



General Instructions

- Take lots of pictures as you take your carburetor apart. This will give you a reference of where things go.
- Using a cookie sheet with folded up sides will help keep parts from falling on the floor.
- We suggest not removing the throttle shaft, valves, or choke shaft unless they are corroded, or very dirty. These parts can be easily damaged and are difficult to re-assemble.
- Instruction sheets that come with our carburetor kits are somewhat generic. It may not match your parts exactly.
- Do NOT use WD-40 around your carburetor. It reacts with ethanol.
- Using Silicon Spray Lubricant on the gaskets will help with sticking in case you need to take the carburetor apart again.
- Be careful after taking the top of the carburetor off. Turning the carburetor upside down may cause parts to fall out and you won't know where they were.
- Screws and jets that are frozen can often be removed after heating outside the screw or jet.
- Stuck check balls can be removed by heating the outside of where the check ball resides and tapping the carburetor on the work bench.
- Do not discard any parts until complete done. You may have to refer for size, or matching.

Cleaning:

- Clean with carburetor dis-assembled.
- Soak all parts except rubber & electrical in Simple Green for 2 hours. Aluminum parts will get discolored if left longer.
- Wash parts with hot water if available to remove all chemicals.
- Blow out each passage way taking special notice of the smaller ones. Test each passage that air goes through the entire passage.
- Blow out the idle mixture hole.

- Check any hole above the idle mixture hole (inside the bore). This is the idle discharge and often becomes plugged.
- A tooth brush can facilitate cleaning parts.
- Soda blasting, then washing again will make the carburetor look good any will clean any minor deposits.
- Any corrosion, or deposits that are hard to remove may indicate the passages are also corroded and the carburetor should be replaced.
- If your engine has been sitting for 6 months or more, the gas has probably turned, and the gas tank will need to be cleaned as well as the fuel lines. Flushing new gas through the tank will not be enough.

Assembly:

- Do NOT apply any gasket sealant on any of the gaskets. Gas will break sealant part and the particles will clog the small passages.
- Test your float.
 - Brass floats should be immersed into hot water. As the air inside expands any leak will be noticeable with air bubbles.
 - Plastic, or Nitrophyl floats should be weighed. The weight is in grams. Check our technical pages for any weight specification that we may have.
- Most gaskets will fit as expected, but you may have to trim some, especially under the venturis.
- Your kit may include multiple gaskets in order to get better coverage out of the kit. Use the one that fits the best. Look for any opening the gasket may leave allowing air into the carburetor. Some holes may be casting holes that don't lead to anything and do not have to be covered.
- Mounting gaskets for multiple bore carburetors do not have to have matching holes. Example a four-barrel gasket can be open in the middle instead of 4 holes as long as the carburetor has some kind of passage between bores. The passage is between primary, or secondary, not both.
- When adjusting the float be careful not to put any pressure on the needle. The viton tip is easily damaged.
- Most idle mixture screws can be cleaned using a soft wire wheel. Inspect for any scoring, which would indicate over tightening. Screw with scoring should be replaced.

Accelerator Pumps:

- On leather cups run your finger around the inside of the cup to break any manufacturer sealant.
- Apply 2 drops of oil to cups (leather, or rubber) before inserting into carburetor. Do not soak the cup in oil. The swelling of the cup needs to happen inside the carburetor. Allow the 2 drops of oil and the gas to do its job naturally.
- Twist the pump as you are inserting to help keep the cup from curling or folding over.
- Test your accelerator pump circuit before putting the top of the carburetor back on. Our technical pages have instructions on how to do this for most carburetor types.
- Pump wells are usually slight tapered, and the pump will not seal until it gets towards the bottom.

INSTRUCTION SHEET

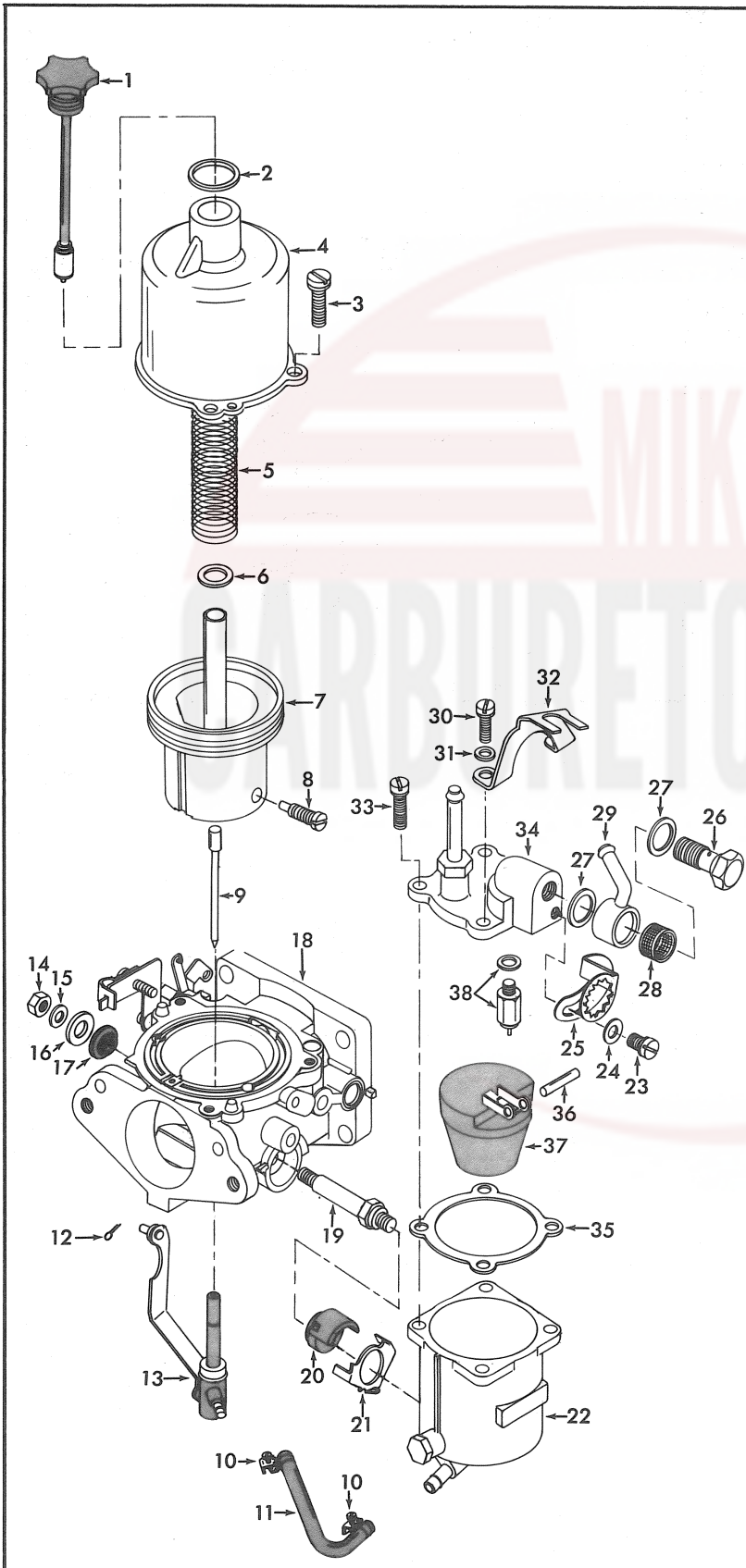
HITACHI S. U. CARBURETOR - MODEL HJG46W

(DUAL CARBURETORS)

50-483

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. ALWAYS DISASSEMBLE CARBURETORS INDIVIDUALLY AS PARTS SHOULD NOT BE INTERCHANGED. THE NUMERICAL SEQUENCE MAY GENERALLY BE FOLLOWED TO DISASSEMBLE UNIT FAR ENOUGH TO PERMIT CLEANING AND INSPECTION. CAUTION: SUCTION CHAMBER AND PISTON ASSY. ARE PRECISION MADE AND MUST NOT BE TREATED ROUGHLY. DO NOT DISASSEMBLE NOZZLE (13). RUBBER GROMMETS (17)(20) MUST BE REMOVED BEFORE SOAKING IN CARBURETOR CLEANER.

NOMENCLATURE

REF. NO.	REF. NO.
1. OIL CAP NUT ASSY.	20. ADAPTER (RUBBER) - BOWL STUD
2. GASKET - OIL CAP NUT	21. WASHER - FUEL BOWL SUPPORT
3. SCREW & LOCKWASHER (3) - SUCTION CHAMBER	22. FLOAT BOWL & COVER ASSY.
4. CHAMBER - SUCTION	23. SCREW & LOCKWASHER - BOLT CLAMP
5. SPRING - SUCTION CHAMBER	24. WASHER (FLAT) - BOLT CLAMP SCREW
6. WASHER (PLASTIC) - SUCTION PISTON	25. CLAMP - BOLT
7. PISTON - SUCTION	26. BOLT - FILTER NIPPLE
8. SCREW - NEEDLE JET LOCK	27. GASKET (2) - BOLT
9. NEEDLE - JET	28. SCREEN - FILTER
10. CLAMP (2) - FUEL PIPE	29. NIPPLE - FUEL
11. PIPE - FUEL	30. SCREW & LOCKWASHER (2) - NIPPLE BRACKET
12. COTTER PIN - CONNECTING PLATE	31. WASHER (2) FLAT - BRACKET SCREW
13. NOZZLE & CONNECTING PLATE ASSY.	32. BRACKET - NIPPLE
14. NUT - BOWL STUD	33. SCREW & LOCKWASHER (2) - BOWL COVER
15. LOCKWASHER - BOWL STUD	34. BOWL COVER ASSY.
16. FLAT WASHER - BOWL STUD	35. GASKET - BOWL COVER
17. ADAPTER (RUBBER) - BOWL STUD	36. PIN - FLOAT
18. THROTTLE BODY ASSY.	37. FLOAT & LEVER ASSY.
19. BOLT - FUEL BOWL ATTACHING	38. NEEDLE, SEAT & GASKET ASSY.

CLEANING

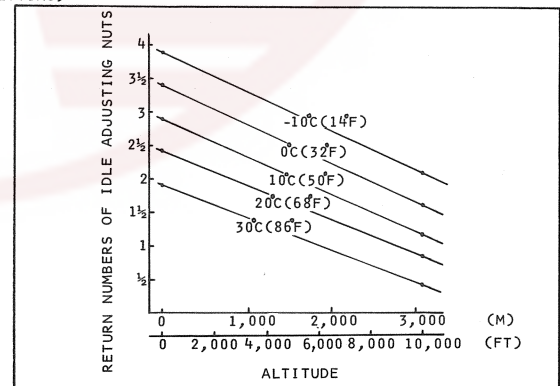
CLEANING MUST BE DONE WITH CARBURETOR COMPLETELY DISASSEMBLED. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. USE A CARBURETOR CLEANING SOLVENT. MAKE CERTAIN THE THROTTLE BORE IS FREE OF ALL CARBON AND VARNISH DEPOSITS. RINSE OFF IN SUITABLE SOLVENT. BLOW OUT ALL PASSAGES IN CASTINGS WITH COMPRESSED AIR AND CHECK CAREFULLY TO INSURE THOROUGH CLEANING OF OBSCURE AREAS. CAUTION: DO NOT SOAK PARTS CONTAINING RUBBER OR PLASTIC MATERIALS.

REASSEMBLY

REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY. NOTE SPECIAL INSTRUCTIONS AND FOLLOW NUMERICAL OUTLINE IN MAKING ADJUSTMENTS.

SPECIAL INSTRUCTIONS

BEFORE INSTALLING NOZZLE (13) - MAKE INITIAL IDLE ADJUSTMENT. TURN IDLE ADJUSTING NUT IN UNTIL IT SEATS, THEN BACK OUT NUMBER OF TURNS ARRIVED FROM CHART. (2 1/2 TURNS GENERAL SETTING)

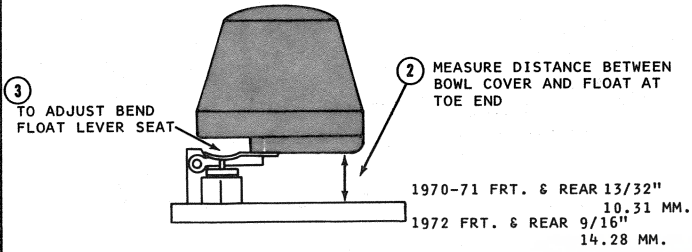


PISTON ASSY. (7) - LUBRICATE PISTON ROD LIGHTLY BEFORE INSTALLING. (LUBRICATE NO OTHER PART OF PISTON.)

ADJUSTMENTS

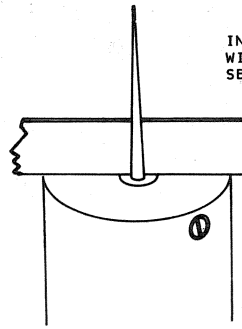
CAUTION: DO NOT EXERT PRESSURE ON RESILIENT NEEDLE.

- ① BOWL COVER INVERTED. LIFT UP THE FLOAT AND THEN SLOWLY LOWER UNTIL FLOAT LEVER SEAT JUST CONTACTS THE VALVE STEM.



FLOAT LEVEL SETTING

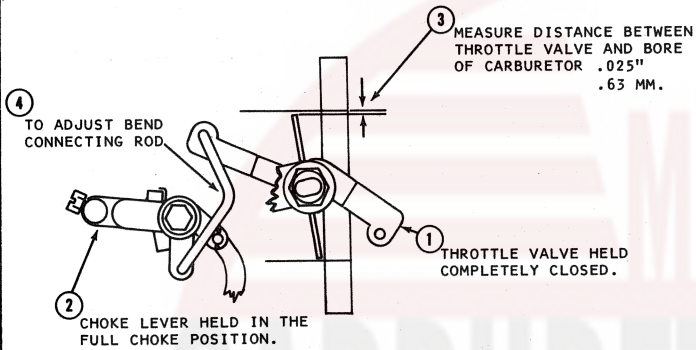
FIG. 1



INSTALL NEEDLE WITH SHOULDER OF NEEDLE FLUSH WITH FLAT SURFACE OF SUCTION PISTON. TIGHTEN SET SCREW. (DO NOT OVERTIGHTEN)

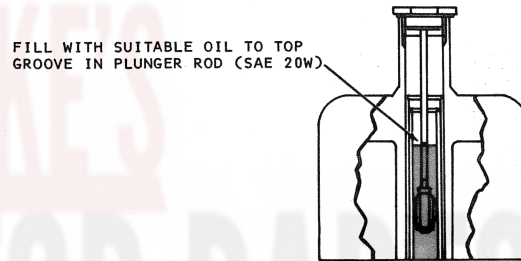
METERING NEEDLE POSITION

FIG. 2



COLD STARTING DEVICE ADJUSTMENT

FIG. 3



FILL WITH SUITABLE OIL TO TOP GROOVE IN PLUNGER ROD (SAE 20W)

HYDRAULIC DAMPER (OIL LEVEL)

FIG. 4