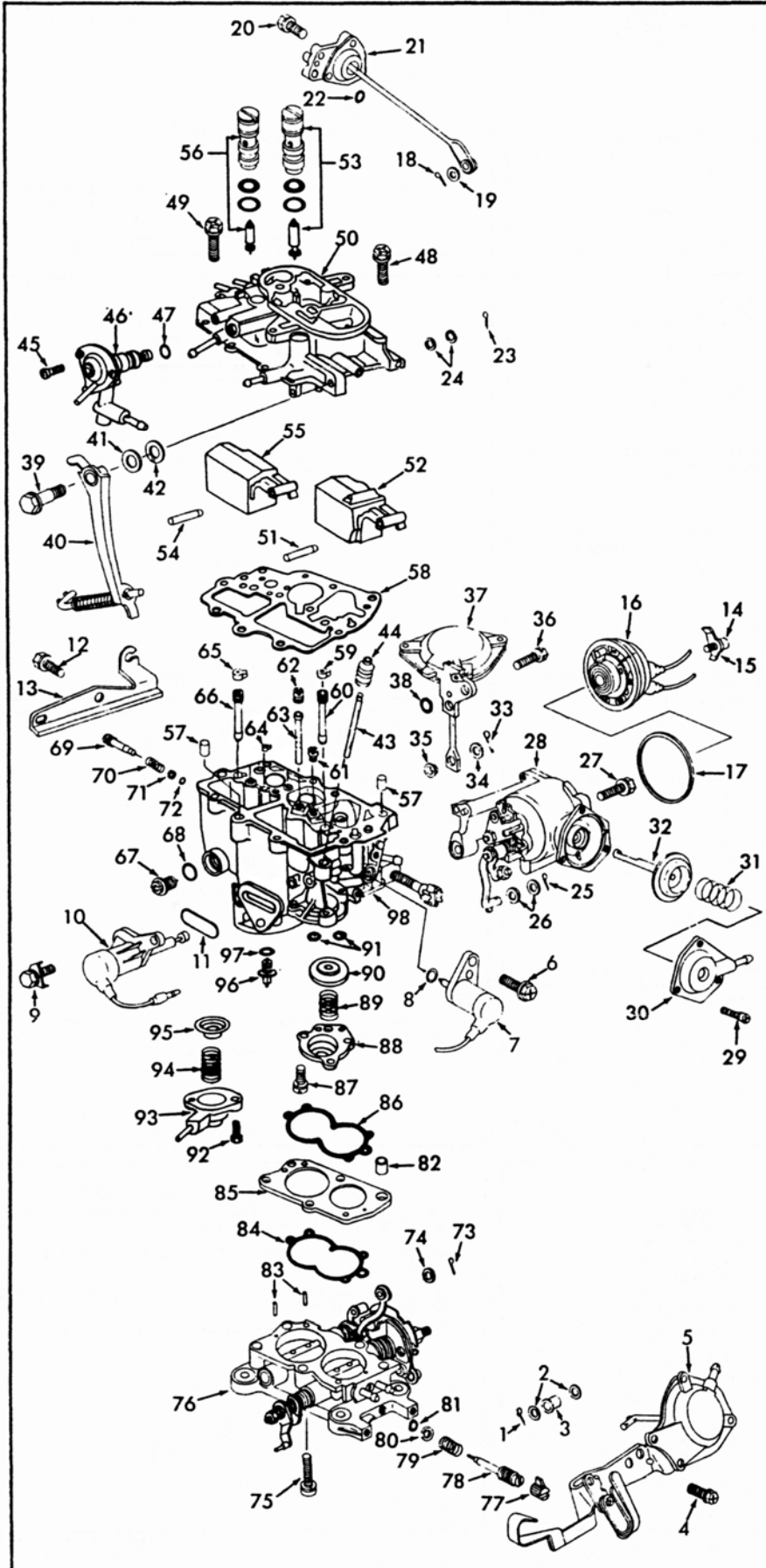


INSTRUCTION SHEET OFF VEHICLE CARBURETOR SERVICE (HONDA) KEIHIN CARBURETOR

50-599-2

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: TO REMOVE FLOAT PINS (51), (54), CAREFULLY SUPPORT SHORT BOSS (FLOAT PIN SUPPORT) USING 1/16" PIN PUNCH & HAMMER, TAP PIN TOWARDS SHORT BOSS. INSIDE END HAS A TAPER WHICH FITS SNUG IN LONG BOSS. RECORD SIZES OF JETS AND TUBES (BELOW) FOR PROPER REASSEMBLY. AUXILIARY IDLE MIXTURE NEEDLE (69) BEFORE REMOVING. TURN IN COUNTING THE NUMBER OF TURNS IT IS FROM THE SEATED POSITION. IDLE LIMITER CAP (77) CAN BE CAREFULLY PULLED OFF IDLE ADJUSTING NEEDLE (WILL BE USED OVER).

NOTE: CHOKE COVER REMOVAL (WITH POP RIVETS). USE A 5/32" DRILL. DRILL OUT RIVETS AND REMOVE THE RETAINER RING. BE SURE TO RETAIN THE GEAR IN THE CHOKE COVER AND THE CASE. LINKAGE COVER REMOVAL USE A 3/16" DRILL TO DRILL OUT RIVETS

NOMENCLATURE

REF. NO.	REF. NO.
1. COTTER PIN-T.C. ROD	48. SCREW, LKWSHR. & FLAT WASHER (2)-BOWL COVER (LOCATOR PIN HOLES)
2. WASHER (2)-T.C. ROD	49. SCREW & LKWSHR. (8)-BOWL COVER
3. BUSHING-T.C. ROD	50. BOWL COVER ASSY.
4. SCREW & LKWSHR. (2)-BRACKET T.C.	51. PIN-MAIN FLOAT
5. THROTTLE CONTROLLER DIAPH. ASSY.	52. FLOAT-MAIN
6. SCREW & LKWSHR.-SOLENOID	53. NEEDLE & SEAT ASSY.-MAIN
7. SOLENOID-IDLE CUT OFF	54. PIN-AUXILIARY FLOAT
8. O-RING-SOLENOID MOUNTING	55. FLOAT-AUXILIARY
9. SCREW & LKWSHR. (2)-SOLENOID	56. NEEDLE & SEAT ASSY. AUXILIARY
10. SOLENOID-PRIMARY MAIN JET CUT OFF	57. PIN (2)-LOCATOR
11. O-RING-SOLENOID MOUNTING	58. GASKET-BOWL COVER
12. SCREW (2)-BRACKET	59. CAP (BLACK)-PRIMARY SLOW JET
13. BRACKET AND WIRE CLAMP ASSY.	60. JET-PRIMARY SLOW
14. SCREW & LKWSHR. (3)-RETAINER	61. JET-PRIMARY MAIN AIR BLEED
15. RETAINER (3)-CHOKE COVER	62. JET-SEC. MAIN AIR BLEED
16. CHOKE COVER ASSY.	63. TUBE-SECONDARY EMULSION
17. GASKET-CHOKE COVER	64. CAP (WHITE)-PASSAGE
18. COTTER PIN-ROD	65. CAP (WHITE)-AUXILIARY SLOW JET
19. WASHER-ROD	66. JET-AUXILIARY SLOW
20. SCREW & LKWSHR. (2)-CHOKE OPENER	67. PLUG-AUXILIARY FUEL BOWL
21. CHOKE OPENER DIAPH. ASSY.	68. O-RING-PLUG
22. O-RING-CHOKE OPENER	69. NEEDLE-AUXILIARY IDLE
23. COTTER PIN-CHOKE ROD	70. SPRING-AUX. IDLE NEEDLE
24. WASHER (2)-CHOKE ROD	71. WASHER-AUX. IDLE NEEDLE
25. COTTER PIN-FAST IDLE ROD (LOWER END)	72. O-RING-AUX. IDLE NEEDLE
26. WASHER (2)-FAST IDLE ROD	73. COTTER PIN-AUX. THROTTLE LINK
27. SCREW & LKWSHR. (2)-CHOKE HSG.	74. WASHER-AUX. THROTTLE LINK
28. CHOKE HOUSING ASSY.	75. SCREW & LKWSHR. (5)-THROTTLE BODY
29. SCREW & LKWSHR. (3)-COVER	76. THROTTLE BODY ASSY.
30. COVER-DIAPHRAGM	77. CAP-IDLE LIMITER
31. SPRING-DIAPHRAGM	78. NEEDLE-PRIMARY IDLE ADJ.
32. DIAPH. ASSY.-FAST IDLE UNLOADER	79. SPRING-IDLE ADJ. NEEDLE
33. COTTER PIN-SEC. DIAPH. ROD	80. WASHER-IDLE NEEDLE
34. WASHER-SEC. DIAPH. ROD	81. O-RING-IDLE NEEDLE
35. BUSHING-SEC. DIAPH. ROD	82. PIN-LOCATOR (LARGE)
36. SCREW & LKWSHR.-SEC. DIAPH. ASSY.	83. PIN (2)-LOCATOR (SMALL)
37. SECONDARY DIAPHRAGM ASSY.	84. O-RING-SPACER
38. O-RING-SEC. DIAPH. PASSAGE	85. SPACER-THROTTLE BODY
39. SCREW-PUMP LEVER	86. SCREW & LKWSHR. (3)-COVER
40. PUMP LEVER & ROD ASSY.	87. COVER-PUMP DIAPHRAGM
41. WASHER-LEVER SCREW	89. SPRING-DIAPHRAGM RETURN
42. LOCKWASHER-LEVER SCREW	90. DIAPHRAGM-PUMP
43. ROD-PUMP	91. O-RING (2)-PUMP PASSAGE
44. BOOT-PUMP ROD	92. SCREW & LKWSHR. (2)-COVER
45. SCREW & LKWSHR.-BOWL VENT SHUT OFF	93. COVER-POWER VALVE DIAPHRAGM
46. BOWL VENT SHUT OFF ASSY.	94. SPRING-DIAPHRAGM
47. O-RING-BOWL VENT SHUT OFF ASSY.	95. DIAPHRAGM-POWER VALVE
	96. POWER VALVE ASSY.
	97. O-RING-POWER VALVE
	98. BOWL ASSEMBLY

CLEANING

CLEANING MUST BE DONE WITH CARBURETOR DISASSEMBLED. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. DO NOT SOAK ANY ASSEMBLIES FOR A PROLONGED PERIOD OF TIME WITH PLASTIC PARTS THAT ARE NOT REMOVED. USE A CARBURETOR CLEANING SOLVENT. MAKE CERTAIN THE THROTTLE BODY IS FREE OF ALL CARBON DEPOSITS. WASH OFF IN SUITABLE SOLVENT. BLOW OUT ALL PASSAGES AND JETS IN CASTINGS WITH COMPRESSED AIR AND CHECK CAREFULLY TO INSURE THOROUGH CLEANING OF OBSCURE AREAS. CAUTION: DO NOT SOAK DIAPHRAGM OR SOLENOID ASSEMBLIES (51), (71), (101), (211), (321), (371), (461), CHOKE COVER (16), FLOATS (52), (55), OR PARTS MADE OF RUBBER IN ANY TYPE OF CLEANING SOLVENTS.

NOTE: 1982 BOWL ASSY. BE CAREFUL NOT TO LEAVE FUEL BOWL IN CLEANING SOLVENT BECAUSE OF WINDOW SEALS WHICH OR NOT REPLACEABLE.

REASSEMBLY

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

SPECIAL INSTRUCTIONS

IDLE ADJUSTING NEEDLE (78)-TO INSTALL, FIRST ASSEMBLE SPRING (79), WASHER (80), O-RING (81) ON NEEDLE. TURN NEEDLE IN UNTIL LIGHTLY SEATED THEN BACK OUT 2 TURNS. (DO NOT INSTALL IDLE LIMITER CAP AT THIS TIME). SPECIAL WRENCH FOR CALIF.

THROTTLE BODY ASSEMBLY (76)-WHEN INSTALLING IT TO BOWL ASSEMBLY BE SURE TO HOOK UP AUXILIARY THROTTLE LINK.

AUXILIARY IDLE ADJUSTING NEEDLE (69)-TO INSTALL FIRST ASSEMBLE SPRING (70), WASHER (71), O-RING (72) ON NEEDLE. TURN NEEDLE IN UNTIL LIGHTLY SEATED THEN BACK OUT NUMBER OF TURNS COUNTED ON DISASSEMBLY (IF ORIGINAL SCREW POSITION IS NOT KNOWN, TURN THE SCREW 1 3/4 TURNS OUT FROM THE SEATED POSITION).

NEEDLE & SEAT ASSEMBLIES (53), (58)-AFTER FLOAT LEVELS HAVE BEEN ADJUSTED BE SURE TO SEAL SCREW HEADS OF NEEDLE SEAT WITH A SEALER TO PREVENT TURNING.

FLOAT PINS (51), (54)-INSTALL WITH TAPERED ENDS TOWARDS LONG BOSS (CENTER OF BOWL COVER).

BOWL COVER SCREWS (48), (49)-TIGHTEN SCREWS FROM THE CENTER OUT.

CHOKE COVER ASSY. (16)-WHEN INSTALLING BE SURE LOOP END OF SPRING IS PLACED ON PIN OF LEVER.

FOLLOW SERVICE MANUAL INSTRUCTIONS TO MAKE FINAL ADJUSTMENTS ON CAR.

ADJUSTMENTS

1 BOWL COVER INVERTED, THEN TURN UP TO THE VERTICAL POSITION WITH FLOAT ARM PINS TO THE TOP FLOAT RESTING LIGHTLY ON NEEDLE (WHICH IS SPRING LOADED) DO NOT COMPRESS SPRING LOADED NEEDLE.

2 MEASURE DISTANCE FROM GASKET SURFACE OF BOWL COVER TO FLAT BOTTOM SURFACE OF FLOAT AT TOE END

3 TO ADJUST TURN NEEDLE SEAT.

NOTE: AFTER FLOATS ARE ADJUSTED, SEAL TOP OF NEEDLE SEAT WITH A SEALER TO PREVENT TURNING.

CAUTION: DO NOT EXERT PRESSURE ON RESILIENT NEEDLE VALVE.

WET FUEL LEVEL GAUGE OR CATCH TRAY IS AVAILABLE FROM DEALER GAUGE NO. 07501-6950100, CATCH TRAY 07501-6950201

38MM LARGE FLOAT

34MM SMALL FLOAT

DRY FLOAT LEVEL ADJUSTMENT **FIG. 1**

1 CURB IDLE STOP SCREW BACKED OUT. (THROTTLE VALVES COMPLETELY CLOSED)

2 PUMP LEVER MUST BE IN CONTACT WITH PUMP SHAFT.

3 MEASURE BETWEEN PUMP LEVER TANG AND STOP BRACKET.

4 TO ADJUST, BEND TANG.

DO NOT BEND THIS TANG

CLEARANCE
1980 14.5-15MM, 9/16"-19/32"
1981-83 11.5-12MM, 29/64"-31/64"

PUMP LINKAGE TRAVEL **FIG. 2**

1 OPEN THROTTLE, CLOSE CHOKE THEN CLOSE THROTTLE SETTING FAST IDLE LEVER ON HIGH STEP OF CAM. (KEEP THIS POSITION THRU THE FOLLOWING ADJUSTMENTS).

2 APPLY 85 P. S. I. AIR PRESSURE TO FITTING ON CHOKE OPENER.

3 PRESS UP LEVER "A" TOWARDS DIAPHRAGM UNTIL IT STOPS.

4 KEEPING LEVER "B" IN CONTACT WITH "A" MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND AIR HORN WALL.

5 TO ADJUST BEND LOWER ARE OF LEVER "A".

6 DISCONNECT AIR PRESSURE. PRESS UP ON LEVER "A" UNTIL STOP MAKES CONTACT WITH HOUSING

7 KEEPING LEVER "B" IN CONTACT WITH "A" MEASURE DISTANCE BETWEEN UPPER EDGE OF CHOKE VALVE AND AIR HORN WALL.

8 TO ADJUST BEND UPPER ARM OF LEVER "A".

9 HOLDING LEVER "A" AGAINST STOP. RELEASE LEVER "B" AND CHECK VALVE CLEARANCE.

10 TO ADJUST BEND UPPER ARM ON LEVER "B".

CLEARANCE STAGE 1

CLEARANCE STAGE 2

CLEARANCE STAGE 3

CHOKE OPENER ADJUSTMENT **FIG. 3**

INSTALL COVER AND ALIGN INDEX MARKS ON COVER & HOUSING. (NOTE: BE SURE LOOP ON SPRING IS IN PLACE ON LEVER PIN BUSHING)

AUTOMATIC CHOKE ADJUSTMENT **FIG. 4**

- ENGINE AT NORMAL OPERATING TEMPERATURE AND IDLE ADJUSTED (USE CAR SERVICE MANUAL PROCEDURE)
- DISCONNECT AND PLUG THE HOSE FROM FAST IDLE UNLOADER.
- ENGINE OFF, OPEN THROTTLE, CLOSE CHOKE VALVE, RELEASE THROTTLE TO SET FAST IDLE LEVER ON HIGH STEP OF FAST IDLE CAM.
- START ENGINE, DO NOT TOUCH THROTTLE RUN FOR 1 MINUTE AND CHECK R. P. M.
- TO ADJUST TURN FAST IDLE ADJUSTING SCREW

SETTING
2500 ± 500 R. P. M.

FAST IDLE ADJUSTMENT **FIG. 5**

DATE TABLE

YEAR		STAGE 1	STAGE 2	STAGE 3
1980		.68MM-.026"	1.48MM-.058"	2.05MM-.080"
1981 CIVIC				
1300/1500	50S	.95MM-.037"	1.75MM-.069"	3.83MM-.151"
1500 HI/ALT.	M/T	1.1MM-.043"	1.75MM-.069"	3.83MM-.151"
	A/T	.95MM-.037"	1.75MM-.069"	3.83MM-.151"
1982-83 CIVIC				
	M/T	1.1MM-.043"	2.02MM-.080"	4.07MM-.160"
	A/T	.95MM-.037"	2.02MM-.080"	4.07MM-.160"
1500 HI/ALT	A/T	1.1MM-.043"	2.02MM-.080"	4.06MM-.160"
1981-83 ACCORD, PRELUDE, 49S				
	M/T	1.1-.043"	1.93MM-.076"	4.07MM-.160"
	A/T	.95MM-.037"	1.93MM-.076"	4.07MM-.160"
HI/ALT.	M/T	1.25MM-.049"	1.93MM-.076"	4.31MM-.170"
	A/T	1.1MM-.043"	1.93MM-.076"	4.07MM-.160"
CALIF.	ALL/T	1.1MM-.043"	1.93MM-.076"	4.07MM-.160"

CHOKE OPENER ADJUSTMENT

1982-83 WET FLOAT LEVEL ADJUSTMENT

- CAR ON LEVEL GROUND, ENGINE AT OPERATING TEMPERATURE. SNAP THROTTLE TO 3000 R.P.M. THEN LET IT IDLE.
- WHEN FUEL LEVEL STABILIZES, CHECK FUEL LEVEL. IT SHOULD TOUCH DOT ON INSPECTION WINDOW.
- TO CHANGE LEVEL TURN NEEDLE SEAT NOT MORE THAN 1/8 TURN EVERY 15 SECONDS. REPEAT STEP 1.
- SEAL TOP OF NEEDLE SEAT WITH A SEALER TO PREVENT TURNING

1982-83 WET FLOAT LEVEL ADJUSTMENT **FIG. 6**