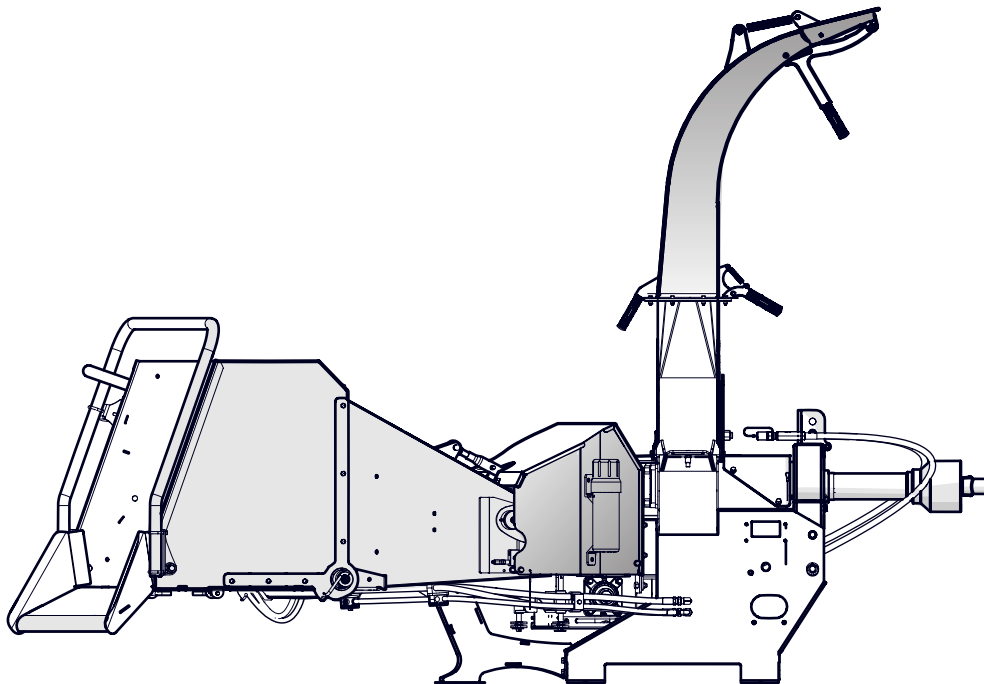


PARTS MANUAL

Serial Number 172R240 & up

BX72R / RI **3 PH ROLLER-FEED CHIPPER**



Foreword

This Wallenstein parts manual is prepared to assist customers in ordering quality OEM replacement parts.

Regular maintenance combined with replacing old, worn or broken parts with the correct OEM parts is essential in prolonging the life of your Wallenstein product. 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://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. Wallenstein reserves the right to change product specifications at any time without notice.

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

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WARNING!

Refer to the operators manual for safe operation and maintenance.

Maintenance should be performed by trained personnel only.

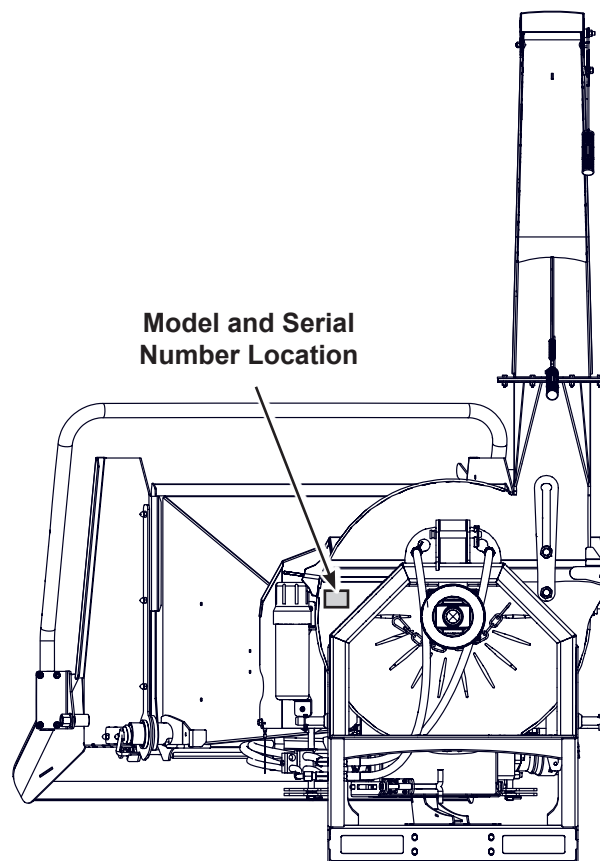
Serial Number Location

Always provide the model and serial number of your Wallenstein product when ordering parts or requesting service or other information. This information is found on the product information plate as shown below.

Record your product information here for future reference.

Model _____

Serial Number _____



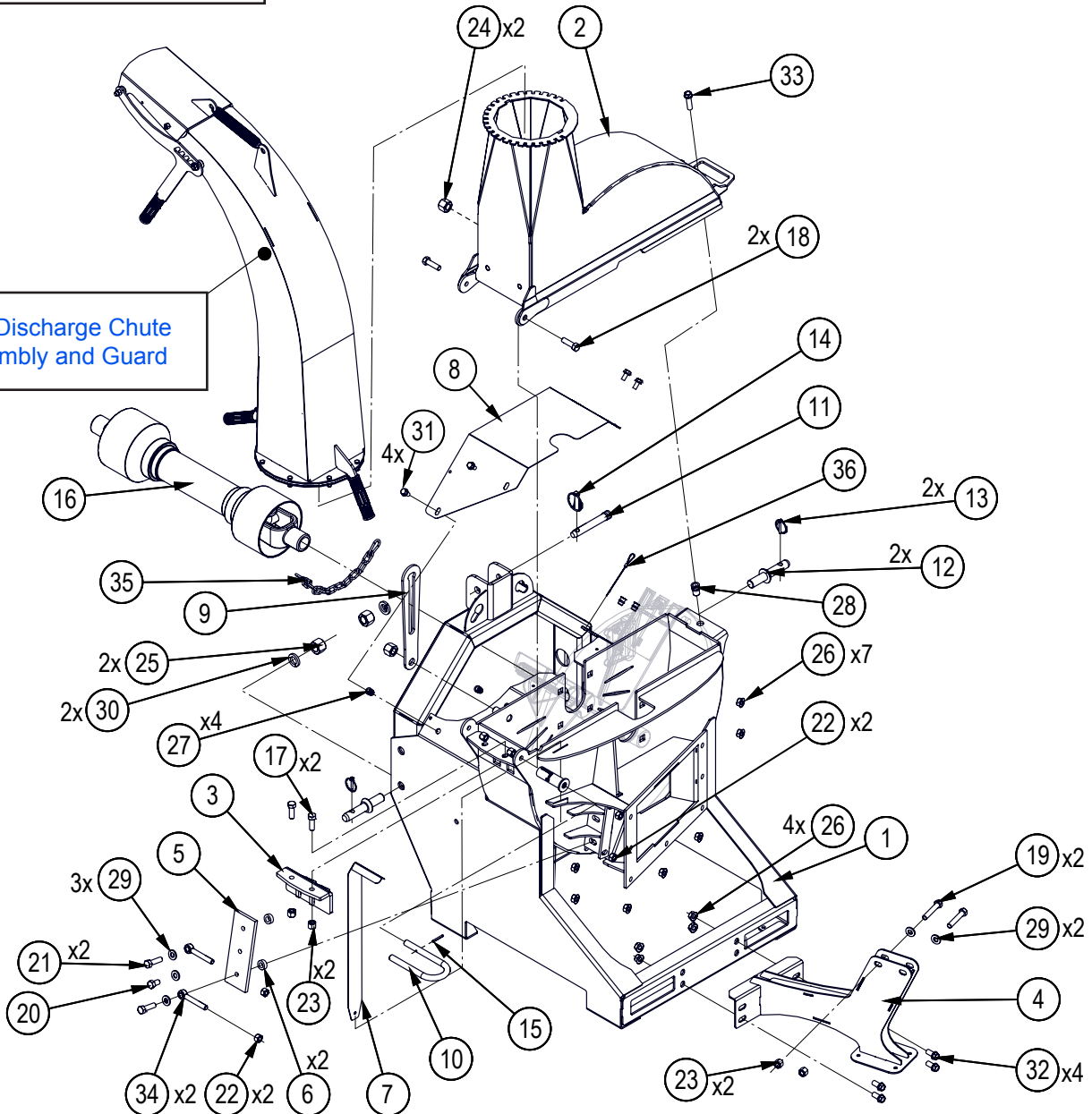
www.wallensteinequipment.com

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PTO Base Assembly

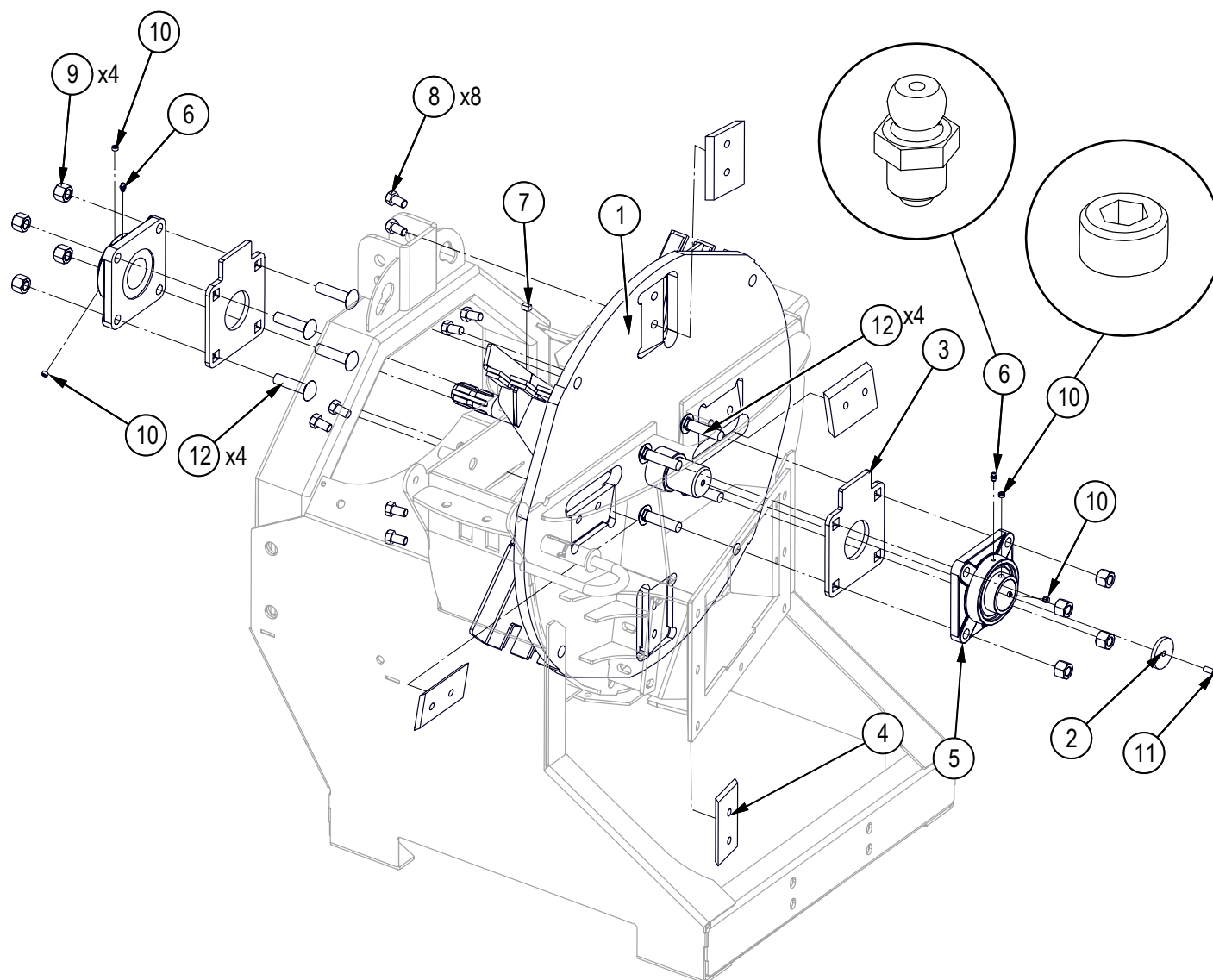
See Discharge Chute
Assembly and Guard



Item No.	Part No.	Description	Qty
1	1023W102	Lower Housing	1
2	1023W222	Upper Housing	1
3	1012W204	Twig Breaker	1
4	1023W104	Hopper Support	1
5	1012M204	Knife, BX62 Ledger	1
6	1023L150	Ledger Washer	2
7	1012L269	Gauge, Ledger Setting	1
8	1023L153	PTO Shield	1
9	1023L155	Rotation Stop	1
10	1082M402	Locking Plunger	1
11	Z11122	Toplink Pin, 3/4" x 3-7/8"	1
12	Z11431	Implement Pin, 7/8" x 1-3/4" x 7/8NF	2
13	Z12110	Lynch Pin, 3/16"	2
14	Z12140	Lynch Pin, 7/16"	1
15	Z14151	Roll Pin, 3/16" x 1-1/2"	1
16	Z44504	PTO Shaft, Series B5 x 30.748"	1
17	Z71515	Hex Bolt, 1/2NC x 1-1/2"	2
18	Z71517	Hex Bolt, 1/2NC x 1-3/4"	2
19	Z71527	Hex Bolt, 1/2NC x 2-3/4"	2

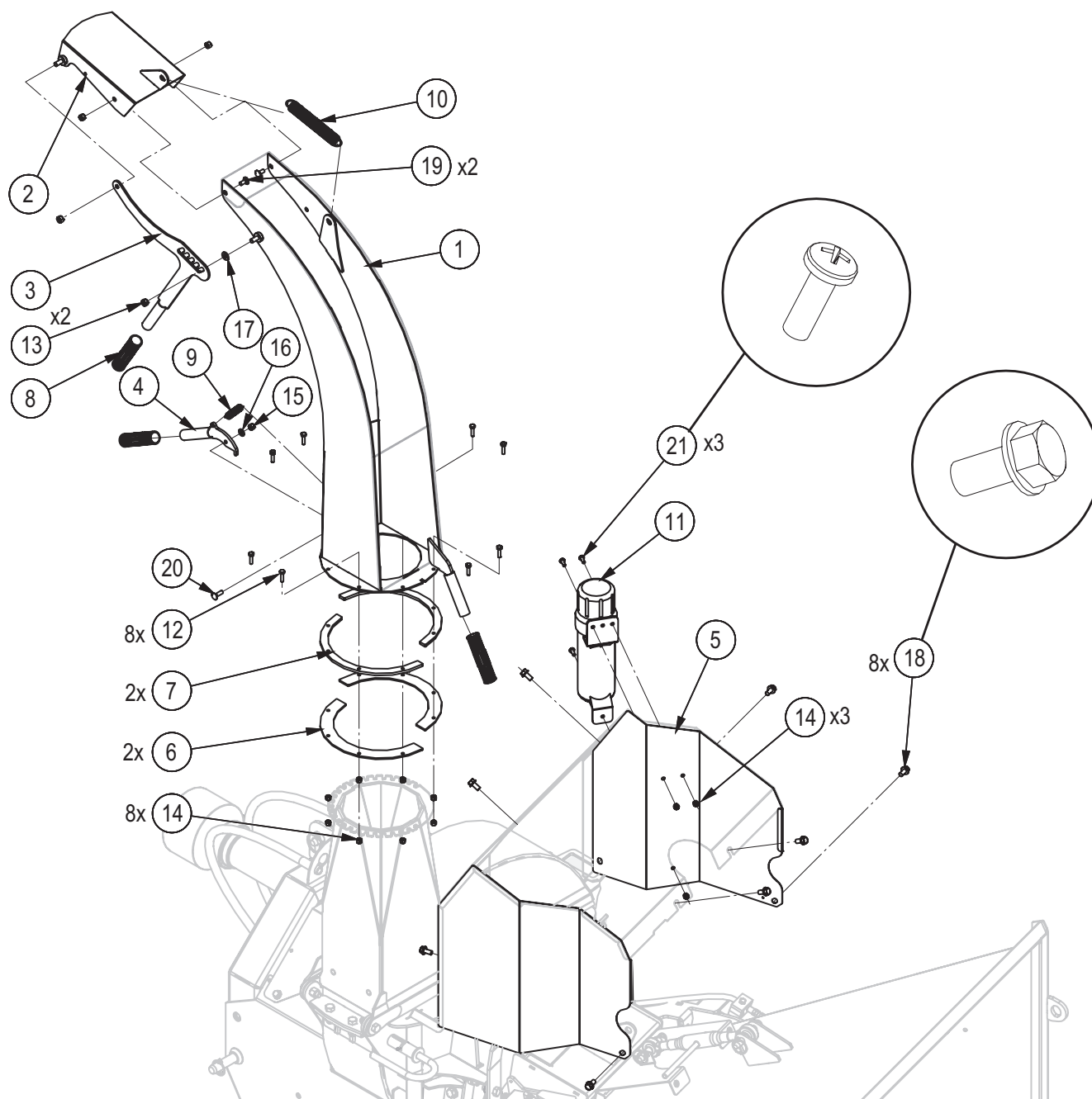
Item No.	Part No.	Description	Qty
20	Z71572G8	Hex Bolt, 1/2NF x 7/8" G8	1
21	Z71579G8	Hex Bolt, 1/2NF x 1-3/4" G8	2
22	Z72151	Hex Nut, 1/2NC	4
23	Z72251	Hex Lock Nut, 1/2NC	6
24	Z72271	Hex Lock Nut, 3/4NC	2
25	Z72282	Hex Lock Nut, 7/8NF	2
26	Z72551	Serrated Flange Locknut, 1/2NC	11
27	Z72959	Rivet Nut, 3/8NC x 312	4
28	Z72961	Rivet Nut, 1/2NC x 350	1
29	Z73151	SAE Washer, 1/2"	5
30	Z73381	Split Lock Washer, 7/8"	2
31	Z76133	Flange Bolt, 3/8NC x 3/4"	4
32	Z76153	Flange Bolt, 1/2NC x 1"	4
33	Z76155	Flange Bolt, 1/2NC x 1-3/4"	1
34	Z76553	Rod End, 1/2NC x 3-1/2" Full Threads	2
35	Z92310	PTO Support Chain, 3/16" x 1ft with Two Snaps	1
36	Z92110	Aircraft Cable, 1/16" x 24"	1

Rotor Parts



Item No.	Description	Description	Qty
1	1023W101	Rotor, 7" Capacity	1
2	1021S102	Rotation Indicator Cover	1
3	1023L145	Bearing Plate, Hopper Side	2
4	1053M303	Split Knife, BXT62 Rotor	4
5	Z25208	2" Flange Bearing Ductile Housing	2
6	Z29202	Grease Zerk 1/4NF	2
7	Z46545	Key, 5/16 x 5/16 x 1/2	1
8	Z71572G8	Hex Bolt, 1/2NF x 7/8 Gr8	8
9	Z72261G8	Hex Lock Nut, 5/8NC Grade 8	8
10	Z74132	Set Screw, 3/8NF	4
11	Z75351	BHCS, 5/16NF x 3/4	1
12	Z76264G8	Carriage Bolt, 5/8NC x 2-1/2 Grade 8	8

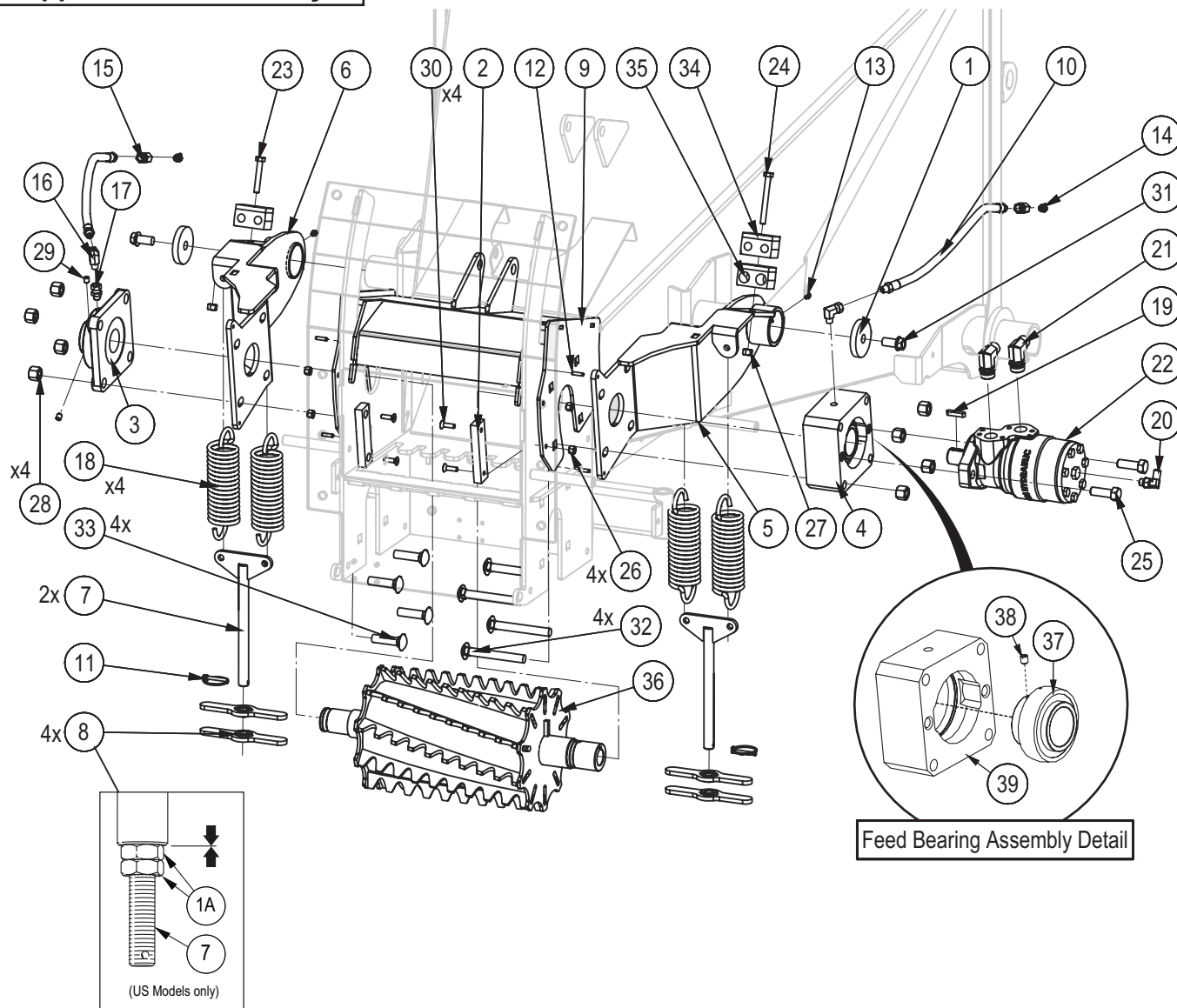
Discharge Chute Assembly and Guard



Item No.	Part No.	Description	Qty
1	1023W223	Discharge Chute	1
2	1023W224	Discharge Deflector	1
3	1023W226	Deflector Handle	1
4	1024W108	Discharge Latch	1
5	1023W221	Bridge Guard	1
6	1023L291	Hood Capture Ring	2
7	1023L292	Spacer Ring	2
8	Z19321	Handle Grip, 1"	3
9	Z31305	Ext Spring, 5/8" OD x 3" x 0.08"	1
10	Z31403	Ext Spring, 27mm OD x 178mm x 0.105"	1
11	Z96503	Manual Tube, 3-1/2" Short	1

Item No.	Part No.	Description	Qty
12	Z71110	Hex Bolt, 1/4NC x 1"	8
13	Z72231	Hex Lock Nut, 3/8NC	2
14	Z72211	Hex Lock Nut, 1/4NC	11
15	Z72221	Hex Lock Nut, 5/16NC	3
16	Z73122	SAE Washer, 5/16"	1
17	Z73131	SAE Washer, 3/8"	1
18	Z76133	Flange Bolt, 3/8NC x 3/4"	8
19	Z76221	Carriage Bolt, 5/16NC x 3/4"	2
20	Z76225	Carriage Bolt, 5/16NC x 1"	1
21	Z78301	Machine Screw, 1/4NC x 3/4"	3

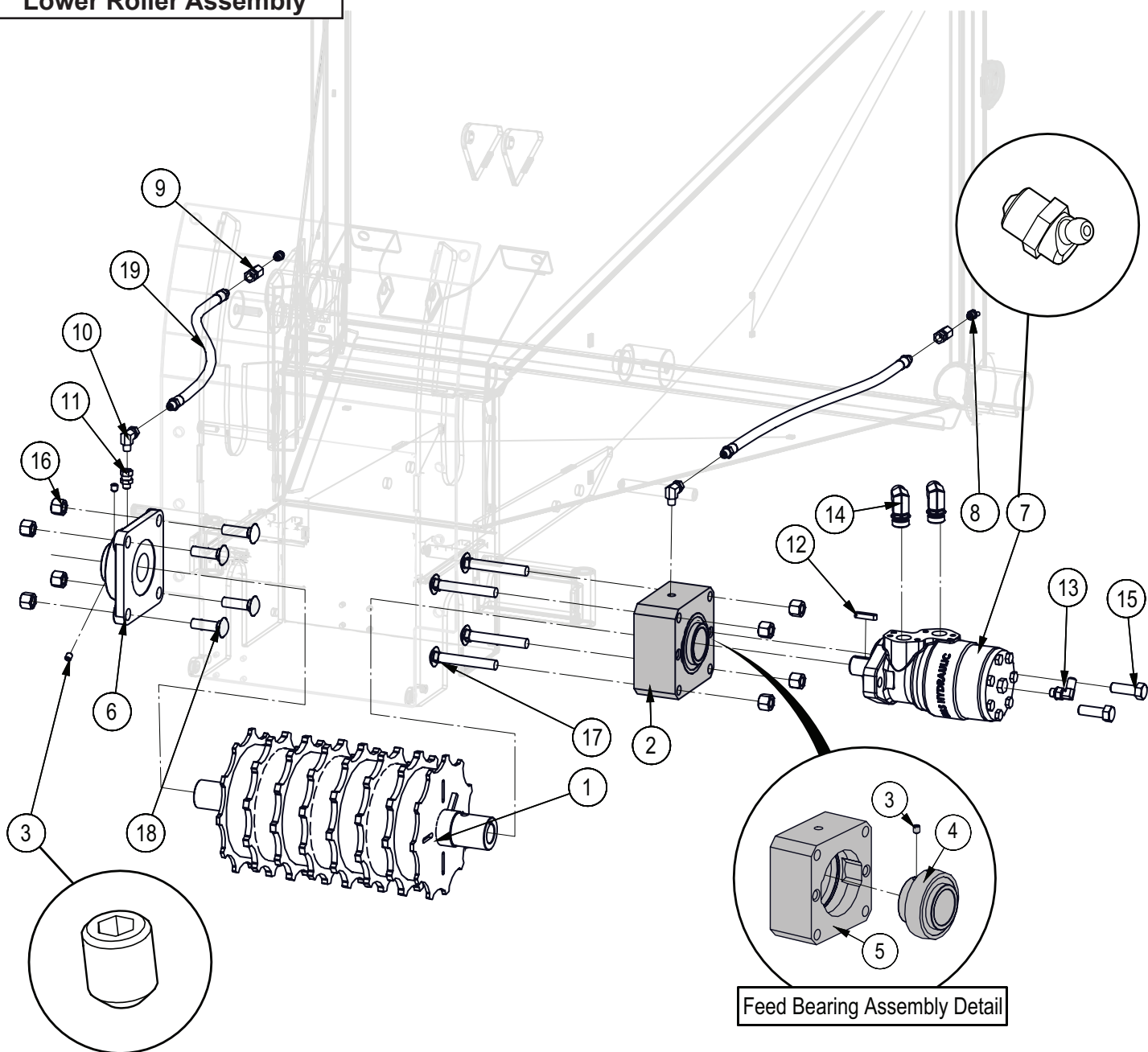
Upper Roller Assembly



Item No.	Part No.	Description	Qty
1	1015L618	Capture Washer	2
2	1022S208	Rotor Hood Slide	2
3	Z25204	4-Bolt Flange Bearing, UCF208-24	1
4	1022A205	Feed Bearing Assembly	1
5	1023W202	Roller Pivot Arm LH	1
6	1023W202H	Roller Pivot Arm RH	1
7	1022W206	Spring Yoke	2
8	1022W220	Nut Handle	4
8A	Z72361	Jam Nut, 5/8NC (US models only)	4
9	1061W168	Bridge, Guarded	1
10	1023F112	1/4" Grease Whip, MP02 x MP02 x 13"	2
11	Z12110	Lynch Pin, 3/16"	2
12	Z14152	Roll Pin, 3/16" x 3/4"	4
13	Z29202	Grease Fitting, 1/4NF	2
14	Z29204	Elbow 45 Grease Fitting, MP02	2
15	Z29302	Grease Fitting, FP x FPX 0202	2
16	Z29307	Elbow 90 Grease Fitting, MP x FPX 0202	2
17	Z29311	Grease Fitting, MP x FPX 0202	1
18	Z31501	Ext Spring, 2" OD x 7" x 0.250"	4
19	Z46594	Blind Chipper Key, 1/4" x 1/4" x 1-1/4"	1
20	Z51657	Elbow 90, MJIC x MORB 0404	1

Item No.	Part No.	Description	Qty
21	Z51658	Elbow 90, MJIC x MORB 0810	2
22	Z54104	Hydraulic Motor, 315CCR	1
23	Z71220	Hex Bolt, 5/16NC x 2"	1
24	Z71230	Hex Bolt, 5/16NC x 3"	1
25	Z71515	Hex Bolt, 1/2NC x 1-1/2"	2
26	Z72211	Hex Lock Nut, 1/4NC	4
27	Z72221	Hex Lock Nut, 5/16NC	2
28	Z72251	Hex Lock Nut, 1/2NC	8
29	Z74122	Set Screw, 5/16NF x 3/8"	2
30	Z75211	FHCS, 1/4NC x 7/8"	4
31	Z76153	Flange Bolt, 1/2NC x 1"	2
32	Z762511	Carriage Bolt, 1/2NC x 4"	4
33	Z76255	Carriage Bolt, 1/2NC x 2"	4
34	Z79462	Double Hose Clamp, 1/2" OD	2
35	Z79463	Double Hose Clamp, 11/16" OD	1
36	1023W227	BX72R Upper Feed Roller, Spiral	1
37	Z21903	Ball Bearing, UC209-28 x Insert	1
38	Z74122	Set Screw, 5/16NF x 3/8"	1
39	1022M218	UC Motor Bearing Housing	1

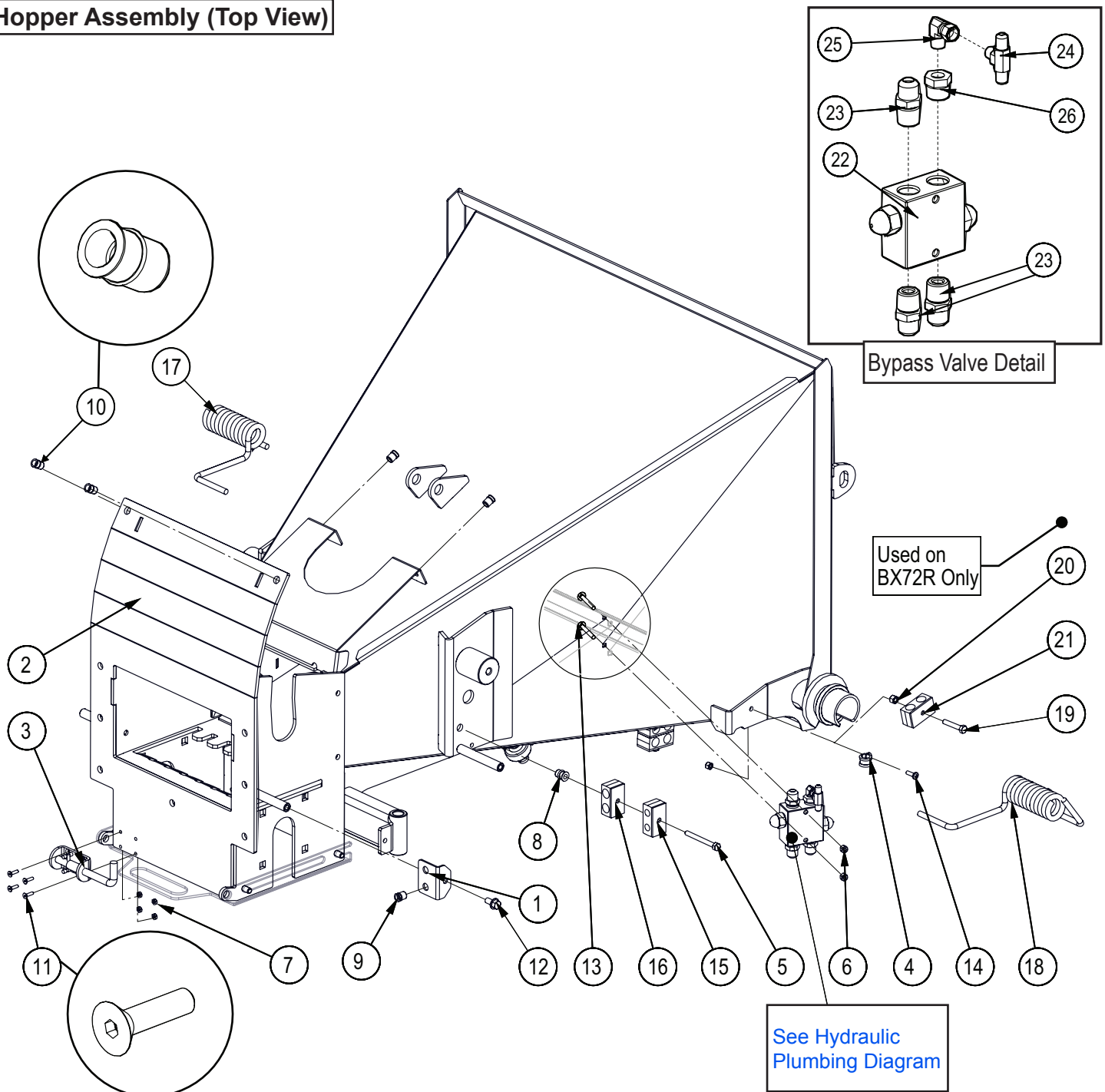
Lower Roller Assembly



Feed Bearing Assembly Detail

Item No.	Part No.	Description	Qty
1	1023W205	Lower Feed Roll	1
2	1022A205	Feed Bearing Assembly	1
3	Z74122	Set Screw, 5/16NF x 3/8"	3
4	Z21903	Ball Bearing, UC209-28 x Insert	1
5	1022M218	UC Motor Bearing Housing	1
6	Z25204	4-Bolt Flange Bearing, UCF208-24	1
7	Z54104	Hydraulic Motor, 315CCR	1
8	Z29204	Elbow 45 Grease Fitting, MP02	2
9	Z29302	Grease Fitting, FP x FPX 0202	2
10	Z29307	Elbow 90 Grease Fitting, MP x FPX 0202	2

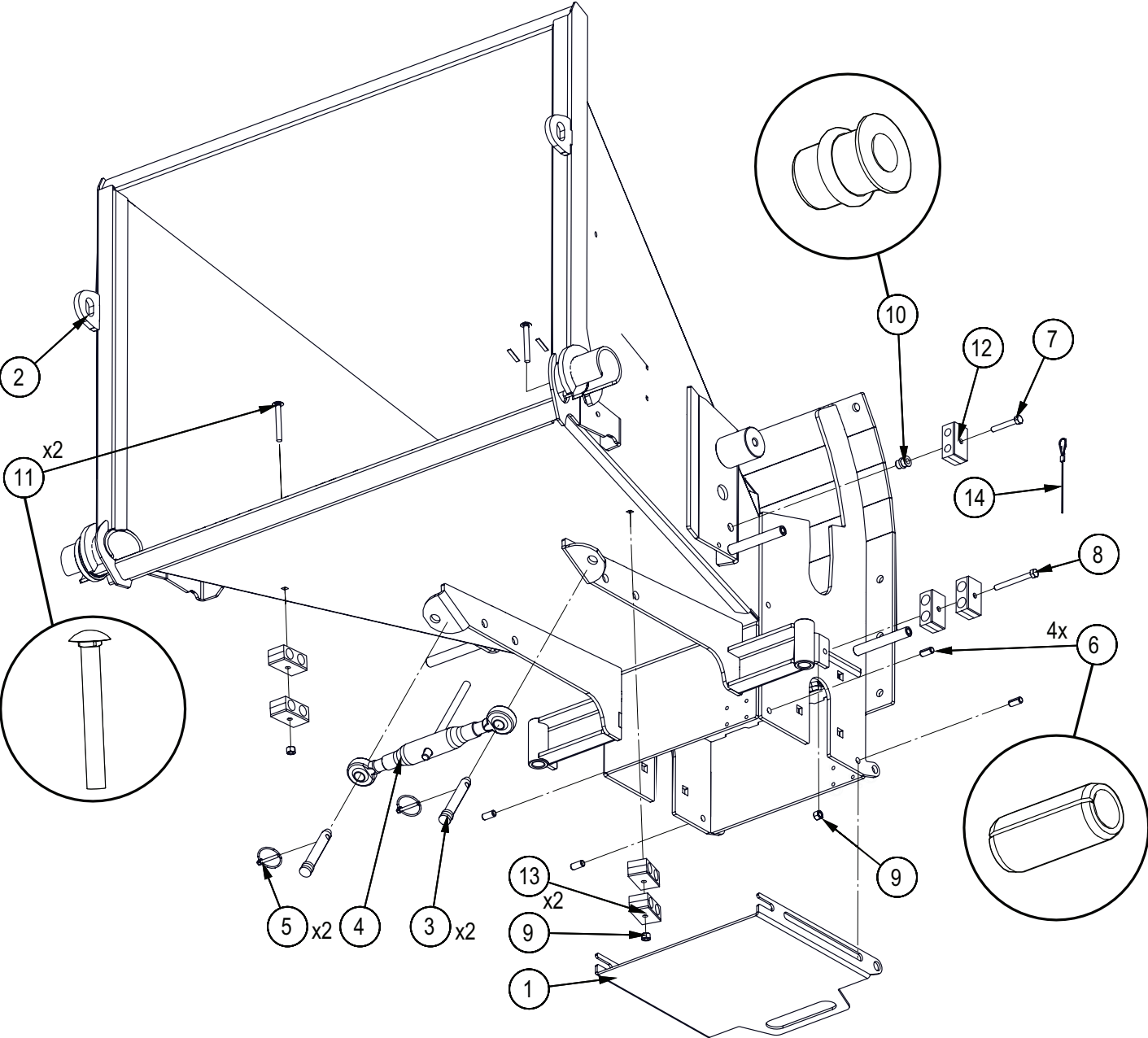
Item No.	Part No.	Description	Qty
11	Z29311	Grease Fitting, MP x FPX 0202	1
12	Z46594	Blind Chipper Key, 1/4" x 1/4" x 1-1/4"	1
13	Z51657	Elbow 90, MJIC x MORB 0404	1
14	Z51658	Elbow 90, MJIC x MORB 0810	2
15	Z71515	Hex Bolt, 1/2NC x 1-1/2"	2
16	Z72251	Hex Lock Nut, 1/2NC	8
17	Z762510	Carriage Bolt, 1/2NC x 3-1/2"	4
18	Z76258	Carriage Bolt, 1/2NC x 1-3/4"	4
19	1023F113	1/4" Grease Whip, MP02 x MP02 x 16"	2

Hopper Assembly (Top View)

Item No.	Part No.	Description	Qty
1	1023L300	Bridge Guard Mount	1
2	1023W201	Main Hopper	1
3	Z18207	Spring Latch Pin 1/2 x 1" Stroke	1
4	Z62819	Rubberized Wire Clamp, 1/2"	1
5	Z71230	Hex Bolt, 5/16NC x 3	1
6	Z72211	Hex Lock Nut, 1/4NC	3
7	Z72752	Machine Nut, #10-32NF	4
8	Z72957	Riv-Nut 5/16NC x 312	1
9	Z72958	Riv-Nut 3/8NC x 150	3
10	Z72959	Riv-Nut 3/8NC x 312	2
11	Z75203	FHCS, #10-32NF x 3/4	4
12	Z76133	Flange Bolt, 3/8NC x 3/4	1
13	Z76213	Carriage Bolt, 1/4NC x 2	2
14	Z78301	Machine Screw, 1/4-20NC x 3/4	1

Item No.	Part No.	Description	Qty
15	Z79462	Double Hose Clamp 1/2"	1
16	Z79463	Double Hose Clamp 11/16"	1
17	Z33301	Torsion Spring 3/8wire x 2 O.D. x 5" RH	1
18	Z33302	Torsion Spring 3/8wire x 2 O.D. x 5" LH	1
19	Z71217	Hex Bolt, 5/16NC x 1-3/4	1
20	Z72221	Hex Lock Nut, 5/16NC	1
21	Z79463	Double Hose Clamp 11/16"	1
22	Z56401	Crossover Relief Valve	1
23	Z51442	#8 JIC x 1/2NPT	3
24	Z51488	Tee MJIC x MJIC x MJIC 040404	1
25	Z51522	Elbow 90 MP x FJICX 0404	1
26	Z51222	Reducer, 1/2MP x 1/4FP	1

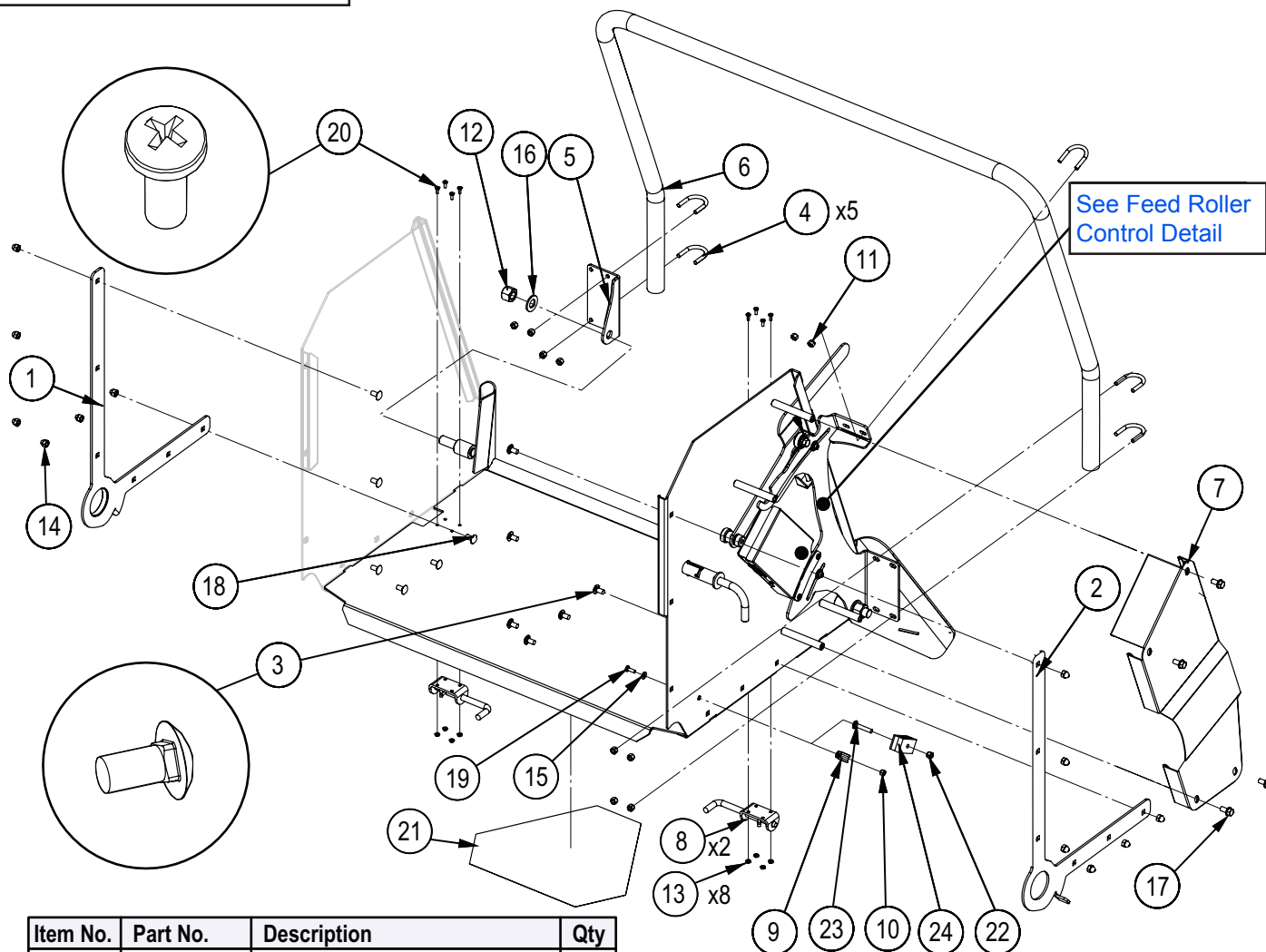
Hopper Assembly (Bottom View)



Item No.	Part No.	Description	Qty
1	1023L280	Lower Roller Guard	1
2	1023W201	Main Hopper	1
3	Z11111	Toplink Pin 5/8 x 2-3/4	2
4	Z11501	Toplink, Cat 0	1
5	Z12110	Latch Pin 3/16	2
6	Z14301	Roll Pin, 10mm x 22mm	4
7	Z71220	Hex Bolt, 5/16NC x 2	1
8	Z71230	Hex Bolt, 5/16NC x 3	1

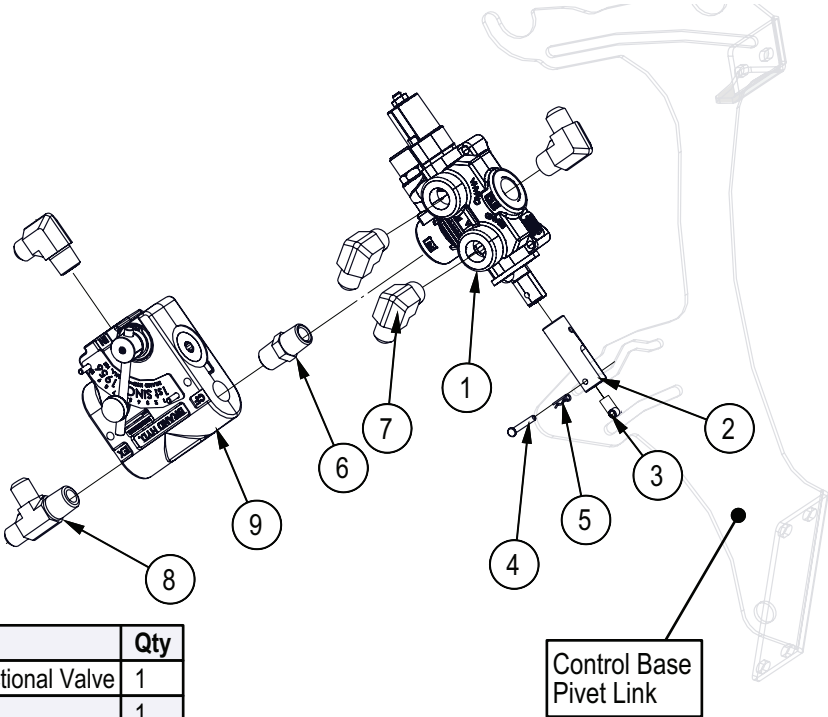
Item No.	Part No.	Description	Qty
9	Z72221	Hex Lock Nut, 5/16NC	3
10	Z72957	Riv-Nut 5/16NC x 312	1
11	Z76229	Carriage Bolt, 5/16NC x 3	2
12	Z79462	Double Hose Clamp 1/2"	1
13	Z79463	Double Hose Clamp 11/16"	6
14	Z92110	1/16 Aircraft cable x 2'	1

Feed Table Parts



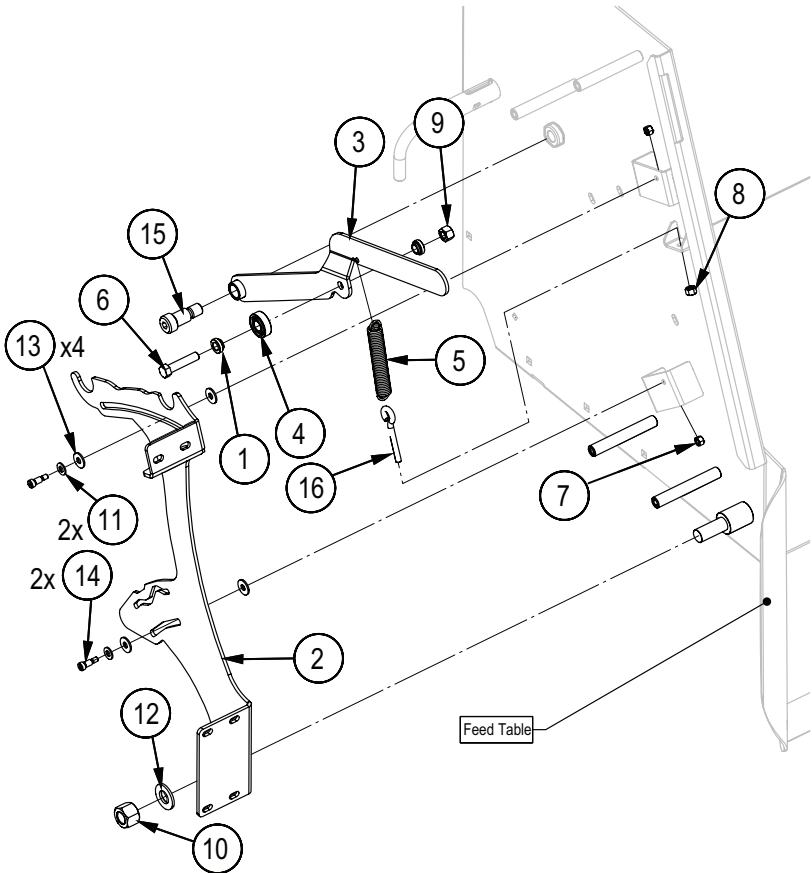
Item No.	Part No.	Description	Qty	
1	1022W230	Feed Table Trap Plate	1	
2	1022W230H	Feed Table Trap, LH	1	
3	1023W204	Feed Table	1	
4	1015S538	U-bolt, Bearing Adapter	5	
5	1022L271	Feed Control Pivot	1	
6	1023S203	Feed Control Handle	1	
7	1022L256	Valve Guard	1	Model BX72R only
8	Z18207	Spring Latch Pin 1/2 x 1" Stroke	2	
9	Z62819	Rubberized Wire Clamp, 1/2"	1	Model BX72RI only
10	Z72211	Hex Lock Nut, 1/4NC	1	Model BX72RI only
11	Z72521	Serrated Flange Locknut, 5/16NC	10	
12	Z72271	Hex Lock Nut, 3/4NC	1	
13	Z72204	Hex Lock Nut, #10NF	8	
14	Z72911	Acorn Nut, 3/8NC	12	
15	Z73111	Flat Washer, 1/4	1	Model BX72RI only
16	Z73171	Flat Washer, 3/4"	1	
17	Z76133	Flange Bolt, 3/8NC x 3/4	4	
18	Z76233	Carriage Bolt, 3/8NC x 3/4	12	
19	Z78301	Machine Screw, 1/4-20NC x 3/4	1	Model BX72RI only
20	Z78316	Machine Screw, #10NF x 3/4	8	
21	Z94601	Decal, SMV	1	
22	Z72221	Hex Lock Nut, 5/16NC	1	Model BX72R only
23	Z76227	Carriage Bolt, 5/16NC x 1-3/4	1	Model BX72R only
24	Z79463	Double Hose Clamp 11/16"	1	Model BX72R only

Feed Roller Valve Detail



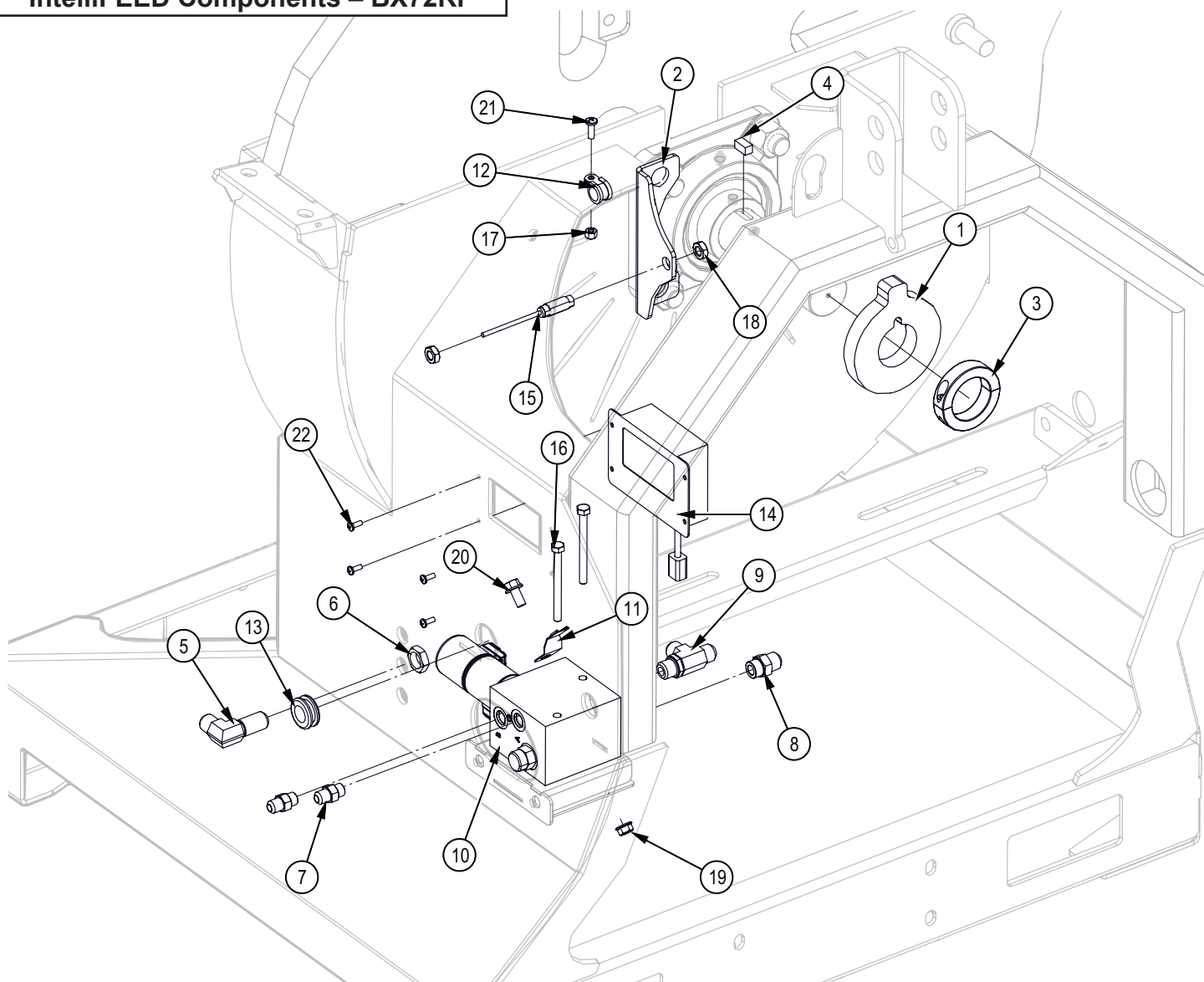
Item No.	Part No.	Description	Qty
1	Z56215	Spring Ctr Low Force Directional Valve	1
2	1022M213	Bearing Yoke	1
3	1022M217	Solid Bearing	1
4	Z11301	Clevis Pin 3/16 x 1-3/8"	1
5	Z12210	Hitch Pin Clip, 1/16	1
6	Z51122	Nipple, MP x MP 0808	1
7	Z51451	#8JIC x 1/2NPT 90 Elbow	4
8	Z51487	Tee MJIC x MP x MJIC 080808	1
9	Z56305	Brand PFC 0-8 GPM	1

Feed Roller Control Detail



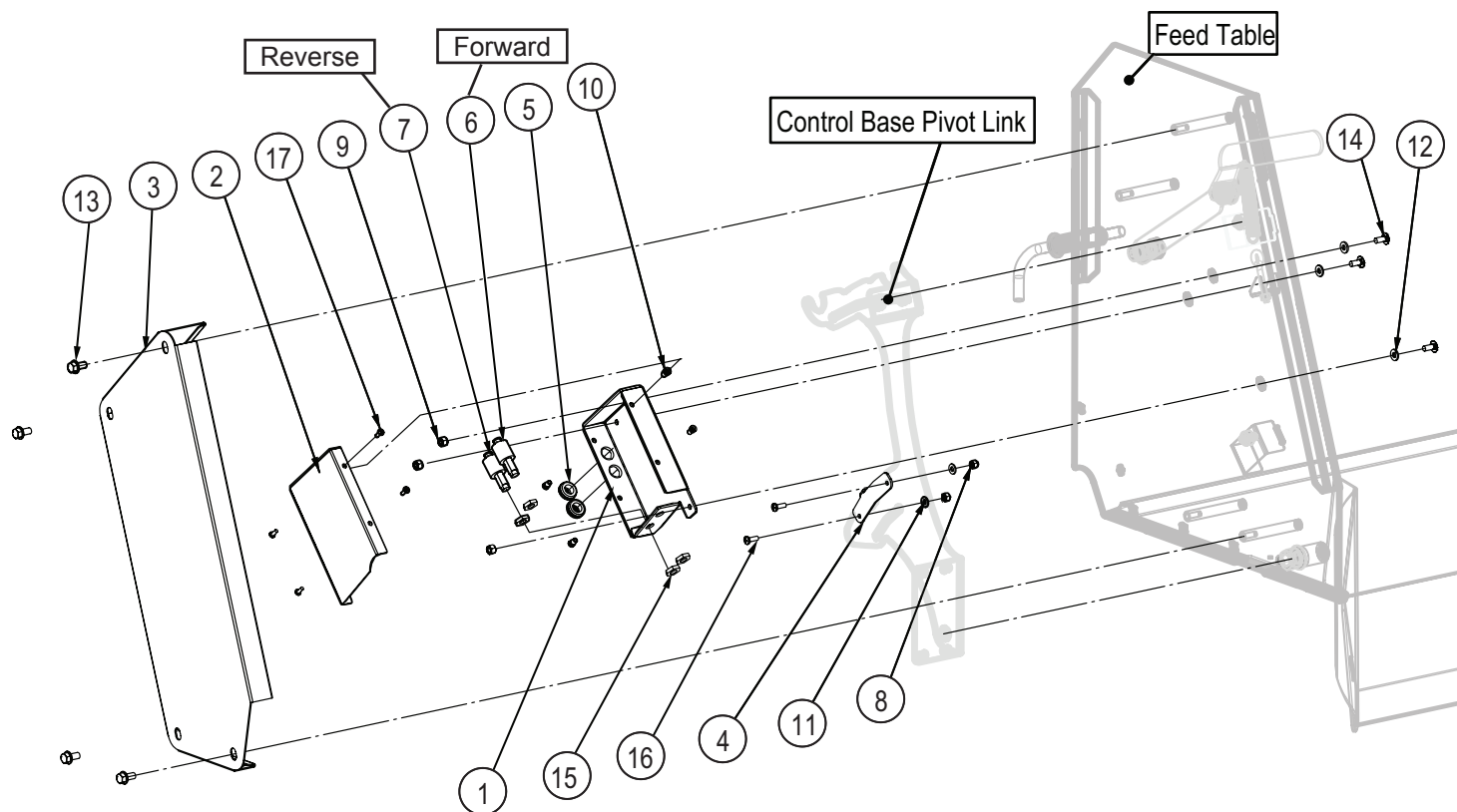
Item No.	Part No.	Description	Qty
1	1015M537	Bushing, Bearing	2
2	1022L239	Control Base Pivot Link	1
3	1022W224	Detent Reset	1
4	Z21203	Ball Bearing 6202 RS	1
5	Z31401	Spring 3/4 x 4" Heavy	1
6	Z71420	Hex Bolt, 7/16NC x 2	1
7	Z72211	Hex Lock Nut, 1/4NC	2
8	Z72221	Hex Lock Nut, 5/16NC	1
9	Z72241	Hex Lock Nut, 7/16NC	1
10	Z72271	Hex Lock Nut, 3/4NC	1
11	Z73122	Flat Washer, 5/16	2
12	Z73171	Flat Washer, 3/4"	1
13	Z73222	PTFE Flat Washer, 5/16 x 0.080"	4
14	Z75522	Shoulder Bolt, 5/16 x 1/2"	2
15	Z75574	Shoulder Bolt, 3/4 x 1	1
16	Z76522	Eye Bolt 5/16NC x 2	1

IntelliFEED Components – BX72RI



Item No.	Description	Description	Qty
1	1083L151	Rotor Speed Indicator, BX102R	1
2	1083L152	Sensor Mounting Bracket	1
3	Z46314	Shaft Collar, 2" ID x 11/16	1
4	Z46552	Key, 3/8 x 3/8 x 3/4	1
5	Z51492	Elbow 90 MJIC x BH 0808	1
6	Z51493	BH Locknut, 08	1
7	Z51641	#6ORB x #6JIC	2
8	Z51643	#8ORB x #8JIC	1
9	Z51673	Tee, MJIC x MORB x MJIC 080808	1
10	Z56508	CR IntelliFEED Manifold 6gpm	1
11	Z62816	Deutsch Mounting Clip	1
12	Z62819	Rubberized Wire Clamp, 1/2"	1
13	Z62822	Rubber Grommet 3/4 x 1/4	1
14	Z66204	Control, IntelliFEED	1
15	Z66207	IntelliFEED Pickup Sensor with Lead	1
16	Z71235	Hex Bolt, 5/16NC x 3-1/2	2
17	Z72211	Hex Lock Nut, 1/4NC	1
18	Z72341	Jam Nut, 7/16-14NC	2
19	Z72531	Flange Nut 3/8NC	1
20	Z76133	Flange Bolt, 3/8NC x 3/4	1
21	Z78301	Machine Screw, 1/4-20NC x 3/4	1
22	Z78303	Machine Screw, #10-32NF x 1/2	4

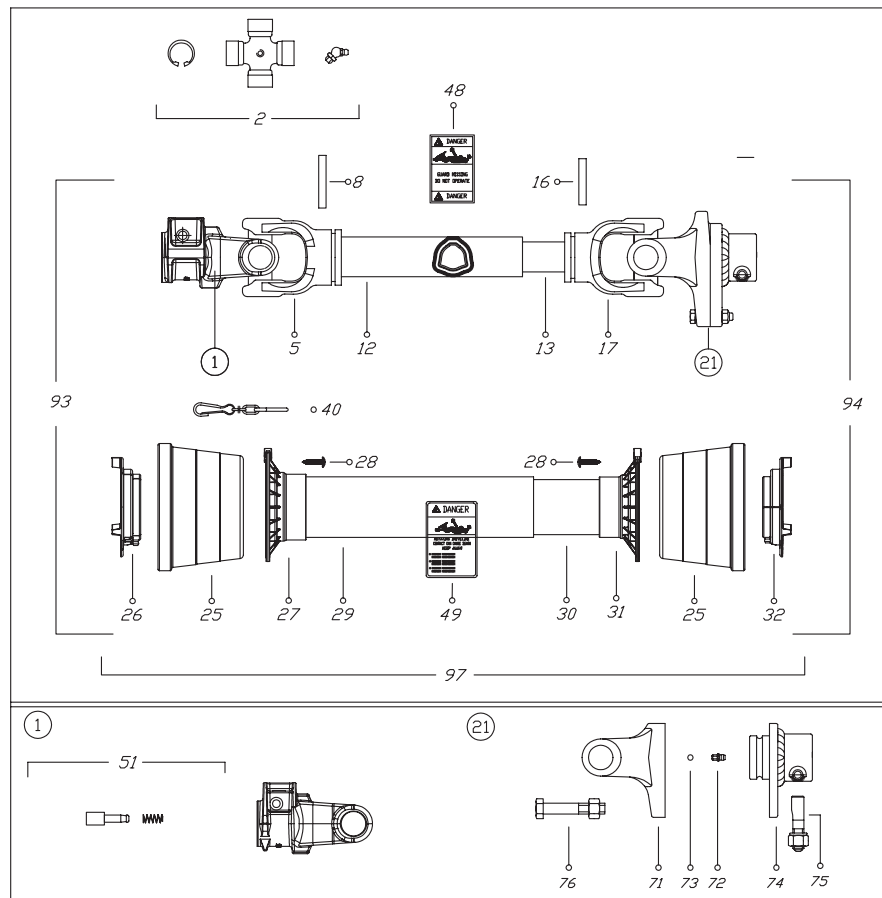
IntelliFEED Roller Control Components



Item No.	Part No.	Description	Qty
1	1083L154	Switch Mount Plate, BX102RI	1
2	1083L155	Sensor Box Lid	1
3	1083L156	Feed Switch Guard	1
4	1083L157	Feed Pickup Trigger	1
5	Z62823	Rubber Grommet 3/4 x 1/8	2
6	Z64403	Prox Switch NO Sourcing 5amp	1
7	Z64405	Prox Switch NO Sinking 5amp	1
8	Z72211	Hex Lock Nut, 1/4NC	4
9	Z72221	Hex Lock Nut, 5/16NC	4
10	Z72954	Riv-Nut #10-32NF - 130	4
11	Z73111	Flat Washer, 1/4	2
12	Z73123	Rubber Flat Washer, 5/16 x 0.093"	3
13	Z76133	Flange Bolt, 3/8NC x 3/4	4
14	Z76221	Carriage Bolt, 5/16NC x 3/4	3
15	Z77282	Jam Nut, M14 x 1.5	4
16	Z78301	Machine Screw, 1/4-20NC x 3/4	2
17	Z78303	Machine Screw, #10-32NF x 1/2	4

Forward
Reverse

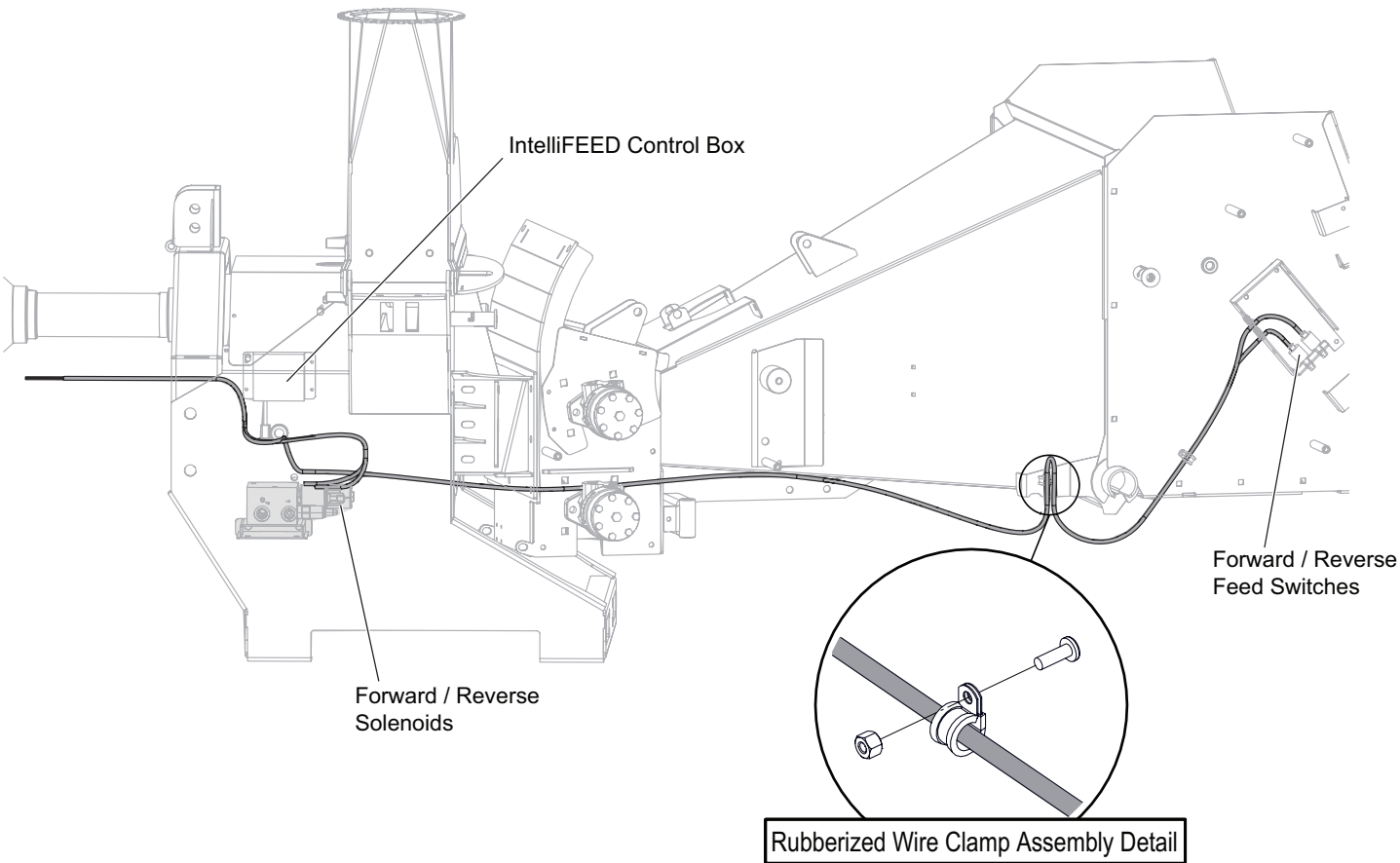
PTO Shaft



PTO Shaft Z44504

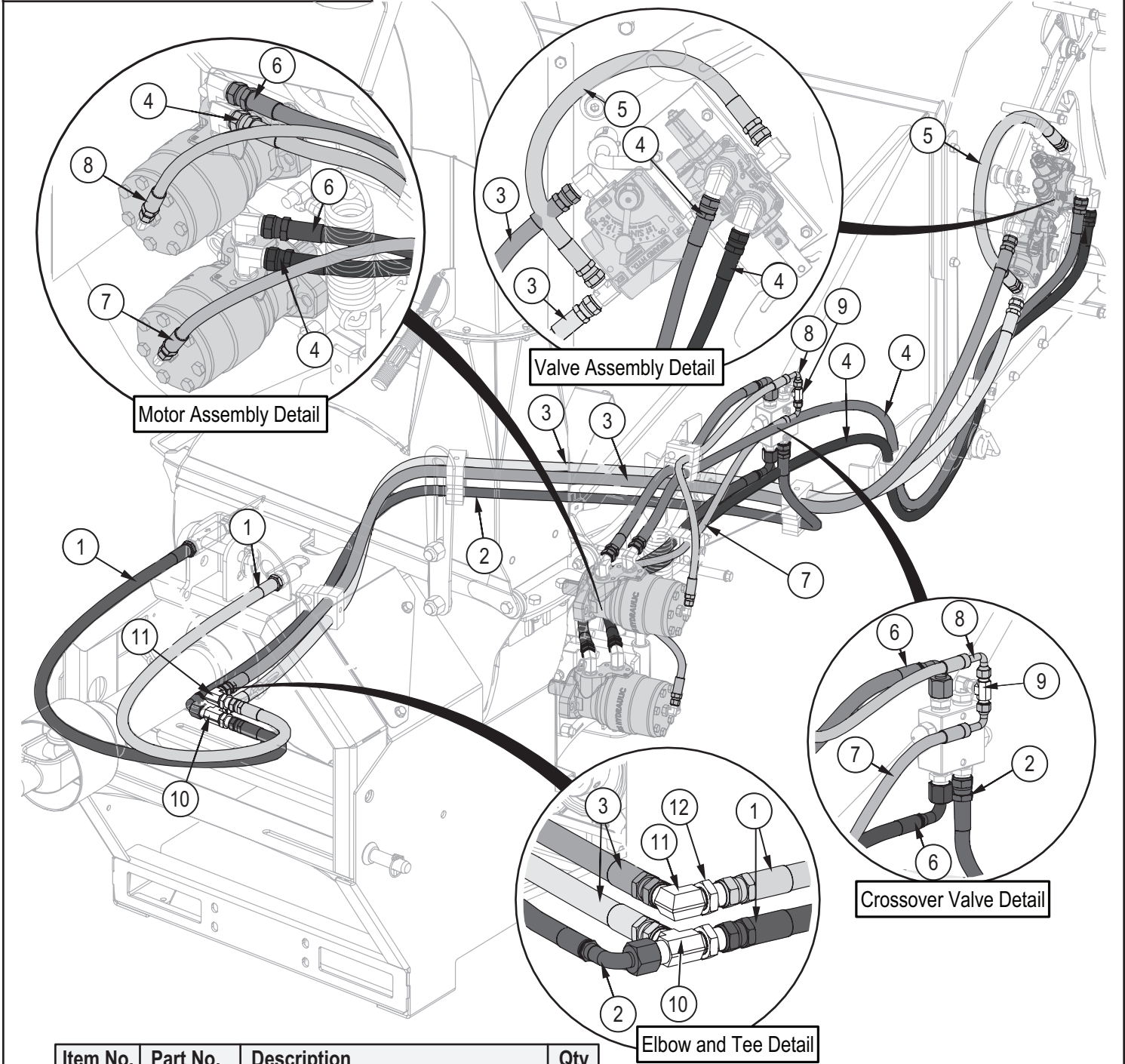
POS.	DESCRIPTION	Q.	Part #
01	YOKE	1	0800503
02	CROSS JOURNAL ASS.	2	08205
05	OUTER TUBE YOKE	1	08005021
08	FLEXIBLE PIN	1	098701075
12	CM. 100 CARDAN TUBE(*)	1	09881523100
13	CM. 100 CARDAN TUBE(*)	1	09881454100
16	FLEXIBLE PIN	1	0987001065
17	INNER TUBE YOKE	1	08005011
21	SHEAR BOLT M10X1.5X55	1	Z19407 (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

Wiring Harness



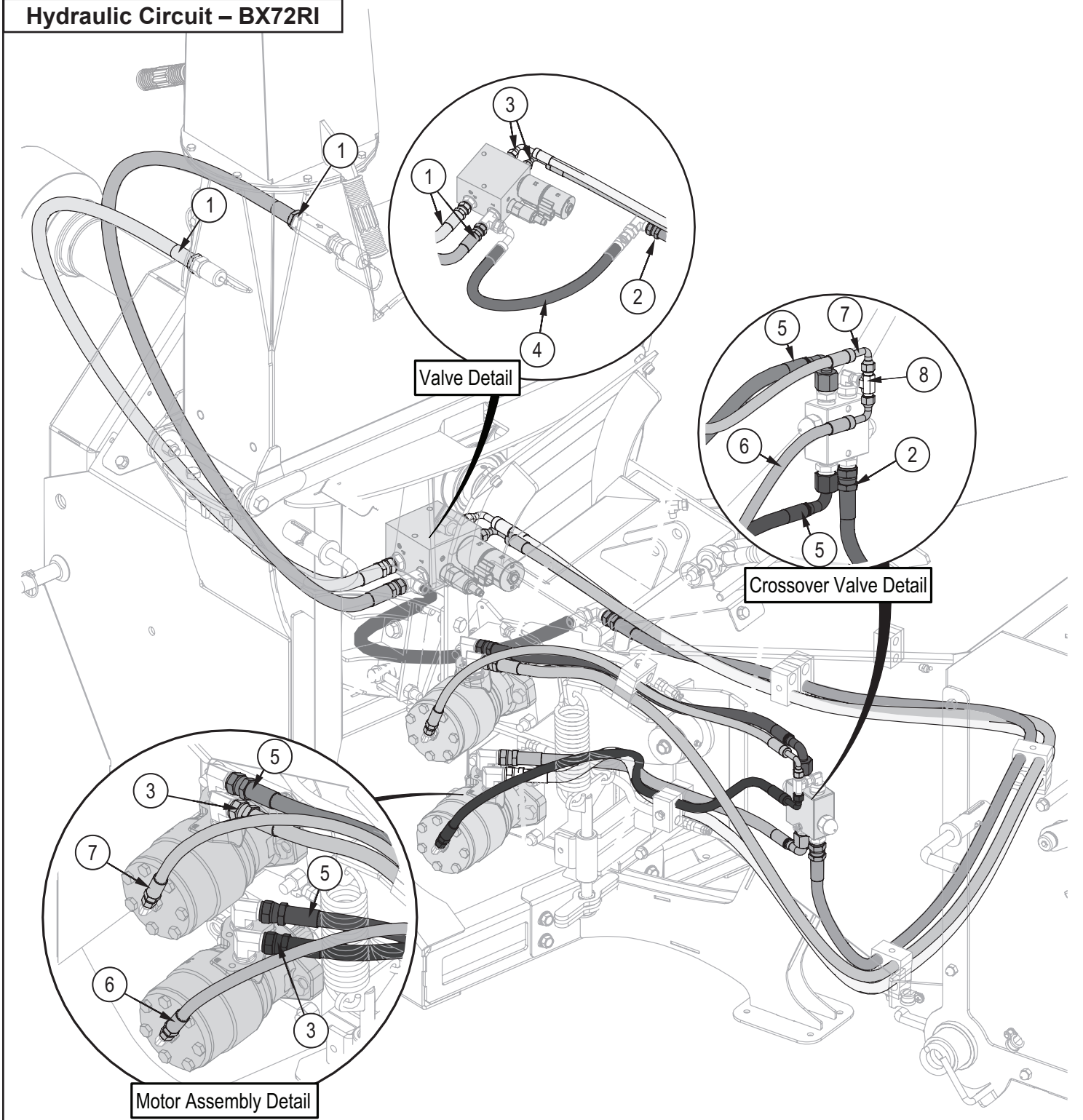
Item No.	Part No.	Description	Qty
1	Z62109	Wire Harness, IntelliFEED	1

Hydraulic Circuit – BX72R



Item No.	Part No.	Description	Qty
1	1023F101	1/2" Hose, FJIC08 x MP08 x 84"	2
2	1023F102	3/8" Hose, FJIC08 x 90FJIC08 x 68"	1
3	1023F104	1/2" Hose, FJIC08 x FJIC08 x 82"	2
4	1023F105	3/8" Hose, FJIC08 x FJIC08 x 70"	2
5	1023F108	1/2" Hose, FJIC08 x FJIC08 x 22"	1
6	1023F109	3/8" Hose, FJIC08 x 90FJIC08 x 23"	2
7	1023F110	1/4" Hose, FJIC04 x 90FJIC04 x 34"	1
8	1023F111	1/4" Hose, FJIC04 x 90FJIC04 x 26"	1
9	Z51488	Tee, MJIC x MJIC x MJIC 040404	1
10	Z51494	Tee, MJIC x BH x MJIC 080808	1
11	Z51492	Elbow 90, MJIC x BH 0808	1
12	Z51493	BH Locknut, 08	2

Hydraulic Circuit – BX72RI

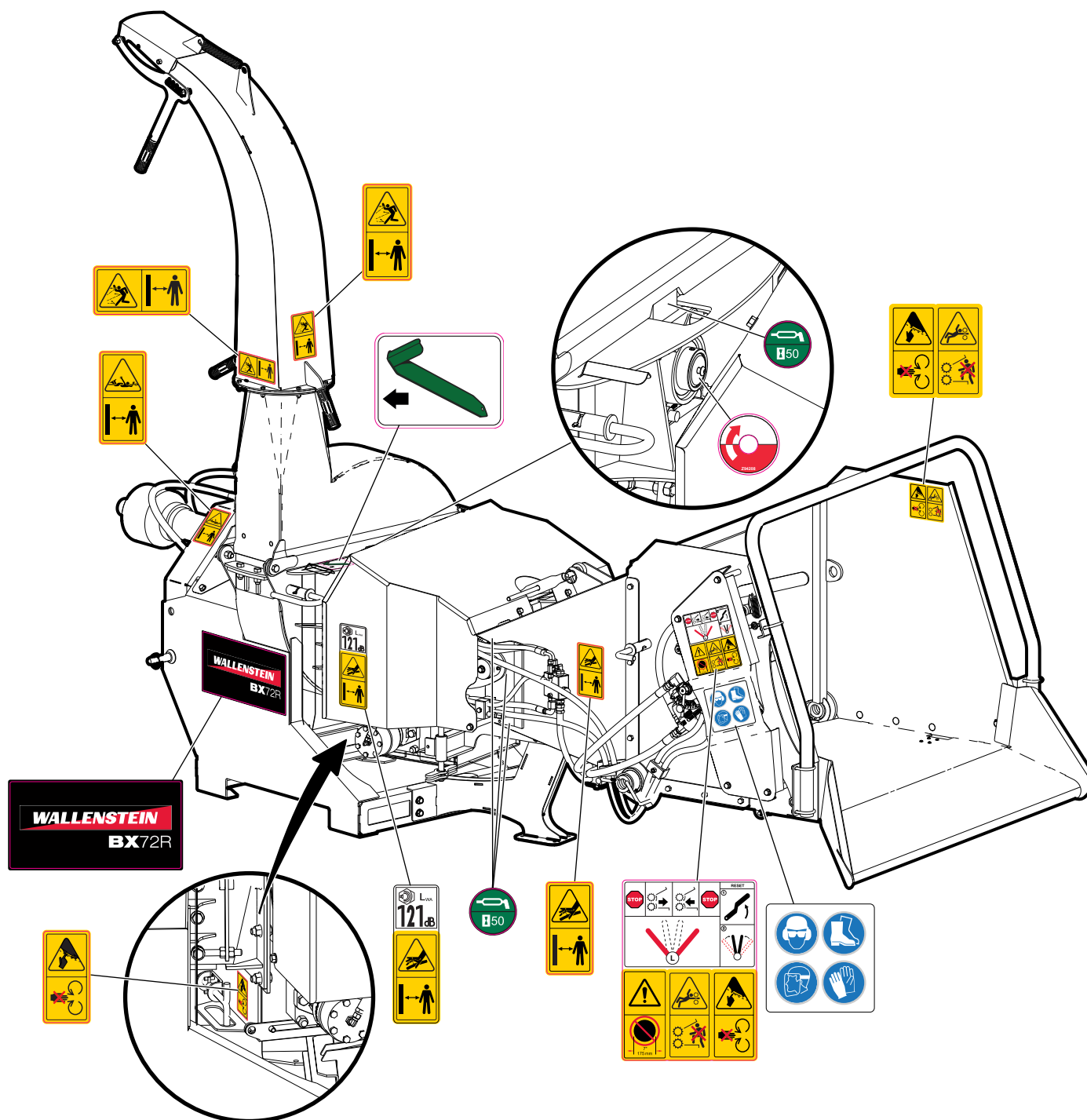


Item No.	Part No.	Description	Qty
1	1023F101	1/2" Hose, FJIC08 x MP08 x 84"	2
2	1023F103	3/8" Hose, FJIC08 x FJIC08 x 68"	1
3	1023F106	3/8" Hose, FJIC08 x 90FJIC06 x 106"	2
4	1023F107	1/2" Hose, FJIC08 x 90FJIC08 x 16"	1
5	1023F109	3/8" Hose, FJIC08 x 90FJIC08 x 23"	2
6	1023F110	1/4" Hose, FJIC04 x 90FJIC04 x 34"	1
7	1023F109	1/4" Hose, FJIC04 x 90FJIC04 x 26"	1
8	Z51488	Tee, MJIC x MJIC 040404	1

Decal Layout

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

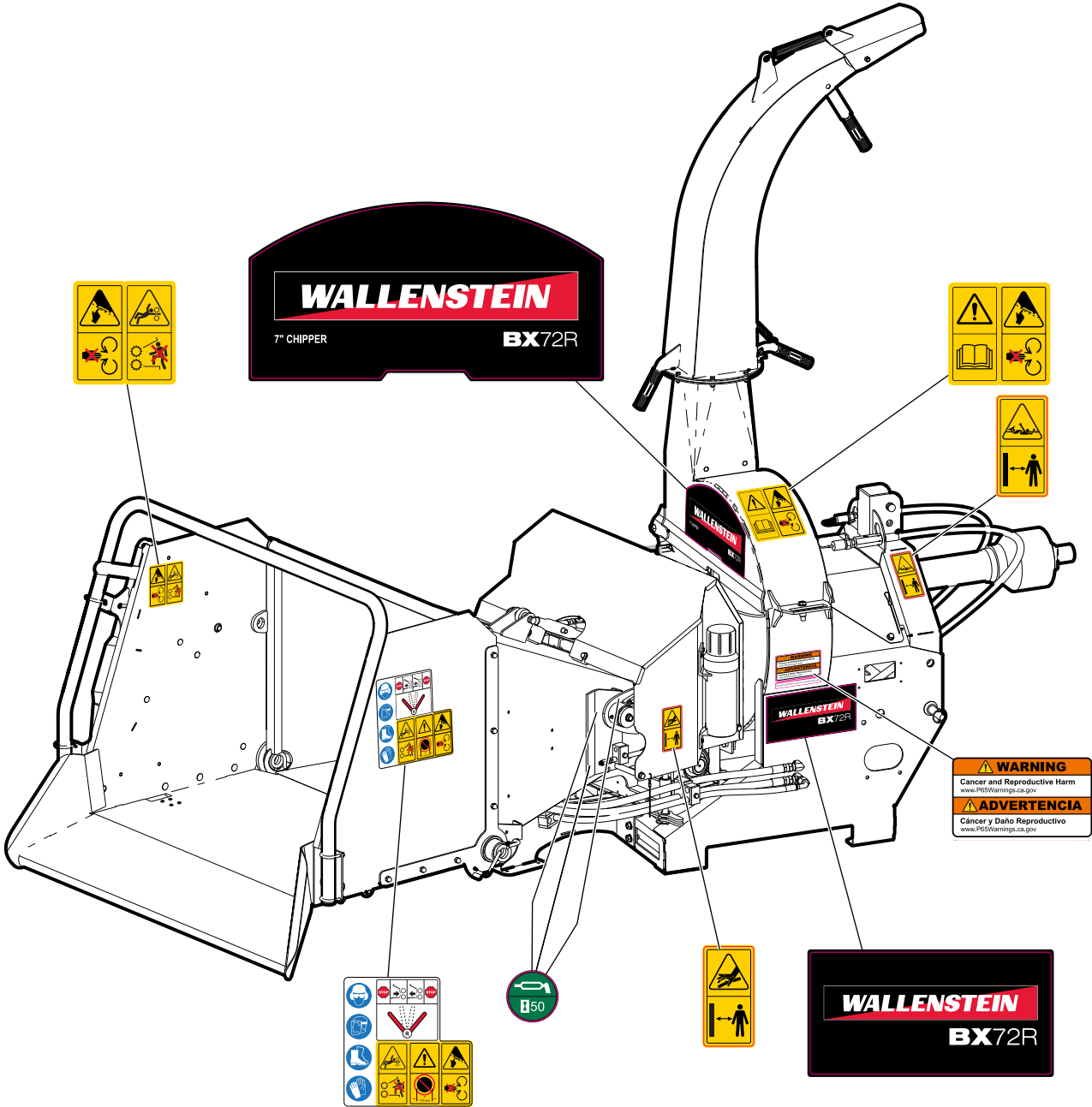
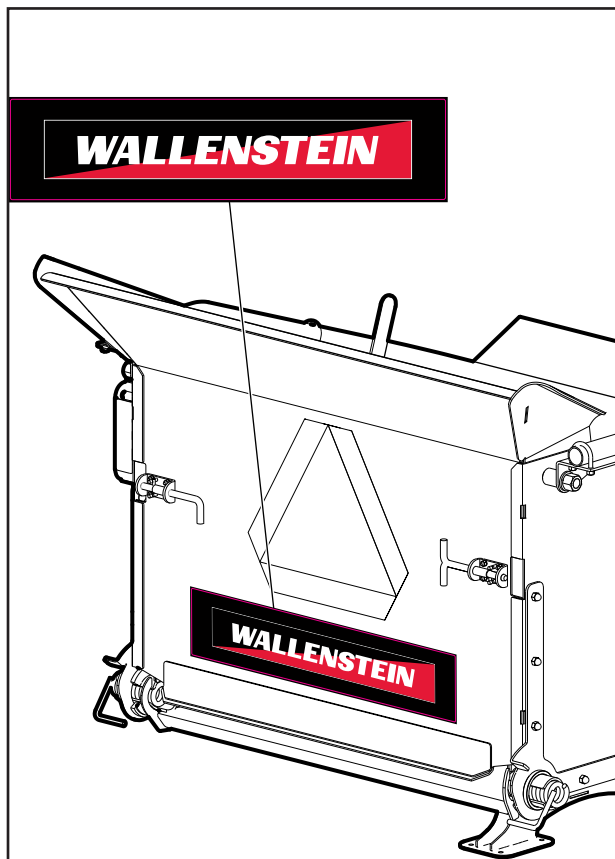
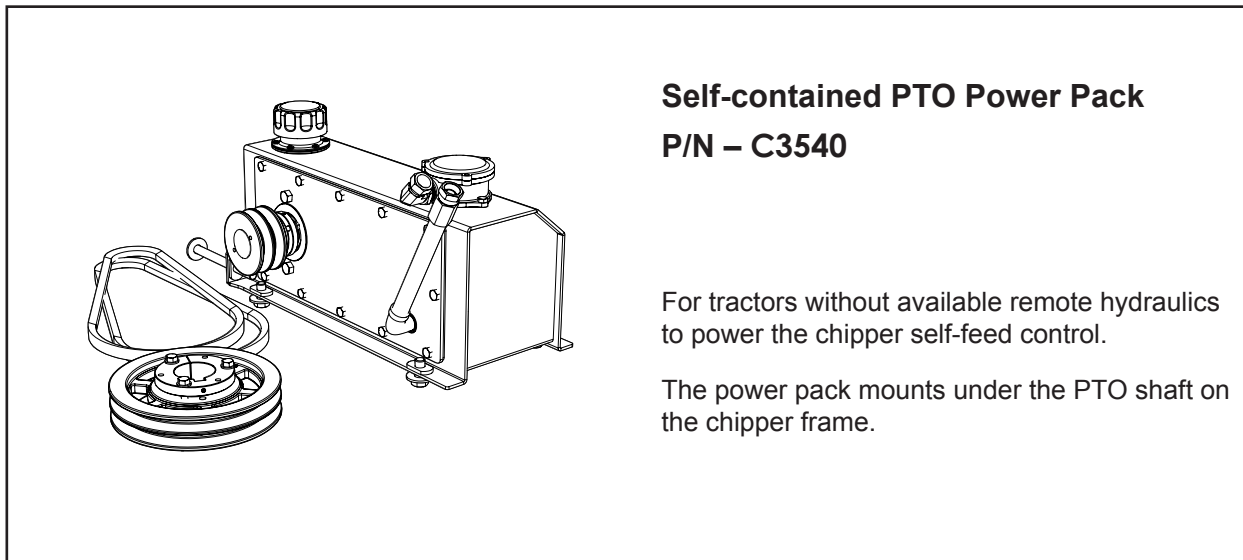


Diagram illustrating the Wallenstein BX72R chipper, showing its components and safety features. The machine is labeled **WALLENSTEIN** and **BX72R**. Key components and safety features are highlighted:

- WALLENSTEIN** logo and **BX72R** model designation.
- INTELLIFEED** ELECTRONIC CONTROL SYSTEM (BX72RI only).
- 540-1000 rpm** speed range indicator.
- B50** safety feature.
- SAFETY** warning symbols (e.g., falling object, sharp edges, rotation).
- 540 RPM 1000 RPM** speed range indicator.
- WALLENSTEIN** logo.



Accessories**Self-contained PTO Power Pack****P/N – C3540**

For tractors without available remote hydraulics to power the chipper self-feed control.

The power pack mounts under the PTO shaft on the chipper frame.

Call your dealer for pricing and availability

Common Bolt Torque Values

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



SAE Gr. 2



SAE Gr. 5



SAE Gr. 8

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



8.8



10.9

Hydraulic Fitting Torque Values

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.