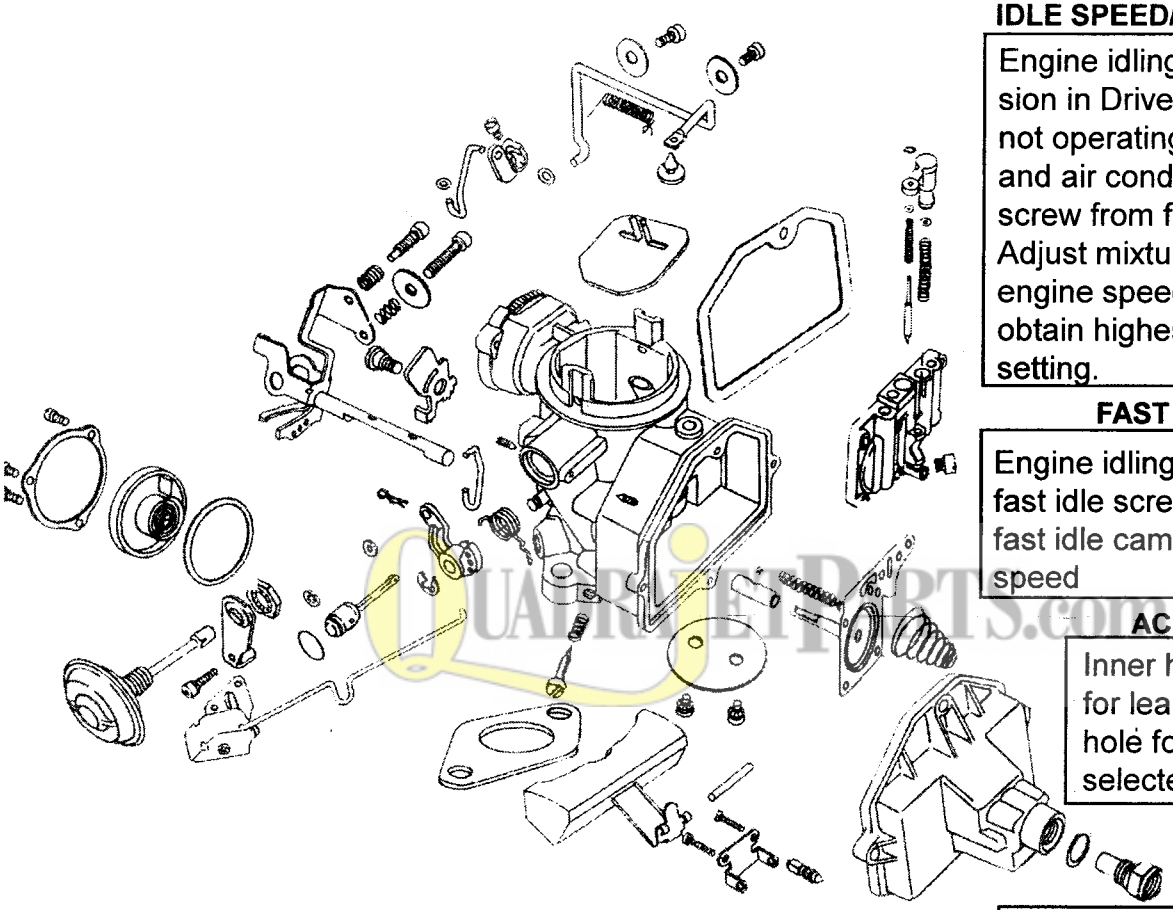
INSTRUCTION SHEET

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.

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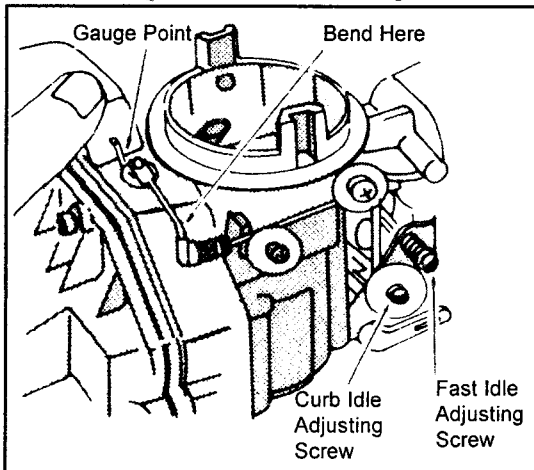
Year	Carburetor No.	Choke Qualifying Setting	Auto Choke Setting	Idle R.P.M. Slow	Idle R.P.M. Fast[3]	Pump Rod Setting
66-67	R-3250A,AAS,-1A,-1AAS	3/16	Index	550[4,6]	1600	Center*
	R-3251A,AAS	3/16	1-lean		1500	
	R-3252AAS,3A,AAS	7/64	1-lean		1400	
	R-3650A,AAS	3/32	Index		1400	
64-68	R-2697A,1A,1AAS	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*

Bowl Vent Adj.



When throttle valve is set in normal idle position, distance between bowl vent valve and seat should be 1/16" (5/64" on all -2A carbs). Adjust by bending vent rod at horizontal section above float bowl.