



# REPLACEMENT CARBURETOR REPAIR KIT FOR HOLLEY CARBURETORS

Instructions may vary from model to model.

## DISASSEMBLY

1. Disassemble the carburetor by the fuel bowl and air-intake-throttle body and separate parts by these two groups.
2. Clean all metal parts thoroughly in a commercial cleaning solution. Blow out all parts and passages with air pressure. Housing needs to be inspected for damage, burrs, warpage, or excessive wear.

**CAUTION: DO NOT CLEAN NON-METALLIC PARTS IN P & D METALCENE OR SPEEDCENE.**

## REASSEMBLY

Use the reverse order from disassembly.

### Fuel Body Assembly

1. Use a hammer to install shaft hole plug in choke shaft hole.
2. Install choke bracket, bracket attaching screws and lockwashers.
3. Install choke shaft and lever assembly. Rotate shaft until cut out section faces out.
4. Start choke plate into place (poppet valve stem and spring facing into air intake). Center choke plate in closed position and start choke plate screws into place. When plate is properly centered, tighten screws securely.
5. Install choke lever spring to return choke to wide open position.
6. Install fiber washer and main jet in threaded hole at bottom of fuel bowl.
7. Install well vent jet in fuel bowl. Tighten, using small screwdriver.
8. Install fiber washer and discharge jet in large threaded passageway below fuel bowl.
9. Install drain plug in threaded passage at fuel bowl bottom.
10. Install main passage plug with fiber washer. When main jet adjustment is used, back out adjusting screw two or three turns before installing.

### Throttle Body Assembly

1. Insert throttle shaft packing into throttle shaft hole and lightly drive packing into body flush with machined surface or slightly below surface to avoid interference with throttle lever.
2. Insert stop assembly and throttle lever in throttle body. Rotate throttle shaft to wide open position and insert throttle plate on shaft. Rotate to closed position and hold plate closed with fingers.
3. Start throttle plate screws and leave screws loose. Center throttle plate in throttle bore and tighten throttle plate screws securely.
4. Install throttle shaft hole plug in side opposite throttle lever. Drive plug in flush with face of boss.
5. Install idle adjusting needle and friction spring in threaded passage at side of throttle body. Turn idle needle lightly against seat. Back out needle 1-1/4 turns for a preliminary setting.
6. Install idle jet in counter-bored passage of machined surface.
7. Install fuel valve seat and fiber washer.
8. Position new throttle body to bowl gasket on machined surface of throttle body. Install fuel valve needle in seat and place float assembly in hinge bracket.
9. Insert float pin through hinge bracket at side opposite slot and guide pin through float bushing. Press pin through slotted end of bracket.
10. Check distance "A" from top of floats to machined surface of throttle body without gasket, inverting throttle body as shown. The dimension should be 1-5/32" plus or minus 1/32".
11. Insert venturi in throttle body bore, large opening first, and position so that flat side will be toward well vent jet when carburetor is assembled.

### Bowl Body To Throttle Body Assembly

1. Place fuel bowl assembly on throttle body assembly. Be careful not to damage floats. Align screw holes in fuel bowl with gasket holes and throttle body.
2. Start all bowl to body screws and lockwashers. Tighten screws uniformly and securely.
3. Hold throttle lever in closed position. Turn throttle stop screw in until it just contacts the stop pin. Turn screw IN 1-1/2 additional turns as a preliminary idle speed adjustment.