

OFF VEHICLE THROTTLE BODY INJECTION SERVICE ROCHESTER-MODEL 400 (CROSSFIRE T. B. I.)

CAUTION NOTES

THROTTLE ROD IS PERMANENTLY ATTACHED TO THROTTLE LEVER STUD OF REAR UNIT. DO NOT REMOVE.

REAR AND FRONT UNITS ARE NOT CALIBRATED THE SAME. FUEL METER COVER AND DIAPHRAGM ASSEMBLIES MUST NOT BE SWITCHED. FUEL INJECTORS ARE CALIBRATED DIFFERENTLY AND MUST NOT BE INTERCHANGED.

DO ONE UNIT AT A TIME TO PREVENT MIXING PARTS. USE A HOLDING FIXTURE WHEN SERVICING UNIT. IT IS POSSIBLE TO DAMAGE THE THROTTLE VALVE.

DISASSEMBLY

FUEL METER COVER & REGULATOR ASSY. (3) OR ACCUMULATOR ASSY. (3)-TO DISASSEMBLE FOLLOW THIS PROCEDURE BECAUSE OF THE LARGE SPRING UNDER HEAVY TENSION. REMOVE 2 DIAPHRAGM COVER SCREWS (4) ACROSS FROM EACH OTHER. THEN REINSTALL THEM FOR 3 TURNS. CAREFULLY REMOVE THE OTHER 2 SCREWS EVENLY TO RELEASE THE SPRING TENSION. HOLDING COVER AND HOUSING REMOVE ALL SCREWS. (DO NOT DISTURB PRESSURE ADJUSTING SCREW UNDER SPRING.)

FUEL FILTERS (13)-TO REMOVE ROTATE BACK AND FORTH PULLING FROM BASE OF INJECTOR.

THROTTLE POSITION SENSOR (24)- AN ELECTRICAL UNIT. FACTORY ADJUSTED. THROTTLE BODY ASSEMBLY CAN BE CLEANED WITHOUT REMOVING TPS IF CARE IS USED. TPS MUST NOT BE IMMERSED IN ANY TYPE OF LIQUID SOLVENT OR CLEANER.

THROTTLE POSITION SENSOR REMOVAL.

1. SCRIBE LOCATING MARKS ON SENSOR AND CARB. BODY FOR REASSEMBLY.
2. REMOVE SCREWS, LOCKWASHERS & RETAINERS.

FRONT UNIT

REF. NO.	NOMENCLATURE
1.	SCREW & LOCKWASHER (2)-FUEL METER COVER (SHORT)
2.	SCREW & LOCKWASHER (3)-FUEL METER COVER (LONG)
3.	FUEL METER COVER & ACCUMULATOR ASSEMBLY
4.	SCREW & LOCKWASHER (4)-DIAPHRAGM COVER
5.	COVER-SPRING & DIAPHRAGM
6.	RETAINER-SPRING
7.	SPRING-ACCUMULATOR DIAPHRAGM
8.	DIAPHRAGM ASSY.-ACCUMULATOR
9.	GASKET-FUEL OUTLET PASSAGE
10.	GASKET-FUEL METER COVER
11.	INJECTOR-FUEL
12.	O-RING-FUEL INJECTOR (SMALL)
13.	FILTER-FUEL INJECTOR
14.	O-RING-FUEL INJECTOR (LARGE)
15.	WASHER-O-RING BACK UP
16.	FITTING-FUEL INLET
17.	GASKET-FITTING
18.	FITTING-FUEL RETURN
19.	GASKET-FITTING
20.	SCREW & LOCKWASHER (3)-FUEL METER BODY
21.	FUEL METER BODY
22.	GASKET-FUEL METER BODY
23.	VALVE-IDLE AIR CONTROL
24.	GASKET-AIR CONTROL VALVE
25.	THROTTLE BODY ASSEMBLY

REAR UNIT

REF. NO.	NOMENCLATURE
1.	SCREW & LOCKWASHER (2)-FUEL METER COVER (SHORT)
2.	SCREW & LOCKWASHER (3)-FUEL METER COVER (LONG)
3.	FUEL METER COVER & REGULATOR ASSEMBLY
4.	SCREW & LOCKWASHER (4)-DIAPHRAGM COVER
5.	COVER-SPRING & DIAPHRAGM
6.	SPRING-PRESSURE REG. DIAPHRAGM
7.	DIAPHRAGM ASSY.-PRESSURE REGULATOR
8.	DUST SEAL-PRESSURE REGULATOR
9.	GASKET-FUEL OUTLET PASSAGE
10.	GASKET-FUEL METER COVER
11.	INJECTOR-FUEL
12.	O-RING-FUEL INJECTOR (SMALL)
13.	FILTER-FUEL INJECTOR
14.	O-RING-FUEL INJECTOR (LARGE)
15.	WASHER-O-RING BACK UP
16.	FITTING-FUEL INLET
17.	GASKET-FITTING
18.	FITTING-FUEL RETURN
19.	GASKET-FITTING
20.	SCREW & LOCKWASHER (3)-FUEL METER BODY
21.	FUEL METER BODY
22.	GASKET-FUEL METER BODY
23.	SCREW & LOCKWASHER W/RETAINER (2)-SENSOR
24.	SENSOR-THROTTLE POSITION
25.	VALVE-IDLE AIR CONTROL
26.	GASKET-AIR CONTROL VALVE
27.	THROTTLE BODY ASSEMBLY

CLEANING

CLEANING MUST BE DONE WITH UNIT DISASSEMBLED. SOAK PARTS LONG ENOUGH TO SOFTEN AND REMOVE ALL FOREIGN MATERIAL. USE A COLD IMMERSION TYPE CLEANER. MAKE CERTAIN THE THROTTLE BORES ARE FREE OF ALL CARBON AND VARNISH DEPOSITS. RINSE OFF IN A SUITABLE SOLVENT. BLOW OUT ALL PASSAGES IN THE CASTINGS WITH COMPRESSED AIR AND CHECK CAREFULLY TO INSURE THOROUGH CLEANING OF OBSCURE AREAS. CAUTION: DO NOT SOAK ELECTRICAL OR DIAPHRAGM UNITS, OR RUBBER PARTS IN ANY TYPE OF CLEANING SOLVENTS.

REASSEMBLY

REASSEMBLE IN REVERSE ORDER OF DISASSEMBLY. NOTE SPECIAL INSTRUCTIONS.

SPECIAL INSTRUCTION

IDLE AIR CONTROL VALVE-BEFORE INSTALLING CHECK PLUNGER POSITION. END OF PLUNGER IS NOT TO BE EXTENDED MORE THAN 1 1/8" FROM GASKET SURFACE OF VALVE. IF IT IS TO FAR OUT, PUSH IN ON END OF CONE UNTIL RETRACTED. INSTALL AND TIGHTEN TO 13 FT. LBS.

THROTTLE POSITION SENSOR (24)-REINSTALL ON THE THROTTLE BODY ASSEMBLY. WITH THROTTLE VALVE IN THE NORMAL CLOSED POSITION. ALIGN SCRIBE MARKS MADE ON DISASSEMBLY AND TIGHTEN SCREWS.

SCREW & LOCKWASHER INSTALLATION-SCREW FREE FROM OIL AND GREASE. USE AN ANAEROBIC THREAD LOCKING COMPOUND (SUCH AS LOCTITE 262 OR EQUIVALENT) APPLY COMPOUND TO THE FIRST 3 THREADS OF EACH SCREW. ANAEROBICS CURE AFTER THE COMPONENTS ARE ASSEMBLED. DO NOT APPLY A HIGHER STRENGTH THREAD LOCKING COMPOUND THAN RECOMMENDED.

FUEL METER BODY SCREWS-TORQUE TO 35 INCH LBS.

FUEL METER COVER SCREWS-TORQUE TO 28 INCH LBS.

INLET AND OUTLET FITTINGS-TORQUE TO 21 FT. LBS.

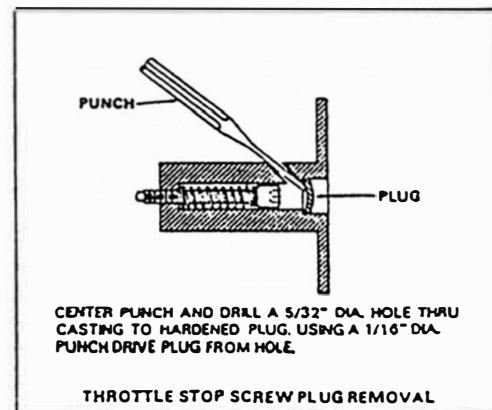
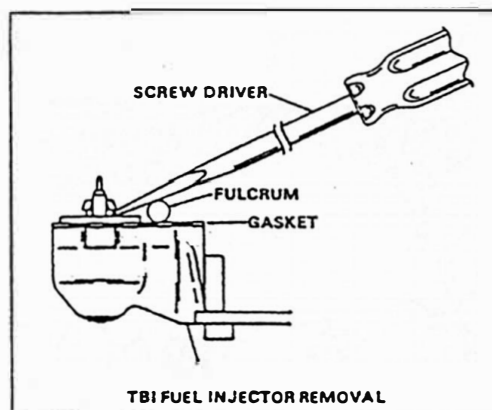
O-RINGS-LUBRICATE O-RINGS WITH AUTOMATIC TRANSMISSION OIL BEFORE INSTALLING.

FUEL FILTER-LARGE OPEN END OF FILTER FACES UP SO THAT FILTER COVERS RAISED RIB AT BASE OF INJECTOR. THEN INSTALL SMALL O-RING AGAINST FILTER

FUEL INJECTOR (11), (11)-INSTALL WASHER (15), (15) AND O-RING (14), (14) IN FUEL METER BODY (21), (21). THEN INSTALL INJECTOR BY USING A TWISTING MOTION TO CENTER NOZZLE O-RING IN INJECTOR CAVITY AND ALIGN LUG ON BASE WITH NOTCH IN FUEL METER BODY. PUSH DOWN ON INJECTOR TO INSURE IT IS FULLY SEATED IN CAVITY. PROPERLY SEATED LUG WILL BE IN NOTCH AND THE ELECTRICAL CONNECTIONS WILL BE PARALLEL TO THE THROTTLE SHAFT.

PRESSURE REGULATOR (3) OR ACCUMULATOR (3)-INSTALL GUIDE STUDS ACROSS FROM EACH OTHER. ASSEMBLE DIAPHRAGM, SPRING, AND COVER. COMPRESS SPRING AND INSTALL 2 SCREWS SNUGLY. REMOVE STUDS AND INSTALL REMAINING SCREWS, TIGHTEN SCREWS DOWN EVENLY.

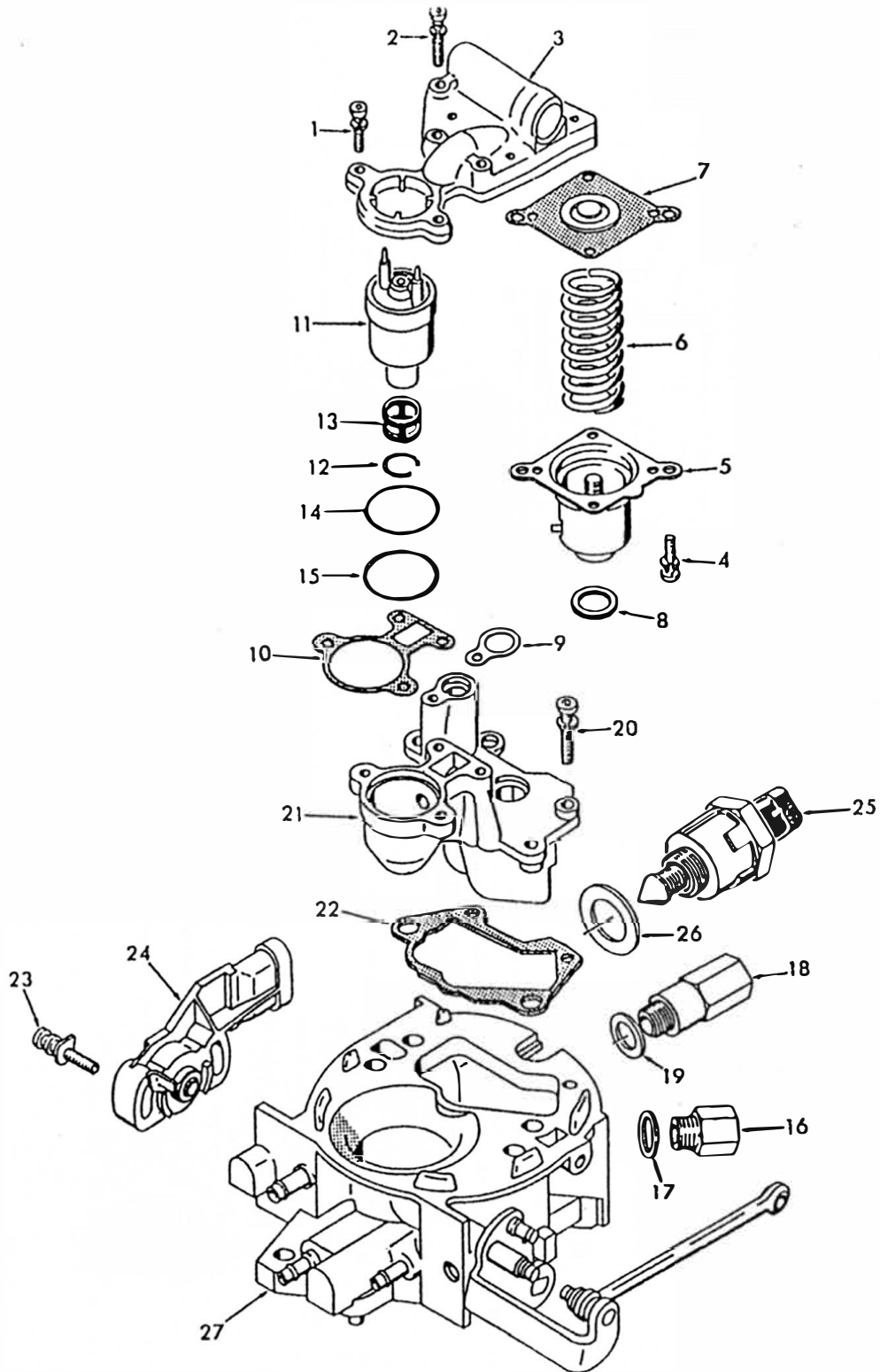
USE VEHICLE MANUFACTURER'S SERVICE MANUALS FOR "ON VEHICLE SERVICE AND ADJUSTMENTS."



CENTER PUNCH AND DRILL A 5/32" DIA. HOLE THRU CASTING TO HARDENED PLUG. USING A 1/16" DIA. PUNCH DRIVE PLUG FROM HOLE.

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

REAR UNIT



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

FRONT UNIT

