

Instructions for Replacement of FH or S Carburetor Butterflies

#1 Remove Carburetor from Engine

#2 Remove Intake Check Valve Tube from bottom of Carburetor (loosen locknut and unscrew counter clockwise from bottom of carburetor)

#3 You need a 3 inch long $\frac{1}{4}$ inch 28 bolt (fine threads), cut off hex head and grind flat. Screw the threaded end into the Carburetor and tighten with pliers. Then mount carburetor into a vise as shown in figure.



#4 Using a sharp chisel and hammer lightly tap on rings to remove them. (you may have to grind the carburetor metal off if it has mushroomed over the top of the rings)



#5 Carefully drill out the 4 rivets (hollow end) using a $\frac{1}{8}$ inch or slightly larger drill bit. Punch out the rivets using a $\frac{1}{8}$ inch or smaller punch.



#6 Once rivets are removed, Carefully separate the two halves of the carburetor(carb has 2 locating pins so it may be a little tight, insert a wood dowel, small screw driver handle or similar item in the holes and wiggle to help separate) and clean pieces with a fine wire brush.



#7 Once parts are cleaned, hold half (with out intake pipe hole) in hand and place both butterfly pieces into carb as shown. Gear parts are flat. Then place other half on top and press together.



#8 Mount the 1/4 inch bolt in the vise straight up, Insert a rivet into one of the carburetor holes and have someone hold carburetor over the bolt.



#9 Using a round FLAT end punch and hammer, carefully flatten the end of the rivet until rivet is tight, Usually 2 or 3 light hits. Repeat for the other 3 rivets.



#10 Tap rings back on with a hammer, replace check valve tube. Install Carburetor back on Engine.