



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:

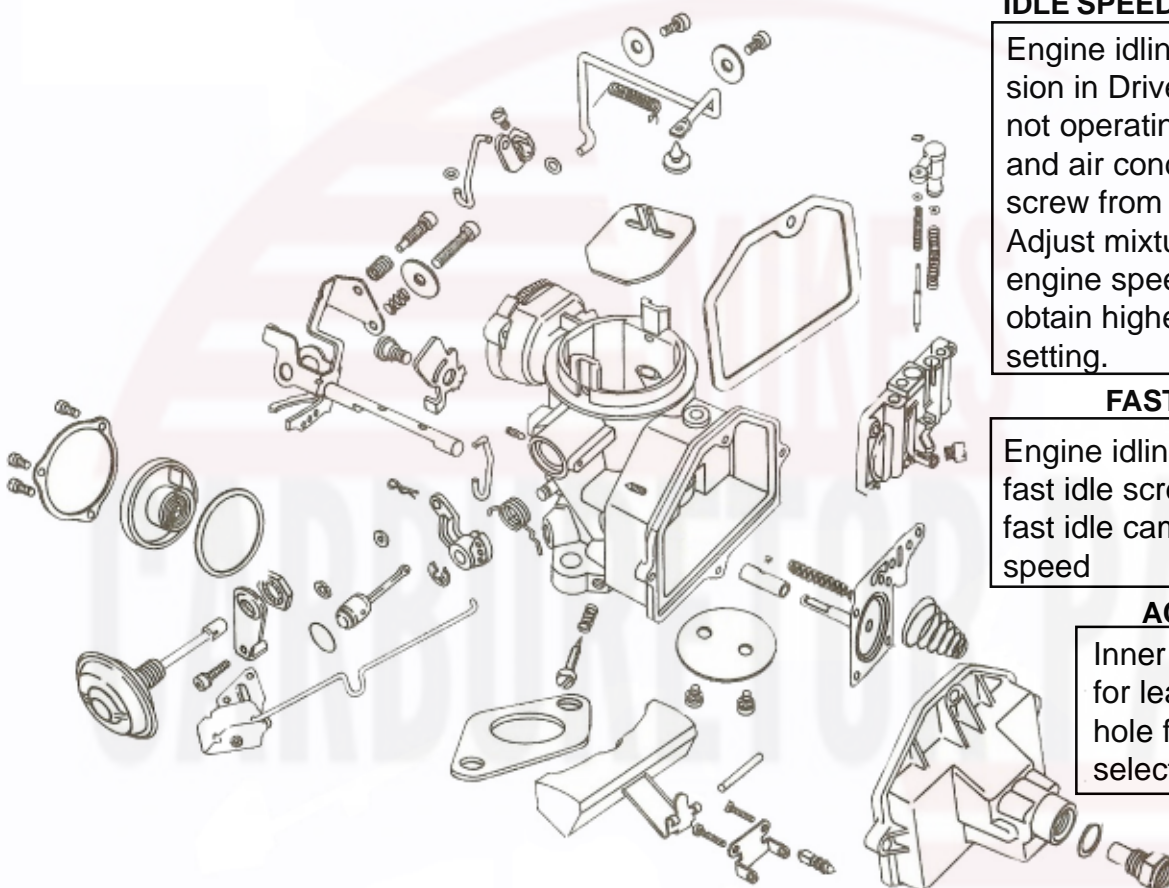
- On leather cups run your finger around the inside of the cup to break any manufacturer sealant.
- Apply 2 drops of oil to cups (leather, or rubber) before inserting into carburetor. Do not soak the cup in oil. The swelling of the cup needs to happen inside the carburetor. Allow the 2 drops of oil and 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

Holley Model 1931

CLEANING

Cleaning should be done with carburetor disassembled. Soak parts long enough to soften and remove all foreign material. Use a cleaning solvent and remove hard carbon deposits. Rinse with clean solvent and blow all passages with compressed air. Reassemble in reverse order of disassembly. When cleaning with solvent do not soak or spray rubber, plastic or electrical components. The pump assembly must be flared then soaked in clean oil for several minutes before installation. Note: The exploded view is typical and may differ slightly from carburetor being serviced and does not reflect contents of kit.



IDLE SPEED/MIXTURE ADJUSTMENT

Engine idling, normal temp, transmission in Drive, choke open, fast idle not operating, air cleaner installed and air condition OFF. Adjust idle screw from full rich to specified RPM. Adjust mixture screw clockwise until engine speed drops. Turn left to obtain highest RPM at lean best idle setting.

FAST IDLE ADJUSTMENT

Engine idling, normal temp, adjust fast idle screw to specified step of fast idle cam and proper engine speed

ACCELERATION PUMP

Inner hole for rich, middle hole for leaner mixture and outer hole for leanest, connect link to selected hole as specified.

Bowl Vent Adj.

Year	Carburetor No.	Choke Qualifying Setting	Auto Choke Setting	Idle R.P.M.		Pump Rod Setting	
				Slow	Fast ³		
66-67	R-3250A,AAS,-1A,-1AAS	3/16	Index	550 ^{4,5}	1600	Center*	
	R-3251A,AAS	3/16	1-lean		1500		
	R-3252AAS,3A,AAS	7/64	1-lean		1400		
	R-3650A,AAS	3/32	Index		1400		
64-68	R-2697A,1A,1AAS	3/16	Index	550 ^{4,5}	1400	Inner*	
	R-2880A,AAS	3/16	Index	550 ^{4,5}	1350	Center*	
	R-3199A	3/16	Index	550 ^{4,5}	1400	Center*	
	R-3200A,AAS	3/16	Index	550 ^{4,5}	1400	Inner*	
	R-3292A,AAS	3/16	Index	575 ^{4,6}	1600	Center*	
	R-3294A,AAS	3/16	Index	575 ^{4,6}	1600	Center*	
	R-3295A,AAS	3/16	1 rich	575 ^{4,6}	1600	Center*	
	R-3438A,AAS	3/16	1 rich	575 ^{4,6}	1600	Center*	
	R-3624A,AAS	3/32	Index	600 ⁶	1400	Center*	
	R-3704A,AAS	3/32	Index	600 ⁶	1400	Center*	
	R-3705A,AAS	3/32	Index	600 ⁶	1400	Center*	
	R-3706A,1A,1AAS	7/64	1 rich	525 ⁷	1500	Center*	
	R-3707A,1A,1AAS	9/64	Index	600 ⁶	1600	Center*	
	R-3708A,1A,1AAS	1/8	1 rich	525 ⁷	1400	Center*	
	R-3709A,AAS	7/64	1 rich	600 ⁶	1400	Center*	
	R-3966A,-1A,-1AAS,-2A,-2AAS	7/64	1 rich	525 ⁸	1600	Center*	
	R-3967A,-1A,-1AAS,-2A,-2AAS	7/64 ⁹	1 rich	525 ⁸	1600	Inner*	
	R-3968A,-1A,-1AAS,-2A,-2AAS	1/8	1 rich	525 ⁸	1600	Center*	
	R-3978A,AAS	9/64	1 rich	525 ⁷	1550	Inner*	
	R-4102-1A,-1AAS,-2A	9/64 ¹⁰	1 rich	525 ⁸	1600	Center*	
	69	R-4294A,AAS	1/8	1 rich	525 ⁸	1600	Outer*

