

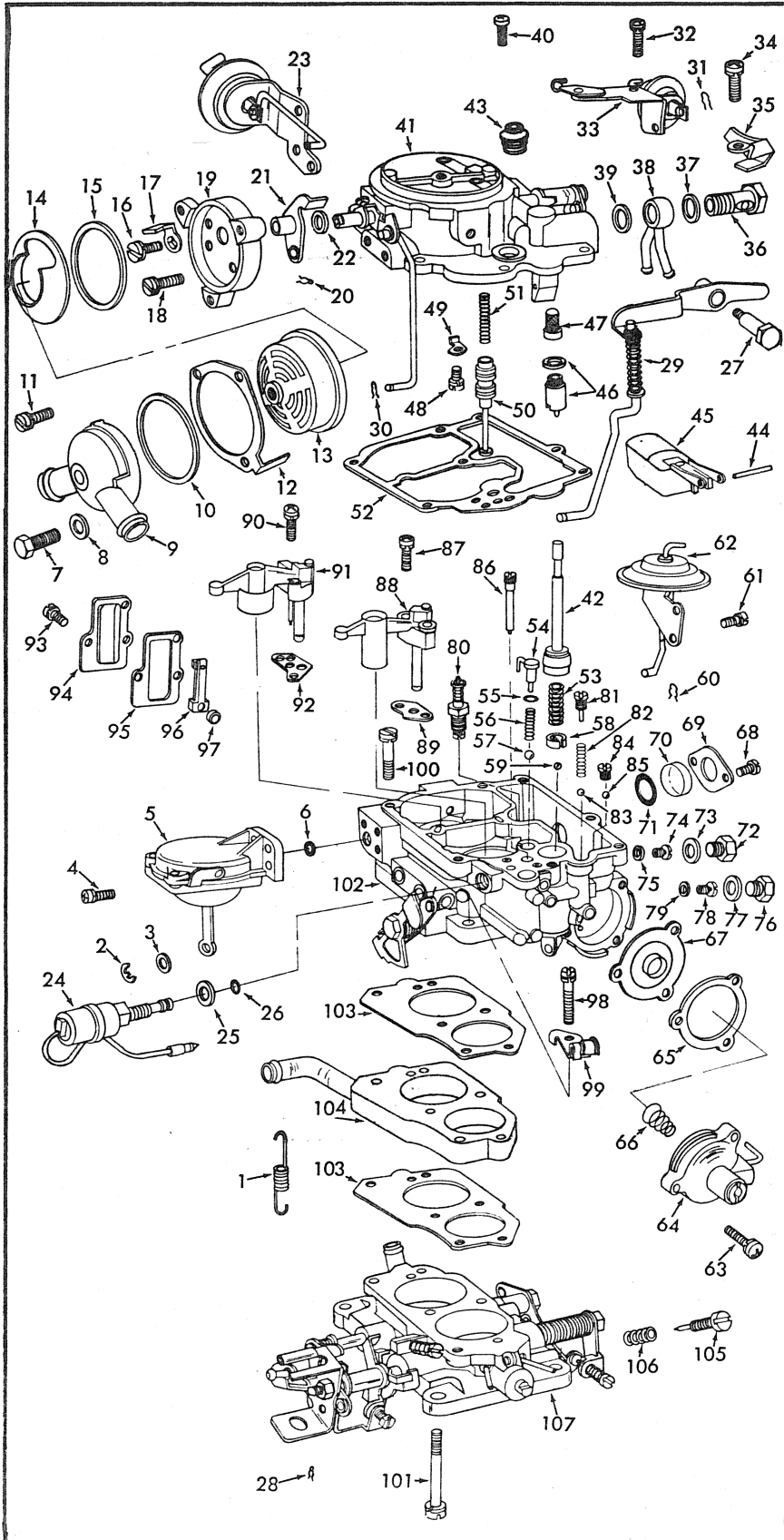
INSTRUCTION SHEET

AISAN CARBURETOR (20 R ENGINE)

50-518-2

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. THE NUMERICAL SEQUENCE MAY GENERALLY BE FOLLOWED TO DISASSEMBLE UNIT FAR ENOUGH TO PERMIT CLEANING AND INSPECTION. NOTE: DISSASSEMBLY OF SECONDARY VACUUM UNIT IS NOT NECESSARY UNLESS DIAPHRAGM IS BEING REPLACED. INSULATOR BLOCK (104) HAS BONDED GASKETS ON EACH SURFACE, IT WILL BE NECESSARY TO CAREFULLY SCRAPE OFF OLD GASKETS FROM BLOCK BEFORE REASSEMBLY.

NOMENCLATURE

REF. NO.	REF. NO.
1. SPRING- SEC. THROTTLE RETURN.	54. JET- PUMP.
2. RETAINER- SEC. DIAPHRAGM LINK.	55. O-RING- PUMP JET.
3. WASHER- SEC. DIAPHRAGM LINK.	56. SPRING- PUMP DISC. BALL.
4. SCREW, LOCK & FLAT WASHER (2)- SEC. DIAPH. ASSY.	57. BALL- PUMP DISC. (LARGE).
5. SECONDARY DIAPHRAGM ASSY.	58. RETAINER- INTAKE BALL.
6. GASKET- SEC. DIAPHRAGM ASSY.	59. BALL- PUMP INTAKE CHECK (SMALL).
7. BOLT- CHOKE WATER COVER.	60. RETAINER- THROTTLE POSITIONER LINK.
8. GASKET- BOLT	61. SCREW & LOCKWASHER (2)- THROTTLE POSITIONER.
9. COVER- CHOKE WATER HSG.	62. THROTTLE POSITIONER ASSY.
10. GASKET- COVER.	63. SCREW & LOCKWASHER (3)- AUX. PUMP COVER.
11. SCREW & LOCKWASHER (3)- CHOKE COIL RETAINER.	64. COVER- AUX. PUMP.
12. RETAINER- CHOKE COIL ASSY.	65. GASKET- COVER.
13. CHOKE COIL ASSY.	66. SPRING- AUX. PUMP DIAPHRAGM.
14. SHIELD- CHOKE COIL.	67. DIAPHRAGM- AUX. PUMP.
15. GASKET- SHIELD.	68. SCREW (2)- RETAINER SIGHT GLASS.
16. SCREW, FLAT & LOCK WASHER- CHOKE SHAFT ARM.	69. RETAINER- SIGHT GLASS.
17. ARM- CHOKE SHAFT.	70. SIGHT GLASS.
18. SCREW & LOCKWASHER (3)- CHOKE HOUSING.	71. O-RING- SIGHT GLASS SEAL.
19. HOUSING- CHOKE	72. PLUG- SEC. MAIN JET.
20. RETAINER- CHOKE PULL OFF LINK.	73. GASKET- PLUG.
21. LEVER- CHOKE PULL OFF LINK.	74. JET- SEC. MAIN (CROME).
22. WASHER- LEVER SPACER.	75. GASKET- SEC. MAIN JET.
23. CHOKE PULL OFF ASSY.	76. PLUG- PRI. MAIN JET.
24. SOLENOID- IDLE CUT OFF.	77. GASKET- PLUG.
25. GASKET- SOLENOID.	78. JET- PRI. MAIN. (BRASS).
26. O-RING- SOLENOID.	79. GASKET- PRI. MAIN JET.
27. BOLT- PUMP LEVER.	80. POWER VALVE ASSY.
28. RETAINER- PUMP ROD.	81. PLUG- AUX. PUMP CHECK BALL SPRING.
29. LEVER & CONNECTING ROD ASSY- PUMP.	82. SPRING- AUX. PUMP CHECK BALL.
30. RETAINER- FAST IDLE ROD.	83. BALL- AUX. PUMP DISC. CHECK.
31. RETAINER- AUX. PULL OFF LINK.	84. PLUG- AUX. PUMP CHECK BALL.
32. SCREW & LOCKWASHER (2)- AUX. PULL OFF ASSY.	85. BALL- AUX. PUMP INTAKE CHECK.
33. AUX. PULL OFF ASSY.	86. JET- IDLE.
34. SCREW & LOCKWASHER- FUEL PIPE STOP.	87. SCREW & LOCKWASHER (2)- PRI. VENTURI.
35. STOP- FUEL INLET PIPE.	88. PRIMARY VENTURI ASSY.
36. BOLT- FUEL INLET PIPE.	89. GASKET- PRI. VENTURI.
37. GASKET- BOLT.	90. SCREW & LOCKWASHER (2)- SEC. VENTURI.
38. FUEL INLET PIPE.	91. SECONDARY VENTURI ASSY.
39. GASKET- FUEL PIPE.	92. GASKET- SEC. VENTURI.
40. SCREW & LOCKWASHER (4)- BOWL COVER.	93. SCREW & LOCKWASHER (3)- COVER.
41. BOWL COVER ASSY.	94. COVER- IDLE COMPENSATOR.
42. PUMP PLUNGER ASSY.	95. GASKET- COVER.
43. BOOT- PUMP PLUNGER.	96. VALVE- IDLE COMPENSATOR.
44. PIN- FLOAT.	97. GASKET- IDLE COMPENSATOR VALVE.
45. FLOAT ASSY.	98. SCREW & LOCKWASHER- WIRE CLAMP.
46. NEEDLE & SEAT ASSY.	99. CLAMP- WIRE.
47. SCREEN- NEEDLE SEAT FILTER.	100. SCREW & LOCKWASHER- THROTTLE BODY.
48. SCREW & LOCKWASHER- PISTON RETAINER.	101. SCREW & LOCKWASHER- THROTTLE BODY (HOLLOW).
49. RETAINER- POWER PISTON.	102. FLOAT BOWL ASSY.
50. PISTON- POWER VALVE.	103. GASKET (2)- THROTTLE BODY.
51. SPRING- POWER PISTON.	104. INSULATOR- THROTTLE BODY.
52. GASKET- BOWL COVER.	105. NEEDLE- IDLE ADJUSTING.
53. SPRING- PUMP RETURN.	106. SPRING- IDLE ADJ. NEEDLE.
	107. THROTTLE BODY ASSY.

CLEANING

CLEANING MUST BE DONE WITH CARBURETOR DISASSEMBLED. USE A CARBURETOR CLEANING SOLVENT. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. MAKE CERTAIN THE THROTTLE BORES ARE FREE OF ALL CARBON DEPOSITS. WASH 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 RUBBER PARTS IN CLEANING SOLVENTS, BEING VERY CAREFUL OF DIAPHRAGM ASSY'S (5), (23), (33), (62), SOLENOID (24), FLOAT (45) AND IDLE COMPENSATOR VALVE (96) WHICH HAVE RUBBER COMPONENTS.

REASSEMBLY

REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY, NOTE SPECIAL INSTRUCTIONS AND ADJUSTMENTS.

ADJUSTMENTS

SPECIAL INSTRUCTIONS

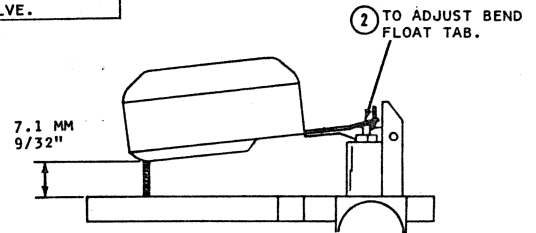
IDLE ADJUSTING NEEDLE (105)-TURN NEEDLE IN UNTIL LIGHTLY SEATED, THEN BACK OUT 2 1/4 TURNS.

PUMP PLUNGER (42)-REMOVE PAPER SLEEVE FROM LEATHER CUP, FLEX LEATHER OUTWARD SLIGHTLY. SOAK CUP IN LIGHT OIL A FEW MINUTES PRIOR TO PLACING IN CARBURETOR.

SIGHT GLASS (70)-INSTALL WITH DOT TO THE INSIDE OF FUEL BOWL.

CHOKE COIL COVER (13)-WHEN INSTALLING BE SURE LOOP ON COIL SPRING IS PLACED ON ARM OF CHOKE SHAFT. ROTATE CHOKE COVER AGAINST SPRING TENSION. ALIGN MARK ON COVER WITH INDEX MARK ON HOUSING.

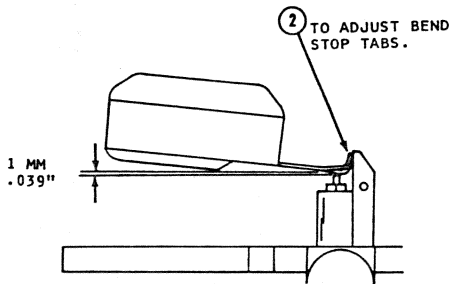
CAUTION: DO NOT EXERT PRESSURE ON RESILIENT NEEDLE VALVE.



- ① BOWL COVER INVERTED, FLOAT RESTING ON NEEDLE OF ITS OWN WEIGHT. MEASURE DISTANCE BETWEEN FLOAT AT TOE END AND CASTING SURFACE.
- ② TO ADJUST BEND FLOAT TAB.

1975-80-TOYOTA
DRY FLOAT LEVEL ADJUSTMENT.

FIG. 1.

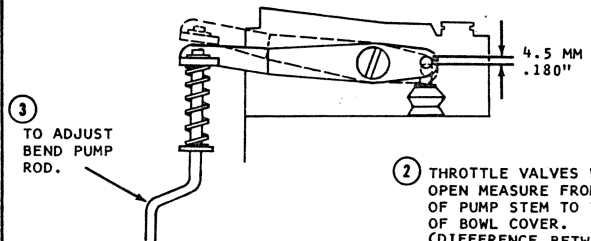


- ① BOWL COVER INVERTED. RAISE FLOAT BY HAND UNTIL IT CONTACTS FLOAT HANGER. MEASURE DISTANCE BETWEEN NEEDLE VALVE AND FLOAT TAB.
- ② TO ADJUST BEND STOP TABS.

1975-80-TOYOTA
FLOAT DROP ADJUSTMENT.

FIG. 2.

- ① THROTTLE VALVES CLOSED MEASURE FROM TOP OF PUMP STEM TO TOP OF BOWL COVER.



- ② THROTTLE VALVES WIDE OPEN MEASURE FROM TOP OF PUMP STEM TO TOP OF BOWL COVER. (DIFFERENCE BETWEEN THE TWO MEASUREMENTS IS THE TOTAL STROKE TRAVEL.)
- ③ TO ADJUST BEND PUMP ROD.

1975-80-TOYOTA
PUMP ADJUSTMENT.

FIG. 3.

1975-80-TOYOTA



ROTATE CHOKE COVER AGAINST SPRING TENSION. SET MARK ON CHOKE COVER TO INDEX MARK ON CHOKE HOUSING:

AUTOMATIC CHOKE ADJUSTMENT

FIG. 4

- ④ MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND INSIDE AIR HORN WALL.
- ③ LIGHTLY HOLD CHOKE VALVE TOWARDS CLOSED POSITION. DO NOT PULL DIAPHRAGM OFF ITS SEAT.
- ⑤ TO ADJUST BEND TAB ON RELIEF LEVER.
- ① PLACE FAST IDLE ARM ON HIGH STEP OF FAST IDLE CAM.
- ② APPLY OUTSIDE VACUUM SOURCE TO SEAT DIAPHRAGM.

1975-76-4.7MM-.186"
1977 -5.5MM-.220"
1978-80 CHECK CHOKE VALVE ANGLE(38)DEGREES FROM BORE.

VACUUM BREAK ADJUSTMENT

FIG. 5

- ③ LIGHTLY HOLD CHOKE VALVE TOWARDS CLOSED POSITION. DO NOT PULL DIAPHRAGM OFF ITS SEAT.
- ④ MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND INSIDE AIR HORN WALL.
- ⑤ TO ADJUST BEND ROD.
- ① PLACE FAST IDLE ARM ON HIGH STEP OF FAST IDLE CAM.
- ② APPLY OUTSIDE VACUUM SOURCE TO SEAT DIAPHRAGM.

1975-76-2.8MM-.112"
1977 -2.8MM-.112"
1978-80 CHECK CHOKE VALVE ANGLE(50)DEGREES FROM BORE.

AUXILIARY CHOKE OPENER ADJUSTMENT

FIG. 6

- ① HOLD THROTTLE LEVER IN WIDE OPEN POSITION.
- ② HOLD CHOKE VALVE TOWARDS CLOSED POSITION. MEASURE BETWEEN UPPER EDGE OF CHOKE VALVE AND INSIDE AIR HORN WALL.
- ③ TO ADJUST BEND TANG.

1975-77-2.8MM-.112"
1978-80 CHECK CHOKE VALVE ANGLE(50)DEGREES FROM BORE.

UNLOADER ADJUSTMENT

FIG. 7