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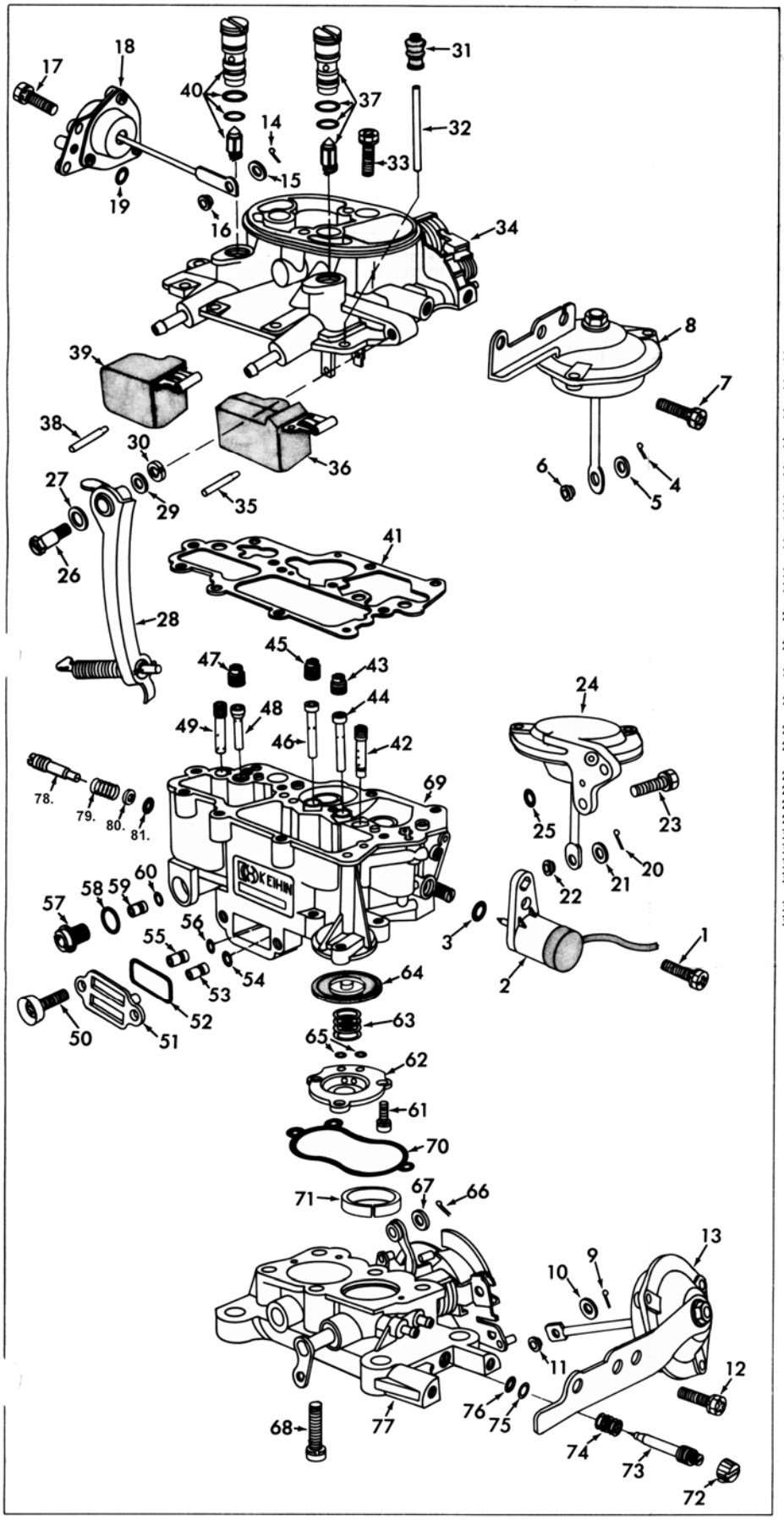
INSTRUCTION SHEET
KEIHIN CARBURETOR
HONDA CIVIC (CVCC ENGINE)

50-523

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: BEFORE REMOVING BOWL COVER, REMOVE EPOXY SEALER FROM TOP OF NEEDLE SEAT SCREW HEADS. TO REMOVE FLOAT PINS (35) (38) WHICH HAVE A PRESSED IN FIT. USE A PIN PUNCH & SMALL HAMMER. CAREFULLY DRIVE PINS OUT FROM THE INSIDE END WHICH HAS THE TAPERED PRESSED FIT. RECORD SIZES OF JETS & TUBES (BELOW) FOR PROPER ASSEMBLY. IDLE LIMITER CAP (72) CAN BE CAREFULLY PULLED OFF OF IDLE ADJ. NEEDLE. (WILL BE USED OVER).

NOMENCLATURE

REF. NO.	
1.	SCREW & LOCKWASHER- SOLENOID
2.	SOLENOID- FUEL CUT OFF
3.	O-RING- SOLENOID
4.	COTTER PIN- DASHPOT ROD
5.	WASHER- DASHPOT ROD
6.	BUSHING- DASHPOT ROD
7.	SCREW & LOCKWASHER (2)- DASHPOT BRACKET
8.	DASHPOT & BRACKET ASSY.
9.	COTTER PIN- THROTTLE OPENER ROD
10.	WASHER- THROTTLE OPENER ROD
11.	BUSHING- THROTTLE OPENER ROD
12.	SCREW & LOCKWASHER (2)- THROTTLE OPENER BRACKET
13.	THROTTLE OPENER & BRACKET ASSY.
14.	COTTER PIN- CHOKE OPENER ROD
15.	WASHER- CHOKE OPENER ROD
16.	BUSHING- CHOKE OPENER ROD
17.	SCREW & LOCKWASHER (2)- CHOKE OPENER ASSY.
18.	CHOKE OPENER ASSY.
19.	O-RING- CHOKE OPENER ASSY.
20.	COTTER PIN- SECONDARY DIAPHRAGM ROD
21.	WASHER- SECONDARY DIAPHRAGM ROD
22.	BUSHING- SEC. DIAPH. ROD
23.	SCREW & LOCKWASHER (2)- SEC. DIAPH. ASSY.
24.	SECONDARY DIAPHRAGM ASSY.
25.	O-RING- SECONDARY DIAPHRAGM ASSY.
26.	SCREW- PUMP LEVER
27.	WASHER- LEVER SCREW
28.	PUMP LEVER & ROD ASSY.
29.	WASHER- LEVER SCREW
30.	LOCKWASHER- LEVER SCREW
31.	BOOT- PUMP PIN
32.	PIN- PUMP DIAPHRAGM
33.	SCREW & LOCKWASHER (10)- BOWL COVER
34.	BOWL COVER ASSY.
35.	PIN- MAIN FLOAT
36.	FLOAT- MAIN
37.	NEEDLE & SEAT ASSY- MAIN
38.	PIN- AUX. FLOAT
39.	FLOAT- AUXILARY
40.	NEEDLE & SEAT ASSY.- AUXILARY
41.	GASKET- BOWL COVER
42.	JET- PRIMARY SLOW _____
43.	JET- PRI. MAIN AIR BLEED _____
44.	TUBE- PRI. EMULSION _____
45.	JET- SEC. MAIN AIR BLEED _____
46.	TUBE- SEC. EMULSION _____
47.	JET- AUX. MAIN AIR BLEED _____
48.	TUBE- AUX. EMULSION _____
49.	JET- AUX. SLOW _____
50.	SCREW & LOCKWASHER (2)- MAIN JET COVER
51.	COVER- MAIN JET
52.	O-RING- MAIN JET COVER
53.	JET- PRIMARY MAIN _____
54.	O-RING- PRI. MAIN JET
55.	JET- SECONDARY MAIN _____
56.	O-RING- SEC. MAIN JET
57.	PLUG- AUX. MAIN JET
58.	O-RING- PLUG
59.	JET- AUX. MAIN _____
60.	O-RING- AUX. MAIN JET
61.	SCREW & LOCKWASHER (3)- COVER
62.	COVER- PUMP DIAPHRAGM
63.	SPRING- PUMP DIAPHRAGM
64.	DIAPHRAGM- PUMP
65.	O-RING- (2)- PUMP COVER SEAL
66.	COTTER PIN- AUX. THROTTLE LINK
67.	WASHER- AUX. THROTTLE LINK
68.	SCREW & LOCKWASHER (5)- THROTTLE BODY
69.	BOWL ASSY.
70.	O-RING- THROTTLE BODY
71.	SLEEVE- PRIMARY BORE
72.	CAP- IDLE LIMITER
73.	NEEDLE- IDLE ADJUSTING
74.	SPRING- IDLE ADJ. NEEDLE
75.	WASHER- IDLE NEEDLE
76.	O-RING- IDLE NEEDLE
77.	THROTTLE BODY ASSY.
78.	SCREW, AUX. IDLE MIXTURE # TURNS _____
79.	SPRING, AUX. IDLE MIX. SCREW
80.	WASHER, AUX. IDLE MIX. SCREW
81.	ORIG. AUX. IDLE MIX SCREW

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 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 ASSEMBLIES (8) (13) (18) (24), SOLENOID (2) FLOATS (36) (39) OR PARTS MADE OF RUBBER IN ANY TYPE OF CLEANING SOLVENT.

REASSEMBLY

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

SPECIAL INSTRUCTIONS

IDLE ADJUSTING NEEDLE. (73)- TO INSTALL FIRST ASSEMBLE SPRING (74), WASHER (75), O-RING (76) ONTO NEEDLE. TURN NEEDLE IN UNTIL LIGHTLY SEATED THEN BACK OUT 2 TURNS. (DO NOT INSTALL IDLE LIMITER CAP AT THIS TIME.)

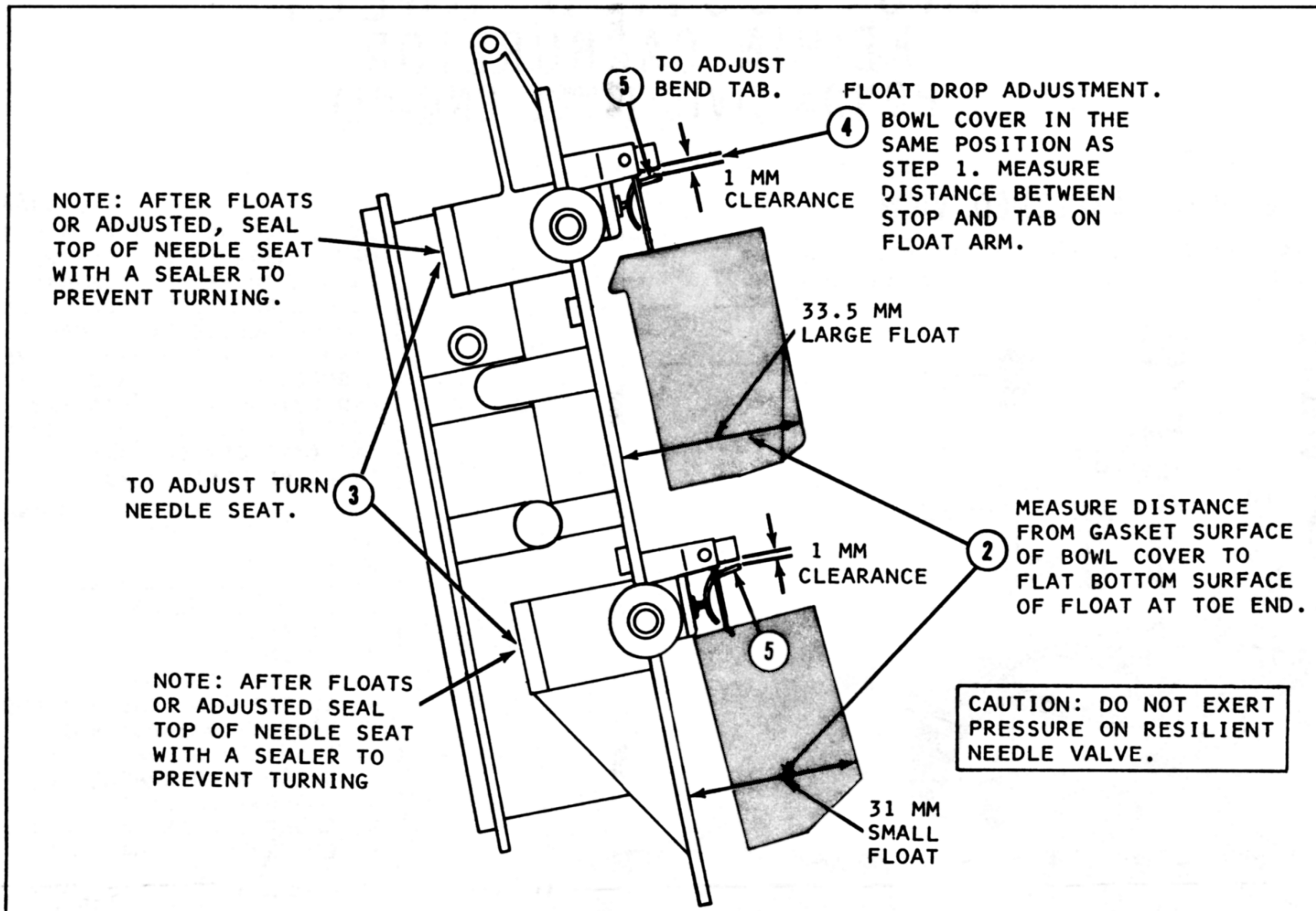
THROTTLE BODY ASSY. (77) WHEN INSTALLING IT TO BOWL ASSY. BE SURE TO HOOK UP AUX. THROTTLE LINK.

SEC. MAIN JET (55)- BE SURE TO INSTALL IN CENTER HOLE. END HOLE ON SECONDARY SIDE IS BLANK.

NEEDLE & SEAT ASSYS (37) (40)- AFTER FLOAT LEVELS HAVE BEEN ADJUSTED BE SURE TO SEAL SCREW HEADS WITH AN EPOXY SEALER TO PREVENT TURNING OF NEEDLE SEATS.

FLOAT PINS (35)(38)- BE SURE TO INSTALL WITH TAPERED END TOWARDS CENTER OF BOWL COVER.

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.

DRY FLOAT LEVEL ADJUSTMENT.