

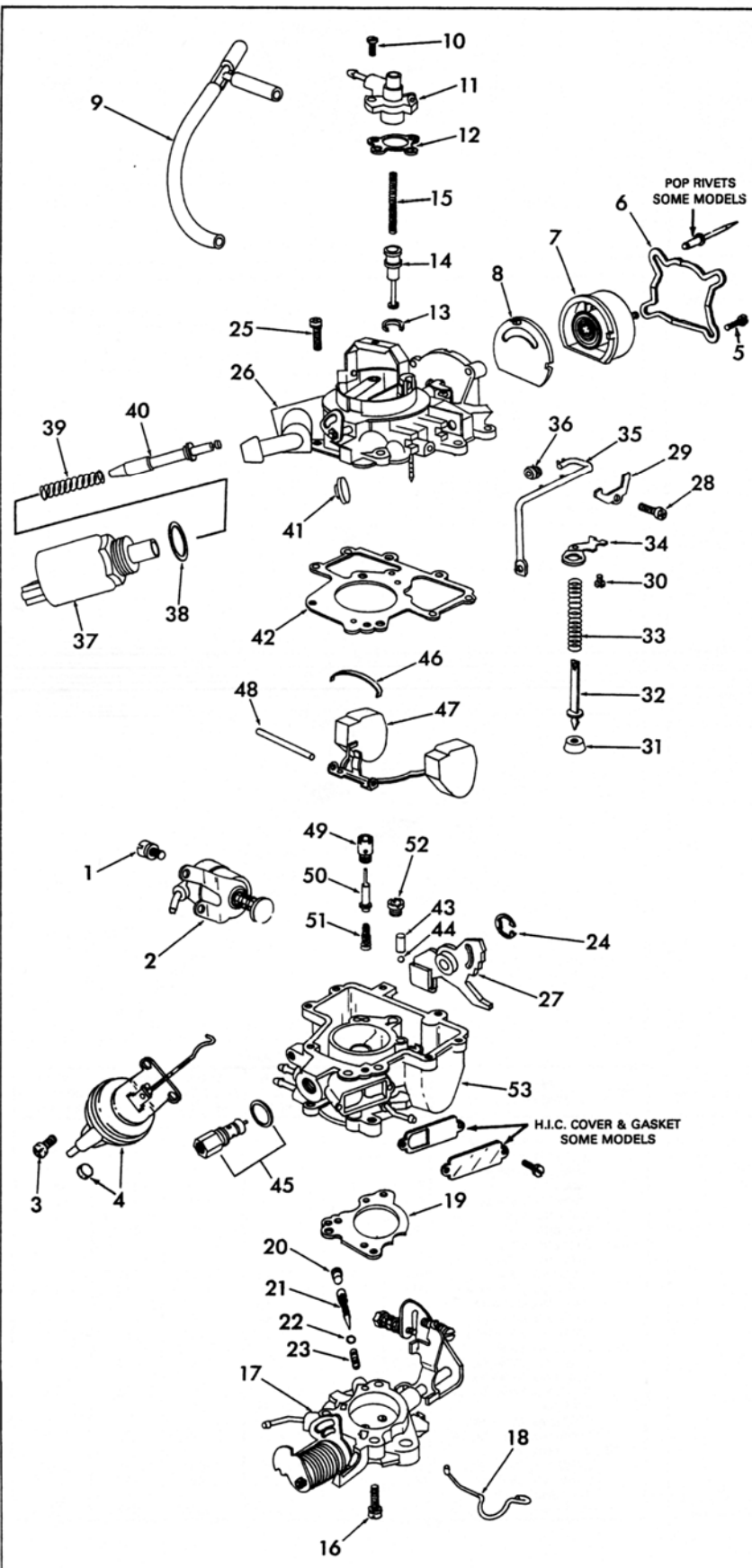
INSTRUCTION SHEET

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 (E-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.

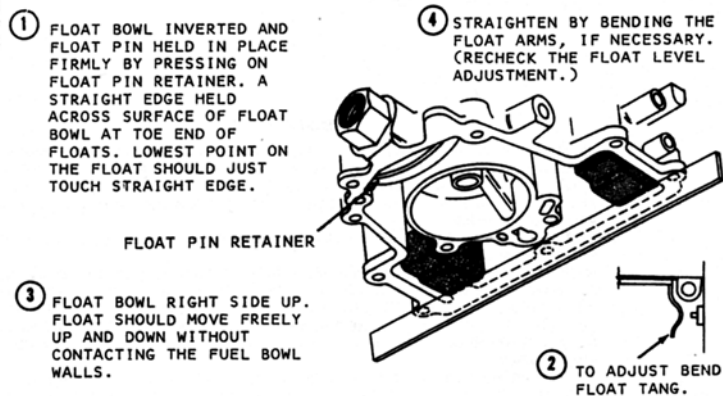
ELECTRIC CHOKE COIL ASSY. (7) - HAS A FIXED SETTING, IS NOT ADJUSTABLE. INSTALL POP RIVETS IN PROPER HOLES, ON UNITS WHERE RIVETS WERE REMOVED.

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.

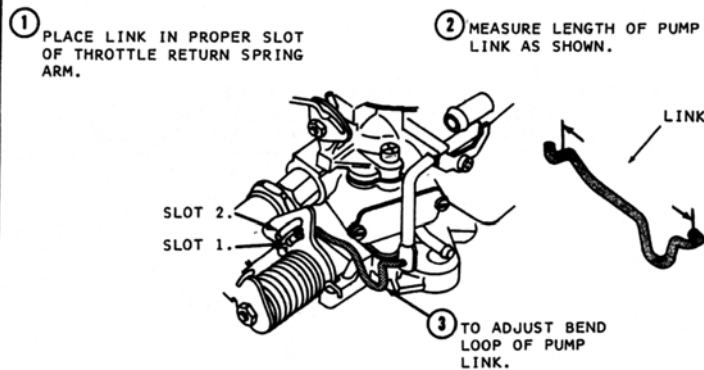
PLEASE REFER TO THE ENGINE DECAL, SERVICE SPECIFICATIONS AND TECHNICAL BULLETINS FOR REVISIONS TO THIS INFORMATION.

ADJUSTMENTS



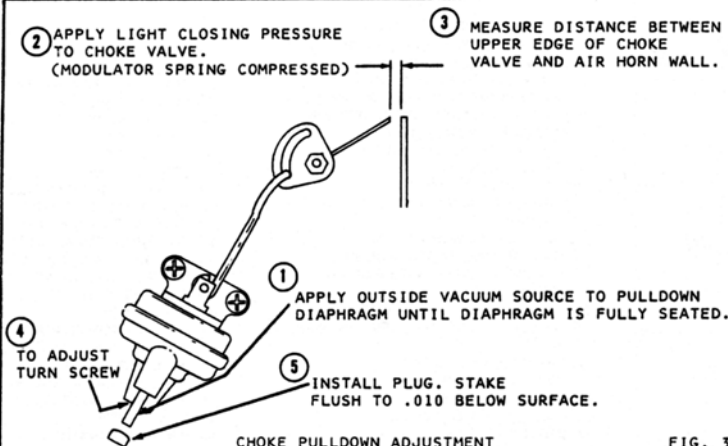
DRY FLOAT LEVEL ADJUSTMENT

FIG. 1



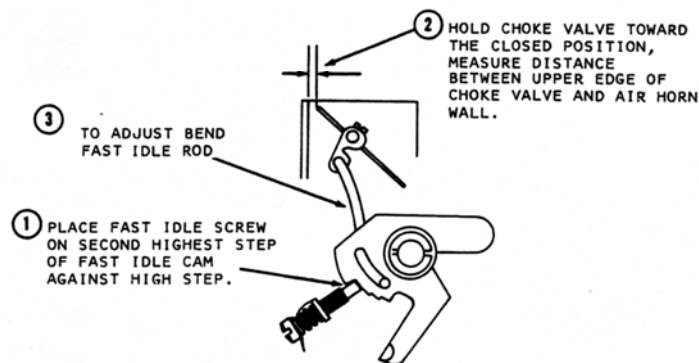
PUMP STROKE ADJUSTMENT

FIG. 2



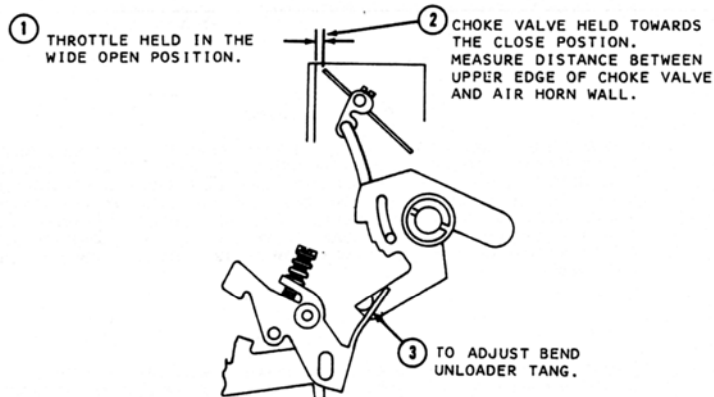
CHOKE PULLDOWN ADJUSTMENT

FIG. 3



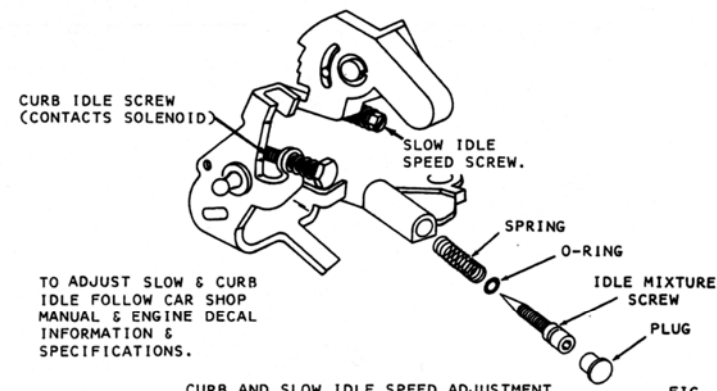
FAST IDLE CAM POSITION ADJUSTMENT

FIG. 4



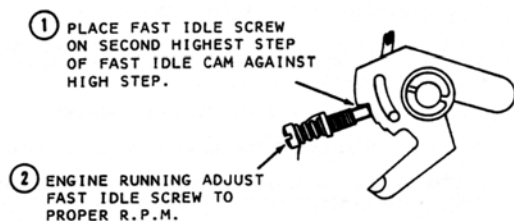
CHOKE UNLOADER ADJUSTMENT

FIG. 5



CURB AND SLOW IDLE SPEED ADJUSTMENT

FIG. 6



(CHECK INFORMATION ON ENGINE DECAL).

FAST IDLE ADJUSTMENT

FIG. 7

ADJUSTMENT DATA TABLE

YEAR	APPLICATION FORD PRODUCTS	DRY FLOAT LEVEL	PUMP ADJUSTMENT		CHOKE PULLDOWN SETTING	FAST IDLE CAM SETTING	CHOKE UNLOADER SETTING
			SLOT	ROD LENGTH			
1980	200" ENG. CALIF. CARB. NO. E0BE-AAA, ZA	FIG. 1	1	2 25/64"	.115"	.090"	.150"
	200" ENG. 49S CARB. NO. E0BE-AA, CA,	FIG. 1	2	2 25/64"	.100"	.070"	.150"
	AMA, ALA CARB. NO. E0ZE-DA, EA	FIG. 1	2	2 25/64"	.110"	.070"	.150"
	CARB. NO. E0ZE-FA, GA, BAA, BBA	FIG. 1	2	2 25/64"	.120"	.086"	.150"
1981	200" ENG. 50 S CARB. NO. E1BE-AFA, AKA,	FIG. 1	2	2 25/64"	.113"	.082"	.150"
	E1BE-ARA, ASA	FIG. 1	2	2 25/64"	.120"	.086"	.150"
	CARB. NO. E1BE-AGA 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"
1982	200" ENG. 50 S CARB. NO. E2BE-BA, CA	FIG. 1	2	2 25/64"	.110"	.078"	.150"
	200" ENG. CANADA CARB. NO. E2BE-HA, JA	FIG. 1	2	2 25/64"	.110"	.078"	.150"
	E2BE-EA 200" ENG. ALTITUDE	FIG. 1	2	2 25/64"	.120"	.086"	.150"
	CARB. NO. E2BE-SA, TA	FIG. 1	2	2 25/64"	.110"	.078"	.150"
1983	200" ENG. 49S CARB. NO. E3SE-CA, DA	FIG. 1	2	2 9/32"	.105"	.078"	.150"
	CARB. NO. E3DE-CA, DA 200" ENG. CALIF.	FIG. 1	2	2 9/32"	.105"	.078"	.150"
	CARB. NO. E3SE-AA, BA	FIG. 1	2	2 25/64"	.105"	.078"	.150"