

# qualitymark

Trusted professionals & superiority in innovation

# H<sub>2</sub>O<sup>TM</sup>

PERFORMANCE <sub>2</sub> PARTS



- Breakthrough Technology
- Rigorous Testing
- Unrivalled Quality



**Welcome to Quality Mark products.**

We put purpose before profit and strive to be an extraordinary business to partner with and to work for. Always improving performance, delivering quality and achieving sustainable business excellence.

**\*Highest quality material**



**\*Excellent surface finish**



**\*CNC machining**



**\*100% leak tested**



**\*In house painting**



**\*Well packaged**





**T-20918 Elbow**

*Jacked upper for swivel*



**Cross Reference**

Crusader # 97386  
Sierra # 18-1918



\*80309 Gasket



**26562-MK**

**Mounting kit, Elbow**

*Includes gasket and mounting hardware*



**T-20927  
Riser**



**T-20916  
Riser**



**T-20925 Manifold, starboard**



**Cross Reference**

Barr # CR-1-97752

**Crusader # 97752 AND 96120**

Sierra # 18-1925



\*80872 Gasket



**20775-MK**  
**Mounting kit, Manifold**  
Includes gasket and mounting hardware



**T-20927**  
**Riser**



**T-20916**  
**Riser**



**T-20926 Manifold, port**



**Cross Reference**

Bar# CR-1-97753

**Crusader # 97753 AND 96121**

Sierra # 18-1926



*\*80872 Gasket*



**20775-MK**

**Mounting kit, Manifold**

*Includes gasket and mounting hardware*



**T-20927  
Riser**



**T-20916  
Riser**

## GM Small Block V8 305-350 cu.in.

Models 220 and 270

## GM Big Block V8 454 cu.in.

CH350 AND 454XL



**T-20927 Riser, 4"**



### Cross Reference

Barr # CR-20-97924

**Crusader # 97772**

Sierra # 18-1927



\*80305 Gasket



### 20927-MK

### Mounting kit, Manifold

Includes gasket and mounting hardware



**T-20925  
Manifold**



**T-20926  
Manifold**

GM Big Block V8 454 cu.in.

Models CH350 AND 454XL



**T-20928 Elbow, 4" outlet**

### Cross Reference

Crusader # 97924  
Sierra # 18-1928



\*80309 Gasket

**26562-MK**  
**Mounting kit, Manifold**  
Includes gasket and mounting hardware



**T-20916**  
**Riser, 8"**



**T-20927**  
**Riser, 4"**

**GM Big Block V8 454 cu.in.**

Models CH350 AND 454XL



**T-20929 Manifold, starboard**  
Fits both sides of engine



**Cross Reference**

Barr # CR-1-97992

Crusader # 97992 and 97114

Sierra # 18-1929

\*80418 Gasket



**20799-MK**  
**Mounting kit, Manifold**  
Includes gasket and mounting hardware



**T-20916**  
**Riser, 8"**



**T-20927**  
**Riser, 4"**



**GM Big Block V8 454 cu.in.**

Models CH350 AND 454XL



**T-20933 Manifold, port**



**Cross Reference**

Barr # CR-1-97993

**Crusader # 97993 and 97115**

Sierra # 18-1933

\*80418 Gasket



**20799-MK**

**Mounting kit, Manifold**

Includes gasket and mounting hardware



**T-20916  
Riser, 8"**



**T-20927  
Riser, 4"**

## GM Small Block V8 305-350 cu.in.

Models 220 and 270

## GM Big Block V8 454 cu.in.

CH350 AND 454XL



**T-20934 Elbow, 4" outlet**



### Cross Reference

Barr # CR-20-98068

**Crusader # 98068**

Sierra # 18-1934



**26562-MK**

**Mounting kit, Manifold**

*Includes gasket and mounting hardware*

\*80309 Gasket



**T-20916  
Riser, 8"**



**T-20927  
Riser, 4"**

GM Big Block V8 454 cu.in.

Models 454XL and 502XL

MP8.1L engines



**T-20982** Manifold



**Cross Reference**

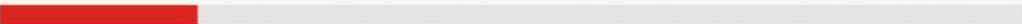
Crusader # 98125 / R0208021A  
Sierra # 18-1982



\*80418 Gasket



**20982-MK**  
**Mounting kit, Manifold**  
Includes gasket and mounting hardware



**T-20938**  
**Riser**

## GM Small Block V8 305-350 cu.in.

Models 220 and 270

## GM Big Block V8 454 cu.in.

CH350 AND 454XL



**T-30984** Spacer, 4"



### Cross Reference

Crusader # 98128  
Sierra # 18-1984



**30984-MK**  
**Mounting kit, Manifold**  
Includes gasket and mounting hardware

\*80475 Gasket



**T-20938**  
**Riser, 4"**



**T-20938 Riser, 4"**



**Cross Reference**

Crusader # RO29015 and 98126  
Sierra # 18-1938



**20938-MK**  
**Mounting kit, Manifold**  
Includes gasket and mounting hardware

\*80475 Gasket



**T-30984**  
**Spacer, 4"**

## GM Small Block V8 305-350 cu.in.

Models 220 and 270

## GM Big Block V8 454 cu.in.

CH350 AND 454XL



**T-20296 Stainless plate, Block off.**  
Separates fresh water from raw water

### Cross Reference

Crusader # 97296  
Sierra # 18-1917



## Installation Procedure

### PLEASE READ BEFORE EXHAUST COMPONENT INSTALLATION

**External Paint/ Coatings:** All QMI exhaust components have been painted for corrosion protection and to allow immediate installation out of the box. The black paint utilized will accept additional enamel top coats if the desire is to match the current OEM paint color.

**Gasket/ Gasket Surfaces:** During installation, it is recommended to remove the paint from any gasket surfaces. This provides the best seal as the exhaust gaskets are designed to be installed dry, without the use of any gasket sealants. The addition of sealants can result in gasket failure and subsequent water intrusion, either internally or externally. **DO NOT** remove the paint from the gasket mounting surfaces with any type of power tools or power assisted devices such as high speed rotary gasket removers, wire wheels, or sand paper flappers. Any type of mechanical or power paint removal could result in an uneven deck surface and improper sealing between components. The use of acetone or lacquer thinner will remove the paint without damaging the deck surface.

**Pipe Plugs and Fittings:** The pipe plugs and fittings for the exhaust components are tapered and should be installed to a snug fit and not-overtightened. Do not attempt to screw the plugs flush with the casting, this could result in an over-tightened situation. Over-tightened fittings can crack the casting, resulting in an unusable product.

**Mounting Hardware:** All mounting hardware supplied is of a grade 5 or higher, unless otherwise specified by the OE manufacturer. Lower grade bolts or stainless steel components are too soft and will not hold the proper torque setting if used in applications that are not designed for these materials. For proper sealing, torque settings should be reset after initial start and warm-up. Please refer to the original manufacturers service manual for specific torque setting. **STUD** installation requires the use of red thread locking compound to prevent studs from backing out or loosening during normal engine operation. **DO NOT** use any type of anti-seize on any mounting hardware as the lubricating properties will result in the hardware backing out.

If you have any questions, please contact us at QMI, Inc. (651)465-6613.



## Warranty

### THREE YEAR LIMITED WARRANTY QUALITY MARK, INC.

*QUALITY MARK, INC., a Minnesota Corporation (the “Company”) and its authorized exclusive suppliers manufacture exhaust manifolds, risers and exhaust connectors for use in marine engines (the “Product”), among other things.*

*The Company warrants these Products against defects in workmanship and/or material to the*

*Original Purchaser for a period of three years from the date of purchase. For purposes of this warranty, the Original Purchaser must have purchased the Product for non-commercial use, from an authorized seller within the Company’s intended chain of sales and/or distribution for the Product’s intended use.*



*This warranty is subject to the following limitations:*

*The Company must be notified of any warranted defect within three years of purchase by the Original Purchaser. This warranty does not extend to anyone other than the Original Purchaser. The Company will not be responsible for the cost of shipping, removal or installation of the Product. Any Product that the Company determines is defective will be repaired or replaced as appropriate, at the Company’s sole option.*

*Any implied warranties such as merchantability or fitness are also hereby limited to the three-year period of this warranty except where otherwise prohibited. Similarly, the Company shall not be liable for any incidental, consequential or special damages except to the extent otherwise prohibited.*

*This warranty does not cover defects that are caused by ordinary wear and tear, modification, excessive use, misuse, improper installation and/or improper handling.*