

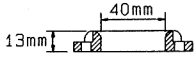
Part Four

Air Horns

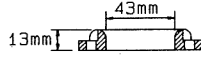
The majority of performance applications using DCOE and similar carburetors will require air horns, whether

or not air filters are fitted.

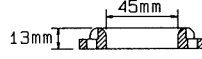
Air horns smooth the flow of air into the carburettor reducing turbulence and improving performance and response.



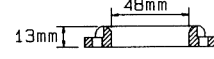
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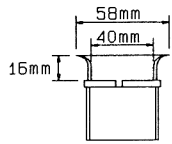
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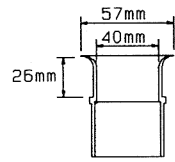
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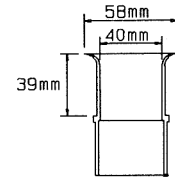
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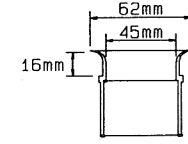
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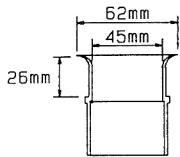
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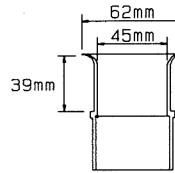
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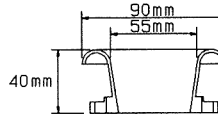
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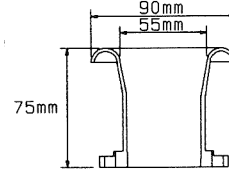
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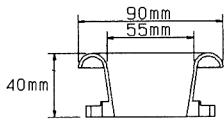
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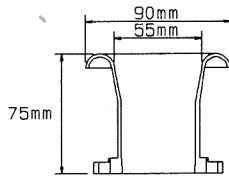
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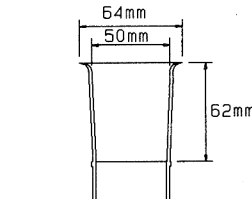
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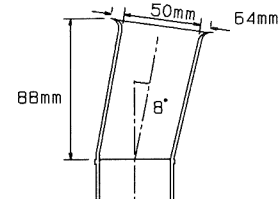
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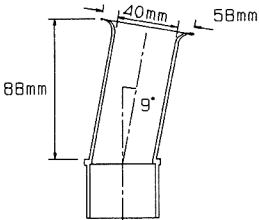
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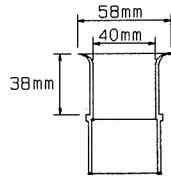
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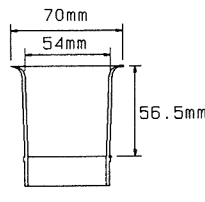
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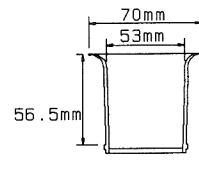
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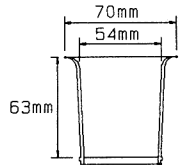
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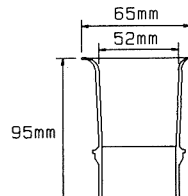
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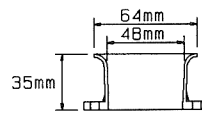
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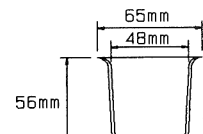
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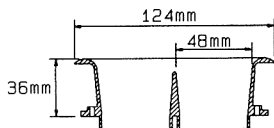
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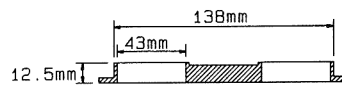
44 IDF 5284501200



44 IDF 5284501400



40 & 42 DCNF 5284800100



40 & 44 IDF 5284800300

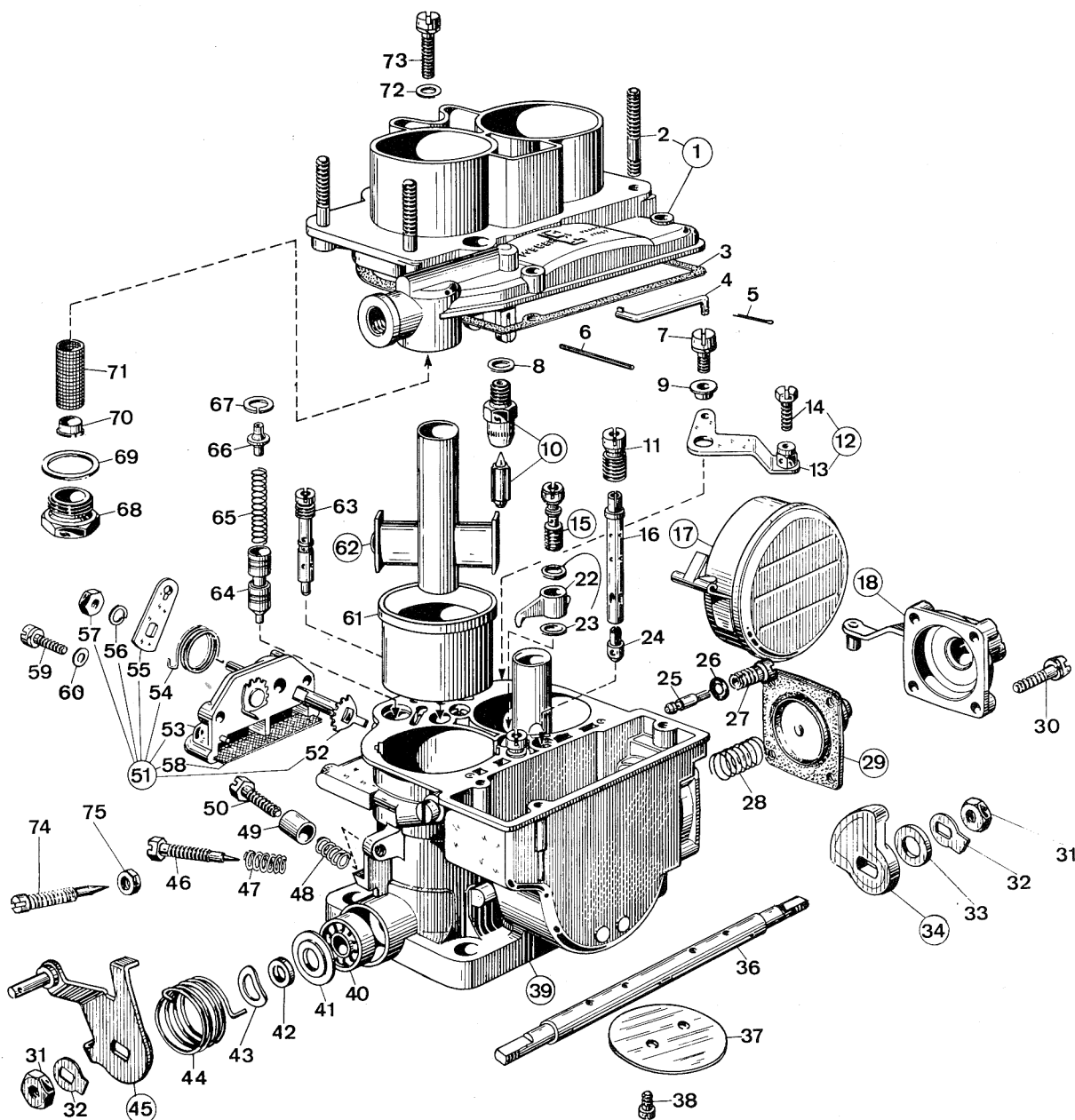
Fig Qty	Description	Code		Fig Qty	Description	Code			
1	1	Filter Cover	61002.010	48	2	Vacuum Take-Off Cover	64590.008		
2	1	Filter Cover Gasket	41530.024	M	49	2	Pump Jet Gasket	41535.021	M
3	1	Filter Element	37022.002	M	50	1	Throttle Spindle		
4	1	Jet Inspection Cover	32376.003				Return Spring	47605.012	
5	9	Screw	64700.001		51	1	Spring Anchor Plate	52210.006	
6	1	Jet Inspection Cover Gasket	41550.002	M	52	1	Throttle Stop Screw	64625.012	
7	1	Top Cover Gasket	41715.011	M	53	1	Pump Plunger	58602.003	
8	1	Needle Valve	79503.175	M	54	2	Starter Valve	64330.003	
9	1	Float	41030.034		55	2	Starter Valve Spring	47600.105	
10	2	Emulsion Tube Holder	52580.001		56	2	Idle Mixture Screw	64750.003	
11	2	Air Corrector Jet	77401.200		57	2	Pump Jet	76801.040	
12	2	Idle Jet Holder	52585.006		58	2	Pump Jet 'O' Ring	41565.009	M
13	2	Emulsion Tube	61450.031		59	2	Pump Jet Cover	61015.008	
14	1	Stud	64955.007		60	1	Pump Rod Spring	47600.064	
15	2	Main Jet	73401.115		61	1	Pump Rod	10410.015	
16	2	Idle Jet	74822.045		62	2	Starter Jet	75507.085	
17	2	Auxiliary Venturi	69912.450		63	2	Pump Demand Valve Ball	58300.003	
18	2	Air Horn	52840.012		64	2	Pump Valve Weight	52730.001	
19	4	Air Horn Fixing Nut	34705.004		65	2	Pump Demand Valve Cover	61015.006	
20	4	Spring Washer	55525.010		66	1	Needle Valve Gasket	83102.120	M
21	4	Air Horn Tab	52150.012		67	1	Fuel Union Gasket	41530.031	M
22	2	Venturi (Choke Tube)	72302.300		68	1	Fuel Union	10536.035	
23	4	Stud	64955.110		69	1	Fuel Union Gasket	41530.024	M
24	2	Lock Nut	34710.003	R	70	1	Fuel Union Bolt	12715.008	
25	2	Air By-Pass Screw Cap	14945.003		71	2	Progression Hole		
26	2	Air By-Pass Screw	64750.002				Inspection Cover	61015.009	
27	2	By-Pass Screw Lock Nut	34705.001		72	1	Float Pin	52000.001	R
28	4	Locking Screw	64830.006		73	1	Choke Cable Clamp	64605.017	
31	2	Lock Washer	55520.004	R	74	2	Starter Air Jet	77505.150	
32	2	Throttle Spindle Nut	34710.003		75	1	Carburettor Top Cover	31734.197	
33	2	Throttle Plate	64005.044		76	1	Plate	52130.003	
35	4	Throttle Plate Screw	64520.027		77	2	Washer	55510.128	
36	1	Bottom Cover Gasket	41640.001	R	78	2	Bearing	32650.001	
39	2	Inspection Cover Fixing Screw	64750.009		79	2	'O' Ring	41575.019	
40	2	Choke Cover Fixing Screw	64700.004		80	1	Inspection Cover	52135.024	
41	1	Pump Cover Gasket	41640.021	R	81	1	Gasket	41640.021	
42	1	Choke Cover	32556.018		82	1	Pin	58445.001	
43	1	Pump Spill	79701.050		83	1	Cover	32374.008	
44	2	Idle Mixture Screw 'O' Ring	41565.002	M	84	1	Pump Cam	45082.005	
45	1	Throttle Lever	45048.007		85	1	Throttle Spindle	10005.446	
46	2	Idle Mixture Screw Cup Washer	58000.006		86	2	Washer	55555.010	
47	3	Spring	47600.007						
				M + R	Service Kit			92.1514.05.01	

Calibration

Choke	30	Throttle Plate Angle	78°
Auxiliary Venturi	4.5	Needle Valve	175
Main Jet	115	Pump Jet	40
Air Corrector Jet	200	Pump Spill	50
Emulsion Tube	F11	Float Level	12 mm
Idle Jet	45 F9	Starter Jet Fuel	85/F9
Idle Mixture Orifice/Bush	100	Starter Jet Air	150
Progression Holes	120/100/100		

Special Application

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Fig	Qty	Description	Code
1	1	Carburettor Top Cover	31716.082
2	4	Stud	64955.007
3	1	Top Cover Gasket	41705.029
4	1	Choke Control Rod	61280.056
5	1	Split Pin	32610.006
6	1	Float Spindle	52000.010
7	1	Screw	64700.012
8	1	Needle Valve 'O' Ring	41535.015
9	1	Bush	12775.010
10	1	Needle Valve	79514.175
11	2	Air Corrector Jet	77501.220
12	1	Choke Control Lever	45096.020
13	1	Lever	45096.019
14	1	Screw	64615.004
15	1	Pump Demand Valve	64290.014
16	2	Emulsion Tube	61450.224
17	1	Float	41015.005
18	1	Pump Cover	32486.041
22	1	Pump Jet	76215.045
23	2	Pump Jet 'O' Ring	41530.012
24	2	Main Jet	73405.125
25	2	Idle Jet	74405.050
26	2	Idle Jet 'O' Ring	41565.002
27	2	Idle Jet Holder	52570.006
28	1	Pump Spring	47600.107
29	1	Pump Diaphragm	47407.050
30	4	Pump Cover Screw	64700.006
31	2	Throttle Spindle Nut	34710.003
32	2	Lock Washer	55520.004
33	1	Bush	12750.032
34	1	Pump Cam	14852.011
36	1	Throttle Spindle	10005.211
37	2	Throttle Valve	64005.020
38	4	Throttle Valve Screw	64520.027
40	2	Roller Bearing	32650.001
41	2	Bearing Cover	58000.017
42	2	Spacer Bush	12750.053

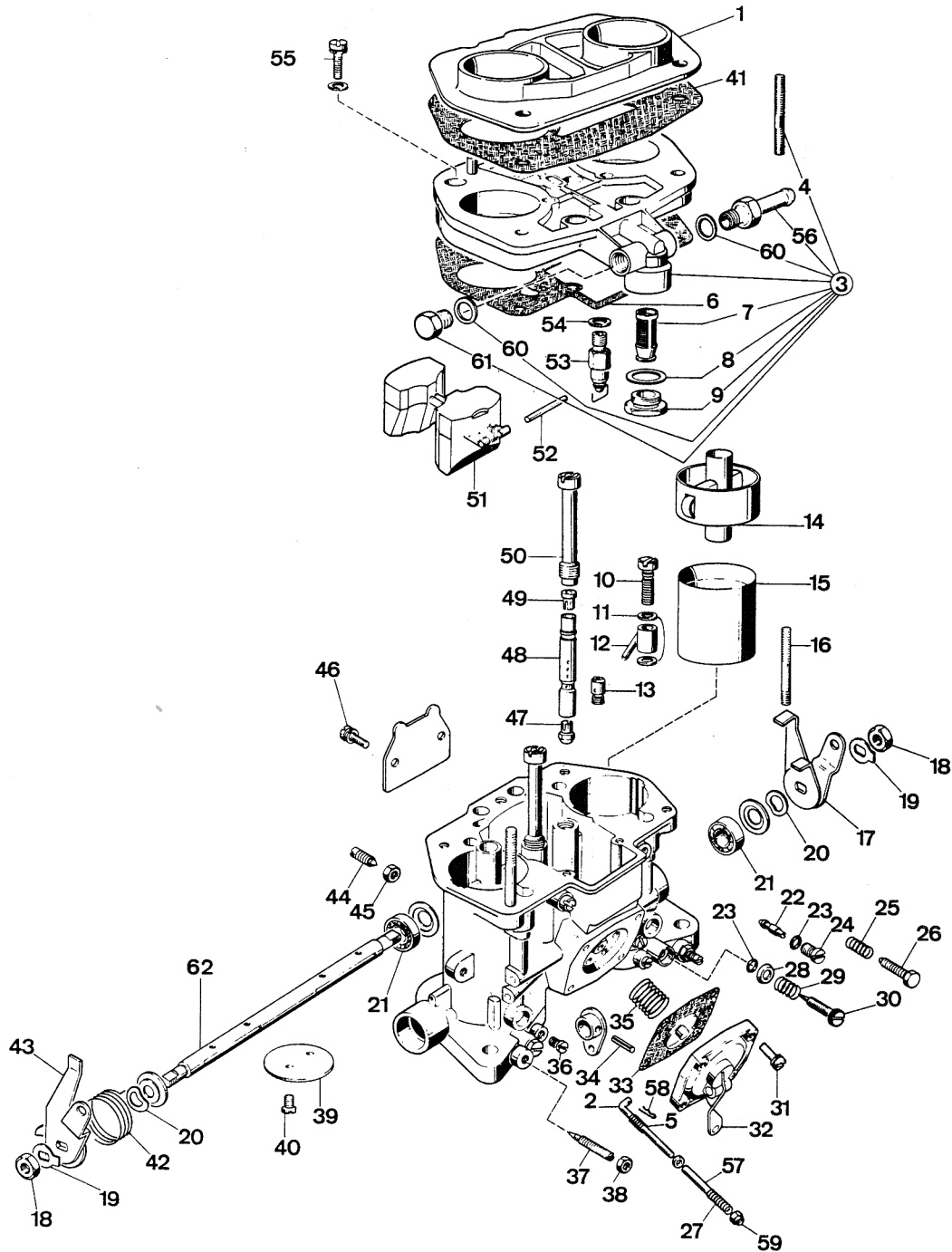
Fig	Qty	Description	Code
43	2	'O' Ring	55530.010
44	1	Throttle Return Spring	47610.078
45	1	Throttle Control Lever	45041.049
46	2	Idle Mixture Screw	64755.007
47	2	Idle Mixture Screw Spring	47600.007
48	1	Throttle Stop Screw Ring	47600.007
49	1	Throttle Stop Screw Spacer	12785.013
50	1	Throttle Stop Screw	64625.014
51	1	Starter Cover	32556.017
52	1	Choke Control Spindle	10085.009
53	1	Cover	32556.016
54	1	Return Spring	47610.043
55	1	Choke Lever	45025.089
56	1	Spring Washer	55525.010
57	1	Nut	34715.010
58	1	Filter Gauze	37000.016
59	2	Choke Cover Screw	64700.004
60	2	Washer	55510.038
61	2	Venturi (Choke Tube)	72129.320
62	2	Auxiliary Venturi	71107.450
63	2	Starter Jet	75605.075
64	2	Starter Valve	64330.008
65	2	Starter Valve Spring	47600.139
66	2	Spring Guide	12775.024
67	2	Spring Clip	10140.002
68	1	Fuel Filter Inspection Cover	61002.010
69	1	Fuel Filter Cover Gasket	41530.024
70	1	Filter Washer	61060.001
71	1	Fuel Filter	37020.002
72	4	Washer	55510.034
73	4	Top Cover Screw	64700.005
74	2	Air By-Pass Screw	64750.002
75	2	Air By-Pass Screw Locking Nut	34705.001
Gasket Kit			92.0077.05
Service Kit			92.1637.05

Calibration

Choke	32	Needle Valve	175
Auxiliary Venturi	4.5	Pump Jet	45
Main Jet	125	Float Level	50 mm
Air Corrector Jet	220	Starter Jet	75/F5
Emulsion Tube	F24	Pump Demand Valve	100
Idle Jet	50		

Special Application

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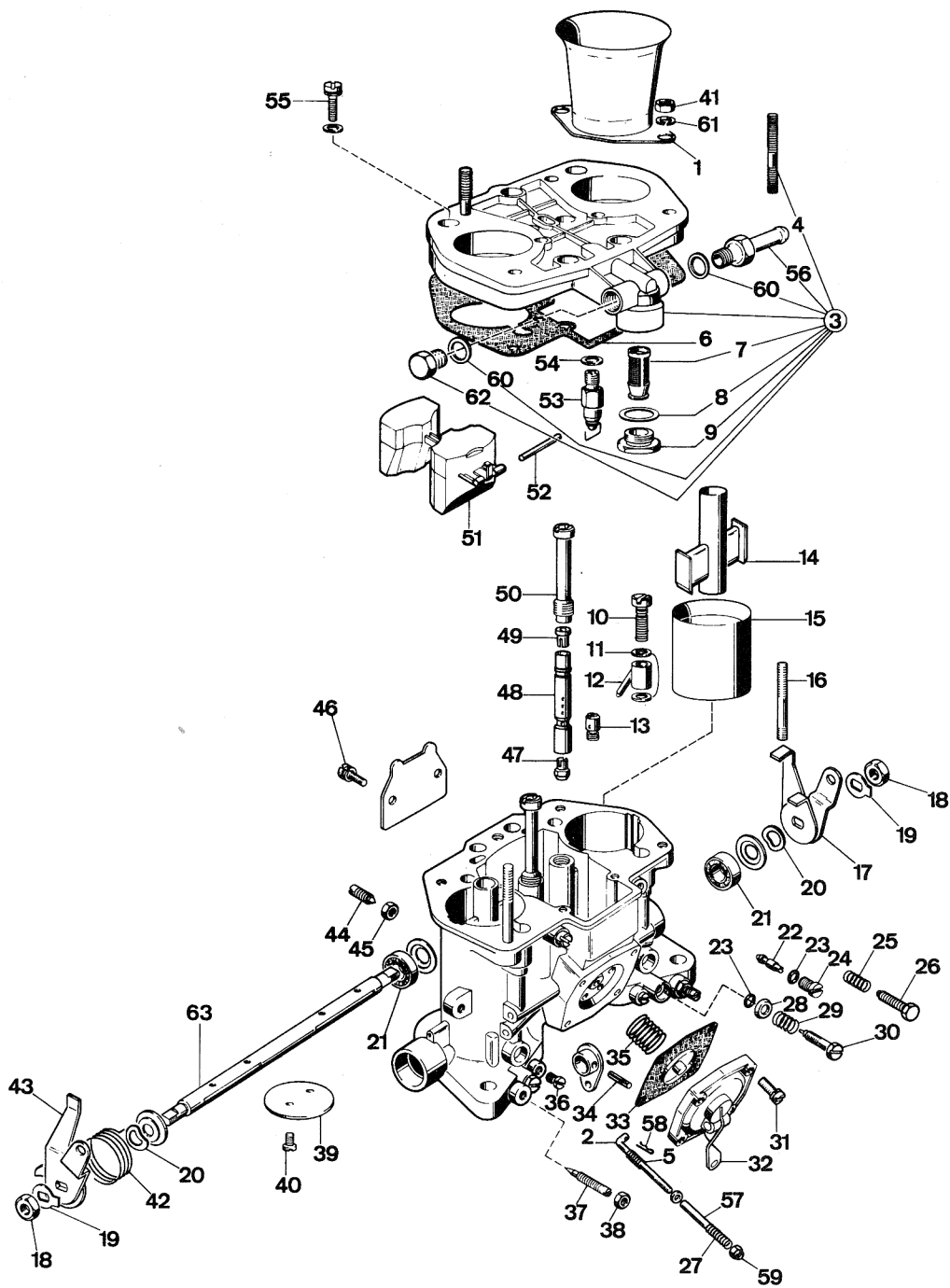
Fig Qty	Description	Code		Fig Qty	Description	Code		
1	1	Air Horn	52848.003	33	1	Pump Diaphragm	47407.207 R	
2	1	Pump Control Rod	61285.042	34	1	Fixing Pin	58445.001	
3	1	Carburettor Top Cover	93.0078.05	35	1	Pump Diaphragm Spring	47600.250	
4	2	Stud	64955.108	36	2	Vacuum Take-Off Cover	61015.005	
5	1	Pump Rod Spring	47600.252	37	2	Air By-Pass Screw	64750.029	
6	1	Carburettor Main Gasket	41705.085	M	38	2	Air By-Pass Screw Nut	34705.001
7	1	Fuel Filter	37022.002	M	39	2	Throttle Plate	64005.126
8	1	Fuel Filter Gasket	41530.024	M	40	4	Throttle Plate Fixing Screw	64520.027
9	1	Fuel Filter Cover	61002.010		41	1	Air Horn Gasket	41655.020 R
10	2	Pump Demand Valve	64290.016		42	1	Throttle Return Spring	47610.035
11	4	Pump Jet Gasket	41530.012	M	43	1	Throttle Lever	45034.109
12	2	Pump Jet	76210.050		44	2	Choke Tube Fixing Screw	64830.002
13	1	Pump Spill	79701.055		45	2	Choke Tube Fixing Screw Nut	34715.010
14	2	Auxiliary Venturi	69002.450		46	2	Fixing Screw	64700.013
15	2	Venturi (Choke Tube)	71506.280		47	2	Main Jet	73401.115
16	2	Stud	64955.114		48	2	Emulsion Tube	61450.031
17	1	Throttle Lever	45034.110		49	2	Air Corrector Jet	77401.200
18	2	Throttle Spindle Nut	34710.003		50	2	Emulsion Tube Holder	52580.006
19	2	Lock Washer	55520.004	R	51	1	Float	41030.008
20	2	Spring Ring	55530.005		52	1	Float Pin	52000.001 R
21	2	Race Bearing	32650.003		53	1	Needle Valve	79511.175 M
22	2	Idle Jet	74405.050		54	1	Needle Valve Gasket	83102.100 M
23	4	Idle Jet 'O' Ring	41565.002		55	5	Top Cover Fixing Screw	64700.005
24	2	Idle Jet Holder	52570.006		56	1	Fuel Inlet Pipe	10525.023
25	1	Throttle Stop Screw Spring	47600.007		57	1	Pump Adjustment Rod	12750.126
26	1	Throttle Stop Screw	64625.015		58	1	Spring Clip	32610.003 R
27	1	Pump Rod Spring	47600.251		59	1	Pump Rod Nut	34725.008
28	2	Mixture Screw 'O' Ring Cap	58000.006		60	2	Fuel Pipe Gasket	41535.003 M
29	2	Mixture Screw Spring	47600.062		61	1	Threaded Cap	61002.022
30	2	Mixture Screw	64750.003		62	1	Throttle Shaft	10005.243
31	4	Pump Cover Screw	64700.004					
32	1	Pump Cover	32486.085					
					M + R	Service Kit	92.1502.0502	

Calibration

Choke	28	Progression Holes	80/90/90/100
Auxiliary Venturi	4.5	Throttle Plate Angle	78°
Main Jet	115	Needle Valve	175
Air Corrector Jet	200	Pump Jet	50
Emulsion Tube	F11	Float Level	12 mm
Idle Jet	50	Mechanical Pump	
Idle Air Bush	115	Gap	5.5 mm
Idle Mixture Orifice/Bush	100		
Spark Advance Orifice	100		

Special Application

CARBURETTOR 44 IDF - Part No. 18990.030



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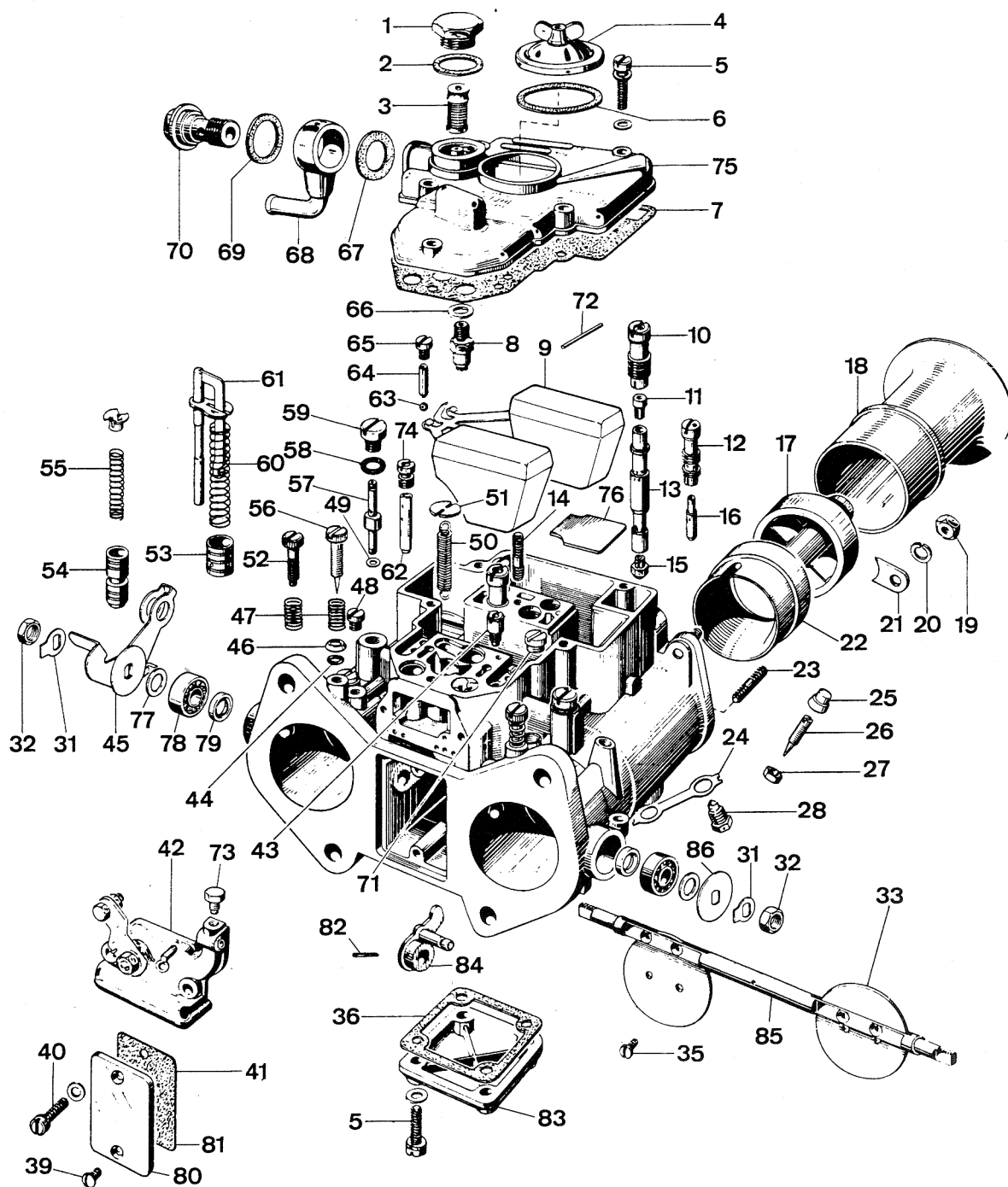
Fig	Qty	Description	Code		Fig	Qty	Description	Code	
1	2	Air Horn	52845.014		34	1	Fixing Pin	58445.001	
2	1	Pump Control Rod	61285.042		35	1	Pump Diaphragm Spring	47600.250	
3	1	Carburettor Top Cover	93.007405		36	3	Vacuum Take-Off Cover	61015.005	
4	2	Stud	64955.108		37	2	Air By-Pass Screw	64750.029	
5	1	Pump Rod Spring	47600.252		38	2	Air By-Pass Screw Nut	34705.001	
6	1	Carburettor Main Gasket	41705.086	M	39	2	Throttle Plate	64005.013	
7	1	Fuel Filter	37022.002	M	40	4	Throttle Plate Fixing Screw	64520.027	
8	1	Fuel Filter Gasket	41530.024	M	41	4	Air Horn Nut	34705.004	
9	1	Fuel Filter Cover	61002.010		42	1	Throttle Return Spring	47610.035	
10	2	Pump Demand Valve	64290.016		43	1	Throttle Lever	45034.109	
11	4	Pump Jet Gasket	41540.014	M	44	2	Choke Tube Fixing Screw	64830.002	
12	2	Pump Jet	76210.050		45	2	Choke Tube Fixing Screw Nut	34715.010	
13	1	Pump Spill	79701.055		46	2	Fixing Screw	64700.013	
14	2	Auxiliary Venturi	71102.450		47	2	Main Jet	73401.135	
15	2	Venturi (Choke Tube)	71513.360		48	2	Emulsion Tube	61450.031	
16	2	Stud	64955.110		49	2	Air Corrector Jet	77401.175	
17	1	Throttle Lever	45034.110		50	2	Emulsion Tube Holder	52580.006	
18	2	Throttle Spindle Nut	34710.003		51	1	Float	41030.008	
19	2	Lock Washer	55520.004	R	52	1	Float Pin	52000.001	R
20	2	Spring Ring	55530.005		53	1	Needle Valve	79511.175	M
21	2	Race Bearing	32650.003		54	1	Needle Valve Gasket	83102.100	M
22	2	Idle Jet	74405.050		55	5	Top Cover Fixing Screw	64700.005	
23	4	Idle Jet 'O' Ring	41565.002		56	1	Fuel Inlet Pipe	10525.023	
24	2	Idle Jet Holder	52570.006		57	1	Pump Adjustment Rod	12750.126	
25	1	Throttle Stop Screw Spring	47600.007		58	1	Spring Clip	32610.003	
26	1	Throttle Stop Screw	64625.015		59	1	Pump Rod Nut	34725.008	
27	1	Pump Rod Spring	47600.251		60	2	Fuel Pipe Gasket	41535.003	M
28	2	Mixture Screw 'O' Ring Cap	58000.006		61	4	Air Horn Washer	55555.056	
29	2	Mixture Screw Spring	47600.062		62	1	Threaded Cap	61002.022	
30	2	Mixture Screw	64755.013		63	1	Throttle Shaft	10005.243	
31	4	Pump Cover Screw	64700.004						
32	1	Pump Cover	32486.085						
33	1	Pump Diaphragm	47407.207	R					
					M + R		Service Kit	92.1508.05	

Calibration

Choke	36	Spark Advance Orifice	100
Auxiliary Venturi	4.5	Progression Holes	80/90/90/100
Main Jet	135	Throttle Plate Angle	78°
Air Corrector Jet	175	Needle Valve	175
Emulsion Tube	F11	Pump Jet	50
Idle Jet	50	Float Level	12 mm
Idle Mixture Orifice/Bush	100		

Special Application

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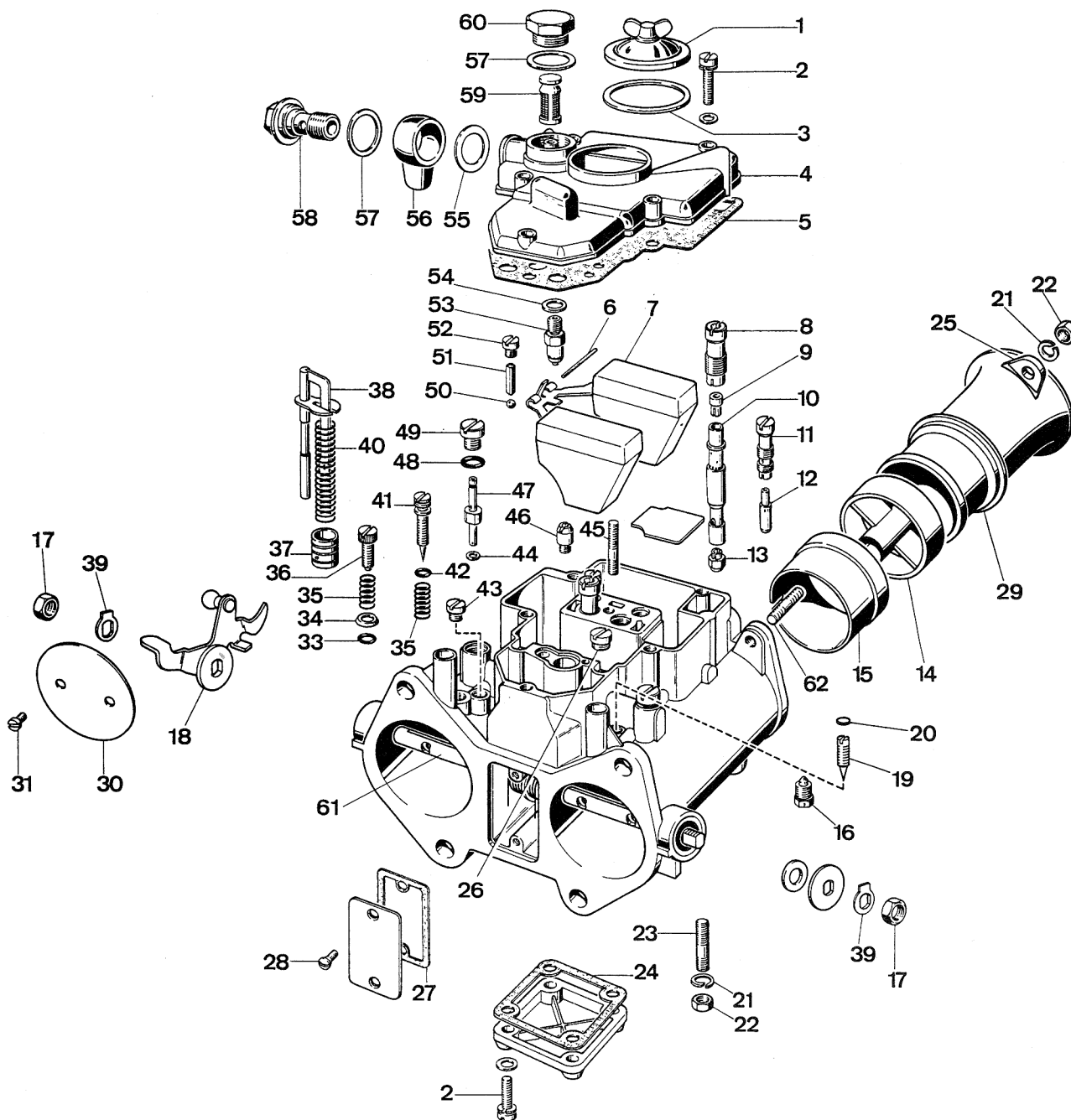
Fig Qty	Description	Code		Fig Qty	Description	Code	
1 1	Filter Cover	61002.010		48 2	Vacuum Take-Off Cover	64590.008	
2 1	Filter Cover Gasket	41530.024	M	49 2	Pump Jet Gasket	41535.021	M
3 1	Filter Element	37022.002	M	50 1	Spring	47605.012	
4 1	Jet Inspection Cover	32376.003		51 1	Spring Anchor Plate	52210.006	
5 9	Screw	64700.001		52 1	Throttle Stop Screw	64625.012	
6 1	Jet Inspection Cover Gasket	41550.002	M	53 1	Pump Plunger	58602.003	
7 1	Top Cover Gasket	41715.011	M	54 2	Starter Valve	64330.003	
8 1	Needle Valve	79503.200	M	55 2	Starter Valve Spring	47600.105	
9 1	Float	41030.034		56 2	Idle Mixture Screw	64750.003	
10 2	Emulsion Tube Holder	52580.001		57 2	Pump Jet	76801.045	
11 2	Air Corrector Jet	77401.155		58 2	Pump Jet 'O' Ring	41565.009	M
12 2	Idle Jet Holder	52585.006		59 2	Pump Jet Cover	61015.008	
13 2	Emulsion Tube	61450.181		60 1	Pump Rod Spring	47600.064	
14 1	Stud	64955.007		61 1	Pump Rod	10410.015	
15 2	Main Jet	73401.145		62 2	Starter Jet	75507.085	
16 2	Idle Jet	74821.055		63 2	Pump Demand Valve Ball	58300.003	
17 2	Auxiliary Venturi	69602.450		64 2	Pump Valve Weight	52730.001	
18 2	Air Horn	52840.001		65 2	Pump Demand Valve Cover	61015.006	
19 4	Air Horn Fixing Nut	34705.004		66 1	Needle Valve Gasket	83102.120	M
20 4	Spring Washer	55525.010		67 1	Fuel Union Gasket	41530.031	M
21 4	Air Horn Tab	52150.004		68 1	Fuel Union	10536.035	
22 2	Venturi (Choke Tube)	72116.360		69 1	Fuel Union Gasket	41530.024	M
23 4	Stud	64955.110		70 1	Fuel Union Bolt	12715.008	
24 2	Lock Washer	52155.003		71 2	Progression Hole		
25 2	Air By-Pass Screw Cap	14945.003			Inspection Cover	61015.009	
26 2	Air By-Pass Screw	64750.002		72 1	Float Pin	52000.001	R
27 2	By-Pass Screw Lock Nut	34705.001		73 1	Choke Cable Clamp	64605.017	
28 2	Locking Screw	64840.003		74 2	Starter Air Jet	77505.150	
31 2	Lock Washer	55520.004	R	75 1	Carburettor Top Cover	31734.198	
32 2	Throttle Spindle Nut	34710.003		76 1	Plate	52130.003	
33 2	Throttle Plate	64005.084		77 2	Washer	55510.128	
35 4	Throttle Plate Screw	64520.027		78 2	Bearing	32650.001	
36 1	Bottom Cover Gasket	41640.001	R	79 2	'O' Ring	41575.019	
39 2	Inspection Cover Fixing Screw	64750.009		80 1	Inspection Cover	52135.024	
40 2	Choke Cover Fixing Screw	64700.004		81 1	Gasket	41640021	
41 1	Pump Cover Gasket	41640.021	R	82 1	Pin	58445.001	
42 1	Choke Cover	32556.018		83 1	Cover	32374.008	
43 1	Pump Spill	79701.040		84 1	Pump Cam	45082.005	
44 2	Idle Mixture Screw 'O' Ring	41565.002	M	85 1	Throttle Spindle	10005.447	
45 1	Throttle Lever	45048.007		86 1	Washer	55555.010	
46 2	Idle Mixture						
	Screw Cup Washer	58000.006					
47 3	Spring	47600.007					
				M + R	Service Kit	92.1514.05.01	

Calibration

Choke	36	Progression Holes	120/100/80
Auxiliary Venturi	4.5	Throttle Plate Angle	78°
Main Jet	145	Needle Valve	200
Air Corrector Jet	155	Pump Jet	45
Emulsion Tube	F16	Pump Spill	40
Idle Jet	55/F8	Float Level	12 mm
Idle Mixture Orifice/Bush	100		

Special Application

CARBURETTOR 48 DCO 2/SP - Part No. 19630.007



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Fig	Qty	Description	Code	
1	1	Jet Inspection Cover	32376.003	
2	9	Screw	64700.001	
3	1	Jet Inspection Cover Gasket	41550.009	M
4	1	Carburettor Cover	31734.199	
5	1	Carburettor Cover Gasket	41715.011	M
6	1	Float Pin	52000.001	R
7	1	Float	41030.034	
8	2	Emulsion Tube Holder	52580.001	
9	2	Air Corrector	77401.160	
10	2	Emulsion Tube	61450.091	
11	2	Idle Jet Holder	52585.006	
12	2	Idle Jet	74821.065	
13	2	Main Jet	73401.180	
14	2	Auxiliary Venturi	68820.500	
15	2	Venturi (Choke Tube)	72136.420	
16	4	Screw	64840.003	
17	1	Throttle Spindle Nut	34710.003	
18	1	Throttle Lever	45041.145.04	
19	2	Air By-Pass Screw	64595.012	
20	2	Air By-Pass Screw Cover	61030.008	
21	5	Spring Washer	55525.010	
22	5	Support Bracket Fixing Nut	34705.004	
23	1	Support Bracket Stud	64955.104	
24	1	Bottom Cover Gasket	41640.066	R
25	4	Air Horn Tab	52135.053	
26	2	Progression Hole Inspection Cover	61015.009	
27	1	Inspection Cover Gasket	41640.065	R
28	2	Inspection Cover Fixing Screw	64570.009	
29	1	Air Horn	52840.034	
30	2	Throttle Plate	64005.108	
31	4	Throttle Plate Fixing Screw	64520.027	
32	4	Stud	64955.110	

Fig	Qty	Description	Code	
33	1	Throttle Stop Screw 'O' Ring	41565.002	R
34	1	Throttle Stop Screw 'O' Ring Cap	58000.006	
35	3	Mixture Screw Spring	47600.007	
36	1	Throttle Stop Screw	64625.015	
37	1	Pump Plunger	58602.003	
38	1	Pump Rod	10410.015	
39	2	Throttle Spindle Lock Washer	55520.004	R
40	1	Pump Rod Spring	47600.068	
41	2	Mixture Screw	64750.058	
42	2	Mixture Screw 'O' Ring	41565.015	M
43	2	Vacuum Take Off Cover	64590.008	
44	2	Pump Jet Gasket	41535.021	M
45	1	Stud	64955.007	
46	1	Pump Spill	79701.100	
47	2	Pump Jet	76801.045	
48	2	Pump Jet Cover 'O' Ring	41565.009	M
49	2	Pump Jet Cover	61015.008	
50	2	Pump Demand Valve Ball	58300.003	
51	2	Pump Demand Valve Weight	52730.001	
52	2	Pump Demand Valve Cover	61015.006	
53	1	Needle Valve	79503.250	M
54	1	Needle Valve Gasket	83102.100	M
55	1	Fuel Union Gasket	41530.031	M
56	1	Fuel Union	10354.019	
57	2	Fuel Union and Filter Cover Gasket	41530.024	M
58	1	Fuel Union Bolt	12715.008	
59	1	Fuel Filter	37022.002	M
60	1	Fuel Filter Cover	61002.010	
61	1	Throttle Shaft	10020.424	
M + R Service Kit			92.1462.05.01	

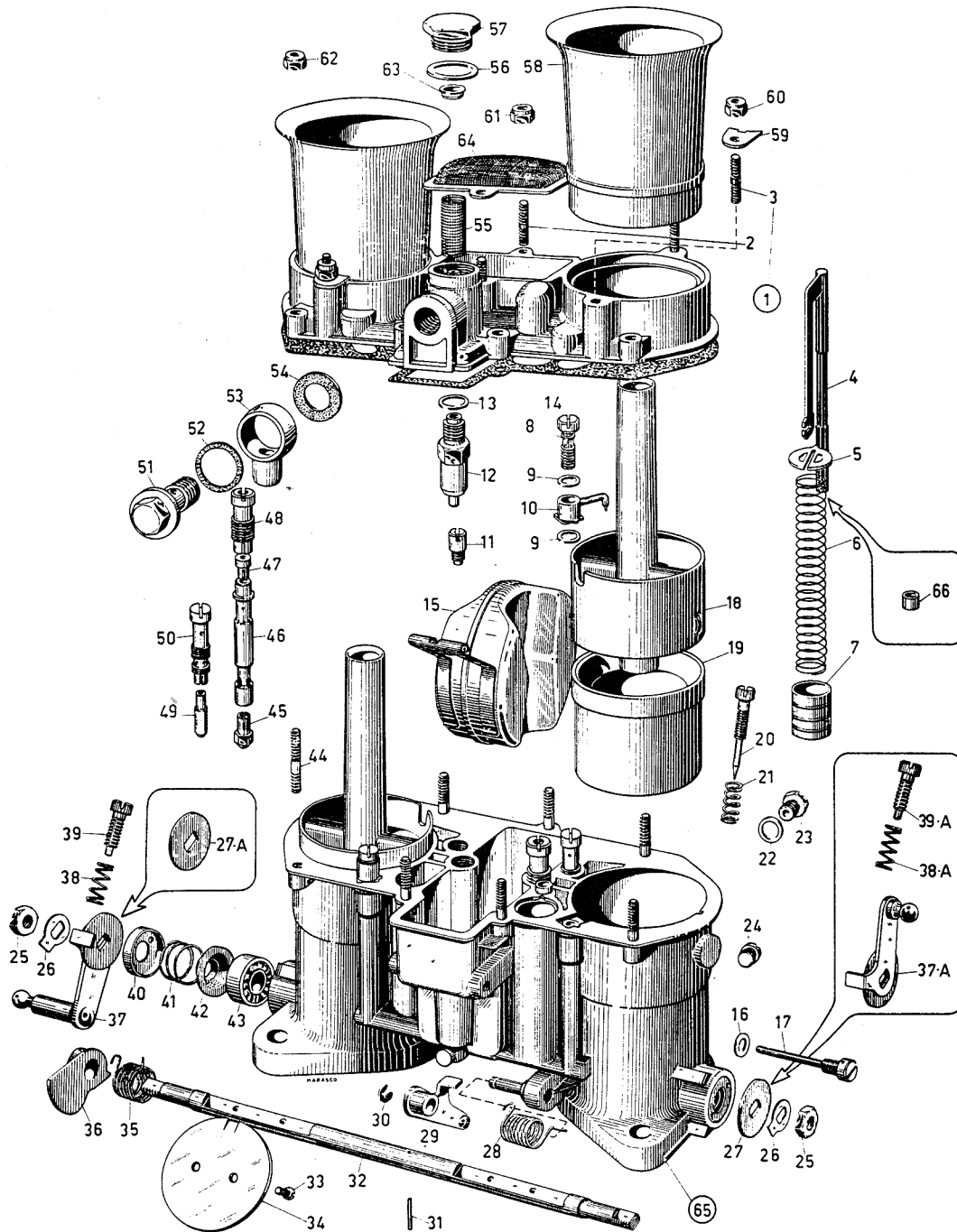
Calibration

Choke	42
Auxiliary Venturi	5.0
Main Jet	180
Air Corrector Jet	160
Emulsion Tube	F7
Idle Jet	F8/65
Idle Mixture Orifice/Bush	135

Progression Holes	100/100/100
Needle Valve	250
Pump Jet	45
Pump Spill	100
Float Level	12 mm

Special Application

CARBURETTOR 48 IDA/46 IDA - Part No. 19030015



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Fig	Qty	Description	Code
1	1	Carburettor Top Cover	31716.056
2	2	Stud	64955.009
3	4	Stud	64955.003
4	1	Pump Rod	10410.021
5	1	Spring Retaining Clip	52140.007
6	1	Pump Spring	47600.103
7	1	Pump Plunger	58602.005
8	2	Pump Demand Valve	64290.003
9	4	Pump Jet 'O' Ring	41530.012
10	2	Pump Jet	76402.050
11	1	Pump Spill	79701.000
12	1	Needle Valve	79504.200
13	1	Needle Valve 'O' Ring	41530.032
14	1	Top Cover Gasket	41705.021
15	1	Float	41015.007
16	1	'O' Ring	41530.017
17	1	Float Spindle	64900.012
18	2	Auxiliary Venturi	69009.450
19	2	Venturi (Choke Tube)	72128.370
20	2	Idle Mixture Screw	64750.007
21	2	Idle Mixture Screw Spring	47600.007
22	1	'O' Ring	41530.008
23	1	Threaded Cover	61002.006
24	2	Progression Hole	
		Inspection Cover	61015.001
25	2	Throttle Spindle Nut	34710.003
26	2	Lock Washer	55520.004
27	1	Washer	55555.010
28	1	Throttle Return Spring	47610.066
29	1	Pump Lever	45034.074
30	1	Spring Washer	10140.502
31	1	Pin	58445.001
32	1	Throttle Spindle	10005.425
33	4	Throttle Spindle Screws	64570.006

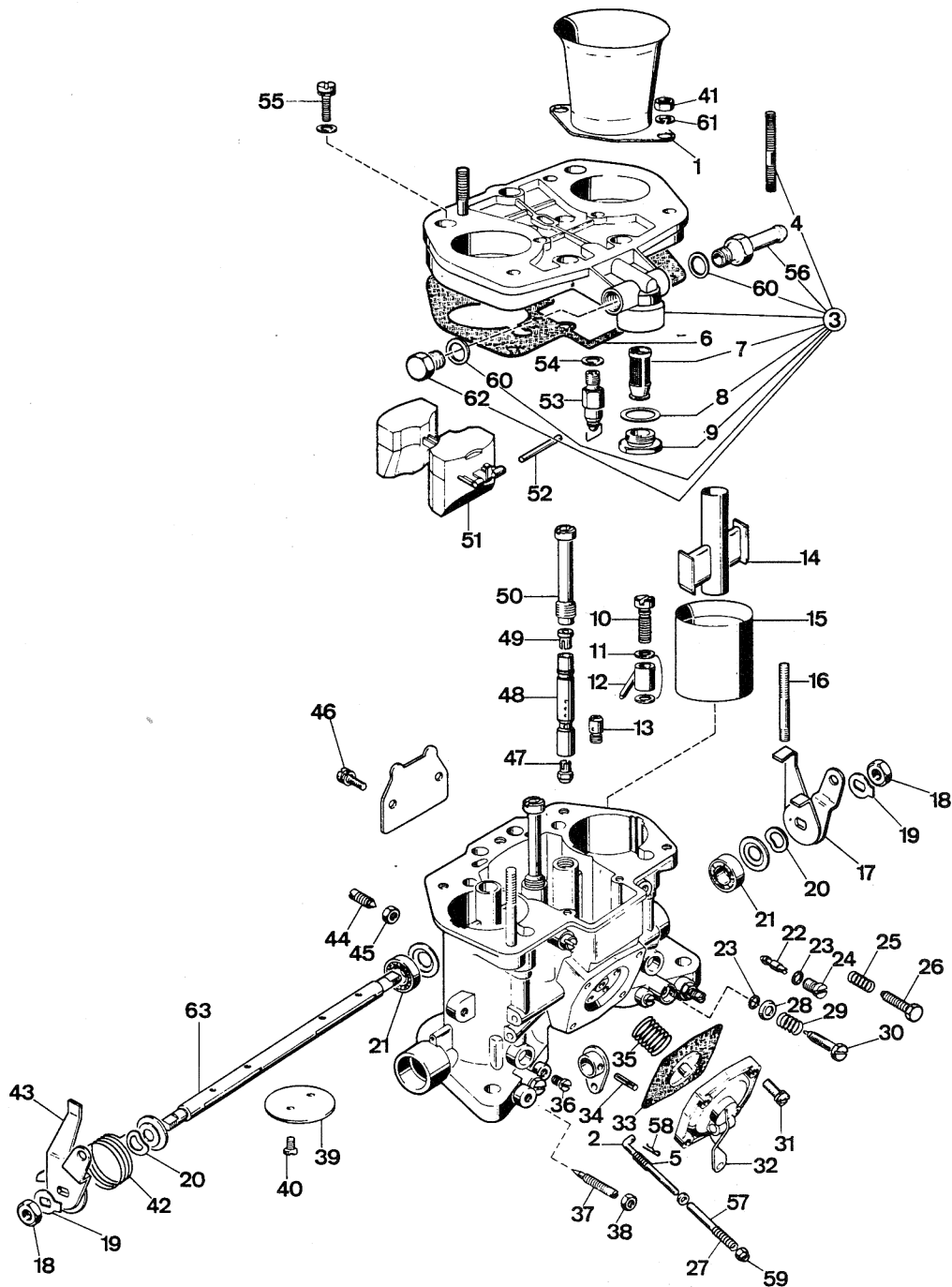
Fig	Qty	Description	Code
34	2	Throttle Valves	64005.091
35	1	Throttle Return Spring	47610.067
36	1	Cam	14852.001
37	1	Throttle Lever	45034.066
38	1	Throttle Stop Screw Spring	47600.007
39	1	Throttle Stop Screw	64590.002
40	2	Compression Spring Cover	58000.007
41	2	Compression Spring	47600.063
42	2	Dust Cap	41570.001
43	2	Roller Bearing	32650.001
44	7	Stud	64955.012
45	2	Main Jet	73401.135
46	2	Emulsion Tube	61450.091
47	2	Air Corrector Jet	77401.120
48	2	Emulsion Tube Holder	52580.001
49	2	Idle Jet	74823.070
50	2	Idle Jet Holder	77903.120
51	1	Fuel Rail Bolt	12715.008
52	1	Gasket	41530.024
53	1	Fuel Banjo	10354.001
54	1	Gasket	41530.031
55	1	Fuel Filter Element	37020.005
56	1	Fuel Filter Cover Gasket	41530.024
57	1	Fuel Filter Cover	61002.010
58	2	Air Horn	52840.027
59	4	Air Horn Fixing Tab	52150.015
60	4	Air Horn Fixing Tab Nut	34725.003
61	2	Gauze Cover Nut	34725.003
62	7	Carburettor Top Cover Nut	34725.003
63	1	Filter Locating Ring	12775.026
64	1	Gauze Cover	37012.004
66	1	Pump Rod Bush	12750.077
		Service Kit	92.1632.05

Calibration

Choke	37	Idle Mixture Orifice/Bush	100
Auxiliary Venturi	4.5	Spark Advance Orifice	
Main Jet	135	Progression Holes	100/100
Air Corrector Jet	120	Needle Valve	200
Emulsion Tube	F7	Pump Jet	50
Idle Jet	F10/70	Float Level	5.75

Special Application

CARBURETTOR 48 IDF 6 - Part No. 19030.021



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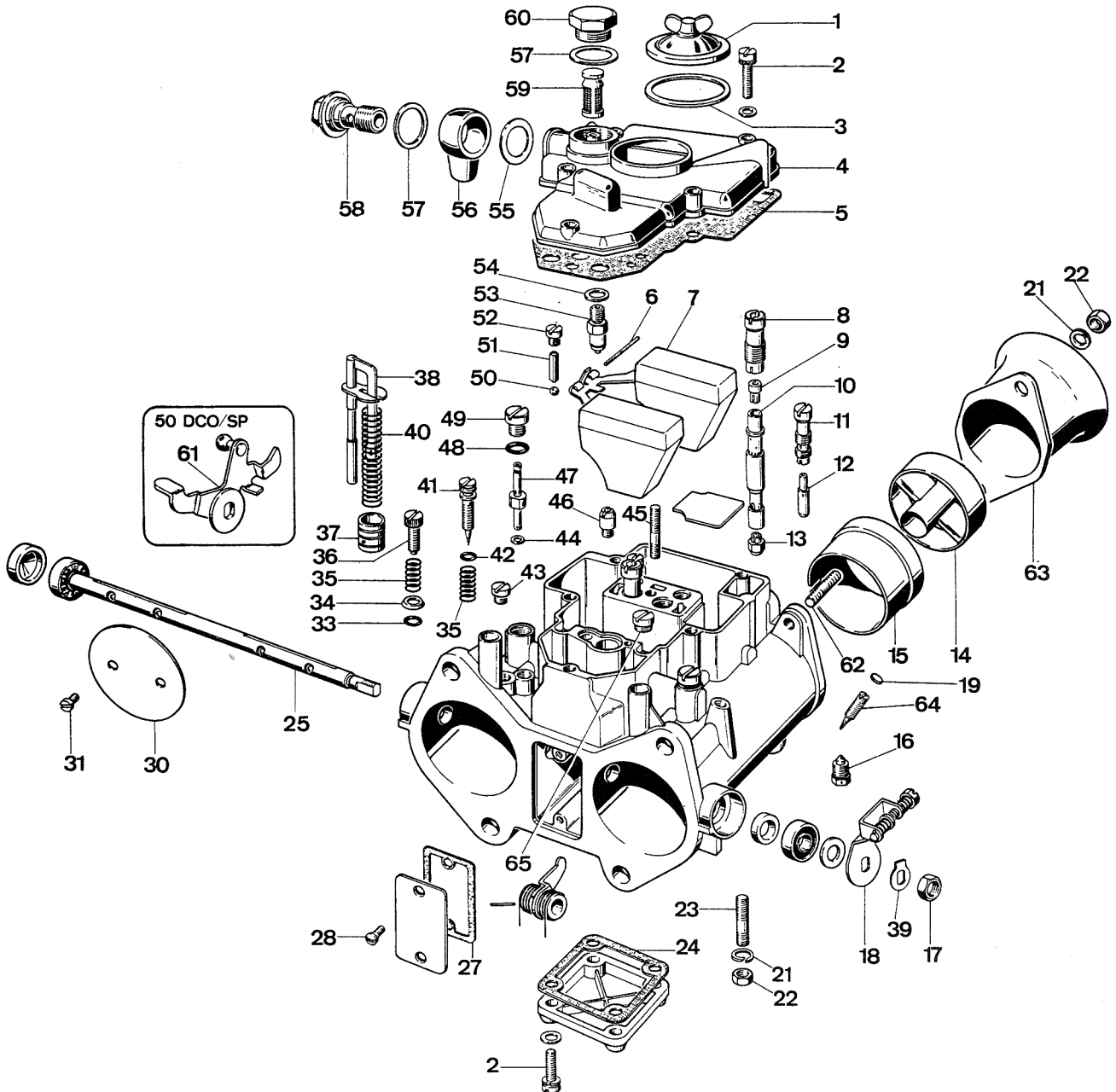
Fig Qty	Description	Code		Fig Qty	Description	Code	
1 2	Air Horn	52845.014		34 1	Fixing Pin	58445.001	
2 1	Pump Control Rod	61285.042		35 1	Pump Diaphragm Spring	47600.250	
3 1	Carburettor Top Cover	93.0079.05		36 3	Vacuum Take-Off Cover	61015.005	
4 2	Stud	64955.108		37 2	Air By-Pass Screw	64750.002	
5 1	Pump Rod Spring	47600.252		38 2	Air By-Pass Screw Nut	34715.006	
6 1	Carburettor Main Gasket	41705.087	M	39 2	Throttle Plate	64005.108	
7 1	Fuel Filter	37022.002	M	40 4	Throttle Plate Fixing Screw	64520.027	
8 1	Fuel Filter Gasket	41530.024	M	41 4	Air Horn Nut	34705.004	
9 1	Fuel Filter Cover	61002.010		42 1	Throttle Return Spring	47610.035	
10 2	Pump Demand Valve	64290.016		43 1	Throttle Lever	45034.109	
11 4	Pump Jet Gasket	41540.014	M	44 2	Choke Fixing Screw	64830.002	
12 2	Pump Jet	76210.050		45 2	Choke Tube Fixing Screw Nut	34715.010	
13 1	Pump Spill	79701.000		46 2	Choke Circuit Cover Screw	64700.013	
14 2	Auxiliary Venturi	71124.450		47 2	Main Jet	73401.150	
15 2	Venturi (Choke Tube)	71513.400		48 2	Emulsion Tube	61450.027	
16 2	Stud	64955.114		49 2	Air Corrector Jet	77401.180	
17 1	Throttle Lever	45034.110		50 2	Emulsion Tube Holder	52580.006	
18 2	Throttle Spindle Nut	34710.003		51 1	Float	41030.008	
19 2	Lock Washer	55520.004	R	52 1	Float Pin	52000.001	R
20 2	Spring Ring	55530.005		53 1	Needle Valve	79511.200	M
21 2	Race Bearing	32650.003		54 1	Needle Valve Gasket	83102.100	M
22 2	Idle Jet	74405.055		55 5	Top Cover Fixing Screw	64700.005	
23 4	Idle Jet 'O' Ring	41565.002		56 1	Fuel Inlet Pipe	10525.023	
24 2	Idle Jet Holder	52570.006		57 1	Pump Adjustment Rod	12750.126	
25 1	Throttle Stop Screw Spring	47600.007		58 1	Spring Clip	32610.003	R
26 1	Throttle Stop Screw	64625.015		59 1	Pump Rod Nut	34725.008	
27 1	Pump Rod Spring	47600.251		60 2	Fuel Pipe Gasket	41535.003	M
28 2	Mixture Screw 'O' Ring Cap	58000.006		61 4	Air Horn Washer	55555.056	
29 2	Mixture Screw Spring	47600.062		62 1	Threaded Cap	61002.022	
30 2	Mixture Screw	64755.013		63 1	Throttle Shaft	10005.244	
31 4	Pump Cover Screw	64700.004					
32 1	Pump Cover	32486.085					
33 1	Pump Diaphragm	47407.207	R	M + R	Service Kit	92.15020.502	

Calibration

Choke	40	Progression Holes	80/90/90/100
Auxiliary Venturi	4.5	Throttle Plate Angle	78°
Main Jet	150	Needle Valve	200
Air Corrector Jet	180	Pump Jet	50
Emulsion Tube	F2	Float Level	12 mm
Idle Jet	55	Mechanical Pump Gap	5.5 mm
Idle Air Bush	115		
Idle Mixture Orifice/Bush	100		
Spark Advance Orifice	100		

Special Application

CARBURETTOR 50 DCO SP - 1/SP - Part No. 19650.001/002



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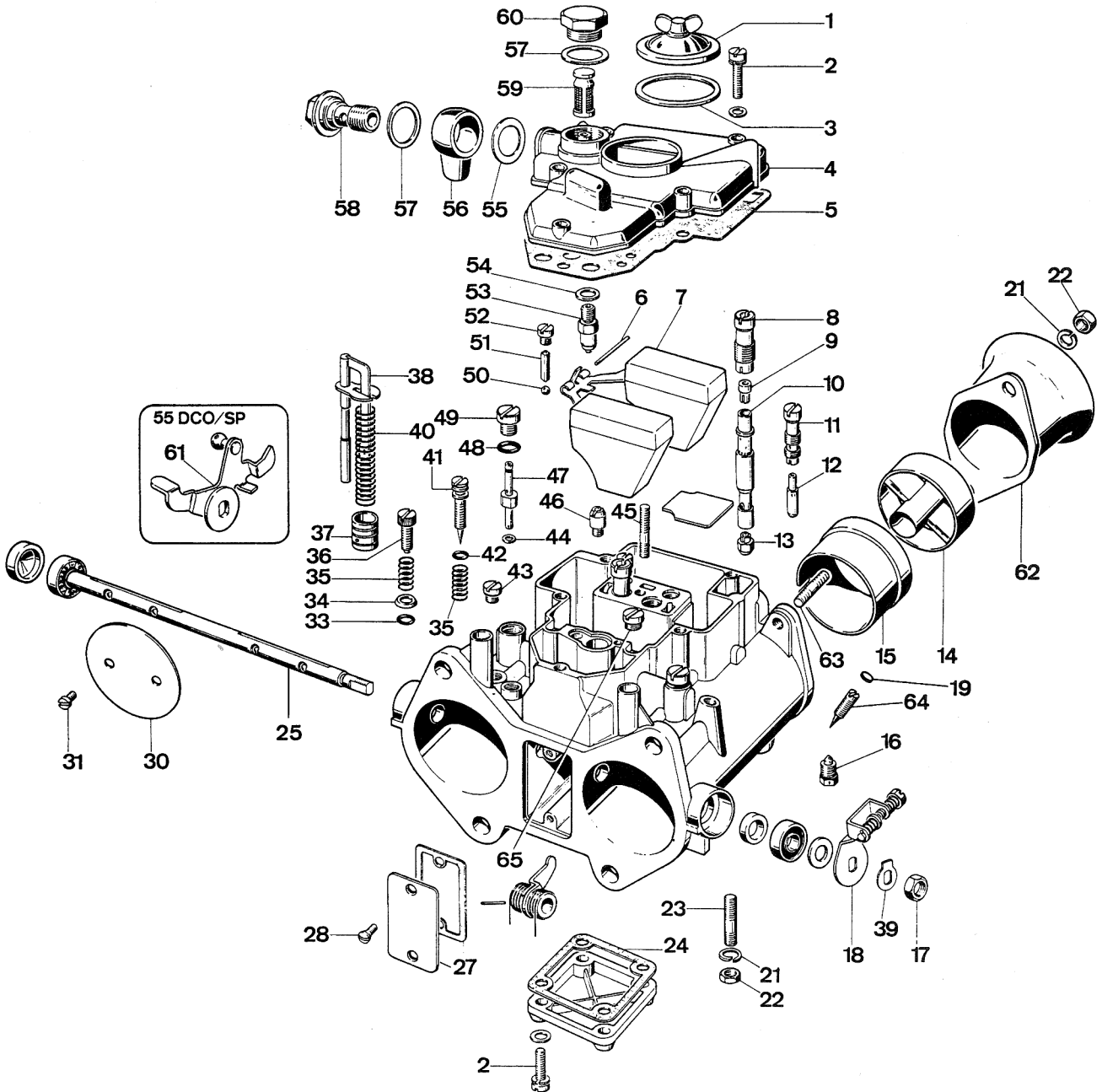
Fig	Qty	Description	Code		Fig	Qty	Description	Code	
1	1	Jet Inspection Cover	32376.003		35	3	Mixture Screw Spring	47600.007	
2	9	Screw	64700.001		36	1	Throttle Stop Screw	64625.015	
3	1	Jet Inspection Cover Gasket	41550.009	M	37	1	Pump Plunger	58602.003	
4	1	Carburettor Cover (50 DCO/SP)	31734.193		38	1	Pump Rod	10410.015	
4	1	Carburettor Cover (50 DCO 1/SP)	31734.194		39	1	Throttle Spindle Lock Washer	55520.004	R
5	1	Carburettor Cover Gasket	41715.011	M	40	1	Pump Rod Spring	47600.068	
6	1	Float Pin	52000.001	R	41	2	Mixture Screw	64750.058	
7	1	Float	41030.034		42	2	Mixture Screw 'O' Ring	41565.015	M
8	2	Emulsion Tube Holder	52580.001		43	2	Vacuum Take-Off Cover	61015.009	
9	2	Air Corrector Jet	77401.160		44	2	Pump Jet Gasket	41535.021	M
10	2	Emulsion Tube	61450.091		45	1	Stud	64955.007	
11	2	Idle Jet Holder	52585.006		46	1	Pump Spill	79701.100	
12	2	Idle Jet	74821.065		47	2	Pump Jet	76801.045	
13	2	Main Jet	73401.180		48	2	Pump Jet Cover 'O' Ring	41565.009	M
14	2	Auxiliary Venturi	68820.500		49	2	Pump Jet Cover	61015.008	
15	2	Venturi (Choke Tube)	72136.460		50	2	Pump Demand Valve Ball	58300.003	
16	4	Screw	64840.003		51	2	Pump Demand Valve Weight	52730.001	
17	1	Throttle Spindle Nut	34715.017		52	2	Pump Demand Valve Cover	61015.006	
18	1	Throttle Lever	45041.270		53	1	Needle Valve	79503.250	M
19	2	Air By-Pass Screw Cover	61030.008		54	1	Needle Valve Gasket	83102.100	M
21	5	Spring Washer	55525.010		55	1	Fuel Union Gasket	41530.031	M
22	5	Support Bracket Fixing Nut	34705.004		56	1	Fuel Union	10354.019	
23	1	Support Bracket Stud	64955.104		57	2	Fuel Union and Filter Cover Gasket	41530.024	M
24	1	Bottom Cover Gasket	41640.066	R	58	1	Fuel Union Bolt	12715.008	
25	1	Throttle Shaft	10020.240		59	1	Fuel Filter	37002.002	
27	1	Inspection Cover Gasket	41640.065	R	60	1	Fuel Filter Cover	61002.010	
28	2	Inspection Cover Fixing Screw	64570.009		61	1	Throttle Lever	45041.269	
30	2	Throttle Plate	64005.135		62	4	Stud	64955.101	
31	4	Throttle Plate Fixing Screw	64520.027		63	2	Air Horn	52845.015	
33	1	Throttle Stop Screw 'O' Ring	41565.002	R	64	2	Air By-Pass Screw	64595.012	
34	1	Throttle Stop Screw 'O' Ring Cap	58000.006		65	2	Progression Hole Inspection Cover	64590.008	
					M + R	Service Kit		92.1462.05.01	

Calibration

Choke	46	Progression Holes	100/100/100/100
Auxiliary Venturi	5.0	Needle Valve	250
Main Jet	180	Pump Jet	45
Air Corrector Jet	160	Pump Spill	100
Emulsion Tube	F7	Float Level	12 mm
Idle Jet	65/F8		
Idle Mixture Orifice/Bush	135		

Special Application

CARBURETTOR 55 DCO SP - 1/SP - Part No. 19700.001/002



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Fig Qty	Description	Code		Fig Qty	Description	Code			
1	1	Jet Inspection Cover	32376.003	35	1	Mixture Screw Spring	47600.007		
2	9	Screw	64700.001	36	1	Throttle Stop Screw	64625.015		
3	1	Jet Inspection Cover Gasket	41550.009	M	37	1	Pump Plunger	58602.003	
4	1	Carburettor Cover		38	1	Pump Rod	10410.015		
		(55 DCO/SP)	31734.195	39	1	Throttle Spindle Lock Washer	55520.004	R	
4	1	Carburettor Cover		40	1	Pump Rod Spring	47600.068		
		(55 DCO 1/SP)	31734.196	41	2	Mixture Screw	64750.058		
5	1	Carburettor Cover Gasket	41715.011	M	42	2	Mixture Screw 'O' Ring	41565.015	
6	1	Float Pin	52000.001	R	43	2	Vacuum Take-Off Cover	61015.009	
7	1	Float	41030.034	44	2	Pump Jet Gasket	41535.021	M	
8	2	Emulsion Tube Holder	52580.001	45	1	Stud	64955.007		
9	2	Air Corrector Jet	77401.180	46	1	Pump Spill	79701.100		
10	2	Emulsion Tube	61450.030	47	2	Pump Jet	76801.045		
11	2	Idle Jet Holder	52585.006	48	2	Pump Jet Cover 'O' Ring	41565.009	M	
12	2	Idle Jet	74821.060	49	2	Pump Jet Cover	61015.008		
13	2	Main Jet	73401.180	50	2	Pump Demand Valve Ball	58300.003		
14	2	Auxiliary Venturi	68820.500	51	2	Pump Demand Valve Weight	52730.001		
15	2	Venturi (Choke Tube)	72135.480	52	2	Pump Demand Valve Cover	61015.006		
16	4	Screw	64840.003	53	1	Needle Valve	79503.250	M	
17	1	Throttle Spindle Nut	34715.017	54	1	Needle Valve Gasket	83102.100	M	
18	1	Throttle Lever	45041.270	55	1	Fuel Union Gasket	41530.031	M	
19	2	Air By-Pass Screw Cover	61030.008	56	1	Fuel Union	10354.019		
21	1	Spring Washer	55525.010	57	2	Fuel Union and Filter			
22	1	Fixing Screw	34705.004			Cover Gasket	41530.024	M	
23	1	Support Bracket Stud	64955.104	58	1	Fuel Union Bolt	12715.008		
24	1	Bottom Cover Gasket	41640.066	R	59	1	Fuel Filter	37022.002	M
25		Throttle Shaft	10020.240	60	1	Fuel Filter Cover	61002.010		
27	1	Inspection Cover Gasket	41640.065	R	61	1	Throttle Lever (55 DCO/SP)	45041.269	
28	2	Inspection Cover Fixing Screw	64570.009	62	2	Air Horn	52845.015		
30	2	Throttle Plate	64005.132	63	4	Stud	64955.101		
31	4	Throttle Plate Fixing Screw	64520.027	64	2	Air By-Pass Screw	64595.012		
33	1	Throttle Stop Screw 'O' Ring	41565.002	R	65	2	Progression Hole Cover	64590.008	
34	1	Throttle Stop Screw 'O' Ring							
		Cap	58000.006						
35	2	Mixture Screw Spring	47600.007						
				M + R	Service Kit		92.1462.05.01		

Calibration

Choke	48	Idle Mixture Orifice/Bush	135
Auxiliary Venturi	5.0	Progression Holes	100/100/100
Main Jet	180	Needle Valve	250
Air Corrector Jet	180	Pump Jet	45
Emulsion Tube	F9	Pump Spill	100
Idle Jet	F8/60	Float Level	12 mm