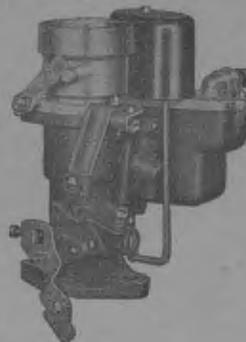


DEPT. OF NATIONAL DEFENCE
SPECIAL VEHICLES ONLY



CHEVROLET TRUCK 1940-41-42-43

(387S Superseded by 518SA)

Casting No. 329 on face of flange.
Cut Shows 387S

DOWN-DRAFT CARBURETERS Nos. 387S-518S-518SA—LIST PRICE \$17.65

A \$2.50 exchange allowance is deducted from the list price if buyer turns in old carburetor.

CARBURETER SPECIFICATIONS

For Chevrolet Six Engine: 3½ Inch Bore, 3¾ Inch Stroke

Dimensions: Flange size, 1¼ inch S. A. E.

Primary venturi, 11/32 inch I. D.

Secondary venturi, 11/16 inch I. D.

Main venturi, 1¼ inch I. D.

Float Level: Distance from float (at free end) to float chamber cover to be ¾ inch, plus or minus 1/64 when needle is seated.

Vents: Outside, none. Inside (balance vents) above choke valve through shaft, size No. 27 drill. Below choke valve, No. 35 drill.

Gasoline Intake: Square vertical needle, No. 48 drill size in needle seat.

Low Speed Jet Tube: Jet size, No. 72 drill.

By-pass in body, size No. 56 drill.

Economizer jet: size .059 to .060 inch diameter.

Idle passage bleed, into bore, above port; size No. 54 drill.

Idle Ports: Upper port diameter, No. 44 drill. Lower port diameter, No. 52 drill.

Idle Port Opening: (387S-518S) Top of lower port .034 to .038 inch above top edge of valve, with valve tight closed. (518SA) .016 to .020 inch.

Idle Screw Seat: Size No. 50 drill.

Idle Adjustment Screw: Set one turn to two turns open. For richer mixture, turn screw out. Do not attempt to idle engine below 350 r. p. m.

Slip Nozzle: In primary venturi, angle 30°. Discharge jet size, .125 inch diameter.

Screw Nozzle: (Seats in slip nozzle) Jet: Size No. 31 drill.

Metering Rod: Economy step, .064 inch diameter; middle step tapers from .058 to .053 inch diameter; power step, .039 inch diameter. Length, 3¾ inches.

Metering Rod Jet: Size, .094 inch diameter.

Metering Rod Setting: Use gauge (Part No. T109-25) 2.795 inches.

Accelerating Pump: Low pressure type, with adjustable stroke. Discharge jet, size No. 72 drill.

Intake disk check plug, size No. 62 drill.

Discharge disk check plug, size No. 40 drill.

Choke: Manual—butterfly type, split valve.

Vacuum Spark Ports: (387S-518S) Upper port: Size No. 50 drill.

Lower port (Enters bore on angle): Size No. 56 drill.

(518SA) Slot type, .041 x .125 inch. Bottom of port .000 to .004 inch above valve.

Motor Tune-Up—Be Accurate! Always Use Feeler Gauges!

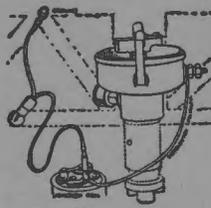
CAUTION: Change worn or leaky flange gaskets. Tighten manifold bolts and test compression before adjusting carburetor.



Spark
Plug Gap
.040"



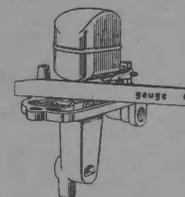
Set
Breaker Points
.018"



Use Neon Timing
Light or Timing Light
Breaker Points to
open 5° before
top dead center



Set Valves Hot
(Road Operating
Temperature)
Intake .010"
Exhaust .020"



Correct Float Level
(Remove Cork Gasket
and measure from
machined surface of
float cover)
¾ Inch



Idle Adjustment
Screw Setting
1 to 2
Turns Open

NOTE ON VALVE ADJUSTMENT. It is important that valves be adjusted with engine at operating temperature. Where quietness is desired and vehicle is not operated at high speed or on heavy hauling, etc., exhaust valves may be adjusted to .015" minimum.

CARBURETER ADJUSTMENTS

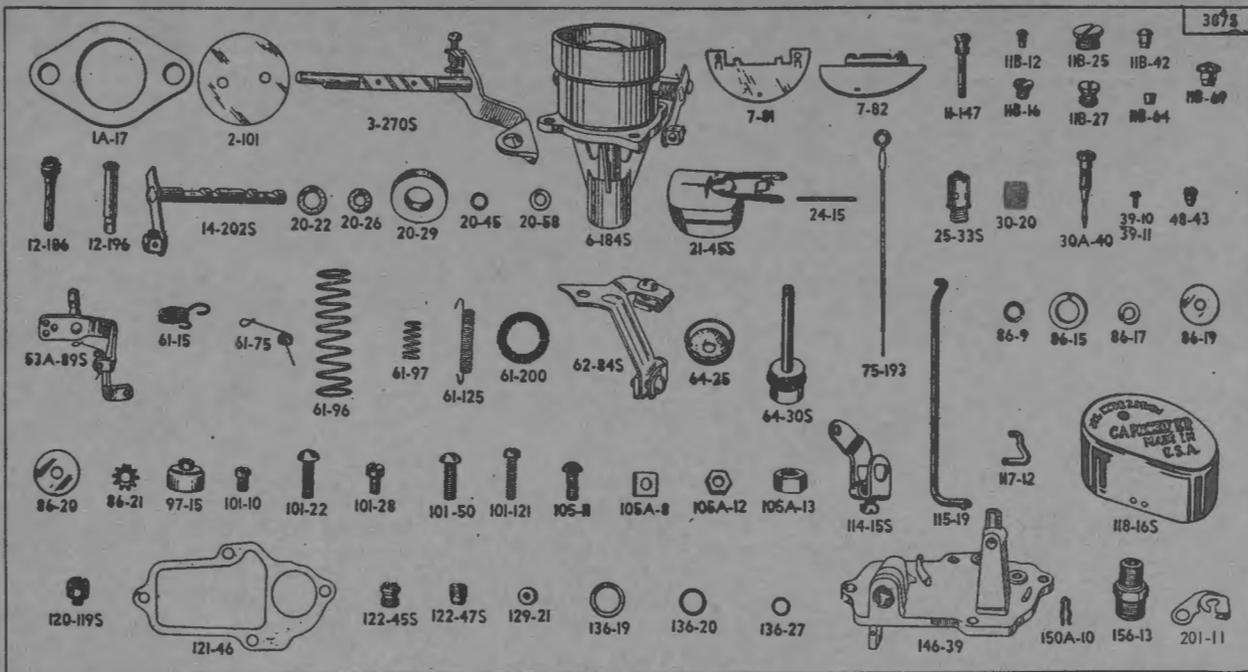
If carburetor loads up after considerable service, float level should be checked. Wear on lip of float lever will raise float level. Float level may be reset by bending lip of float lever down to raise float level or bending lever up to lower float level. Only a very slight bend is needed.

If motor stalls while idling, reset idle adjustment screw and throttle lever adjusting screw. If these adjustments do not correct the trouble, remove low speed jet tube and clean thoroughly with compressed air. Examine and see that tube seats gasoline-tight in body casting, top and bottom. If not, replace with a new tube of identical specifications. **NEVER CHANGE A LOW SPEED JET TUBE FROM ONE CARBURETER TO ANOTHER.**

Holes in pump arm provide pump adjustment. Set to longest stroke for extreme cold weather, shortest stroke for hot weather driving.

Increased resistance on foot throttle indicates a clogged pump jet. Pump jet should be removed and cleaned with compressed air, which, in many cases, will remove the dirt or lint. However, it is usually advisable to replace the pump jet, as its cost is nominal. All jets and ball checks must be seated gasoline-tight.

Poor acceleration may be due to damaged or worn plunger leather in accelerating pump, corrosion in pump cylinder, loose or cracked cylinder, cracked plunger cup or bent pump arm (parts which may be replaced at small cost). If plunger is removed from cylinder, always use loading tool in re-assembling to avoid damage to plunger leather.



Chevrolet Truck—Special Model 1940-41-42-43—Carburetors 387S-518S-518SA—List Price \$17.65

USE REPAIR PARTS PACKAGE No. 1074B, PRICE \$5.10

All Prices Subject to Prevailing Surcharge

PART NAMES IN BOLD TYPE, LISTED BELOW, INDICATE CONTENTS OF REPAIR PACKAGE

Part No.	PART NAME	List Price	Part No.	PART NAME	List Price
1A-17	Flange gasket—graphited asbestos—1¼" S. A. E.	\$0.07	61-96	Pump spring	.15
2-101	Throttle valve	.15	61-97	Adjusting screw lock spring	.15
3-2705	Throttle shaft and lever assembly (387S)	.90	61-125	Choke valve spring	.15
3-431S	Throttle shaft and lever assembly (518S-518SA)	.90	61-200	Plunger spring	.15
6-184S	Air horn assembly	3.25	62-84S	Tube clamp assembly	.35
7-81	Choker valve (not sold separately, Part of 7-89)		64-25	Plunger leather	.35
7-82	Choker valve hinge (not sold separately, Part of 7-89)		64-30S	Plunger and rod assembly (Identified by Shaft No. 49-94)	1.30
7-89	Choke valve unit (Consists of 7-81, 7-82; 61-125 and 2-39-10)	.60	75-193	Metering rod—Standard—.069"-.069" to .060"-.060" to .058"-.044" (Sup. by 75-571)	.45
11-147	Low speed jet	.30	75-571	Metering rod—Standard—.064"-.058" to .053"-.039"	.45
11B-12	Rivet plug	.04	86-15	Flange stud lock washer	.02
11B-16	Pump jet passage plug (Sup. by 11B-198)	.15	86-19	Plunger washer (inner)	.05
11B-25	Check valve passage plug	.15	86-20	Plunger washer (outer)	.05
11B-27	Nozzle and idle passage plug (Sup. by 11B-199)	.15	86-21	Plunger shaft lock washer	.02
11B-42	Rivet plug (387S-518S)	.04	97-15	Plunger cup	.20
11B-64	Rivet plug (387S-518S)	.04	101-10	Wire clamp screw	.07
11B-69	Rivet plug	.04	101-28	Throttle shaft arm clamp screw	.07
11B-198	Pump jet passage plug	.15	101-121	Throttle lever adjusting screw	.07
11B-199	Idle hole passage plug	.15	101-143S	Dust cover attaching screw and washer ass'y	.07
12-206	Nozzle ass'y (Consists of 12-186 and 12-196) (Sup by 12-303U)	.90	101-144S	Air horn attaching screw and washer assembly	.07
12-303U	Nozzle Unit (Consists of 12-300S, 120-45 and 11B-164)	.90	105-11	Tube clamp screw	.07
14-202S	Choker assembly with clamp and screw	.60	105A-8	Tube clamp nut	.07
20-22	*Needle seat gasket	.07	105A-12	Plunger shaft hex nut	.07
20-26	*Metering rod jet gasket	.07	105A-13	Flange stud nut	.07
20-29	Pump cylinder bushing gasket—upper	.07	114-15S	Throttle shaft arm and screw assembly	.30
20-45	Nozzle gasket	.07	115-19	Throttle connector rod	.20
20-58	Air horn gasket	.07	117-12	Connector link	.07
21-45S	Float and lever assembly	1.20	118-16S	Dust cover and spring assembly	.75
24-15	Float lever pin	.07	120-119S	Metering rod jet and gasket assembly, .094"	.45
25-33S	Needle and seat assembly	1.20	121-46	Bowl cover gasket	.15
30-20	Strainer gauze	.15	122-45S	Intake disk check assembly	.35
30A-40	Idle adjustment screw	.45	122-47S	Discharge disk check assembly	.35
39-10	Choke valve attaching screw	.2 for .07	129-21	Metering rod disk	.04
39-11	Throttle valve attaching screw	.2 for .07	136-15	Starting plate stem washer	.04
48-43	Pump jet, .025"	.20	136-19	Plug washer (Conical)	.02
53A-89S	Pump arm, spring and countershaft assembly	.75	136-20	Plug washer (Conical)	.02
61-15	Choker spring	.15	136-27	Plug washer (Conical)	.02
61-75	Metering rod spring	.15	146-39	Bowl cover	1.45
			150A-10	Pin spring	.02
			156-13	Gas line nipple	.30
			201-11	Metering rod disk stop	.15

*Gaskets so marked must be soaked in 90 proof denatured alcohol for 15 minutes, installed on part and let dry before using.

List price of \$4.40 per 100 applies to parts listed at \$0.07 each.
List price of \$2.55 per 100 applies to parts listed at \$0.05 each.

List price of \$1.85 per 100 applies to parts listed at \$0.04 each.
List price of \$0.75 per 100 applies to parts listed at \$0.02 each.

CARTER SERVICE DISTRIBUTORS:

AUTO ELECTRIC SERVICE CO., Ltd., 1009 BAY ST., TORONTO, ONT.
BEATTIE AUTO ELECTRIC, Ltd., 176 FORT ST., WINNIPEG, MAN.