

## GENERAL INSTRUCTIONS FOR ALL THROTTLE PLATE KITS Installation Instructions

**WARNING!** These instructions must be read and fully understood before installation. If this manual is not fully understood, installation should not be attempted.

**GENERAL:** These are basic general instructions to remove and install the throttle plates in any two or four barrel Holley carburetors. Since a four barrel carburetor was used in this instruction sheet, the same basic removal and installation steps apply to two barrels also.

**IMPORTANT NOTE:** Before starting the actual work, go through a "dry" run with the throttle body and the instruction sheet. This will help you familiarize yourself and gain confidence with all the procedures.

### TOOLS AND MATERIAL REQUIRED FOR INSTALLATION

- Phillips screwdriver
- Soft wood blocks
- Loctite Grade 290
- Access to compressed air
- Standard screwdriver
- Duct tape
- "Duck Billed" tip vise grips
- Vise
- Fine/medium file
- Carburetor stand (or suitable holding fixture)

### REMOVAL OF THROTTLE BODY:

1. Place carburetor on its side to remove the throttle body screws. On vacuum secondary four barrels it will be necessary to remove the "C" clip which holds the vacuum diaphragm stem onto the secondary throttle shaft. See Figure 1.
2. Place all screws, clips, and links on the side for later installation.

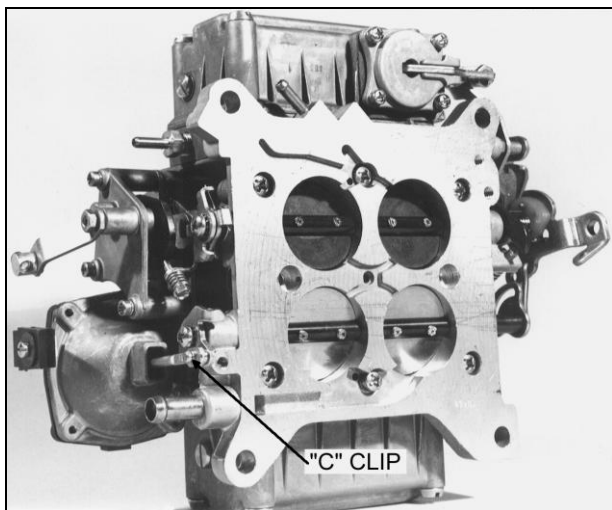


FIGURE 1

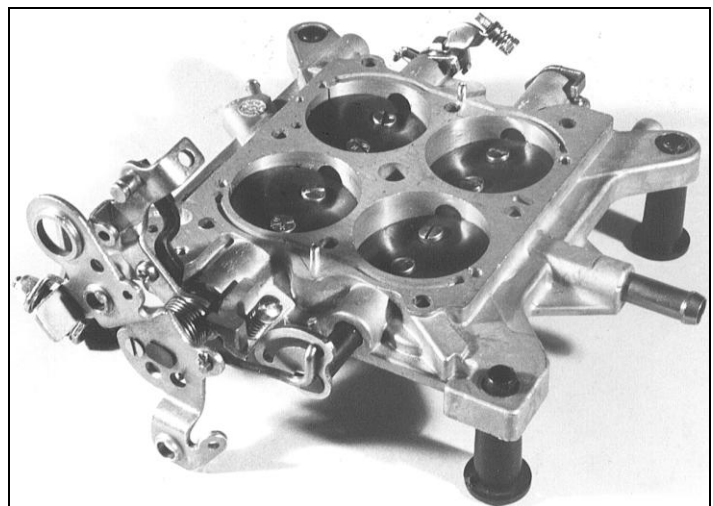
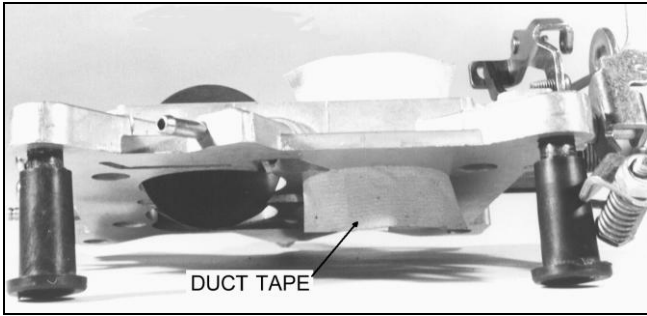
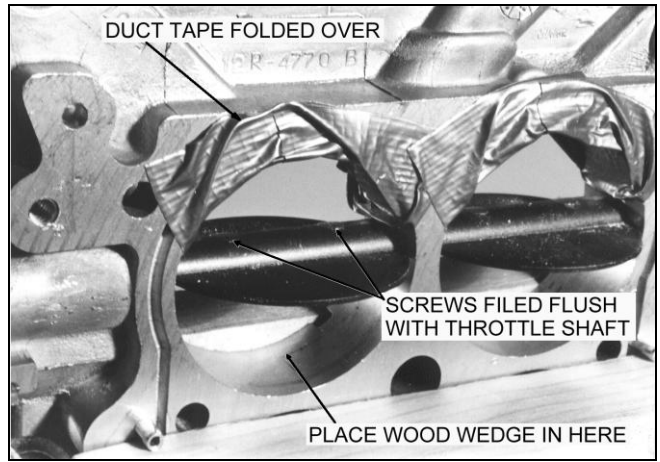


FIGURE 2



**FIGURE 3**



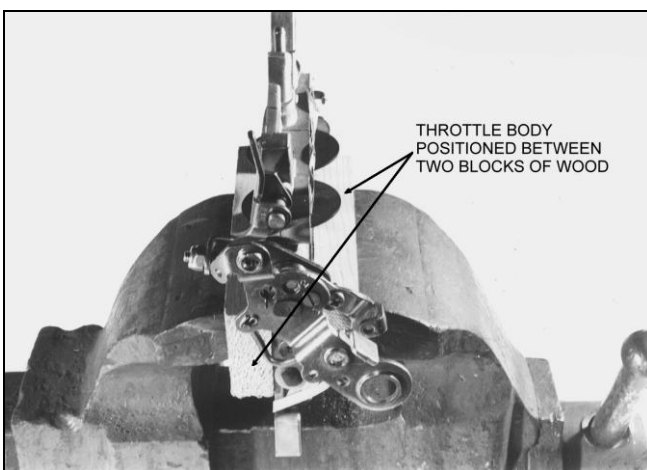
**Front Side of Primary Throttle Bores shown**  
**FIGURE 4**

## REMOVAL OF OLD THROTTLE PLATES

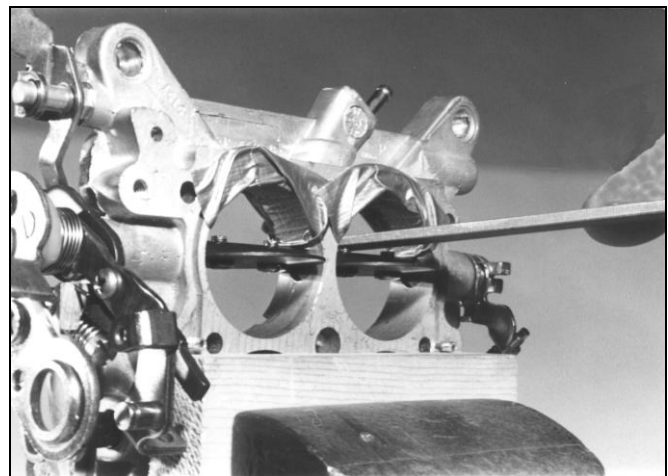
1. Place the throttle body on a carburetor stand. See Figure 2.

**RECOMMENDATION:** When servicing a carburetor off the vehicle it is recommended to place it in a suitable holding fixture. This helps prevent damage to the machined surfaces of the throttle body.

2. Open the throttle shaft to the wide-open position. To help keep the throttle open, use a wedged shape piece of soft wood positioned between the throttle shaft and the primary throttle bore. See figure 4.
3. Next, cut a piece of duct tape large enough to extend at least 1 inch through the top and bottom of the front side of the primary throttle bores and the back side of the secondary throttle bores. See Figure 3. Two pieces of tape in each bore may be used to accomplish this also.
4. Take the throttle body and place it between two blocks of wood in a vise. See Figure 5.
5. Using a fine/medium tooth file, begin by filing the end of the throttle plate screws on the primary side using firm even strokes. File away enough of each screw so that the ends are flush with the throttle shaft. Remove the throttle body from the vise and turn over. Now file the throttle plate screws on the secondary side. See Figures 6 and 7.
6. When all eight screws have been filed down flush with the shaft, remove the throttle body from the vise, remove the wood wedges from the bores, and remove the throttle plate screws.
7. Inspect the throttle shaft where the filing was done and check for any burrs. Remove any burrs that are present with the file. Remove the duck tape. Afterwards, blow off throttle body with compressed air to remove metal filings and chips.



**FIGURE 5**



**FIGURE 6**

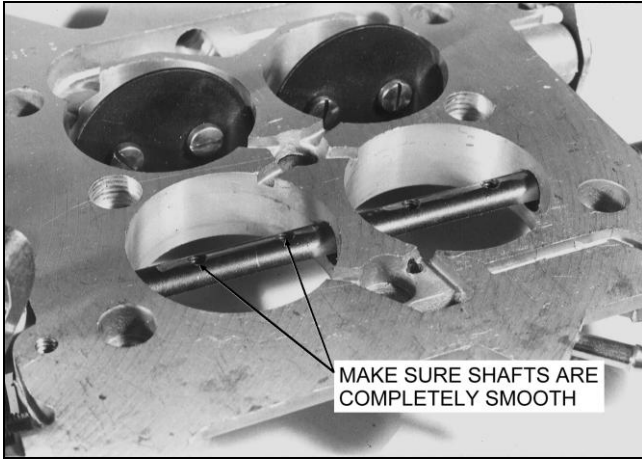


FIGURE 7

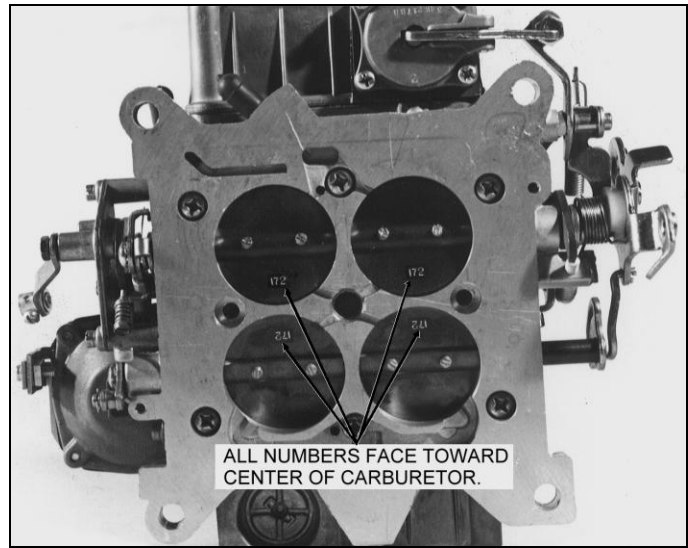


FIGURE 8

## INSTALLATION OF NEW THROTTLE PLATES

1. Place the throttle body on a carburetor stand or a suitable holding fixture.
2. Notice the part numbers stamped on each plate. Take a new throttle plate and place it into the throttle bore with "R" facing down and the Part number facing to the center of the carburetor. See Figure 8. The throttle plate should rest at a 15° angle in the closed position.

**NOTE:** The photo in Figure 8 shows the bottom and side views of the throttle body and throttle plates. Notice that the part numbers stamped on the plates face toward the center of the throttle body. On two barrel carburetors, the numbers will face towards the rear.

3. With the throttle plate screw holes aligned with the shaft, install the screws. Add 1 drop of Loctite 290 to each screw thread. Snug down both screws, then back out a 1/2 turn. Lightly, open and close throttle. Do this at least 6 times so the plate can seat in the throttle bore.
4. Tighten screws. Open and close again to check for binding. If any binding is present, repeat step 3. If there is no binding go to the next throttle bore and do the same.
5. After the new throttle plates are installed using steps 1 through 4, open throttle to wide-open position and release. Do this as fast as possible at least 10 times. Be absolutely sure that there is **NO** binding present. Repeat steps 1 through 4, if necessary. **DO NOT** go any further until problem is solved.

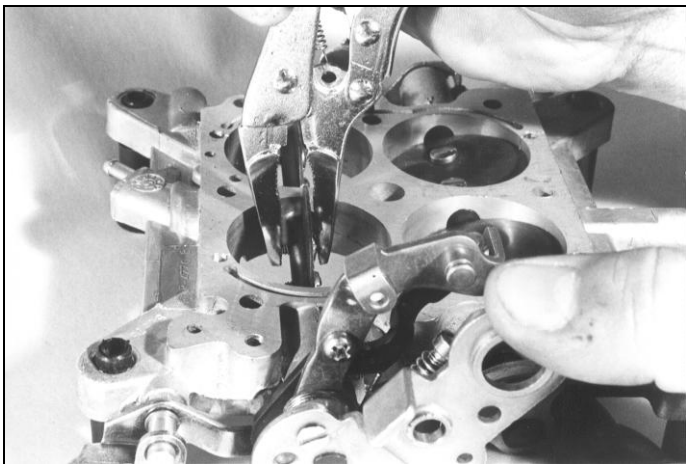


FIGURE 9

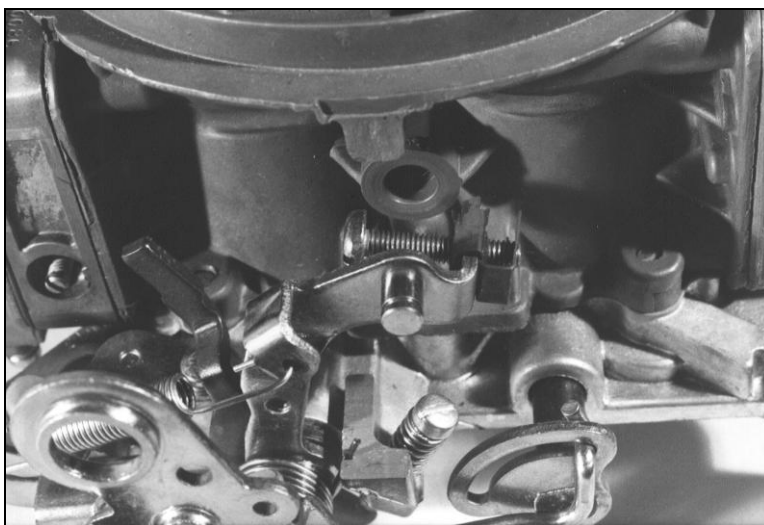


FIGURE 10

6. Hold the throttle body against a light bulb, check to see that the light passing between the throttle plates and the bores are uniform. If not the plate must be repositioned. This will affect the idle characteristics of the engine.
7. Making sure that there is no binding in the throttle shaft, you will now restake the throttle plate screws. See Figure 9. Use a pair of "Duck Billed" vise grip pliers for this procedure. Using this type of plier design will prevent damage to the throttle bore. Figure 10 shows a satisfactory pattern on the end of the screw after restaking.

## **FINAL ASSEMBLY**

1. Install the main body gasket supplied in the kit. Install the throttle body to the main body.
2. Attach the "C" clip to the secondary diaphragm stem.
3. Remember to readjust the curb idle and replace the carburetor flange gasket if the original has been used.
4. As shown in Figure 11, attach the transmission kickdown lever return spring, spring bracket, adjusting screw and locknut.



**FIGURE 11**

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