McCULLOCH

# SERVICE BULLETIN #1048

SUBJECT STEEL BALL SEAT REPLACEMENT

MODEL **MAC D30** D36, S44A and S55A DATE 1/6/59

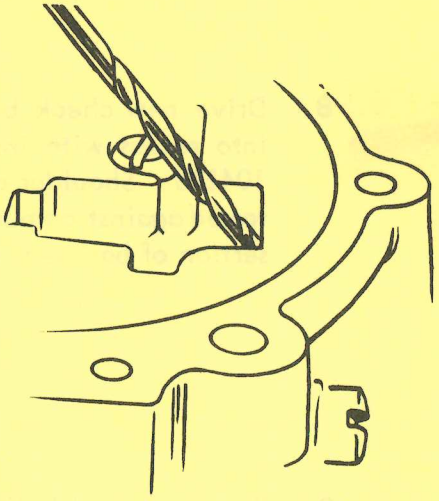
Engine flooding or carburetor leakage caused by a corroded, pitted, or out-of-round steel check ball seat, can be corrected by replacing the ball seat according to the following procedure:

1. Remove fuel pump body, fuel pump diaphragm, fuel pump gasket, diaphragm plate and diaphragm.

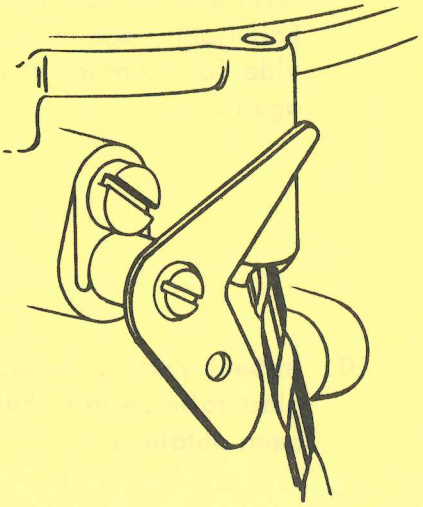
2. Remove inlet control spring, lever, pin and check ball. NOTE: Keep ball handy for future use.

3. Clamp carburetor body firmly in a smooth jaw vise. CAUTION: Take care to avoid damaging choke butterfly when clamping S44A or S55A carburetor body in vise.

4. Insert a No. 44 drill (.086 inch diameter) through defective ball seat (which will act as a guide) and drill through to outside of carburetor body.



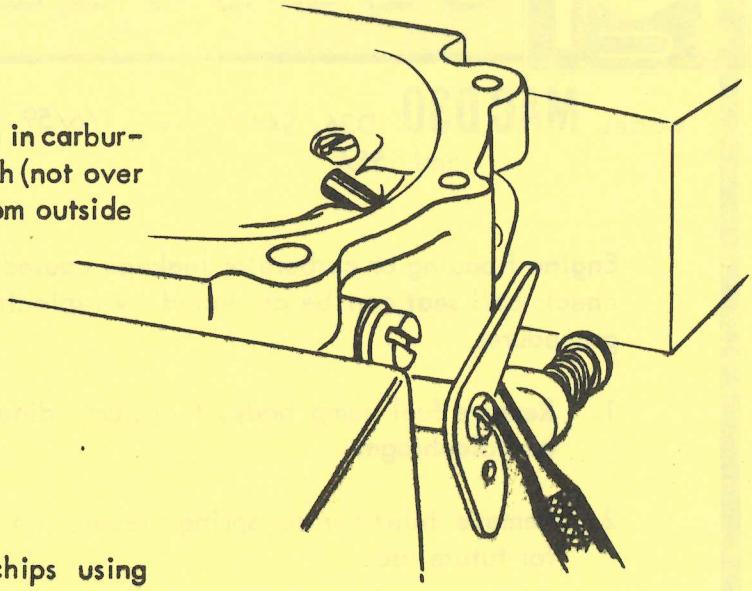
5. Enlarge hole below ball seat from outside with a No. 33 drill (.113 inch diameter).



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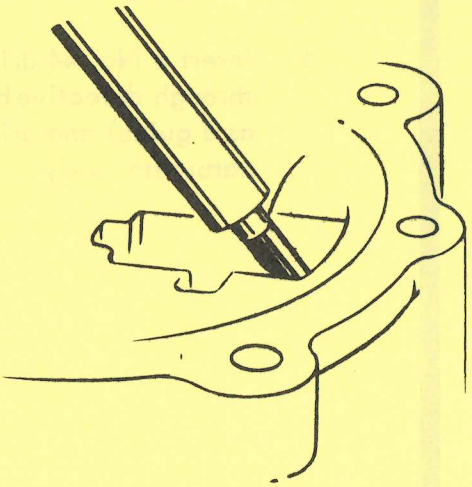
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6. Drive ball seat out of its recess in carburetor body with a small pin punch (not over .113 inch diameter) inserted from outside of enlarged hole.

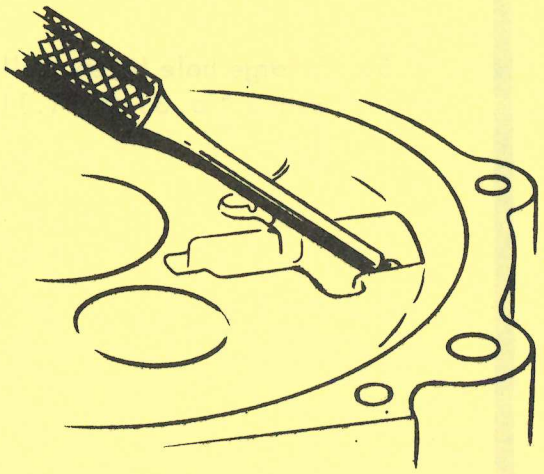


7. Clear fuel flow passages of chips using compressed air.

8. Drive new check ball seat, P/N 55343, into recess with inserting tool, Part No. 104178. Shoulder of inserting tool, bottomed against carburetor body, assures insertion of ball seat to correct depth.

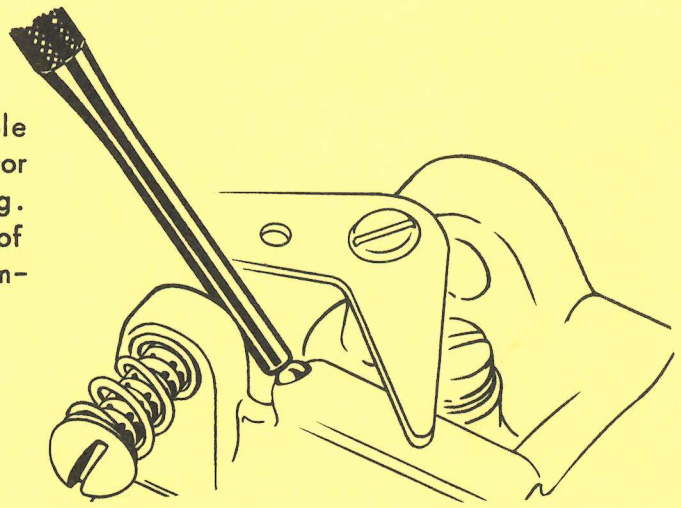


9. Place old check ball on installed new seat. With a pin punch and small hammer drive ball lightly against seating surface to provide full contact coverage for new ball against seat.



10. Inspect seating surface with magnifying glass to be certain that perfect seating has been obtained.

11. Drive old check ball into .113 inch hole (drilled previously on outside of carburetor body) until ball is flush with opening. Swedge rim of hole over ball. A drop of sealing compound on ball will assure complete sealing.



12. Wash carburetor thoroughly and blow out passages with compressed air.

13. Install new check ball, P/N 100302 on seat.

14. Reassemble inlet control lever parts and check height setting. (Refer to Service Bulletin No. 1039.)

15. Reassemble fuel pump and diaphragm components on carburetor body.

16. Tighten screws in recommended diagonal sequence. (Refer to Service Bulletin No. 1036.)