

ROCHESTER 2GV CARBURETOR

CONTENTS

Subject	Page No.
DESCRIPTION AND OPERATION:	
Description of Rochester 2GV Carburetor	6E-186
DIAGNOSIS:	
Model 2GV	6E-190
MAINTENANCE AND ADJUSTMENTS:	
External Adjustment of Rochester 2GV Carburetor	6E-195
MAJOR REPAIR:	
Rochester 2GV Carburetor Removal and Installation	6E-198
Disassembly, Cleaning and Inspection of Rochester 2GV Carburetor	6E-199
Assembly of Rochester 2GV Carburetor	6E-200
SPECIFICATIONS:	
Rochester 2GV Carburetor Calibrations	6E-203
Rochester 2GV Carburetor Adjustments	6E-203

DESCRIPTION AND OPERATION

GENERAL DESCRIPTION

An exhaust gas recirculation system (E.G.R.) is used on all applications, for 1974, to control oxides of nitrogen. The vacuum supply necessary to operate the recirculation valve is located in the throttle body and connects through a channel to a tube which is located just beneath the spark vacuum tube in the float bowl. A tube has been added at the rear of the throttle body on California models for a vacuum source to operate the new dual diaphragm EGR valve. See Idle System for port location, and operation.

On 1974 model carburetors, the idle mixture screw and limiter are new. A new plastic limit cap permits limited mixture adjustment. Adjustments should be made only at the 24,000 mile point. See TUNE-UP SECTION for proper idle mixture adjustment procedure.

This carburetor uses a calibrated cluster design, which places in a removable assembly, the main well tubes, idle tubes, mixture passages, air bleeds and pump jets. This cluster can easily be removed for cleaning and inspection purposes. The idle and main

well tubes are permanently installed in the cluster body by means of a precision pressed fit and, therefore, cannot be serviced separately. The Rochester Model 2GV carburetor employs the use of a vacuum-operated power system for extra power when needed. Power mixtures are regulated by drop in engine manifold vacuum regardless of the degree of throttle opening.

Thereby, additional fuel can be supplied for power mixtures according to the engine demands.

The carburetor is internally vented through a large tube which leads from beneath the air cleaner inside the air horn bore to the fuel in the float bowl. No external venting is used in order to meet evaporative loss emissions.

In that the fuel tank will not be vented to atmosphere, all fuel vapors are collected in a carbon canister. Purge ports for the canister are provided in the carburetor air cleaner snorkel.

The carburetor part number is stamped on a flat section of the float bowl just beneath the fuel inlet nut. When replacing the float bowl assembly, follow the manufacturer's instructions contained in the service package, so that the part number can be transferred to the new float bowl.

Adjustments have been made as simple as possible. They consist of idle, float level, float drop, pump, choke, choke rod, choke unloader, pump rod, choke coil rod, and vacuum break adjustments.

Incorporated in the Rochester Model 2GV carburetor are six basic systems. They are Float, Low Speed, Main Metering, Power, Accelerating and Choke systems. The following explanation and illustrations show that each system operates to provide efficient carburetion through all operating conditions.

Operation of Float System

The float system controls the level of the fuel in the carburetor fuel bowl. Fuel level is very important because it must be maintained to give proper metering through all operating ranges. As fuel is used from the carburetor bowl the float drops, moving the float needle off its seat and replenishing the fuel in the bowl, thereby keeping the fuel level constant. See Figure 6E-18.

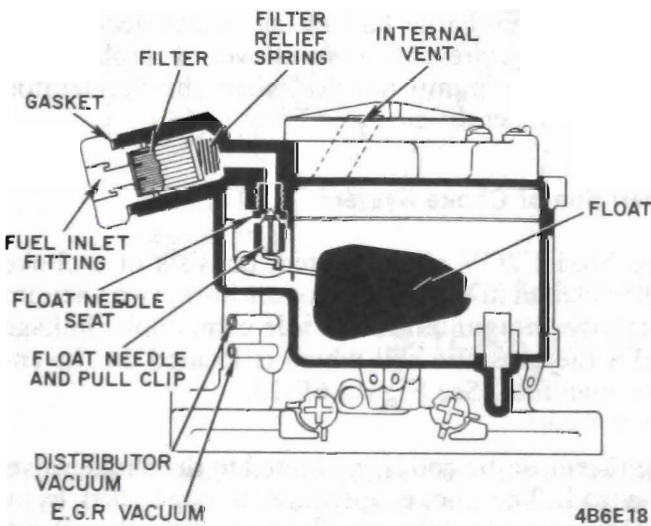


Figure 6E-18 - Float System

Operation of Idle (Low Speed) System

The idle system is used to provide the proper mixture ratios required during idle and low-speed operation of the engine.

The idle system consists of the idle tubes, idle passages, idle air bleeds, idle mixture adjustments, off-idle discharge ports and idle needle discharge holes. See Figure 6E-19.

As the throttle valve is opened further, the off-idle discharge port is exposed to manifold vacuum. This port supplies additional fuel mixture for off-idle engine requirements.

Operation of Main Metering (High-Speed) System

As the throttle valves are opened beyond the off-idle

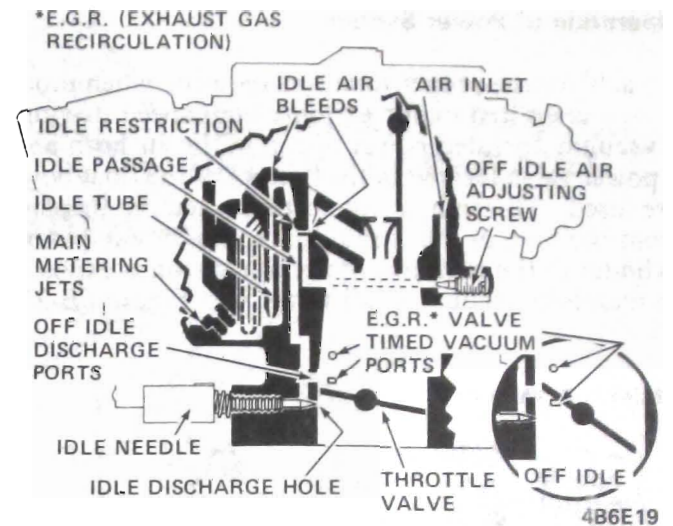


Figure 6E-19 - Idle (Low Speed) System

position and the engine demands more air and fuel, the throttle valves move gradually away from the wall of the carburetor bore, reducing the vacuum so that the discharge of fuel mixture at the idle mixture needle holes and off-idle port gradually diminishes.

Fuel from the float bowl passes through the main metering jets into the main well and rises in the main well tubes. Plastic main well inserts are used in the main wells to provide smooth fuel flow for more efficient metering. This results in improved fuel control in the off-idle transfer and part throttle range. Air entering the main well through the main well air bleeds is mixed with fuel through calibrated holes in the main well tube. The mixture moves up and out of the main discharge nozzle into a mixture (high speed) passage where more air is added. The mixture then travels down to the mixture passage to the small venturi where it is delivered to the air stream and then to the intake manifold. See Figure 6E-20.

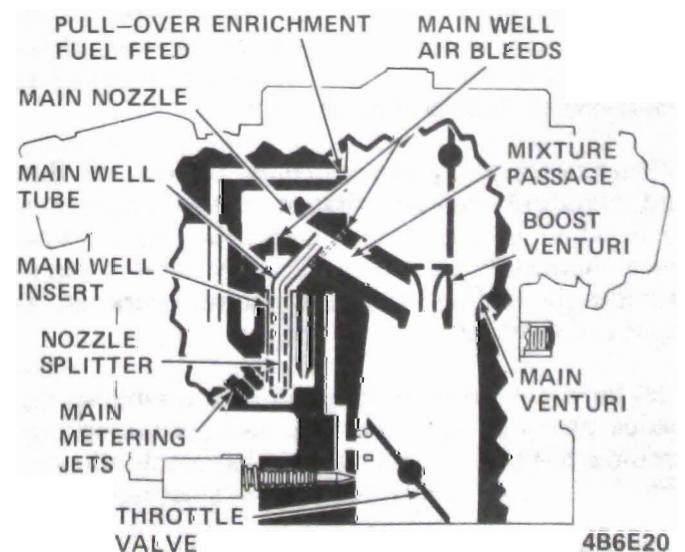


Figure 6E-20 - Main Metering (High-Speed) System

6E-188 1974 BUICK SERVICE MANUAL**Operation of Power System**

To achieve the proper mixtures required when more power is desired or for extreme high speed driving, a vacuum operated power piston in the air horn and a power valve located in the bottom of the float bowl are used. Through a connecting vacuum passage from the base of the carburetor to the power piston cylinder in the air horn, the power piston is exposed to manifold vacuum at all times. See Figure 6E-21.

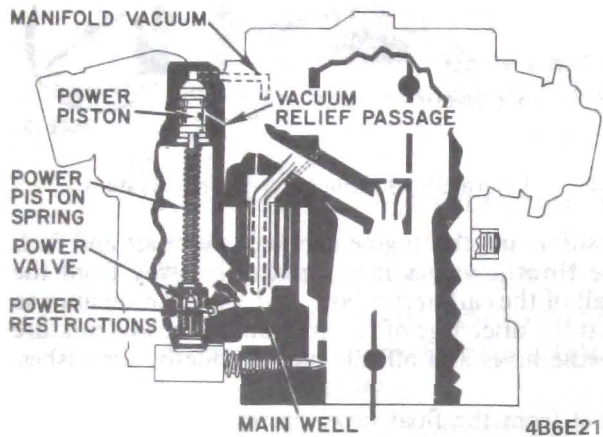


Figure 6E-21 Power System

During idle and part throttle operation, the relatively high vacuum holds the power piston up against spring tension and the power valve remains closed.

Increase in engine load lowers the manifold vacuum. When it has dropped sufficiently, the power piston spring overcomes the upward vacuum pull and the power piston moves downward, opening the power valve to allow additional fuel to flow through calibrated restrictions into the main well.

Operation of Accelerating System

When the throttle valve is opened rapidly, air flow and manifold vacuum change almost instantaneously, while the heavier fuel tends to lag behind causing a momentary leanness. The accelerator pump provides the fuel necessary for smooth operation on rapid acceleration.

Fuel for acceleration is supplied by a double-spring loaded pump plunger. The top and bottom springs combine to move the plunger so that a smooth, sustained charge of fuel is delivered for acceleration.

Fuel is drawn into the pump well through the inlet ball check on the intake stroke of the pump plunger (upward stroke). See Figure 6E-22.

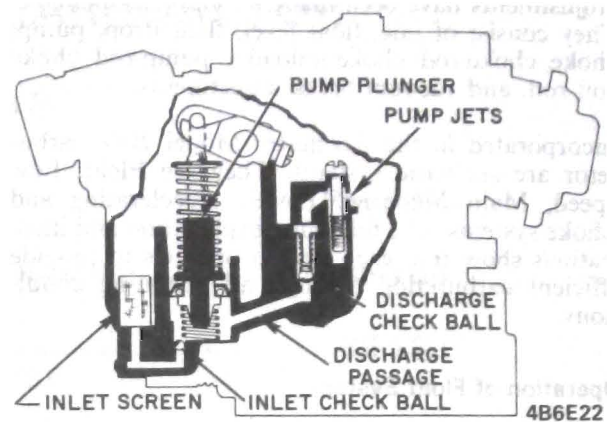


Figure 6E-22 - Accelerating Pump System

Downward motion of the pump plunger seats the inlet ball check and forces the fuel through the discharge passage where it unseats the pump discharge ball and then passes on through to the pump jets where it sprays into the venturi.

The pump discharge ball check in the accelerator pump passage prevents any pullover or discharge of fuel from the pump nozzles when the accelerator pump is inoperative.

Operation of Choke System

The Model 2GV choke system consists of a choke valve located in the carburetor air horn, two vacuum break diaphragm units, fast idle cam, choke linkage and a thermostatic coil which is located on the engine manifold. See Figure 6E-23.

The thermostatic coil is connected to the choke valve by a rod. The choke operation is controlled by a combination of intake manifold vacuum, the off-set choke valve, and temperature.

The thermostatic coil located on the engine manifold is calibrated to hold the choke valve closed when the engine is cold. While starting the engine, air velocity against the off-set choke valve causes the valve to open slightly, against the torque of the thermostatic coil. When the engine starts, manifold vacuum increases. Two vacuum break diaphragm units connected by linkage to the choke valve shaft, open the choke valve a pre-determined amount against choke coil tension, so that the fuel mixture will be lean enough and the engine will run without stalling.

Two vacuum break diaphragm units are used for refined fuel mixture blending during this period. The primary or main vacuum break diaphragm opens the choke valve to a point where the engine will run without loading or stalling. As the engine manifold is wetted and friction in the engine decreases, the

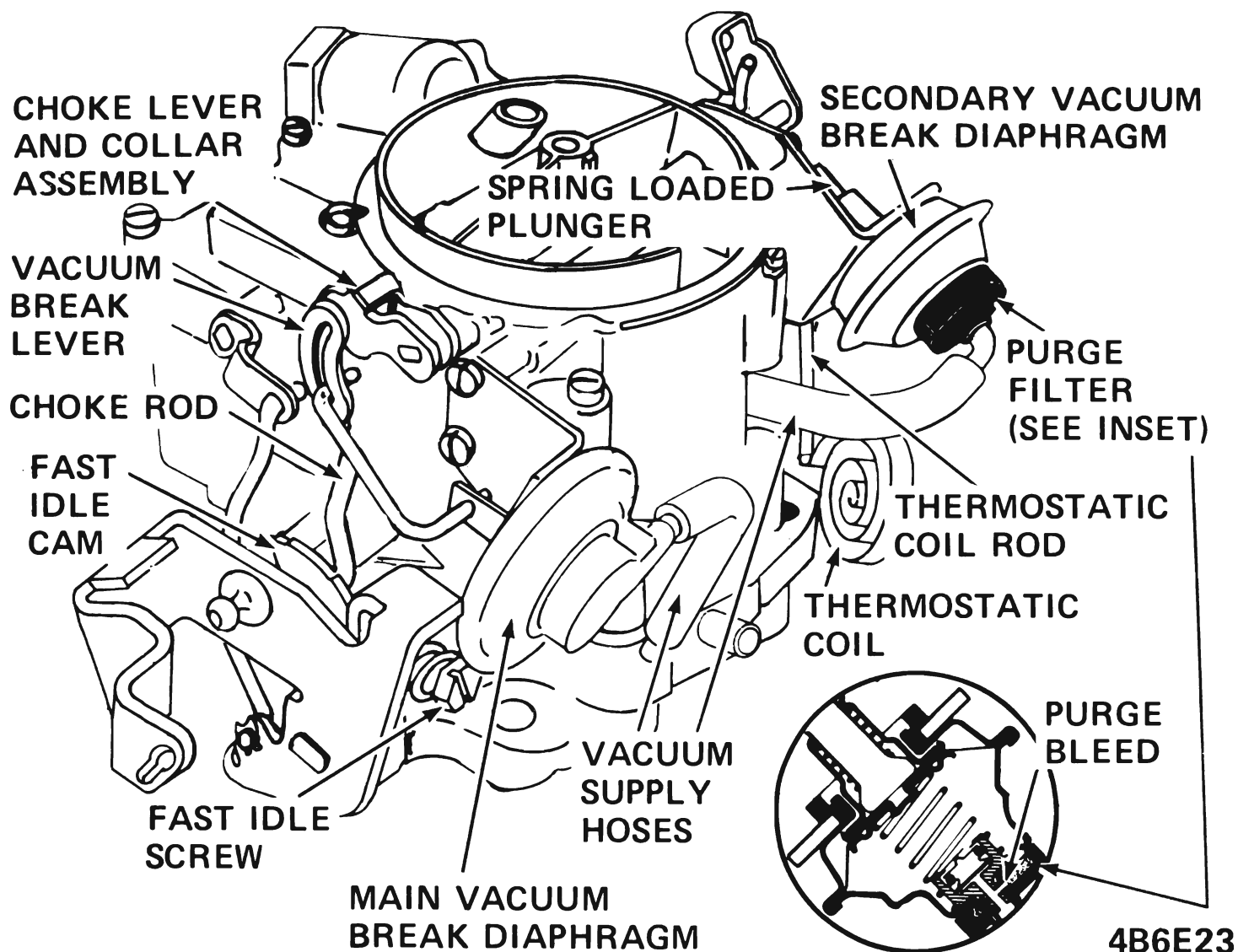


Figure 6E-23 - Choke System

secondary or auxiliary vacuum break unit which has a delayed action, gradually opens the choke valve a little further to prevent loading and reduce exhaust emissions. The primary (main) vacuum break unit located on the throttle lever side operates the same as on previous units. The secondary or auxiliary vacuum break unit located at the opposite end of the choke shaft has a delayed action created by an internal check valve which has a very small bleed orifice. This delays the movement of the vacuum diaphragm a few seconds until the engine will run at slightly leaner mixtures.

The auxiliary vacuum break unit has a spring loaded plunger. The purpose of the spring loaded plunger is to off-set choke thermostatic coil tension to provide leaner mixtures during warm-up for reduced exhaust emissions. A clean air purge feature is added to the auxiliary vacuum break unit. The purpose of the clean air purge is to bleed air into the auxiliary vacuum break circuit and purge the system of any fuel vapors or dirt contamination which might be pulled into the bleed check valve located inside the

diaphragm unit. The purge system consists of a small bleed hole located in the vacuum break diaphragm tube just beneath a filter element covered by a rubber boot. During engine operation vacuum acting upon the diaphragm unit pulls a small amount of filtered air through this bleed hole to purge the system.

As the engine continues to warm up, the choke coil continues to relax its tension until the choke valve is fully opened and the engine can now run at normal fuel mixtures.

To provide correct engine speeds during warm up, a fast idle cam is used to run the engine at slightly higher speeds than idle to prevent stalling. This is accomplished by graduated steps on the fast idle cam. During engine starting, the fast idle speed screw is on the highest step of the cam which holds the throttle valve open further than at normal idle. As the engine warms up and the choke valve begins to move open, the fast idle speed screw drops to lower steps on the cam and gradually lowers engine speed until the engine is thoroughly warm, at which point

6E-190 1974 BUICK SERVICE MANUAL

the engine will run at normal idle speed. The fast idle cam follows rotation of the choke valve. When the choke valve is fully open, the fast idle cam drops so that the fast idle screw no longer comes in contact with the fast idle cam. At this point, the engine idle is controlled by the idle stop solenoid.

A mechanical choke unloader is provided to allow

the driver to open the choke valve mechanically during the cold starting period, should the engine become flooded. When the accelerator pedal is depressed to the floor, a tang on the throttle lever pushes on the tail of the fast idle cam and forces the choke valve slightly open to allow extra air into the engine to lean the fuel mixtures so the engine will start.

DIAGNOSIS**MODEL 2GV**

Condition	Possible Cause	Correction
Engine Cranks (Turns Over) Will Not Start	1. Improper starting procedure used.	1. Check with the customer to determine if proper starting procedure is used, as outlined in the Owner's Manual.
	2. Choke valve not closing.	1. Adjust the choke thermostatic coil. Check the choke valve and/or linkage for binds. Realign the choke valve or linkage as necessary. Replace parts if malfunctioning. If caused by dirt and gum, clean with automatic choke cleaner.
	3. No fuel in carburetor.	1. Remove fuel line at carburetor. Connect hose to fuel line and run into metal container. Remove the high tension wire from the coil to distributor and ground. Crank over engine if there is no fuel discharge from the fuel line, test fuel pump as outlined in the Fuel Section. If fuel supply is okay, check the following: a) Inspect fuel inlet filter. If plugged, replace. b) If fuel filter is okay, remove air horn and check for a bind in the float mechanism or a sticking float needle. If okay, adjust float as specified.
	4. Engine flooded. To check for flooding remove the air cleaner, with the engine off, and look into the carburetor bores. Fuel will be dripping off nozzles and/or the carburetor bores will be very wet	1. Check to determine if customer is using proper carburetor unloading procedure. Depress the accelerator to the floor and check the carburetor to determine if the choke valve is opening. If not, adjust the throttle linkage and unloader, as specified. If choke unloader is operating properly, check for carburetor flooding.

Condition	Possible Cause	Correction
Engine Starts - Will Not Keep Running	1. Engine does not have enough fast idle speed when cold.	1. Check and reset the idle stop screw and fast idle cam.
	2. Choke vacuum break units, are not adjusted to specification or are malfunctioning.	1. Adjust both vacuum break assemblies to specification. If adjusted okay, check the vacuum break units for proper operation as follows: Connect a piece of hose to the nipple on the vacuum break unit and apply suction by mouth or use Tool J-23417 to apply vacuum. Plunger should move inward and hold vacuum. If not, replace the unit. Always check the fast idle cam first before adjusting vacuum break units.
	3. Choke valve sticking or binding.	1. Clean and align linkage, or replace if necessary. Readjust if part replacement is necessary.

6E-192 1974 BUICK SERVICE MANUAL

Condition	Possible Cause	Correction
Engine Idles Rough and/or Stalls	4. Insufficient fuel in carburetor.	1. Check fuel pump pressure and volume. Check for partially-plugged fuel inlet filter. Replace if dirty. Check the float mechanism for sufficient float drop. Adjust as specified.
	1. Idle speed incorrectly set.	1. Reset idle speed per instructions on label in engine compartment.
	2. Air leaks into carburetor bores beneath throttle valves, manifold leaks, or vacuum hoses disconnected or installed improperly.	1. Check all vacuum hoses leading into the manifold or carburetor base for leaks or being disconnected. Install or replace as necessary. Torque carburetor to manifold bolts to 15 lb. ft., using a pressure oil can, spray light oil or kerosene around manifold legs and carburetor base. If engine RPM changes, tighten or replace the carburetor or manifold gaskets as necessary.
	3. Carburetor flooding. Check by using procedure outlined under "Engine Flooded".	1. Remove air horn and check float. Check float needle and seat for proper seal. If a needle and seat tester is not available, mouth suction can be applied to the needle seat with needle installed. If the needle is inoperative, replace needle and seat with a factory-matched set. Check float for being loaded with fuel bent float hanger or binds in the float arm. A solid float can be checked for fuel absorption by lightly squeezing between fingers. If wetness appears on surface or float feels heavy (check the float assembly). Check metal float for leakage by shaking. If excessive dirt is found in the carburetor, clean the fuel system and carburetor. Replace fuel filters as necessary.
Engine Hesitates on Acceleration	1. Accelerator pump not adjusted to specification.	1. Adjust accelerator pump.

Condition	Possible Cause	Correction
<p>Engine hesitation can be caused by many different engine problems. Before checking the carburetor, make sure the engine has been thoroughly tuned. This should include a complete fuel pump and electrical check.</p>	<p>2. Malfunctioning accelerator pump system. A quick check of the pump system can be made as follows: With the engine off, look into the carburetor bores and observe pump shooters, while briskly opening throttle valves. A full stream of fuel should emit from each pump jet and strike the boost venturi area.</p>	<p>1. Remove air horn and check pump cup. If cracked, scored or distorted, replace the pump plunger. Check the pump inlet and discharge balls for proper seating and location. The pump discharge ball is 3/16" steel and is located beneath the venturi cluster assembly. Check pump discharge ball for proper seating by filling cavity above ball with fuel to level of casting. No "leak down" should occur with discharge ball, spring and retainer in place. Restake or replace check ball if leaking. The pump inlet ball is the small aluminum ball located in the bottom of the pump well.</p>
	<p>3. Dirt in pump passages.</p>	<p>1. Clean and blow out with compressed air.</p>
	<p>4. Float level too low.</p>	<p>1. Check and reset float level to specification.</p>
<p>Engine hesitation at low speeds on acceleration.</p>	<p>1. Misadjusted front wheel Max-Trac sensor.</p>	<p>1. Set Max-Trac switch to off position. If hesitation disappears check front wheel sensor for proper gap. Proper gap is: a. Felt pad still in place: position sensor so felt pad just touches rotor. b. Felt pad not in place: with feeler gauge position sensor .050" from rotor.</p>
<p>No Power on Heavy Acceleration or at High Speed.</p>	<p>1. Carburetor throttle valves not going wide open. Check by pushing accelerator pedal to floor.</p>	<p>1. Adjust throttle linkage to obtain wide open throttle in carburetor.</p>
	<p>2. Dirty or plugged fuel inlet filter.</p>	<p>1. Replace with a new filter element.</p>
	<p>3. Power system not opening.</p>	<p>1. Remove the carburetor air horn and check the power valve in the bottom of the float bowl for the following: Look for dirty, sticking or loose valve. Clean, tighten and/or replace as necessary. Check the power piston spring and power piston in the air horn cavity. Check for bent or sticking power piston or distorted spring. Clean or replace as necessary.</p>

6E-194 1974 BUICK SERVICE MANUAL

Condition	Possible Cause	Correction
	4. Float level too low.	1. Check and reset float level to specification.
	5. Float not dropping far enough into float bowl.	1. Check and adjust float drop as specified.
	6. Main metering jets or venturi cluster dirty, plugged or incorrect part.	1. If the main metering jets are plugged or dirty and excessive dirt is in the fuel bowl, the carburetor should be completely disassembled and cleaned. If the jets are incorrect size, consult the parts list for proper usage. The last two digits stamped on the jet face are the same as the last two digits of the part number.
Engine Start Hard When Hot. This can be caused by many items other than carburetor, so a complete ignition and fuel pump check should be made before proceeding with carburetor items.	1. Choke valve not opening completely when engine is warm.	1. Check for binding choke valve and/or linkage. Clean and/or replace as necessary. Check and adjust choke thermostatic coil.
	2. Engine flooded.	1. See procedure under "Engine Cranks, Will Not Start - Engine Flooded".
	3. No fuel in carburetor.	1. Check fuel pump. Run pressure and volume test. Check fuel by-pass line for restriction. Pinch off return-line to prime fuel pump. Check float needle for sticking in seat or binding float.
	4. Leaking float bowl.	1. Fill bowl with fuel and look for leaks.
Poor Fuel Economy	1. Customer driving habits.	1. Run mileage test with customer driving, if possible. Make sure car has 2000-3000 miles for the "break-in" period.
	2. Engine needs complete tune-up.	1. Check engine compression, examine spark plugs (if dirty or improperly gapped, clean and regap or replace), ignition point dwell, check condition, readjust ignition points, if necessary, and check and reset ignition timing. Clean or replace air cleaner element if dirty. Check for restricted exhaust system and intake manifold for leakage. Make sure all vacuum hoses are connected.

Condition	Possible Cause	Correction
	3. Choke valve not fully opening.	1. Clean choke and free up linkage. Check choke coil for proper adjustment. Reset to specification.
	4. Fuel Leaks.	1. Check fuel tank, fuel lines and fuel pump for any fuel leakage.
	5. High fuel level in carburetor.	1. Check for dirt in the needle and seat. Test, using suction by mouth or needle seat tester. Check for loaded or leaking float. Reset carburetor float to specification. If excessive dirt is present in the carburetor bowl, the carburetor should be cleaned.
	6. Power system in carburetor not functioning properly - power piston sticking or power valve open.	1. Free up or replace, as necessary.
	7. Incorrect main metering jets installed.	1. Consult parts list for proper jet. The last two digits of the part number appear on the jet face.
	8. Fuel being pulled from accelerator system into venturi through pump jets.	1. Run engine at RPM where nozzles are feeding fuel. Observe pump jets. If fuel is feeding from jets, check the pump discharge ball, spring and retainer. Check pump discharge ball for proper seating by filling cavity above ball with fuel to level of casting. No "leak down" should occur with discharge ball, spring and retainer in place. Restake or replace leaking check ball.

MAINTENANCE AND ADJUSTMENTS

EXTERNAL ADJUSTMENT OF ROCHESTER 2GV CARBURETOR

All adjustments on the carburetor, except for float adjustments, are made externally.

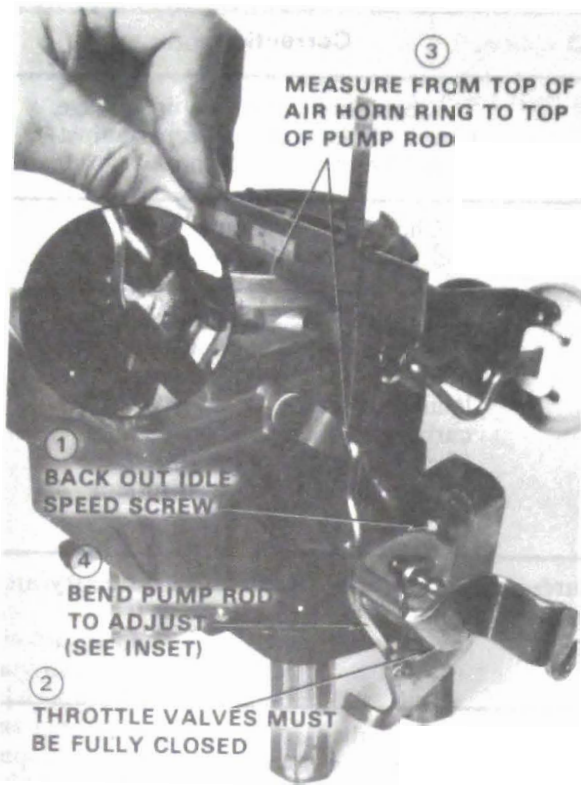
Pump Rod Adjustment

Back out the fast idle stop screw and completely close throttle valves in bore. Place pump gauge across top of carburetor air horn ring, as shown, with leg of gauge pointing downwards towards top of pump rod. Lower edge of gauge leg should just touch the top of the pump rod, with the gauge set at the specified dimension. Bend the pump rod as required

to obtain the specified setting using Tool J-4552. See Figure 6E-24.

Fast Idle Cam Adjustment

Place the fast idle speed adjusting screw in its normal position, which is approximately 1 to 1-1/2 turns in after contact with the lowest step of the fast idle cam. After initial fast idle screw adjustment, place the screw on the second step of the fast idle cam against the shoulder of the high step, as shown. With the choke valve held towards the closed position, measure the distance between the upper edge of the choke valve and the inside air horn wall with the specified plug gauge. Bend the tang on the choke lever, as shown, to adjust. See Figure 6E-25.



486E24

Figure 6E-24 - Pump Rod Adjustment

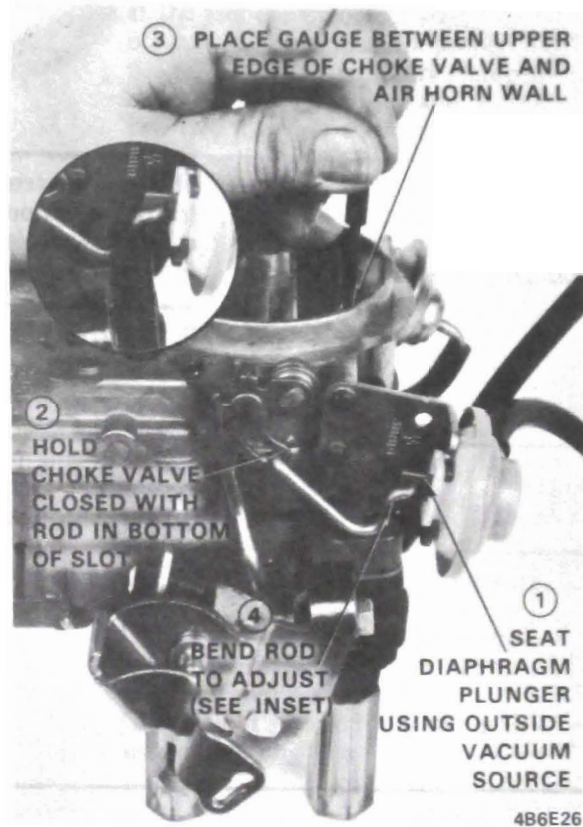


486E25

Figure 6E-25 - Fast Idle Cam Adjustment

Primary Vacuum Break Adjustment

Seat primary vacuum break diaphragm plunger with Special Tool J-23417, Carburetor Vacuum Break Actuator. Rotate choke valve towards the closed position so that the vacuum break rod is at the bottom of the slot in the choke shaft lever, place the proper gauge between the upper edge of the choke valve and inside wall of the air horn bore. To adjust, bend the vacuum break rod so that the gauge will just fit between the edge of valve and bore. See Figure 6E-26.



486E26

Figure 6E-26 - Primary Vacuum Break Adjustment

Secondary Vacuum Break Adjustment

In order to make sure that the secondary vacuum break diaphragm will stay in the seated position, when applying vacuum, the small bleed hole in the diaphragm tube beneath the filter element must be plugged. Remove the vacuum break diaphragm hose and the rubber covered filter element from the vacuum break tube. Use a small piece of tape and plug the small bleed hole. After adjustment, remove the tape making sure that the small bleed hole is open and install the rubber covered filter element over the vacuum break tube. Fully seat the secondary vacuum break diaphragm plunger using J- 23417, Carburetor Vacuum Break Actuator. It will take approximately

eight seconds for diaphragm to retract. With the secondary vacuum break diaphragm in the fully seated position, push the choke valve toward the closed position until the spring loaded diaphragm plunger is fully extended. With the choke valve held in this position, measure the distance between the upper edge of choke valve and inside air horn wall. Dimension should be as specified, if not, bend the vacuum break link at the point shown to adjust. See Figure 6E-27. Care should be used when compressing the diaphragm plunger spring so that the force used in closing the choke valve does not pull the vacuum diaphragm off its seat.

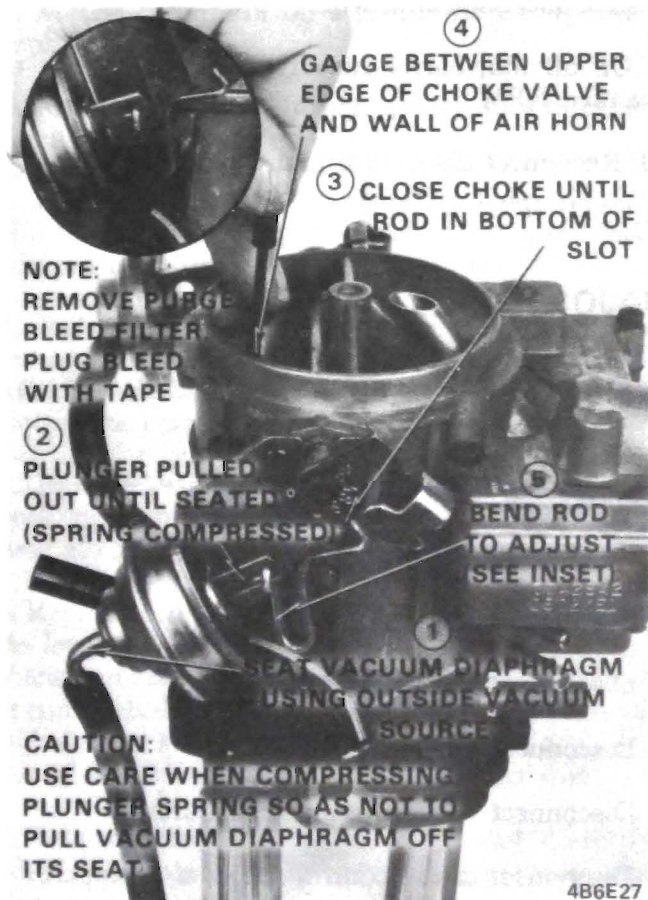


Figure 6E-27 - Secondary Vacuum Break Adjustment

Choke Unloader Adjustment

With the throttle valves held wide open, choke valve should be opened enough to admit end of gauge between upper edge of choke valve and inner air horn wall. Bend unloader tang on the throttle lever to obtain the correct measurement. See Figure 6E-11. It is advisable to check the choke unloader by depressing the accelerator pedal to insure full throttle valve opening of the carburetor.

Choke Coil Rod Adjustment

To adjust, remove clip and disconnect the upper end of choke coil rod from the choke lever. With the choke valve completely closed, pull upward on the

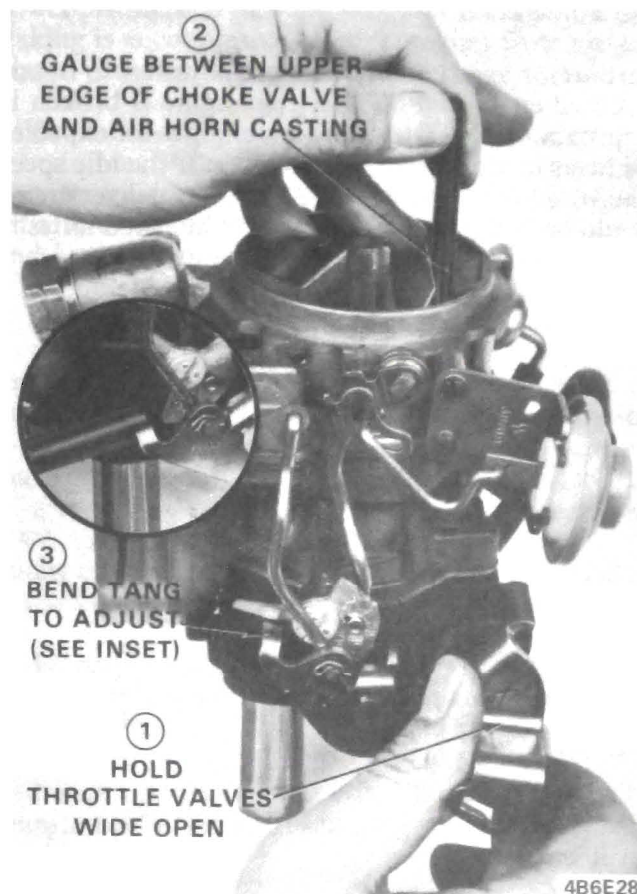


Figure 6E-28 - Choke Unloader Adjustment

choke coil rod to the limit of its travel. The end of the rod should fit into the gauge notch in lever. To adjust, bend the rod as shown. See Figure 6E-29. After adjustment is complete, install the rod end in the lever hole and install retaining clip.

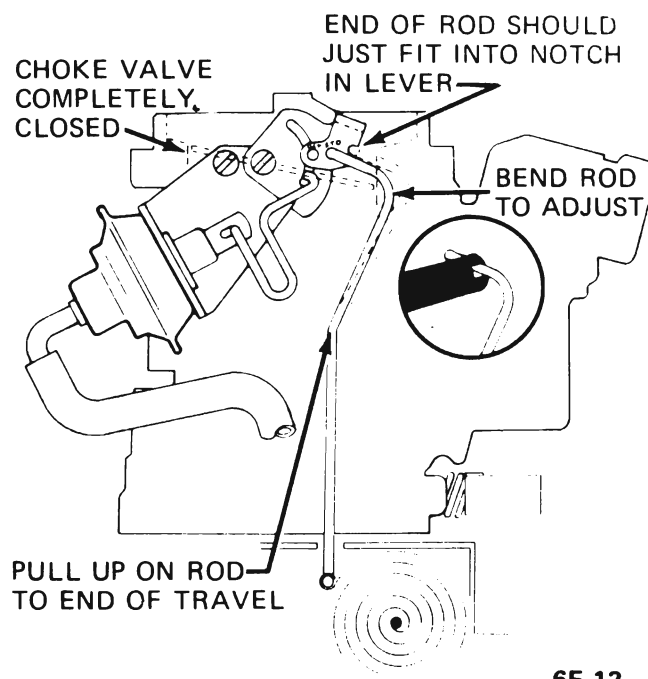


Figure 6E-29 - Choke Coil Rod Adjustment

6E-198 1974 BUICK SERVICE MANUAL**Idle Adjustment**

Carburetor speed screws are pre-adjusted to obtain specified engine RPM after the engine is broken in (approximately 500 miles). New engines are expected to idle as much as 100 RPM slower. If the idle speed is adjusted to specifications at new car delivery, care should be taken to reset after a few hundred miles to prevent dieseling and improve idle quality.

1. Connect an accurate tachometer to engine.
2. Start engine and run it at fast idle until upper radiator inlet is hot and choke valve is wide open.
3. Disconnect and plug distributor vacuum line, start engine, and set ignition timing.
4. Set transmission in "Drive" for automatic transmissions and "Neutral" for manual transmission.
5. Open throttle sufficiently to allow solenoid to extend and contact the throttle lever pad in the idle position.
6. Adjust solenoid set screw to obtain specified RPM. Reposition solenoid bracket if additional movement is required.
7. Disconnect solenoid wire to disengage solenoid.
8. Adjust carburetor idle screw to obtain specified RPM.
9. Reconnect solenoid wire.
10. Adjust idle mixture needles. As Specified in the TUNE-UP Section.

Idle Control Solenoid Adjustment

All 1974 Buick engines are equipped with an idle control solenoid. The solenoid is energized with the ignition switch in the "On" or "Run" positions and deenergized in the "Off" position.

Adjust solenoid with transmission in "Drive".

All adjustments are to be made with engine at normal operating temperature, choke open, air cleaner on and air conditioning off and plug disconnected vacuum fittings.

1. Disconnect hose from air cleaner to vapor canister.
2. Disconnect distributor vacuum hose. Plug hose to carburetor.
3. Set dwell and timing.

4. Open throttle sufficiently to allow solenoid to extend and contact the throttle lever pad in idle position.

5. Adjust solenoid set screw to obtain specified RPM. Reposition the solenoid mounting bracket if additional movement is required.
6. Disconnect solenoid wire to disengage solenoid.
7. Adjust carburetor idle screw to obtain specified RPM.
8. Reconnect solenoid wire.
9. On all four-barrel carburetors, set fast idle to specified RPM.
10. Reconnect distributor and canister hoses.

MAJOR REPAIR**ROCHESTER 2GV CARBURETOR REMOVAL AND INSTALLATION****Removal**

1. Remove air cleaner.
2. Disconnect fuel line at carburetor.
3. Disconnect choke coil rod.
4. Disconnect throttle cable.
5. Disconnect vacuum lines to carburetor.
6. Disconnect cruise control chain, if equipped.
7. Disconnect throttle springs.
8. Remove 4 carburetor-to-manifold bolts.
9. Remove vacuum hose fitting at back of carburetor.

Installation

1. Install manifold vacuum fitting at back of carburetor.
2. Install carburetor gasket and carburetor.
3. Connect throttle springs.
4. Connect cruise control chain, if equipped.
5. Connect vacuum lines to carburetor.

6. Connect throttle cable.
7. Connect choke coil rod.
8. Connect gas line to carburetor.
9. Replace air cleaner.

DISASSEMBLY, CLEANING AND INSPECTION OF ROCHESTER 2-BARREL CARBURETOR

Choke Disassembly and Removal of Air Horn

1. Mount carburetor on a proper mounting fixture such as J-5923.
2. Remove fuel inlet fitting, gasket, fuel filter, and filter spring.
3. Remove pump rod by removing lower retaining clip and rotating pump rod until lug on upper end of rod passes through upper pump lever.
4. Remove fast idle cam attaching screw. Then remove fast idle cam and rod assembly by rotating until lug on upper end of choke rod passes through slot in the upper choke lever and collar assembly.
5. Remove vacuum break diaphragm hoses from both vacuum breaks units and from each vacuum tube at throttle body.
6. Remove primary vacuum break diaphragm (throttle lever side) by removing two attaching screws. Vacuum break rod can now be removed from lever at end of choke shaft by rotating the rod until the end slides out of slot in lever and lug on other end of rod out of slot in end of diaphragm plunger shaft.
7. Remove secondary vacuum break unit (choke coil side) by first removing lever from end of choke shaft. Then remove lever from the diaphragm plunger rod and rod from diaphragm plunger shaft. Then remove two bracket attaching screws and remove diaphragm and bracket assembly from air horn.
8. Remove eight air horn attaching screws and carefully remove air horn assembly from fuel bowl by lifting gently upward.

Disassembly of Air Horn

1. Place air horn assembly inverted on bench. Remove float hinge pin and lift float assembly from cover. Remove float needle from the float arm. Remove float needle seat and fibre gasket.
2. Remove air horn gasket.
3. Remove power piston by depressing shaft and allowing spring to snap repeatedly, thus forcing the

power piston retaining washer from casting. If heavy staking is encountered, remove staking from around power piston retaining washer.

4. The following should be observed when removing the air horn. Remove the pump plunger assembly and inner pump lever from pump shaft by loosening set screw on inner lever. Then rotate pump assembly and remove from inner pump arm.

CAUTION: : *Do not bend arm on inner pump lever to remove pump assembly. If inner pump lever is bent it will cause binding of the pump assembly which could hold the throttle open.*

A plastic washer is used between the outer pump lever and air horn casting on the pump shaft. This should be removed from the pump shaft and not immersed in carburetor cleaner.

5. Remove two choke valve retaining screws, then remove choke valve from choke shaft. Remove choke shaft from air horn, then choke lever and collar assembly can be removed from choke shaft. Note position of the choke lever in relation to the choke trip lever on the end of the choke shaft for ease in reassembly.

Disassembly of Float Bowl

1. Remove pump plunger return spring from pump well. Remove small aluminum check ball from the bottom of pump well by inverting bowl and shaking into hand. Remove pump inlet screen from bottom of fuel bowl.
2. Remove main metering jets.
3. Remove power valve and fibre gasket.
4. Remove three venturi cluster attaching screws and remove cluster and gasket. Center cluster screw has smooth shank and fibre gasket for sealing the accelerator pump fuel by-pass.
5. Remove plastic main well inserts.
6. Using a pair of long nosed pliers, remove pump discharge ball spring "T" shaped retainer. Then remove pump discharge spring and steel discharge ball.
7. Invert carburetor and remove three throttle body to bowl attaching screws. Remove throttle body and throttle body to bowl gasket.

Disassembly of Throttle Body

No further disassembly of the throttle body is needed. The throttle valves should never be removed

6E-200 1974 BUICK SERVICE MANUAL

as the idle holes are drilled in direct relation to the location of the throttle valves and shaft. Removal of the throttle valves will upset this location. The throttle body assembly is only serviced as a complete unit with throttle valves intact.

The plastic idle limiter caps should not be removed, except if it is necessary to clean out the idle channels or the idle mixture needles are damaged. If necessary to remove the idle mixture needles, break the plastic caps, then remove the mixture needles from the throttle body.

After installation of the mixture needles, it will be necessary to readjust the idle on the car and install new red limiter caps provided in the repair kit.

Cleaning and Inspection

Dirt gum, water or carbon contamination in or on , the exterior moving parts of a carburetor are often responsible for unsatisfactory performance. For this reason, efficient carburetion depends upon careful cleaning and inspection while servicing.

1. Thoroughly clean carburetor castings and metal parts in carburetor cleaning solvent. Pump plunger or any fibre or rubber parts should never be immersed in carburetor cleaner. Wash pump plunger in clean solvent.

2. Blow out all passages in the castings with compressed air and blow off all parts until they are dry. Make sure all jets and passages are clean. Do not use wires for cleaning fuel passages or air bleeds.

3. Check all parts for wear. If wear is noted, defective parts must be replaced. Note especially the following:

(a) Check float needle and seat for wear. If wear is noted, the assembly must be replaced.

(b) Check float hinge pin for wear and float for dents or distortion.

(c) Check throttle and choke shaft bores for wear and out of round.

(d) Inspect idle mixture adjusting needles for burrs or grooves. Such a condition requires replacement.

(e) Inspect pump plunger cup; replace if damaged worn, or hard.

(f) Inspect pump well in bowl for wear or scoring.

4. Check filter for dirt or lint. If dirty, replace.

5. If for any reason, parts have become loose or damaged in the cluster casting, the cluster assembly must be replaced.

6. It is recommended that new gaskets be used whenever the carburetor is disassembled or overhauled.

ASSEMBLY OF ROCHESTER 2-BARREL CARBURETOR**Assembly of Throttle Body**

1. If the idle mixture needles and springs had to be removed, turn the mixture needles in until finger tight. Back out screws two turns as a preliminary idle adjustment.

Do not force the idle mixture needles against their seats or damage may result.

2. Invert the float bowl assembly and place the new throttle body gasket on bowl. Install throttle body on bowl, using three screws and lockwashers. Tighten securely.

Assembly of Float Bowl

1. Drop steel pump discharge check ball into discharge hole. Install pump discharge spring and "T" shaped retainer, staking retainer in place. Top of retainer must be flush with flat of bowl casting.

2. Install two main well inserts. Install venturi cluster with gasket. Install venturi cluster screws and tighten evenly and securely. Make sure center screw is fitted with fibre gasket and special smooth shank screw is used.

3. Install two main metering jets, power valve gasket and power valve.

4. Install small aluminum inlet check ball in pump inlet in the bottom of pump well; insert pump return spring and center in well by pressing downward with finger.

5. Install pump inlet screen in the bottom of float bowl.

Assembly of Air Horn

1. Install choke lever and collar onto choke shaft. Tang on choke lever faces away from air horn and is on top of vacuum break lever.

2. Install choke shaft and lever assembly into air horn. Choke rod hole in the choke lever faces fuel inlet side of carburetor.

3. Install choke valve in choke shaft so that letters "RP" will face upward in finished carburetor. Install two new choke valve attaching screws but do not tighten securely until choke valve is centered. Center choke valve on choke shaft by holding choke valve

tightly closed; then slide choke shaft in to obtain approximately .020 clearance between choke vacuum break lever and choke lever and collar assembly. Tighten choke valve screws securely and stake lightly in place. Choke valve will be perfectly free in all positions when installed correctly.

4. Install pump plunger assembly into hole on the inner pump lever with end of pump plunger shaft pointing towards the air horn bore. The retainer tang on the inner pump lever will be towards the outside of the carburetor when installing on upper pump shaft and lever.

5. Install plastic washer over pump shaft and slide against outer lever. Install outer pump lever and shaft assembly into air horn with lever pointing towards choke shaft. Holding the pump plunger assembly and inner pump lever into the air horn cavity, slide the pump shaft into the inner pump lever until seated and tighten set screw securely.

6. Install float needle seat and gasket in air horn. Tighten needle seat securely, using a wide bladed screwdriver.

7. Install power piston into vacuum cavity. Lightly stake piston retainer washer in place. Piston should travel freely in cavity.

8. Install air horn gasket on air horn, fitting gasket over guide pin.

9. Attach float needle to float. Carefully position float and insert float hinge pin. Drop tang on rear of float arm should point downward toward air horn.

A fuel inlet baffle is used which surrounds the float needle seat. Make sure that the hinge pin slides through the holes provided in the baffle and also that the baffle is not distorted so that the float arm does not bind in any position.

10. Install fuel inlet fitting, gasket, fuel filter, and relief spring.

11. *Float level adjustment*

With air horn assembly inverted, measure distance from air horn gasket to lip at toe of float, as shown. Bend float arm as required to obtain 15/32 inch measurement. See Figure 6E-30.

12. *Float drop adjustment*

With air horn assembly held upright, measure distance from gasket to notch at toe of float as shown. Bend float tang as required to obtain a 1-9/32 inch measurement. See Figure 6E-31.

13. Carefully place air horn assembly on float bowl, making certain that the pump plunger is properly

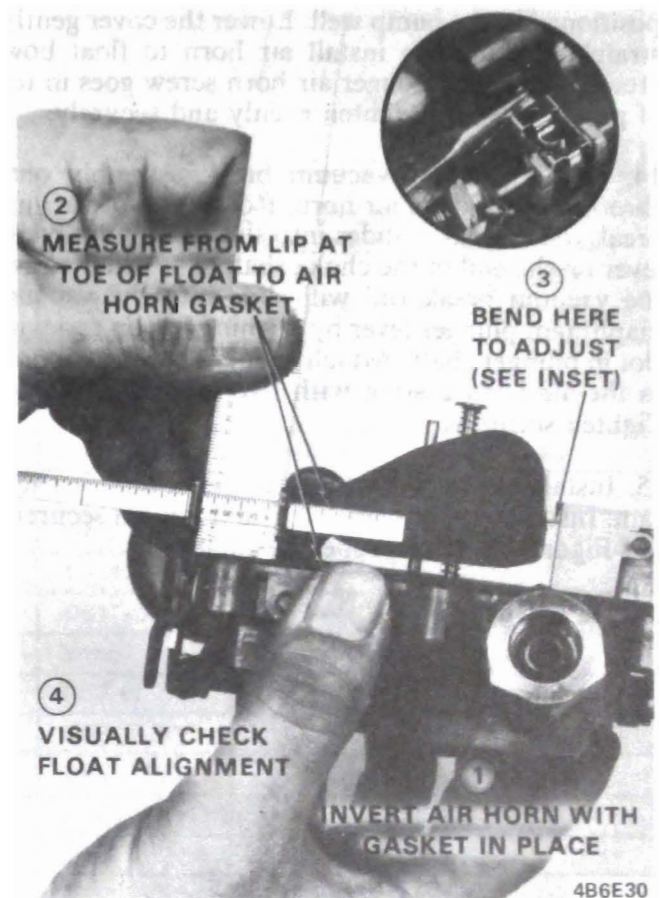


Figure 6E-30 - Float Level Adjustment

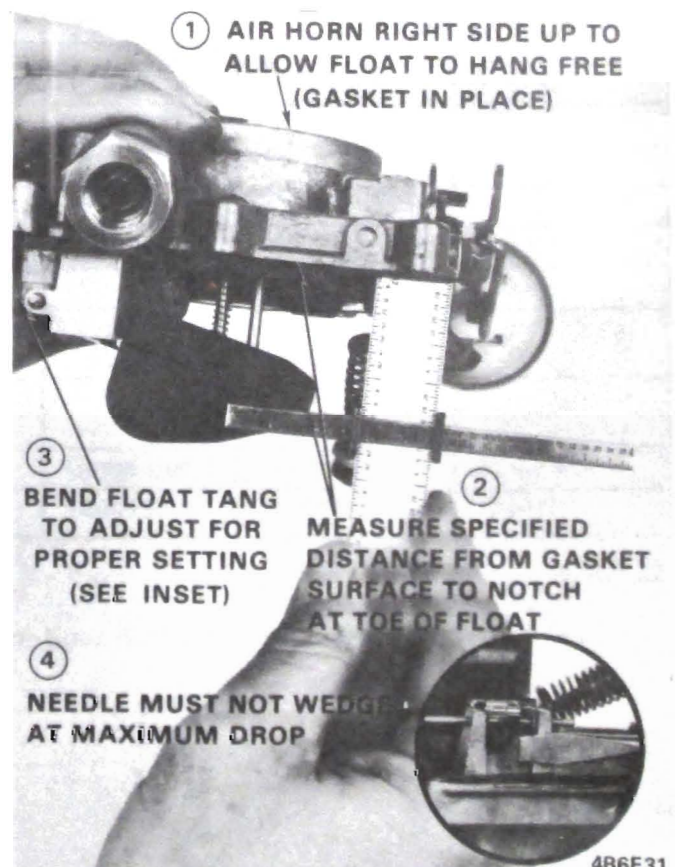


Figure 6E-31 - Float Drop Adjustment

positioned in the pump well. Lower the cover gently, straight down, then install air horn to float bowl attaching screws. Longer air horn screw goes in top of pump housing. Tighten evenly and securely.

14. Install primary vacuum break assembly onto throttle lever side of air horn. Rotate end of vacuum break rod so that it slides into slot in vacuum break lever on the end of the choke shaft. The other end of the vacuum break rod will slide into the vacuum diaphragm plunger lever by aligning lug on rod with slot in plunger shaft. Attach vacuum break assembly to the air horn casting with two attaching screws. Tighten securely.

15. Install choke rod into choke lever and fast idle cam. Install fast idle cam screw and tighten securely. See Figure 6E-8 for proper installation.

16. Install accelerator pump rod in pump lever and in throttle lever and install retainers.

17. Install secondary vacuum break lever on end of choke shaft with retaining screw. Slot in lever hangs downward when choke valve is open when installed correctly. Tighten securely.

18. Install secondary vacuum break assembly onto air horn using two attaching screws and actuating rod in slots in the vacuum break lever and vacuum diaphragm plunger shaft. Loop on secondary vacuum break rod hangs downward. Tighten vacuum break attaching screw securely.

19. Install vacuum hoses to primary and secondary vacuum break diaphragms. Then connect each vacuum hose to the separate tubes provided on the throttle body.

SPECIFICATIONS

ROCHESTER 2GV CARBURETOR CALIBRATIONS

	350 ENGINE A-B SERIES NON CALIFORNIA	350 ENGINE A-B SERIES CALIFORNIA	455 ENGINE A-B SERIES ALL	350 ENGINE X-SERIES NON CALIFORNIA	350 ENGINE X-SERIES CALIFORNIA
Model designation	2GV	2GV	2GV	2GV	2GV
Number of barrels	2	2	2	2	2
Part Number	7044142	7044442	7044141	7044144	7044444
Throttle bore	1-11/16"	1-11/16"	1-11/16"	1-11/16"	1-11/16"
Small venturi	1/8"	1/8"	1/8"	1/8"	1/8"
Large venturi	1-1/4"	1-1/4"	1-1/4"	1-1/4"	1-1/4"
Main metering jet prod.	.060"-60°	.060"-60°	.061"-60°	.060"-60°	.060"-60°
High altitude	None	None	None	None	None
Idle tube restriction	# 67	# 67	# 67	# 67	# 67
Idle needle hole	# 53	# 53	# 53	# 53	# 53
Spark holes	.045 x 125"	.045 x 125"	.045 x 125"	.045 x 125"	.045 x 125"
Pump discharge holes	2- #67	2- #67	2-.034"	2- #67	2- #67
Choke coil letters	BB	BB	BA	BB	BB
Fast idle cam numbers	17050023	17050023	7048865	17050023	17050023
Dome vent	2- #67	2- #67	2- #67	2- #67	2- #67
Cluster top bleed	2- #58	2- #58	2- #58	2- #58	2- #58
Float level adjustment	15/32"	15/32"	15/32"	15/32"	15/32"
Float drop adjustment	1-9/32"	1-9/32"	1-9/32"	1-9/32"	1-9/32"
Pump rod adjustment	1-15/32"	1-15/32"	1-15/32"	1-15/32"	1-15/32"
Choke tang adjustment	.080"	.080"	.080"	.080"	.080"
Choke unloader adjustment	.180"	.180"	.180"	.180"	.180"
Idle speed (on car)					
Solenoid energized	650 in "D"	650 in "D"	650 in "D"	650 in "D"	650 in "D"
Solenoid de-energized	500 in "D"	500 in "D"	500 in "D"	500 in "D"	500 in "D"
Vacuum break adjustment (Pri)	.140"	.140"	.160"	.140"	.140"
Vacuum Break adjustment (Sec)	.120"	.120"	.120"	.120"	.120"
Choke coil rod adjustment	Guage slot	Guage slot	Guage slot	Guage slot	Guage slot
Choke assembly no.	7044194	7044194	7044195	7044194	7044194

4B6E32

Figure 6E-32 Carburetor Specifications

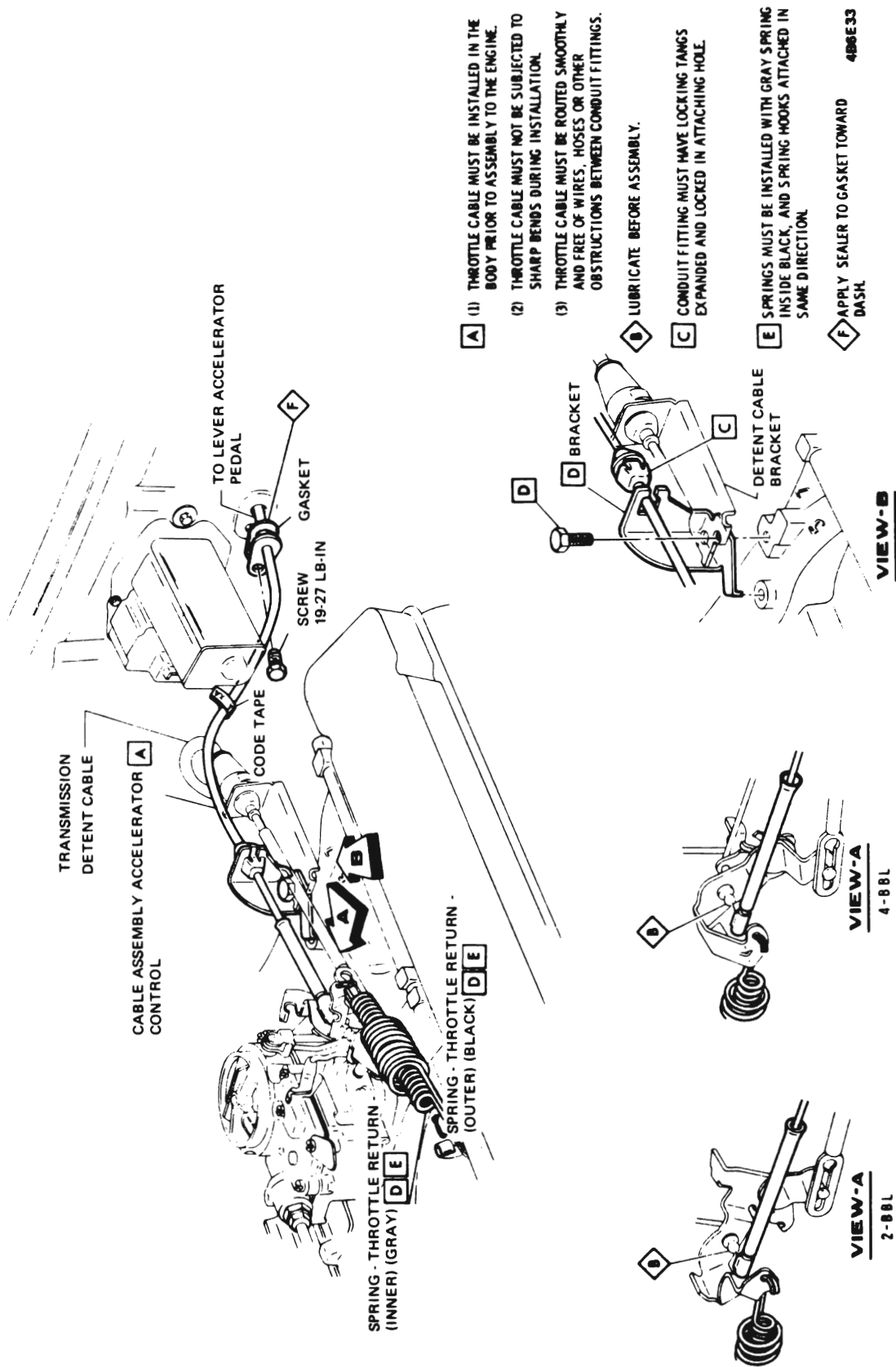


Figure 6E-33 "X" Series Accelerator Controls (350 Engine)

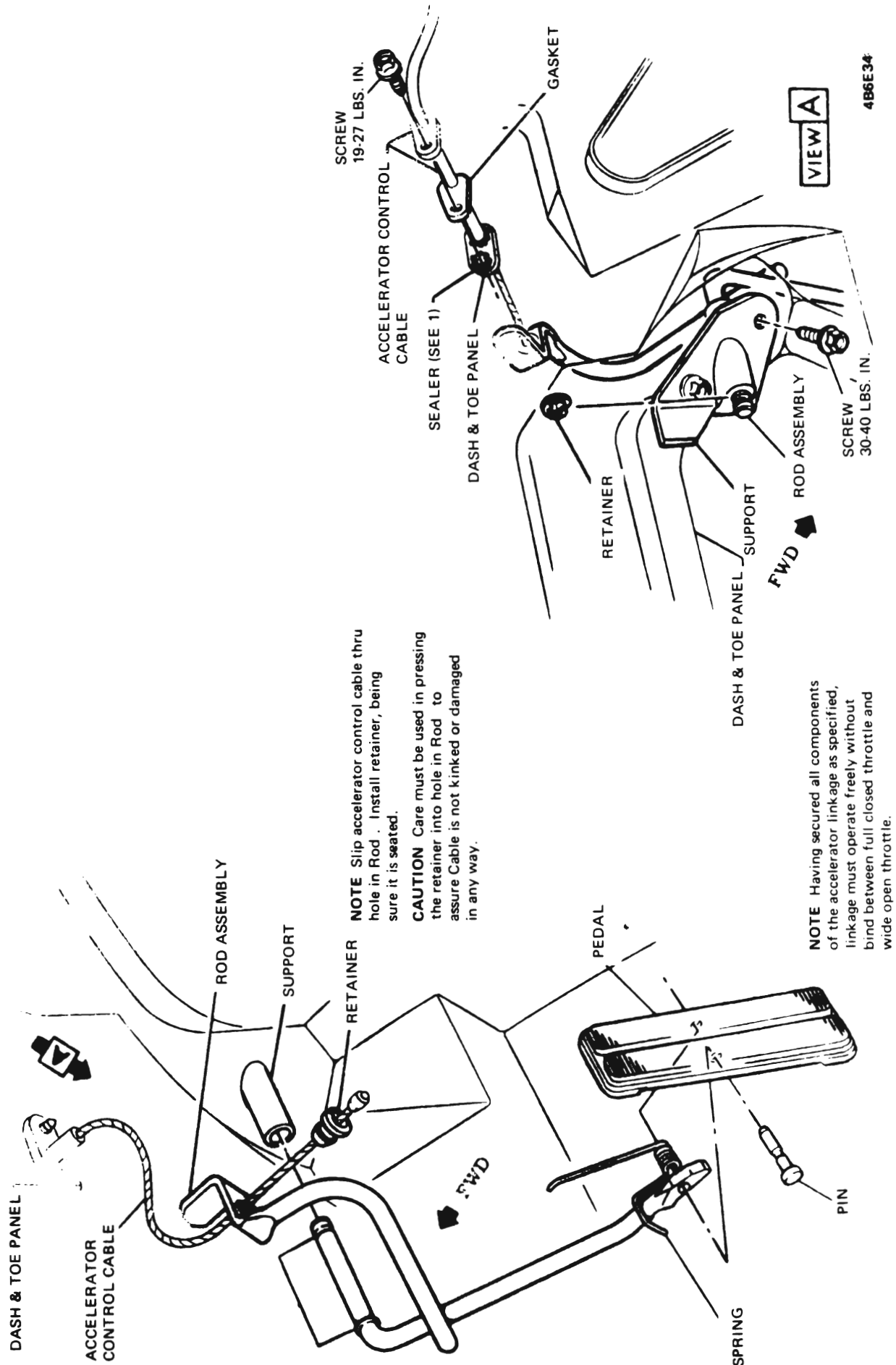


Figure 6E-34 "X" Series Accelerator Controls (Passenger Compartment)

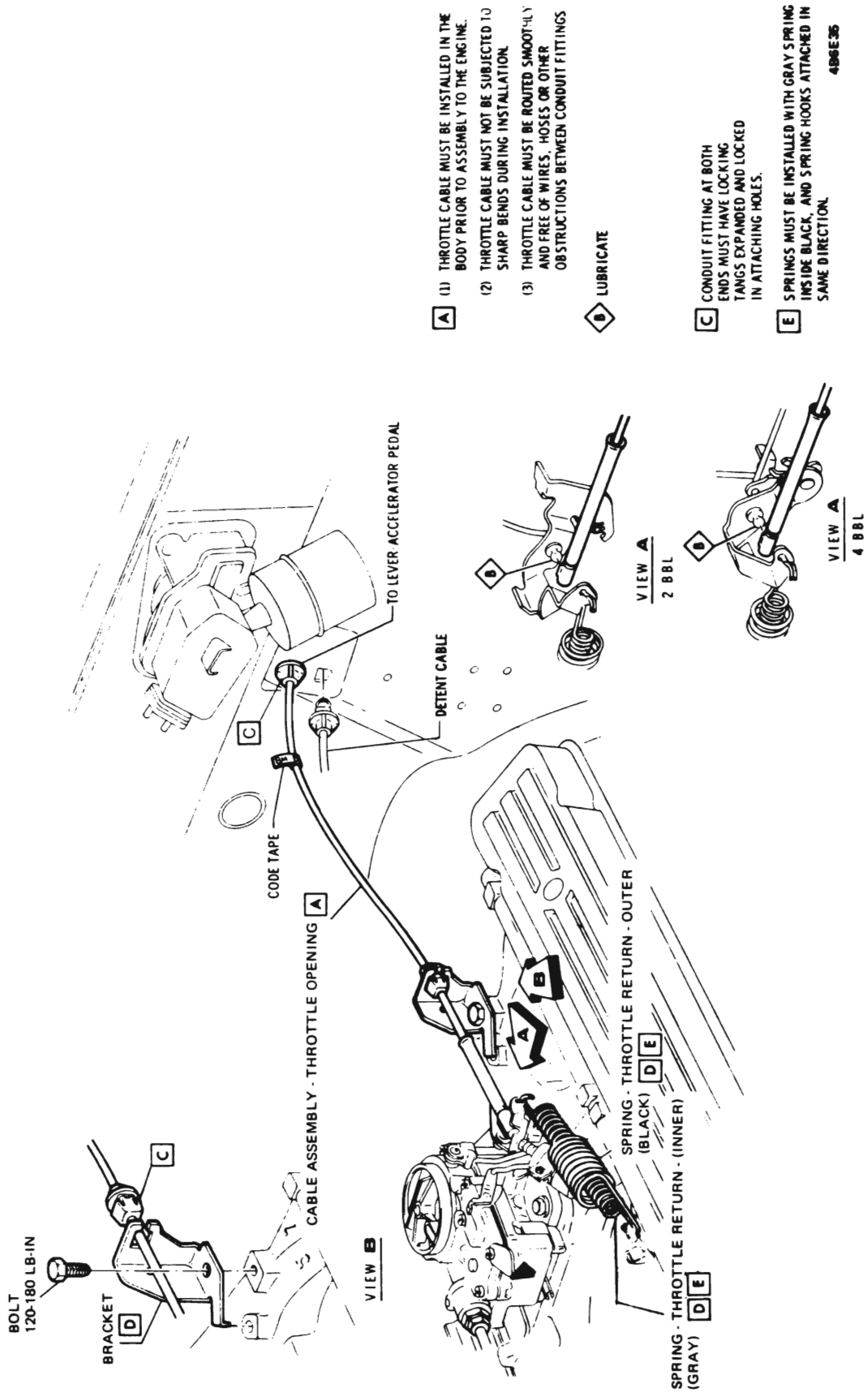


Figure 6E-35 A-B Series Accelerator Controls (350 Engine)

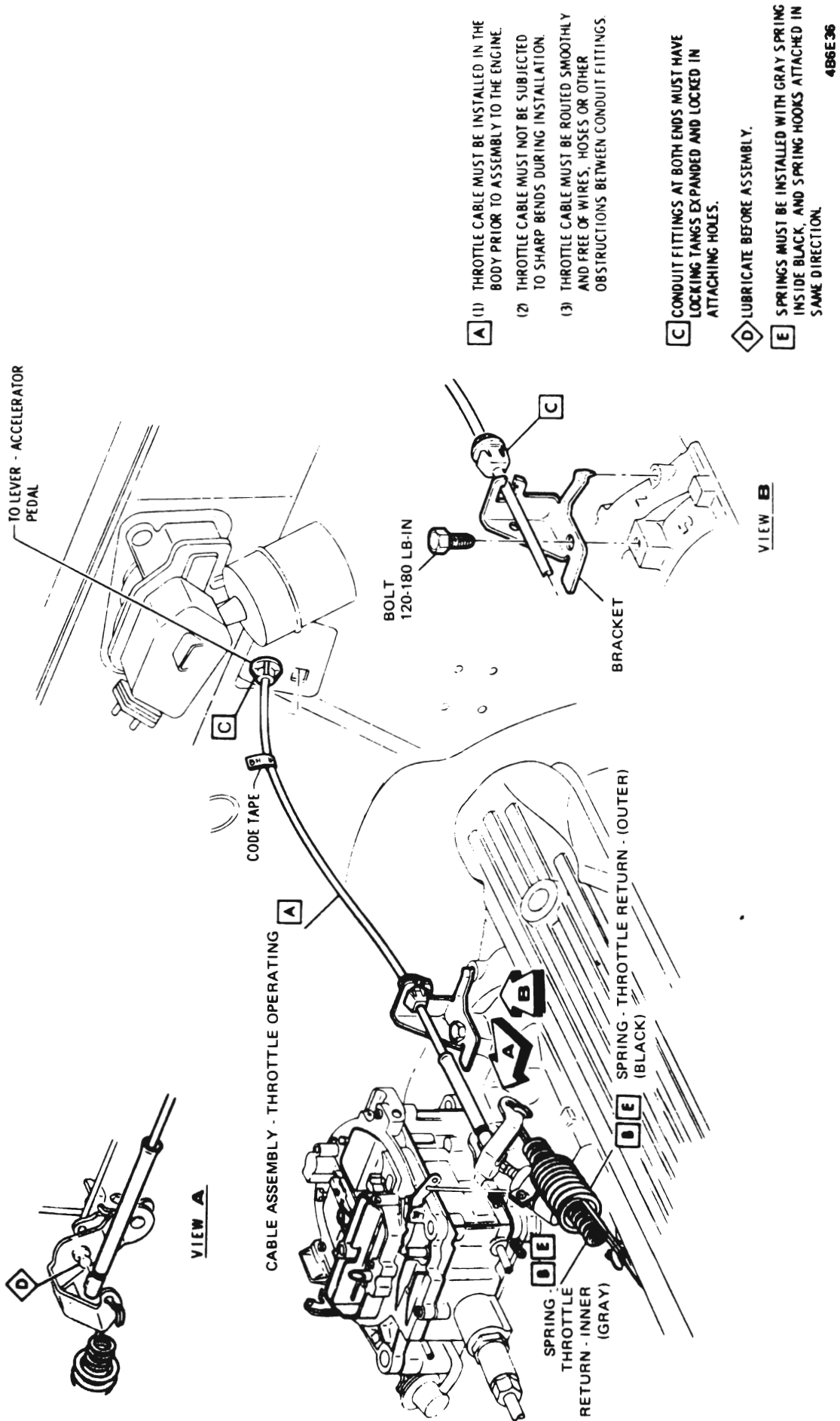
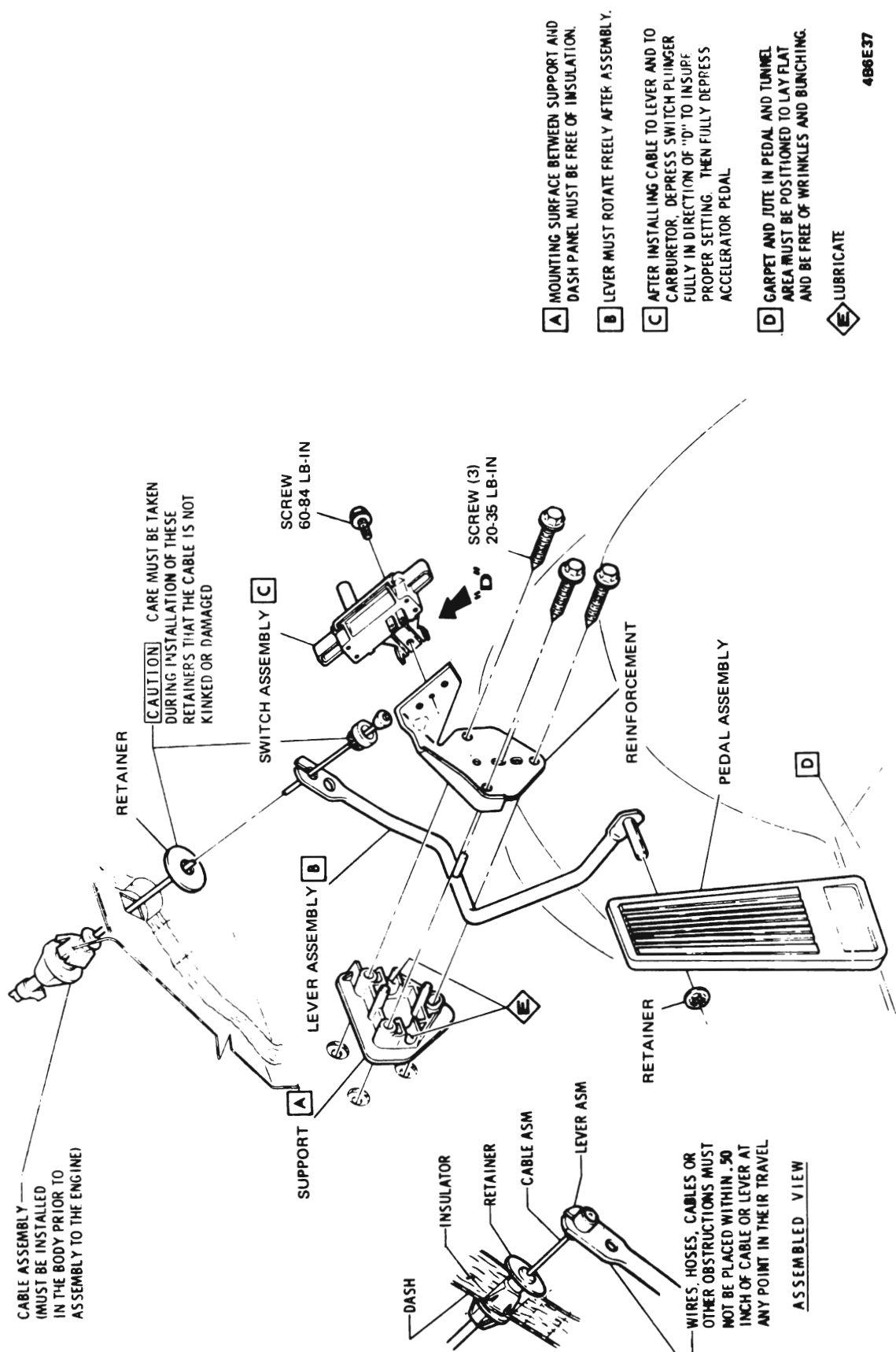


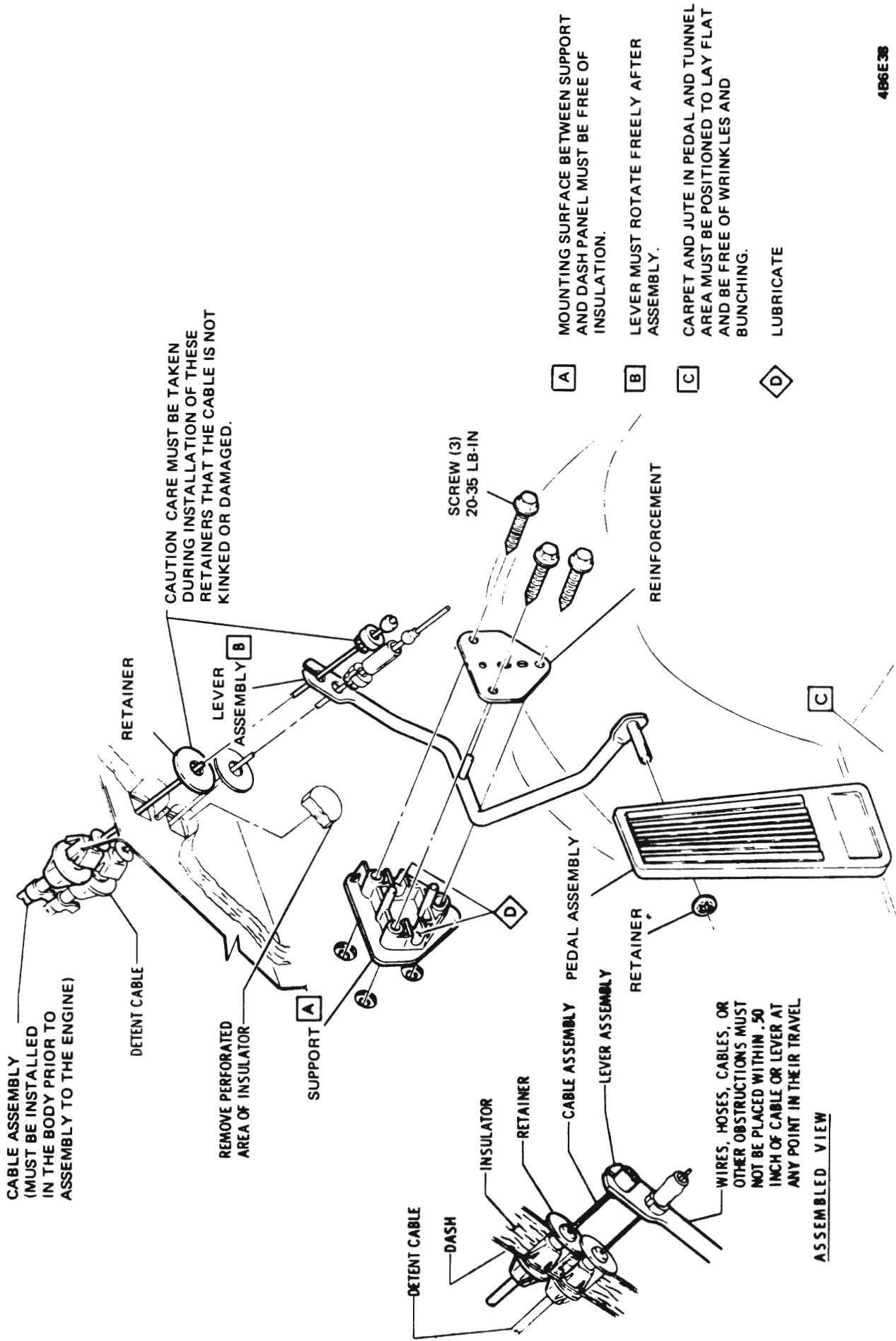
Figure 6E-36 A-B-C-E Series Accelerator Controls (455 Engine)



- A** MOUNTING SURFACE BETWEEN SUPPORT AND DASH PANEL MUST BE FREE OF INSULATION.
- B** LEVER MUST ROTATE FREELY AFTER ASSEMBLY.
- C** AFTER INSTALLING CABLE TO LEVER AND TO CARBURETOR, DEPRESS SWITCH PLUNGER FULLY IN DIRECTION OF "D" TO INSURE PROPER SETTING. THEN FULLY DEPRESS ACCELERATOR PEDAL.
- D** CARPET AND JUTE IN PEDAL AND TUNNEL AREA MUST BE POSITIONED TO LAY FLAT AND BE FREE OF WRINKLES AND BUNCHING.
- E** LUBRICATE

486E37

Figure 6E-37 "A" Series Accelerator Controls (400 Trans.)



486E38

Figure 6E-38 "A" Series Accelerator Controls (350 Trans.)

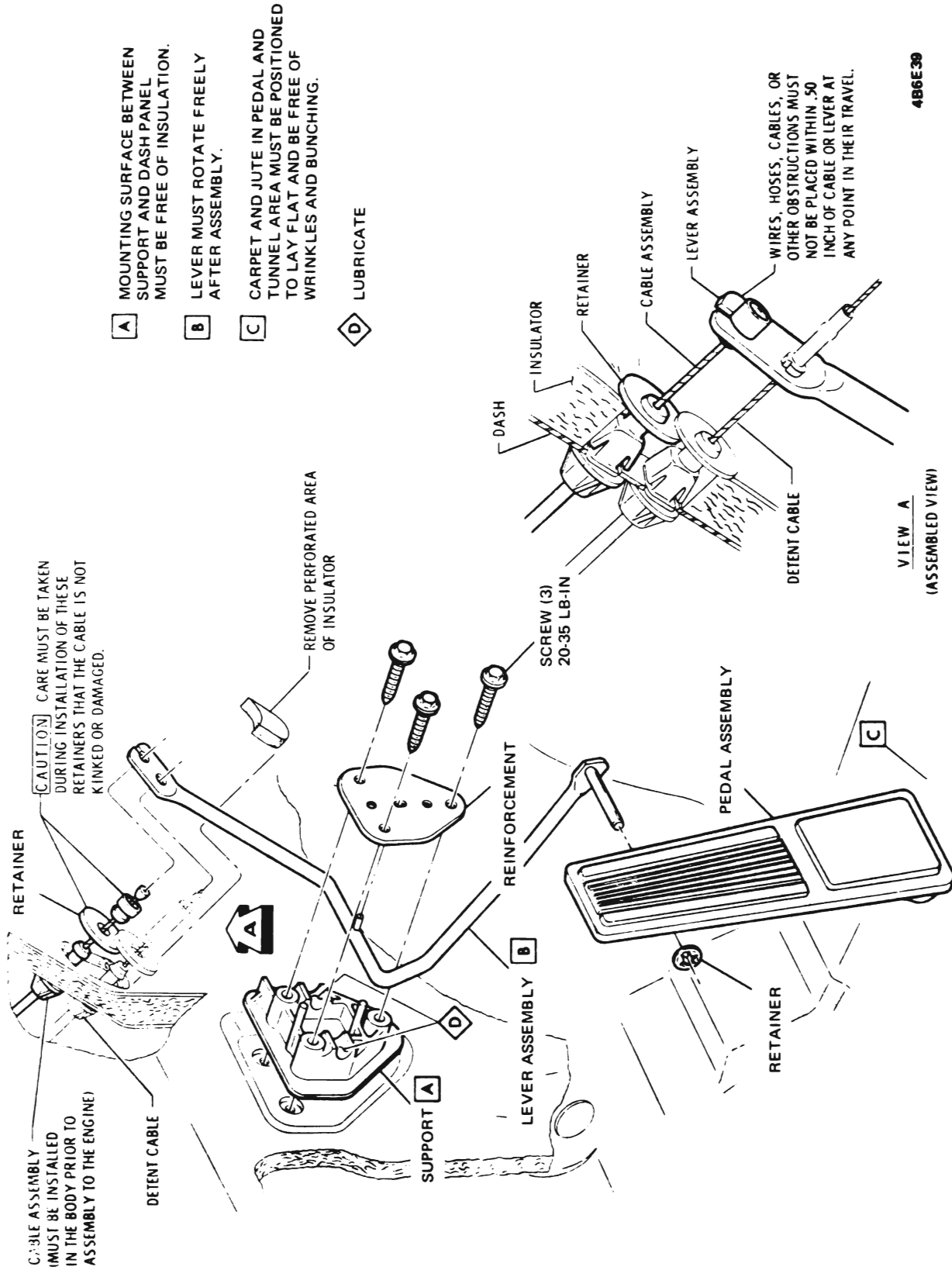
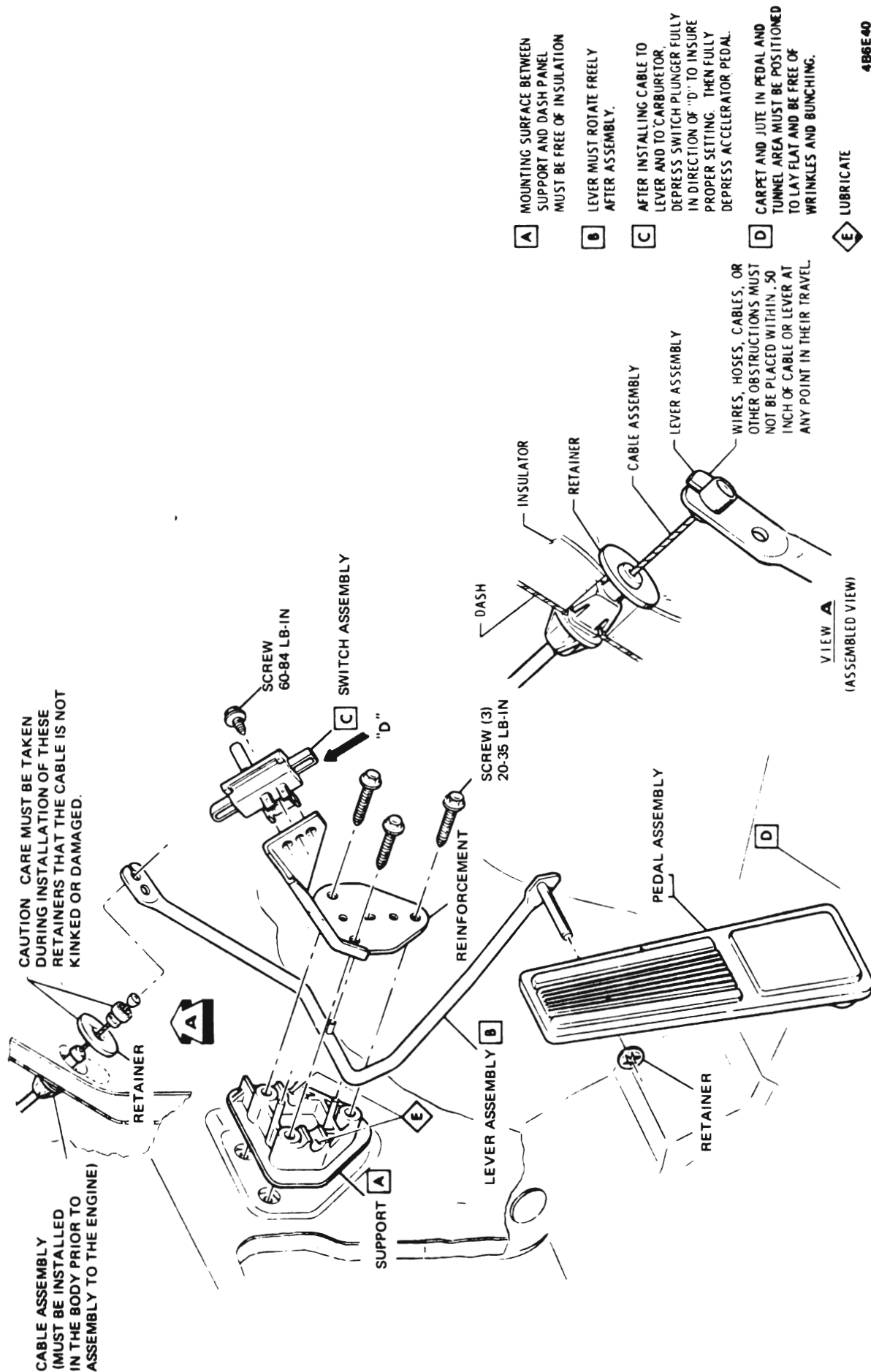


Figure 6E-39 'B' Series Accelerator Controls (375B Trans.)



4B6E40

Figure 6E-40 B-C-E Series Accelerator Controls (400 Trans.)