SPECIFICATIONS

Model Numbers . . . . . TR-10 (standard length)
TRL-10 (5" longer)
*Horsepower (O.B.C.-certified) . . . . . 55 hp at 5000 rpm
Full throttle operating range . . . . . 4500 to 5500 rpm
Tank test with test wheel . . . . . 4600 rpm
Engine type . . . . . 2 cycle, 3 cylinders in line
Bore and stroke . . . . . 3" bore x 2-11/32" stroke
Piston displacement . . . . . 49.7 cubic inches
Piston ring sets (3 per set) standard . . . . . Part Number 381496
.020" oversize . . . . . Part Number 593429
Diameter of ring . . . . . 3.000 in. (standard)
Width of ring . . . . . .0935 - .0925 in.
Piston ring lbs. compression
recommended when compressed . . . . . 7.5 to 13.0 lbs.
Piston less rings
Standard . . . . . Part Number 382274
.020" oversize . . . . . Part Number 383144
Crankshaft size
Top journal . . . . . 1.4979 - 1.4974 in.
Center journals . . . . . 1.3752 - 1.3748 in.
Bottom journal . . . . . 1.1815 - 1.1810 in.
Connecting rod crank pin . . . . . 1.1828 - 1.1823 in.
Carburetion . . . 3 carburetors - Float feed with low-speed adjustment.
Automatic, thermo electric manual lever and remote control choke
Float level setting . . . . . Remove float bowl, turn it upside down so weight of float closes needle; float should now be parallel with rim of casting.
Carburetor orifice plug . . . . . Hole size .054"
Inlet needle seat . . . . . .065 - .062 Use a #52 drill as gage.
Cooling system . . . . . Thermostatically controlled recirculating system
Propeller gear ratio 12:29
Propeller . . . . . 3 blade, 13-1/4" dia. x 17" pitch
Alternate propellers . . . . . 3 blade, 14" dia. x 9" pitch
3 blade, 14" dia. x 11" pitch
3 blade, 14" dia. x 13" pitch
3 blade, 13-3/4" dia. x 15" pitch
3 blade, 13" dia. x 19" pitch
Speed control . . . . . Remote control - synchronized throttle and spark
Gear shift control . . . . . Hydro-Electric - forward, neutral, reverse - remote control
Weight (without fuel tank) . . . . . Model TR-10 - 190 lbs.
Model TRL-10 - 195 lbs.
(Fuel tank weight 11 lbs. net)
Fuel capacity . . . . . 6 gallons, suction type tank
Starter . . . . . 9 amp electric and emergency rope
Electrical system . . . . . Alternating current generator
Starter amp draw when cranking . . . . . 135 amperes maximum
Ignition (CD with breaker points) . . . . . Battery - power pulse
Spark plug . . . . . AC V4OFF or Champion L-19V
Spark plug torque . . . . . 17-1/2 - 20-1/2 foot-pounds
Breaker point gap . . . . . .010 in.
Breaker point spring tension . . . . . 28 - 32 oz.
Part No. 580730 Coil Test Specifications - New Stevens Tester Model No. M.A. - 75

Merc-O-Tronic with Capacitor Discharge Adapter Model 55-980

Operating Amperage	Primary Resistance	Secondary Continuity
Min. - Max.	Min. - Max.	Min. - Max.
.8 - 1.2		22.5 - 25

*Horsepower established at sea level. Allow 2% reduction per 1000' above sea level.

Secondary Continuity	3000 ohms maximum
Primary Continuity	1.2 ohms maximum
Coil Index	60
Coil Test (Normal)	9 minimum
Coil Test (Amplified)	80 minimum
Gap Index	50 maximum

CLEARANCE CHART

Power head	
Piston and wrist pin - loose end	.006 max. - .001 min.
Piston ring gap	.017 max. - .007 min.
Piston ring groove clearance	.007 max. - .0045 min.
Cylinder and piston	.0055 max. - .004 min.
Crankshaft bearings	
Upper	Roller type
Center	Roller type
Lower	Ball type
Crankshaft end play	.011 max. - .003 min.
Connecting rod bearings	
Piston end	Roller type
Crankshaft end	Roller type
Lower unit	
Gearcase head and propeller shaft	Roller type
Driveshaft to gearcase - upper	Roller type
Pinion to gearcase	Roller type
Propeller shaft to oil pump	Roller type
Front gear bushing to propeller shaft	.002 max. - .001 min.
Rear gear bushing to propeller shaft	.0015 max. - .0005 min.
Propeller on shaft	.007 max. - .003 min.

TORQUE CHART

Power head	
Flywheel nut	70-85 ft.-lbs.
Connecting rod screws	348-372 in.-lbs. (29-31 ft.-lbs.)
**Cylinder head screws	168-192 in.-lbs. (14-16 ft.-lbs.)
Crankcase to cylinder screws and nuts	
Upper	144-168 in.-lbs.
Center	144-168 in.-lbs.
Lower	144-168 in.-lbs.
Spark plugs	17-1/2-20-1/2 ft.-lbs.
Lower journal bearing retainer plate screws	96-120 in.-lbs.

**Retorque to 18-20 ft.-lbs. or 216-240 in.-lbs. after motor test.

CAUTION

When tightening two or more screws on the same part, DO NOT tighten screws completely, one at a time. To avoid distortion of the part, first tighten all screws together to one-third of specified torque, then to two-thirds of specified torque, then torque down completely.

NOTE

Retorque cylinder head screws and spark plugs after motor has been run and has reached operating temperature, and has cooled off.