Part Number: 1024T500

WALLENSTEIN

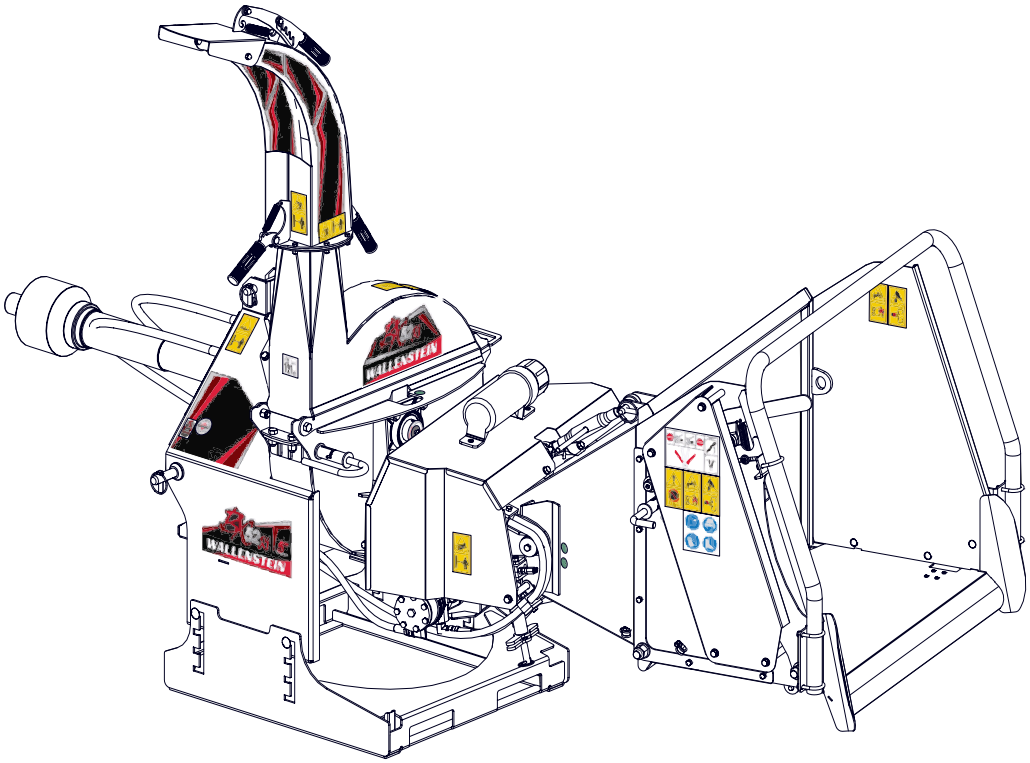
EMB Manufacturing Inc.
4144 Boomer Line · St. Clements, Ontario · N0B 2M0 · Canada
www.wallensteinequipment.com

PARTS MANUAL

BX52R and BX52RI

3PH Roller Feed Chipper

Serial Number 152R559 & up



CE

Revision B1 Apr-2018

Foreword

EMB Manufacturing has prepared this parts manual to assist customers in ordering quality OEM replacement parts.

Regular maintenance, and replacing old, worn or broken parts with the correct OEM parts, is essential in prolonging the life of your EMB product. Please refer to this manual to identify replacement parts.

To order parts, contact your Wallenstein dealer or distributor. Have the product model and serial number handy.

If your dealer is no longer available, please go to our website: http://www.wallensteinequipment.com and click on the Dealer Locator to find the nearest dealer.

All information contained in this parts manual is current as per the revision date at the bottom of the page. EMB reserves the right to change product specifications at any time without notice.

If your product specifications differ from those contained in this manual, contact EMB Manufacturing for information.

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⚠ WARNING!

Refer to the operators manual for safe operation and maintenance.

Maintenance should be performed by trained personnel only.

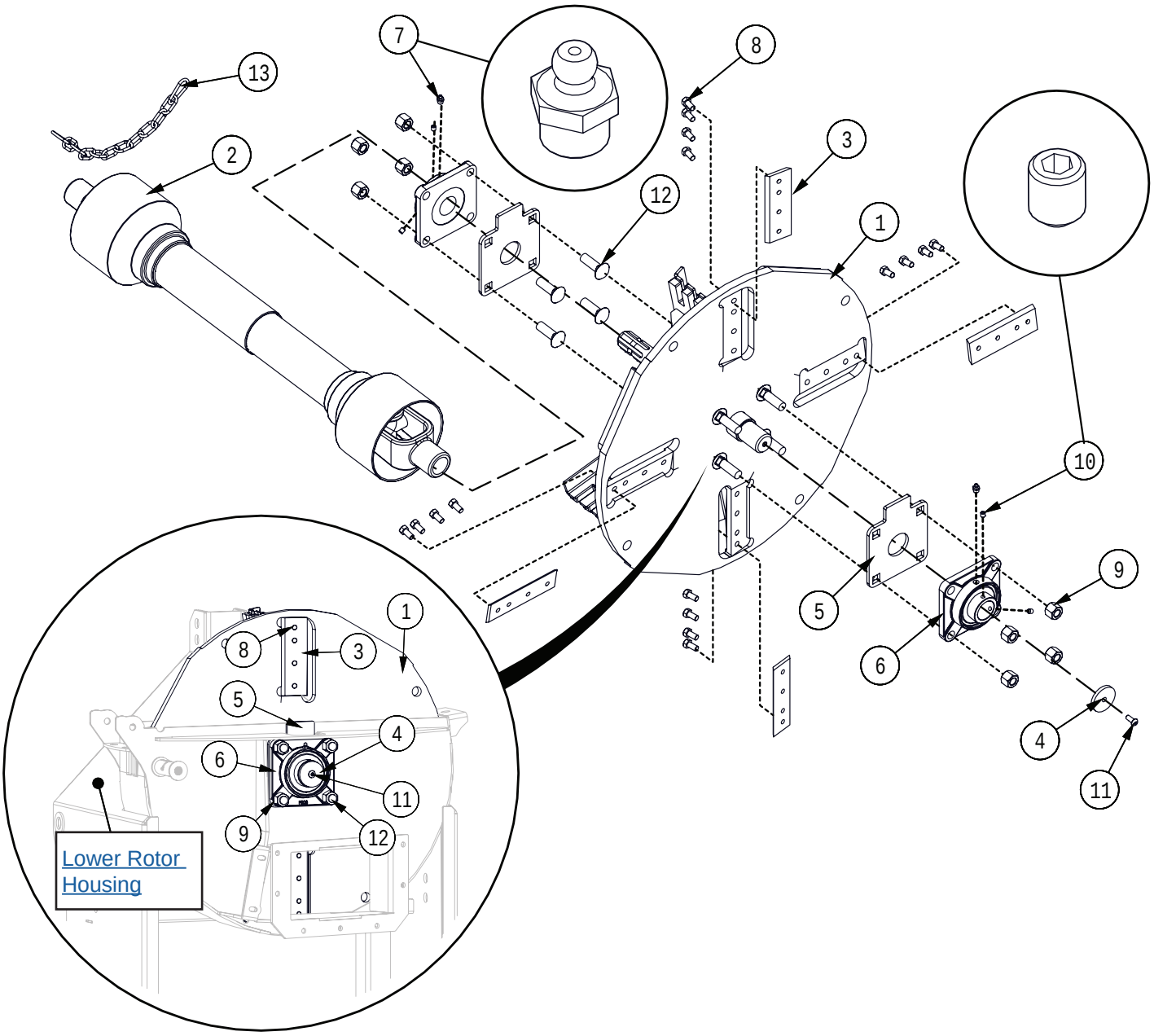
BX52 Variation Chart

BX Option Cross Referance			Option			
			Self Feed	Roller Feed	Intellifeed	Revision Level
Model	BX52SEU	BX52S	x			#
	BX52REU	BX52R		x		#
	BX52RIEU	BX52RI		x	x	#

Contents

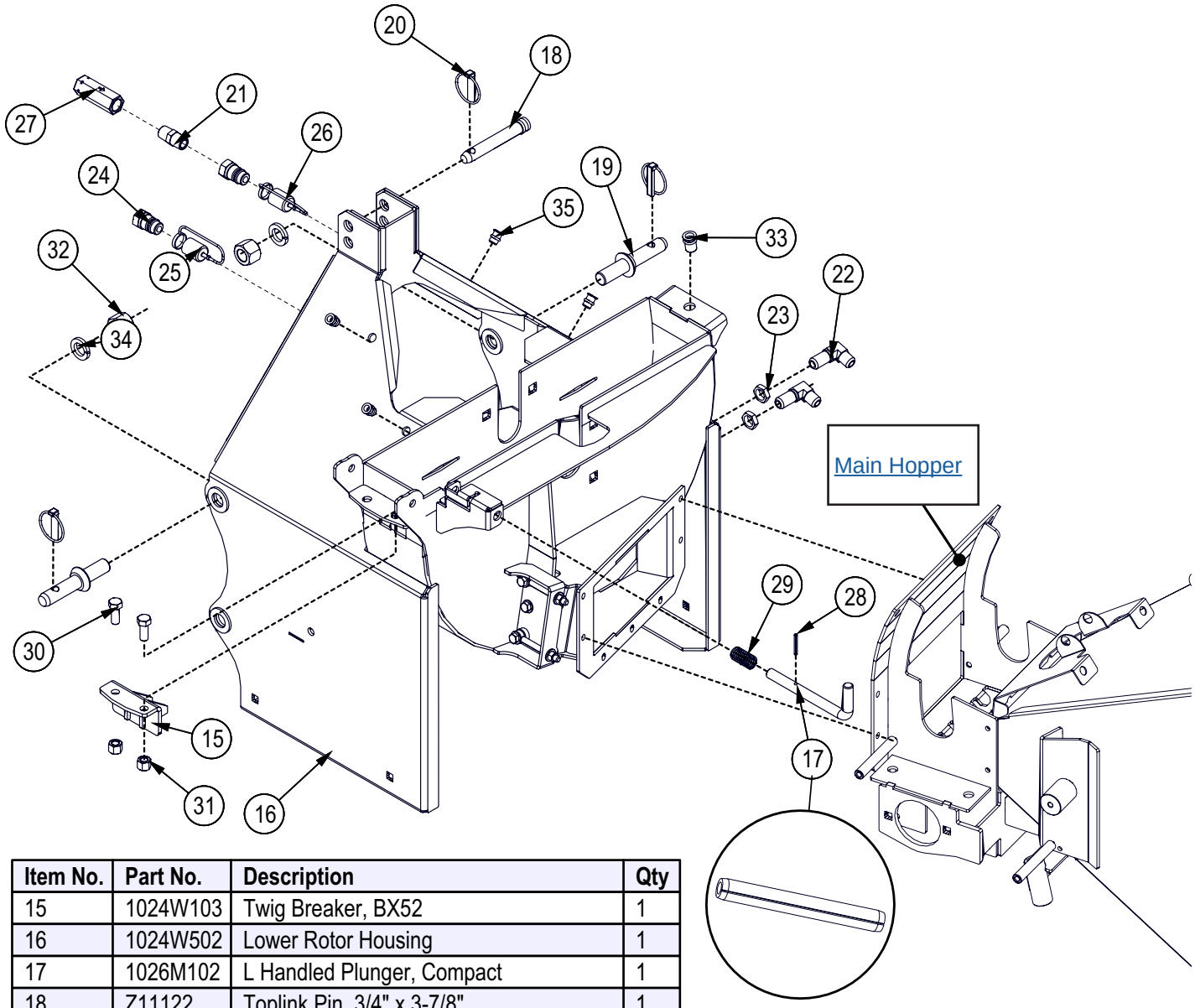
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Rotor Assembly



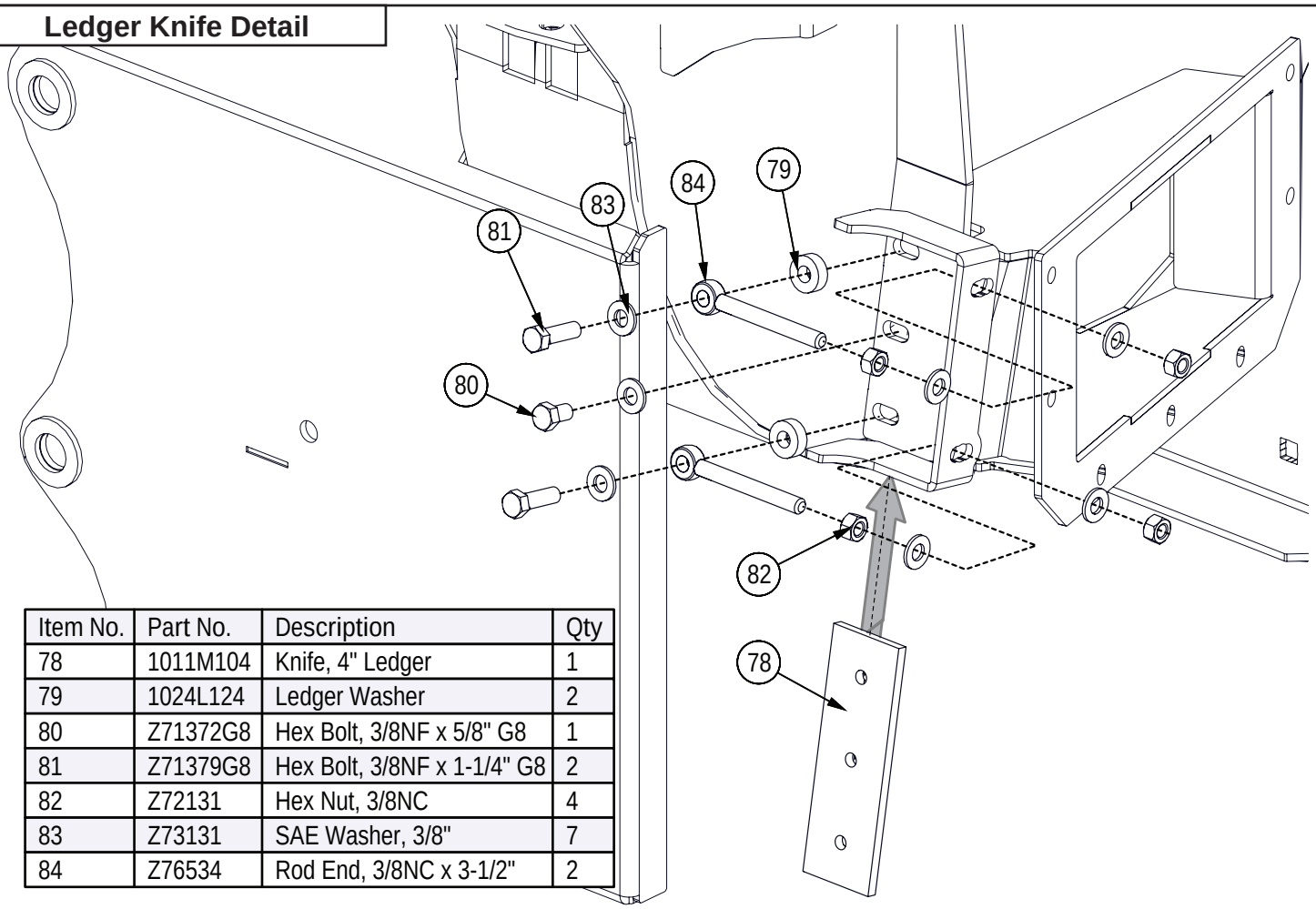
Item No.	Part No.	Description	Qty
1	1024W501	Roller Feed Rotor, 5" Capacity	1
2	Z44504	#5 Global PTO Shaft M10 Shear	1
3	1011M103	Knife, 4" Rotor	4
4	1021S102	Rotation Indicator Cover	1
5	1024L107	Bearing Plate, BX52	2
6	Z25204	4-Bolt Flange Bearing, 1-1/2" Bore	2
7	Z29201	Grease Fitting, 1/8NPT	2
8	Z71373G8	Hex Bolt, 3/8NF x 3/4 G8	16
9	Z72261G8	Hex Lock Nut, 5/8NC G8	8
10	Z74122	Set Screw, 5/16NF x 3/8"	4
11	Z75351	BHCS, 5/16NF x 3/4"	1
12	Z76261G8	Carriage Bolt, 5/8NC x 2" G8	8
13	Z92310	Chain 3/16" x 12" double hook ends	1

Lower Rotor Housing



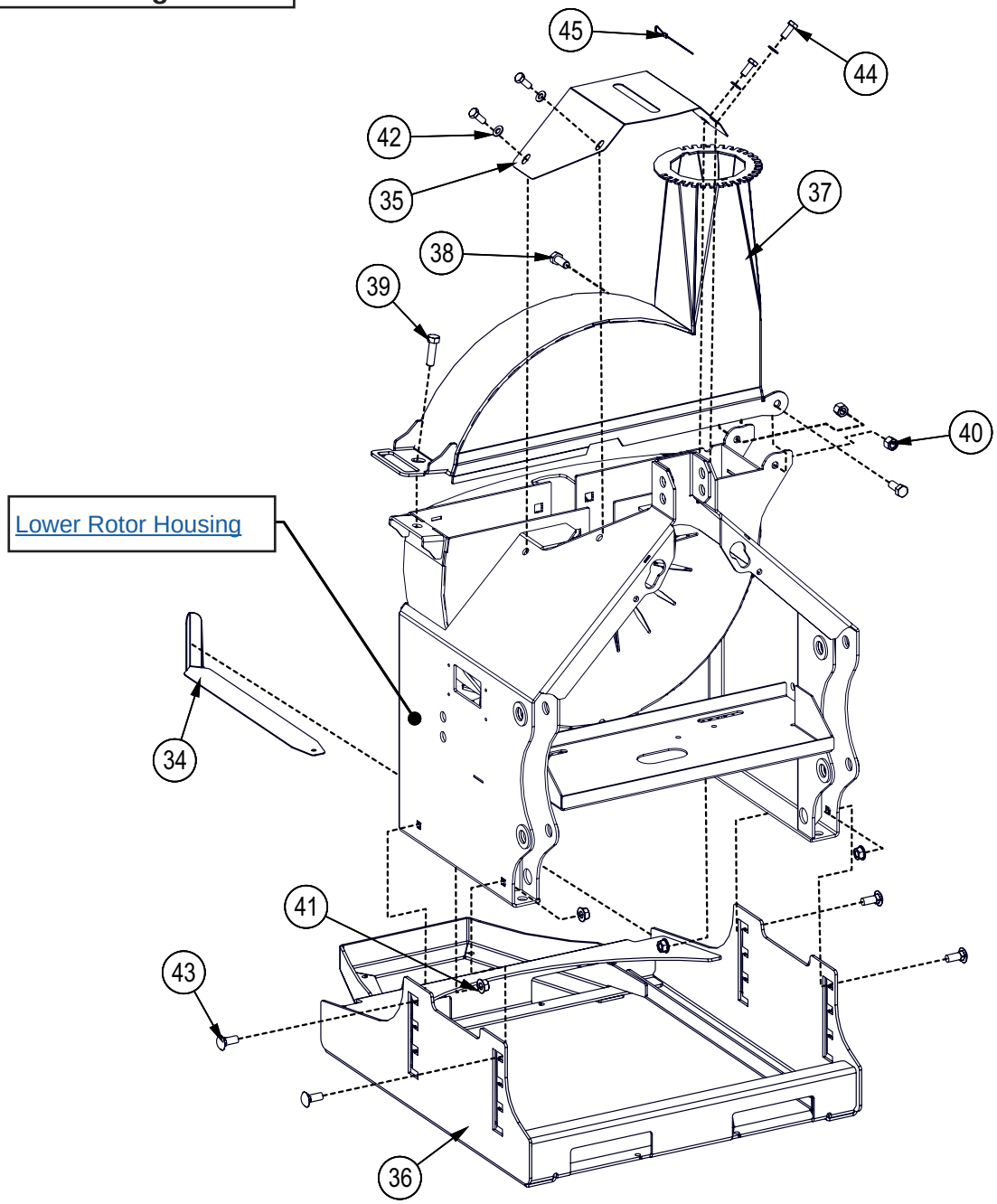
Item No.	Part No.	Description	Qty
15	1024W103	Twig Breaker, BX52	1
16	1024W502	Lower Rotor Housing	1
17	1026M102	L Handled Plunger, Compact	1
18	Z11122	Toplink Pin, 3/4" x 3-7/8"	1
19	Z11431	Implement Pin, 7/8" x 1-3/4" x 7/8NF	2
20	Z12140	Lynch Pin, 7/16"	3
21	Z51122	Straight, MP x MP 0808	1
22	Z51492	Elbow 90, MJIC x BH 0808	2
23	Z51493	BH Locknut, 08	2
24	Z51926	Quick Coupler, FP08 x M ISO 7241-1	2
25	Z52831	Nipple Cap, ISO 7241-1 x Red	1
26	Z52832	Nipple Cap, ISO 7241-1 x Black	1
27	Z56102	Check Valve, FP08 x 0PSI	1
28	Z14151	Roll Pin, 3/16" x 1-1/2"	1
29	Z32305	Comp Spring, 0.845" OD x 3-1/2" x 0.085"	1
30	Z71512	Hex Bolt, 1/2NC x 1-1/4"	2
31	Z72251	Hex Lock Nut, 1/2NC	2
32	Z72282	Hex Lock Nut, 7/8NF	2
33	Z72960	Rivet Nut, 1/2NC x 200	1
34	Z73381	Split Lock Washer, 7/8"	2
35	Z77940	Rivet Nut, M10x1.5 x 313	4

Ledger Knife Detail



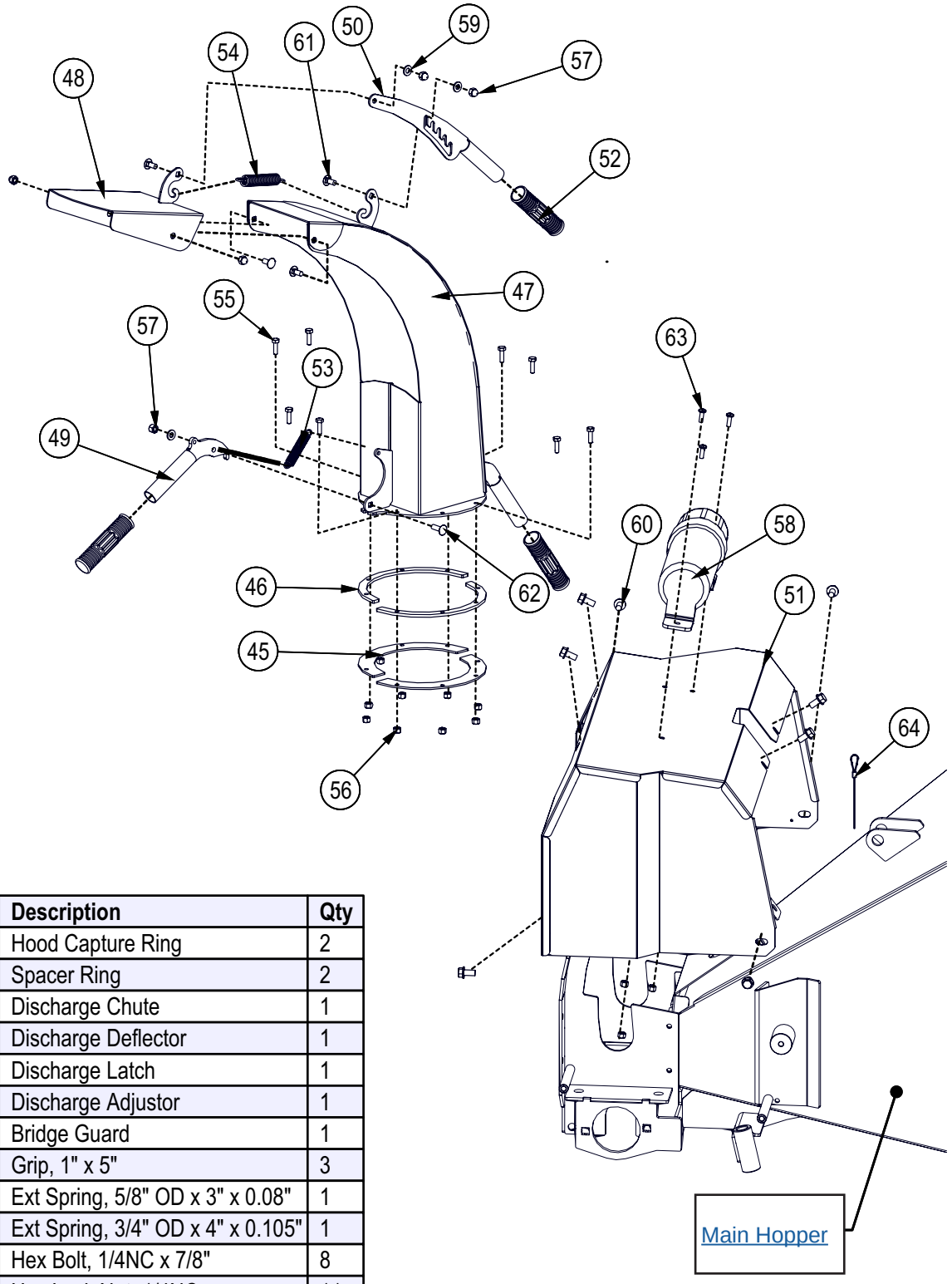
Item No.	Part No.	Description	Qty
78	1011M104	Knife, 4" Ledger	1
79	1024L124	Ledger Washer	2
80	Z71372G8	Hex Bolt, 3/8NF x 5/8" G8	1
81	Z71379G8	Hex Bolt, 3/8NF x 1-1/4" G8	2
82	Z72131	Hex Nut, 3/8NC	4
83	Z73131	SAE Washer, 3/8"	7
84	Z76534	Rod End, 3/8NC x 3-1/2"	2

Upper Rotor Housing



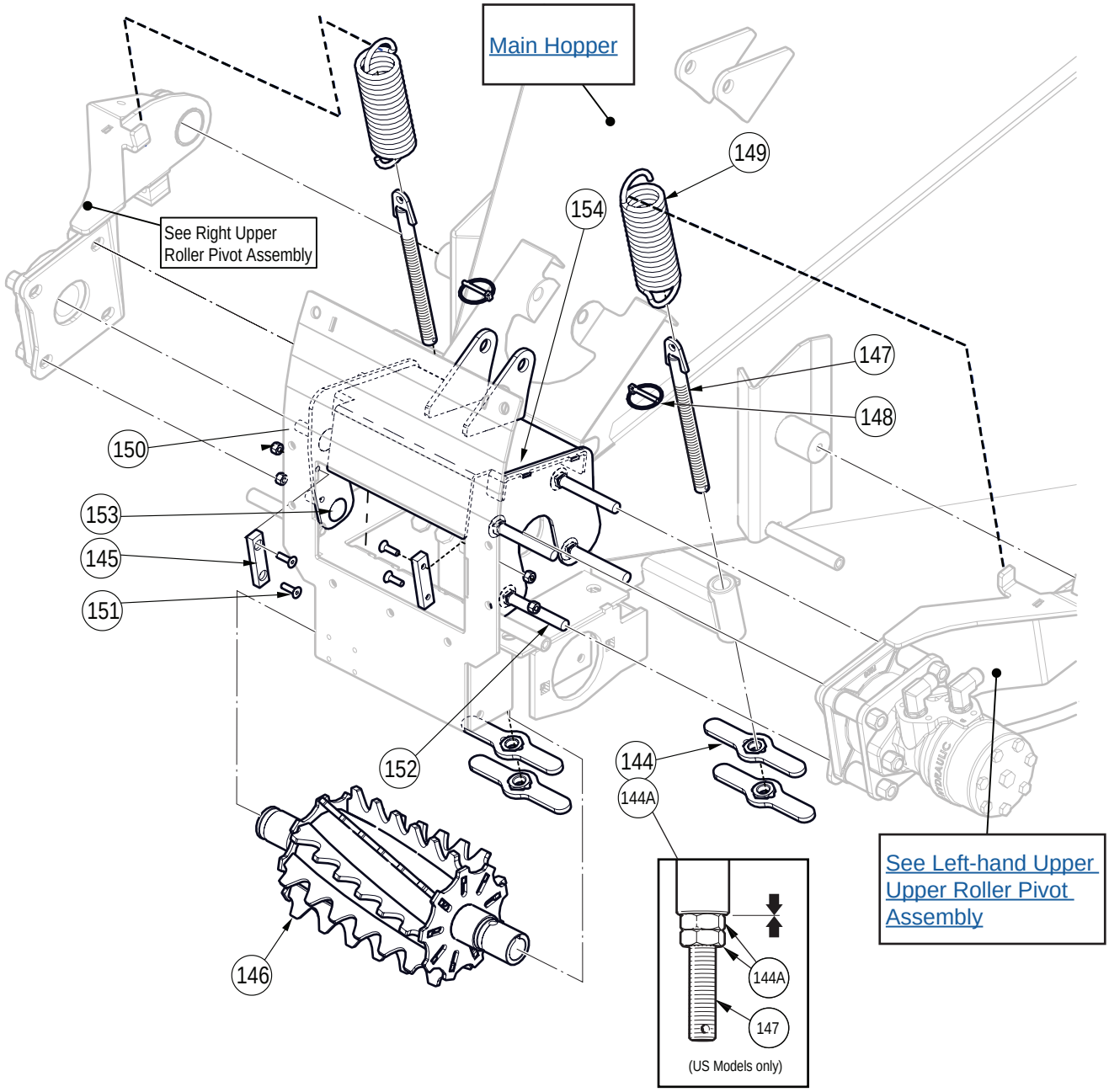
Item No.	Part No.	Description	Qty
34	1024L161	Gauge, Ledger Setting	1
35	1024L554	PTO Guard	1
36	1024W709	BX52R Extended Base	1
37	1024W104	Upper Rotor Housing	1
38	Z71512	Hex Bolt, 1/2NC x 1-1/4"	2
39	Z76155	Flange Bolt, 1/2NC x 1-3/4"	1
40	Z72251	Hex Lock Nut, 1/2NC	2
41	Z72551	Serrated Flange Locknut, 1/2NC	4
42	Z73131	SAE Washer, 3/8"	4
43	Z76259	Carriage Bolt, 1/2NC x 1-1/4"	4
44	Z77162	Hex Bolt, M10x1.5 x 25mm	4
45	Z92127	1/16 Aircraft cable x 16"	1

Discharge Chute



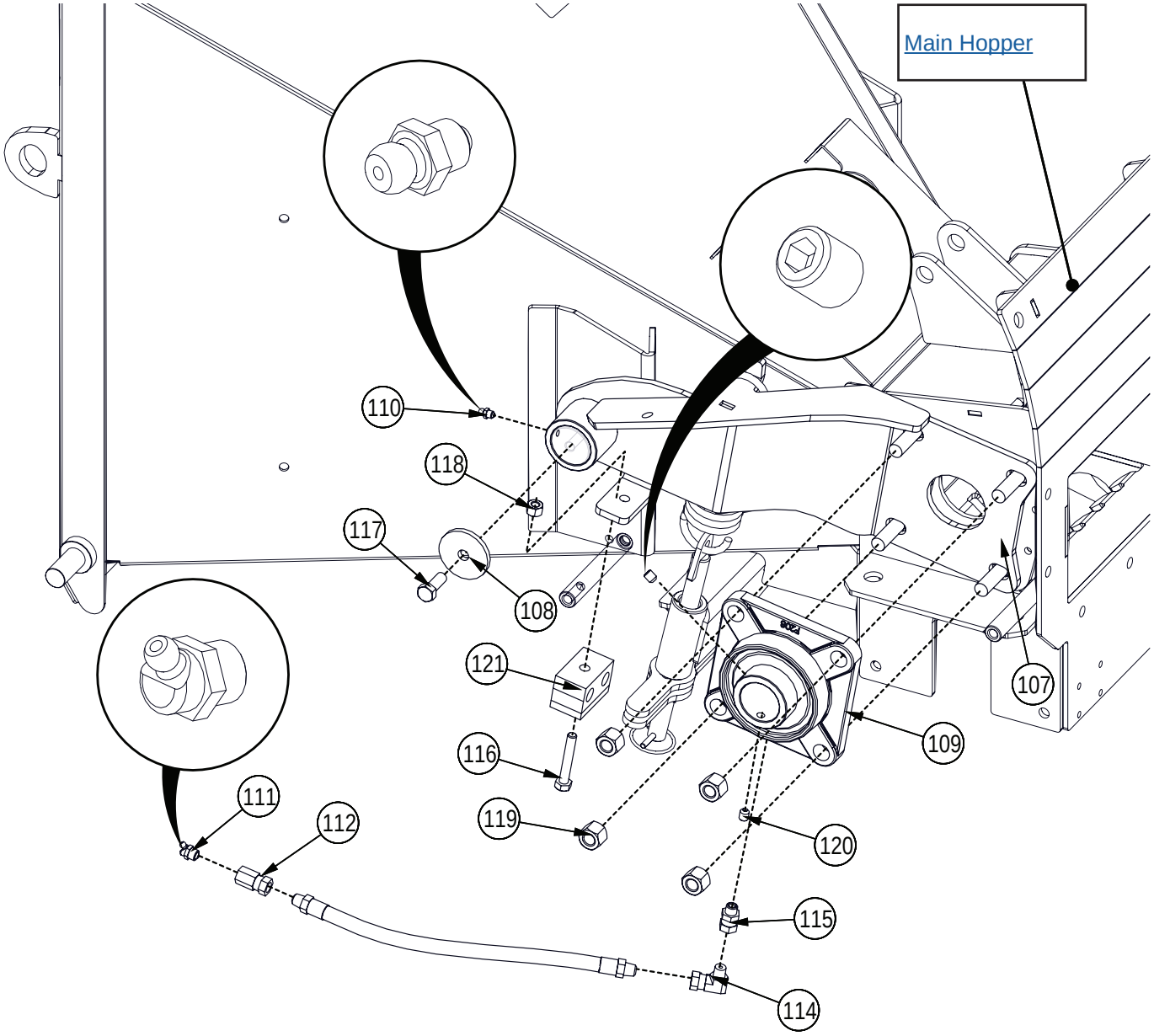
Item No.	Part No.	Description	Qty
45	1024L133	Hood Capture Ring	2
46	1024L134	Spacer Ring	2
47	1024W106	Discharge Chute	1
48	1024W107	Discharge Deflector	1
49	1024W108	Discharge Latch	1
50	1024W109	Discharge Adjustor	1
51	1024W621	Bridge Guard	1
52	Z19321	Grip, 1" x 5"	3
53	Z31305	Ext Spring, 5/8" OD x 3" x 0.08"	1
54	Z31401	Ext Spring, 3/4" OD x 4" x 0.105"	1
55	Z71108	Hex Bolt, 1/4NC x 7/8"	8
56	Z72211	Hex Lock Nut, 1/4NC	11
57	Z72221	Hex Lock Nut, 5/16NC	5
58	Z96503	Manual Tube 3-1/2 Short	1
59	Z73122	SAE Washer, 5/16"	3
60	Z76133	Flange Bolt, 3/8NC x 3/4"	8
61	Z76221	Carriage Bolt, 5/16NC x 3/4"	4
62	Z76225	Carriage Bolt, 5/16NC x 1"	1
63	Z78301	Machine Screw, 1/4NC x 3/4"	3
64	Z92110	1/16 Aircraft cable x 2'	1

Upper Roller Detail



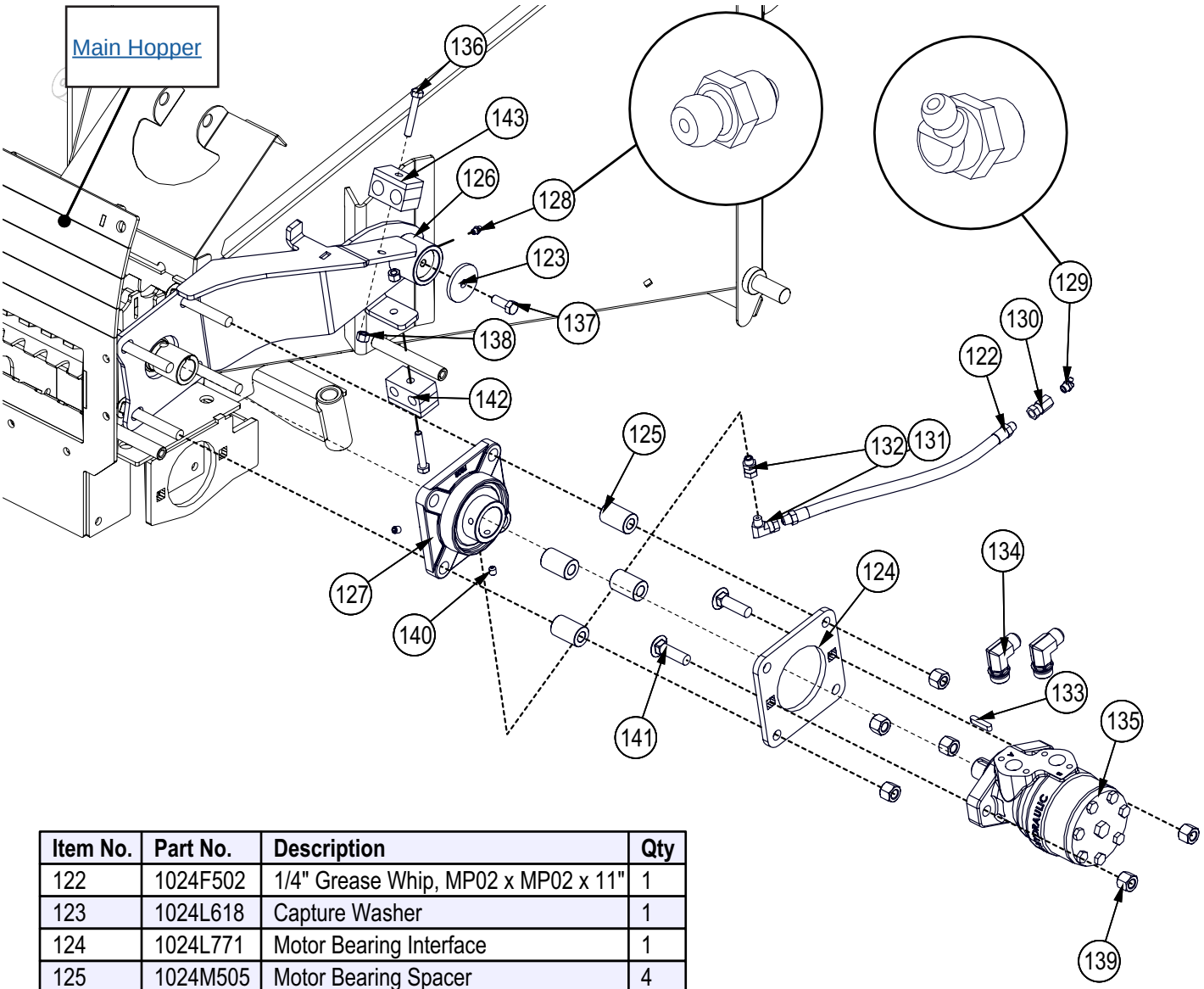
Item No.	Part No.	Description	Qty
144	1022W220	Nut Handle	4
144A	Z72361	Jam Nut, 5/8NC (US Models only)	4
145	1024S707	Rotor Hood Slide	2
146	1024W710	Upper Feed Roller, Spiral Overlap	1
147	1024W708	Spring Yoke	2
148	Z12110	Lynch Pin, 3/16"	2
149	Z31501	Ext Spring, 2" OD x 7" x 0.250"	2
150	Z72211	Hex Lock Nut, 1/4NC	4
151	Z75211	FHCS, 1/4NC x 7/8"	4
152	Z762510	Carriage Bolt, 1/2NC x 3-1/2"	4
153	Z76258	Carriage Bolt, 1/2NC x 1-3/4"	4
154	1024W618	Bridge	1

Right Upper Roller Pivot Assembly



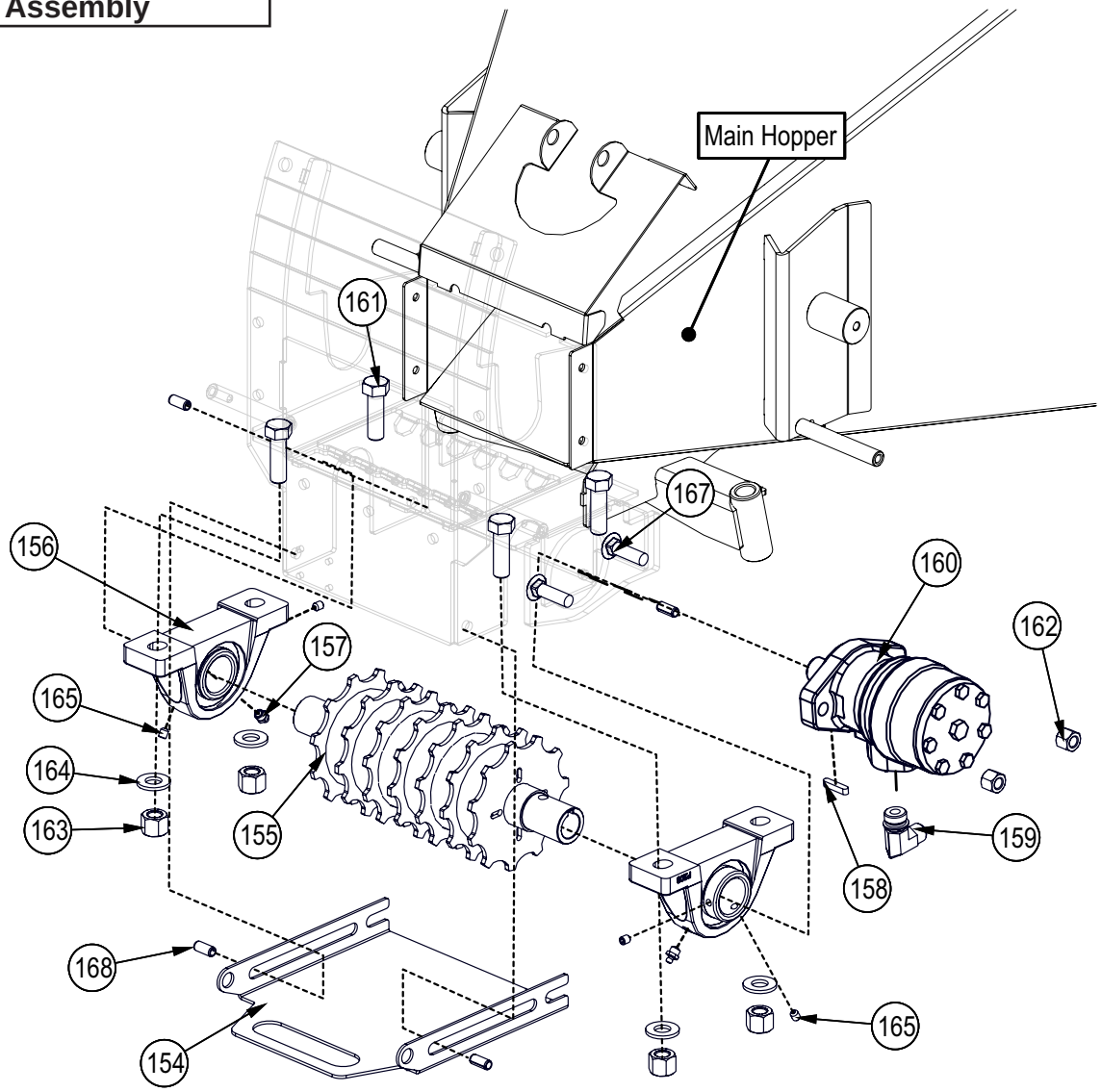
Item No.	Part No.	Description	Qty
107	1024W602H	Roller Pivot Arm RH	1
108	1024L618	Capture Washer	1
109	Z25204	4-Bolt Flange Bearing, UCF208-24	1
110	Z29202	Grease Fitting, 1/4NF	1
111	Z29204	Elbow 45 Grease Fitting, MP02	1
112	Z29302	Grease Fitting, FP x FPX 0202	1
114	Z29307	Elbow 90 Grease Fitting, MP x FPX 0202	1
115	Z29311	Grease Fitting, MP x FPX 0202	1
116	Z71220	Hex Bolt, 5/16NC x 2"	1
117	Z71310	Hex Bolt, 3/8NC x 1"	1
118	Z72221	Hex Lock Nut, 5/16NC	1
119	Z72251	Hex Lock Nut, 1/2NC	4
120	Z74122	Set Screw, 5/16NF x 3/8"	2
121	Z79462	Double Hose Clamp, 1/2" OD	1

Left Upper Roller Pivot Assembly



Item No.	Part No.	Description	Qty
122	1024F502	1/4" Grease Whip, MP02 x MP02 x 11"	1
123	1024L618	Capture Washer	1
124	1024L771	Motor Bearing Interface	1
125	1024M505	Motor Bearing Spacer	4
126	1024W602	Roller Pivot Arm LH	1
127	Z25204	4-Bolt Flange Bearing, 1-1/2" Bore	1
128	Z29202	Grease Zerk 1/4NF	1
129	Z29204	Grease Fitting, 1/8NPT x 45	1
130	Z29302	Straight, FP x FPX 0202	1
131	Z29307	Elbow 90 MP x FPX 0202	1
132	Z29311	Straight, MP x FPX 0202	1
133	Z46594	Blind Chipper Key 1/4 x 1-1/4	1
134	Z51658	Elbow 90, MJIC x MORB 0810	2
135	Z54102	Hydraulic Motor, 200CCR	1
136	Z71220	Hex Bolt, 5/16NC x 2"	2
137	Z71310	Hex Bolt, 3/8NC x 1"	1
138	Z72221	Hex Lock Nut, 5/16NC	2
139	Z72251	Hex Lock Nut, 1/2NC	6
140	Z74122	Set Screw, 5/16NF x 3/8"	2
141	Z76258	Carriage Bolt, 1/2NC x 1-3/4"	2
142	Z79462	Double Hose Clamp, 1/2" OD	1
143	Z79463	Double Hose Clamp, 11/16" OD	1

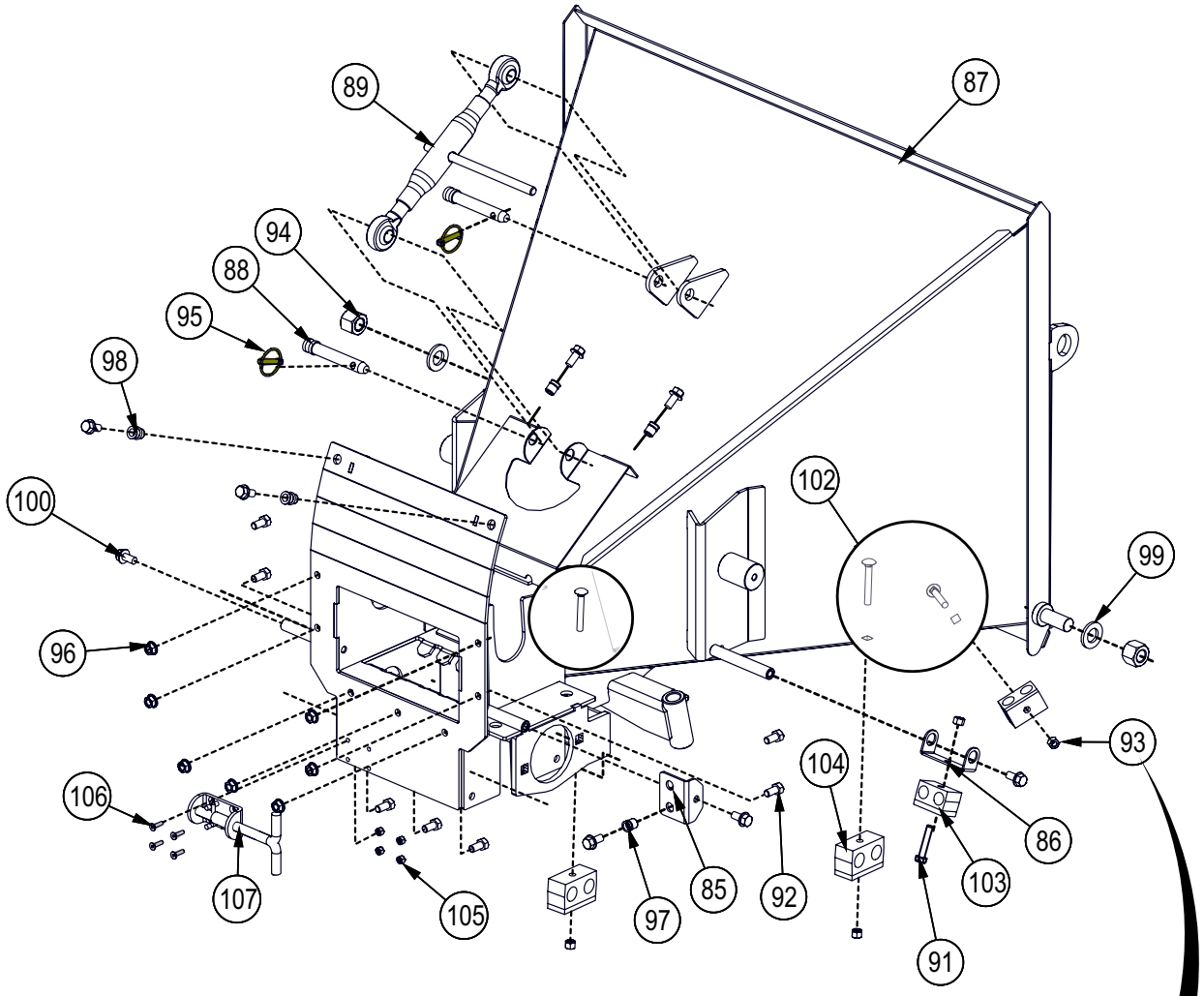
Lower Roller Assembly



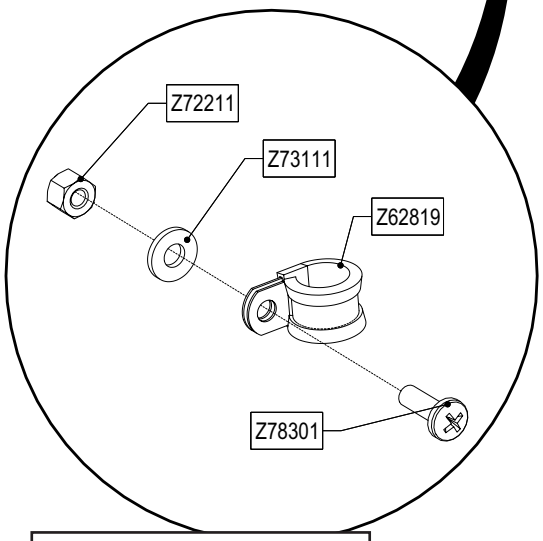
Item No.	Part No.	Description	Qty
154	1024L774	Lower Roller Guard	1
155	1024W605	Lower Feed Roll	1
156	Z24101	P208 Pillow Block 1-1/2	2
157	Z29201	Grease Fitting, 1/8NPT	2
158	Z46594	Blind Chipper Key 1/4 x 1-1/4	1
159	Z51658	Elbow 90, MJIC x MORB 0810	2
160	Z54102	Hydraulic Motor, 200CCR	1
161	Z71620	Hex Bolt, 5/8NC x 2"	4
162	Z72251	Hex Lock Nut, 1/2NC	2
163	Z72261	Hex Lock Nut, 5/8NC	4
164	Z73161	SAE Washer, 5/8"	4
165	Z74122	Set Screw, 5/16NF x 3/8"	4
167	Z76258	Carriage Bolt, 1/2NC x 1-3/4"	2
168	Z14301	Roll Pin, 10mm x 22mm	4

* Seal Kit SKMLHP–U/DE

Main Hopper Assembly



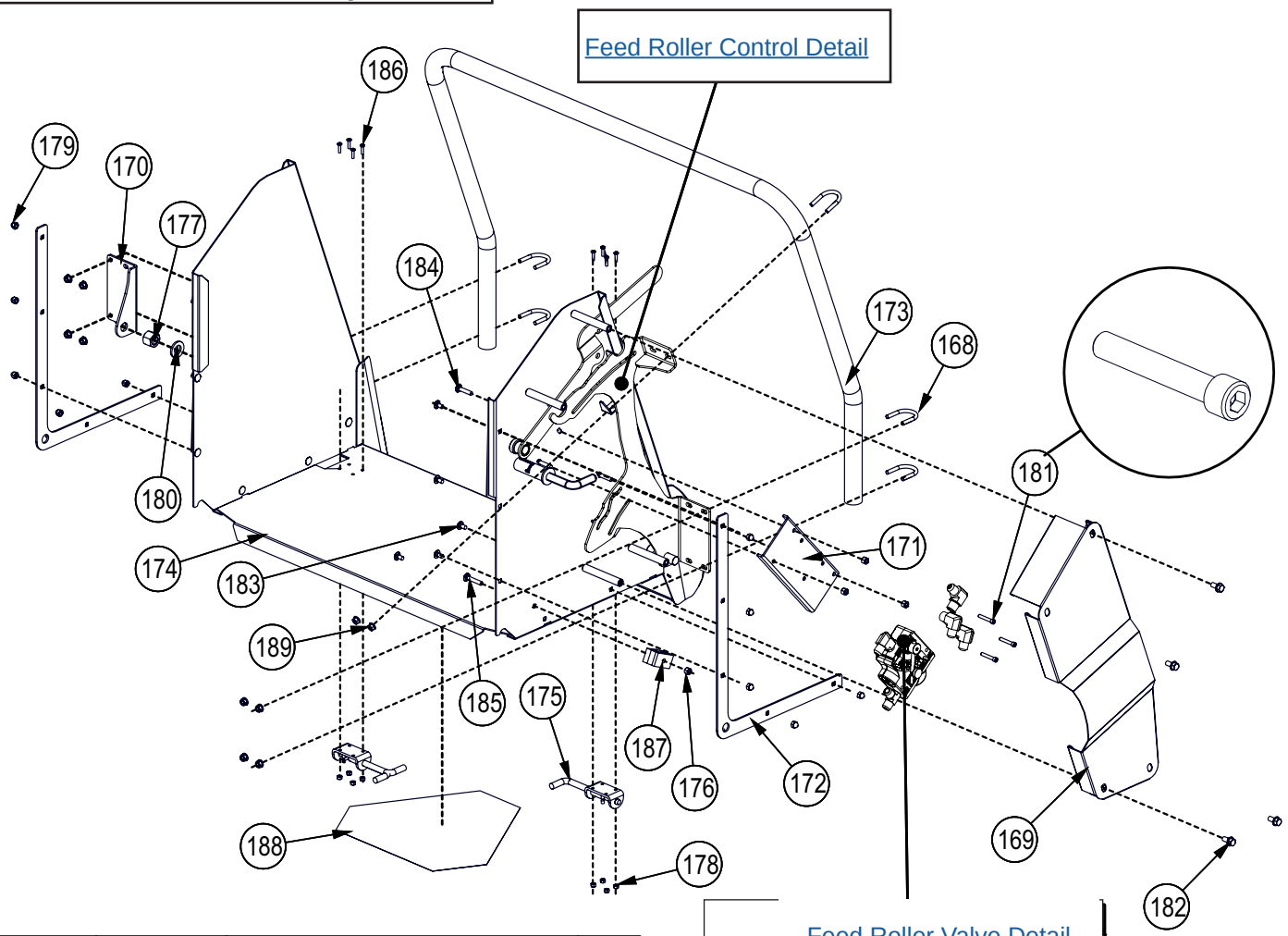
Item No.	Part No.	Description	Qty
85	1023L300	Bridge Guard Mount	1
86	1024L775	Clamp Mount	1
87	1024W601	Main Hopper	1
88	Z11111	Toplink Pin, 5/8" x 2-3/4"	2
89	Z11501	Toplink, Cat 0 x 10-1/2" x 16"	1
91	Z71217	Hex Bolt, 5/16NC x 1-3/4"	1
92	Z71307	Hex Bolt, 3/8NC x 3/4"	7
93	Z72221	Hex Lock Nut, 5/16NC	4
94	Z72271	Hex Lock Nut, 3/4NC	2
95	Z12120	Lynch Pin, 1/4"	2
96	Z72531	Serrated Flange Locknut, 3/8NC	7
97	Z72958	Rivet Nut, 3/8NC x 150	3
98	Z72959	Rivet Nut, 3/8NC x 312	2
99	Z73171	SAE Washer, 3/4"	2
100	Z76133	Flange Bolt, 3/8NC x 3/4"	9
102	Z76228	Carriage Bolt, 5/16NC x 2-1/4"	2
103	Z79463	Double Hose Clamp, 11/16" OD	2
104	Z79464	Double Hose Clamp, 13/16" OD	2
105	Z72204	Hex Lock Nut, #10NF	4
106	Z75203	FHCS, #10NF x 3/4"	4
107	Z18207	Spring Latch Pin 1/2 x 1" Stroke	1



Used on BX52RI instead of # 93, 101 &103.

Part No.	Description	Qty
Z62819	Rubberized Wire Clamp, 1/2"	1
Z72211	Hex Lock Nut, 1/4NC	1
Z73111	SAE Washer, 1/4"	1
Z78301	Machine Screw, 1/4NC x 3/4"	1

Feed Table Assembly



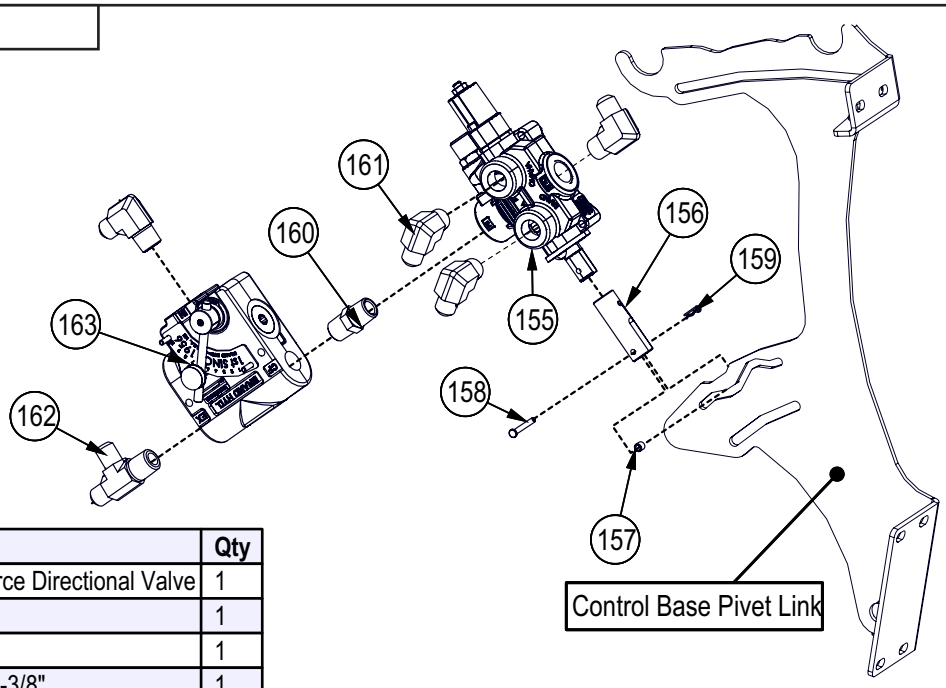
Item No.	Part No.	Description	Qty
168	1015S538	U-bolt, Bearing Adapter	5
169	1022L256	Valve Guard	1
170	1022L271	Feed Control Pivot	1
171	1022W217	Valve Mount Weldment	1
172	1024L724	Fold Table Trap Plate	2
173	1024S703	Feed Control Handle	1
174	1024W704	Feed Table Weldment	1
175	Z18207	Spring Latch Pin, 1/2" x 1" Stroke	2
176	Z72221	Hex Lock Nut, 5/16NC	4
177	Z72271	Hex Lock Nut, 3/4NC	1
178	Z72204	Hex Lock Nut, #10NF	8
179	Z72914	Acorn Nut, 5/16NC	10
180	Z73171	SAE Washer, 3/4"	1
181	Z75116	SHCS, 1/4NC x 1-1/2"	3
182	Z76133	Flange Bolt, 3/8NC x 3/4"	4
183	Z76222	Carriage Bolt, 5/16NC x 5/8"	10
184	Z76224	Carriage Bolt, 5/16NC x 1-1/2"	3
185	Z76227	Carriage Bolt, 5/16NC x 1-3/4"	1
186	Z78316	Machine Screw, #10NF x 3/4"	8
187	Z79463	Double Hose Clamp, 11/16" OD	1
188	Z94601	Decal, SMV	1
189	Z72521	Serrated Flange Locknut, 5/16NC	10

Used on BX52RI instead of # 176, 185 & 187.

Part No.	Description	Qty
Z62819	Rubberized Wire Clamp, 1/2"	1
Z72211	Hex Lock Nut, 1/4NC	1
Z73111	SAE Washer, 1/4"	1
Z78301	Machine Screw, 1/4NC x 3/4"	1

Feed Roller Valve Detail

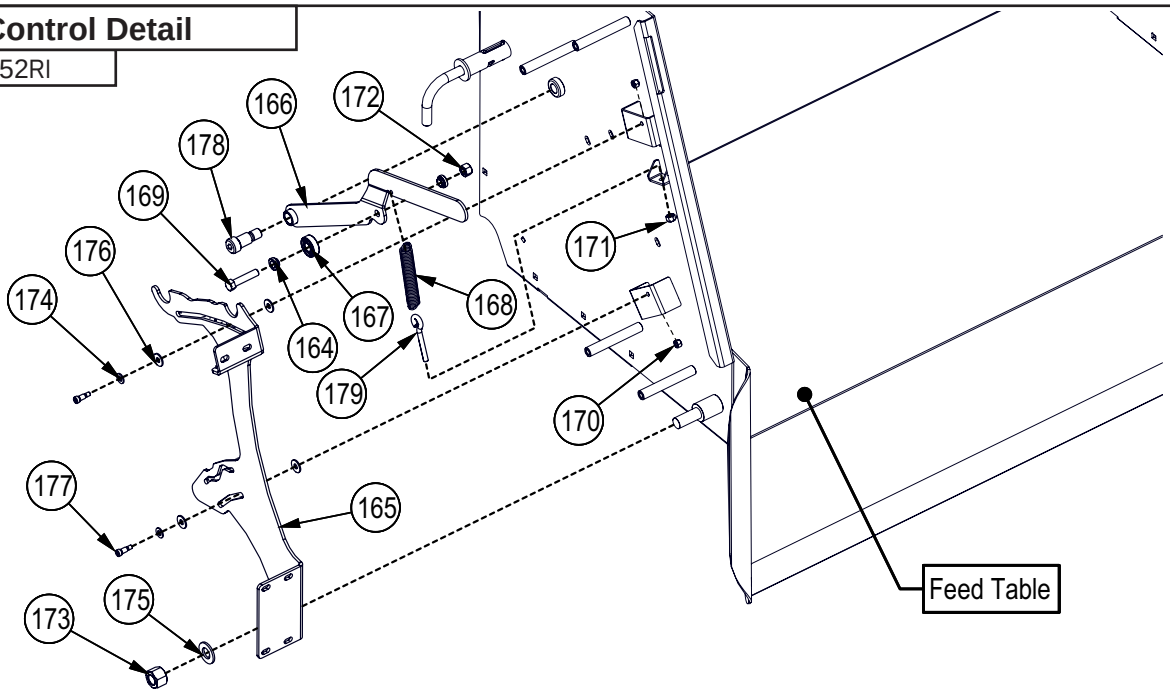
MODELS BX52R, BX52RI



Item No.	Description	Description	Qty
155	Z56215	Spring Ctr Low Force Directional Valve	1
156	1022M213	Bearing Yoke	1
157	1022M217	Solid Bearing	1
158	Z11301	Clevis Pin 3/16 x 1-3/8"	1
159	Z12210	Hitch Pin Clip, 1/16	1
160	Z51122	Nipple, MP x MP 0808	1
161	Z51451	#8JIC x 1/2NPT 90 Elbow	4
162	Z51487	Tee MJIC x MP x MJIC 080808	1
163	Z56305	Brand PFC 0-8 GPM	1

Feed Roller Control Detail

MODELS BX52R, BX52RI

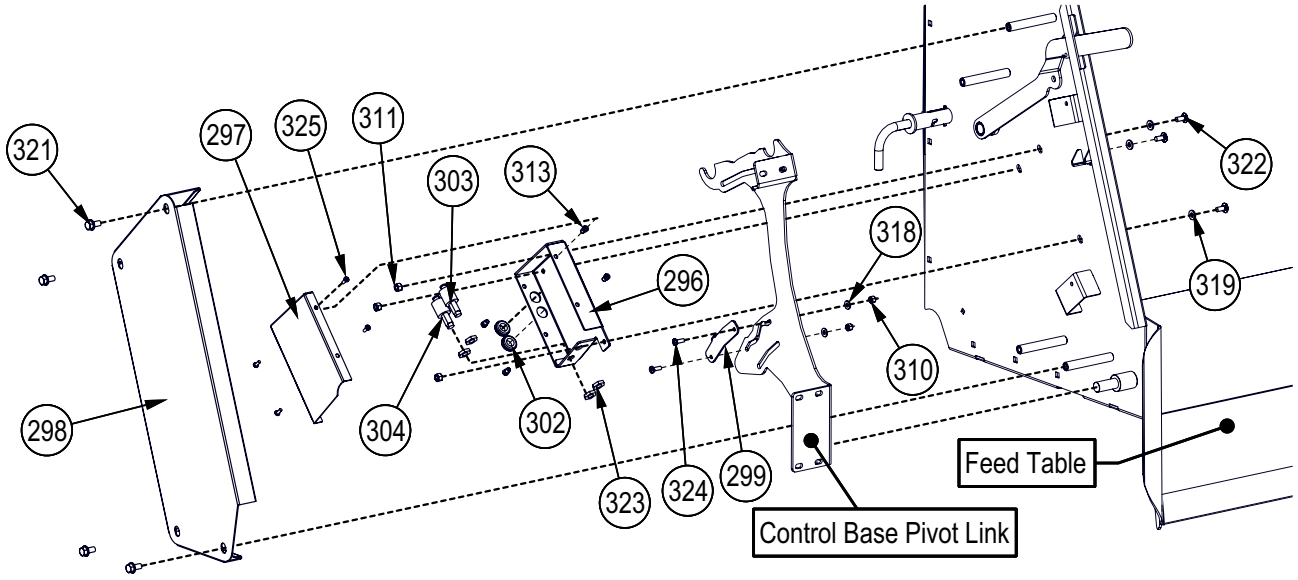


Item No.	Description	Description	Qty
164	1015M537	Bushing, Bearing	2
165	1022L239	Control Base Pivot Link	1
166	1022W224	Detent Reset	1
167	Z21203	Ball Bearing 6202 RS	1
168	Z31401	Spring 3/4 x 4" Heavy	1
169	Z71420	Hex Bolt, 7/16NC x 2	1
170	Z72211	Hex Lock Nut, 1/4NC	2
171	Z72221	Hex Lock Nut, 5/16NC	1
172	Z72241	Hex Lock Nut, 7/16NC	1

Item No.	Description	Description	Qty
173	Z72271	Hex Lock Nut, 3/4NC	1
174	Z73122	Flat Washer, 5/16	2
175	Z73171	Flat Washer, 3/4"	1
176	Z73222	PTFE Flat Washer, 5/16 x 0.080"	4
177	Z75522	Shoulder Bolt, 5/16 x 1/2"	2
178	Z75574	Shoulder Bolt, 3/4 x 1	1
179	Z76522	Eye Bolt 5/16NC x 2	1

Intellifeed Roller Control Components

MODEL BX52RI

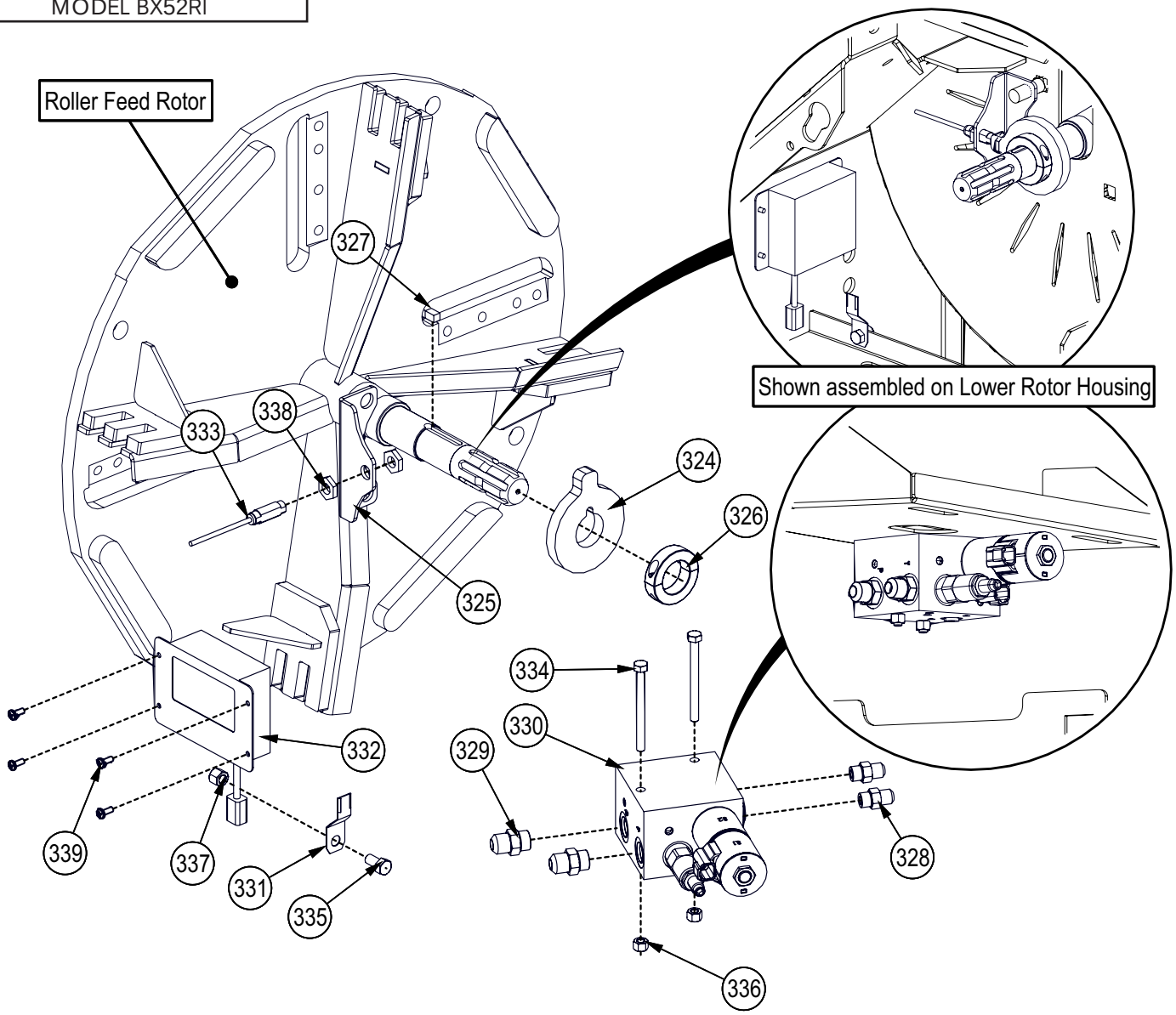


Item No.	Description	Description	Qty
296	1083L154	Switch Mount Plate, BX102RI	1
297	1083L155	Sensor Box Lid	1
298	1083L156	Feed Switch Guard	1
299	1083L157	Feed Pickup Trigger	1
302	Z62823	Rubber Grommet 3/4 x 1/8	2
303	Z64403	Prox Switch NO Sourcing 5amp	1
304	Z64405	Prox Switch NO Sinking 5amp	1
310	Z72211	Hex Lock Nut, 1/4NC	2
311	Z72221	Hex Lock Nut, 5/16NC	3

Item No.	Description	Description	Qty
313	Z72954	Riv-Nut #10-32NF - 130	4
318	Z73111	Flat Washer, 1/4	2
319	Z73123	Rubber Flat Washer, 5/16 x 0.093"	3
321	Z76133	Flange Bolt, 3/8NC x 3/4	4
322	Z76221	Carriage Bolt, 5/16NC x 3/4	3
323	Z77282	Jam Nut, M14 x 1.5	4
324	Z78301	Machine Screw, 1/4-20NC x 3/4	2
325	Z78303	Machine Screw, #10-32NF x 1/2	4

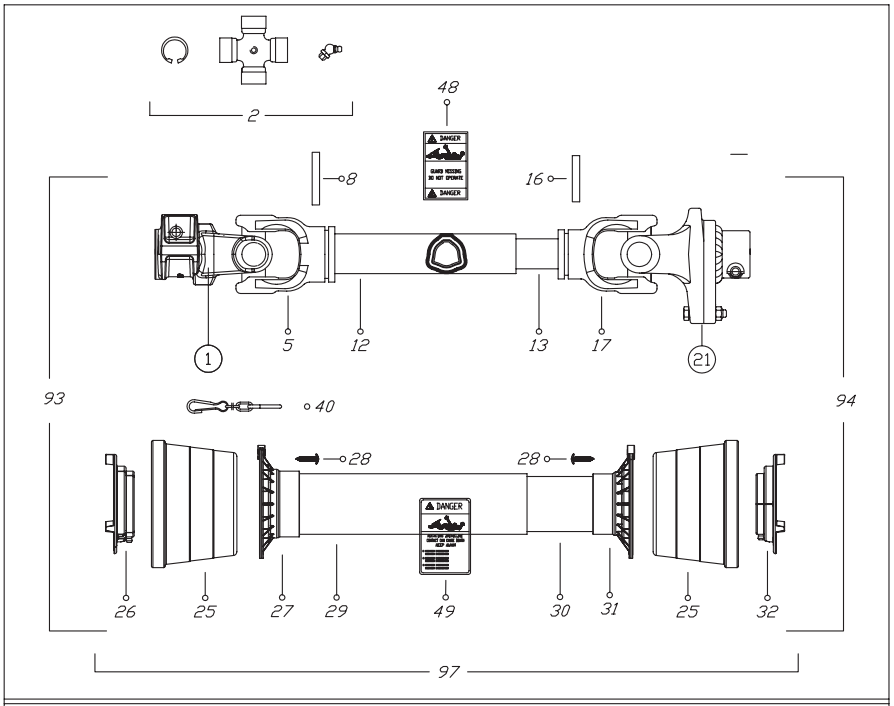
Intellifeed Components

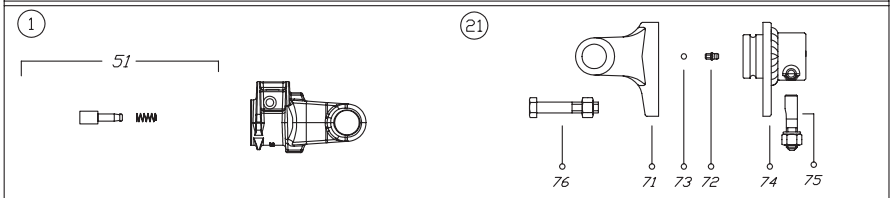
MODEL BX52RI



Item No.	Description	Description	Qty
324	1023L751	Rotor Speed Indicator, BX102R	1
325	1024L556	Sensor Mounting Bracket	1
326	Z46315	Shaft Collar, 1-3/8" ID x 9/16	1
327	Z46545	Key, 5/16 x 5/16 x 1/2	1
328	Z51641	Straight, MJIC x MORB 0606	2
329	Z51643	Straight, MJIC x MORB 0808	2
330	Z56508	Single Spool Valve, OC Tandem PROPSOL x 6GPM	1
331	Z62816	Deutsch Mounting Clip	1
332	Z66204	Control, IntelliFEED	1
333	Z66210	IntelliFEED Pickup Sensor with 68" Lead	1
334	Z71235	Hex Bolt, 5/16NC x 3-1/2"	2
335	Z71307	Hex Bolt, 3/8NC x 3/4"	1
336	Z72221	Hex Lock Nut, 5/16NC	2
337	Z72231	Hex Lock Nut, 3/8NC	1
338	Z72357	Brass Jam Nut, 9/16NF	2
339	Z78303	Machine Screw, #10NF x 1/2"	4

PTO Shaft #Z44504





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NOT PERMITTED AL RIGHTS RESERVED NICHT GENEHMIGTE VERVIELFAELTINGUNGEN SIND UNZULAESSING

CODICE C.E.D. B8D061US098001

DATA 29/01/10

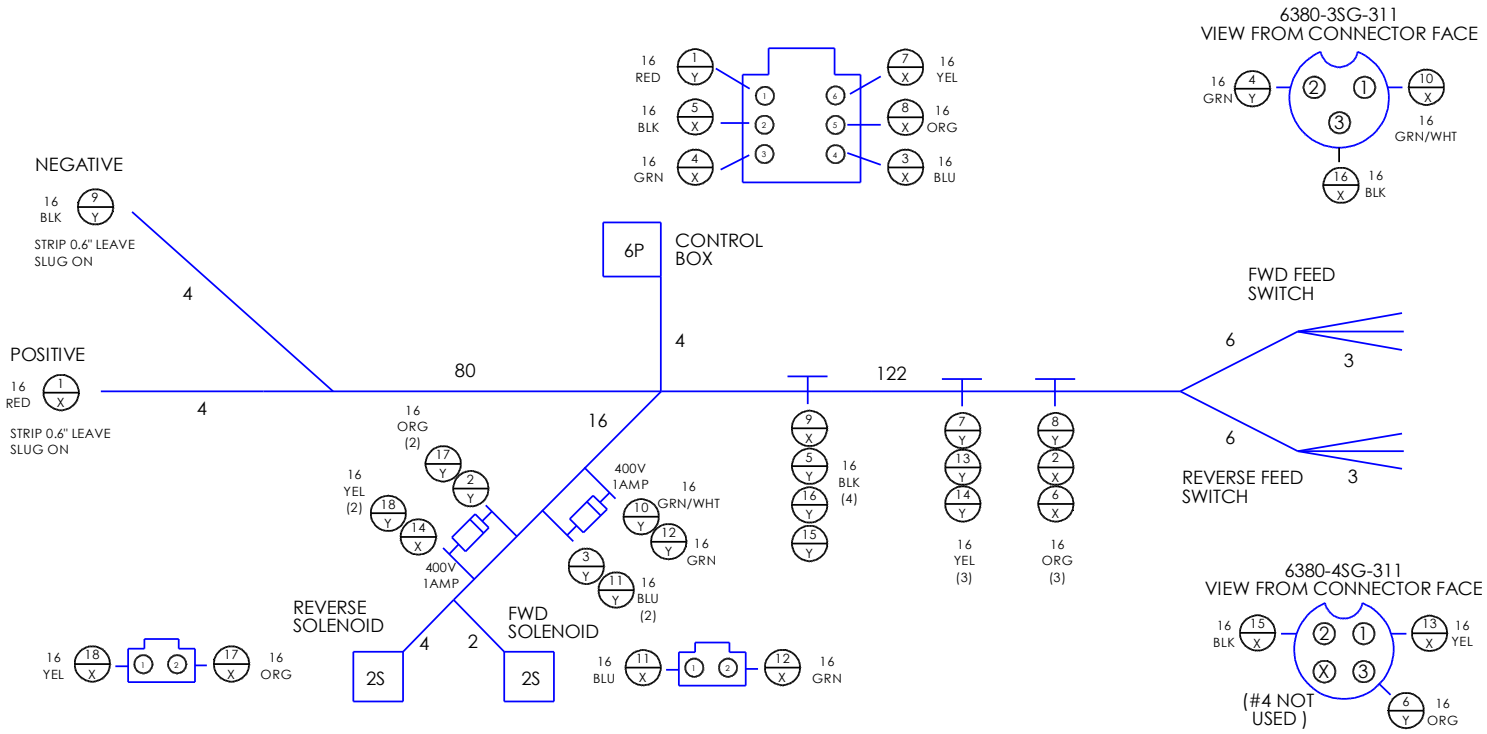
Binacchi SPARE PARTS LIST : B5D056US098001

POS.	DESCRIPTION	Q.	Part #
01	YOKE	1	0800503
02	CROSS JOURNAL ASS.	2	08205
05	OUTER TUBE YOKE	1	08005021
08	FLEXIBLE PIN	1	098701075
12	CM. 100 CARDAN TUBE(*)	1	09881523100
13	CM. 100 CARDAN TUBE(*)	1	09881454100
16	FLEXIBLE PIN	1	0987001065
17	INNER TUBE YOKE	1	08005011
21	SHEAR BOLT M10X1.5X55	1	Z19407 (5 Pack)
25	CONE SHIELD BELL 05-06	2	021906C001
26	OUTER BEARING 05	1	025505C001
27	OUTER BASE CONE 05-06	1	025406C001
28	SCREW	6	0998052242
29	OUTER SAFETY TUBE	1	0988981NB5056
30	INNER SAFETY TUBE	1	0988975NB5056
31	INNER BASE CONE 05-06	1	025406C002
32	INNER BEARING 05	1	025505C002
40	CHAIN	1	0252000001
48	LABEL DANGER OUTER DRIVE TUBE	1	09872006
49	EXTERNAL SHIELD LABEL	1	09872003
51	COMPLETE PUSH BUTTTON	1	0986014047
71	YOKE FOR LB5	1	08896905
72	GREASE NIPPLE	1	0984010150
73	STEEL BALL	23	098680104
74	HUB	1	088965A60
75	PUSH PIN SET	1	0986014075
76	NUT AND BOLT M10 x 1.5 x 55 10.9	1	Z19407 (5 Pack)
93	OUTER HALF SHAFT	1	B5056US2
94	INNER HALF SHAFT	1	B5056US1098001
97	SAFETY GUARD	1	083US05056

Intellifeed Wiring Diagram #Z62109

MODEL BX52RI

NOTE: HARNESS IS BRAIDED



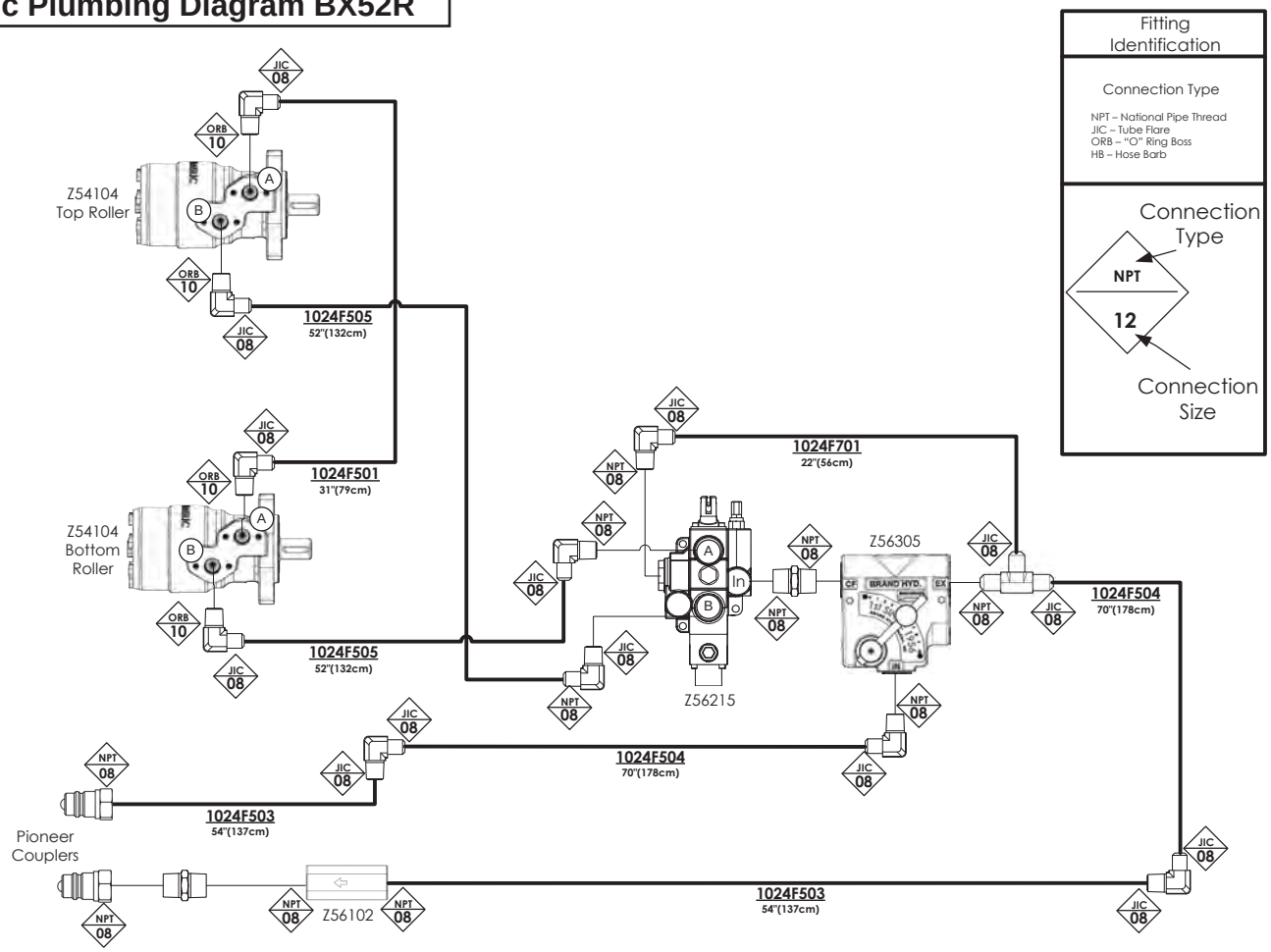
Hydraulic Hose Parts List

The table below is a complete list of hydraulic hoses for all models of the BX52R & BX52RI. For information on your model and its hose connections, review the hydraulic plumbing diagrams on the following page.

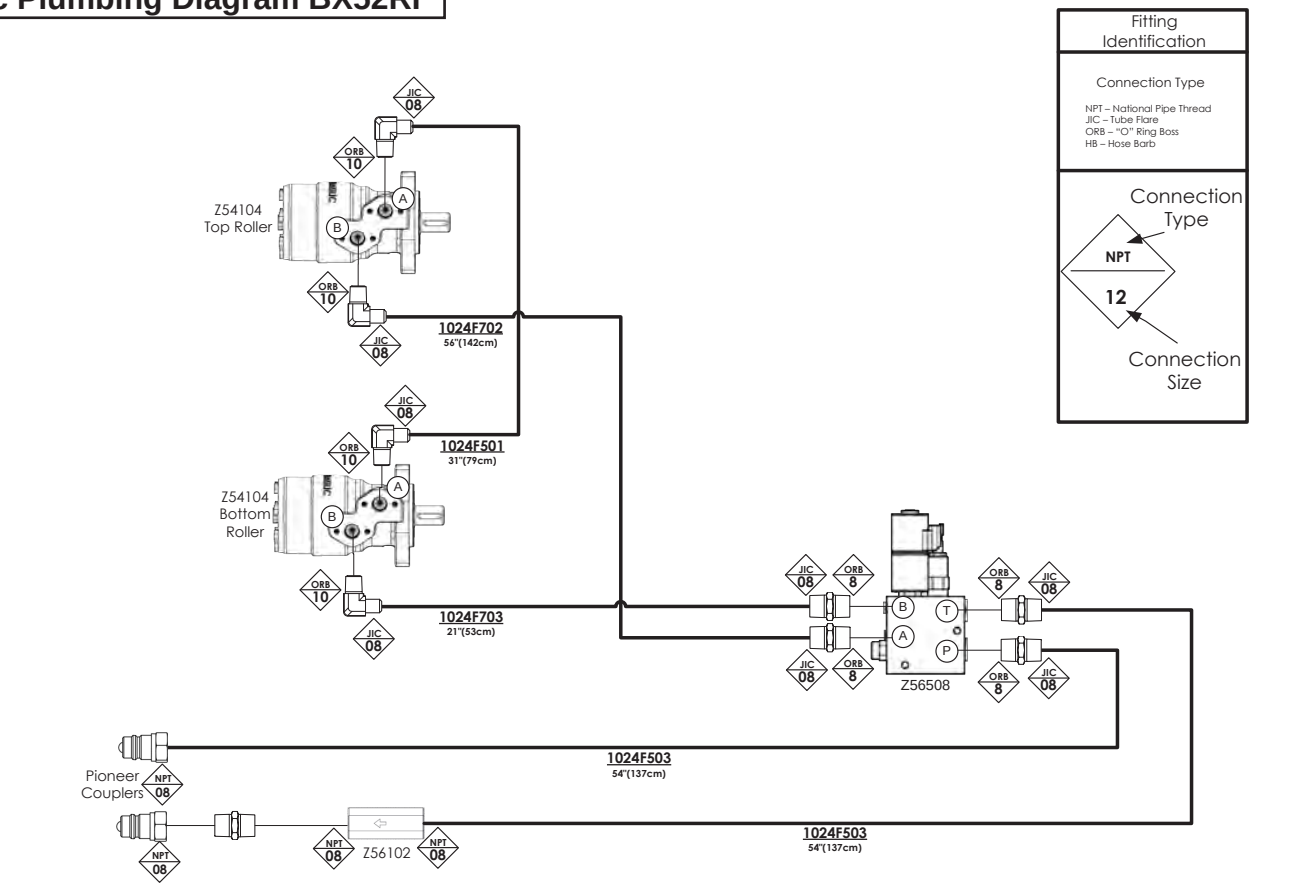
PARTNUMBER		Description	QTY	
With Protective Sleeve	With Out Protective Sleeve		BX52R	BX52RI
1024F501SC	1024F501	3/8" Hose, FJIC08 x FJIC08 x 31"	1	1
1024F503SC	1024F503	1/2" Hose, FJIC08 x MP08 x 54"	2	2
1024F504SC	1024F504	1/2" Hose, FJIC08 x FJIC08 x 70"	2	
1024F505SC	1024F505	3/8" Hose, FJIC08 x FJIC08 x 52"	2	
1024F703SC	1024F703	3/8" Hose, FJIC08 x 90FJIC06 x 21"		2

Hoses with Protective Sleeves are required for EU models

Hydraulic Plumbing Diagram BX52R



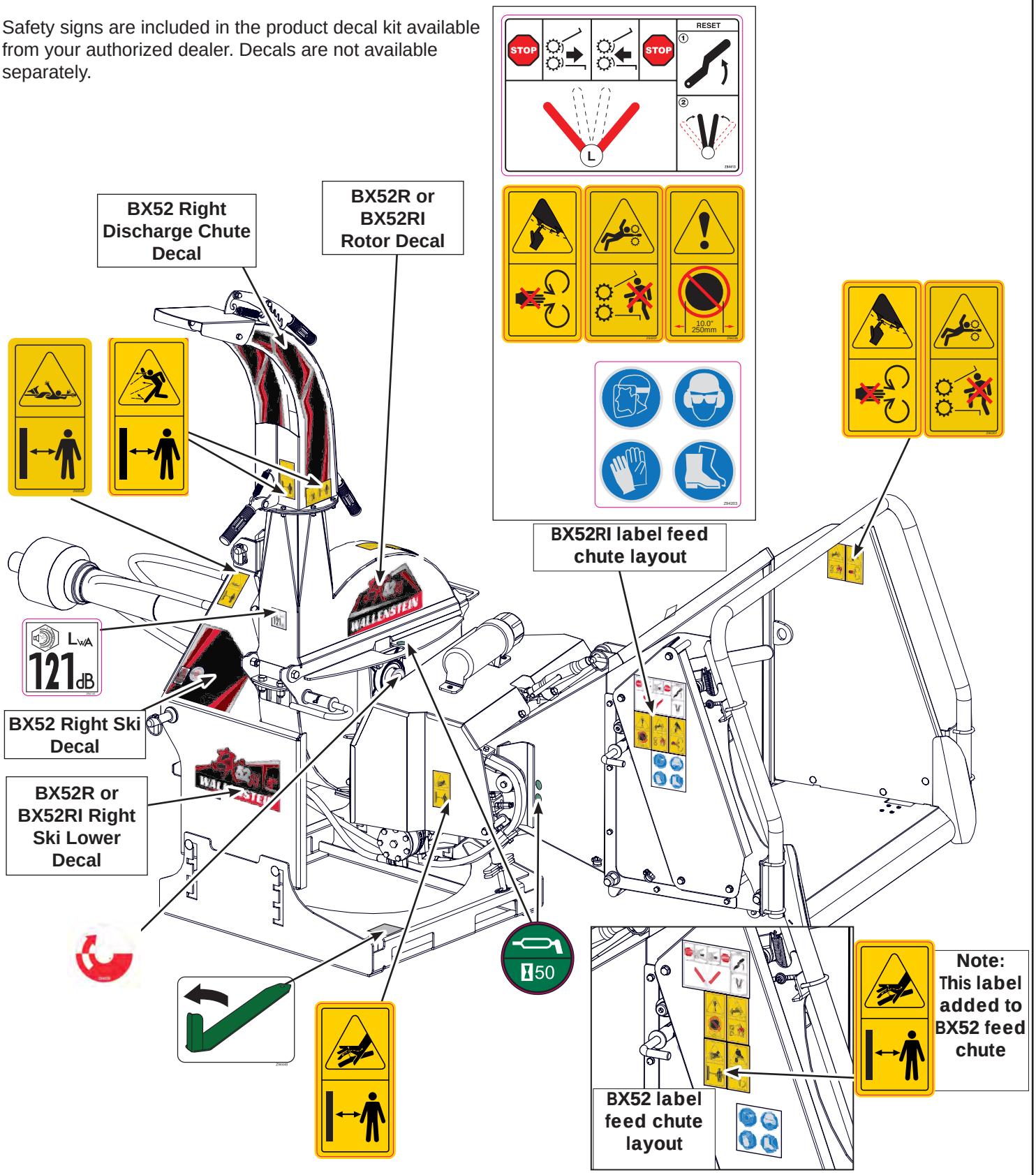
Hydraulic Plumbing Diagram BX52RI



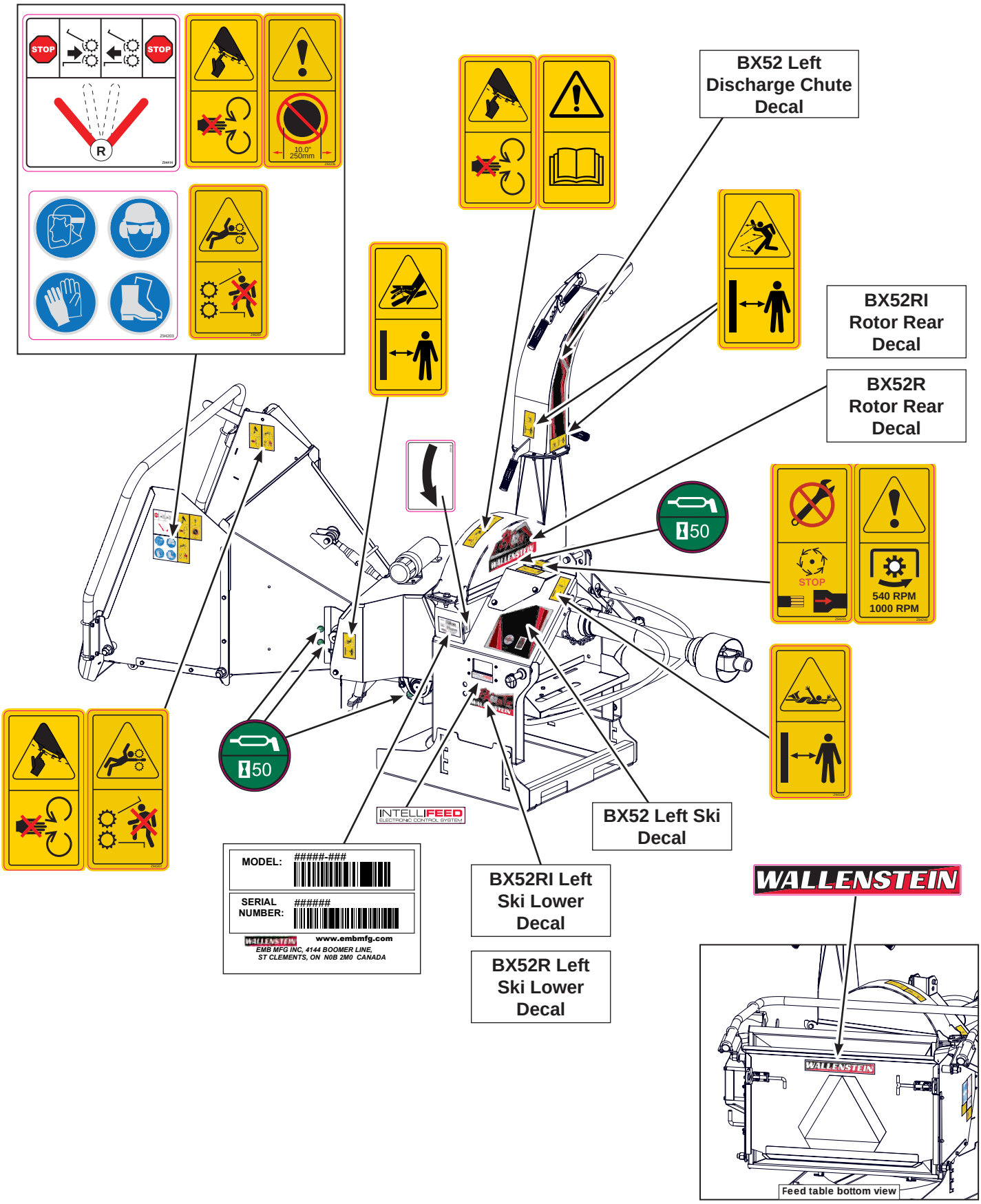
Decal Layout – Left Side View

IMPORTANT! If parts are replaced that have safety signs on them, new signs must be applied. Safety signs must always be replaced if they become damaged, are removed, or become illegible.

Safety signs are included in the product decal kit available from your authorized dealer. Decals are not available separately.

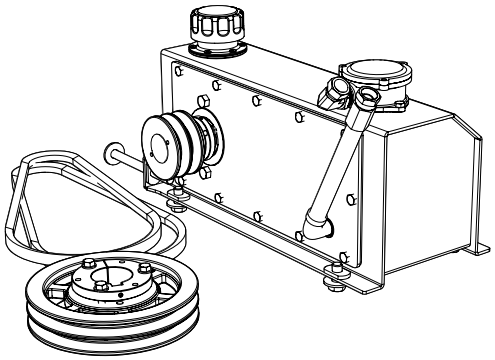


Decal Layout – Right Side View



Accessories

Call your dealer for pricing and availability



#C3540 SELF CONTAINED PTO POWER PACK

For model: **BX52R & BX52RI**

Easy to install

For tractors without available hydraulics, the optional power–pack mounts on the chipper just under the PTO shaft, and provides you with the means to operate the hydraulic feed hopper on model BX52R and BX52RI.

Bolt Torque

Checking Bolt Torque

The tables shown give correct torque values for various bolts and capscrews. Tighten all bolts to the torque values specified in the table, unless indicated otherwise. Check tightness of bolts periodically.

IMPORTANT! If replacing hardware, use fasteners of the same grade.

IMPORTANT! Torque figures indicated in the table are for non-greased or non-oiled threads. Do not grease or oil threads unless indicated otherwise. When using a thread locker, increase torque values by 5%.

NOTE: Bolt grades are identified by their head markings.

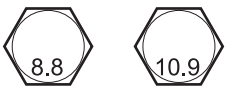
Imperial Bolt Torque Specifications

Bolt Diameter	Torque Value					
	SAE Gr. 2		SAE Gr. 5		SAE Gr. 8	
	lbf•ft	N•m	lbf•ft	N•m	lbf•ft	N•m
1/4"	6	8	9	12	12	17
5/16"	10	13	19	25	27	36
3/8"	20	27	33	45	45	63
7/16"	30	41	53	72	75	100
1/2"	45	61	80	110	115	155
9/16"	60	95	115	155	165	220
5/8"	95	128	160	215	220	305
3/4"	165	225	290	390	400	540
7/8"	170	230	420	570	650	880
1"	225	345	630	850	970	1320



Metric Bolt Torque Specifications

Bolt Diameter	Torque Value			
	Gr. 8.8		Gr. 10.9	
	lbf•ft	N•m	lbf•ft	N•m
M3	0.4	0.5	1.3	1.8
M4	2.2	3	3.3	4.5
M6	7	10	11	15
M8	18	25	26	35
M10	37	50	52	70
M12	66	90	92	125
M16	166	225	229	310
M20	321	435	450	610
M30	1,103	1 495	1,550	2 100
M36	1,917	2 600	2,700	3 675



Hydraulic Fitting Torque

Tightening Flare Type Tube Fittings

1. Check flare and flare seat for defects that might cause leakage.
2. Align tube with fitting before tightening.
3. Hand-tighten swivel nut until snug.
4. To prevent twisting the tube, use two wrenches. Place one wrench on the connector body and tighten the swivel nut with the second. Torque to values shown.

If a torque wrench is not available, use the FFFT (Flats From Finger Tight) method.

Hydraulic Fitting Torque					
Tube Size OD	Hex Size Across Flats	Torque value		Flats From Finger Tight	
Inches	Inches	lbf•ft	N•m	Flats	Turns
3/16	7/16	6	8	2	1/6
1/4	9/16	11–12	15–17	2	1/6
5/16	5/8	14–16	19–22	2	1/6
3/8	11/16	20–22	27–30	1-1/4	1/6
1/2	7/8	44–48	59–65	1	1/6
5/8	1	50–58	68–79	1	1/6
3/4	1-1/4	79–88	107–119	1	1/8
1	1-5/8	117–125	158–170	1	1/8

Values shown are for non-lubricated connections.