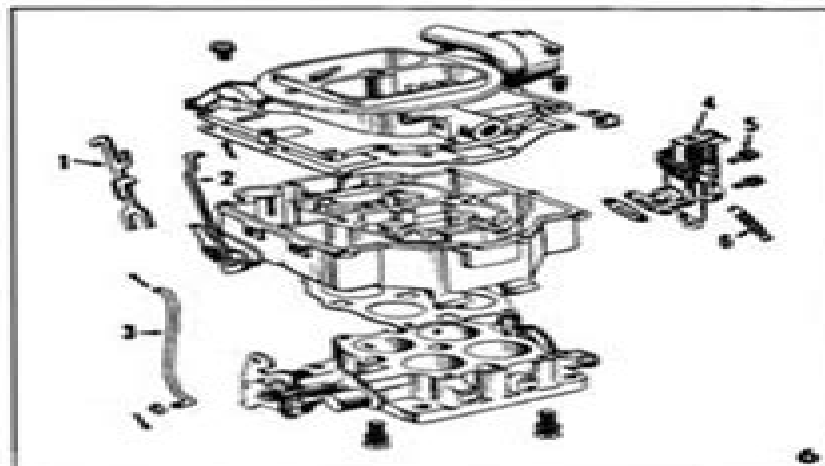
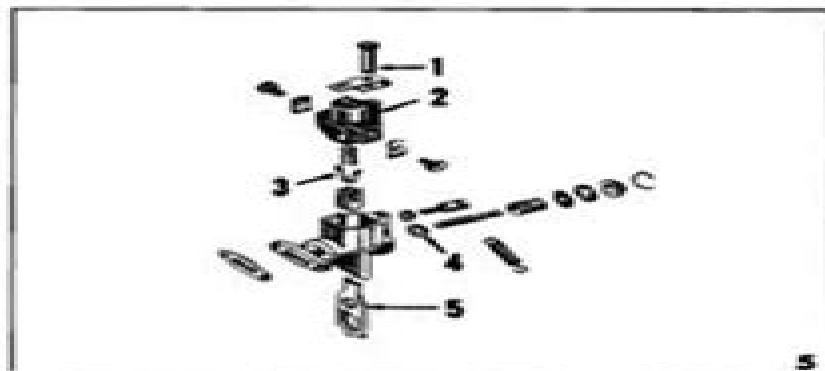
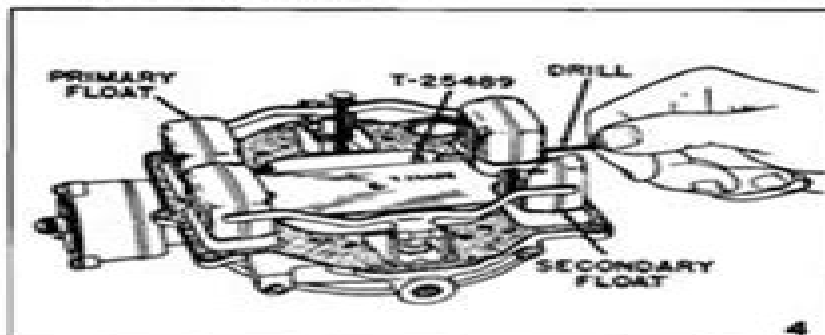


A S S E M B L Y

Attach primary needle valve to clip on primary float (stamped "522" on lever), and attach float (4) to float hanger with fulcrum pin. Tap pin at serrated end lightly to seat pin in float hanger.



Insert secondary needle valve, spring and pin in needle valve seat and attach secondary float (5) (stamped "520" on lever) to float hanger with serrated pin.

Replace vacuum power piston (6). Stake in place.

4 Adjust primary and secondary float levels as follows:
a. Place Float Gauge Tool T-25489 flat on air horn gasket with bosses of gauge in the two holes along center line of air horn. Gauge must rest flat against gasket. see Figure 4. Use #56 (5/64") drill to gauge distance between top center of primary float pontoons and gasket. When adjustment is necessary, bend float lever using Tool T-24733.

b. Use #68 (1/16") drill to gauge distance between top center of secondary float pontoons and gasket. Bend float lever as required.

c. Align floats so that sides of float pontoons are parallel with, and just clear uprights of gauge. Float must move freely with gauge in place.

Assemble spring, washer and felt on accelerating pump piston (7), see Fig. 3. Insert link end through hole in air horn and attach link to pump lever (8).

Assemble wave washer, cup washer and torsion spring on fulcrum screw (9), and attach pump lever to air horn.

5 STARTING SWITCH

Install piston end seal (4) in groove of housing. Then insert slide (5) in housing so hole in slide lines up with cylinder bore.

Assemble piston spring, piston, screen, filter, cupped washer and snap ring.

Apply Stromberg lubricant, Part No. 385093 sparingly to switch contacts.

Place contact spring (3) and contact guide spring in contact piston. Align contact points with terminal screws and insert parts in terminal cap and assemble on housing. Make certain end of slide is in slot of contact piston.

Assemble terminal cap to housing with clip and screw (1). DO NOT use excessive force when tightening screw. Seal terminal cap to switch housing with light coating of Permatex sealing compound.

6 THREE BASIC GROUPS

Invert main body, place new gasket on main body and attach throttle body to main body. Securely tighten screws.

Turn assembly over and carefully guide accelerating pump piston in pump cylinder. Place forked end of lockout slide (1) in groove of auxiliary throttle shaft. Lift air horn and assemble side fork of slide in groove of guide pin on air horn.

Attach fast idle rod (2) to choke lever and accelerating pump rod (3) to pump lever.

Align holes in air horn with main body and replace air horn attaching screw and lockwashers. Loop end of torsion spring on pump lever goes under air horn attaching screw next to pump lever. Starting switch wire clip goes under screw at opposite corner of air horn. Securely tighten all twelve screws and lockwashers.

Check fast idle linkage for free movement.

Attach starting switch assembly (4) to main body using new gasket. Spring anchor screw (5) goes in hole to right of switch. Then attach secondary throttle lever spring (6) to ear of starting lever and to spring anchor pin.

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A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the Carter Carburetor Corporation text.

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