

Printed in U. S. A.

**SPECIAL INSTRUCTIONS
FOR
NEEDLE & SEAT REPLACEMENT**

The Needle and Seat Assembly in this carburetor kit contains two fuel needles for service.

Fuel Needle Selection —

Assemble Needle and Seat removed from carburetor, then select appropriate replacement needle to make new assembly of same overall length.

NOTE: If incorrect needle is used, float cannot be installed properly.

INSTRUCTION SHEET

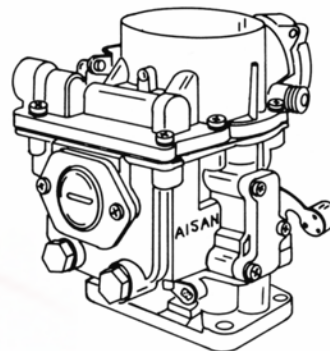
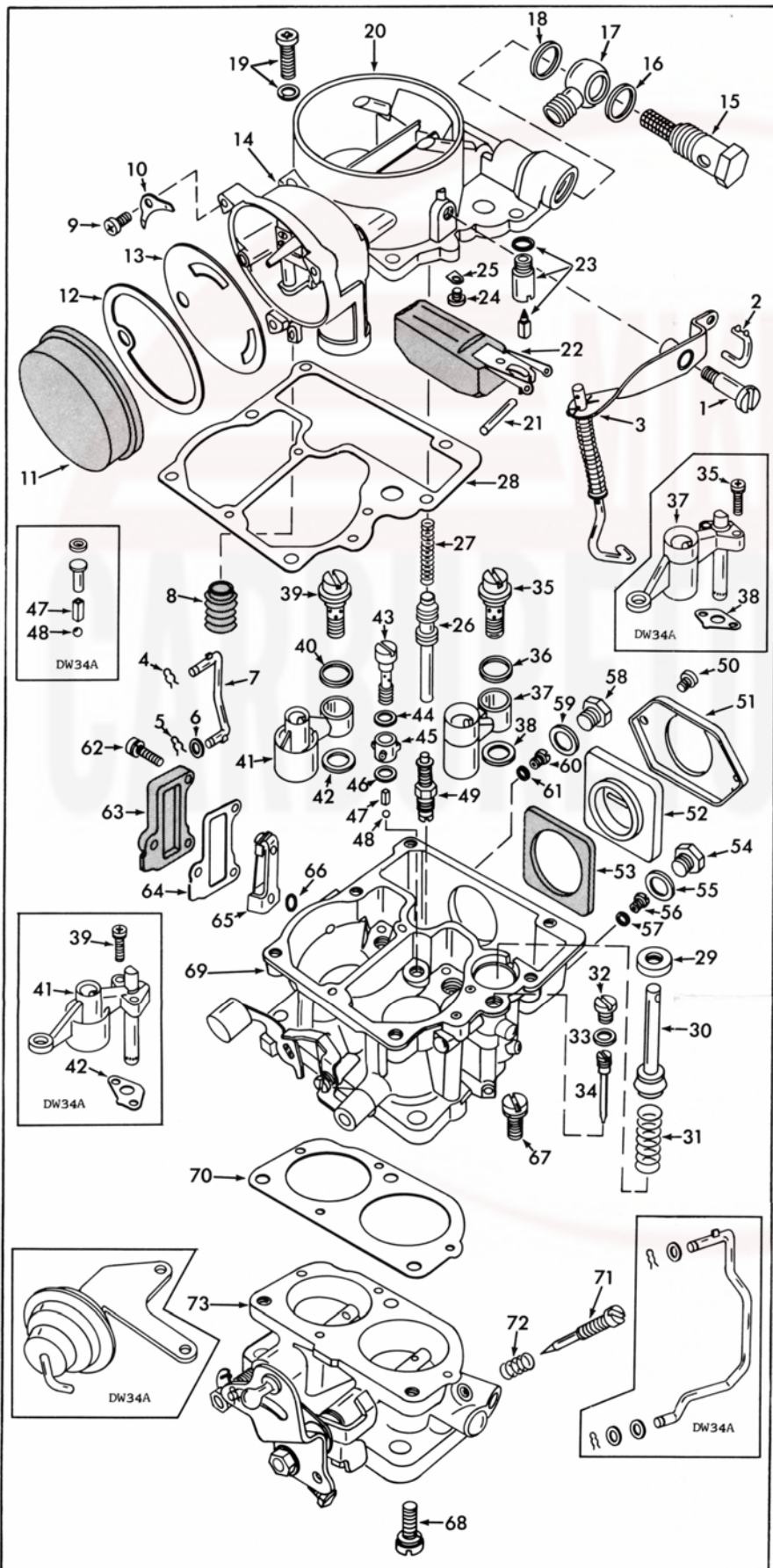
OFF VEHICLE CARBURETOR SERVICE

AISAN - 2 BORE

50-418

GENERAL EXPLODED VIEW

THE GENERAL DESIGN AND PARTS SHOWN WILL VARY TO INDIVIDUAL UNITS COVERED ON THIS INSTRUCTION SHEET.



DISASSEMBLY

USE EXPLODED VIEW AS A GUIDE. THE NUMERICAL SEQUENCE MAY GENERALLY BE FOLLOWED TO DISASSEMBLE UNIT FAR ENOUGH TO PERMIT CLEANING AND INSPECTION. NOTE: IF FOUND NECESSARY TO REPLACE CHOKE HOUSING GASKET, (14) BE SURE TO FILE OFF PEENED END OF CHOKE VALVE SCREWS BEFORE REMOVING.

NOMENCLATURE

REF. NO.	REF. NO.
1. SCREW-PUMP ARM	38. GASKET LOWER-PRIMARY VENTURI
2. LINK-PUMP	39. SCREW-SECONDARY VENTURI
3. LEVER & CONNECTING ROD-PUMP	40. GASKET UPPER-SECONDARY VENTURI
4. RETAINER-UPPER FAST IDLE LINK	41. VENTURI-SECONDARY
5. RETAINER-LOWER FAST IDLE LINK	42. GASKET LOWER-SECONDARY VENTURI
6. WASHER-FAST IDLE LINK	43. SCREW-PUMP JET
7. LINK-FAST IDLE	44. GASKET UPPER-PUMP JET
8. BOOT-FAST IDLE ROD	45. JET-PUMP
9. SCREW (3)-STAT COVER RETAINER	46. GASKET LOWER-PUMP JET
10. RETAINER (3)-STAT COVER	47. WEIGHT-PUMP DISCHARGE CHECK BALL
11. STAT COVER	48. BALL-PUMP DISCHARGE CHECK
12. GASKET-STAT COVER	49. POWER VALVE ASSY.
13. PLATE-CHOKE BAFFLE	50. SCREW (2)-FUEL BOWL WINDOW RETAINER
14. GASKET-CHOKE HOUSING (NOT SHOWN)	51. RETAINER-FUEL BOWL WINDOW
15. BOLT-UNION NIPPLE	52. WINDOW-FUEL BOWL
16. WASHER-UNION NIPPLE	53. GASKET-FUEL BOWL WINDOW
17. NIPPLE-UNION	54. PLUG-PRIMARY JET
18. WASHER-UNION NIPPLE	55. GASKET-PRIMARY JET PLUG
19. SCREW & LOCKWASHER (6)-BOWL COVER	56. JET-PRIMARY MAIN
20. BOWL COVER	57. GASKET-PRIMARY MAIN JET
21. PIN-FLOAT LEVER	58. PLUG-SECONDARY JET
22. FLOAT & LEVER ASSY.	59. GASKET-SECONDARY JET PLUG
23. NEEDLE, SEAT & GASKET ASSY.	60. JET-SECONDARY MAIN
24. SCREW & LOCKWASHER-POWER PISTON RETAINER	61. GASKET-SECONDARY MAIN JET
25. RETAINER-POWER PISTON	62. SCREW & LOCKWASHER (3)-IDLE COMP. VALVE COVER
26. PISTON-POWER	63. COVER-IDLE COMP. VALVE
27. SPRING-POWER PISTON	64. GASKET-IDLE COMP. VALVE COVER
28. GASKET-BOWL COVER	65. VALVE-IDLE COMPENSATOR
29. SEAL-PUMP SHAFT	66. O-RING-IDLE COMP. VALVE
30. PUMP ASSY.	67. SCREW & LOCKWASHER (2)-THROTTLE BODY TO BOWL
31. SPRING-PUMP RETURN	68. SCREW & LOCKWASHER (1)-THROTTLE BODY TO BOWL
32. SCREW PLUG-IDLE JET PASSAGE	69. BOWL ASSY.-FLOAT
33. GASKET-SCREW PLUG	70. GASKET-THROTTLE BODY
34. JET-IDLE	71. NEEDLE-IDLE ADJUSTING
35. SCREW-PRIMARY VENTURI	72. SPRING-IDLE ADJ. NEEDLE
36. GASKET UPPER-PRIMARY VENTURI	73. THROTTLE BODY ASSY.
37. VENTURI-PRIMARY	

CLEANING

CLEANING MUST BE DONE WITH CARBURETOR DISASSEMBLED. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. USE (1) A CARBURETOR CLEANING SOLVENT, (2) LAQUER THINNER OR (3) DENATURATED ALCOHOL. MAKE CERTAIN THE THROTTLE BODY IS FREE OF ALL CARBON DEPOSITS. WASH OFF IN SUITABLE SOLVENT. BLOW OUT ALL PASSAGES IN CASTINGS WITH COMPRESSED AIR AND CHECK CAREFULLY TO INSURE THOROUGH CLEANING OF OBSCURE AREAS. CAUTION: DO NOT SOAK RUBBER OR PLASTIC PARTS IN SOLVENT, BEING CAREFUL OF PUMP SHAFT SEAL (29) AND IDLE COMPENSATOR VALVE (65) WHICH HAVE RUBBER COMPONENTS.

REASSEMBLY

REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY. NOTE SPECIAL INSTRUCTIONS AND ADJUSTMENTS.

SPECIAL INSTRUCTIONS

SEE OTHER SIDE FOR SPECIAL INSTRUCTIONS AND ADJUSTMENTS.

ADJUSTMENTS

IDLE ADJUSTING NEEDLE (71) - TURN NEEDLE IN UNTIL LIGHTLY SEATED, THEN BACK OUT 2 1/2 TURNS.

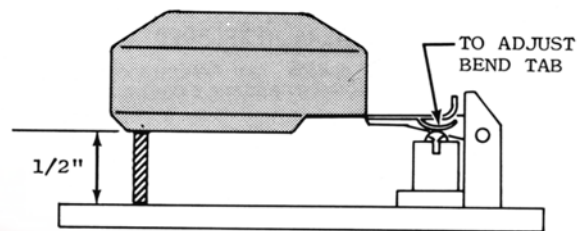
PRIMARY MAIN JET (56) - BRASS SMALL HOLE
SECONDARY MAIN JET (60) - ALUMINUM LARGE HOLE

PUMP JET (45) - INSTALL WITH LONGEST LOCATING STOP FACING FUEL BOWL.

PUMP PLUNGER (30) - REMOVE PAPER SLEEVE FROM LEATHER CUP IF USED. FLEX LEATHER OUTWARD SLIGHTLY. SOAK CUP IN GASOLINE, KEROSENE OR OIL FOR A FEW MINUTES PRIOR TO PLACING IN CARBURETOR.

SECONDARY THROTTLE VALVE ADJUSTMENT - HOLD PRIMARY THROTTLE VALVE IN WIDE OPEN POSITION. SECONDARY VALVE SHOULD ALSO BE IN WIDE OPEN POSITION. IF NECESSARY ADJUST SECONDARY OPENING LINK.

CAUTION: DO NOT EXERT PRESSURE ON RESILIENT NEEDLE VALVE.

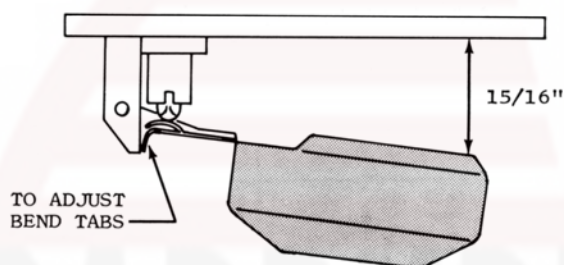


BOWL COVER INVERTED, MEASURE DISTANCE BETWEEN END OF FLOAT AND BOWL COVER.

FLOAT LEVEL ADJUSTMENT

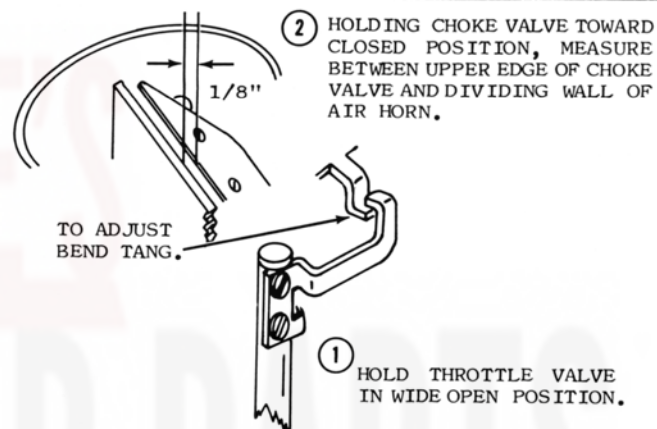
Fig. 1

FLOAT HANGING FREE, MEASURE DISTANCE BETWEEN BOWL COVER AND END OF FLOAT.



FLOAT DROP ADJUSTMENT

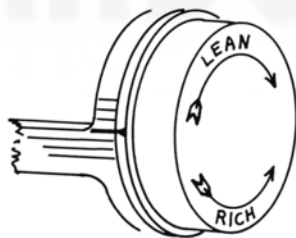
Fig. 2



UNLOADER ADJUSTMENT

Fig. 3

ALLOWABLE VARIATIONS
2 NOTCHES EITHER WAY
FROM INITIAL SETTING.

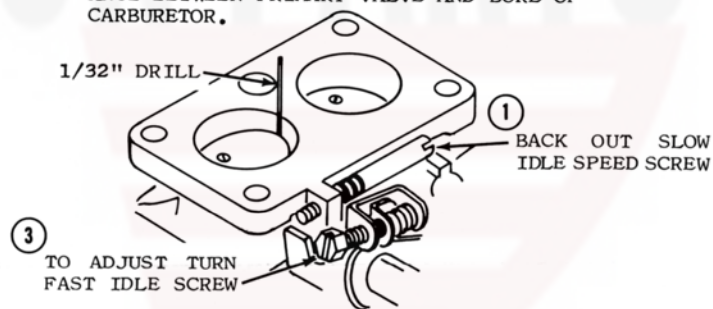


ROTATE STAT COVER AGAINST SPRING TENSION, ALIGN MARK ON COVER WITH INDEX MARK ON HOUSING.

AUTOMATIC CHOKE ADJUSTMENT

Fig. 4

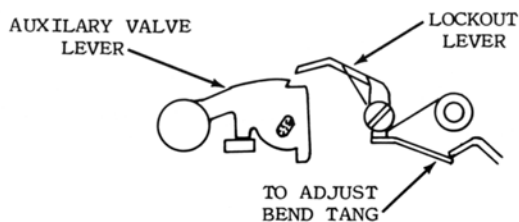
② OPEN PRIMARY THROTTLE VALVE, THEN CLOSE CHOKE VALVE TO POSITION FAST IDLE CAM. CLOSE THROTTLE VALVE AND CHECK CLEARANCE BETWEEN PRIMARY VALVE AND BORE OF CARBURETOR.



FAST IDLE ADJUSTMENT

Fig. 5

OPEN PRIMARY THROTTLE VALVE UNTIL LEVER CONTACTS SECONDARY OPENING LINK. AT THIS POINT LOCKOUT LEVER SHOULD BE FREE FROM NOTCH IN AUXILIARY VALVE LEVER.



AUXILIARY THROTTLE VALVE LOCKOUT ADJUSTMENT

Fig. 6

ENGINE AT OPERATING TEMPERATURE, CHOKE VALVE FULLY OPEN, AIR CLEANER INSTALLED. ADJUST IDLE MIXTURE SCREW (71) IN OR OUT FOR A SMOOTH IDLE, AND ADJUST IDLE STOP SCREW FOR PROPER R.P.M.

500-550 R.P.M. S/T
500-550 R.P.M. A/T IN DRIVE

NOTE: BE SURE IDLE COMPENSATOR VALVE (65) IS NOT OPEN WHEN ADJUSTING IDLE. VALVE WILL START TO OPEN WHEN TEMPERATURE AROUND CARBURETOR REACHES 140° F.

SLOW IDLE ADJUSTMENT

Fig. 7