HOLTZMAN ENGINEERING, INC., VACUUM SOURCE INSTRUCTIONS (02/08/07)

The vacuum source fitting is installed in **one carb only**. Suitable adhesives are RED Loctite or epoxy. **In all cases, the vacuum source fitting must not interfere with slide movement. Loss of vehicle control and possible injury or death may result.**

MIKUNI TM FLATSLIDE (cover plate designs vary)



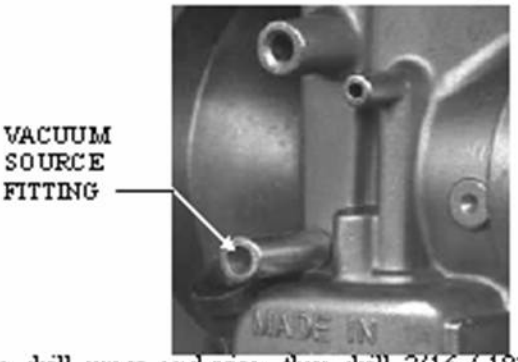


Remove a slide chamber cover plate. Use a **drill press** to drill a 15/64" (.234") hole anywhere in the plate but avoid slide stop pin, apply adhesive, and press the vacuum fitting's .27" diameter step against plate. For thin plates (Yamaha), after installing the fitting it can be "riveted" by lightly striking a tapered punch inserted in the carb side hole of the fitting (with the barb end on a solid surface). Install plate and **verify free movement of slide**. **Before installing on late model Ski-Doo's** see reverse side.

MIKUNI VM ROUNDSLIDE (No Picture)

Install the vacuum source fitting in a slide chamber cover located to avoid the slide spring and throttle cable. Install similarly to the TM flatslide shown above. An air passage at least as large as a 5/32" diameter hole must exist through the slide and cable retaining washer in any possible orientation; drill/modify as necessary. Arctic Cat with Magnet Block: Drill a 5/32" hole through **block and slide** using the off-center hole in the block as a guide, remove the block and drill a 5/32" horizontal hole through the block's edge into the off-center hole, and grind a 1/8" deep x 3/4" long flat on the washer's edge.

MIKUNI 38mm TMX (aftermarket)



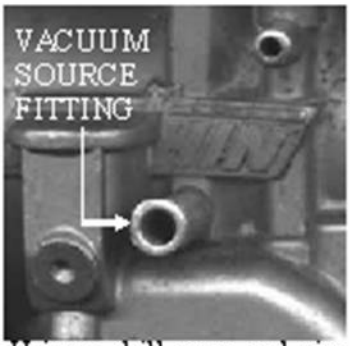
Using a drill press and vise, thru drill 3/16 (.187") on approximately a 3 degree angle **toward carb inlet bell** centered .21" above float bowl casting and .140" from bell edge of slide groove casting. Drill 15/64 (.234)"a depth of .125". Apply adhesive and press .27" diameter step firmly against carb. **Verify free movement of slide.**

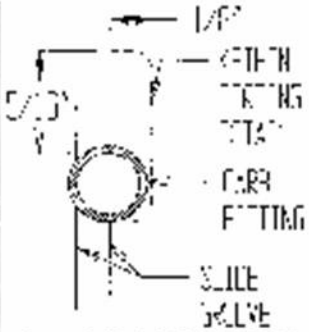
MIKUNI 34mm SNOPRO



Using a drill press and vise, thru drill 15/64 (.234)" centered on slide and as low as possible so tube will clear float bowl. Shorten smallest diameter step of vacuum source fitting to .1" long, apply adhesive and press fitting firmly against carb. **Optional Slide Modification:** In line with and on the same side as the vacuum fitting, mill lower edge of the slide .25" wide by .175" tall as shown. **Verify free movement of slide.**

KEIHIN 39mm PWK





Using a drill press and vise, thru drill 15/64 (.234)" on approximately a 2 degree angle **toward carb inlet bell**; hole center should be centered on flat surface of body and .21" above top of float bowl. Shorten smallest diameter step on vacuum fitting to .07" and de-burr, apply adhesive and insert until .27" diameter step is firmly against carb body. **Verify free movement of slide.**

TEMPA FLOW and ATAC C applications. Install vacuum fitting, then use 1/8" ball end mill and Dremel tool and **widen slide groove** (toward the air box side) to depth of slide groove. Use milling detail above as a guide (view is looking at fitting inside the carb bore from the air box and PTO side).

Optional Slide Modification: To provide compensation at lower throttle positions, on vacuum fitting side grind lower corner of slide 1/8" horizontally, 1/8" vertically.

For Mikuni CV, Keihin CVK, or other carbs not shown here, call Holtzman Engineering, Inc., 715-479-8727.