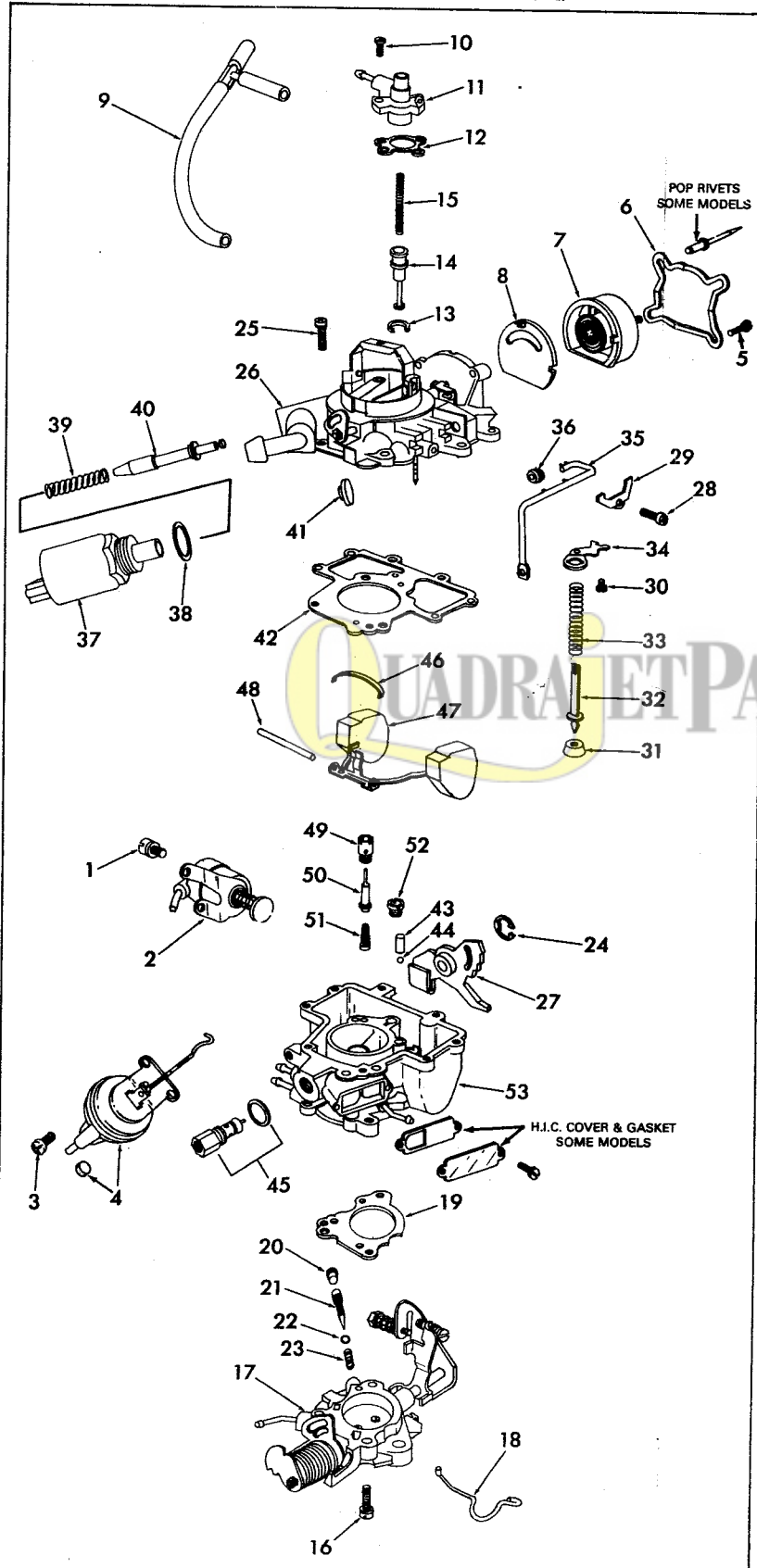


INSTRUCTION SHEET

HOLLEY CARBURETOR- MODEL 1946

50-581-3

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



DISASSEMBLY

USE THE EXPLODED VIEW AS A GUIDE. THE NUMERICAL SEQUENCE MAY GENERALLY BE FOLLOWED TO DISASSEMBLE UNIT FAR ENOUGH TO PERMIT CLEANING AND INSPECTION. WHEN POP RIVETS ARE USED ON CHOKE COVER RETAINER, DRILL RIVET HEAD JUST ENOUGH TO COME LOOSE FROM RIVET BODY. USING A SMALL PUNCH, DRIVE REMAINING RIVET OUT OF HOLE.
REMOVE STAKING FROM POWER PISTON HOUSING FOR EASY REMOVAL OF POWER PISTON RETAINING WASHER (13).
TO REMOVE TAMPER RESISTANT IDLE MIXTURE PLUG (20) AND CHOKE PULLDOWN MOTOR PLUG (4A), CENTER PUNCH AND DRILL A 3/32" DIA. HOLE THROUGH THE HARDENED STEEL PLUG. INSTALL AN EASY-OUT INTO THE HOLE AND REMOVE PLUG. BEFORE REMOVING IDLE MIXTURE NEEDLE USING THE PROPER WRENCH, TURN IDLE ADJUSTING NEEDLE IN COUNTING THE NUMBER OF TURNS IT TAKES TO LIGHTLY SEAT THE NEEDLE (RECORD FOR REASSEMBLY).
TO REMOVE VENT VALVE STEM (40), PULL IT OUT OF THE RUBBER VENT VALVE (41). MAIN WELL TUBE IS NOT REMOVABLE. TAKE EXTREME CARE NOT TO BEND OR DAMAGE TUBE.

NOMENCLATURE

REF. NO.	REF. NO.
1. SCREW & LOCKWASHER (2)- SOLENOID	26. BOWL COVER ASSY.
2. SOLENOID ASSY.- ANTI DIESEL	27. CAM- FAST IDLE
3. SCREW (2)- CHOKE PULLDOWN ASSY.	28. SCREW- PUMP ROD CLAMP
4. CHOKE PULLDOWN, PLUG & LINK ASSY.	29. CLAMP- PUMP ROD
5. SCREW (4)- CHOKE COVER RETAINER	30. SCREW- SPRING RETAINER PLATE
6. RETAINER- CHOKE COVER	31. CUP- PUMP
7. ELECTRIC CHOKE COIL ASSY.	32. STEM- PUMP
8. CHOKE INDEX SPACER	33. SPRING- PUMP
9. HOSE- POWER VALVE	34. PLATE- PUMP SPRING RETAINER
10. SCREW & LOCKWASHER (2)- VAC. PISTON HOUSING.	35. ROD- PUMP OPERATING
11. HOUSING- POWER PISTON	36. GROMMET- PUMP ROD
12. GASKET- VAC. PISTON HOUSING	37. SOLENOID- BOWL VENT
13. RETAINER- VAC. POWER PISTON	38. GASKET- BOWL VENT SOLENOID
14. PISTON- VAC. POWER	39. SPRING- VENT VALVE STEM
15. SPRING- VAC. POWER PISTON	40. STEM- VENT VALVE
16. SCREW & LOCKWASHER (3)- THROTTLE BODY.	41. VALVE- VENT
17. THROTTLE BODY ASSY.	42. GASKET- BOWL COVER
18. LINK- PUMP OPERATING	43. WEIGHT- PUMP DISC. BALL
19. GASKET- THROTTLE BODY	44. BALL- PUMP DISC.
20. PLUG- IDLE ADJ. NEEDLE	45. NEEDLE, SEAT & GASKET ASSY.
21. NEEDLE- IDLE ADJUSTING	46. RETAINER- FLOAT PIN
22. O-RING- IDLE ADJ. NEEDLE	47. FLOAT ASSY.
23. SPRING- IDLE ADJ. NEEDLE	48. PIN- FLOAT HINGE
24. RETAINER (RE-CLIP)- FAST IDLE CAM	49. JET- POWER VALVE
25. SCREW & LOCKWASHER (7)- BOWL COVER	50. STEM- POWER VALVE
	51. SPRING- POWER VALVE
	52. JET- MAIN
	53. BOWL ASSY.

CLEANING

CLEANING MUST BE DONE WITH CARBURETOR DISASSEMBLED. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. USE A CARBURETOR CLEANING SOLVENT. MAKE CERTAIN THE THROTTLE BORES ARE FREE OF ALL CARBON AND VARNISH DEPOSITS. RINSE OFF IN A 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 SOLENOIDS (2)-(37), CHOKE PULLOFF (4), ELECTRIC CHOKE ASSY. (7), FLOAT(47), OR PARTS MADE OF RUBBER IN CLEANING SOLVENT.

REASSEMBLY

REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY. NOTE SPECIAL INSTRUCTIONS AND FOLLOW NUMERICAL OUTLINE IN MAKING ADJUSTMENTS NECESSARY FOR CARBURETOR BEING SERVICED.

SPECIAL INSTRUCTIONS

VENT VALVE (41) — TO INSTALL, DROP VENT VALVE INTO PLACE, LUBE END OF VENT VALVE STEM (40), CAREFULLY INSERT THE STEM INTO THE HOLE OF THE VALVE AND PUSH STEM UNTIL IT SNAPS INTO THE SEAT OF THE VALVE.

PUMP SPRING (33) — INSTALL WITH SMALL END TOWARDS PUMP CUP.

BOWL COVER SCREWS (25) — TORQUE TO 20—INCH LBS.

IDLE ADJ. NEEDLE (21)- TURN IN UNTIL LIGHTLY SEATED. THEN BACK OUT NUMBER OF TURNS RECORDED ON DISASSEMBLY. (INSTALL PLUG (20) AFTER COMPLETING ALL RUNNING IDLE ADJUSTMENTS ON CAR.)

THROTTLE BODY SCREWS (16) — TORQUE TO 30—INCH LBS.

VACUUM POWER PISTON RETAINER (13) — LIGHTLY STAKE CASTING AROUND WASHER.

ELECTRIC CHOKE COIL ASSY. (7)- HAS A FIXED SETTING, IS NOT ADJUSTABLE. INSTALL POP RIVETS IN PROPER HOLES, ON UNITS WHERE RIVETS WERE REMOVED.

NOTICE

THE INFORMATION AND SPECIFICATIONS CONTAINED HEREIN ARE BASED ON LATEST PRODUCT INFORMATION AVAILABLE AT THE TIME OF PUBLICATION. THE RIGHT IS RESERVED TO MAKE CHANGES AT ANY TIME WITHOUT NOTICE.

PLEASE REFER TO THE ENGINE DECAL, SERVICE SPECIFICATIONS AND TECHNICAL BULLETINS FOR REVISIONS TO THIS INFORMATION.

ADJUSTMENTS

① FLOAT BOWL INVERTED AND FLOAT PIN HELD IN PLACE FIRMLY BY PRESSING ON FLOAT PIN RETAINER. A STRAIGHT EDGE HELD ACROSS SURFACE OF FLOAT BOWL AT TOE END OF FLOATS. LOWES: POINT ON THE FLOAT SHOULD JUST TOUCH STRAIGHT EDGE.

② STRAIGHTEN BY BENDING THE FLOAT ARMS, IF NECESSARY. (RECHECK THE FLOAT LEVEL ADJUSTMENT.)

③ FLOAT BOWL RIGHT SIDE UP. FLOAT SHOULD MOVE FREELY UP AND DOWN WITHOUT CONTACTING THE FUEL BOWL WALLS.

④ TO ADJUST BEND FLOAT TANG.

DRY FLOAT LEVEL ADJUSTMENT

FIG. 1

① PLACE LINK IN PROPER SLOT OF THROTTLE RETURN SPRING ARM.

② MEASURE LENGTH OF PUMP LINK AS SHOWN.

③ TO ADJUST BEND LOOP OF PUMP LINK.

PUMP STROKE ADJUSTMENT

FIG. 2

② APPLY LIGHT CLOSING PRESSURE TO CHOKE VALVE. (MODULATOR SPRING COMPRESSED)

③ MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND AIR HORN WALL.

④ TO ADJUST TURN SCREW

⑤ INSTALL PLUG. STAKE FLUSH TO .010 BELOW SURFACE.

CHOKE PULLDOWN ADJUSTMENT

FIG. 3

② HOLD CHOKE VALVE TOWARD THE CLOSED POSITION, MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND AIR HORN WALL.

③ TO ADJUST BEND FAST IDLE ROD

① PLACE FAST IDLE SCREW ON SECOND HIGHEST STEP OF FAST IDLE CAM AGAINST HIGH STEP.

FAST IDLE CAM POSITION ADJUSTMENT

FIG. 4

① THROTTLE HELD IN THE WIDE OPEN POSITION.

② CHOKE VALVE HELD TOWARD THE CLOSE POSITION. MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND AIR HORN WALL.

④ TO ADJUST BEND UNLOADER TANG.

CHOKE UNLOADER ADJUSTMENT

FIG. 5

CURB IDLE SCREW (CONTACTS SOLENOID)

SLOW IDLE SPEED SCREW.

SPRING

O-RING

IDLE MIXTURE SCREW

PLUG

TO ADJUST SLOW & CURB IDLE FOLLOW CAR SHOP MANUAL & ENGINE DECAL INFORMATION & SPECIFICATIONS.

CURB AND SLOW IDLE SPEED ADJUSTMENT

FIG. 6

ADJUSTMENT DATA TABLE

YEAR	APPLICATION FORD PRODUCTS	DRY FLOAT LEVEL	PUMP ADJUSTMENT ROD SLOT	ROD LENGTH	CHOKE PULLDOWN SETTING	FAST IDLE CAM SETTING	CHOKE UNLOADER SETTING
1980	200" ENG. CALIF. CARB. NO. E0BE-AAA, ZA	FIG. 1	1	2.25/64"	.115"	.090"	.150"
	200" ENG. 49S	FIG. 1	2	2.25/64"	.100"	.070"	.150"
	CARB. NO. E0BE-AA, CA, AMA, ALA	FIG. 1	2	2.25/64"	.110"	.070"	.150"
	CARB. NO. E0ZE-DA, EA CARB. NO. E0ZE-FA, GA, BAA, BBA	FIG. 1	2	2.25/64"	.120"	.086"	.150"
1981	200" ENG. 50 S	FIG. 1	2	2.25/64"	.113"	.082"	.150"
	CARB. NO. E1BE-AFA, AKA, E1BE-ARA, ASA	FIG. 1	2	2.25/64"	.120"	.086"	.150"
	CARB. NO. E1BE-AGA	FIG. 1	2	2.25/64"	.100"	.070"	.150"
	200" ENG. CANADA	FIG. 1	2	2.25/64"	.100"	.070"	.150"
	CARB. NO. E0BE-AA, CA CARB. NO. E0ZE-BAA, BBA	FIG. 1	2	2.25/64"	.120"	.086"	.150"
	200" ENG. 50 S	FIG. 1	2	2.25/64"	.110"	.078"	.150"
1982	CARB. NO. E2BE-BA, CA	FIG. 1	2	2.25/64"	.110"	.078"	.150"
	200" ENG. CANADA	FIG. 1	2	2.25/64"	.110"	.078"	.150"
	CARB. NO. E2BE-HA, JA	FIG. 1	2	2.25/64"	.120"	.086"	.150"
	E2BE-EA	FIG. 1	2	2.25/64"	.110"	.078"	.150"
	200" ENG. ALTITUDE	FIG. 1	2	2.25/64"	.110"	.078"	.150"
	CARB. NO. E2BE-SA, TA	FIG. 1	2	2.25/64"	.110"	.078"	.150"
1983	200" ENG. 49S	FIG. 1	2	2.32"	.105"	.078"	.150"
	CARB. NO. E3DE-CA, DA	FIG. 1	2	2.29/2"	.105"	.078"	.150"
	200" ENG. CALIF.	FIG. 1	2	2.25/64"	.105"	.078"	.150"
	CARB. NO. E3SE-AA, BA	FIG. 1	2	2.25/64"	.105"	.078"	.150"

① PLACE FAST IDLE SCREW ON SECOND HIGHEST STEP OF FAST IDLE CAM AGAINST HIGH STEP.

② ENGINE RUNNING ADJUST FAST IDLE SCREW TO PROPER R.P.M.

(CHECK INFORMATION ON ENGINE DECAL).

FAST IDLE ADJUSTMENT

FIG. 7