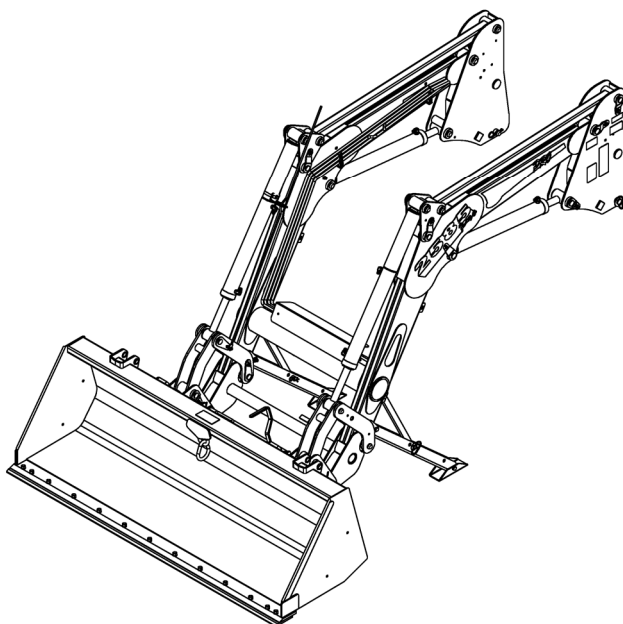


OWNERS MANUAL

MANUAL NO. 679755

11/18/21



**IMPORTANT-KOYKER DEALER
BE SURE THIS MANUAL IS GIVEN TO THE
PURCHASER FOR FUTURE REFERENCE
KOYKER MANUFACTURING CO., P.O. BOX 409
LENNOX, SD 57039**

Phone 1-800-456-1107 E-mail koyker@koykermfg.com

CONTENTS

| CONTENTS | PAGE |
|---|-------------|
| Introduction..... | 1 |
| SAFETY INFORMATION | |
| Safety Alert Symbol..... | 2 |
| Safety Information | 3-5 |
| Safety Decals | 6 |
| Tractor & Safety Pointers | 7 |
| ASSEMBLY INSTRUCTIONS | |
| Attaching Loader | 8 |
| Attaching Bucket | 9 |
| Detaching Loader..... | 10 |
| Detaching Bucket..... | 11 |
| OPERATING INSTRUCTIONS | |
| Operational..... | 12-13 |
| SERVICE AND MAINTENANCE | |
| Specifications..... | 14 |
| Loader Inspection, Service, and Maintenance | 15 |
| Hydraulic System Parts List..... | 16 |
| Hydraulic System Parts Diagram..... | 17 |
| Pro “2585” Loader Parts Diagram | 18 |
| Parts Identification Schedule | 19-20 |
| Euro Adapter Parts Diagram..... | 21 |
| Euro Adapter Parts Identification Schedule..... | 22 |
| Bucket Parts Diagram | 23 |
| Bucket Parts Identification Schedule | 24 |
| Accumulator Kit Parts Diagram..... | 25 |
| Accumulator Kit Parts Identification Schedule | 26 |
| Hydraulic Cylinder Information | 27 |
| Hydraulics Information..... | 28 |
| 3 1/4” Cylinder Service Kit..... | 29 |
| Hydraulic Cylinder Parts List | 30 |
| Hydraulic Cylinder Parts Diagram..... | 31 |
| Piston and Gland Diagram | 32 |
| LIMITED WARRANTY INFORMATION | |
| Limited Warranty..... | 33 |
| TORQUE SPECIFICATIONS | |
| Torque Specifications | 34 |

INTRODUCTION

Koyker Manufacturing Inc. has engineered and manufactured a PRO Loader that includes the features YOU want in a top-of-the-line loader, including:

- Greaseless Pivot Connections
- Large Chrome Pivot Pins
- Mechanical Self Leveling
- Bucket Linkage for Increased Roll Back Angle and Force
- Euro Attachment System
- Dual Torque Tubes
- Rounded Back Bucket
- Soft Ride Nitrogen Accumulator

Koyker Manufacturing Inc. has created one of the best loaders in the market through consumer research, product testing and by using the latest technological enhancements to deliver what you've been asking for... a loader that will get the job done with ease.

TO THE PURCHASER

You have purchased an excellent product. With proper care and use, it will give you years of good safe service. Use only **KOYKER** or **KOYKER** approved parts in the general maintenance and repair of your equipment. **Please fill out ownership registration card as soon as possible.**

Should you have any questions, comments, improvements, or suggestions regarding the contents of any of the manuals provided, please contact Koyker Manufacturing Company. (800-456-1107 or E-mail koyker@koykermfg.com)

We care about your safety!

Remember ALL safety decals are no charge from the factory. Please replace all safety decals if missing or damaged. Your safety is important to us.

SAFETY ALERT SYMBOL

The symbol shown below is used to call your attention to instructions concerning your personal safety. Watch for this symbol it points out important safety precautions. It means **ATTENTION! Become Alert! Your Personal Safety Is Involved!**

Read the message that follows and be alert to the possibility of personal injury or death.

DANGER: Indicates an imminently hazardous situation that, if not avoided, will result in death or serious injury.

WARNING: Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury.

CAUTION: Indicates a potentially hazardous situation that, if not avoided may result in minor or moderate injury.



WARNING!

Anyone who will operate or work around a front-end loader should first read this manual.



SAFETY

Improper use of a loader can cause serious injury or death. The following safety precautions, and those given on the tractor mount installation instructions, should be thoroughly understood before attempting to operate this machine.

BEFORE OPERATING:

Carefully study and understand this manual, the specific tractor mount instructions, and the attachment(s) manual(s).

Prior to operation, inspect the loader for system leaks and damaged, missing, or malfunctioning components in an effort to avoid the possibility of a dangerous failure involving structural members or hydraulic system components.

Be certain any repairs necessary are completed prior to loader operation.

Follow recommended maintenance procedures and precautions on Page 15.

Completely familiarize yourself and others involved with the operation of the hydraulic control valve before operating the loader.

Be certain all bystanders are clear of the machine and operation area prior to operation.

It may be necessary to add wheel ballast or rear weights as recommended by the tractor manufacturer to maintain stability of the machine to prevent tipping or upset which could result in serious injury or death. See mounting instructions for specific information.

It is recommended that both front and rear wheel treads be set to the widest recommended width to prevent tipping or upset which could result in serious injury or death.

This loader is designed for farm type operations such as snow removal, barn and feedlot cleaning, light commercial or light grading and digging. It's design is **NOT** intended for industrial use.

DURING OPERATION:

Never operate the machine other than from the tractor operator's seat.

Be sure operating area is clear of others during machine operations.

Never lift, hoist, or carry humans in the bucket or on any portion of the loader or loader attachments. Failure to heed, may result in serious injury or death.

SAFETY CONTINUED

Transport the machine load at the slowest speed possible and with the loader boom at the lowest transport position to avoid tipping or upsetting, which may result in serious injury or death.

Be extremely careful when working on inclines or near loose fill, rocks, and holes as they can cause tipping or upsetting which may result in serious injury or death.

Be certain to avoid overhead electrical wires when operating loader. Contact with power lines may cause serious injury or death.

Avoid sudden stops when lowering or lifting the loader boom to prevent loss of control over the machine and/or load, which may result in serious injury or death.

Use maximum ballast and the widest recommended wheel setting on your tractor when handling large shiftable loads.

Never attempt to ram with the bucket at high speed or full tractor power. Sudden impact may result in structural failure and possible serious injury or death.

Never adjust or perform maintenance on the loader or tractor with the unit in motion, or without power source locked out.

Never get under bucket or lift arms or reach through the lift arms or bucket linkage when the loader is in operation. Inadvertent movement may cause serious injury or death.

FOLLOWING OPERATION:

Whenever the machine is not in operation, lower the loader boom and set the tractor brakes, disengage drive, shut the engine off, and remove the ignition key before dismounting the tractor.

If loader is to be disengaged from tractor, be sure the loader is securely supported on a hard, level surface and the stand is securely engaged. Be certain all connections between tractor and loader are free before disengaging.

TRANSPORTING:

Use safety lights and SMV emblem in addition to whatever local codes require when equipment is being transported on the road or highway. Check with proper authorities for legal limitations.

Transport all loads at a slow and safe speed.

Carry the load as low as possible and maintain adequate visibility and good round clearance at all times.

SAFETY CONTINUED

PERFORMING MAINTENANCE:

Carefully review, understand, and follow the “maintenance” section in this owners manual before attempting to service loader.

Lower the bucket or attachment to the ground, shut off tractor engine, and relieve pressure in the hydraulic system before adjusting, or servicing the loader.

Escaping hydraulic oil under pressure can penetrate the skin. Never use any part of your body to check for hydraulic leaks. Use cardboard when checking for leaks. See Fig. 5-1. Relieve hydraulic pressure before disconnecting any hydraulic line. Failure to heed may result in serious injury or death.

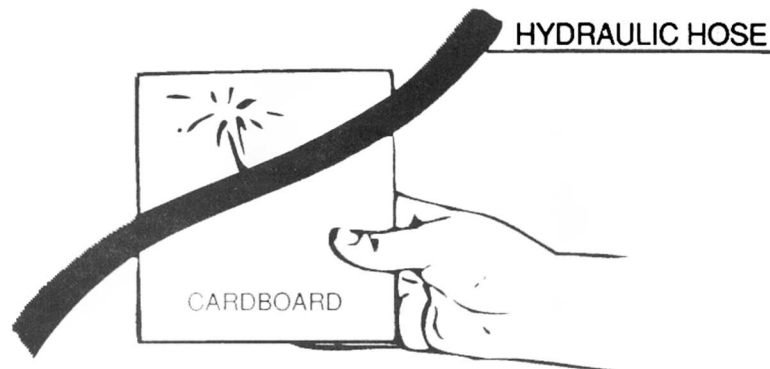
Before disconnecting hydraulic lines, lower the loader and attachments. Lock out the hydraulic supply and relieve all hydraulic pressure.

Replace any damaged or painted-over decals. See Page 6 for replacement decals.

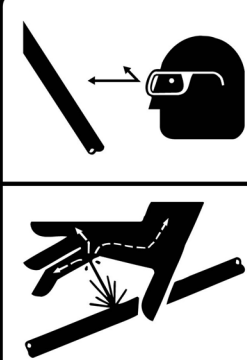
REMEMBER:

1. Move Slowly!
2. Always use care and common sense!
3. Be careful for your own sake and for that of others!
4. Koyker Mfg. Co. includes all reasonable means for accident prevention except a safe and careful operator.

FIG. 5-1



SAFETY DECALS

| | |
|---|---|
|  | <h2 style="margin: 0;">⚠ WARNING</h2> |
| | <p>HIGH-PRESSURE FLUID HAZARD</p> <p>To prevent serious injury or death:</p> <ul style="list-style-type: none"> • Relieve pressure on hydraulic system before servicing or disconnecting hoses. • Wear proper hand and eye protection when searching for leaks. <p>Use wood or cardboard instead of hands.</p> <ul style="list-style-type: none"> • Keep all components in good repair. • Refer to owners manual if injury should occur. |
| | 666943 |

| |
|--|
| <h2 style="margin: 0;">⚠ WARNING</h2> |
|  |
| <p>To avoid injury or death caused by falling loads:</p> <ul style="list-style-type: none"> • Do not handle round bales unless loader is equipped with approved bale handling attachments. • Handle raised loads with caution • Carry load low • Read operators manual |
| <h2 style="margin: 0;">⚠ WARNING</h2> |
|  |
| <p>To avoid injury from falls:</p> <ul style="list-style-type: none"> • Do not work from or allow riders on loaders or its attachments <p>KOYKER MFG CO. INCLUDES ALL REASONABLE MEANS FOR ACCIDENT PREVENTION EXCEPT A SAFE AND CAREFUL OPERATOR.</p> |
| 666944 |

| |
|---|
| <h2 style="margin: 0;">⚠ WARNING</h2> |
|  |
| <p>To avoid injury from falling loader:</p> <ul style="list-style-type: none"> • Do not walk or perform service under a raised loader. • Lower loader to ground when parked. <p>KOYKER MFG CO. INCLUDES ALL REASONABLE MEANS FOR ACCIDENT PREVENTION EXCEPT A SAFE AND CAREFUL OPERATOR.</p> |
| 666946 |

| |
|--|
| <h2 style="margin: 0;">⚠ DANGER</h2> |
|  |
| <p>Serious injury or death can result from rollovers.</p> <ul style="list-style-type: none"> • Use rops and seatbelt at all times. • Add required rear ballast. • Move wheels to widest recommended setting. • Operate tractor at low seeds. • Carry all loads close to ground. |
| <h2 style="margin: 0;">⚠ DANGER</h2> |
|  |
| <p>Serious injury or death can result from contact with electric lines.</p> <p>KOYKER MFG CO. INCLUDES ALL REASONABLE MEANS FOR ACCIDENT PREVENTION EXCEPT A SAFE AND CAREFUL OPERATOR.</p> |
| 666945 |

TRACTOR & SAFETY POINTERS

The use of good judgment and common sense is necessary by the operator in using this loader. The front and rear wheels should be set for the widest wheel tread to assure best stability. Use extra caution when rear wheel weights and tire ballast are added to a loader-equipped tractor. DO NOT ram into frozen dirt piles, frozen manure piles, ice, etc., with great momentum where sudden shock loads are encountered. Serious and costly damage may result to both the loader and the tractor.

When scraping or back dragging do not extend the attachment cylinders more than one half of the cylinder's stroke. A limited amount of leveling may be done, when the loader valving is arranged with a float control. This will prevent damage to cylinder rods. Never ride in the bucket.

Before operating the loader, be sure no one is standing near it. Only one person, the operator, should be on the tractor. Remain at the controls and under no circumstances leave the tractor unattended with the bucket in a raised position.

Never lift a person in the bucket or walk under a raised bucket.

Never drive your loader-equipped tractor down a hill that is steeper than 15 degrees. Carry all loads low and use care on side hills.

Always keep unused PTO shaft clutch levers disengaged.

Keep hands, feet, and clothing away from all moving parts.

Hydraulic oil, under pressure, can cause injury. Be sure that all connections are tight and that all pressure is relieved before disconnecting any lines.

Care must be taken with your loader cylinders. Nicks, scratches, rust, or other shaft damage can result in worn packing causing cylinder leakage and subnormal performance.

MOVE SLOWLY

USE COMMON SENSE

BE CAREFUL FOR YOUR OWN SAKE AND THAT OF OTHER PEOPLE

ATTACHING LOADER



IMPORTANT:

Never attempt loader attachment on grades which are not reasonably level.



Fig 8-1



Fig 8-2



Fig 8-3

1. Check to be sure that the surfaces of the mounts are free of obstructions. (Fig 8-1)
2. Drive the tractor slowly and carefully in between the loader arms only far enough to permit hook-up of the hydraulic system hoses.
3. Once all hoses have been properly coupled drive the tractor forward checking to insure that the top pivot shaft on each loader upright clears the top cradle on each mount tower. (Fig. 8-2)
4. Allow the top pivot shaft to settle into the cradle on the top of each mount tower. After the uprights slide into the mount raise the loader slowly to engage firmly into the mount cradles. (Fig. 8-3)
5. To lock the loader onto the mount, install the two 669514 – 1 3/8” diameter mount pins into the outside of the upright through the mount tightener, and pin with hitch pin on other side. (Fig. 8-4)
6. To secure the loader to the mount tighten the 1” bolt at the back of the mount tower. (Fig. 8-5) Re-check bolts after first three hours of use.
7. After both uprights are secured to the mounts, raise the loader still further to disengage and store the loader stands with provided mount pins. (Fig 8-6) & (Fig 8-7)
8. Prior to operation, be certain to review all safety and operation information contained within this manual. Check bolts on back of mount or the first 3 hours of use, then check periodically during normal maintenance procedure.



Fig 8-4



Fig 8-5



Fig 8-6



Fig 8-7

ATTACHING BUCKET

1. Prior to attaching the bucket, prepare the adapter for engagement by pulling the adapter handle back (towards the operator) into its cocked position. With the bucket positioned on level ground, tilt the bucket adapter forward approximately 45°. (Fig 9-1) Slowly drive forward into the bucket, centering the adapter with the bucket as you go and position the top mount bar of the adapter just below the hooks on the back side of the bucket. (Fig 9-2) Slowly raise the loader paying attention that both hooks are engaged. With the top mount bar fully engaged, slowly roll the bucket back. The bottom mount bar of the adapter will come in contact with the bottom of the bucket. (Fig 9-3) Continue to slowly roll bucket until the adapter handle comes in contact with its stop and engages itself with the bucket. (Fig 9-4) If the adapter handle does not come in contact with its stop, lower the loader until it engages.



Fig. 9-2

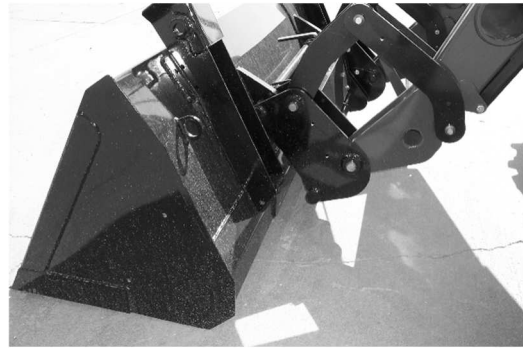


Fig. 9-1



Fig. 9-3

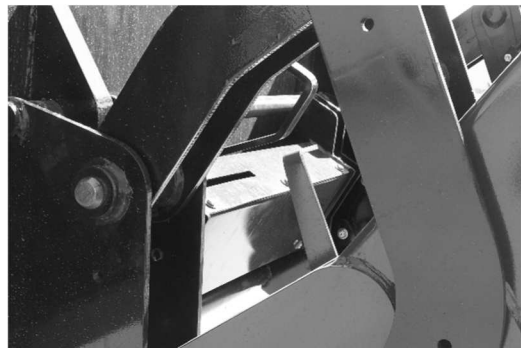


Fig. 9-4

DETACHING LOADER



IMPORTANT:

Never attempt loader attachment on grades which are not reasonably level.



Fig 10-1



Fig 10-2



Fig 10-3

1. Raise loader frame slightly to permit loader stand reengagement. (Fig. 10-1)
2. Lower bucket to ground and tip slightly forward to apply pressure to mount connection. Note: This will prevent the loader from inadvertently rocking forward when the mount pins are removed and uprights are disengaged from it's cradle. (Fig. 10-2)
3. Loosen the 1" bolt at the back of the mount enough to permit the removal of the mount pins. (Fig. 10-3)
4. Use the lift cylinders to disengage the bottom anchor bar from the mount tower. Then tilt the bucket back to rotate the top of the upright up and out of the cradle, and into a storage position. (Fig. 10-4)
5. Before completely backing out, disconnect and store the loader system hydraulic hoses. It is important that the hoses be properly stored to keep the hose couplers as clean as possible. (Fig 10-5)

IMPORTANT:

Never store the detached loader where insufficient soil bearing capacity exists. Good firm clay or firmly packed dirt are sufficient, providing the area is dry. If you are unsure, use blocking under the stand foot to disperse the load. Failure to heed, may allow the loader to settle and prevent attachment at later date.



Fig 10-4



Fig 10-5

DETACHING BUCKET

1. Prior to detaching the bucket, prepare the adapter for disengagement by pulling the adapter handle back (towards the operator) into its cocked position (Fig 11-1 & Fig 11-2). The bucket should be resting on level ground. Slowly lower and dump your way out of the bucket (Fig 11-3). Slowly back away from the bucket until you are clear of the bucket and safe to maneuver (Fig 11-4).



Fig 11-1



Fig 11-2



Fig 11-3



Fig 11-4

OPERATION



WARNING:

Never allow anyone to operate the loader until they have carefully reviewed and understood this owners manual.

FILLING THE BUCKET:

When manure is piled on a slope, it is best to drive tractor up the slope straight into the pile. Operating sideways on a slope has a tendency to tip the loading unit. Drive tractor straight into the pile, raise the bucket about six inches, then drop bucket and drive forward until the bucket is filled. Tilt bucket completely back, raise main frame and back away from manure pile.

DUMPING THE BUCKET:

When dumping, bring the bucket to proper dumping height which is just high enough so it will not strike the spreader as the load is being dumped. With the bucket tipped, drive tractor forward and raise the bucket at the same time to distribute the load evenly into spreader or conveyance.

RAISING THE BUCKET:

WARNING:



Make sure material in bucket cannot spill out on to tractor when loader boom is raised. Keep clear of overhead obstructions such as trees, limbs or power lines when raising the bucket.

Side cutting is the best method of reducing large stockpiles. If the sides of the pile are too high, use the loader to pull them down and reduce the possibility of slides.

Make sure you keep all lines, cylinders, and complete hydraulic system free of all sand, dirt, and foreign matter. Use only clean oil in the hydraulic system. When removing the loader from the tractor, be sure to plug all open ports. If the loader will be out of service for several days or longer, grease the exposed polished piston shafts on the bucket and the lift cylinders.

WARNING:

NEVER attempt to operate the loader with someone near the loader frame or bucket.



If this loader is equipped with a Grapple fork, be sure Grapple teeth are closed before leaving seat of tractor.

OPERATION CONTINUED

SOFT RIDE FEATURE:

The soft ride feature was designed to diminish the stresses on the tractor, mounts, loader and operator while transporting heavy loads to and from the field. The soft ride feature incorporates a pre-charged nitrogen accumulator to act as a shock absorber similar to that of an automobile. While in operation the loader may feel “squishy” or soft.

1. Mount the loader and plumbing kit. Relieve the lift cylinder pressure on the loader.
2. Locate the lift hose (bottom steel line) on the loader. Disconnect the hose. **See in Fig. 1-1.**
3. Install the run tee. Point the tee down.
4. Attach the accumulator block to the bracket. Secure with two 1/4” x 3” HH cap screws, lock washers and nuts.
5. Attach the fittings (one on top and two on bottom of block). Install the accumulator. (See page 26)
6. Using two 1/2” x 1 1/2” HH cap screws, lock washers and hex nuts attach the accumulator bracket to the upright of the loader .
7. Run 3/6” hydraulic hose from accumulator to the run tee on the bottom steel line. **TIGHTEN ALL THE CONNECTIONS SECURELY!**
8. Start the tractor. Actuate the loader to charge the hydraulic system. Add hydraulic fluid as required using the recommended amount for your tractor.



Fig 1-1

SPECIFICATIONS

KOYKER PRO 2585 LOADER SPECIFICATIONS

Description of Equipment Rated

| | |
|---------------------------------------|-------------|
| Loader Model..... | PRO 2585 |
| Attachment Adapter & Bucket Size..... | 6' |
| Rated Flow..... | 25 GPM |
| Maximum Pressure..... | 2500 PSI |
| Lift Cylinder Dia..... | 3 1/4" Bore |
| Attachment Cylinder Dia..... | 3 1/4" Bore |
| Tractor Horsepower Range..... | 90-180 HP |

Dimensional Specifications

| | |
|--|---------|
| (A) *Maximum Lift Height to Pivot Pin..... | 13' 9" |
| (B) *Lift Height under Level Bucket..... | 12' 11" |
| (C) *Clearance with Bucket Fully Dumped..... | 10' 8" |
| (D) *Reach at Maximum Lift Height..... | DNA |
| (E) Maximum Dump Angle..... | 46° |
| (F) *Reach with Bucket on Ground..... | DNA |
| (G) Maximum Rollback Angle..... | 31° |
| (H) *Digging Depth..... | 5" |
| (J) *Overall Height in Carry Position..... | 7' 2" |

Operational Specifications

| | |
|--|-----------|
| (U) *Lift Capacity to Maximum Height at Pivot Pin..... | 5067 lbs. |
| (V) *Lift Capacity to Maximum Height 31.5" Forward of Pivot Pin..... | 3527 lbs. |
| (Y) *Breakout Force at Ground Line at Pivot Pin..... | 6802 lbs. |
| (Z) *Breakout Force at Ground Line 31.5" Forward of Pivot Pin..... | 5059 lbs. |
| *Raising Time..... | 5 seconds |
| *Lower Time..... | 3 seconds |
| *Attachment Dumping Time..... | 4 seconds |
| *Attachment Rollback Time..... | 3 seconds |

*Specifications based on ASABE standards S301.3 (Front-End Agricultural Loader Ratings) The above information is based on testing done by Koyker Mfg. Variations in maximum lift height and other specs for different tractors are due to tire sizes, variations in loader mounting locations and hydraulic system efficiency.

Specifications are subject to change without notice and without liability therefore.

LOADER INSPECTION, SERVICE, AND MAINTENANCE

Lower the bucket to the ground, shut off tractor engine, and relieve the pressure in the hydraulic system before adjusting, lubricating, or servicing the loader.

Periodically check all bolts for looseness and re-torque if necessary.

Before storage, be certain all hydraulic cylinders are fully collapsed so that the rod will not be exposed to the elements or damaged.

Be certain hydraulic system remains sealed at all times to prevent contamination.

Check and maintain an adequate fluid level in the tractor reservoir prior to use.

Inspect all hydraulic system hoses and fittings. Replace prior to further operation if damaged.

Periodically inspect the two grease fittings for the engagement pins. See page 21 for adapter break parts diagram.



WARNING!

Escaping hydraulic oil under pressure can penetrate the skin. Never use body to check for hydraulic leaks. Use cardboard when checking for leaks. See Fig. 13-1. Relieve hydraulic pressure before disconnecting any hydraulic line. Failure to heed may result in serious injury or death.

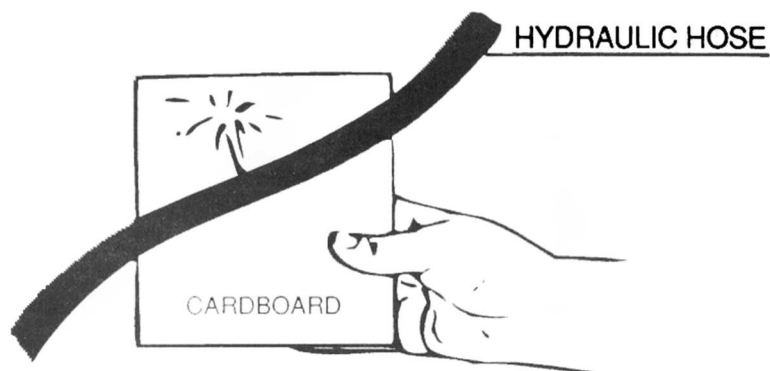
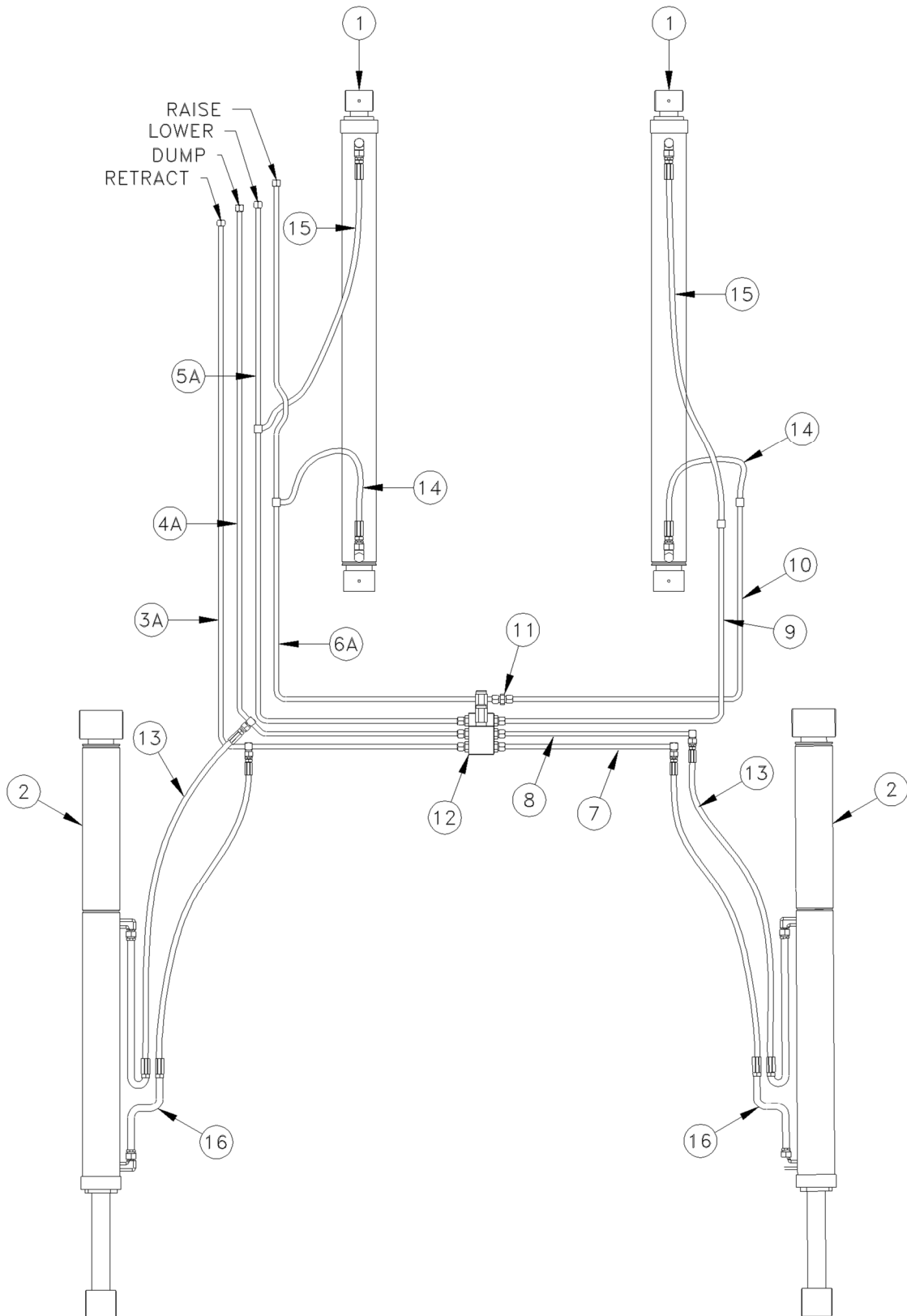


FIG. 13-1

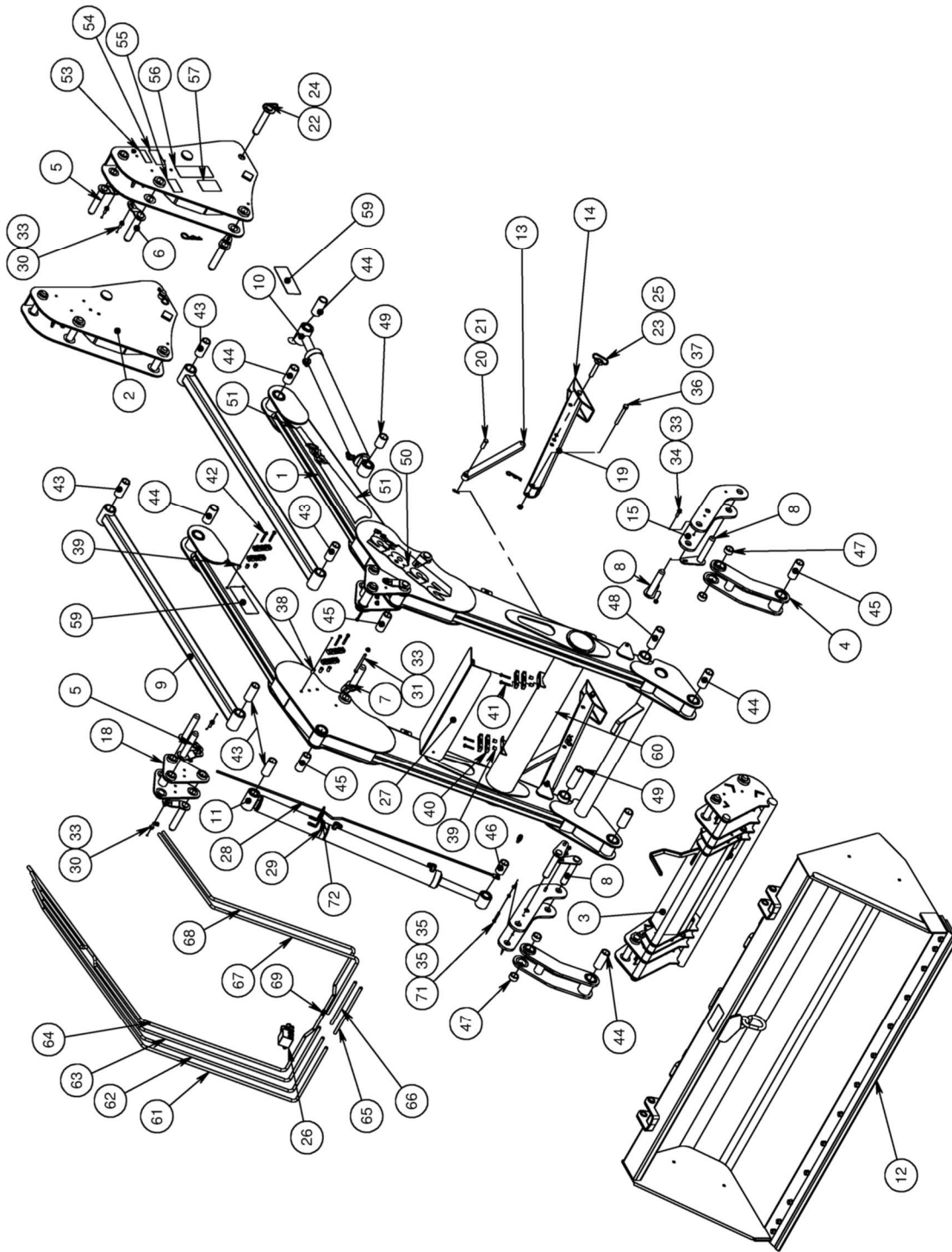
HYDRAULIC SYSTEM PARTS LIST

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|-------------------------------|------|
| 1 | 679260 | 3 1/4" LIFT CYLINDER | 2 |
| 2 | 680735 | 3 1/4' BUCKET CYLINDER | 2 |
| 3 | 679760A | 1ST OIL LINE (A) | 1 |
| 4 | 679761A | 2ND OIL LINE (A) | 1 |
| 5 | 679762A | 3RD OIL LINE (A) | 1 |
| 6 | 679763A | 4TH OIL LINE (A) | 1 |
| 7 | 679760B | 1ST OIL LINE (B) | 1 |
| 8 | 679761B | 2ND OIL LINE (B) | 1 |
| 9 | 679762B | 3RD OIL LINE (B) | 1 |
| 10 | 679763B | 4TH OIL LINE (B) | 1 |
| 11 | 663508 | HYDRAULIC ADAPTER 8MJX - 8MJX | 1 |
| 12 | 679627 | CROSS PORT RELIEF | 1 |
| 13 | 679765 | 49" HYDRAULIC LINE HOSE | 2 |
| 14 | 663188 | 18" HYDRAULIC HOSE | 2 |
| 15 | 673799 | 20" HYDRAULIC HOSE | 2 |
| 16 | 679764 | 29" HYDRAULIC LINE HOSE | 2 |

HYDRAULIC SYSTEM PARTS DIAGRAM



KOYKER "PRO 2585" LOADER PARTS DIAGRAM



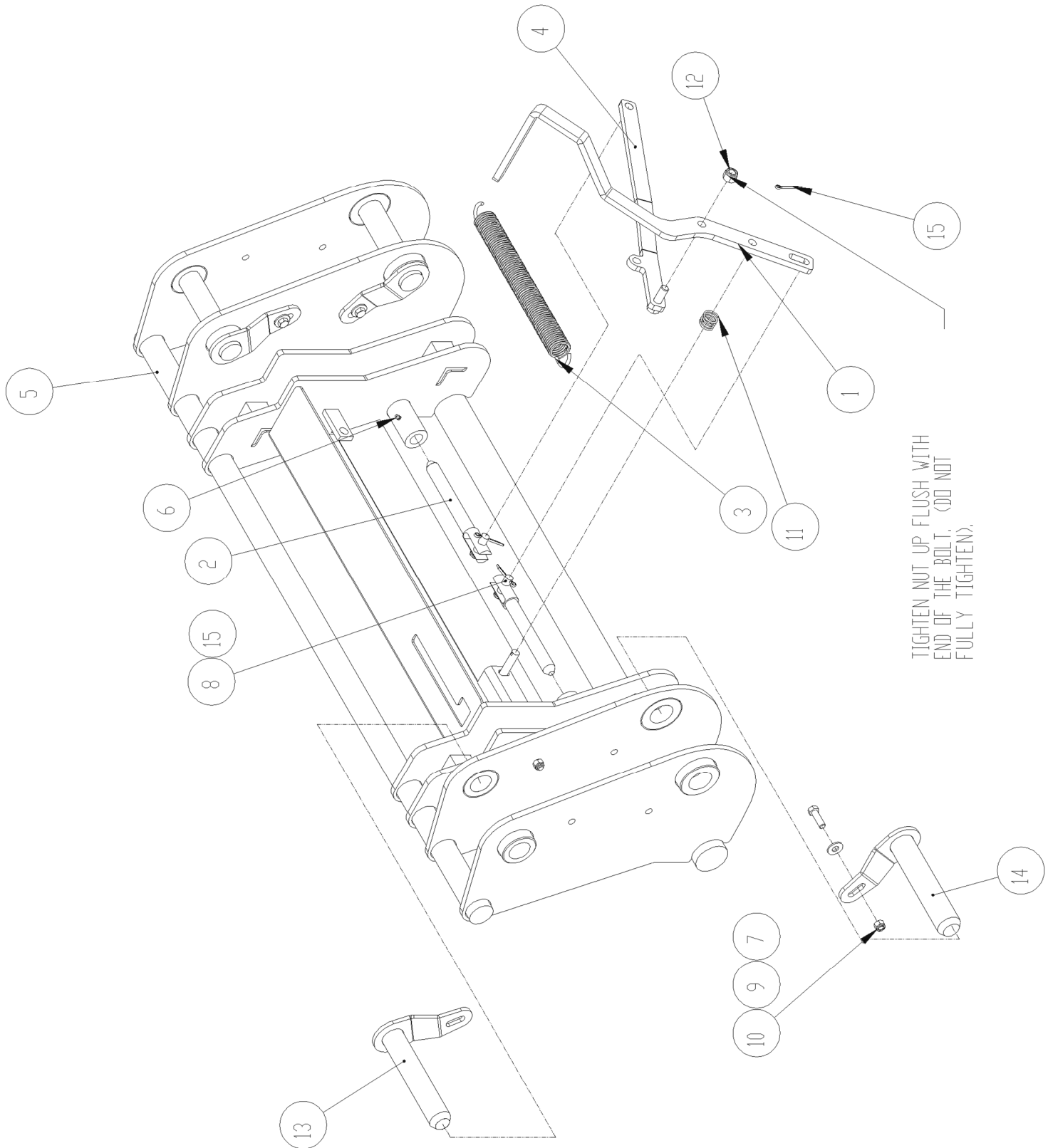
PARTS IDENTIFICATION SCHEDULE

| KEY | PART NUMBER | DESCRIPTION | QTY |
|-----|-----------------------|----------------------------------|-----|
| 1 | 678254 | MAINFRAME WLDT 2585 | 1 |
| 2 | Call Customer Service | 2585 UPRIGHT WLDT | 2 |
| 3 | 679238 | EURO ATTACHMENT ASSEMBLY | 1 |
| 4 | 679276 | FRONT LINKAGE WLDT | 2 |
| 5 | 678243 | 1 3/8" X 7 1/2" PIN WLDT | 8 |
| 6 | 678245 | 1 1/2" X 7 1/2" PIN WLDT | 4 |
| 7 | 679272 | 1 1/2 X 6 1/4 PIN WLDT | 2 |
| 8 | 679256 | 1 3/8" X 7 1/2" PIN WLDT FLAT | 4 |
| 9 | 679205 | LEIVING ARM WLDT | 2 |
| 10 | 679260 | 2585 LIFT CYLINDER ASSEMBLY | 2 |
| 11 | 679246 | 2585 BUCKET CYLINDER ASSEMBLY | 2 |
| 12 | 689070 | 7' EURO BUCKET ASSEMBLY | 1 |
| | 689071 | 8' EURO BUCKET ASSEMBLY | 1 |
| | 689072 | 8 1/2' EURO BUCKET ASSEMBLY | 1 |
| 13 | 679289 | LEG STAND SUPPORT | 2 |
| 14 | 679288 | LEG STAND FOOT | 2 |
| 15 | 679258 | LH REAR LINKAGE WLDT | 1 |
| 16 | 679257 | RH REAR LINKAGE WLDT | 1 |
| 17 | 679340 | LATCH BRACKET | 2 |
| 18 | 679618 | SELF LEVELING PIVOT WLDT | 2 |
| 19 | 679414 | LEG STAND | 2 |
| 20 | 681165 | CLEVIS PIN .75" X 2" | 2 |
| 21 | 640671 | HITCH PIN #3 | 2 |
| 22 | 669514 | MOUNT PIN | 2 |
| 23 | Call Customer Service | MOUNT PIN WELDMENT | 2 |
| 24 | 660006 | HITCH PIN CLIP #6 | 2 |
| 25 | 640246 | #6 HITCH PIN | 2 |
| 26 | 679627 | CROSS PORT RELIEF | 1 |
| 27 | 679729 | OIL LINE COVER WLDT | 1 |
| 28 | 679709 | INDICATOR ROD (Zinc Coated) | 1 |
| 29 | 679789 | 3.25 - 4.125 HOSE CLAMP | 1 |
| 30 | 683297 | SCREW-.4375-14 X 1.25 GR 5 HHC | 12 |
| 31 | 683298 | SCREW - .4375-14 X 5.00 GR 5 HHC | 2 |
| 32 | 640154 | WASHER - 3/8" FLAT | 2 |
| 33 | 682857 | NUT - .4375 - 14 FLANGE LOCK | 16 |
| 34 | 682856 | SCREW-.375-16 X 1.50 GR 5 HHC | 1 |

PARTS IDENTIFICATION CONTINUED

| KEY | PART NUMBER | DESCRIPTION | QTY |
|-----|-------------|--|-----|
| 35 | 654121 | NUT - .375 - 16 GR 2 LOCK NYLON INSERT | 4 |
| 36 | 162279 | SCREW - .625-11 X 5.00 GR 5 HHC | 4 |
| 37 | 640141 | NUT - .625-11 GR 5 CENTER LOCK | 4 |
| 38 | 676798 | INSERT-.313-18 | 4 |
| 39 | 673336 | INSERT-.313-18 | 11 |
| 40 | 672503 | OIL LINE CLAMP | 18 |
| 41 | 673615 | SCREW - .3125-18 X 2.00 HHSLDR | 4 |
| 42 | 676797 | SCREW - .3125-18 X 2.50 HHSLDR | 5 |
| 43 | 677829 | 1.384" X 4.25" NYLATRON BUSHING | 6 |
| 44 | 677831 | 1.509" X 4.25" NYLATRON BUSHING | 6 |
| 45 | 677832 | 1.384" X 4.5" NYLATRON BUSHING | 4 |
| 46 | 678240 | 1.384" X 3" NYLATRON BUSHING | 2 |
| 47 | 679642 | 1.384" X 1" NYLATRON BUSHING | 4 |
| 48 | 679766 | 1.384" X 5.25" NYLATRON BUSHING | 2 |
| 49 | 679266 | 1.509" X 2.75" NYLATRON BUSHING | 2 |
| 50 | | PRO 2585 DECAL | 2 |
| 51 | | RH PRO STRIPE | 1 |
| 52 | | LH PRO STRIPE | 1 |
| 53 | 666941 | SERIAL NUMBER DECAL | 1 |
| 54 | 654629 | AMERICAN MADE DECAL | 2 |
| 55 | 672275 | OPERATION DECAL | 2 |
| 56 | 666944 | WARNING DECAL | 1 |
| 57 | 666946 | WARNING DECAL | 2 |
| 58 | 666945 | "DANGER DECAL" | 1 |
| 59 | 666943 | HYDRAULIC PRESSURE DECAL | 5 |
| 60 | 680205 | KOYKER DECAL | 1 |
| 61 | 679760A | 1ST OIL LINE (A) | 1 |
| 62 | 679761A | 2ND OIL LINE (A) | 1 |
| 63 | 679762A | 3RD OIL LINE (A) | 1 |
| 64 | 679763A | 4TH OIL LINE (A) | 1 |
| 65 | 679760B | 1ST OIL LINE (B) | 1 |
| 66 | 679761B | 1ST OIL LINE (B) | 1 |
| 67 | 679762B | 3RD OIL LINE (B) | 1 |
| 68 | 679763B | 4TH OIL LINE (B) | 1 |
| 69 | 663508 | FITTING - HYD ADA 8MJX - 8MJX | 1 |
| | 679788 | ACCUMULATOR KIT | 1 |
| 71 | 680743 | SCREW-.375-16 X 2.50 GR 5 HHT | 1 |
| 72 | 680752 | INDICATOR PLATE (Zinc Coated) | 1 |

EURO ADAPTER PARTS DIAGRAM

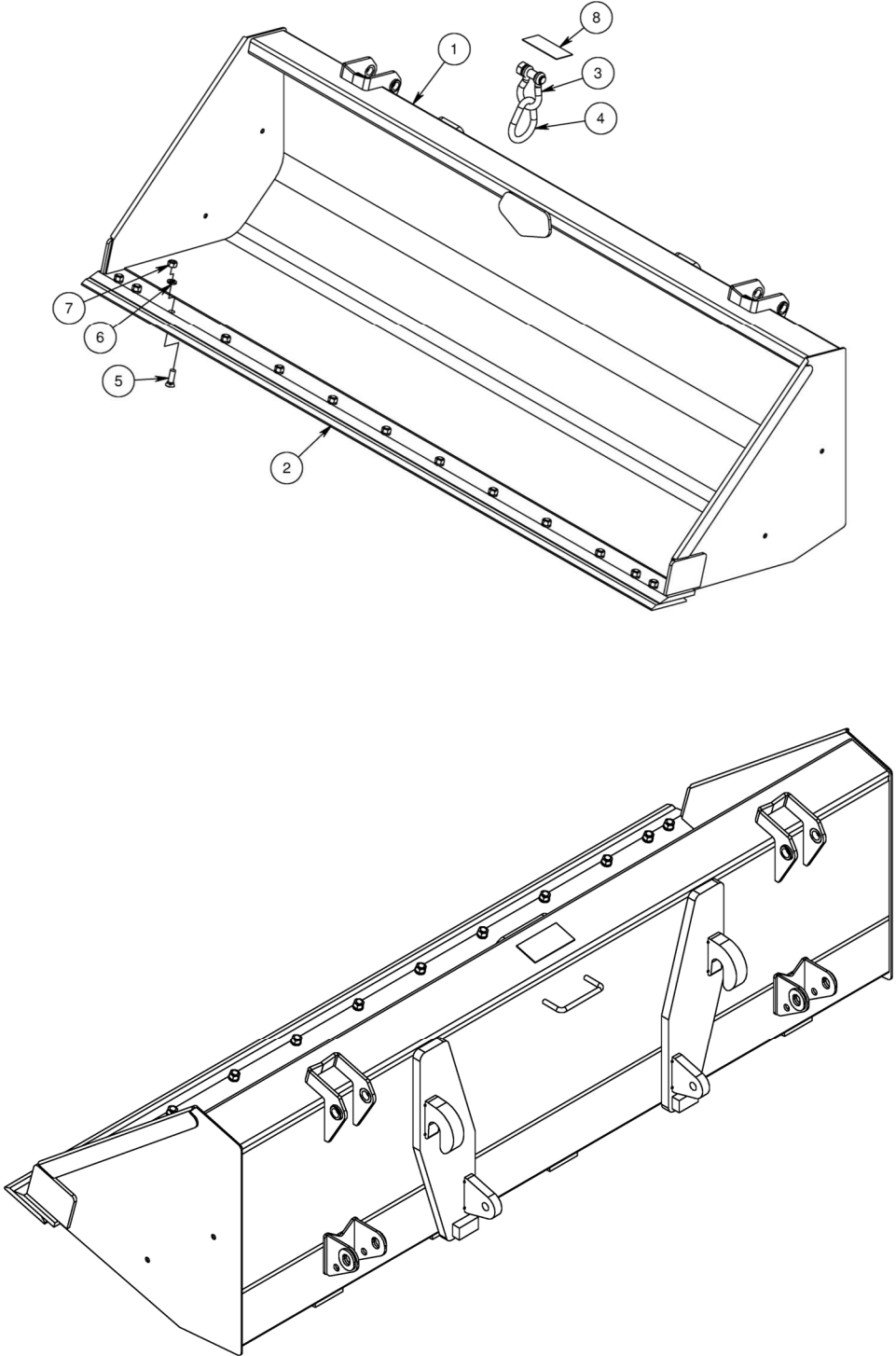


TIGHTEN NUT UP FLUSH WITH
END OF THE BOLT. (DO NOT
FULLY TIGHTEN).

EURO ADAPTER PARTS IDENTIFICATION SCHEDULE

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|--|------|
| 1 | 680769 | Euro Adapter Handle (Painted) | 1 |
| 2 | 679304 | .79" (20 MM) x 8" Pivot Pin | 2 |
| 3 | 679308 | EXTENSION SPRING | 1 |
| 4 | 680766 | CROSS MEMBER WLDT | 1 |
| 5 | 679316 | EURO ATTACHMENT WLDT | 1 |
| 6 | 657632 | ZERK-1/4-28 GREASE | 2 |
| 7 | 640032 | SCREW-.375-16 X 1.25 GR 5 HHC | 4 |
| 8 | 680761 | CLEVIS PIN .5" X 1.5" | 2 |
| 9 | 640154 | WASHER - 3/8" FLAT | 4 |
| 10 | 654121 | NUT - .375 - 16 GR 2 LOCK NYLON INSERT | 4 |
| 11 | 680767 | COMPRESSION SPRING | 1 |
| 12 | 660638 | NUT - .500 - 13 GR 2 LOCK NYLON INSERT | 1 |
| 13 | 678248 | 1 3/8" X 7 7/8" PIN WLDT | 2 |
| 14 | 678249 | 1 1/2" X 7 7/8" PIN WLDT | 2 |
| 15 | 680768 | COTTER PIN - .156 X 1.50 | 3 |

BUCKET PARTS DIAGRAM



BUCKET PARTS IDENTIFICATION SCHEDULE

Optional Euro Buckets with Bolt-on Blade & Clevis

7' Euro Bucket

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|-----------------------------------|------|
| 1 | 689073 | 7' EURO BUCKET WELDMENT | 1 |
| 2 | 672847 | 7' BOLT ON BUCKET BLADE (PAINTED) | 1 |
| 3 | 672852 | BUCKET CLEVIS | 1 |
| 4 | 673286 | SLING LINK | 1 |
| 5 | 673366 | SCREW - .625-11 X 2.00 GR 5 PH | 11 |
| 6 | 640159 | WASHER - 5/8" SPRING LOCK | 11 |
| 7 | 640142 | NUT-.625-11 GR 5 HEX | 11 |
| 8 | 672981 | WARNING DECAL | 1 |

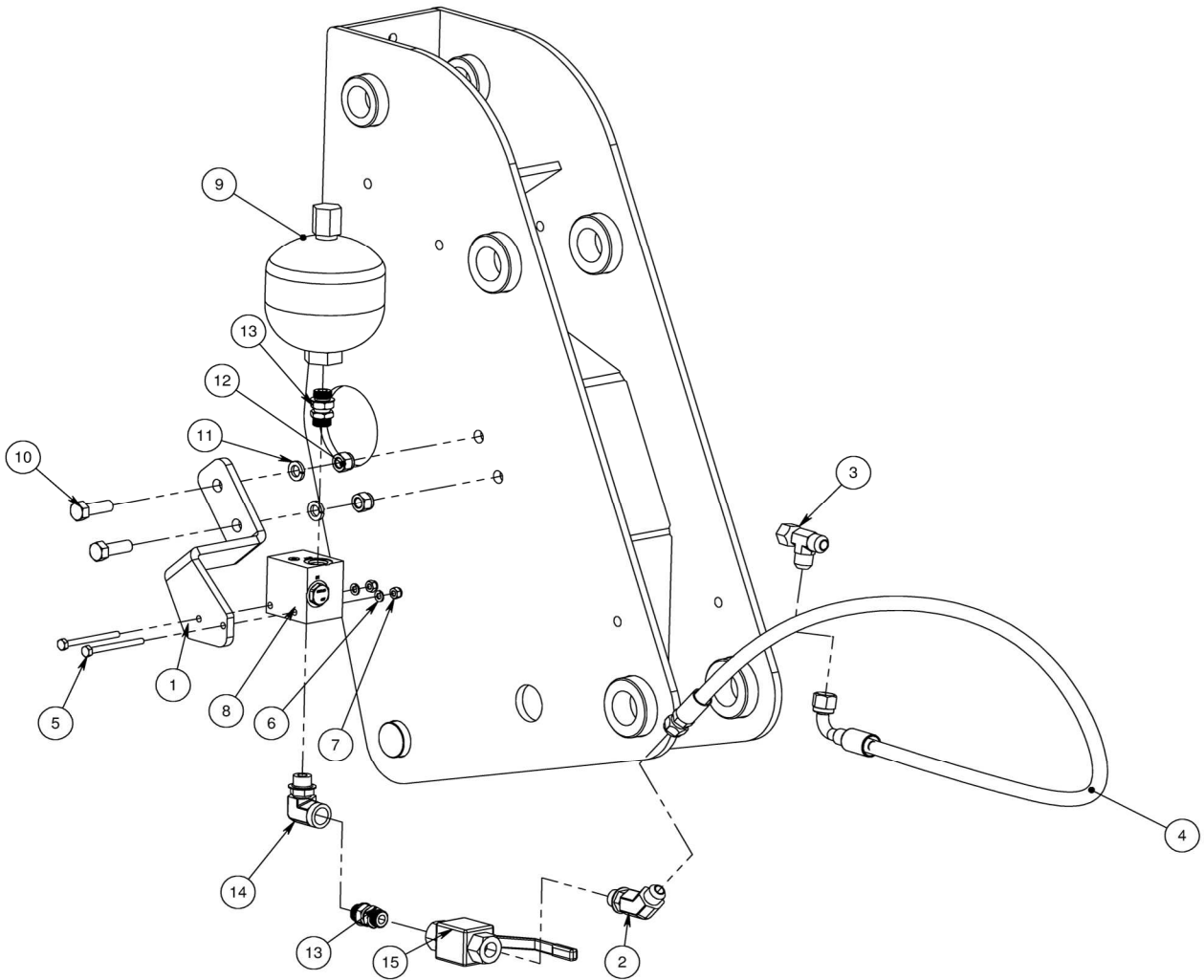
8' Euro Bucket

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|-----------------------------------|------|
| 1 | 689074 | 8' EURO BUCKET WELDMENT | 1 |
| 2 | 672848 | 8' BOLT ON BUCKET BLADE (PAINTED) | 1 |
| 3 | 672852 | BUCKET CLEVIS | 1 |
| 4 | 673286 | SLING LINK | 1 |
| 5 | 673366 | SCREW - .625-11 X 2.00 GR 5 PH | 13 |
| 6 | 640159 | WASHER - 5/8" SPRING LOCK | 13 |
| 7 | 640142 | NUT-.625-11 GR 5 HEX | 13 |
| 8 | 672981 | WARNING DECAL | 1 |

8' 6" Euro Bucket

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|--------------------------------------|------|
| 1 | 699075 | 8' 6" EURO BUCKET WELDMENT | 1 |
| 2 | 679772 | 8' 6" BOLT ON BUCKET BLADE (PAINTED) | 1 |
| 3 | 672852 | BUCKET CLEVIS | 1 |
| 4 | 673286 | SLING LINK | 1 |
| 5 | 673366 | SCREW - .625-11 X 2.00 GR 5 PH | 13 |
| 6 | 640159 | WASHER - 5/8" SPRING LOCK | 13 |
| 7 | 640142 | NUT-.625-11 GR 5 HEX | 13 |
| 8 | 672981 | WARNING DECAL | 1 |

ACCUMULATOR KIT PARTS DIAGRAM



ACCUMULATOR KIT PARTS IDENTIFICATION SCHEDULE

| KEY | PART NUMBER | DESCRIPTION | QTY |
|-----|-------------|--|-----|
| 1 | 679727 | ACCUMULATOR BRACKET | 1 |
| 2 | 641429 | FITTING - ELB ADA 8FJX - 8 ORM 45 | 1 |
| 3 | 681471 | 8FJX-8MJX-8MJX HYD TEE | 1 |
| 4 | 678346 | 36" HYDRAULIC HOSE | 1 |
| 5 | 640956 | SCREW-.250-20 X 3.00 GR 5 HHC | 2 |
| 6 | 640149 | WASHER - 1/4" SPRING LOCK | 2 |
| 7 | 654453 | NUT - .250-20 GR 2 LOCK NYLON INSERT | 2 |
| 8 | 679791 | ACCUMALATOR BLOCK | 1 |
| 9 | 679726 | SOFT RIDE ACCUMULATOR | 1 |
| 10 | 640059 | SCREW-.50-13 X 1.50 GR 5 HHC | 2 |
| 11 | 640157 | WASHER - 1/2" SPRING LOCK | 2 |
| 12 | 660638 | NUT - .500 - 13 GR 2 LOCK NYLON INSERT | 2 |
| 13 | 679796 | FITTING 8ORM X 8ORM | 1 |
| 14 | 674672 | FITTING - ELBOW -8ORM - 8ORF | 1 |
| 15 | 680744 | BALL VALVE | 1 |

CYLINDERS

IMPORTANT: Read these service tips before beginning assembly of cylinder gland or piston.

1. Keep seals clean from the time they are removed from package until they are installed.
2. Clean the groove or bore into which the seal is to be fitted before installing the seal.
3. Never touch the seal lip in handling. Always pick up the seal by its outer member.
4. Inspect each seal lip carefully for nicks, scratches, and dirt at time of installation. If dirty use a soft, clean cloth and carefully wipe off seal. **DO NOT wipe seal with fingers, this only imbeds dirt in the seal.**



NEVER clean rubber related seals with a mineral based solvent! Clean rubber seals in denatured alcohol or non-mineral based solvents only.

NOTE: Seals can be made more pliable and easier to install, if first heated in hydraulic oil to 160°F. Never use direct heat on any seals.

HYDRAULIC SYSTEM

The hoses from the tractor valves are attached to the oil lines which are on the inside of the loader main frame.

Re-check all joints to prevent leakage after loader is mounted and in operation.

KEEP SYSTEM CLEAN - USE ONLY CLEAN OIL



CAUTION! It is of utmost importance that the hydraulic system of this loader be kept free from dirt and foreign matter.

All internal parts to the hydraulic system of your loader have been carefully cleaned, inspected, and plugged with protective caps before shipment. All protective caps should be kept in place until the hydraulic system is connected.

NOTE: Over 75 percent of all hydraulic failure and service is caused by dirt, etc. in the system.

REMEMBER - CLEAN OIL MEANS LONGER LIFE!

3 1/4" CYLINDER SERVICE KITS WITH 1 3/4" SHAFT

KIT NO. 675574:

Complete kit with all seals needed to service one (1) 3 1/4" Cylinder. Consists of:

| | |
|--------|-----------------------|
| 1 each | 3 1/4" Gland "O" Ring |
| 1 each | 3 1/4" Backup Ring |
| 1 each | 1 3/4" U-cup Seal |
| 1 each | 1 3/4" Rod Wiper |
| 2 each | 3 1/4" U-cup Seal |
| 1 each | 1" Rod "O" Ring |
| 1 each | 1" Locknut |

KIT NO. 675572:

Complete assembled 3 1/4" Cylinder Gland with all seals. Consists of:

| | |
|--------|-----------------------|
| 1 each | 3 1/4" Aluminum Gland |
| 1 each | 3 1/4" Gland "O" Ring |
| 1 each | 3 1/4" Backup Ring |
| 1 each | 1 3/4" U-cup Seal |
| 1 each | 1 3/4" Rod Wiper |
| 1 each | 1" Locknut |

KIT NO. 675576:

Complete assembled 3 1/4" Cylinder Piston with all seals. Consists of:

| | |
|--------|------------------------|
| 1 each | 3 1/4" Aluminum Piston |
| 2 each | 3 1/4" U-cup Seal |
| 1 each | 1" Rod "O" Ring |
| 1 each | 1" Locknut |

KIT NO. 675573:

All seals needed to service one (1) 3 1/4" Cylinder Gland. Consists of:

| | |
|--------|-----------------------|
| 1 each | 3 1/4" Gland "O" Ring |
| 1 each | 3 1/4" Backup Ring |
| 1 each | 1 3/4" U-cup Seal |
| 1 each | 1 3/4" Rod Wiper |
| 1 each | 1" Locknut |

KIT NO. 675575:

All seals needed to service one (1) 3 1/4" Cylinder Piston. Consists of:

| | |
|--------|-------------------|
| 2 each | 3 1/4" U-cup Seal |
| 1 each | 1" Rod "O" Ring |
| 1 each | 1" Locknut |

HYDRAULIC CYLINDER PARTS LIST

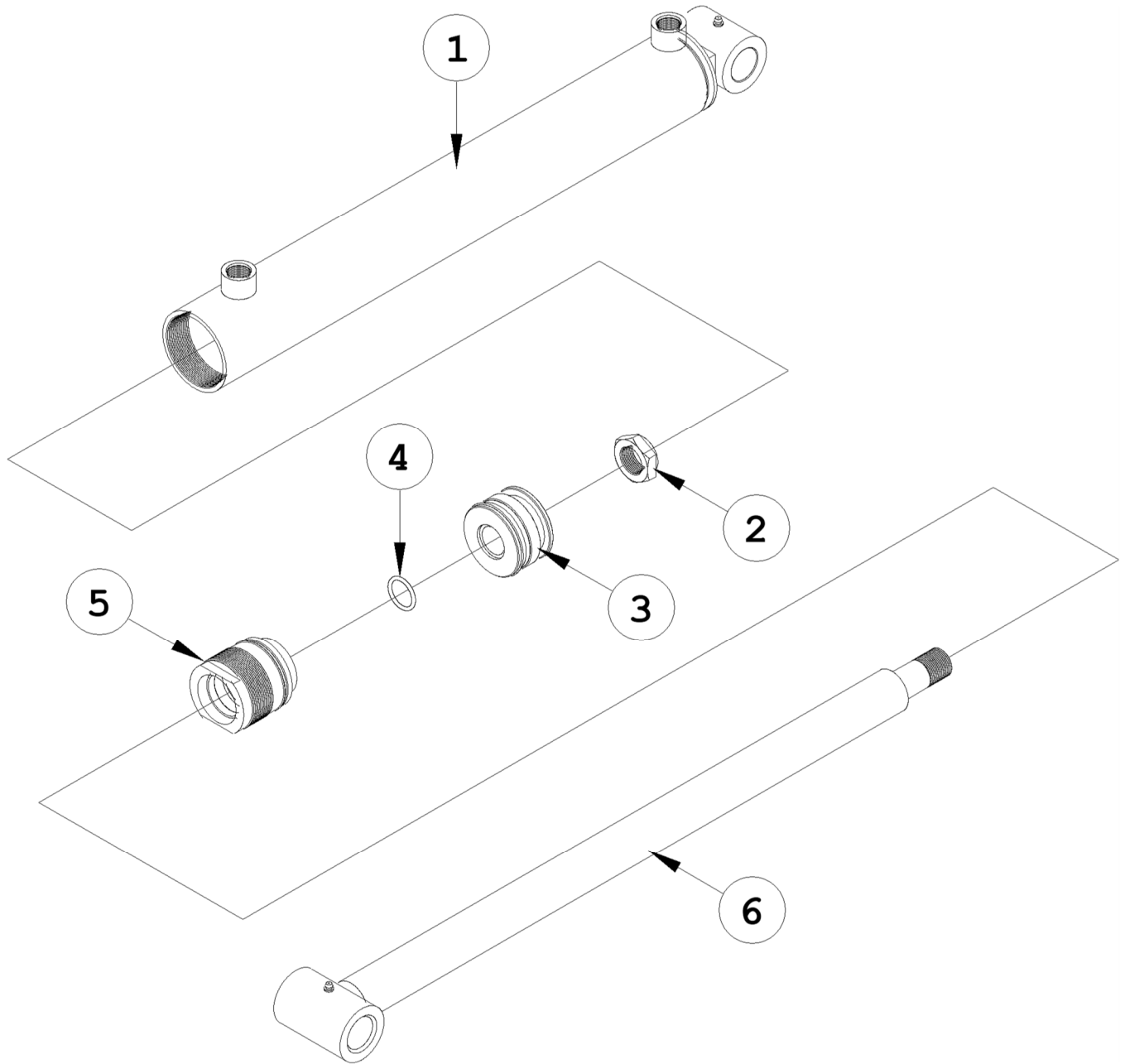
LIFT CYLINDER (Part No. 679260)

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|------------------------------|------|
| 1 | 679261 | TUBE WELDMENT | 1 |
| 2 | 661017 | NUT - 1.00-14 GR C LOCK THIN | 1 |
| 3 | 675577 | PISTON ASSEMBLY | 1 |
| 4 | 640301 | 1" O-RING | 1 |
| 5 | 675570 | GLAND ASSEMBLY | 1 |
| 6 | 679262 | ROD WELDMENT | 1 |

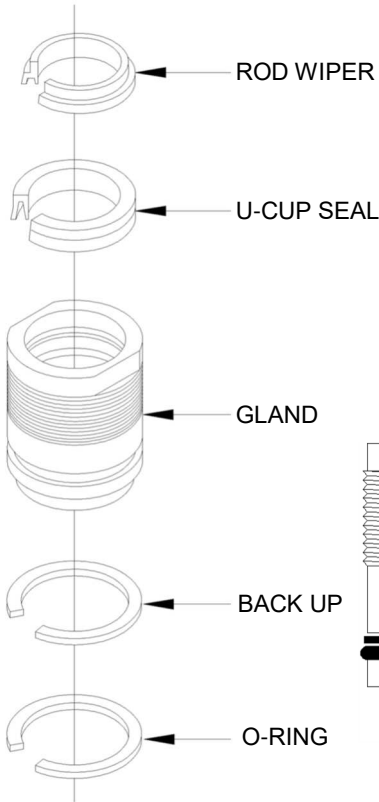
BUCKET CYLINDER (Part No. 679246)

| ITEM NO. | PART NO. | DESCRIPTION | QTY. |
|----------|----------|------------------------------|------|
| 1 | 679247 | TUBE WELDMENT | 1 |
| 2 | 661017 | NUT - 1.00-14 GR C LOCK THIN | 1 |
| 3 | 675577 | PISTON ASSEMBLY | 1 |
| 4 | 640301 | 1" O-RING | 1 |
| 5 | 675570 | GLAND ASSEMBLY | 1 |
| 6 | 679248 | ROD WELDMENT | 1 |

HYDRAULIC CYLINDER PARTS DIAGRAM

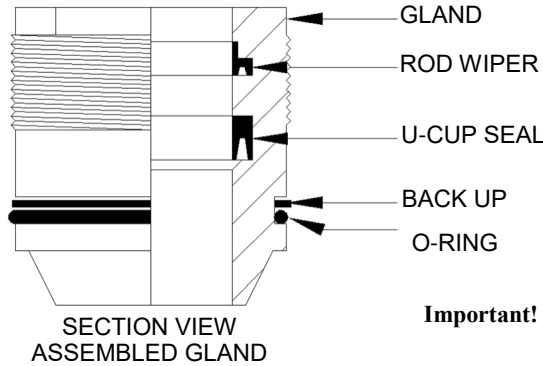
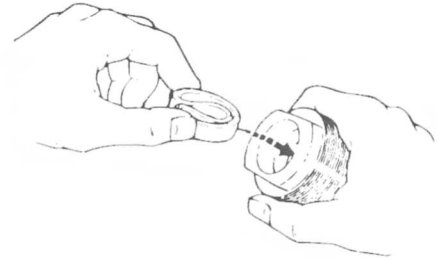


CYLINDER GLAND SERVICE DIAGRAM



All gland seals shown with a section removed to facilitate correct installation.

Note: To install rod wiper and U-cup seal, fold similar to shape shown below, slip into gland bore and locate each in its respective groove. Tools are used to fold seals, take care not to damage sealing surfaces.

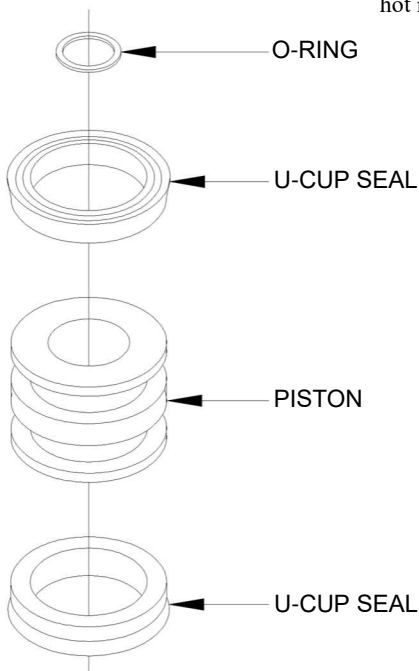


Important! Be sure all gland and piston seals have been installed correctly before cylinder is assembled!

CYLINDER PISTON SERVICE DIAGRAM

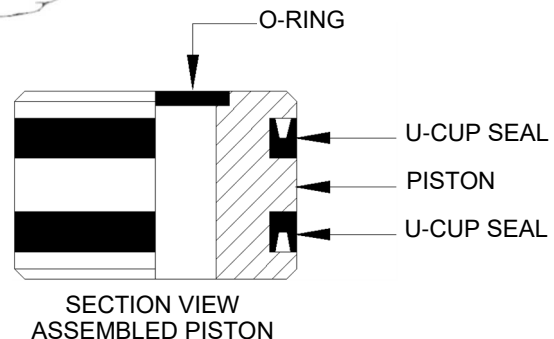
To Remove Seals:

Carefully cut across each seal with a sharp knife. Be sure not to scratch sealing surfaces of aluminum piston. If a sharp knife is not available. An electric soldering gun or hot iron may be used to melt throughout seals.



To Install Seals:

1. Thoroughly clean piston sealing surface of all foreign matter.
2. Heat new seals in hydraulic oil to 160° F. Never use a direct flame or heated water on hydraulic seals.
3. Remove seals from oil, wipe dry and install in piston grooves as shown in illustration at left. Be sure seals have completely seated in piston grooves before allowed to cool.
4. Replace piston on cylinder shaft and assemble cylinder when seals have cooled to room temperature.





NEW KOYKER FRONT-END LOADER WARRANTY

| LIMITED WARRANTY FOR NEW KOYKER MANUFACTURING COMPANY PRODUCTS | | |
|--|--|---------|
| <p>A. GENERAL PROVISIONS. "Koyker" means Koyker Manufacturing Company, 200 N. Cleveland, P.O. Box 409, Lennox, South Dakota 57039. The warranties described below are provided by Koyker to the original purchasers of new products purchased from Koyker or from an authorized Koyker Dealer (the "Products"). Under these warranties, Koyker will, at its option, repair or replace at its factory any Product covered under these warranties which is found to be defective in material and workmanship during the applicable warranty term or refund the purchase price paid for the defective Product. Customer will be responsible for labor charges for removing the defective Product and re-installing the repaired or replacement Product, any premium charge for overtime labor requested of Koyker and shipping charges to and from Koyker's factory. These warranties are not transferrable.</p> | | |
| <p>B. WARRANTY PERIOD. Subject to exclusions and limitations set forth herein, each new Product is warranted for the number of years specified below. Each warranty term begins from the date of purchase regardless of delay in receipt of the Product by Customer due to the time required to process, handle, ship, assemble, construct and install the Product. Customer must retain proof of the date of purchase. Replacement parts for and repairs to the Product will be warranted only for the remainder of the original warranty term. The replacement parts for or repairs to the Product will not extend the warranty term beyond the original warranty term. Products include all parts, components and accessories.</p> | | |
| PRODUCTS | | |
| Koyker Front-End Loaders | Consumer Use | 2 years |
| | Commercial or Government Use | 1 year |
| <p>C. ITEMS COVERED SEPARATELY. The Koyker warranties do not cover any parts, components or materials that are part of the Product, or used in conjunction with the Product, that are not manufactured by Koyker. Such parts, components and materials will be subject to the warranties provided by the manufacturer, if any.</p> | | |
| <p>D. WHAT IS NOT WARRANTED. Koyker does not warrant and is not responsible for the following: (1) used Products; (2) modification or alteration of the Products; (3) Products that have not been properly installed or not installed in accordance with the instruction manual, improper assembly, or improper construction by any persons other than Koyker employees; (4) depreciation, damage or loss caused by the use of parts, components or accessories not provided by Koyker, unauthorized repairs, normal wear, lack of necessary and proper maintenance, a failure to follow operating instructions/recommendations, misuse, lack of proper protection during storage, vandalism or theft, exposure to the elements or corrosive materials, accidents or acts of nature including lightning, flooding, hail, straight winds and tornadoes; and (5) cosmetic damage or damage that does not hinder the functionality of the Products.</p> | | |
| <p>E. LIMITATIONS OF WARRANTIES AND CUSTOMER'S REMEDIES. To the extent permitted by law, neither Koyker, the Dealer nor any person or company affiliated with either of them makes any warranties, representations, conditions or promises express or implied as to the quality, performance or freedom from defects of the Products covered by these warranties other than those set forth herein. THERE ARE NO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. NEITHER KOYKER, THE DEALER, NOR ANY PERSON OR COMPANY AFFILIATED WITH EITHER OF THEM WILL BE LIABLE FOR ANY DAMAGES, INCLUDING, BUT NOT LIMITED TO, INCIDENTAL, SPECIAL, EXEMPLARY, CONSEQUENTIAL, LOST PROFITS AND REVENUES, LOST USE OF THE PRODUCTS OR ANY OTHER PROPERTY, BODILY INJURY OR PROPERTY DAMAGE CLAIMS OF ANY PERSON, LOST COMMODITIES, REMOVAL OR STORAGE COSTS FOR THE PRODUCTS, OTHER EQUIPMENT AND COMMODITIES, DAMAGE TO THE ENVIRONMENT ARISING FROM OR IN ANY MANNER RELATED TO ANY RELEASE OF HAZARDOUS MATERIALS, AND REMEDIATION EXPENSES THEREFORE, WHETHER BASED ON CONTRACT, TORT, STRICT LIABILITY OR ANY OTHER LEGAL BASIS, EVEN IF ADVISED OF THE POSSIBILITY OF SUCH DAMAGES. IN NO INSTANCE WILL KOYKER, THE DEALER OR ANY PERSON OR COMPANY AFFILIATED WITH EITHER OF THEM BE LIABLE TO CUSTOMER OR ANY PERSON IN AN AMOUNT IN EXCESS OF THE PURCHASE PRICE PAID BY CUSTOMER FOR THE PRODUCT.</p> | | |
| <p>F. NO DEALER WARRANTY. THE DEALER HAS NO AUTHORITY TO MAKE ANY WARRANTY, REPRESENTATION, CONDITION OR PROMISE ON BEHALF OF KOYKER, OR TO MODIFY THE TERMS OR LIMITATIONS OF THIS WARRANTY IN ANY WAY.</p> | | |
| <p>G. GOVERNING LAW/VENUE. These warranties, and all terms set forth herein, are governed by the laws of the State of South Dakota and, where applicable, the laws of the United States of America. Any and all disputes arising from these warranties, the purchase and use of the Products, bodily injury and property damage claims or otherwise must be venued in the South Dakota Circuit Court sitting in Minnehaha County, South Dakota. Customer agrees to such venue and waives any challenge to such court's jurisdiction based upon lack of personal jurisdiction or inconvenience.</p> | | |
| <p>H. SECURING WARRANTY SERVICE. In order to receive warranty services, customer must give Koyker written notice of a warranty claim within 30 days of the date of discovery of the defective materials or workmanship, and Customer must complete the following steps:</p> | | |
| (1) | Obtain from Koyker a Return Materials Authorization Number ("RMA Number") by calling the Customer Service Department at 1-800-456-1107 or e-mail Koyker at koyker@koykermfg.com , and providing the following information: | |
| | An explanation as to why the Product is being returned. | |
| | The name of the territory representative, Dealer or Koyker salesperson from whom the Product was purchased. | |
| | The Dealer's identification number. | |
| | The invoice number and date of purchase. | |
| | Customer's name, phone number, fax number, mailing address and email address. | |
| | The date that the Product will be returned. | |
| (2) | Pay the shipping charges to ship the Product to Koyker's factory, and the return shipping charges. | |
| (3) | Ship the Product to Koyker at 200 N. Cleveland, Lennox, South Dakota 57039. | |

TORQUE SPECIFICATIONS

1. Tightening Bolts & Nuts

Check all loader bolts and nuts for tightness every 50 working hours. The movement of the loader over rough terrain may cause bolts to come under pressure and over a long period of time some slight stretching of the bolt may occur. The slack created may need to be taken up by tightening. Please refer below for recommended torque settings.

Metric Recommended Torque Settings

| Size | Class 8.8 | | Class 10.9 | | | | | |
|----------|-------------------|--------------|-------------------|--------------|------|------|------|------|
| | Lubricated N*m | Dry Lb-ft | Lubricated N*m | Dry Lb-ft | | | | |
| M6..... | 9 | 6.5 | 11 | 8.5..... | 13 | 9.5 | 17 | 12 |
| M8..... | 22 | 16 | 28 | 20..... | 32 | 24 | 40 | 30 |
| M10..... | 43 | 32 | 55 | 40..... | 63 | 47 | 80 | 60 |
| M12..... | 75 | 55 | 95 | 70..... | 110 | 80 | 140 | 105 |
| M14..... | 120 | 88 | 150 | 110..... | 175 | 130 | 225 | 165 |
| M16..... | 190 | 140 | 240 | 175..... | 275 | 200 | 350 | 225 |
| M18..... | 260 | 195 | 330 | 250..... | 375 | 275 | 475 | 350 |
| M20..... | 375 | 275 | 475 | 350..... | 530 | 400 | 675 | 500 |
| M22..... | 510 | 375 | 650 | 475..... | 725 | 540 | 925 | 675 |
| M24..... | 650 | 475 | 825 | 600..... | 925 | 675 | 1150 | 850 |
| M27..... | 950 | 700 | 1200 | 875..... | 1350 | 1000 | 1700 | 1250 |
| M30..... | 1300 | 950 | 1650 | 1200..... | 1850 | 1350 | 2300 | 1700 |
| M33..... | 1750 | 1300 | 2200 | 1650..... | 2500 | 1850 | 3150 | 2350 |
| M36..... | 2250 | 1650 | 2850 | 2100..... | 3200 | 2350 | 4050 | 3000 |

SAE Recommended Torque Settings

| Size | Grade 5 | | Grade 8 | | | | | |
|------------|-------------------|--------------|-------------------|--------------|------|------|------|------|
| | Lubricated N*m | Dry Lb-ft | Lubricated N*m | Dry Lb-ft | | | | |
| 1/4..... | 9.5 | 7 | 12 | 9..... | 13.5 | 10 | 17 | 12.5 |
| 5/16..... | 20 | 15 | 25 | 18..... | 28 | 21 | 35 | 26 |
| 3/8..... | 35 | 26 | 44 | 33..... | 50 | 36 | 63 | 46 |
| 7/16..... | 55 | 41 | 70 | 52..... | 80 | 58 | 100 | 75 |
| 1/2..... | 85 | 63 | 110 | 80..... | 120 | 90 | 150 | 115 |
| 9/16..... | 125 | 90 | 155 | 115..... | 175 | 130 | 225 | 160 |
| 5/8..... | 170 | 125 | 215 | 160..... | 215 | 160 | 300 | 225 |
| 3/4..... | 300 | 225 | 375 | 280..... | 425 | 310 | 550 | 400 |
| 7/8..... | 490 | 360 | 625 | 450..... | 700 | 500 | 875 | 650 |
| 1..... | 725 | 540 | 925 | 675..... | 1050 | 750 | 1300 | 975 |
| 1-1/8..... | 900 | 675 | 1150 | 1200..... | 2050 | 1500 | 2600 | 1950 |
| 1-3/8..... | 1700 | 1250 | 2150 | 1550..... | 2700 | 2000 | 3400 | 2550 |
| 1-1/2..... | 2250 | 1650 | 2850 | 2100..... | 3600 | 2650 | 4550 | 3350 |

DO NOT use these values if a different torque value or tightening procedure is given for a specific application. Torque values listed are for general use only and include a +/- 10% variance. Check tightness of fasteners periodically. DO NOT use air powered wrenches. Shear bolts are designed to fail under predetermined loads. Always replace shear bolts with identical grade.

