

KEY NO.	PART NAME
1	GASKET - Flange
2	SCREW - Throttle Plate
3	PLATE - Throttle
4	SPRING - Idle Adj. Needle
5	NEEDLE - Idle Adjusting
6	BODY - Throttle
7	PLUG - Fuel Inlet
8	BUSHING - Throttle Shaft
9	SEAL - Throttle Shaft
10	RETAINER - Shaft Seal
11	TAPER PIN - Throt. Stop Lever
12	SHAFT - Throttle
13	LEVER & STOP - Throttle
14	SHAFT & LEVER - Throttle
15	SCREW - Throttle Stop
16	JET - Idle
17	AXLE - Float
18	FLOAT
19	WASHER - Fuel Valve Seal
20	VALVE & SEAT - Fuel
21	GASKET - Bowl to Body
22	BOWL - Fuel
23	PLUG - Main Jet Passage
24	NEEDLE - Main Jet Adj.
25	WASHER - Passage Plug
26	JET - Main
27	WASHER - Main Jet
28	SCREW - Bowl to Body
29	PLUG - Bowl Drain
30	RETAINER - Choke Sh. Packing
31	BRACKET - Choke
32	LOCKWASHER - Bracket Screw
33	SCREW - Bracket Assembly
34	LEVER - Choke
35	TAPER PIN - Choke Lever
36	LEVER & SHAFT - Choke
37	SHAFT - Choke
38	LEVER - Choke
39	SCREW - Swivel
40	NUT - Choke Shaft
41	L'WASHER - Choke Shaft Nut
42	SPRING - Choke Lever
43	SCREW - Tube Clamp
44	CLAMP - Bracket Tube
45	NUT - Clamp Screw
46	WASHER - Choke Sh. Packing
47	DISC - Intake Drain
48	PLATE - Choke
49	SCREW - Choke Plate
50	PLUG - Choke Shaft Hole
51	WASHER - Discharge Jet
52	JET - Discharge
53	JET - Well Vent
54	VENTURI
55	TUBE - Idle Channel Filler

### 1 DISASSEMBLY

Disassembly consists of separating the carburetor into two basic groups: fuel bowl and air intake-throttle body and the disassembly of each of these groups. Use exploded illustration above as a guide for disassembly and reassembly.

### 2 CLEANING AND INSPECTION

Thoroughly clean all metal parts in P & D Metalclene or Speedclene. Blow out all parts and channels with air pressure. Inspect housing for damage, excessive wear, burrs or warpage. **DO NOT CLEAN NON-METALLIC PARTS** in P & D Metalclene or Speedclene.

### 3 REASSEMBLY

When reassembling carburetor use essentially the reverse order from disassembly.

#### ASSEMBLY OF FUEL BOWL BODY

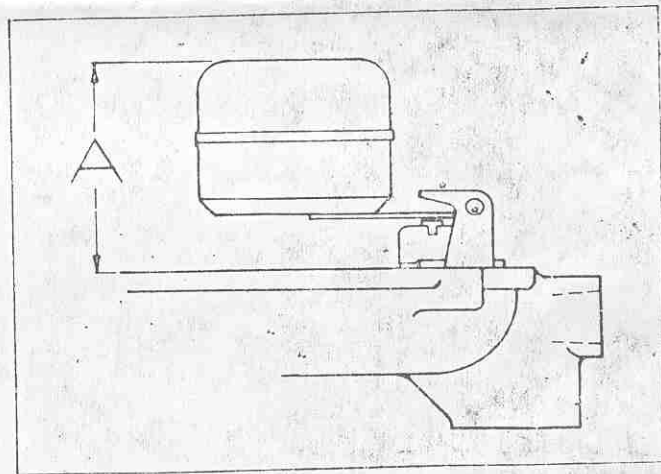
1. Insert packing (46) in open side of packing retainer (30) and place assembly on C161-72-1 bushing driver with packing facing small end of driver.
2. Insert small end of driver into choke shaft hole; start retainer into counter bore in body and lightly drive retainer into body until flush with machined surface.

3. Insert choke shaft (37) or choke shaft and lever (36), as the case may be, into the air intake and install choke plate (48) in same position in air intake with poppet valve facing the same way as it was before disassembly.
4. Align holes in plate with holes in shaft and install choke plate screws (49), leaving screws loose. Close choke for best closing and then tighten screws, using a small screwdriver.
5. Install choke shaft hole plug (50) or install choke lever (34) with taper pin (35) if carburetor includes lever.
6. Place choke bracket (31) in position on air intake with bracket aligned to scribe marks and attach bracket with screws (33) and lockwashers (32).
7. Place choke lever (38) on choke shaft, close choke and position lever to align with scribe marks. Then assemble choke shaft nut (40) and lockwasher (41) and securely tighten nut, using C161-25 wrench.
8. Attach choke lever spring (42) to choke bracket and to choke lever.
9. Install main discharge jet (52) and fiber washer (51) in fuel bowl and tighten jet firmly, using C161-9 jet wrench.
10. Install well vent jet (53) in fuel bowl and tighten, using a small screwdriver.
11. Place fiber washer (27) on main jet (26) and install jet in threaded opening at side of fuel bowl, using C161-83 jet wrench.
12. Install main jet adjustment (24) and fiber washer (25) or main passage plug (23), as the case may be, in threaded passage at side of fuel bowl, using 1/2" wrench.

#### ASSEMBLY OF THROTTLE BODY

1. Insert packing (9) in open side of packing retainer (10) and place assembly on C161-72-1 bushing driver with packing facing small end of driver.
2. After inserting small end of driver into throttle shaft hole, start retainer into counter-bore in throttle body and lightly drive retainer into body until flush with machined surface or slightly below surface to avoid striking throttle lever.
3. Insert throttle shaft and lever assembly (14) in throttle body. Rotate shaft to wide open; then insert throttle plate (3) in shaft and rotate to closed position, holding plate in position with fingers. Make certain beveled sides of plate fit against throttle bore when plate is closed.
4. Start throttle plate screws (2), leaving screws loose. Close throttle plate several times, making sure plate is centered in throttle bore. Then tighten screws, using small screwdriver.
5. Install idle adjusting needle (5) and friction spring (4) in threaded passage at side of throttle body. Turn needle in lightly against its seat, then back out needle 1-1/4 turns as a preliminary adjustment.
6. Install idle jet (16) in machined surface of throttle body, using a small screwdriver.

7. Install fuel valve seat (20) and fiber washer (19), using C161-82 wrench.
8. Install venturi (54) in throttle bore, large opening end first. Then place new bowl to body gasket (21) on machined surface of throttle body, making sure venturi flange is set in throttle body recess below gasket.
9. Install fuel valve needle (20) in seat and position float assembly (18) in hinge bracket.
10. Insert float axle through hinge bracket and float lever bushing from side opposite slot in hinge bracket with fingers only. Then press float axle (17) through slotted side of bracket, using handle of screwdriver.
11. To insure correct fuel level in the float chamber, check distance "A" from top of floats to machined surface of throttle body (no gasket) with throttle body inverted. This dimension should be 1-5/32" plus or minus 1/32". To increase or decrease distance from top of float bodies to machined surface, use long nose pliers and bend lever close to float body.



NOTE: Do not bend, twist or apply pressure on the float bodies. The float bodies when viewed from the free end of the bodies must be centered and at right angles to the machined surface and must move freely on the float axle.

#### ASSEMBLY OF THROTTLE AND FUEL BOWL BODIES

1. Place fuel bowl assembly in position on throttle body, being careful not to damage floats. Then align holes in fuel bowl with holes in gasket and throttle body.
2. Install four bowl to body screw and lockwasher assemblies (28) and tighten screws securely, using screwdriver.
3. Install hex head plug (7) and filter screen (if used) in threaded passage in throttle body, using C161-10 wrench.
4. With throttle held in closed position, turn throttle stop screw (15) in until stop screw just contacts throttle stop and then turn stop screw 1 X 1-1/2 additional turns as a preliminary idle speed setting.