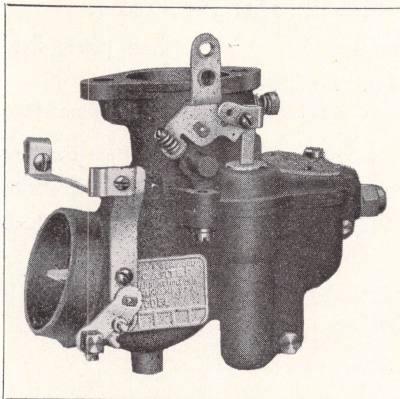


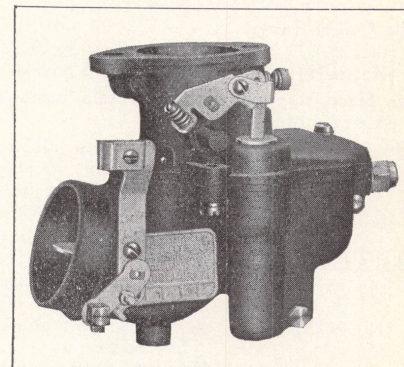
FEDERAL TRUCKS—1933 AND 1934



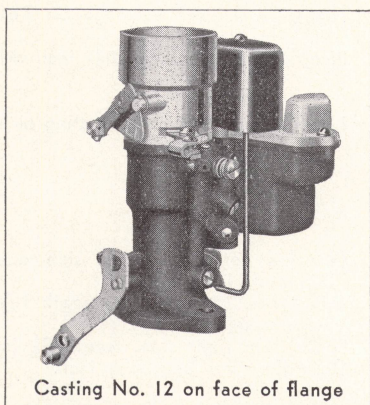
Federal Trucks—Models E3-E4-G5
BB Model Updraft Carburetor—No. 2575
(List Price \$12.00)

Federal Milk Truck—Model DM
BB Model Updraft Carburetor—No. 2625
(List Price \$12.00)

(This carburetor to be used in conjunction with Body Flange Assembly No. 1-79S. See Parts List, Page 3)



Federal Trucks—Models 15A-20A-25A
WI Model Downdraft Carburetor—No. 2765
(List Price \$12.00)



Casting No. 12 on face of flange

A \$2.00 exchange allowance is deducted from the list price if buyer turns in the carburetor which is replaced by a 2765.

MOTOR TUNE-UP

Be Accurate! Always Use Feeler Gauges!

CAUTION: Change worn or leaky flange gaskets. Tighten manifold bolts and test compression before adjusting carburetor.

<p>Federal Trucks Models E3-E4-G5 1933 — Carburetor No. 2575</p>	 Spark Plug Gap .025"	 Set Breaker Points .023"	<p>Use Timing Light</p> Breaker Points begin to separate with ignition mark on flywheel 1/2" Before T.D.C.—Spark fully advanced.	<p>Valve Clearance</p> With Motor Operating at Normal Temperature Set Valves Intake .006" Exhaust .008"	 Correct Float Level Flush with, to 1/32" below edge of casting. (Remove Gasket)	 Set Idle Adjustment Main Metering Screw 3/8 to 1 1/8 turns open. Part No. 159-15
<p>Federal Milk Truck Model DM Carb. No. 2625</p>	<p>.025"</p>	<p>.023"</p>	<p>Breaker Points begin to separate with ignition mark on flywheel 1/2" Before T.D.C.—Spark fully advanced.</p>	<p>Intake .006" Exhaust .008"</p>	<p>Flush with, to 1/32" below edge of casting. (Remove Gasket)</p>	<p>Set Idle Adjustment Main Metering Screw 3/4 to 1 1/2 turns open. Part No. 159-17</p>
<p>Federal Trucks Models 15A-20A-25A 1933-1934 — Carburetor No. 2765</p>	 Spark Plug Gap .025"	 Set Breaker Points .020"	<p>Use Timing Light</p> Retard Distributor 10° from center mark. Then set breaker points to open when D.C. mark on flywheel is on inspection hole. Then advance Distributor 10°	<p>Valve Clearance</p> With Motor Operating at Normal Temperature Set Valves Intake .008" Exhaust .010"	 Correct Float Level (Remove Cork Pump Gasket) 3/8 to 13/32 Inch	 Idle Adjustment Screw Setting Set Idle Adjustment-Screw 1/2 to 1 turn open Standard 75-67 62-45 1 Step Lean 75-88 65-46 2 Steps Lean 75-97 66-49 1 Step Rich 75-79 61-44 Part No. Marked

CARBURETER SPECIFICATIONS

Federal Truck—Carbureter No. 257S. Federal Milk Truck—Carbureter No. 262S.

(Note: Carbureter No. 262S to be used in conjunction with body flange assembly No. 1-79S. See parts list.)

Dimensions: Flange size, 1 $\frac{1}{4}$ inch S. A. E.
(Both models) Throttle bore, 1-7/16 inch I. D.

Float Setting: Top of float flush to 1/32 inch below top
(Both models) surface of lower body casting.

Vent: (To float chamber) Outside: No. 30 drill
(Both models) size.

Gasoline Intake Needle: Triangular, horizontal. No. 38 drill in
(Both models) needle seat.

Idle Orifice Tube: Jet size, .0256 to .0276 inch drill.
(No. 257S)
(No. 262S) Jet size, .0236 inch drill.

Air bleed through venturi, to idle passage .085 to .087 inch diameter drill.

Idle Ports: Lower port size: .062 to .064 inch diameter.
(Both models) Top of port located .005 to .009 inch below lower edge of valve.

(Both models) Upper port size: .053 to .057 inch diameter (for idle adjustment screw).

Idle Adjustment Screw: 1/4 to 1 turn open. For richer mixture turn
(No. 257S) screw out.

(No. 262S) 3/4 to 1 1/2 turns open. For richer mixture turn screw out.

(Do not idle engine below 300 rpm or 6 miles per hour idle speed).

Main Metering Screw: Calibrated to flow 222 CC per minute.
(No. 257S) Calibrated to flow 198 to 202 CC per
(No. 262S) minute.
(Do not gauge for size. If in doubt, replace with new part.)

Nozzle: No. 30 drill size.
(No. 257S)

Accelerating Jets

- 2—.0394 inch drill 1/16 inch from shoulder.
- 1—.051 inch drill 3/8 inch from shoulder.
- 1—.051 inch drill 23/32 inch from shoulder.
- 1—.051 inch drill 1-1/16 inch from shoulder.

(No. 262S) No. 33 drill size.

Accelerating Jets

- 2—.0394 inch drill 1/16 inch from shoulder.
- 1—.051 inch drill 3/8 inch from shoulder.

Accelerating Jets

- 1—.063 inch drill 23/32 inch from shoulder.
- 1—.051 inch drill 1-1/16 inch from shoulder.

Air Bleed to Nozzle: (Both models) Size: .0275 to .0295 inch drill.

Step-up Jet: (Power Orifice)
(No. 257S) .0236 inch drill size.
(No. 262S) .0256 inch drill size.

Main venturi, 1 inch I. D.

Accelerating Pump: Type, low pressure, delayed action.
(Both models) Stroke: Summer setting (inner hole, short stroke) 9/16 inch.
(Both models) Winter setting (outer hole, long stroke) 1 inch.

(Both models) Pump intake check valve, size 1/8 inch.
(No. 257S) Pump (discharge) metering screw: Jet size No. 52 drill.

(No. 262S) Pump (discharge) valve check: Retainer, jet size, No. 52 drill.

(No. 262S) Pump bleed back, size .067 inch drill.

Choker: Butterfly type with compensating air valve.
(Both models) Lever on left side.

Throttle Lever Dog: Adjustable. On left side.
(No. 262S)

Throttle Lever: (Viewing carbureter from side opposite air intake.)
(No. 257S) Adjustable. On left side, length 1 1/2 inch when open points up.
(No. 262S) Loose. On right side, length 3/4 inch. On right side, length 3/4 inch.

Tube Clamp: On air intake. Also under body attaching screw.
(No. 257S)
(No. 262S) On air intake.

Federal Truck—Carbureter No. 276S

Dimensions: Flange size, 1 $\frac{1}{4}$ inch S.A.E.
Primary venturi, 11/32 inch I. D.
Secondary venturi, 11/16 inch I. D.
Main venturi, 1-3/16 inch I. D.

Float Level: Distance from float (at free end) to float chamber cover to be 3/8 inch to 13/32 inch when needle is seated.

Outside Vent: No. 50 drill size. No inside vent.

Gasoline Intake: Square vertical needle. No. 38 drill size in needle seat.

Gasoline Line Connection: 5/16 inch.

Low Speed Jet Tube: Jet, No. 72 drill size.
By-pass in body, No. 55 drill size; Economizer in body, No. 48 drill size.

Idle Port: Dumb-bell type. Length, .185 inch. Width, .029 inch. Top, .052 inch diameter. Bottom, .046 inch diameter.

Idle Port Opening: .035 to .038 inch with valve closed tight.

Idle Adjustment Screw: Correct setting 1/2 to 1 turn open. For richer mixture turn screw in.
Do not attempt to idle engine below 360 rpm.

Main Nozzle: In primary venturi, angle 30°. Size, No. 40 drill.

Metering Rod: (Standard) Economy step, .062 inch diameter. Middle step, .060 inch diameter. Power step, .045 inch diameter. Length 3-25/64 inches.

Metering Rod Jet: .087 inch diameter.

Metering Rod Setting: Use Gauge, 2.795 inch. (Part No. T109-25.)

Accelerating Pump: Low Pressure type with adjustable stroke.
Discharge Jet: No. 72 drill size.
Intake ball check, No. 62 drill size.
Discharge ball check, No. 45 drill size.
Relief Disk check, No. 65 drill size.

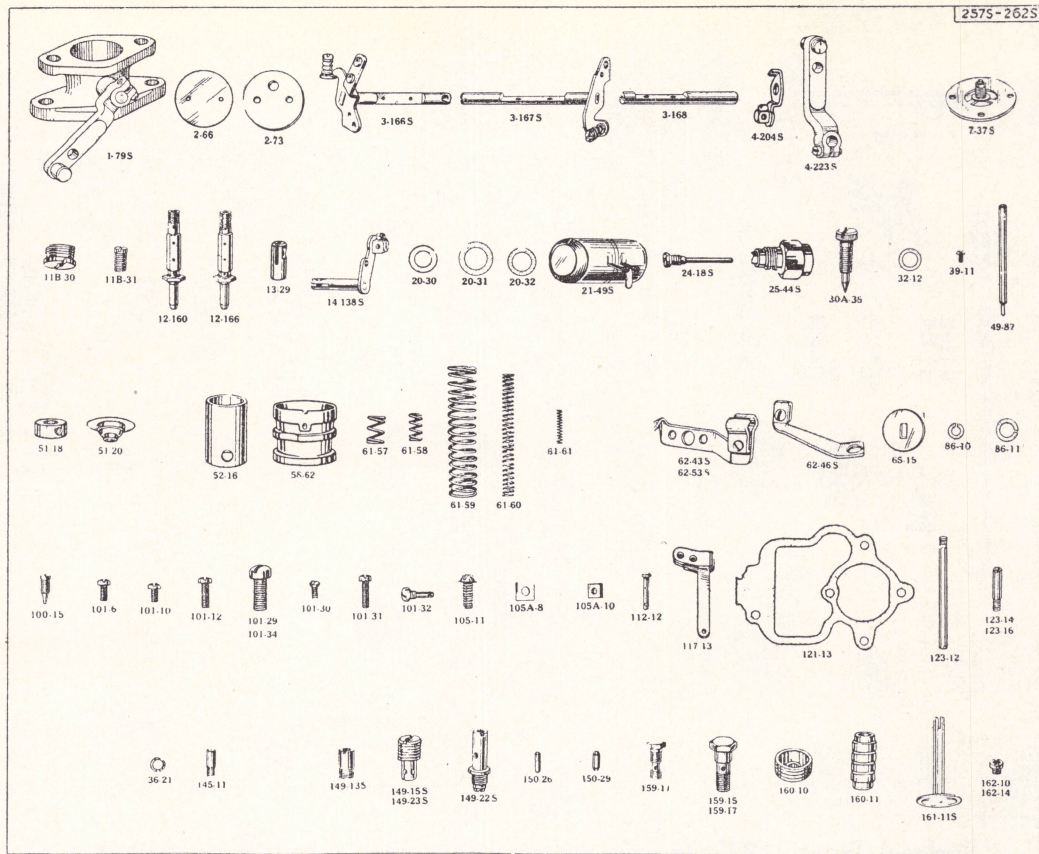
Throttle Lever: At left. Length, 1-3/16 inch. In center of travel points down.

Choker: In air horn; butterfly type with compensating air valve.

Choker Lever: At left. When open, points down.

Tube Support Bracket: At left on air horn.

Viewing carbureter from side opposite air intake



Federal Trucks, 1933—Carbureters Nos. 257S-262S—List Price \$12.00

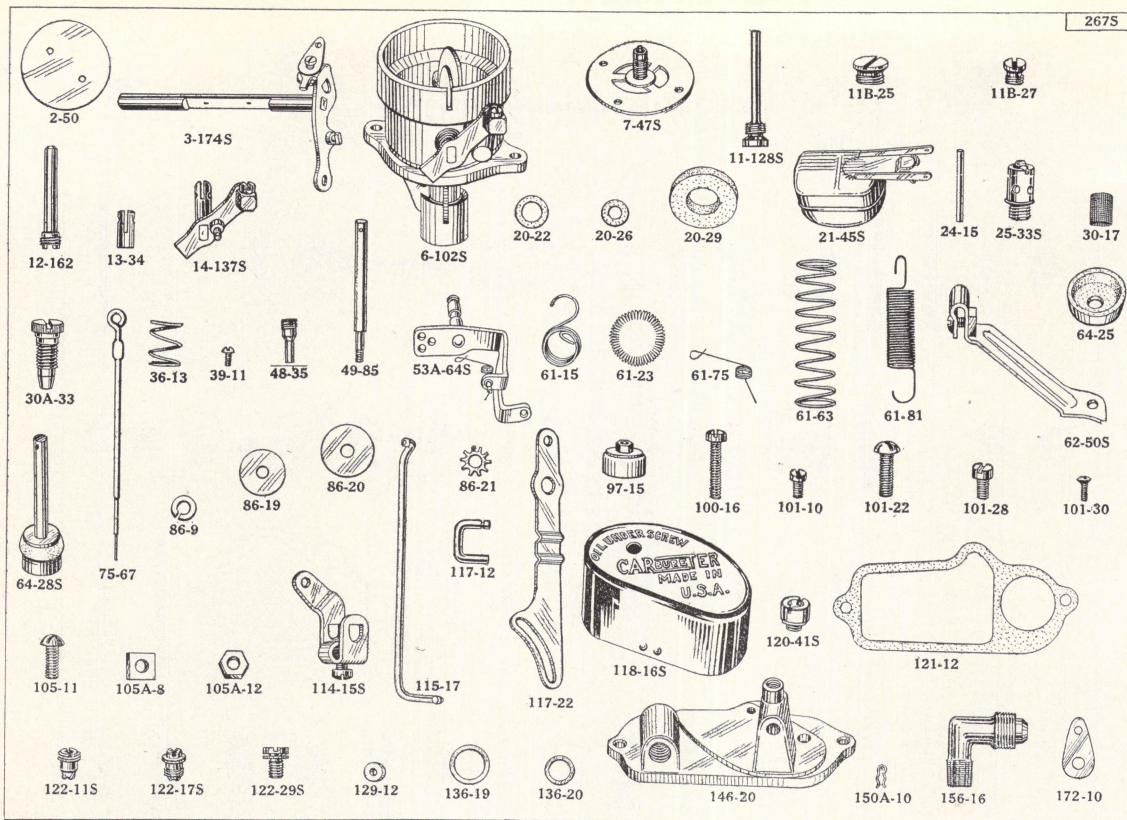
Part No.	PART NAME	List Price	Part No.	PART NAME	List Price
1-79S	*Body flange assembly.....	\$3.00	65-15	*Pump link cover plate.....	\$0.02
2-66	Throttle valve.....	.20	86-10	Lock washer.....	.01
2-73	*Throttle valve (Body flange assembly).....	.20	86-11	Lock washer.....	.01
3-166S	**Throttle shaft and lever assembly.....	.60	100-15	**Collar screw.....	.05
3-167S	*Throttle shaft (Body flange assembly).....	.30	101-6	Choke bracket attaching screw.....	.05
3-168	*Throttle shaft (Body flange assembly).....	.30	101-10	Wire clamp screw.....	.05
4-204S	**Throttle lever assembly (loose).....	.30	101-12	Clamp screw.....	.05
4-223S	*Throttle lever assembly (Body flange assembly).....	.60	101-29	Body attaching screw.....	.05
7-37S	Choker valve assembly.....	.50	101-30	Choke valve screw.....	.05
11B-12	Rivet plug.....	.02	101-31	Throttle lever adjusting screw.....	.05
11B-26	Rivet plug.....	.02	101-32	Pump link screw.....	.05
11B-30	Step-up piston plug.....	.10	101-34	*Throttle lever clamp screw.....	.05
11B-31	Idle hole plug.....	.10	105-11	**Tube clamp screw.....	.05
12-160	**Nozzle.....	.60	105A-8	**Tube clamp nut.....	.05
12-166	*Nozzle.....	.60	105A-10	Choke tube clamp nut.....	.05
13-29	Choker shaft (stub).....	.15	112-12	Choke air valve stem.....	.05
14-138S	Choker assembly with clamp and screw.....	.40	117-13	Pump link.....	.15
20-30	Nozzle gasket.....	.05	121-13	Body gasket.....	.10
20-31	Needle seat gasket.....	.05	123-12	Idle passage tube.....	.10
20-32	Metering screw gasket.....	.05	123-14	**Idle orifice tube.....	.20
21-49S	Float and lever assembly.....	.80	123-16	*Idle orifice tube.....	.20
24-18S	Float lever pin and plug assembly.....	.10	136-21	Plug washer.....	.01
25-44S	Needle and seat assembly.....	.80	145-11	Venturi tube.....	.05
30A-35	Idle adjustment screw.....	.30	149-11S	**Step-up valve assembly.....	.40
32-12	Pump rod gasket.....	.05	149-13S	**Check valve cage assembly.....	.30
39-11	Throttle valve screw.....	.05	149-15S	**Pump valve cage assembly.....	.30
49-87	Step-up push rod.....	.10	149-22S	*Step-up valve cage assembly.....	.40
51-18	**Throttle shaft collar.....	.15	149-23S	*Pump valve cage assembly.....	.30
51-20	Pump collar.....	.10	150-26	Pump collar pin.....	.02
52-16	Pump sleeve.....	.20	150-29	Venturi pin.....	.02
58-62	Venturi.....	.40	159-11	**Pump metering screw.....	.20
61-57	Idle adjustment screw spring.....	.05	159-15	**Main metering screw.....	.30
61-58	Throttle lever adjusting screw spring.....	.05	159-17	*Main metering screw.....	.30
61-59	Pump spring.....	.10	160-10	Pump piston.....	.40
61-60	Step-up piston spring.....	.05	160-11	Step-up piston.....	.20
61-61	Step-up spring.....	.05	161-11S	Pump rod plate and rod assembly.....	.30
62-43S	**Choke tube bracket assembly.....	.25	162-10	**Power orifice (Step-up jet).....	.10
62-46S	**Tube clamp assembly.....	.25	162-14	*Power orifice (Step-up jet).....	.10
62-53S	*Choke tube bracket assembly.....	.25			

*Used on carburetor No. 262S only.

**Used on carburetor No. 257S only.

List price of \$3.00 per 100 applies to parts listed at \$0.05 each.
List price of \$1.25 per 100 applies to parts listed at \$0.02 each.

List price of \$1.75 per 100 applies to parts listed at \$0.03 each.
List price of \$0.50 per 100 applies to parts listed at \$0.01 each.



Federal Truck, 1933-34—Carburetor No. 276S—List Price \$12.00

WHEN SERVICING, USE GASKET ASSORTMENT No. 105—List Price \$0.30

Part No.	PART NAME	List Price	Part No.	NAME PART	List Price
2-50	Throttle valve.....	\$0.10	75-79	Metering rod—one step rich (.061"-.059"-.044")30
3-186S	Throttle shaft and lever assembly.....	.60	75-88	Metering rod—one step lean (.065"-.063"-.046")30
6-108S	Air horn assembly.....	2.20	75-97	Metering rod—two steps lean (.066"-.064"-.049")30
7-47S	Choker valve assembly.....	.50	86-9	Lock washer.....	.01
11-128S	Low speed jet assembly.....	.30	86-19	Plunger washer (Inner).....	.03
11B-12	Rivet plug.....	.02	86-20	Plunger washer (Outer).....	.03
11B-25	Passage plug.....	.10	86-21	Lock washer.....	.01
11B-26	Rivet plug.....	.02	97-15	Plunger cup.....	.15
11B-27	Passage plug.....	.10	100-16	Throttle lever adjusting screw.....	.05
12-162	Nozzle.....	.30	101-10	Wire clamp screw.....	.05
13-34	Choker shaft stub.....	.15	101-22	Attaching screw.....	.05
14-144S	Choker assembly with clamp and screw.....	.40	101-28	Clamp screw.....	.05
20-22	*Needle seat gasket.....	.05	101-30	Choke valve screw.....	.05
20-26	*Metering rod jet gasket.....	.05	101-59	†Air horn and body attaching screw.....	.05
20-29	Pump cylinder bushing gasket—upper.....	.05	105-11	Tube clamp screw.....	.05
21-45S	Float and lever assembly.....	.80	105A-8	Tube clamp nut.....	.05
24-15	Float lever pin.....	.05	105A-12	Hex nut.....	.05
25-42S	Needle and seat assembly.....	.80	114-15S	Throttle shaft arm and screw assembly.....	.20
30-17	Strainer gauze.....	.10	115-17	Throttle connector rod.....	.15
30A-33	Idle adjustment screw.....	.30	117-12	Connector link.....	.05
36-13	Adjustment screw lock spring.....	.10	118-16S	Dust cover assembly.....	.50
39-11	Valve attaching screw.....	.2 for .05	120-41S	Metering rod jet assembly.....	.30
48-35	Pump jet.....	.15	121-12	Bowl cover gasket.....	.10
49-85	Plunger shaft.....	.20	122-11S	Discharge ball check assembly.....	.25
53A-64S	Pump arm, spring and countershaft assembly (Superseded by 53-89S).....	.40	122-17S	Intake ball check assembly.....	.25
53A-89S	Pump arm, spring and countershaft assembly.....	.50	122-29S	Check valve assembly.....	.25
61-15	Choker spring.....	.10	129-12	Metering rod disk.....	.02
61-23	Plunger spring.....	.10	136-19	Plug washer.....	.01
61-52	Pump spring.....	.10	136-20	Plug washer.....	.01
61-75	Metering rod spring.....	.10	146-20	Bowl cover.....	1.00
62-39S	Tube clamp assembly (Superseded by 62-79S).....	.20	150A-10	Pin spring.....	.01
62-79S	Tube clamp assembly.....	.20			
64-25	Plunger leather.....	.25			
64-28S	Plunger and rod assembly.....	.90			
75-67	Metering rod—Standard (.062"-.060"-.045").....	.30			

†This screw, with nut and lock washer, used only on production starting approximately June 1, 1934.

*Gaskets so marked must be soaked in 90 proof denatured alcohol for 15 minutes, installed on part, and let dry before using.

Metering rods are marked with step dimensions in thousandths, thus: rod part No. 75-67 (steps, .062"-.060"-.045"), marking "62-45." Rods should be ordered by part number.

List price of \$3.00 per 100 applies to parts listed at \$0.05 each.
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