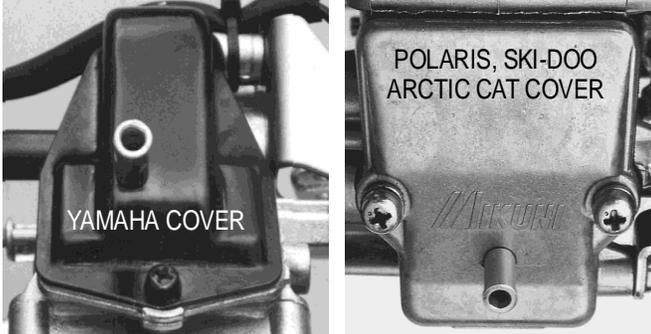


HOLTZMAN ENGINEERING, INC., VACUUM SOURCE INSTRUCTIONS (11/29/10)

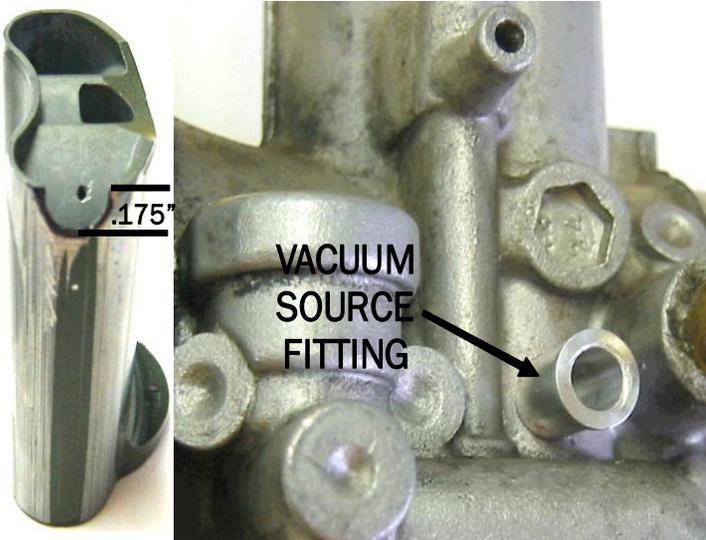
This vacuum source fitting is installed in **ONE carb only** as shown; **NO OTHER VACUUM SOURCES CAN BE USED.** Suitable adhesives are RED Loctite or epoxy. **In all cases, the vacuum source fitting must not interfere with slide movement. Loss of vehicle control and possible injury or death may result.**

MIKUNI TM FLATSLIDE (cover designs vary)



Remove **one** 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 source fitting's .27" diameter step against the 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). **Do not use for '01 and '02 Ski-Doo twins with flat slide carbs.**

MIKUNI TMX (SNOPRO carb)



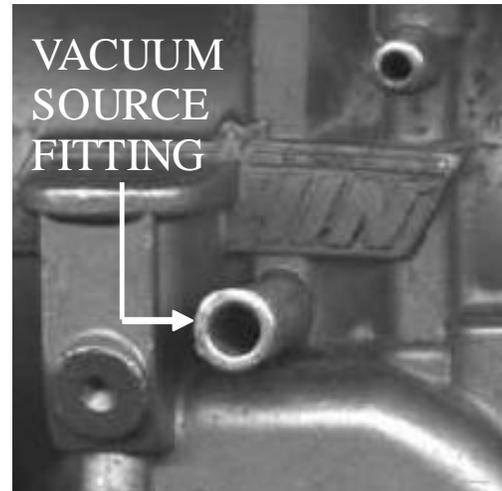
Using a drill press and vise, thru drill 15/64 (.234)" centered on slide and as low as possible so tube will clear float bowl. Shorten smallest diameter step of vacuum source fitting to .1" long, apply adhesive and press fitting firmly against carb. **Optional Slide Modification:** In line with and on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

MIKUNI VM ROUND SLIDE (No Picture)

Install the vacuum source fitting in **one** slide chamber cover similarly to TM flat slide shown at left, locating the fitting to avoid the slide spring and throttle cable. 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. The slide's off-center hole with milled slot for the throttle cable is normally sufficient. Drill/modify if necessary.

Arctic Cat with Magnet Block: Remove **one** slide and, with the magnet block still in the slide, drill a 5/32" vertical hole through the **block and slide** using the off-center hole in the block as a guide. Remove the block and, near the block's top, drill a 5/32" horizontal hole through the block's edge into the off-center hole. Grind a 1/8" deep x 3/4" long flat on the washer's edge.

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. Use a 1/8" ball end mill to widen the slide groove adjacent to the fitting approximately 1/8" horizontally toward the air box and 5/16" vertically above the fitting to the depth of the slide groove. **Verify free movement of the slide.**

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.