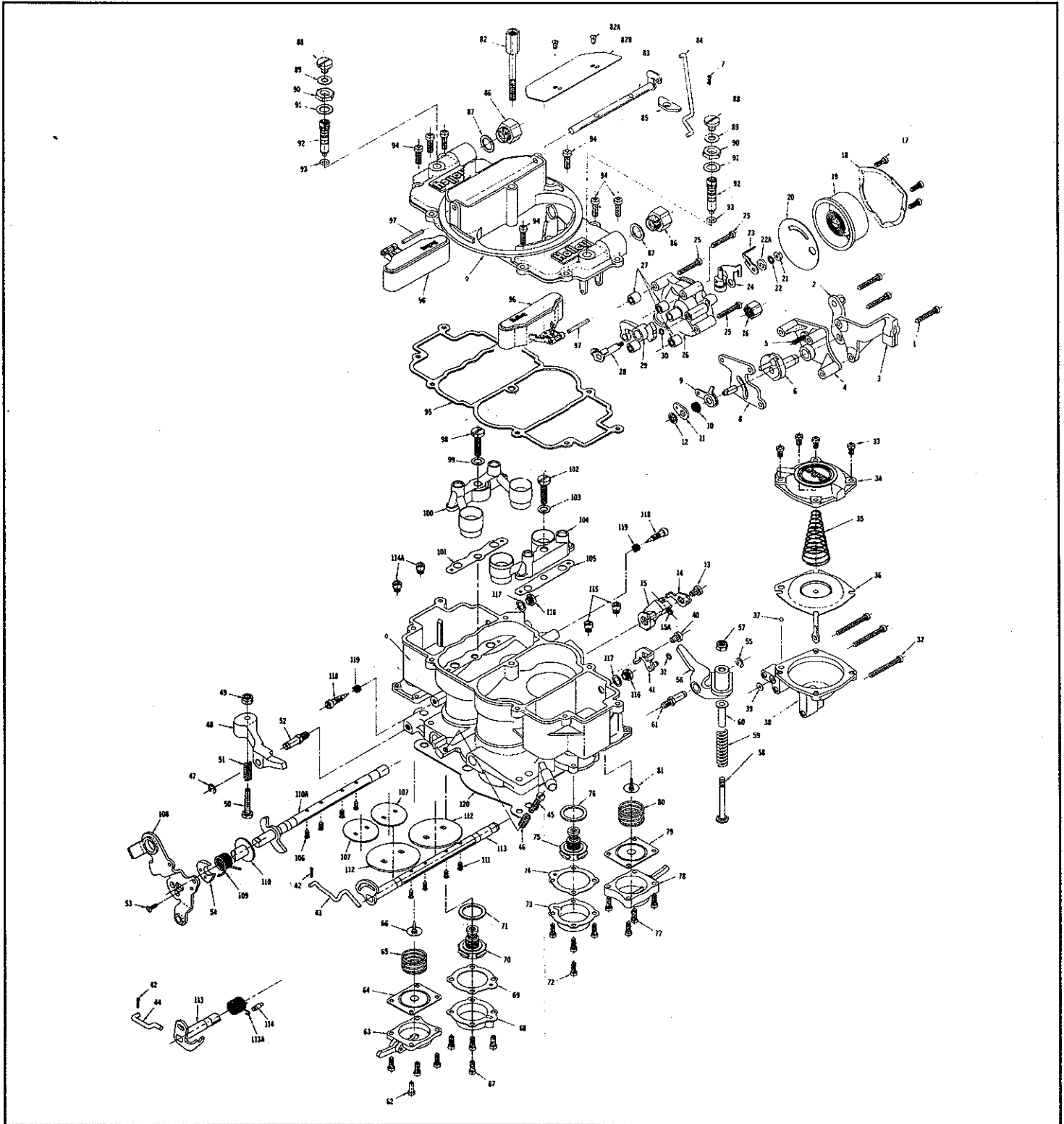


INSTRUCTION SHEET HOLLEY CARBURETOR MODEL 4011

199R-9796

Typical View

The exploded view shown in typical of the model carburetor this kit will service. The view may differ slightly from the actual carburetor being renewed. This is a universal kit that may contain more parts than are actually required to service a given carburetor. When similar gaskets or parts are included in the kit, compare with original parts.



Carburetor Adjustments:

Disassembly

Rest the carburetor on a repair stand to avoid damage to the throttle plates during renew procedures. Use exploded view as a guide, and follow the numerical sequence in general to disassemble unit far enough to permit cleaning and inspections. Do not remove throttle plates or shaft. Observe and record the initial position of needle slot. Turn the idle needles clockwise until lightly seated, recording the number of turns required to seat the needles. This procedure is necessary to reinstall the idle needles after renewing.

Cleaning

Cleaning must be done with carburetor disassembled. Soak parts long enough to soften and remove all foreign material. Use a carburetor solvent, lacquer thinner or denatured alcohol. Make certain the throttle body is free of all hard carbon deposits. Wash 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 parts containing rubber or plastic material. Serious damage could result.

Reassembly

Reassemble in reverse order of disassembly. Note special instructions and follow outline in making adjustments.

Manually operate the throttle lever and choke mechanism, checking for binding or malfunction. Any binding or interference could cause throttle to stick during operation and result in loss of carburetor throttle control (or uncontrolled engine speed). Check carburetor to be sure there are no leaks, flooding, which might cause a fire.

Special Instructions:

Idle Adjusting Needles: Tapered portion of needle must be straight and smooth. If grooved, or ridged, a new needle should be installed.

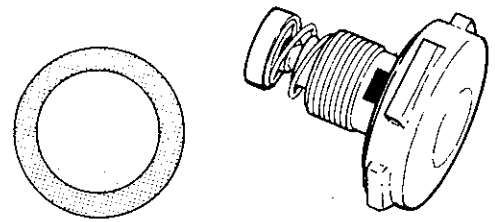
Pump Inlet Check Valve: Lubricate tip of new valve and insert in center hole in pump cavity. Pull through from fuel bowl side until seated.

Pump Valve Cover: Stamped steel cover requires two gaskets, Die cast cover requires only one gasket. Improper gasket usage could result in fuel leakage. See Fig. 1.

Adjustment Specifications

Carburetor Number	Choke Cap Setting	Pump Cam Position	Choke Unloader	Choke Quality
R84010, R84011, R84012, R84013, R84020		No. 1		
R84018	Index	No. 1	.185"	.328"
R84023	Index	No. 1	.305"	.275"

With two "rectangular" fuel openings



Note: Proper valve gasket must be used as shown, use of improper gasket will result in fuel leakage around power valve.
Power valve (B): Torque to 40 - 50 inch pounds

FIG. 2 - POWER VALVE INSTALLATION

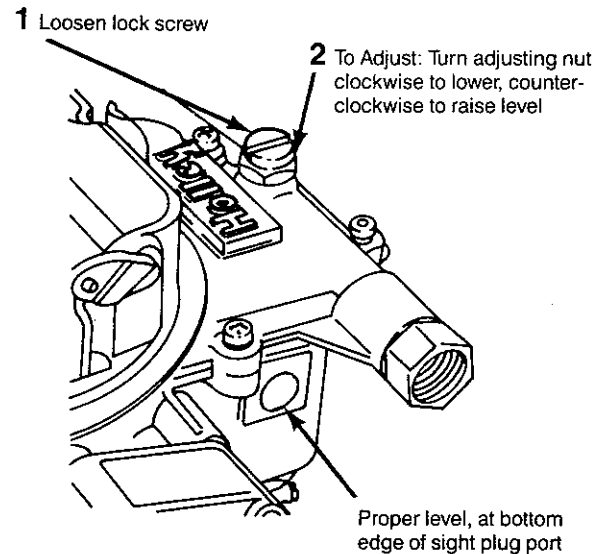


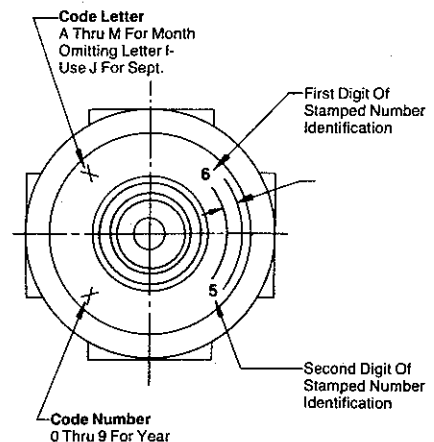
FIG. 3 - WET LEVEL ADJUSTMENT

POWER VALVE IDENTIFICATION

Example: Power Valve Assembly

25R591-65

65 Which designates the stamped number, also identifies the opening point of the power valve (i.e., 6.5" vacuum).

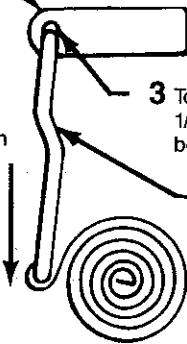


2 Choke lever in closed choke position

1 Push rod down

3 Top of choke rod 1/2 to 1 rod dia. below hole

4 To Adjust: Bend rod here

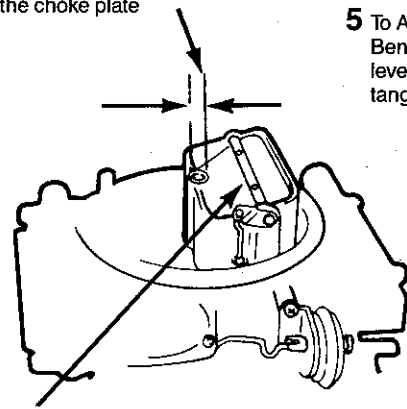


Type 1

FIG. 4 - CHOKE ROD ADJUSTMENT (AUTOMATIC CHOKE)

4 Measure the distance between the lower edge of the choke plate & airhorn wall

5 To Adjust: Bend throttle lever unloader tang

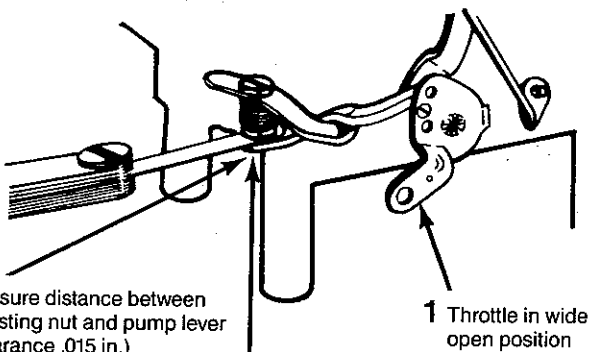


3 Light closing pressure on choke plate

2 Throttle plates in wide open position

1 Choke rod properly adjusted

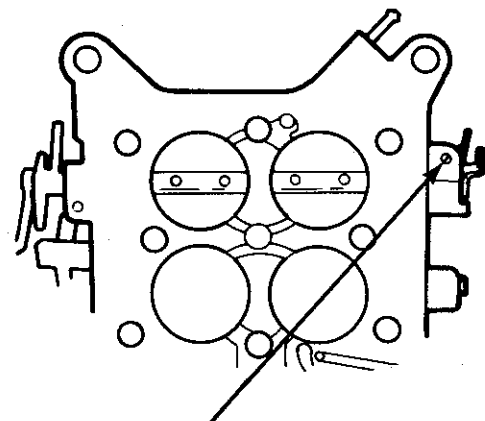
FIG. 5 - UNLOADER ADJUSTMENT (AUTOMATIC CHOKE)



3 Measure distance between adjusting nut and pump lever (clearance .015 in.)

2 Pump operating lever fully compressed

FIG. 6 - PUMP OVERRIDE ADJUSTMENT



Back the secondary throttle stop screw out until the secondary throttle plates are closed in the throttle bore. Turn the screw in (clockwise) until it just touches the stop on the lever, then give it an additional 1/4 turn.

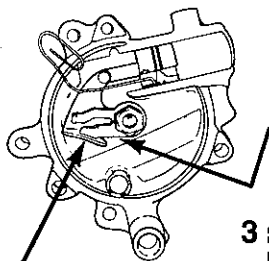
FIG. 7 - SECONDARY THROTTLE STOP ADJUSTMENT

NOTE: Bend a paper clip (.030 to .036 dia.) as shown to provide end no longer than 1/8 inch long.

1 Insert paper clip into piston bore until end of bore slot is hooked as shown

2 Move piston and levers in choke closing direction until edge of piston slot engages paper clip

3 Measure distance between lower edge of choke plate and airhorn See Fig. 5



4 To Adjust: Bend piston lever tang

FIG. 8 - CHOKE QUALIFYING (INTEGRAL CHOKE) ADJUSTMENT

Rotate cover to align ref. mark on cover with specified mark on choke housing.

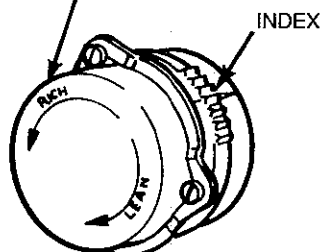


FIG. 9 - CHOKE ADJUSTMENT

1 Turn engine off
2 Close choke
3 Adjust fast idle screw

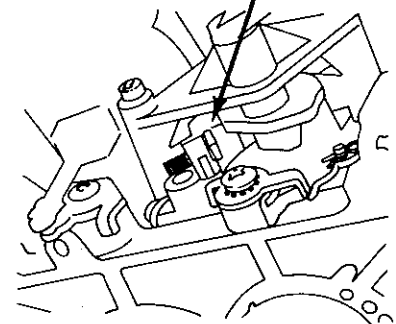
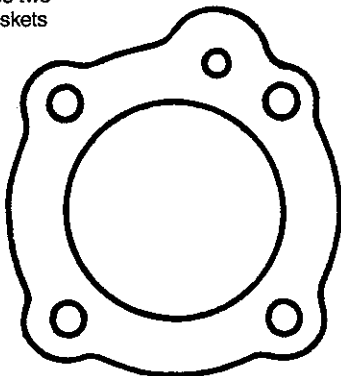


FIG. 10 - FAST IDLE ADJUSTMENT (NON-MARINE ONLY)

NOMENCLATURE

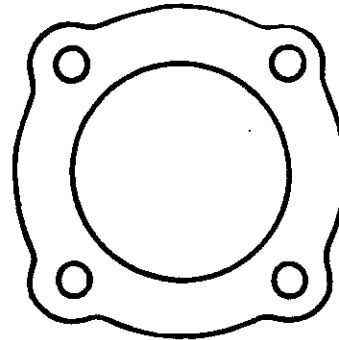
REF. NO.	REF. NO.	REF. NO.
1. Fast Idle Cam Plate screw	41. Sec. Diaphragm Lever Assy.	82A. Choke Plate Screw
2. Choke Lever and Swivel Assy.	42. Cotter Pin-Throttle Connecting Rod	82B. Choke Plate
3. Choke Control Bracket	43. Secondary Connecting Rod	83. Choke Shaft and Lever Assy.
4. Fast Idle Cam Plate	44. Secondary Operating Link	84. Choke Rod
5. Fast Idle Cam Spring	45. Throttle Stop Screw	85. Choke Rod Seal
6. Fast Idle Cam	46. Throttle Stop Adjusting Screw Spring	86. Fuel Inlet Fitting
7. Retainer-Choke Rod	47. E-Ring Retainer	87. Fuel Inlet Fitting Gasket
8. Choke Lever Back-up Plate	48. Pump Operating Lever Assy.	88. Fuel Valve Seat Screw
9. Choke Rod Lever Molded	49. Fibre Locking Nut	89. Seat Lock Screw Gasket
10. Choke Lever Spring	50. Pump Lever Adj. Screw	90. Fuel Valve Seat Lock Nut
11. Choke Spring Ret. Washer	51. Pump Lever Adj. Screw Spring	91. Needle and Seat Adj. Nut Gasket
12. Push Nut Fastener	52. Pump Lever Stud	92. Fuel Inlet Needle and Seat Assy.
13. Fast Cam Lever Screw & L.W.	53. Pump Cam Screw	93. O-Ring Seal
14. Cam Pick-up Lever	54. Pump Cam	94. Airhorn Screw
15. Fast Idle Cam Lever	55. E-Ring Retainer	95. Airhorn Gasket
15A. Fast Idle Adj. Screw	56. Secondary Pump Operating Lever Assy.	96. Float and Tab Assy.
16. Compression Nut	57. Fibre Locking Nut	97. Float Shaft
17. Thermostat Cap Clamp Screw	58. Secondary Pump Lever Adj. Screw	98. Nozzle Bar Screw-Primary
18. Thermostat Cap Clamp	59. Pump Lever Adj. Screw Spring	99. Nozzle Bar Screw Gasket
19. Thermostat & Cap Assy. Indexed	60. Pump Lever Adj. Screw Sleeve	100. Primary Nozzle Bar Assy.
20. Thermostat Cap Gasket	61. Pump Lever Stud	101. Nozzle Bar Gasket
21. Hex Nut	62. Pump Diaphragm Cover Screw	102. Nozzle Bar Screw-Secondary
22. Lockwasher	63. Acc. Pump Diaphragm Cover Assy.	103. Nozzle Bar Screw Gasket
22A. Choke Thermostat Lever Spacer	64. Acc. Pump Diaphragm Assy.	104. Secondary Nozzle Bar Assy.
23. Choke Thermostat Lever	65. Pump Diaphragm Return Spring	105. Nozzle Bar Gasket
24. Thermostat Lever and Piston Assy.	66. Pump Check Valve	106. Throttle Plate Screw
25. Choke Housing Screw	67. Power Valve Cover Screw	107. Primary Throttle Plate
26. Choke Housing	68. Power Valve Cover	108. Primary Throttle Lever
27. Choke Housing Spacer	69. Power Valve Cover Gasket	109. Primary Throttle Return Spring
28. Choke Hsg. Shaft & Lever Assy.	70. Power Valve-Primary	110. Throttle Lever Bushing
29. Fast Idle Cam Assy.	71. Power Valve Gasket	110A. Throttle Shaft and Stop Lever Assy.
30. Choke Housing Gasket	72. Power Valve Cover Screw	111. Throttle Plate Screw
31. E-Ring Retainer	73. Power Valve Cover	112. Secondary Throttle Plate
32. Secondary Diaphragm Housing Screw	74. Power Valve Cover Gasket	113. Secondary Throttle Shaft & Lever Assy.
33. Secondary Diaphragm Cover Screw	75. Power Valve-Secondary	113A. Secondary Throttle Return Spring
34. Secondary Diaphragm Cover	76. Power Valve Gasket	114. Throttle Return Spring Pin
35. Secondary Diaphragm Spring	77. Pump Diaphragm Cover Screw	114A. Primary Main Jet
36. Secondary Diaphragm & Link Assy.	78. Acc. Pump Diaphragm Cover Assy.	115. Secondary Main Jet
37. Check Ball	79. Acc. Pump Diaphragm Assy.	116. Fuel Level Check Plug
38. Secondary Diaphragm Housing	80. Pump Diaphragm Return Spring	117. Fuel Level Plug Gasket
39. Secondary Diaphragm Housing Gasket	81. Pump Check Valve	118. Idle Adj. Needle
40. Sec. Diaphragm Lever Screw & L.W.	82. Air Cleaner Stud	119. Idle Adj. Needle Spring
		120. Flange Gasket

Use two gaskets



Stamped steel cover gasket

Use one gasket



Die cast cover gasket

FIG. 1 - POWER VALVE COVER GASKET