

**THIS ENGINE IS EQUIPPED TO REDUCE EXHAUST EMISSIONS**  
 THE FOLLOWING ADJUSTMENTS ARE NECESSARY TO MAINTAIN THE EFFECTIVENESS OF THE SYSTEM  
 (With engine at operating temperature, choke open, air cleaner installed, air conditioning off)

1. Set mixture screw(s) for max. idle rpm and adjust speed screw to obtain **600 RPM IN DRIVE**.
2. Set ignition timing at **4° BTC** (plug vacuum advance line - this step only).
3. Adjust mixture screw in to obtain a 20 rpm drop (lean oil).
4. Adjust mixture screw out 1/4 turn.
5. Repeat steps 3 and 4 for second mixture screw (if so equipped).
6. Readjust speed screw if necessary to specified idk rpm.

See Service Manual for Additional Tune-up Instructions.

**B**

PART NO. 392738

1968 153 A/T, 327/275HP, 350/295HP, 396/325 & 350HP, 427/385HP Auto Trans Emissions Decal (Code B)

SPECIFICATIONS 13

**TUNE UP CHART**

ENGINE	Type	In Line								V8			
	Displacement	230	250	292	307	327		366	396	427			
	Horsepower	140	155	170	180	200	185	220	220	310	260		
COMPRESSION ①		130 psi				150 psi							
SPARK PLUG	Make & Number	Standard	AC-46N		AC-44N	AC-44S	AC-C43	AC-44	AC-C42N	AC-43N	AC-C42N		
		Cold	AC-44N		AC-C42N	AC-43S	AC-42-1	AC-42-1	AC-C42N				
Gap		.035"											
DIS-TRI-BU-TOR	Point Dwell	31°-34°				28°-32°							
	Point Gap	.016" (Used) .019" (New)											
	Arm Spring Tension	19-23 ounces											
	Condenser	.18-.23 microfarad											
Timing ②	Without A.I.R.	4°B.T.D.C.		4°B.T.D.C.	2°B.T.D.C.	8°B.T.D.C.	4°B.T.D.C.	6°B.T.D.C.	4°B.T.D.C.	6°B.T.D.C.			
		With A.I.R.	Syn.	0°B.T.D.C.	0°B.T.D.C.	0°B.T.D.C.	2°B.T.D.C.	X		0°B.T.D.C.	X		
		Auto.	4°B.T.D.C.	4°B.T.D.C.	4°B.T.D.C.	2°B.T.D.C.	X		4°B.T.D.C.	X			
DRIVE BELT	Fan and P/S	50 lb. Min. 75 ± 5 lbs. (Used) 125 ± 5 lbs. (New) Using Strand Tension Gauge											
	A/C and Air Comp.	65 lb. Min. 95 ± 5 lbs. (Used) 140 ± 5 lbs. (New) Using Strand Tension Gauge											
	Air Injection Pump	35 lb. Min. 55 ± 5 lbs. (Used) 75 ± 5 lbs. (New) Using Strand Tension Gauge											
AIR CLEANER		③											
VALVE LASH		Hydraulic - 1 turn down from zero lash											
IDLE rpm ④	Without A.I.R.	Syn.	500			700	700	500	700	500			
		Auto.	500			500	600*	500	600*	500			
	With A.I.R.	Syn.	700*			700	700*	X		700*	X		
		Auto.	500*	600*		500	600*	X		600*	X		
FUEL PUMP	Pressure in lbs.	3 to 4-1/2				5 to 6-1/2							
	Volume	1 pint in 30-45 seconds											
CRANKCASE VENTILATION		Service at 12,000 miles											

- ① At cranking speed, throttle wide open—Maximum variation, 20 lbs. between cylinders.
- ② At idle speed with vacuum advance line disconnected and plugged.
- ③ On Step Van vehicles, use number two cylinder and timing tab on bottom of cover.  
 PAPER ELEMENT—Service at 12,000 miles initially—Check every 6,000 miles thereafter, until replaced.  
 POLURETHANE BAND—Service every 12,000 miles.  
 OIL BATH—Change oil at regular engine oil change intervals.
- ④ AIR CONDITIONED VEHICLES—Set engine idle to specifications with air conditioning turned on and hot idle compensator held closed. Those indicated by \* Set engine idle to specifications with air conditioning turned "off".