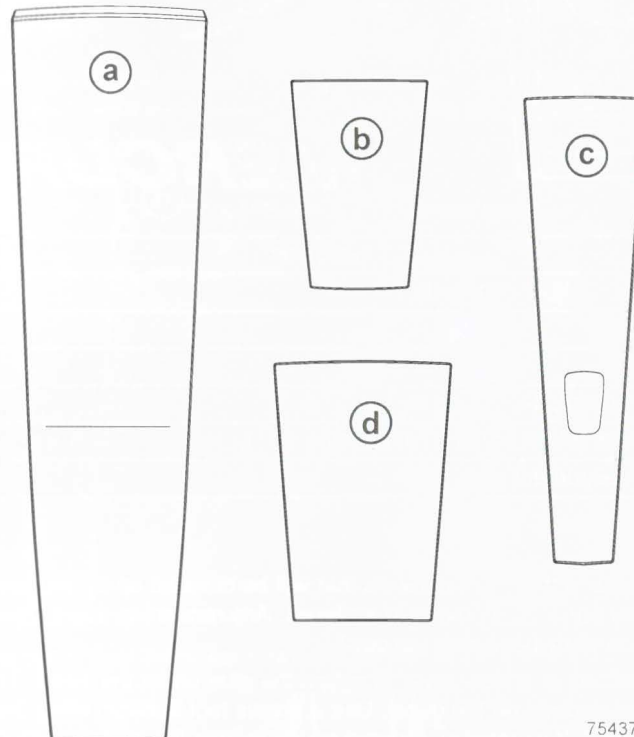


COWL ACCENT PANEL AND DECAL KITS 400R

IMPORTANT: This document guides our dealers, boatbuilders, and company service personnel in the proper installation or service of our products. If you have not been trained in the recommended servicing or installation procedures for these or similar Mercury Marine products, have the work performed by an authorized Mercury Marine dealer technician. Improper installation or servicing of the Mercury product could result in damage to the product or personal injury to those installing or operating the product. Always refer to the appropriate Mercury Marine service manual for component removal and installation instructions.

NOTE: After completing installation, place these instructions with the product for the owner's future use.

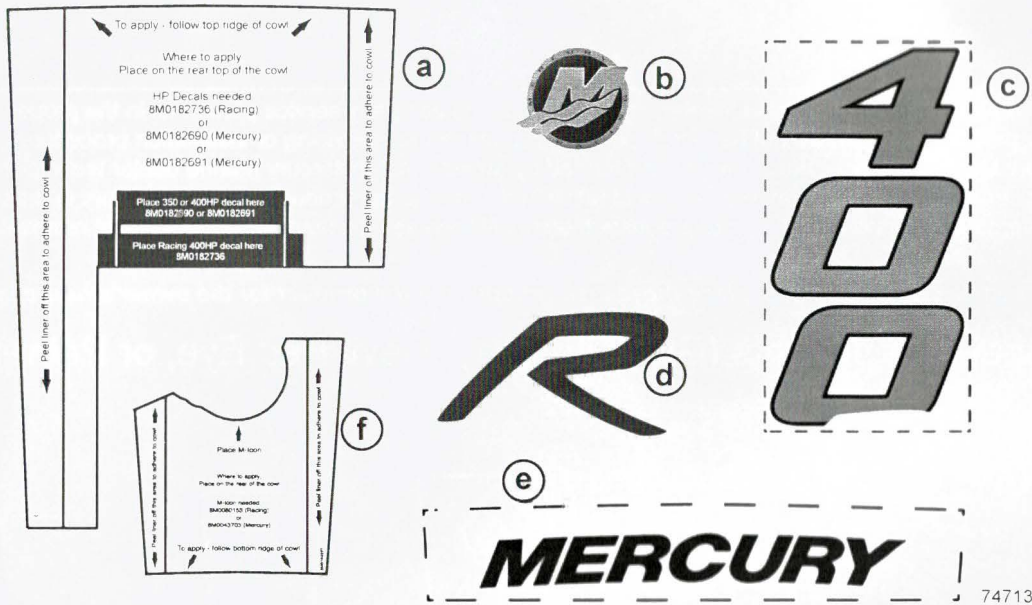
Accent Panel Components (Graphite Gray, Devil Red Eye, or Paint-Ready)



75437

Ref.	Qty.	Description	Part Number
a	1	Top cowl rear accent panel	NSS
b	1	Top cowl front accent panel	NSS
c	1	Lower cowl rear accent panel	NSS
d	1	Top cowl door accent panel	NSS

Decal Kit Components



Ref.	Qty.	Description	Part Number
a	1	Top cowl rear decal alignment guide	NSS
b	1	M-icon - 66 mm	NSS
c	1	3D "400R" decal	NSS
d	1	"R" decal (red or black, depending on kit)	NSS
e	1	3D "Mercury" decal (black or silver, depending on kit)	NSS
f	1	Top cowl M-icon alignment guide	NSS

Decal Removal

IMPORTANT: It is important to remove the original decals that will be covered up by the accent panels, and any adhesive residue before applying the accent panels onto the cowl surfaces. Any remaining decal material or adhesive will limit the ability of the VHB™ adhesive to properly bond with the cowl.

Use a heat gun on the low heat setting or a blow dryer to soften the glue under the decal. Try not to get it too hot or the glue will stay on the surface of the cowl and not on the decal. Use a plastic tool to begin lifting the decal. Continue with low heat until the decal is completely removed. If necessary, remove any glue from the surface with wax and grease remover available at any auto paint supply store.

Accent Panel Installation

Surface Preparation

Application Temperature

Apply the decal when the surface and ambient air temperature is between 16–37.3 °C (61–99 °F).

NOTE: When applying the decal near the minimum temperature specification, the adhesive bond will develop more slowly than at temperatures in the mid to upper specification range.

Step One: General Cleaning

IMPORTANT: Do not shortcut the cleaning process. Perform the general cleaning procedure prior to solvent cleaning. All of the surfaces are considered contaminated prior to thorough surface cleaning preparation.

1. Mix a solution of 29.5 cc (1 fl oz) liquid dishwashing detergent with 3.7 Liter (4 US qt) of warm water.
2. Rinse cowl with clean water.
3. Dry the cowl with a clean Meguiar's® Supreme Shine™ Microfiber Towel.
4. Avoid detergents or preparations that contain waxes, oils, or lotions.

Step Two: Solvent Cleaning

1. Mix a solution of isopropyl alcohol and water to a 1:1 ratio. Store in a spray bottle and identify the solution with a label.

2. Saturate a clean paper towel with the isopropyl alcohol and water solution.
3. Wipe the cowl with the saturated towel followed immediately with a lint-free towel before the solution evaporates.
NOTE: Isopropyl alcohol evaporates quickly. You must wipe the surface immediately after applying the solution.
4. When the paper towel becomes contaminated with dirt, discard it and use a clean paper towel saturated with the isopropyl alcohol and water solution.
5. Ensure that the surface has no contamination and is completely dry.
6. Start to apply the accent panels immediately after solvent cleaning.

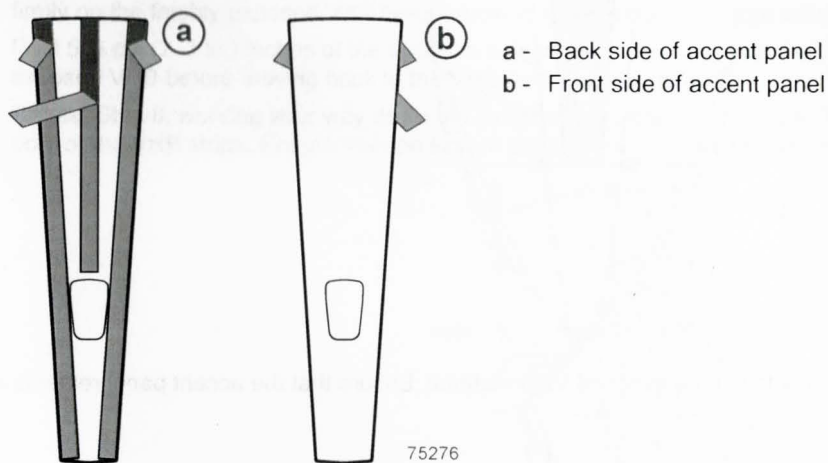
Important Considerations

IMPORTANT: Once the VHB adhesive material comes in contact with the cowl surface, repositioning of the accent panel will not be possible. Ensure that proper alignment is established before adhesive contact is made.

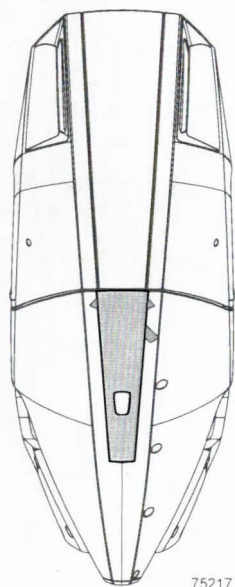
IMPORTANT: A dry fit, or test fit of the accent panels must be done before any of the VHB backer material is removed. This will allow the installer slight adjustments to the position and fitment of the panel prior to exposing the VHB material.

Lower Cowl Rear Panel

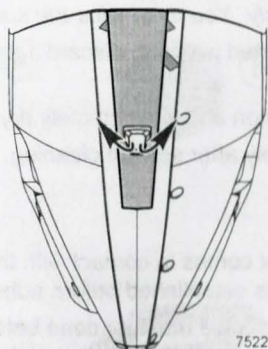
1. Partially peel the backer from the VHB at the top hooked edge of the accent panel as shown. To ensure that the backer is accessible, use masking tape to fix the backer to the outside of the accent panel. Note how the middle backer is below the starboard side backer.



2. Position the lower cowl rear panel over the lower cowl rear portion of the cowling.

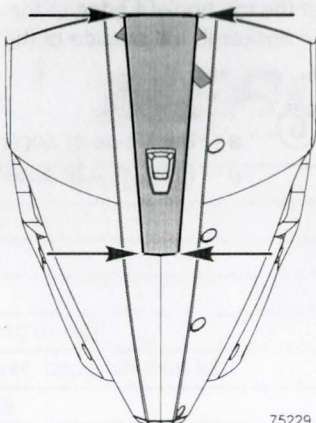


3. Pull the rubber grommet through the accent panel. Starting at one corner of the grommet, bend and fold the rubber in order to get it through the accent panel. Continue until all four corners are completely through the accent panel.



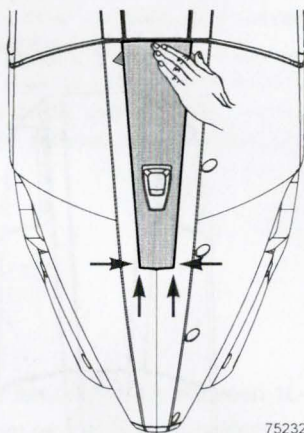
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4. With the grommet now holding the accent panel in place, align the accent panel so that it is in the proper position over the cowl panel.



75229

5. Press the top portion of the accent panel to set the exposed VHB material. Ensure that the accent panel remains in the proper position.



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Accent Panel Installation

Surface Preparation

Application Temperature

Apply the vinyl when the substrate temperature is between 50°F and 100°F.

NOTE: Allow adequate drying time between the application of each layer of vinyl.

Step One: General Cleaning

1. (Optional) Do not wet sand the substrate, and do not use any abrasive cleaning products on the substrate.

2. Use a solution of 20:1 Isopropyl Alcohol and water to clean the substrate.

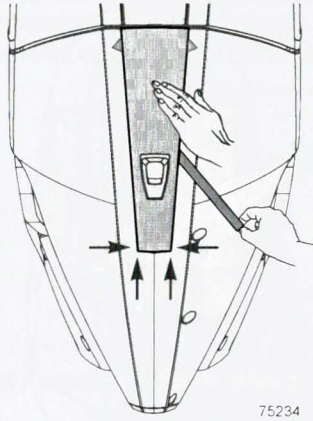
3. Rinse with clean water.

4. Dry the substrate with a clean, lint-free cloth.

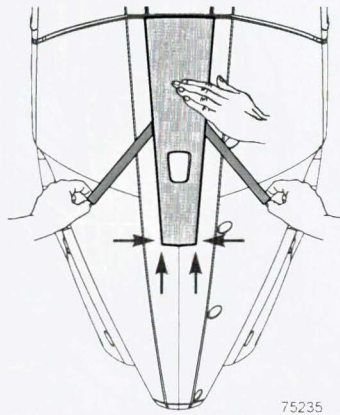
Step Two: Solvent Cleaning

1. Use a solution of 70:30 Isopropyl Alcohol and water to clean the substrate.

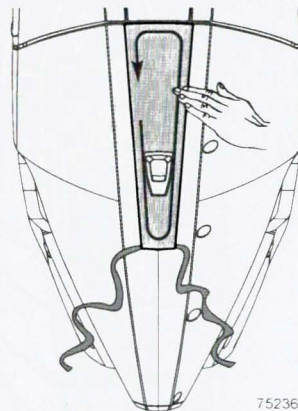
6. Remove the center section of VHB backer while pressing on the accent panel to adhere the accent panel to the lower cowl. Ensure that the accent panel remains in the proper position.



7. Partially peel back the top corners of the outer two strips. Fold the partially removed backer around to the outside of the accent panel.
8. Begin removing the VHB backer by peeling 5–8 cm (2–3 in.) from in between the accent panel and rear panel. Press firmly on the freshly exposed VHB before moving to the VHB on the opposite side.
9. Peel 5–8 cm (2–3 in.) inches of the opposite side VHB backer from in between the two parts. Press firmly on the freshly exposed VHB before moving back to the VHB on the opposite side.
10. Repeat Step 8, working your way down the length of the panel until there is 2.5 cm (1 in.) left of nonpeeled backer on both of the VHB strips. Ensure that the accent panel remains in the proper position.



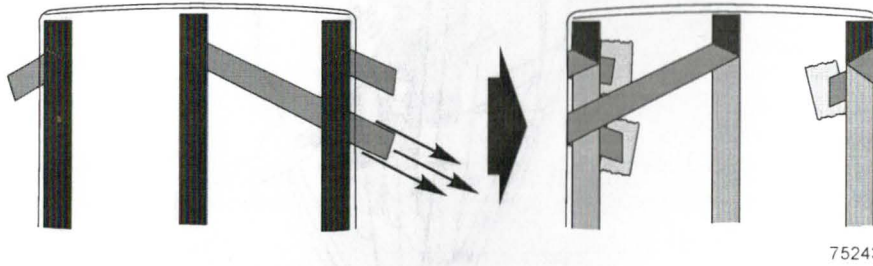
11. Carefully remove the backer completely and firmly press down on the accent panel. Repeat backer removal on the opposite side, then press firmly down on the entire perimeter to complete the installation for this panel.



12. Inspect the idle relief muffer grommet. Use your fingers or a suitable instrument to align the muffer hose with the grommet and seat the hose properly back into the two grommet flange couplings.

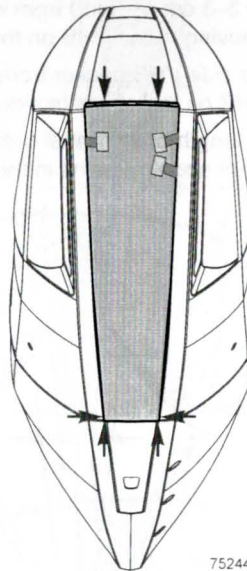
Top Cowl Rear Panel

1. The following illustration depicts the accent panel as transparent for clarity of the instructions. Partially peel the backer from the VHB at the top hooked edge of the accent panel. To ensure that the backer is accessible, use masking tape to fix the backer to the outside of the accent panel. Note how the middle backer is below the starboard side backer.

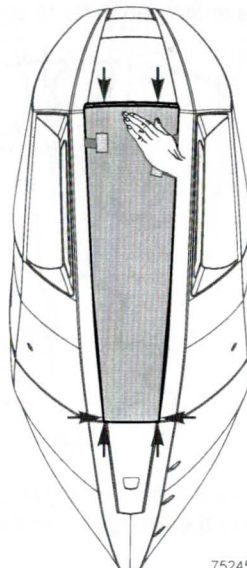


Accent panels shown transparent for clarity

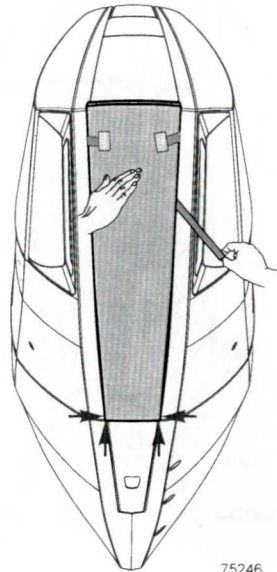
2. Align the lower edge of the accent panel with the bottom edge of the cowl. Begin rocking the accent panel down, drawing the top edge of the accent panel closer to the top peak of the cowl. Make sure the bottom edge of the accent panel remains in line with the bottom edge of the cowl.



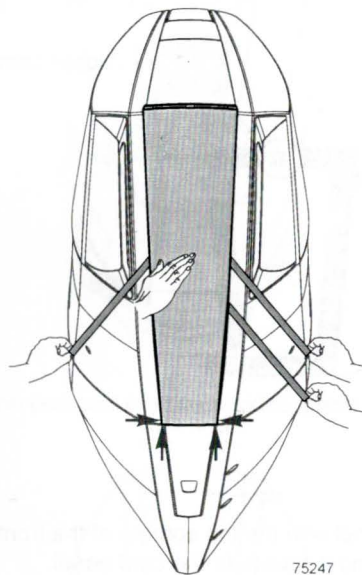
3. Bring the upper edge of the accent panel up so that it is just above the upper corner of the cowl. Press down firmly on the top edge of the panel, snapping it into place. The VHB should now be contacting the cowl surface.



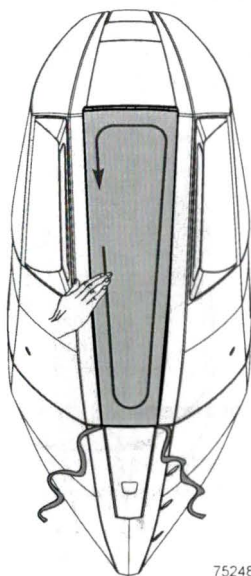
4. Remove the masking tape that was used to hold the pulled backer in place, and begin removing the VHB backer. Starting with the center strip, peel the backer by pulling at a 45° angle from the strip, as shown.



5. Keep removing the starboard side backer, removing enough to keep it in line with the port side backer. The center backer will always need to be further along than the outside backers. Once the three backers have been removed 10–13 cm (4–5 in.) inches, firmly press on the freshly exposed VHB regions.



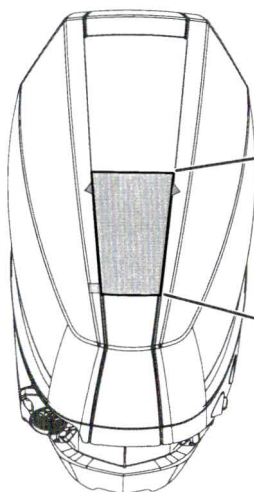
6. Press down on the remaining portion of the accent panel, covering all of the VHB contact areas, to set the adhesive.



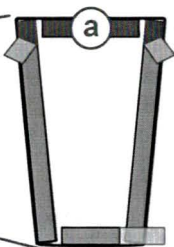
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Top Cowl Front Panel

1. Remove the VHB backer from the upper center strip, and partially peel back the top corners of the outer two strips. Fold the partially removed backer around to the outside of the accent panel.

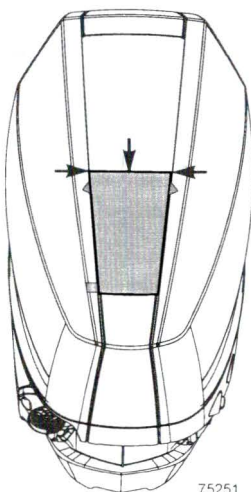


a - Upper center strip



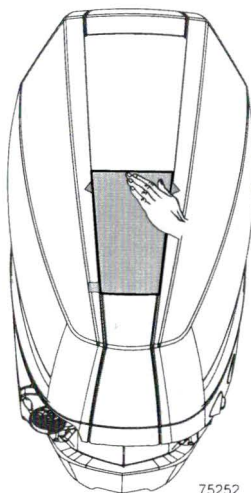
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2. Align the top corners of the accent panel with the top corners of the front panel of the cowl. Rock the accent panel down onto the front panel of the cowl, keeping it square to the cowl panel.



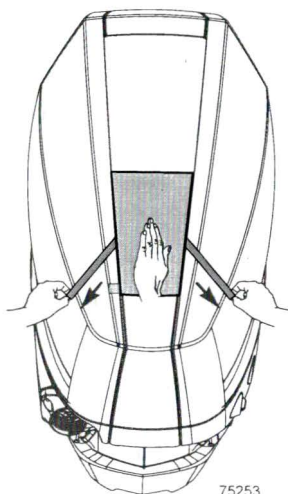
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3. Starting at the top of the accent panel piece, firmly press down on the exposed VHB region of the accent panel.



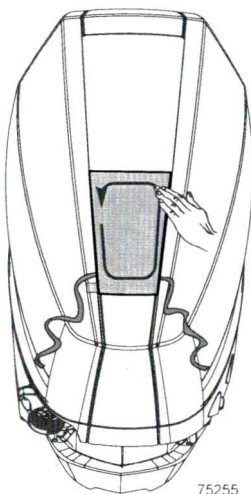
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4. Begin peeling the VHB backer from the port and starboard sides, working a few inches at a time to the lower portion of the accent panel piece.



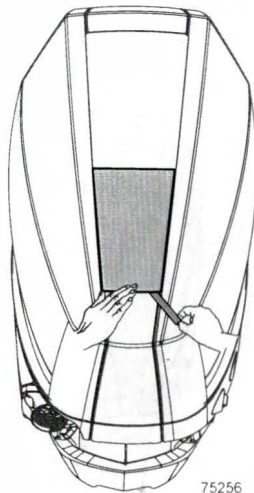
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5. After removing the backer material from the port and starboard sides, press down firmly on the VHB regions to set the adhesive.



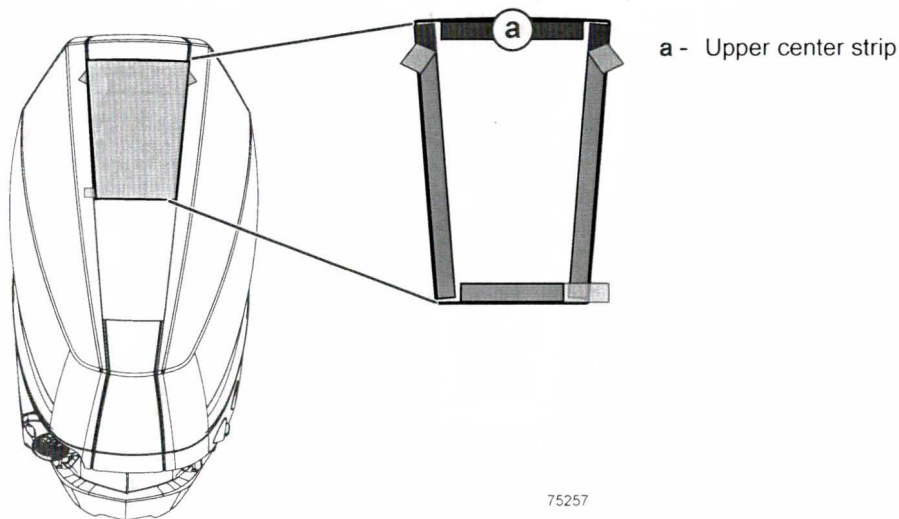
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6. Peel the remaining backer material from the bottom of the accent panel. Press down firmly on the VHB regions to set the adhesive.

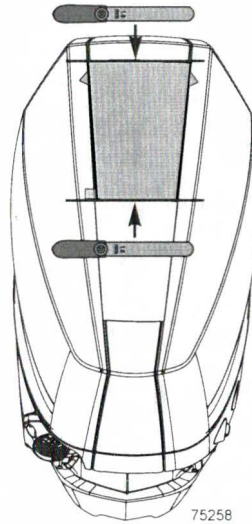


Top Cowl Service Door

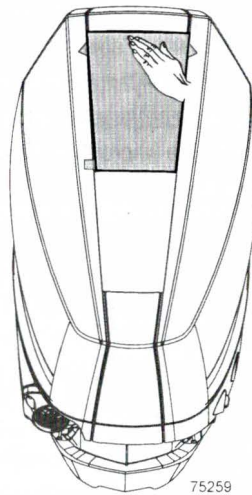
1. Remove the VHB backer from the upper center strip, and partially peel back the top corners of the outer two strips. Fold the partially removed backers around to the front of the accent panel.



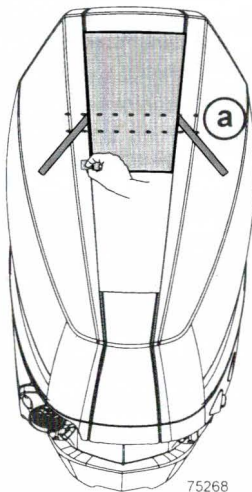
- Align the top and bottom edges of the service door panel using a straightedge, or a 1.0 mm feeler gauge to ensure proper clearance of the service door accent panel. Rock the accent panel down onto the service door panel, keeping it square and aligned to the service door panel gaps.



- Bring the top of the accent panel into contact with the top of the service door panel. Apply firm pressure on the exposed VHB region.

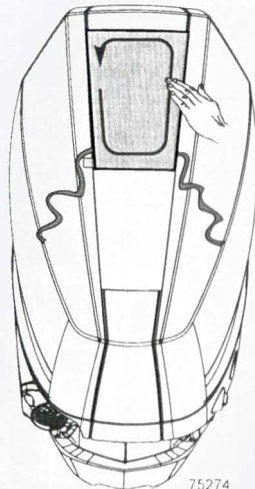


- Begin peeling the backer off the VHB from both the port and starboard sides of the service door accent panel. After every 2.5 cm (1 in.) inch, firmly press the accent panel downward to contact the adhesive.
- When approximately 75 percent of the port and starboard backer has been removed, peel the lower center backer away at a 45° angle, as shown.



a - 75 percent removal distance

6. Peel the remaining backer material from both the port and starboard adhesive strips.
7. Press down firmly on the VHB regions to set the adhesive.



Decal Installation

Tools, Materials, and Surface Requirements

Tools and Materials

- Decal application squeegee (3M® Applicator PA 1 Gold – recommended)
- Air release tool (3M Air Release Tool 391x) or a straight pin – used to remove trapped air bubbles
- Clean microfiber towel (Meguiar's® Supreme Shine Microfiber Towel – recommended)
- Spray bottles and labels for each cleaning solution

Cleaning Solution

- Liquid dishwashing soap
- Isopropyl alcohol

IMPORTANT: Identify each spray bottle of cleaning solution with a label.

Surface Requirements

Special attention is required when applying decals to certain surfaces, including primed, painted, and certain plastics. All painted surfaces must be cured per the manufacturer's requirements. When applying decals to plastic surfaces, allow proper time for out gassing.

Surface Preparation

Application Temperature

Apply the decal when the surface and ambient air temperature is between 16–37.3 °C (61–99 °F).

NOTE: When applying the decal near the minimum temperature specification, the adhesive bond will develop more slowly than at temperatures in the mid to upper specification range.

Step One: General Cleaning

IMPORTANT: Do not shortcut the cleaning process. Perform the general cleaning procedure prior to solvent cleaning. All of the surfaces are considered contaminated prior to thorough surface cleaning preparation.

1. Mix a solution of 29.5 cc (1 fl oz) liquid dishwashing detergent with 3.7 Liter (4 US qt) of warm water.
2. Rinse cowl with clean water.
3. Dry the cowl with a clean Meguiar's® Supreme Shine™ Microfiber Towel.
4. Avoid detergents or preparations that contain waxes, oils, or lotions.

Step Two: Solvent Cleaning

1. Mix a solution of isopropyl alcohol and water to a 1:1 ratio. Store in a spray bottle and identify the solution with a label.
2. Saturate a clean paper towel with the isopropyl alcohol and water solution.

3. Wipe the cowl with the saturated towel followed immediately with a lint-free towel before the solution evaporates.
NOTE: Isopropyl alcohol evaporates quickly. You must wipe the surface immediately after applying the solution.
4. When the paper towel becomes contaminated with dirt, discard it and use a clean paper towel saturated with the isopropyl alcohol and water solution.
5. Ensure that the surface has no contamination and is completely dry.
6. Start to apply the decals immediately after solvent cleaning.

Decal Application

Application Tips

1. Ensure that the surrounding work area and the cowl surface are properly cleaned to avoid contamination.
2. Ensure that the cowl surface temperature and the ambient air temperature is within the specified range.

Surface and Ambient Air Temperature Range
16–37.3 °C (61–99 °F).

3. Ensure that your hands are clean and dry.
4. Ensure that the paper liner on the decal does not become wet. A wet paper liner is very difficult to remove.
5. Use the recommended plastic applicator. The applicator should be new and must not be damaged.
 - a. If the decal has a premask, use the squeegee only.
 - b. If the decal does not have a premask, use a low friction sleeve or felt squeegee to prevent scratching or damage to the decal and cowl.
6. Use firm pressure on the squeegee with overlapping strokes.
7. Remove the premask and application tape at a 180° angle to the decal.
8. Puncture the air bubbles with an air release tool or straight pin. Do not use a knife or razor blade.
9. Using a microfiber towel, using pressure wipe down the entire decal after removing the premask tape.

Applying the Decal

IMPORTANT: Do not allow the new decal to have direct sunlight contact for a minimum of 24 hours.

1. Ensure that your hands are clean and dry.
2. Remove the paper liner from the decal.
3. Secure one end of the decal premask and hold the other end off the cowl, as you squeegee, the decal will lay down on the cowl. Apply pressure to the decal and squeegee the entire decal from end to end and outside edges with overlapping strokes.
4. Remove the premask liner from the decal beginning at one corner and carefully pull the premask liner off and onto itself at a 180° angle.

NOTE: Do not allow the premask to remain on the decal for more than 24 hours after installation.

5. Inspect the decal closely for entrapped air bubbles. Use the squeegee to push the air bubbles to the outside edge.

IMPORTANT: When the premask is removed from the decal, the pulling force loosens the adhesive at the edges of the decal. It is imperative to use a microfiber towel, wipe down the entire decal with special attention to the edges of the decal.

Entrapped Air Removal

The microComply™ adhesive has a unique pattern to the adhesive that allows entrapped air to escape through very small channels for a faster, easier installation. Always work from the center of the decal toward the edge. If the channels are closed off, use an air release tool or straight pin to aid in removing the bubble. Puncture one end of the bubble and use your thumb to push the entrapped air toward the puncture site. Do not use a knife or razor blade to puncture the decal.

Final Decal Wipe Down

It is recommended to use a Meguiar's Supreme Shine Microfiber Towel for the final decal squeegee. With firm hand pressure, work the decal from the center out to the edge. Make sure to pay attention to the edge of the decal during this final decal squeegee.

Cleaning and Maintenance

IMPORTANT: Never use petroleum products or strong household cleaning chemicals to clean the outside surface of the cowls. Using petroleum products or strong household cleaning chemicals will cause damage to the decal and may damage the cowl.

IMPORTANT: Pressure wash with caution. Always use a wide spray pattern, low-pressure, and an angle less than 60° to the surface when using a pressure washer. Low angle water streams can lift the decal from the surface.

General Cleaning Instruction

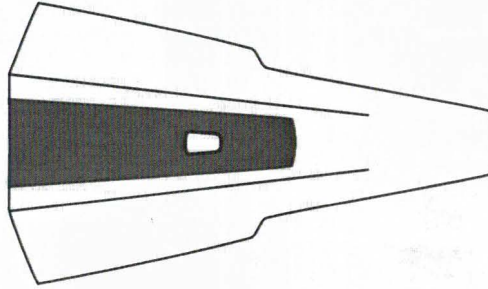
- Rinse the surface well with lukewarm water to remove dirt.
- Use a soft cloth or sponge to gently wash the surface with a mild dishwashing soap with lukewarm water.
- Do not scrub, use a brush, or a squeegee.
- Rinse the surface thoroughly.
- Use a clean, soft, lint-free cloth to dry and prevent water spotting.

Accent Panel Decal Placement

IMPORTANT: The accent panels included with a new 400R outboard have the decals pre-installed.

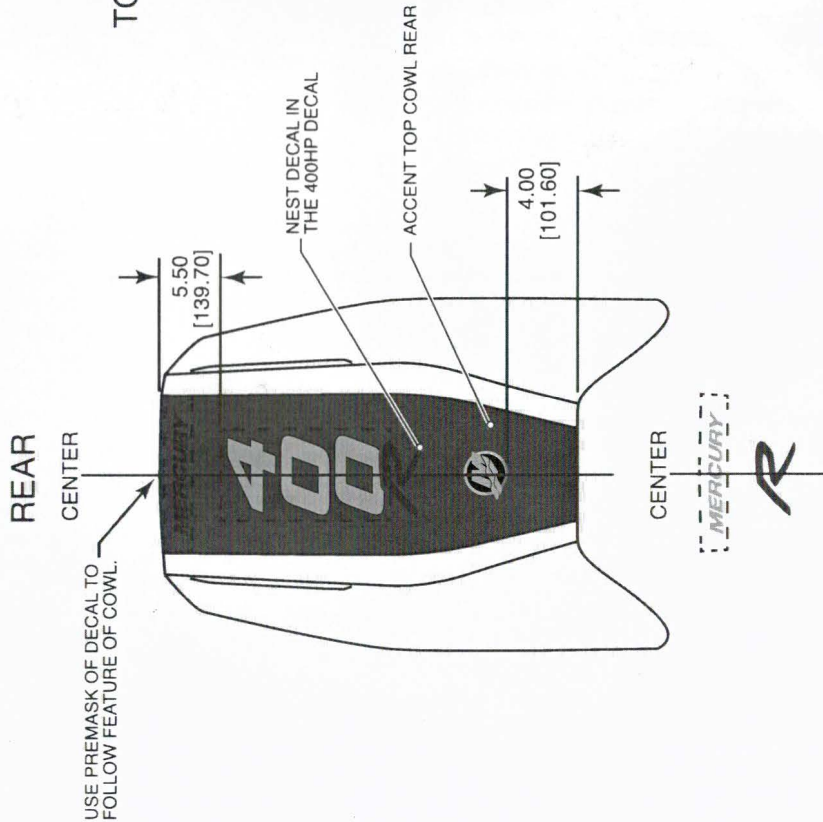
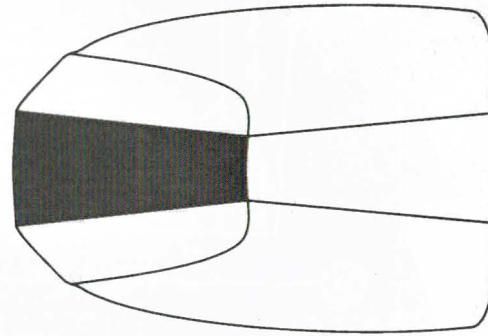
IMPORTANT: Apply the decal alignment guides as illustrated to guide the decal installation. The dashed lines on the drawing represent the decal premasks. Align the premasks with the decal alignment guides and carefully apply the decals as stated in the previous procedures.

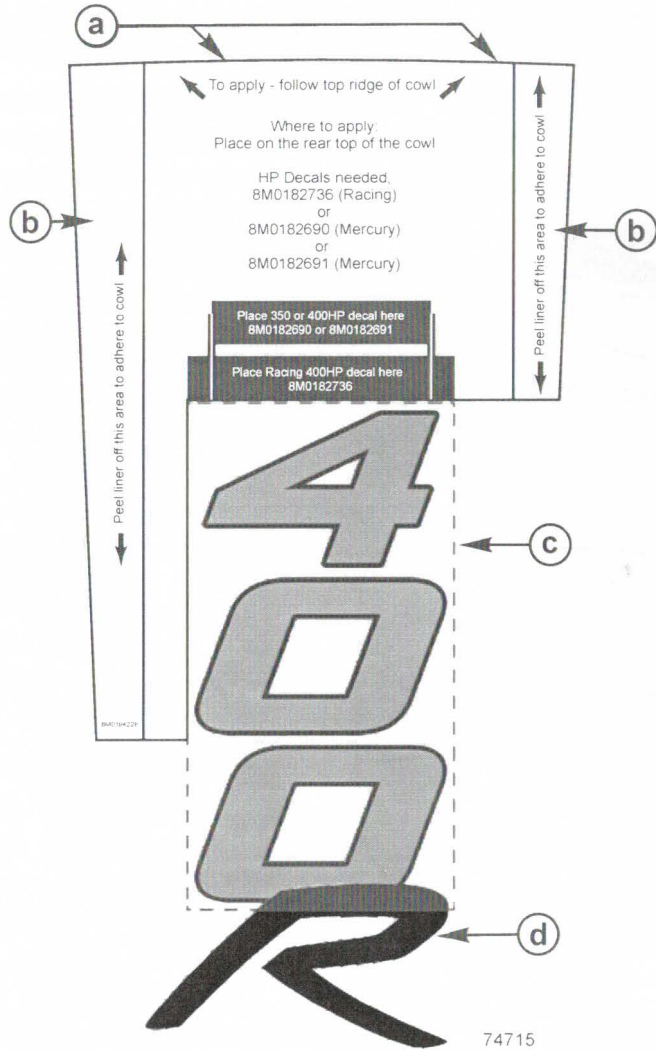
ACCENT -
LOWER COWL



75302

ACCENT -
TOP COWL DOOR & FRONT

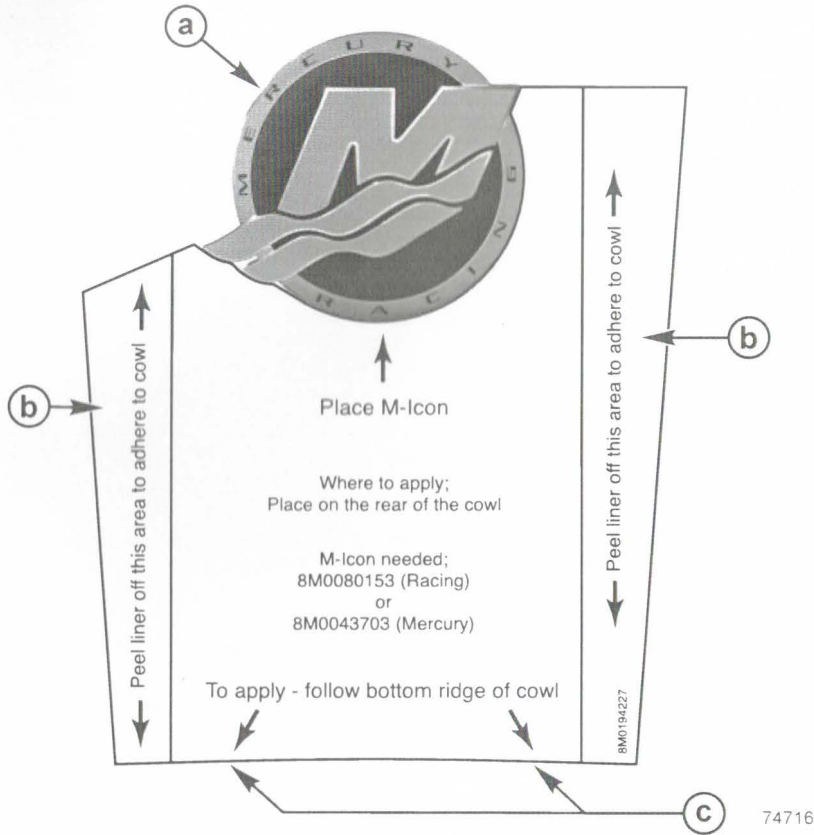




Top cowl rear accent panel decals

- a - Follow top ridge of cowl
- b - Remove the liner from this area to adhere to cowl
- c - 400 decal (premask aligned with decal alignment guide)
- d - R decal

NOTE: The R decal may be red or black, depending on which kit is being installed.



- Top cowl M-Icon emblem**
- a - M-Icon emblem
 - b - Remove the liner from this area to adhere to cowl
 - c - Follow bottom ridge of cowl



- Top cowl Mercury decal**
- a - Align premask with top ridge of cowl
- NOTE: The Mercury decal may be black or silver, depending on which kit is being installed.*