UP	3.375	18-4623	18-4624	18-4625	18-3979	18-3980	18-3981
75	4	6432901	& UP	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
75 (3 cyl.) w/Rod #646-818846	3	C222000	D283221	3.375	18-4623	18-4624	18-4625	18-3979	18-3980	18-3981
75 (3 cyl.)	3	D283222	& UP	3.500	18-4626	18-4627	18-4628	18-3982	18-3983	18-3984
80,800	4	2559001	3493912	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
80,800	4	4831999	6432900	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
80 Jet	3	D283222	& UP	3.500	18-4626	18-4627	18-4628	18-3982	18-3983	18-3984
85,850	4	3493913	4831998	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
85,850	4	4366802	4831998	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
85 Mar.	4	4731898	4842728	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
90,900	6	4845301	& UP	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
90 (3 cyl.) w/Rod #646-818846	3	A9964142	D283221	3.375	18-4623	18-4624	18-4625	18-3979	18-3980	18-3981
90 (3 cyl.)	3	D283222	& UP	3.500	18-4626	18-4627	18-4628	18-3982	18-3983	18-3984
95	6	1809776	2318585	2.875	—	—	—	18-3918	18-3919	18-3920
100 SS	6	2318586	2836018	2.875	—	—	—	18-3918	18-3919	18-3920
100 BP	6	2396698	3253111	2.875	—	—	—	18-3918	18-3919	18-3920
100 (4 cyl.) w/Rod #646-818846	4	B209468	D283221	3.375	18-4623	18-4624	18-4625	18-3979	18-3980	18-3981
100 (4cyl)	4	D283222	& UP	3.500	18-4626	18-4627	18-4628	18-3982	18-3983	18-3984
115 1150	6	2836019	5829643	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
115 Merc.	6	5829644	B209467	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
115 Mar.	6	5738891	5861526	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
115 Mar.	6	5861527	C100000	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
115 (4 cyl.) w/Rod #646-818846	4	C100000	D283221	3.375	18-4623	18-4624	18-4625	18-3979	18-3980	18-3981
115 (4cyl)	4	D283222	& UP	3.500	18-4626	18-4627	18-4628	18-3982	18-3983	18-3984
125 BP	6	2641955	3253111	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
135	6	2839369	3293233	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
140 1400	6	3293234	3502805	2.875	18-4505	18-4520	18-4535	18-3918	18-3919	18-3920
140 1400	6	4865678	& UP	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920
150 1500	6	3502806	5327622	2.875	18-4500	18-4515	18-4530	18-3918	18-3919	18-3920

APPLICATIONS CONTINUED ON NEXT PAGE

OUTBOARD



MERCURY/MARINER

Internal Engine System

2 RING INLINE PISTON & RINGS APPLICATION

H.P.	Cyl.	Beginning Serial No.	Ending Serial No.	Dia. (Bore)	Pistons						Piston Rings		
					Std. (Port)	Stbd.	.015" O.S.	Stbd.	.030" O.S.	Stbd.	Std.	.015" O.S.	.030" O.S.
105 JET	V-6	D082000	& UP	3.125	18-4010	18-4011	18-4012	18-4013	18-4014	18-4015	18-3921	18-3922	18-3923
V-135	V-6	A904646	C239552	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-135 (w/ rod # 644-8141)	V-6	C239553	G960499	3.125	18-4010	18-4011	18-4012	18-4013	18-4014	18-4015	18-3921	18-3922	18-3923
V-135 (w/o rod # 636-8141)	V-6	C239553	G960499	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-140 JET	V-6	D082000	G960499	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-140 Jet	V-6	G960500	UP	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-150 MAR	V-6	5600162	6038680	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-150 MAR	V-6	6038681	C239552	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-150, 150,1500	V-6	4868998	6042945	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-150	V-6	6042946	C239552	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-150 (w/ rod # 644-8141)	V-6	C239553	G960499	3.125	18-4010	18-4011	18-4012	18-4013	18-4014	18-4015	18-3921	18-3922	18-3923
V-150 (w/o rod # 636-8141)	V-6	C239553	G960499	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-150 EFI XR6 MAGIII	V-6	D082000	G960499	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	—
V-150 XR4 MAGIII	V-6	B242885	C239552	3.375	18-4550	18-4555	18-4565	—	18-4580	—	18-3924	18-3925	—
V-150 XR4 MAGIII	V-6	C239553	D081999	3.375	18-4550	18-4555	18-4565	—	18-4580	—	18-3924	18-3925	—
V-175,175,1750	V-6	4301235	6618750	3.125	18-4510	18-4545	18-4525	18-4560	18-4540	18-4575	18-3921	18-3922	18-3923
V-175	V-6	6618751	C239552	3.375	18-4600	18-4555	—	—	—	—	18-3927	—	—
V-175	V-6	C239553	D081999	3.375	18-4550	18-4555	18-4565	—	18-4580	—	18-3924	18-3925	—
V-175	V-6	D082000	G960499	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-175	V-6	G960500	& UP	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-175 I XRI EFI	V-6	D000750	D081999	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-175 XRI EFI	V-6	D000750	D081999	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-175 XRI EFI	V-6	D082000	G303045	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-175 XRI EFI	V-6	G303046	& UP	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-200, 200,2000	V-6	4839034	6203990	3.375	18-4600	18-4555	—	—	—	—	18-3927	—	—
V-200 (2.4L)	V-6	6203991	C291519	3.375	18-4600	18-4555	—	—	—	—	18-3927	—	—
V-200 (2.5L) w/ rod #644-818141)	V-6	C291520	D081999	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-200 (2.5L)	V-6	D082000	& UP	3.500	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-200 XRI EFI	V-6	C100861	C291519	3.375	18-4600	18-4555	—	—	—	—	18-3927	—	—
V-200 XRI EFI	V-6	C291520	G960499	3.375	18-4635	18-4636	18-4637	18-4638	NA	NA	18-3982	18-3983	18-3984
V-220	V-6	B117316	UP	3.500	18-4600	18-4555	—	—	—	—	18-3927	—	—
V-225	V-6	5628028	D280812	3.375	18-4600	18-4555	—	—	—	—	18-3927	—	—
V-225 (3.0L)	V-6	D280813	UP	3.625	18-4639	18-4640	18-4641	18-4642	18-4643	18-4644	18-4050	18-4051	18-4052

OUTBOARD



Bearings & Bearing Kits






Bearings & Bearing Kits

Contrary to popular belief, all bearings are not alike just because they have the same numbers stamped on them. There are many import bearings on the market today. The quality of the materials used and the tolerances in the manufacturing processes can have a dramatic effect on the life expectancy of the bearings. Sierra supplies only the highest quality bearings available to insure the integrity of your repair.

Features... ★ Only premium quality. ★ Available in convenient kits.

OUTBOARD

 <p>NEEDLE BEARINGS</p> <table border="1"> <thead> <tr> <th>Sierra #</th> <th>AP #</th> <th>Replaces:</th> <th>Description</th> <th>Std. Pkg.</th> </tr> </thead> <tbody> <tr> <td>18-4035</td> <td>13271</td> <td>29-20046T</td> <td>Crank End or Main Bearing</td> <td>200</td> </tr> <tr> <td>18-4036</td> <td>2132</td> <td>29-47270</td> <td>Piston End</td> <td>200</td> </tr> <tr> <td>18-4037</td> <td>2133</td> <td>29-71422</td> <td>Main Bearing</td> <td>200</td> </tr> </tbody> </table>	Sierra #	AP #	Replaces:	Description	Std. Pkg.	18-4035	13271	29-20046T	Crank End or Main Bearing	200	18-4036	2132	29-47270	Piston End	200	18-4037	2133	29-71422	Main Bearing	200	 <p>NEEDLE BEARING SETS</p> <table border="1"> <thead> <tr> <th>Sierra #</th> <th>Replaces:</th> <th>Description</th> </tr> </thead> <tbody> <tr> <td>18-4038</td> <td>31-62596A1</td> <td>Crank End-Without Cage</td> </tr> <tr> <td>18-4039</td> <td>31-17514A2</td> <td>Crank End-Without Cage</td> </tr> </tbody> </table> <p>16 Needles - Must re-use cage</p>	Sierra #	Replaces:	Description	18-4038	31-62596A1	Crank End-Without Cage	18-4039	31-17514A2	Crank End-Without Cage	 <p>18-1352 AP# 2763 CENTER MAIN BEARING Replaces: 31-67445 For: 135-200 HP V-6, S/N A904646-C100861</p>	 <p>NEW 18-1186 NEEDLES, LOOSE WITH RETAINER Replaces: 29-88258 + 12-88263 (2 pieces) For: Merc V-6 200/225/250 HP 3.0 3.4L</p>
Sierra #	AP #	Replaces:	Description	Std. Pkg.																												
18-4035	13271	29-20046T	Crank End or Main Bearing	200																												
18-4036	2132	29-47270	Piston End	200																												
18-4037	2133	29-71422	Main Bearing	200																												
Sierra #	Replaces:	Description																														
18-4038	31-62596A1	Crank End-Without Cage																														
18-4039	31-17514A2	Crank End-Without Cage																														
 <p>NEW 18-1194 ROD BEARING WITH CAGE Replaces: 31-17514A1 For: Mercury Outboards</p>	 <p>18-1362 AP# 2769 SPLITSLEEVE BEARING For: 135-200HP V-6, S/NA904646-C100861</p>	 <p>18-1153 AP# 2122 BALL BEARING Replaces: 30-63326</p>	 <p>18-1154 AP# 1988 BALL BEARING Replaces: 30-63742</p>																													
 <p>18-1345 BALL BEARING Replaces: 30-67923T For: 135-225 HP V-6</p>	 <p>18-1346 BALL BEARING Replaces: 30-43011T For: 75-125 3 & 4 cyl.</p>	 <p>18-1348 BALL BEARING Replaces: 30-64424T For: 50-70 HP 3 cyl.</p>																														
 <p>18-1349 BALL BEARING Replaces: 30-69389 For: 4 HP</p>	 <p>18-1397 BALL BEARING Replaces: 30-41341 For: 6/8/9/15 1986-Up</p>	 <p>18-1398 BALL BEARING Replaces: 30-72961 For: 3.5-9.8 HP & Mercruiser belt driven water pump</p>																														

APPLICATION BEGINS ON NEXT PAGE



MERCURY/MARINER

Internal Engine System

HP	Cyl.	Beg. S/N	End. S/N	Con. Rod Crank End	Con. Rod Piston End	Center Main Bearing	Lower Main Bearing	Upper Main Bearing
25 (KF 9)	4	377150	495761	18-4035 ①	—	18-4035 ④	—	—
10 (MK10)	2	1057994	1122327	18-4035 ①	—	—	—	—
15 (MK15)	2	1200114	1287384	18-4035 ①	—	—	—	—
16 (MK20)	2		ALL	18-4035 ①	—	—	—	—
20 (MK25)	2	860979	& UP	18-4035 ①	—	—	—	—
22 (MK28)	2	1158546	1238089	18-4035 ①	—	—	—	—
30 (MK30)	4		ALL	18-4035 ①	—	18-4035 ④	—	—
35 (MK35)	4	1217222	1271884	18-4035 ①	—	18-4035 ④	—	—
25 (MK40)	4	711400	& UP	18-4035 ①	—	18-4035 ④	—	—
40 (MK50)	4		ALL	18-4035 ①	—	18-4035 ④	—	—
40(MK55)	4	831021	& UP	18-4035 ①	—	18-4035 ④	—	—
45 (MK58)	4	1139538	& UP	18-4035 ①	—	18-4035 ④	—	—
60 (MK75)	6		ALL	18-4035 ①	—	18-4037 ④	—	—
70 (MK78)	6	1143038	& UP	18-4035 ①	—	18-4037 ④	—	—
3.5 / 3.6 / 3.9	1		ALL	—	—	—	18-1398	18-1398
4	1	2498136	A809600	—	—	—	18-1398	18-1398
4	2	5589202	& UP	—	—	—	18-1398	—
4.5	1	4107220	& UP	—	—	—	18-1398	18-1398
6	2	1916139	2529894	—	—	—	18-1398	18-1398
6	2	A197112	& UP	—	—	—	18-1397	—
7.5	2	2529895	& UP	—	—	—	18-1398	18-1398
8	2	A197112	& UP	—	—	—	18-1397	—
9.8	2	1865779	& UP	—	—	—	18-1398	18-1398
9.9	2	A197112	& UP	—	—	—	18-1397	—
10	2	1290910	& UP	18-4035 ①	—	—	—	—
15	2	1288910	1349697	18-4035 ①	—	—	—	—
15	2	B292414	& UP	—	—	—	18-1397	—
20	2	1292910	6443972	18-4035 ①	—	—	18-1153	18-1153
25	2	1467499	1499331	18-4035 ①	—	—	—	—
30	4	1271885	1448139	18-4035 ①	—	18-4035 ④	18-1154	18-1154
30	2	G053314	& UP	18-4039	18-4036	—	18-1154	—
30 (jet)	4	C159200	& UP	18-4035	—	18-4037	18-1154	18-1154
30 (jet)	3	G590000	& UP	—	18-4036	—	18-1154	—
35	4	121722	1448139	18-4035 ①	—	18-4035 ④	18-1154	18-1154
35	2	6445653	B110788	18-4038 ②	18-4036 ③	—	18-1154	—
40	4	1279685	1476509	18-4035 ①	—	18-4035 ④	18-1154	18-1154
40	2	2874704	& UP	18-4038 ②	18-4036 ③	—	18-1154	—
40	4	C159200	& UP	18-4035 ①	—	18-4037 ④	18-1154	18-1154
40	2	G053314	& UP	18-1194	18-4036	—	18-1154	—
40	3	G531301	& UP	18-1194	18-4036	—	18-1154	—
45	4	1476510	1531568	18-4035 ①	—	18-4035 ⑤	18-1154	18-1154
45	4	5531630	& UP	18-4035 ①	—	18-4037 ④	18-1154	18-1154
45 (jet)		D000750	G589999	18-4039	18-4036	—	18-1154	—
45 (jet)	3	G590000	& UP	18-1194	18-4036	—	18-1154	—
50	4	1421113	5193258	18-4035 ①	—	18-4035 ⑤	18-1154	18-1154
50	4	5193259	& UP	18-4035 ①	—	18-4037 ④	18-1154	18-1154
50	3	6428681	D000749	18-4038 ②	18-4036 ③	18-4037 ④	—	—
50	3	D000750	G589999	18-4039 ②	18-4036 ③	—	18-1154	—
50	3	G590000	& UP	18-1194	18-4036 ③	—	18-1154	—
55	3	D000750	G589999	18-4039	18-4036	—	18-1154	—
55	3	G590000	& UP	18-1194	18-4036	—	18-1154	—
60	4	1303411	1542744	18-4035 ①	—	18-4037 ④	18-1154	18-1154
60	3	6428681	D000749	18-4038 ②	18-4036 ③	18-4037 ④	—	—
60	3	D000750	G589999	18-4038 ②	18-4036 ③	—	18-1154	—
60	3	G590000	& UP	18-1194	18-4036 ③	—	18-1154	—
65	4	1545745	3293183	—	—	18-4037 ④	18-1154	—
65	3	3293184	4571651	18-4038 ②	18-4036 ③	18-4037 ④	—	—
65 (jet)		D283222	& UP	—	—	—	18-1346	—
70	6	1296411	1566239	18-4035 ①	—	18-4037 ④	18-1154	18-1154
70	3	4571652	6428680	18-4038 ②	18-4036 ③	18-4037 ④	—	—
70	3	A996142	& UP	—	—	—	18-1346	—
75	4	6432901	& UP	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
75	3	C222000	& UP	—	—	—	18-1346	—
80	6	1335465	1566239	—	—	18-4037 ④	18-1154	18-1154
80	4	2559001	6432900	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—

① 25 required per cylinder ④ 56 required per main bearing
 ② 1 required per cylinder: crank end without cage ⑤ 28 required per main bearing
 ③ 29 required per cylinder ⑥ Will not replace 31-17514A1 with needles permanently mounted in cage

OUTBOARD

MERCURY/MARINER

Internal Engine System



HP	Cyl.	Beg. S/N	End. S/N	Con. Rod Crank End	Con. Rod Piston End	Center Main Bearing	Lower Main Bearing	Upper Main Bearing
85	I-6	1460999	1766823	—	—	18-4037 ④	18-1154	—
85	4	3493913	4831998	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
90	I-6	1766824	1869775	—	—	18-4037 ④	18-1154	—
90	I-6	4845301	& UP	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
90	3	A996142	& UP	—	—	—	18-1346	—
95	I-6	1869776	2318585	—	—	18-4037 ④	18-1154	—
100	I-6	1464949	2836018	—	—	18-4037 ④	18-1154	—
100	I-6	2641855	3253111	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
100	4	B209468	& UP	—	—	—	18-1346	—
105 (jet)	V-6	D820000	& UP	—	—	—	18-1345	—
110	I-6	1870204	2314955	—	—	18-4037 ④	18-1154	—
115	I-6	2836019	C099999	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
115	4	C100000	& UP	—	—	—	18-1346	—
115	6	G960500	T178499	18-1194	—	—	—	—
125	I-6	2314956	3253111	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
125	4	D283222	& UP	—	—	—	18-1346	—
135	I-6	2839369	3293233	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
135	V-6	A904646	C239552	18-1194	—	—	—	—
135	V-6	C239553	D082000	18-1194	—	—	—	—
135, 135 DFI	V-6	D082000	& UP	18-4039	—	—	18-1345	—
140	I-6	3293234	& UP	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
140 (jet)	V-6	D082000	& UP	18-4039	—	—	18-1345	—
150	I-6	3502806	5327662	18-4038 ②	18-4036 ③	18-4037 ④	18-1154	—
150	V-6	4868998	A904645	18-4039 ② ⑥	—	—	18-1345	—
150	V-6	4868998	D081999	18-1194	—	—	—	—
150 EFI	V-6	D082000	& UP	18-1194	—	—	—	—
150 DFI	V-6	D082000	& UP	18-4039	—	—	18-1345	—
150 XR6	V-6	D082000	& UP	18-4039	—	—	18-1345	—
XR-4	V-6	B242885	D081999	18-1194	—	—	—	—
175	V-6	4301235	6608750	18-4039 ② ⑥	—	—	18-1345	—
175 (1750)	V-6	4301235	6618750	18-1194	—	—	—	—
175 (1750)	V-6	8058870	& UP	18-1194	—	—	—	—
175	V-6	6618751	D081999	18-1194	—	—	—	—
175	V-6	D082000	& UP	18-1194	—	—	—	—
175 XRI	V-6	D000750	D081999	18-1194	—	—	—	—
175 EFI	V-6	D082000	& UP	18-4039	—	—	18-1345	—
200	V-6	4839034	D081999	18-1194 ② ⑥	—	—	18-1345	—
200	V-6	D082000	& UP	18-4039	—	—	18-1345	—
200 EFI	V-6	C100861	D081999	18-1194	—	—	—	—
200 EFI	V-6	D082000	& UP	18-4039	—	—	18-1345	—
220	V-6	B117316	& UP	18-1194	—	—	—	—
225	V-6	5628028	D280812	18-1194	—	—	—	—
225	V-6	D280813	& UP	18-4039 ② ⑥	—	—	18-1345	—
250/275	V-6	C101891	& UP	18-4039	—	18-1347	18-1345	—
3.4L	V-6	5611648	& UP	18-4039	—	18-1347	18-1345	—

- ① 25 required per cylinder
- ② 1 required per cylinder: crank end without cage
- ③ 29 required per cylinder
- ④ 56 required per main bearing
- ⑤ 28 required per main bearing
- ⑥ Will not replace 31-17514A1 with needles permanently mounted in cage

<p>18-2143 AP# 13054 MOTOR MOUNT Replaces: 78249 Large Diameter Lower Motor Mount Includes: (1) Lower Motor Mount and (2) 3/4" Stainless Steel Washers</p> 	<p>18-2144 AP# 13055 MOTOR MOUNT Replaces: 78687, 78687T Small Diameter Upper Motor Mount Includes: (1) Upper Motor Mount and (2) 1" Stainless Steel Washer</p> 	<p>NEW</p> <p>18-1342 ROD BOLT Replaces: 93886 For: 135, 150, 175, 200 H.P. XR4, Mag II</p> 
<p>18-7901 OIL FILTER Replaces: 825467A1 For: 9.9 4 stroke H000058 - H017099 (1995-02)</p> 	<p>18-7913 OIL FILTER Replaces: 35-822626Q1 For: 4-Stroke O/B's, 9.9/15 & 8/15 Bodensee S/N OG760300 & UP</p> 	<p>18-7914 OIL FILTER Replaces: 35-822626Q2 For: 4-Stroke O/B's, 25/30/40/45/50 HP S/N OG760300 & UP, 75/90 HP S/N OG960500 & UP</p> 

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