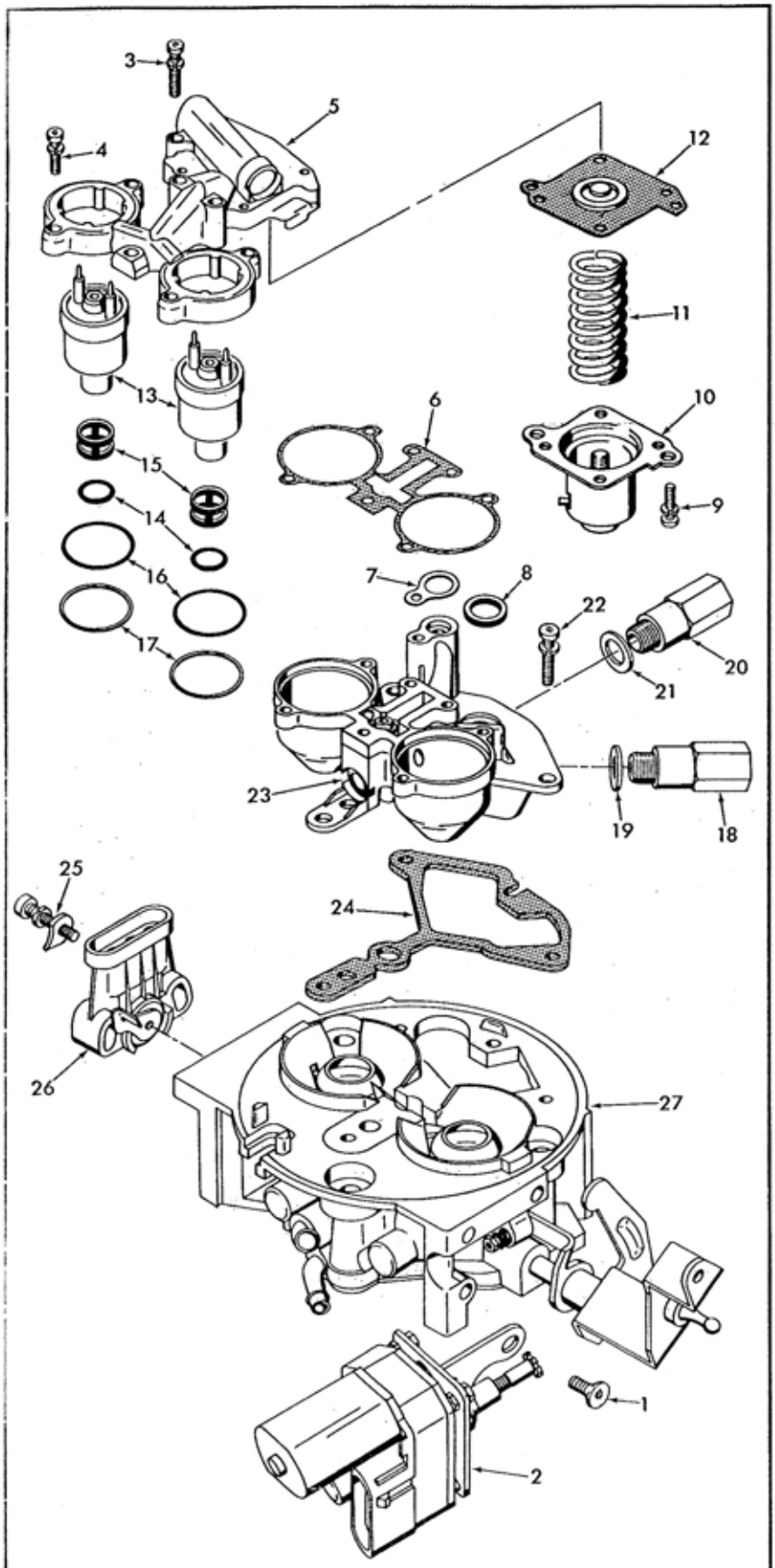
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# INSTRUCTION SHEET
# OFF-VEHICLE THROTTLE BODY INJECTION SERVICE
# ROCHESTER MODEL 100, 200, 220 AND 295 (TWO-POINT TBI)




**GENERAL EXPLODED VIEW**
**Actual Units May Vary**

## CAUTION NOTES

To reduce the risk of fire, it is necessary to relieve fuel system pressure before disconnecting fuel lines. To do this, remove fuse marked "Fuel Pump" from fuse block. Crank engine and run until fuel supply in fuel line is exhausted. When engine stops, engage starter for three (3) seconds more to assure dissipation of any remaining pressure. Use a holding fixture when servicing unit. It is possible to damage the throttle valve.

## DISASSEMBLY

Use the exploded view as a guide. The numerical sequence may generally be followed to disassemble unit far enough to permit cleaning and inspection.

## NOMENCLATURE

1. Screw, Idle Speed Control (2)
2. Idle Speed Control Assembly
3. Screw, Fuel Meter Cover (3)
4. Screw, Fuel Meter Cover (5)
5. Fuel Meter Cover & Pressure Regulator Assembly
6. Gasket, Fuel Meter Cover
7. Gasket, Fuel Meter Outlet
8. Dust Seal, Regulator
9. Screw, Pressure Regulator Cover (4)
10. Cover, Pressure Regulator
11. Spring, Pressure Diaphragm
12. Diaphragm Assembly, Pressure Regulator
13. Fuel Injector (2)
14. O-ring, Fuel Injector (small) (2)
15. Filter, Fuel Injector Nozzle (2)
16. O-ring, Fuel Injector (large) (2)
17. Back-up Washer, Large O-ring (2)
18. Fitting, Fuel Inlet
19. Gasket, Fuel Inlet Fitting
20. Fitting, Fuel Outlet
21. Gasket, Fuel Outlet Fitting
22. Screw & Lockwasher, Fuel Meter Body (3)
23. Fuel Meter Body
24. Gasket, Fuel Meter Body
25. Screw, Throttle Position Sensor Lockwasher & Retainer (2)
26. Throttle Position Sensor
27. Throttle Body Assembly

## SPECIAL DISASSEMBLY INSTRUCTIONS

**Disassembly of Fuel Meter Cover & Pressure Regulator Assembly (5):** Because of the large spring under heavy tension, accidental release could cause injury. Remove two (2) diaphragm cover screws (4) across from each other, then reinstall them for three (3) turns. Carefully remove the other two (2) screws evenly to release the spring tension. Holding cover and housing remove all screws. (Do not disturb pressure adjusting screw under spring.)

**Removal of Fuel Injector (13):** Make sure fuel meter cover gasket (6) is in place to protect casting. (It is recommended that pliers not be used.) Place a 5/16" rod to act as a fulcrum across casting. Using a screwdriver lift the injector until it is free from the fuel meter body (see fig. 2). Fuel injector is only serviced as a complete assembly.

## SPECIAL DISASSEMBLY INSTRUCTIONS (Cont'd)

**Removal of Fuel Filter (14):** Rotate back and forth, pulling from base of injector.

**Removal of Throttle Position Sensor (26):** An electrical unit, factory adjusted with the retaining screws spot welded to retain the critical setting. Throttle body assembly can be cleaned without removing throttle position sensor if care is used. Throttle position sensor must not be immersed in any type of liquid solvent or cleaner.

### TPS Removal for Model 100, 220, 295

1. Scribe locating marks on sensor and carburetor body for reassembly.
2. Using a file, remove two (2) spot welds holding throttle position sensor screws to throttle position sensor retainer plate.

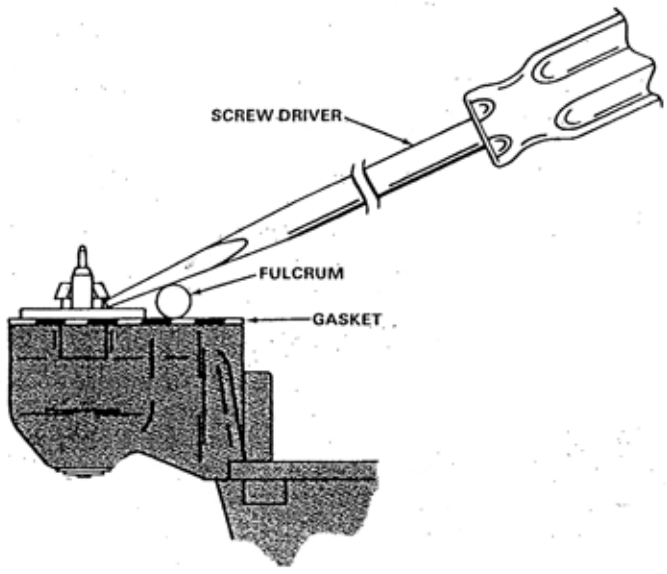
### TPS Removal for Model 200 (Prior to 1983)

1. Scribe location marks on sensor and carburetor body for reassembly.
2. Place throttle body inverted on a clean flat surface.
3. Using a 5/16" drill, drill completely through throttle position sensor screw access holes in base of throttle body to remove the spot welds holding the throttle position sensor screws in place.
4. Remove screws, lockwasher and retainers.

## CLEANING

Cleaning must be done with unit disassembled. Soak parts long enough to soften and remove all foreign material. Use a cold immersion type cleaner. Make certain the throttle bores are free of all carbon and varnish deposits. Rinse off in a suitable solvent. Blow out all passages in the castings with compressed air and check carefully to insure thorough cleaning of obscure areas. CAUTION: Do not soak electrical units, diaphragm units or rubber parts in any type of cleaning solvent.

FIG. 2 FUEL INJECTOR REMOVAL




## REASSEMBLY

Reassemble in reverse order of disassembly.

## SPECIAL REASSEMBLY INSTRUCTIONS

**Throttle Position Sensor (26):** Reinstall on the throttle body assembly with throttle valve in the normal closed position. Align scribe marks made on disassembly and tighten screws.

**Screw & Lockwasher Installation:** Make sure screws are free from oil and grease. Using an anaerobic thread locking compound (such as Loctite 262 or equivalent), apply compound to the first three (3) threads of each screw. Anaerobics cure after the components are assembled. Do not apply a higher strength thread-locking compound than recommended.

### Torque Instructions for TBI100, 200, 220

Fuel Meter Body Screws: Torque to 35 inch lbs.
Fuel Meter Cover Screws: Torque to 28 inch lbs.
Inlet and Outlet Fittings: Torque to 21 foot lbs.
Idle Air Control: Torque to 13 foot lbs.

### Torque Instructions for TBI295

Pressure Regulator Screws: Torque to 21 inch lbs.
Fuel Meter Body Screws: Torque to 28 inch lbs.
Injector Retainer Screws: Torque to 28 inch lbs.
Throttle Position Sensor Attaching Screws: Torque to 18 inch lbs.
Idle Air Control Valve: Torque to 28 inch lbs.
Governor Motor Plate Attaching Screws: Torque to 40 inch lbs.

**O-Rings:** Lubricate o-rings with automatic transmission oil before installing.

**Fuel Filter (14):** With large open end of filter facing up so that filter covers raised rib at base of injector, install small o-ring against filter.

**Fuel Injector (13):** Install washer (17) and o-ring (16) in fuel meter body (23). NOTICE: Back-up washer and large o-ring must be installed before the injector, or improper seating of the large o-ring could cause fuel to leak. Then install injector by using a twisting motion to center nozzle o-ring in injector cavity and align lug on base with notch in fuel meter body. Push down on injector to insure it is fully seated in cavity. Properly seated lug will be in notch and the electrical connections will be parallel to the throttle shaft.

**Pressure Regulator (5):** Install guide studs across from each other. Assemble diaphragm, spring and cover. Compress spring and install two (2) screws snugly. Remove studs and install remaining screws. Tighten screws down evenly.

**USE VEHICLE MANUFACTURER'S SERVICE MANUALS FOR "ON VEHICLE SERVICE AND ADJUSTMENTS.**