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IH: Carburetor, Intake Manifold & Exhaust - Sub-01F

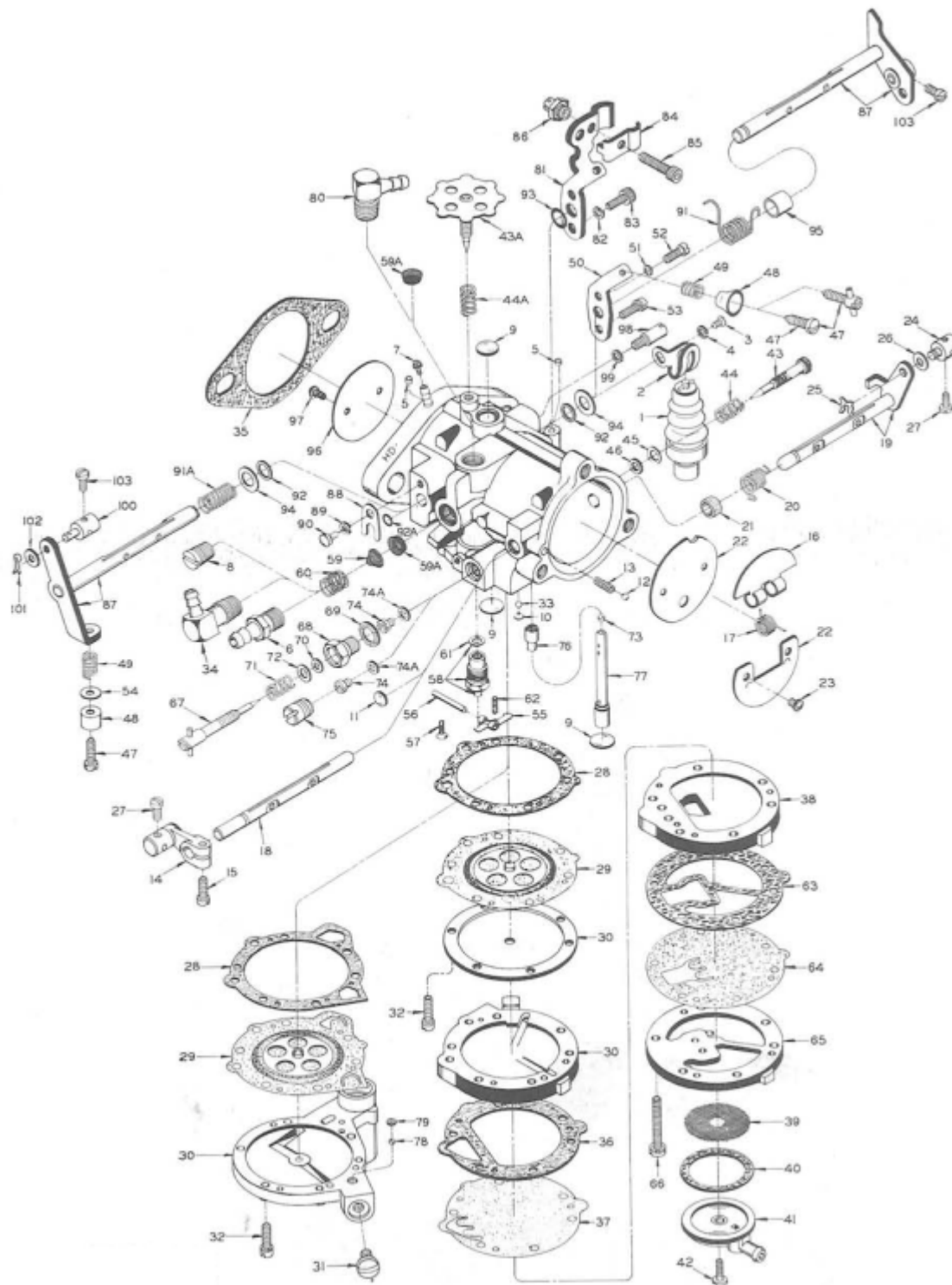
Rebuilding the Tillotson Carb

See also in the Sportsterpedia:

- [Tillotson Carb Basic Information](#)
- [Tillotson Carb Identification](#)
- [Tillotson Carb Functions, Adjustments, Tuning](#)

Parts List

Click on the diagram below to enlarge.



The list below is compilation parts list gathered from Tillotson documentation for carbs factory mounted to Sportsters.

(

[Click Here](#)

) to download a PDF version of this chart. Use the reference numbers below with the diagram above.

Ref No.	HD Part#	Description	Tillotson Part No. per Carb				
			HD1A	HD1B	HD1C	HD1D	HD5A
1	27760-66	* Accelerator Pump Assembly	013785	013785	013785	013785	---
2	27759-66	Accelerator Pump Lever	012761	012761	012761	012761	012761
3	2540	* Accelerator Pump Lever Screw	06393	06393	06393	06393	06393
4	7005	* Body Channel Cup Plug (2)	06396	06396	06396	06396	06396
5	—	* Body Channel Cup Plug (2)	010588	010588	010588	010588	010588
9	711	* Body Channel Welch Plug (2)	04326	04326	04326	04326	04326
10	713	* Body Channel Welch Plug	013737	013737	013737	---	013737
11	712	* Body Channel Welch Plug (Choke)	03489	03489	03489	03489	---
12	27406-26	Choke Friction Ball	04784	04784	04784	04784	---
13	27671-66	Choke Friction Spring	08805	08805	08805	08805	---
16	27668-66	Choke Relief Valve	013742	013742	013742	013742	---
17	27669-66	* Choke Relief Valve Spring	013775	013775	013775	013775	---
19	27718-66	Choke Shaft & Lever	013777	---	---	---	---
	27718-67		---	014296	014296	014296	
21	27661-66	Choke Shaft Seal	09484	09484	09484	09484	---
22	27673-66	Choke Shutter	013741	013741	013741	013741	---
23	27720-61	* Choke Shutter Screw (2)	08942	08942	08942	08942	---
24	27716-67	Choke Wire Connection	---	014294	014294	014294	---
25	27716-55	Choke Wire Retainer Clip	---	010392	010392	010392	---
26	27716-61	Choke Wire Connection Washer	---	012174	012174	012174	---
27	993W	Choke Wire Ret. Screw	---	012305	012305	012305	---
28	27806-66	Diaphragm Gasket	013731	013731	013731	013731	---
	27806-66R		---	---	---	---	014120
29	27816-66	* Diaphragm	013790	013790	013790	013790	---
	27816-66R		---	---	---	---	014248
30	27804-66A	Diaphragm Cover	014871	014871	014871	014871	—
	27804-66R		---	---	---	---	014117

31	27812-66	Diaphragm Cover Plug Screw	013771	013771	013771	013771	---
32	27814-66	Diaphragm Cover Retainer Screw (6)	010278	010278	010278	010278	—
	27812-66R		—	—	—	—	014142
33	27407-66	Economiser Check Ball	05322	05322	05322	---	05322
43	27352-66	Intermediate Mixture Screw	013772	013772	013772	013772	013772
43A	27688-66	Idle Mixture Screw	013787	013787	013787	013787	013787
44	27689-61	* Intermediate Mixture Screw Spring	011103	011103	011103	011103	011103
44A	27689-61	* Idle Mixture Screw Spring	011103	011103	011103	011103	011103
45	27354-66	Intermediate Mixture Screw Washer	03114	03114	03114	03114	03114
46	27353-66	Intermediate Mixture Screw Packing	010511	010511	010511	010511	010511
47	27717-66	* Idle Speed Screw	012177	012177	012177	012177	012177
48	27747-66	Idle Speed Screw Cup	010050	010050	010050	010050	010050
49	27691-59	* Idle Speed Screw Spring	0788	0788	0788	0788	0788
54	27644-66	Idle Speed Screw Washer	04920	04920	04920	04920	04920
55	27740-66	* Inlet Control Lever	014020	014020	014020	014020	014020
56	27613-66	* Inlet Control Lever	013406	013406	---	---	---
	27595-66	Fulcrum Pin	---	---	015397	015397	015397
57	27596-66	* Inlet Control Lever Fulcrum Pin Screw	013269	013269	013269	013269	013269
58	27588-66	Inlet Needle, Seat & Gasket	014224	---	---	---	014224
	27597-67		---	014853	014853	014853	
59A	27746-66	* Inlet Screen (2)	010301	010301	010301	010301	010301
61	27598-66	Inlet Seat Gasket	013744	013744	013744	013744	013744
62	27599-66	* Inlet Tension Spring	013434	013434	013434	013434	013434
67	27745-66R	High Speed Mixture Screw	---	---	---	---	013855
68	27834-71	High Speed Mixture Screw Gland	---	---	---	---	013853

69	27698-61	High Speed Mixture Screw Gland Gasket	---	---	---	---	0676
70	27353-66	High Speed Mixture Screw Gland Packing	---	---	---	---	010511
71	27689-61	* High Speed Mixture Screw Spring	---	---	---	---	011103
72	27354-66	High Speed Mixture Screw Washer	---	---	---	---	03114
74	27615-66	Main Fuel Jet (.057)	011394	011394	011394	011394	---
	27619-66R	Main Fuel Jet (.089)	---	---	---	---	014313
74A	27640-66	Main Fuel Jet	06076	06076	06076	06076	---
	27830-71	Gasket	---	---	---	---	013683
75	27704-61	Main Fuel Jet Plug Screw	01102	01102	01102	01102	---
76	27658-66	Nozzle Check Valve	013789	013789	013789	013789	013789
78	27407-66	Pump Outlet Check Ball	---	---	05322	05322	---
79	—	Pump Outlet Check Ball Retainer	---	---	012153	012153	---
87	27708-66	Throttle Shaft & Lever	013782	---	---	---	---
	27708-67		---	014297	014297	014297	014297
91A	27706-66	* Throttle Shaft Compression Spring	013738	013738	013738	013738	013738
92	27707-66	Throttle Shaft Seal (2)	013740	013740	013740	013740	013740
94	27712-66	* Throttle Shaft Seal Washer (2)	013746	013746	013746	013746	013746
96	013745	Throttle Shutter	013745	013745	013745	013745	013745
97	2545W	* Throttle Shutter Screw (2)	08942	08942	08942	08942	08942
100	27715-67	Throttle Wire Connection	---	014225	014225	014225	014225
101	515	Throttle Wire Connection Retainer Clip	---	0379	0379	0379	0379
102	6189W	Throttle Wire Connection Washer	---	05413	05413	05413	05413
103	993W	* Throttle Wire Retainer Screw	058	058	058	058	058
* Gasket Set			GS-2HD	GS-2HD	GS-2HD	GS-2HD	GS-2HD
Repair Parts Kit			RK-3HD	RK-3HD	RK-3HD	RK-3HD	RK-3HD

(*) Indicates contents of Repair Parts Kit

Cleaning

- The general appearance of the inside of the carb is not necessarily a good indication of its condition.
It can look spotless and have clogged jets, or look cruddy and have clear jets.
- It's good to clean each individual part rather than soak or boil the whole carb in carb cleaner. But either way is good. Do not allow any solvents to contact any rubber parts (tip of needle, O-ring seal for bowl).
- Make sure to take everything apart, jets, needle, accel pump, all rubber components especially.
- Examine all parts for excessive wear, damage, distortion, etc.
- Cleaning solutions/sprays vary based upon your location, needs, budget, preferences and quality. Dismantle the carb down to the body before soaking. You will be surprised at all the dirt in the bottom of the soaking container.

Here are some helpful ideas:

- An overnight soak in a solution of Pinesol and water followed up with a good brush down with a toothbrush then rinse and air dry. ¹⁾
See also [Soaking parts](#) in the REF section of the Sportsterpedia.
- A 20 minute to up to a few days soak in a gallon of Gunk (or other) Carburetor Cleaner that has a basket inside for small parts and lowers in the can with a handle, rinse, air dry, use.
- Soak it in mineral spirits for a few days. ²⁾
- You can use acrylic paint thinners for cleaning up carb parts. It melts the fuel varnish right off. ³⁾
- An aerosol spray carb cleaner will also work but may not loosen all of the build up in the jets or orifices in the carb body if they're not directly sprayed through.
- Blow out all holes, jets and orifices thoroughly with compressed air after cleaning.

A gallon of carburetor cleaner is very useful in cleaning out varnish from the channels and metering chamber.

It is especially useful for soaking stuck gaskets between parts and loosen the joint between them for dis-assembly.

Depending on how old or how 'stuck' the parts are, soaking for a couple hours may help to separate the old gasket in between.

Make sure to remove any rubber or plastic parts before soaking. Also check the label for safety precautions.

Parts that have been sitting for years may have to be soaked for about 24 hours or even days.

Carburetor Cleaner ⁴⁾

**Note:**

The use of wire to 'rod' out jets and orifices is discouraged in the FSM.

However, a hard wire such as a welding tip cleaner, has been known to open up stubborn areas at times. Always use a wire smaller than the orifice cleaned so you don't widen the holes.

Doing so could create burrs or change the hole sizes.

Carb Stand:

- You can put the carb in a vice to remove the screws, and for much of the following work. Wrap in a shop towel; close the vice gently taking extra care with the choke and throttle linkages. The vice is a needed extra pair of hands.
- It can be very confusing trying to decide which way to bend the tang if it is not correct. If the fuel level is low, is the float high or low?, Do you need to bend the tang up or down? etc. On the bench the carb is usually upside down, adding to the confusion. You should sort all this out before making an adjustments.

However, this setup works better than putting the carb directly into the vice.

The carb is set upright as 'in use' making adjustments more straight forward.



5)



6)

Related Service Bulletins

There are 5 known technical service bulletins related to Tillotson carbs.

[Click Here](#) to go to the Service Bulletin page in the Sportsterpedia.

You can scroll down to the following bulletins and click the "Y" next to each bulletin to download it.

- TSB# 518 dated 9-10-1965 (Includes operation, adjustments, troubleshooting and servicing.)
- TSB# 547 dated 10-24-1966 (Models produced after August 10, 1966 have a new carburetor inlet valve lever, needle and seat assembly.)
- TSB# 564 dated 1-15-1968 (Instructions included for Adjusting, Diagnosing, Disassembly, Cleaning and Assembling).
- TSB# 571 dated 5-21-1968 (Tillotson carbs changed to incorporate a ball check valve in accelerating pump passage of plastic cover.)
- TSB# 605 dated 11-28-1969 (Addresses shipments of defective needles with incorrectly formed blunt ends instead of tapered.)

Welch Plug or Expansion Plug

- Inspection:
 - A close inspection around the walls of a welch plug can reveal possible leaks.
- Removal: ⁷⁾
 - Whenever a welsh plug is removed, a new one should be installed in it's place, especially since a large part of the time, removal of one means destroying or deforming it. ⁸⁾
 - Drill an 1/8" hole thru it (just deep enough to break thru to the other side) off center and pry it out with a small punch. Be careful not to drill too deep which could destroy the nozzle assembly or casting. While prying it out, be careful not to damage the casting counter-bore edges around the plug.
 - You can also drill a small hole in it and use a small tap just big enough to start in the hole. ⁹⁾ Thread the tap in the hole.
When it gets to the bottom of the passage, it will force the valve out with out damaging the bottom of carb passage.
Make sure to clean all the chips out to keep from plugging up passages later.
- Installation: ¹⁰⁾¹¹⁾
 - The plug should be seated with a flat end punch that is slightly smaller than the diameter of the plug. The plug should be flat and not concaved to assure a tight fit. If leakage is suspected due to a rough or damaged welch plug seat in the casting, apply a small amount of epoxy or suitable sealant to the edges after installing it.

Links to Welch plug sites:

- [M.D. Hubbard Spring Co.](#)

Diaphragm

The diaphragm for HD1 carbs is HD part# (27816-66).



Links, Parts and Services for Tillotson Carbs

Original P/N for a Sporty Tillotson repair parts kit 27147-66 ¹³⁾

Original P/N for a Big Twin Tillotson repair parts kit 27137-66

- Parts list for Tillotson HD carbs:
 - [HD Series 1 Parts List \(PDF\)](#)
 - [HD Series 2 Parts List \(PDF\)](#)
 - [Tillotson Carburetor Part Number Cross Reference \(PDF\)](#)
- Service manual for Tillotson carbs:
 - [Tillotson HD Series Carburetor \(PDF\)](#)
- Servicing for Tillotson carbs:
 - [Tillotson Company.](#)
 - [EC Carburetors.](#)
 - [The Carburetor Shop.](#)



Tillotson Carburetor repair/ refresh kit¹⁴⁾

Full Tillotson / HD Carb Part# Cross Reference Chart

Cross reference list between HD part#s and Tillotson part#s provided by sungod of the XLForum.

ID Part#	Tillotson Part#	Description	ID Part#	Tillotson Part#	Description

711	04326	Welch Plug	27705-61	08850	Nozzle
712	03489	Welch Plug	27705-66	014049	Spring
713	013737	Welch Plug	27705-66A	015253	Spring
1065W	08315	Screw & Lockwasher	27706-57	010519	Spring
2545W	08942	Screw & Lockwasher	27706-63	012823	
2546W	09066	Screw	27706-66	013738	Spring
27119-74	HD-14A	Carburetor	27707-57	07824	Seal
27123-70R	HD-43A	Carburetor	27707-66	013740	Seal
27132-66R	RK-723	Repair Kit	27708-55	010444	Shaft
27133-66	GS-1HL	Gasket Kit	27708-57	010844	Shaft
27134-66	RK-8HL	Repair Kit	27708-66	013782	Shaft & Lever
27135-63	RK-572	Repair Kit	27708-67	014297	Shaft & Lever
27135-66	RK-3HD	Repair Kit	27709-55	08597	Clip
27135-66	RK-659	Repair Kit	27710-55	010446	Lever & Swivel
27135-66	RK-660	Repair Kit	27710-59	011691	Lever & Wire Connection
27137-66	RK-764	Repair Kit	27711-55	010445	Lever
27138-63	GS-168	Gasket Set	27712-55	03804	Washer
27138-66	GS-187	Gasket Set	27712-66	013746	Washer
27138-66R	GS-204	Gasket Set	27713-55	09067	Lever
27138-71	GS-223	Gasket Set	27713-59	08490	Throttle Stop Lever
27139-66R	RK-771	Repair Kit	27714-55	08646	Shutter
27140-71	RK-988	Repair Kit	27714-61	012146	Shutter
27143-61	MD-119A	Carburetor	27714-63	012283	Shutter
27144-59	MT-76A	Carburetor	27714-66	013745	Shutter
27144-63	MD-198	Carburetor	27715-55	010393	Connection
27145-55	MT-43A	Carburetor	27715-59	011686	Choke & Wire Conn.
27145-55A	MT-43B	Carburetor	27715-61	012328	Connection
27145-60	MT-82A	Carburetor	27715-66	013534	Shutter
27150-71	HD-77A	Carburetor	27715-67	014225	Connection
27150-70A	HD-77B	Carburetor	27716-55	010392	Washer
27152-66	HD-2D	Carburetor	27716-61	012174	Washer
27152-66A	HD-1B	Carburetor	27716-67	014294	Connection
27152-66B	HD-2D	Carburetor	27717-59	05095	Screw
27154-66R	HD-5A	Carburetor	27717-66	012177	Screw
27155-66	HD-1C	Carburetor	27718-61	012334	Shaft & Lever
27155-66A	HD-1B	Carburetor	27718-63	012806	Shaft & Lever
27155-66C	HD-1G	Carburetor	27718-66	013777	Shaft & Lever
27158-63	HL-139A	Carburetor	27718-67	014296	Shaft & Lever
27158-63	HL-139B	Carburetor	27719-60	02672	Bushing
27158-63A	HL-212A	Carburetor	27720-61	08942	Screw & Lockwasher
27158-67	HL-23A	Carburetor	27721-55	GS-106	Gasket Set
27249	012741	Washer	27721-61	GS-116	Gasket Set
27273-63	012825	Lever	27722-55	RK-164	Repair Kit
27274-67A	015594	Lever	27722-59	RK-397	Repair Kit
27274-67	014266	Lever	27722-60	RK-467	Repair Kit
27276-63	012826	Shaft & Lever	27722-61	RK-472	Repair Kit
27276-66	014050	Shaft	27725-61	09644	Shutter
27277-66R	014297	Shaft & Lever	27726-61	09678	Clip
27295-66R	RK-497	Repair Kit	27727-61	09780	Bushing
27317-63	012284	Jet (.043)	27728-61	010079	Lever
27347-69	012392	Spring	27729-61	012111	Clip
27352-66	013772	Mix. Screw	27730-61	013618	Spring
27353-66	010511	Ring	27730-63	012621	Shaft & Lever
27354-66	03114	Washer	27730-66	014048	Shaft & Lever
27407-66	05322	Ball	27730-67	014268	Choke Shaft Assem.
27411-67R	08304	Gasket	27731-61	011072	Seal
27413-63	010165	Gasket	27731-65	013507	Spring
27415-61	07903	Gasket	27732-61	01974	Screw
27593-66	012956	Nut	27732-63	010571	Screw
27595-66	015397	Fulcrum Pin	27733-61	0992	Lockwasher
27596-66	013269	Screw	27734-62	010911	Screen
27597-66	013774	Needle & Seat	27735-61	06062	Screw & Lockwasher
27597-67	014853	Needle & Seat	27736-65	07847	Washer
27598-66	013744	Gasket	27740-61	012321	Mix. Screw
27599-66	013434	Spring	27740-63	010513	Control Lever
27601-63	010529	Gasket	27740-66	014020	Control Lever
27613-66	013406	Pinion Pin	27740-70R	013589	Inlet Lever
27615-66	011394	Jet (.057)	27742-61	012326	Spring
27616-66	011396	Jet (.061)	27743-61	012327	Stop Screw
27617-66	011765	Jet (.033)	27744-61	012332	Screw
27618-66	011722	Jet (.055)	27745-66R	013855	Mix. Screw
27619-66	011395	Jet (.059)	27746-66	010301	Screen
27619-66R	014313	Jet (.089)	27747-66	010050	Cup
27620-66	011385	Jet (.063)	27759-66	012761	Lever
27622-66	011764	Jet (.051)	27760-63	010525	Pump Body
27624-66	011763	Jet (.049)	27760-66	013785	Pump Assembly
27640-66	06076	Gasket	27760-71	014992	Shaft and Lever
27643-71	014645	Pump Body	27760-71A	015959	Shaft and Lever
27644-66	04920	Washer	27761-63	012930	Gasket
27658-66	013789	Check Valve	27775-74	08942	Screw & Lockwasher
27661-66	09484	Seal	27804-63	014336	Diaphragm Cover
27667-71	015937	Lever Assembly	27804-66	013772	Pump Body
27668-66	013742	Relief Valve	27804-66A	014871	Pump Body
27669-66	013775	Spring	27804-66R	014117	Diaphragm Cover
27670-55	03454	Friction Pin	27805-63	010527	Strainer Cover
27671-66	08805	Spring	27806-63	012473	Gasket
27672-55	09158	Shaft & Lever	27806-66	013731	Gasket
27672-59	011692	Shaft & Lever	27806-66R	014120	Gasket
27672-61	012330	Shaft & Lever	27807-63	010098	Screw & Lockwasher
27672-63	012811	Shaft & Lever	27808-63	010530	Strainer Screen
27673-55	05088	Shutter	27809-63	012698	Diaphragm
27673-66	013741	Shutter	27809-63A	014229	Pump Diaphragm
27674-63	012818	Shutter		014230	Pump Diaphragm
27674-63A	09558	Shutter	27810-63	011428	Washer
27674-66	014816	Shutter	27811-63	011401	Packing
27675-55	08080	Gasket	27812-63	02232	Plug Screw
27678-61	03311	Plug Screw	27812-66	013771	Screw
27679-61	07896	Plug Screw	27812-66R	014142	Screw
27680-55	012144	Float	27813-63	011503	Spring
27680-61	011294	Float	27814-66	010278	Screw & Lockwasher
27680-63	012813	Float	27815-63	012084	Check Valve
27681-55	011564	Pin	27816-63	014475	Diaphragm
27682-55	010471	Cover	27816-66R	014248	Diaphragm
27683-55	08658	Gasket	27816-66	013790	Diaphragm
27684-61	012616	Fuel Bowl	27817-71	014248	Diaphragm
27685-61	011859	Pinion Screw	27818-66	013094	Gasket
27688-55	08765	Mix. Screw	27821-63	012370	Jet (.041)
27688-61	012318	Mix. Screw	27819-63	014540	Jet (.037)
27688-63	011825	Mix. Screw	27820-63	013266	Jet (.039)
27688-66	013787	Mix. Screw	27822-63	012284	Jet (.043)
27688-71	015698	Mix. Screw	27823-66R	011482	Jet (.081)
27689-55	08793	Spring	27824-71	014348	Spring
27689-61	011103	Spring	27825-71	014118	Clip
27690-61	06569	Gasket	27826-71	014997	Nut
27691-55	09068	Spring	27827-71	014998	Screw
27691-59	0788	Spring	27828-71	014995	Clamp
27692-55	08875	Idle Tube	27829-71	014999	Bracket
27692-60	011127	Idle Tube	27830-71	013683	Gasket
27692-61	012320	Idle Tube	27831-71	011516	Screen
27693-55	09120	Needle & Seat	27832-71	014578	Check Valve
27693-59	011688	Needle & Seat	27833-71	014993	Jet (.089)
27693-61	012325	Needle & Seat	27833-74	016995	Jet (.0635)
27693-63	012339	Needle & Seat	27834-71	013853	Gland
27693-66	014053	Needle & Seat	27835-71	014247	Mixture Screw
27694-55	02510	Gasket	27836-71	010079	Lever
27695-66R	013854	Mix. Screw	27837-71	014647	Diaphragm
27696-63	010581	Screw	27838-71	014646	Gasket
27696-66	013269	Screw	27839-71	015219	Spring
27697-61	09112	Packing	27840-71	015218	Screen
27697-66R	013853	Gland	27841-71	015596	Needle & Seat
27698-61	0676	Gasket	27842-71	013406	Pinion Pin
27699-55	010347	Mix. Screw	27843-71	014239	Mixture Screw
27699-59	07972	Main Adj. Screw	27844-71	014637	Strainer Cover
27700-55	0705	Packing	27845-71	014644	Diaphragm
27700-61	0702	Gland	27846-71	014643	Gasket
27700-63	012822	Screw	27847-71	015455	Elbow Connector
27701-55	07282	Packing Nut	27848-71	015941	Diaphragm Cover
27701-61	0703	Packing Nut	27849-71	014120	Gasket
27702-55	09159	Nozzle	27850-71	015010	Shutter
27702-60	09070	Nozzle	27851-71	015052	Shaft
27703-55	06076	Gasket	27852-71	014988	Screw & Lockwasher
27704-61	01102	Plug Screw	27853-71	015384	Screw
27704-66	0675	Plug Screw	27854-71	014687	Screw & Lockwasher

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2)

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6) 14)

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7) 10)

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8) 11)

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12)

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