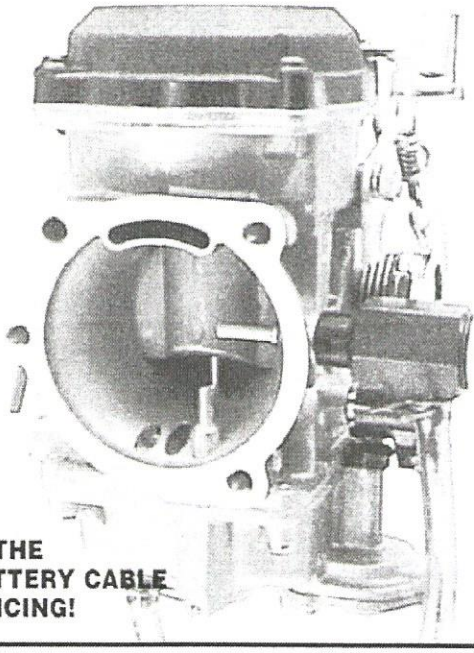
ThunderJet

INSTALLATION INSTRUCTIONS FOR CV CARBS



CAUTION:
DISCONNECT THE NEGATIVE BATTERY CABLE BEFORE SERVICING!

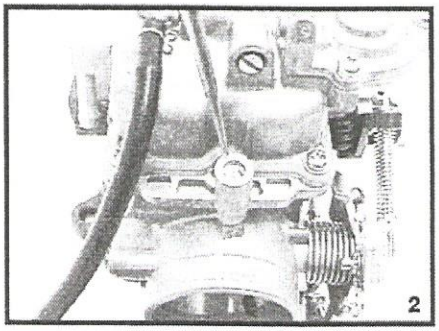
NOTE TO INSTALLER

Motorcycle shops that frequently install ThunderJets will want to consider the ThunderJet CV installation fixture. This tool is available from Zipper's Performance Products, part **#713-915** will accurately place the holes & requires only simple hand tools.

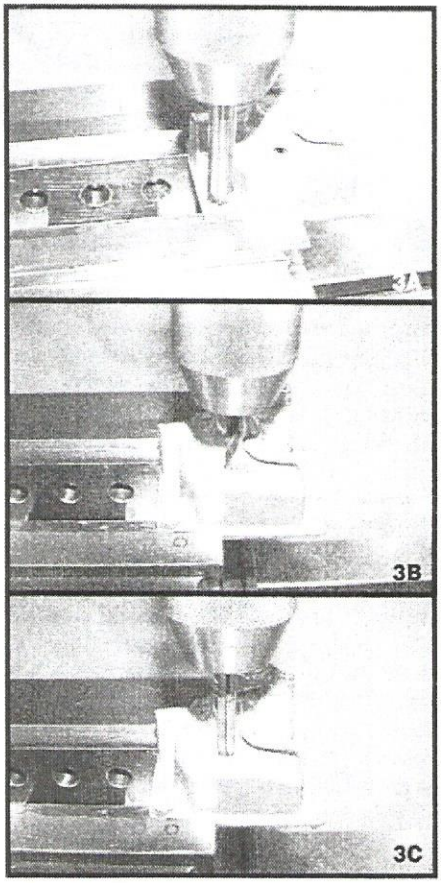
NOTE: This product may not be legal for use on pollution or noise controlled vehicles in some states. Check your state and local regulations.

STEP 1: Remove the carburetor from the motorcycle. Drain all fuel from the carb.

STEP 2: The idle mixture screw is located in a tower below the throttle butterfly. The tower is capped with a small plug. Gently clamp the carb in a vise. Drill the center of the plug using a 5/32" drill bit *(The plug is shallow, so don't drill too far!)*, then use a sheet metal screw to remove the plug. Carefully blow any metal chips out of the tower with compressed air. Using a small screwdriver, gently turn the screw in until it seats, then back out two turns. This is a starting point, the idle mixture will need final adjustment after the carb is reinstalled on the bike. Use caution if this screw is removed, as there is an o-ring, a washer and a spring on the screw. These parts are very small and can easily be overlooked. If these parts are not reinstalled correctly, poor performance will result. The parts are not available individually from H-D®. The correct reassembly method is; place the spring on the screw, then the washer, then the o-ring, then place the assembly in the hole. If the washer and o-ring are trapped inside the hole, bend a small hook on a paperclip and use as a removal tool.



STEP 3: Remove the four float bowl screws, remove the float bowl. Clamp the bowl upside-down in a milling machine vise with the overflow tube facing to the right. Locate center of the front left float bowl mounting hole (3A). Move back .380" *(Y axis)* and over .955" *(X axis)*. This will locate the nipple on the flat area of the bowl for O-ring sealing. Drill through using a #3 drill then tap 1/4"-28. (3B, 3C) Clear any metal chips with compressed air. Install the fuel nipple with o-ring from the outside, washer and nut from the inside, tighten securely. Set the bowl aside.



STEP 4: Clamp the body in a milling machine vise with the air horn facing you and the vacuum piston to the left (4A). Locate the bowl gasket surface and move 1.450" *(X axis)*. Locate the air horn surface and move in .750" *(Y axis)*. This locates center of the carb throat. Drill through with a #3 drill and tap 1/4"-28 (4B, 4C). Clear any metal chips with compressed air. Always force air through carb backwards, so metal chips will move away from the orifices near the butterfly. Install the fuel tube from inside the throat out. Use a drop of low strength thread lock on the threads. Lock the two 1/4"-28 nuts on the fuel tube, tighten the tube in the carb body (4D). ***Do Not Overtighten!*** Remove the 1/4"-28 nuts.

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