

TORQUE SPECS ON PUMPS IN-LBS

USAir

Torque on	Blower Wheel	100-125 80-2hp
"	" Intake Baffle Back	80
"	" Shroud Bolts	80
"	" Head Bolts	125
"	" Cylinder Bolts	125
"	" Tube Fitting Bolts	80
"	" Bearing Cap Bolts	120
"	" Counter Balance	200*
"	" Rotor Bolts	150
Run Out on Rotor		Max. .035"

	VS	VT	VT-3
Head Plate Bolts	97+7	97+7	97+7
Head Bolts	120-150	120-150	120-150
Connecting Rod Bolts	100-130	100-130	100-130
Bearing Cap Bolts	55	55	55