

Worthington 3VC Torque Specifications

Location	Bolt Size	Torque	Location	Thread	Torque
		FT/LB			FT/LB
Capacity Control to Hand Hole Cover	1/4 x 1 1/8	10	Pump Cover Plate	5/16	10
Check Valves	1/4 NPT	8	Pump Housing to Crankcase	7/16	65
Connecting Rods	3/8 x 3 11/16	23	Seal Cover Plate	7/16 x 1 1/4	45
Cylinder Heads	1/2 x 4	65	Suction Shut-off Valve	5/8 x 5 1/2	130
Cylinder liner to Valve Plate	1/4 x 3/4	16	Suction Valve-Cylinder Liner Unloader to Crank Case	5/8 x 2	35
Discharge Valve Seat	1/8 x 15/16	50			
Discharge Shut-Off Valve To Crankcase	5/8 x 4 1/4	130	Misc:		
Electrical Terminals (Large)	7/16	30 – 40	Pipe Plug to Pump Housing		20
Electrical Terminals (Small)	#10	3 – 5	Pipe Plug to End Cover		20
End Cover	9/16 x 2 1/4	100	Pipe Plug Drain	3/4	40
Hand Hole Cover	1/2 x 1 1/2	60	Pipe Plug to Crankcase		70
Manifold Block to Capacity Control	1/4 x 1	10	Coupling To Crankcase		15