

Worthington 3V Compressor Bolt Torques

USAGE	THREAD	TORQUE
Adapter to crankcase	9/16-12 UNC	100-105
Ball check valve	1/4-18 NPTF	7-9
Brass Schrader valve	1/8-27 NPT	10-12.5
Brass Schrader valve	1/4-20 NPT	18-20.8
Connecting rod (3V)	3/8-24 UNF	22-24
Connecting rod (3VX)	3/8-24 UNF	19-21
Cylinder assembly to crankcase	3/8-16 UNC	33-37
Cylinder head to crankcase	1/2-13 UNC	65-70
Cylinder liner to valve plate	1/4-28 UNF	14-16
Discharge shutoff valve	5/8-11 UNC	120-130
Discharge valve seat	1/2-20 UNF	50-55
End cover to crankcase	9/16-12 UNC	100-105
Hand hole cover to crankcase	1/2-13 UNC	65-70
Manifold to unloader harness	1/4-20 UNC	10-12
Pump cover plate	5/16-18 UNF	10-12
Pump housing to crankcase	1/2-13 UNC	65-70
Rotor locking screw	3/4-16 UNF	150-160
Seal cover plate	7/16-14 UNC	42-47
Sensing device to hand hole cover	1/4-20 UNC	10-12
Sight glass to hand hole cover	1/4-20 UNC	10-12
Solenoid to hand hole cover	5/16-18 UNC	10-12
Stator locking pin	3/4-16 UNF	snug
Suction filter to end cover	3/8-16 UNC	23-28
Suction shut off valve	5/8-11 UNC	120-130
Terminal box to plate	10-32 UNF	3-4
Terminal plate to adapter	7/16-14 UNC	42-47
Terminal stud to plate	7/16-14 UNC	3-4
Terminal stud to ring terminals	7/16-14 UNC	18-24

Threads are per inch. NPT = National Pipe Thread. Torque = FT-LBS.

UNC = Unified National Coarse. UNF =
Unified National Fine.

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Compressor Reference 2004