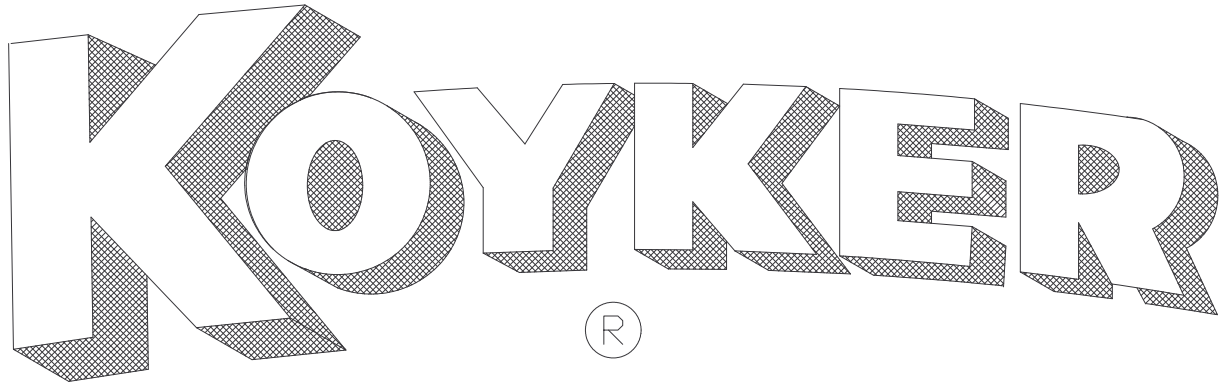
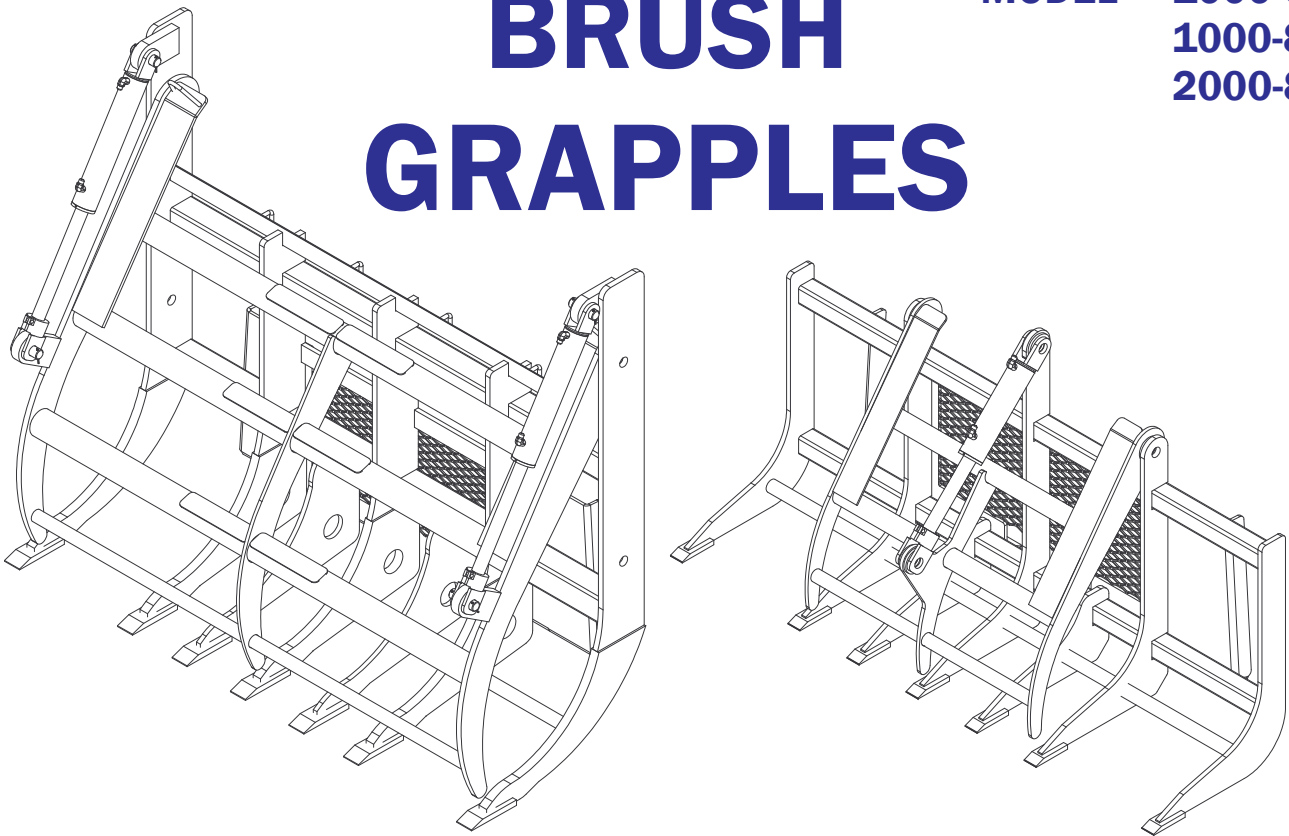


# OWNERS MANUAL



# BRUSH GRAPPLES

**MODEL 1000-6  
1000-8  
2000-8**



**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, Email: [koyker@koykermfg.com](mailto:koyker@koykermfg.com)

Website: [koykermfg.com](http://koykermfg.com)

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## INTRODUCTION

For years, Koyker Manufacturing Company of Lennox, South Dakota, has provided the farm loader industry with innovative ideas for a more efficient and dependable means of material handling. Now, with the increasing popularity of the MFWD (Mechanical Front Wheel Drive) tractors, Koyker has again met the challenge and provided the market with loaders and attachments that will allow the efficient use of these tractors in material handling. The KOYKER Brush Grapple provides you with state-of-the-art design and innovation for your material handling chores.

Features such as quality construction, ease of maintenance, and high performance operating capacities, all at a low price, make the Brush Grapple one of the most efficient loaders ever. With proper care and handling, it will provide many years of dependable service.

This manual is designed to provide you with important information regarding the Brush Grapple. Our sincere intent, in providing this manual, is to help you or those involved better understand the machine and to prevent accidents.

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@koyker mfg.com](mailto:koyker@koyker mfg.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 8.

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 or light grading and digging. It's design is **NOT** intended for commercial and/or 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 grapple 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 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 that loader is securely supported on a hard, level surface and that 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 attachment to the ground, shut off tractor engine, and relieve pressure in the hydraulic system before adjusting, lubricating, 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.

### REMEMBER:

1. Move Slowly!
2. Always use care and common sense!
3. Be careful for your own sake and for that of others!

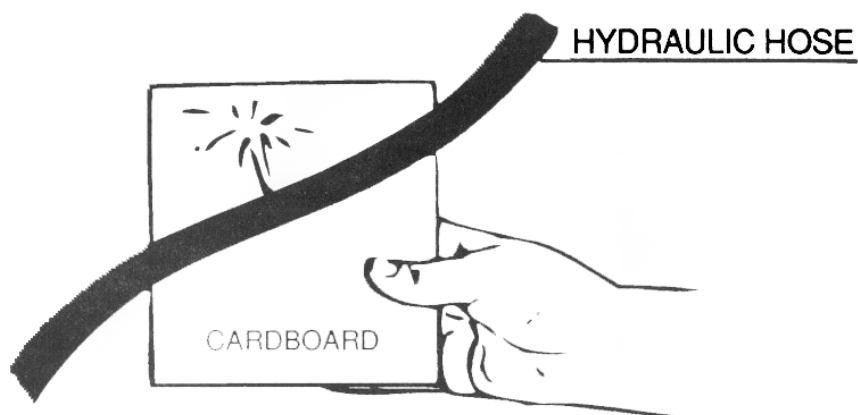
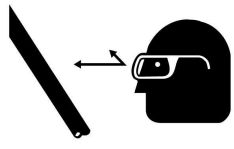




FIG. 5-1

# SAFETY DECALS

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

## ⚠ WARNING



**TO HELP PREVENT BODILY INJURY**

- \*Park and store fork in closed position.
- \*Do not work from or allow riders on loader or its attachments.
- \*Stay clear of grapple fork while in use.
- \*Keep all none operators away from grapple fork during use.
- \*Avoid pinch points.
- \*Read operators manual.

KOYKER MFG CO. INCLUDES ALL REASONABLE MEANS FOR ACCIDENT PREVENTION EXCEPT A SAFE AND CAFEFUL OPERATOR.

679388

## OPERATION



### WARNING:

Never allow anyone to operate the Brush Grapple until they have carefully reviewed and understood this owner's manual.

### MOUNTING THE BRUSH GRAPPLE

The hookup procedure is the same as other powered attachments for your skid steer attachment.

1. Pull up and connect the Brush Grapple to your loader.
2. Secure lock down levers.
3. Connect (2) hydraulic hoses.

### OPERATING THE BRUSH GRAPPLE:

Beware of how the load's weight is distributed.

Open grapple.

Always make certain that folks are completely under the load before lifting.

For well balanced loads:

Position forks so that the load is centered on the forks.

Close grapple.

For well unbalanced loads:

Position forks so that heavy side of the load is toward the Brush Grapple's main frame, (closest to the machine).

Close grapple.

For wide loads:

Position forks under area which will balance the load.

Close grapple.

### WARNING:

Be certain material cannot fall out on tractor or skid steer when raised. Keep clear of overhead obstructions such as trees, limbs, or power lines when raising the loader and brush grapple.



Never lift higher than required. Travel with load at lowest position.

**NEVER** attempt to operate the loader or brush grapple with unauthorized or untrained persons near.

## INSPECTION, SERVICE, AND MAINTENANCE

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

Inspect all pins and grease fittings before each use and lubricate with heavy duty grease as indicated in this manual.

Periodically check all bolts for looseness and retorque 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/skid steer reservoir prior to use.

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

### WARNING!

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. 8-1. Relieve hydraulic pressure before disconnecting any hydraulic line. Failure to heed may result in serious injury or death.

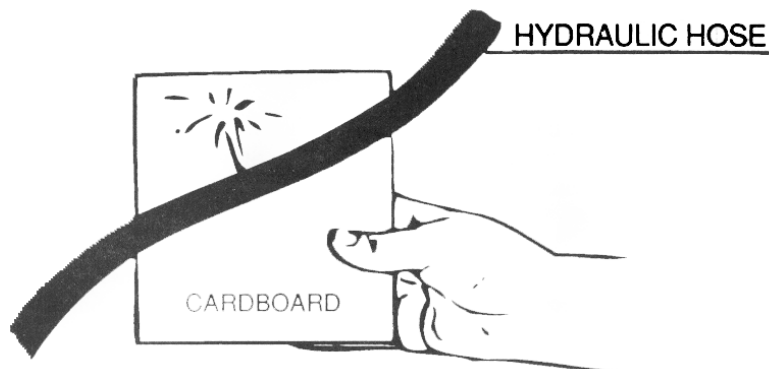
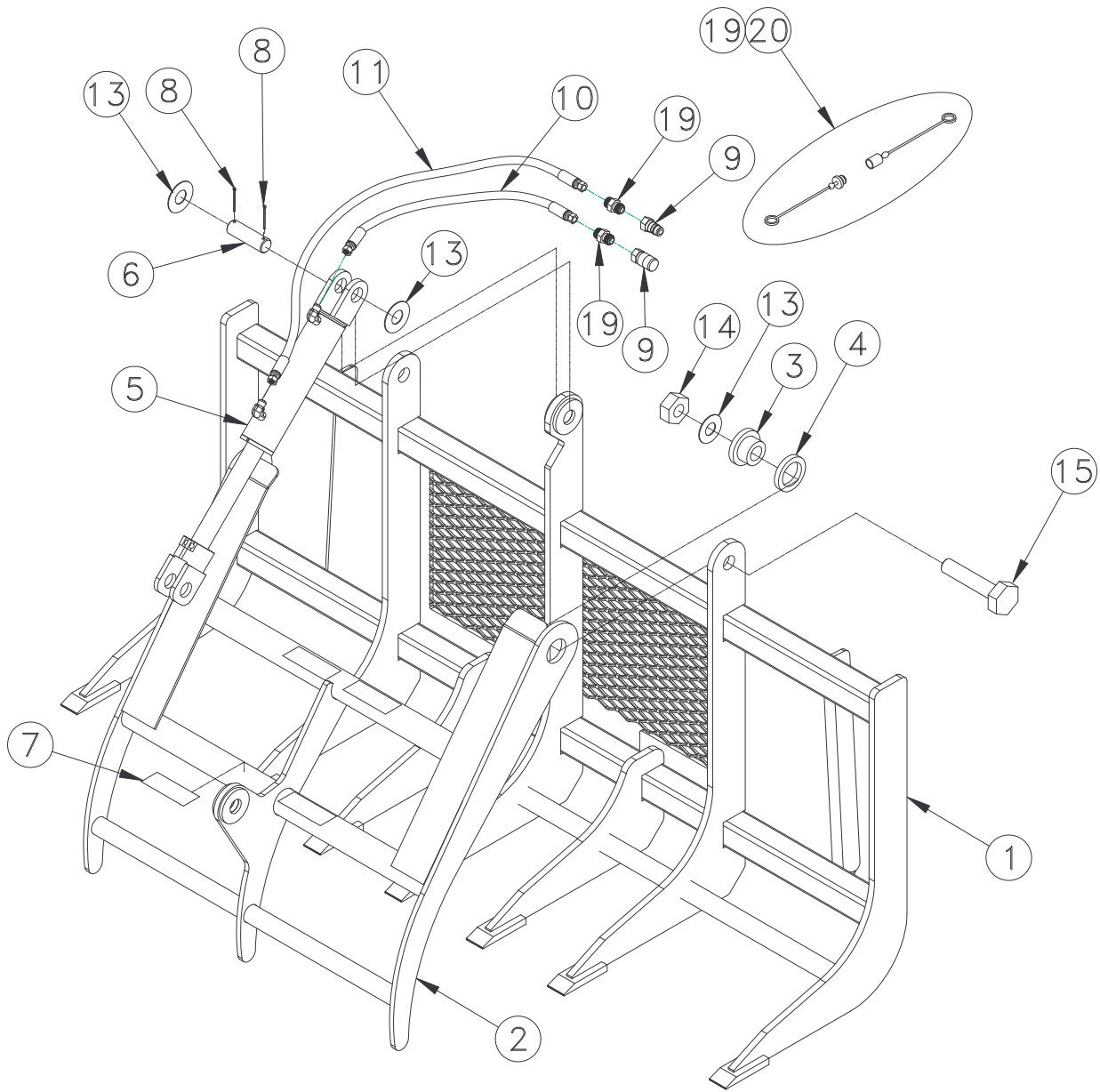


FIG. 8-1

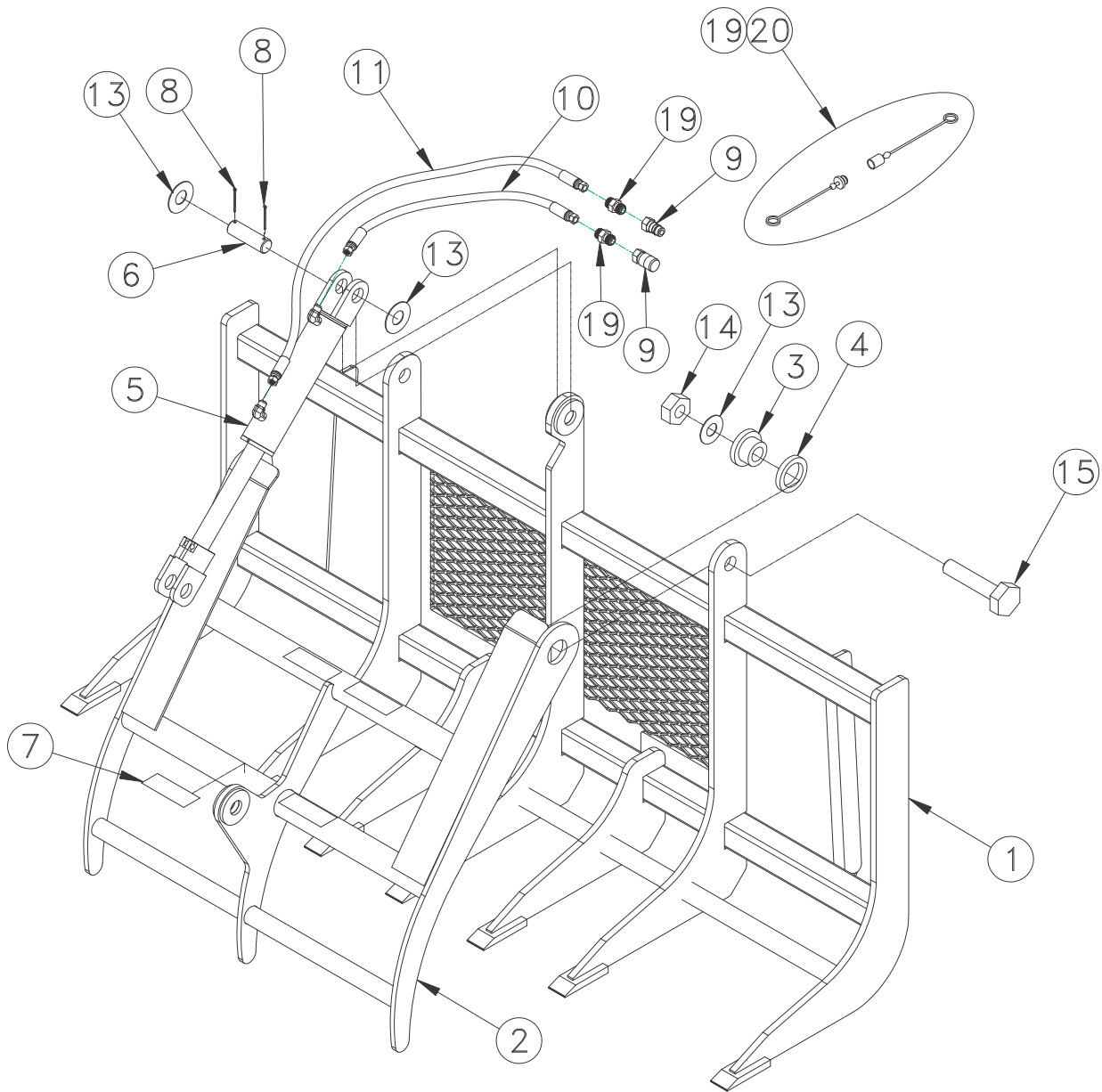
# 1000-6 SMALL BRUSH GRAPPLE PARTS DIAGRAM



# 1000-6 BRUSH GRAPPLE PARTS IDENTIFICATION SCHEDULE

| KEY     | PART NUMBER | DESCRIPTION                            | QUANTITY |
|---------|-------------|--|----------|
| 1.....  | 678718..... | Weldment-Attachment Back Bracket ..... | 1        |
| 2.....  | 678320..... | Weldment-Top Fork.....                 | 1        |
| 3.....  | 678378..... | Bushing-Brush Pivot.....               | 2        |
| 4.....  | 678335..... | Spacer-Pivot Bolt .....                | 2        |
| 5.....  | 678739..... | Cylinder-Assembly 2" .....             | 1        |
| 6.....  | 678716..... | Pin-Pivot Brush Grapple .....          | 2        |
| 7.....  | 679386..... | Skid-Anti 2" x 9" Pad .....            | 6        |
| 8.....  | 640236..... | Pin-Cotter 3/16" X 1 1/2" .....        | 8        |
| 9.....  | 673776..... | Quick Coupler Set; #6 O-ring .....     | 1        |
| 10..... | 679506..... | 54" Hydraulic Hose.....                | 2        |
| 11..... | 679507..... | 60" Hydraulic Hose.....                | 2        |
| 12..... | 669582..... | HH Cap Screw; 1" x 3 1/2".....         | 2        |
| 13..... | 640164..... | Washer-Flat 1" .....                   | 1        |
| 14..... | 700683..... | Nut-1" Center Lock.....                | 2        |
| 15..... | 679388..... | Decal-Warning Brush Grapple .....      | 1        |
| 16..... | 666943..... | Decal-Hydraulic Pressure .....         | 2        |
| 17..... | 673969..... | Fitting-Female Plug #6 Black .....     | 1        |
| 18..... | 673966..... | Fitting-Female Plug #6 Orange.....     | 1        |
| 19..... | 653534..... | Fitting.....                           | 2        |

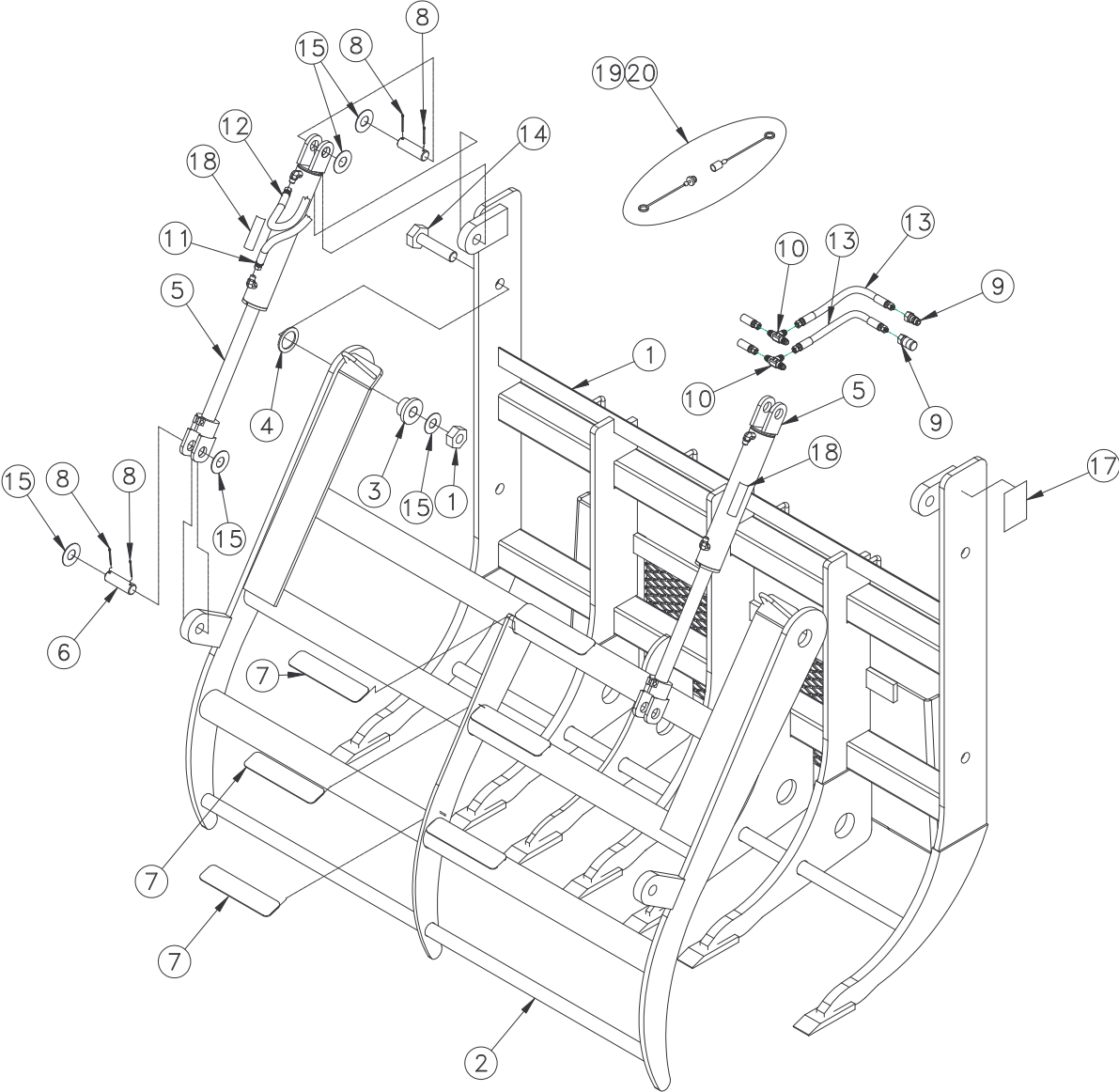
# 1000-8 SMALL BRUSH GRAPPLE PARTS DIAGRAM



# 1000-8 BRUSH GRAPPLE PARTS IDENTIFICATION SCHEDULE

| KEY     | PART NUMBER | DESCRIPTION                            | QUANTITY |
|---------|-------------|--|----------|
| 1.....  | 678718..... | Weldment-Attachment Back Bracket ..... | 1        |
| 2.....  | 678320..... | Weldment-Top Fork.....                 | 1        |
| 3.....  | 678378..... | Bushing-Brush Pivot.....               | 2        |
| 4.....  | 678335..... | Spacer-Pivot Bolt .....                | 2        |
| 5.....  | 678739..... | Cylinder-Assembly 2" .....             | 1        |
| 6.....  | 678716..... | Pin-Pivot Brush Grapple .....          | 2        |
| 7.....  | 679386..... | Skid-Anti 2" x 9" Pad .....            | 6        |
| 8.....  | 640236..... | Pin-Cotter 3/16" X 1 1/2" .....        | 8        |
| 9.....  | 673780..... | Quick Coupler Set; #8 O-ring .....     | 1        |
| 10..... | 679506..... | 54" Hydraulic Hose.....                | 2        |
| 11..... | 679507..... | 60" Hydraulic Hose.....                | 2        |
| 12..... | 669582..... | HH Cap Screw; 1" x 3 1/2".....         | 2        |
| 13..... | 640164..... | Washer-Flat 1" .....                   | 1        |
| 14..... | 700683..... | Nut-1" Center Lock.....                | 2        |
| 15..... | 679388..... | Decal-Warning Brush Grapple .....      | 1        |
| 16..... | 666943..... | Decal-Hydraulic Pressure .....         | 2        |
| 17..... | 673964..... | Fitting-Female Plug #8 Black .....     | 1        |
| 18..... | 673963..... | Fitting-Female Plug #8 Orange.....     | 1        |
| 19..... | 659968..... | Fitting.....                           | 2        |

# 2000-8 BRUSH GRAPPLE PARTS DIAGRAM



## 2000-8 BRUSH GRAPPLE PARTS IDENTIFICATION SCHEDULE

| KEY     | PART NUMBER | DESCRIPTION                            | QUANTITY |
|---------|-------------|--|----------|
| 1.....  | 678370..... | Weldment-Attachment Back Bracket ..... | 1        |
| 2.....  | 678372..... | Weldment-Top Fork.....                 | 1        |
| 3.....  | 678378..... | Bushing-Brush Pivot.....               | 2        |
| 4.....  | 678379..... | Spacer-Pivot Bolt .....                | 2        |
| 5.....  | 678708..... | Cylinder-Assembly 2" .....             | 2        |
| 6.....  | 678716..... | Pin-Pivot Brush Grapple .....          | 4        |
| 7.....  | 679386..... | Skid-Anti 2" x 9" Pad .....            | 6        |
| 8.....  | 640236..... | Pin-Cotter 3/16" X 1 1/2" .....        | 8        |
| 9.....  | 673780..... | Quick Coupler Set; #8 O-ring.....      | 1        |
| 10..... | 676593..... | Fitting-Tee #6 Male .....              | 2        |
| 11..... | 679506..... | 54" Hydraulic Hose.....                | 2        |
| 12..... | 679507..... | 60" Hydraulic Hose.....                | 2        |
| 13..... | 679508..... | 72" Hydraulic Hose.....                | 2        |
| 14..... | 669582..... | HH Cap Screw; 1" x 3 1/2" .....        | 2        |
| 15..... | 640164..... | Washer-Flat 1" .....                   | 1        |
| 16..... | 700683..... | Nut-1" Center Lock.....                | 2        |
| 17..... | 679388..... | Decal-Warning Brush Grapple .....      | 1        |
| 18..... | 666943..... | Decal-Hydraulic Pressure .....         | 2        |
| 19..... | 673964..... | Fitting-Female Plug #8 Black .....     | 1        |
| 20..... | 673963..... | Fitting-Female Plug #8 Orange.....     | 1        |

## CYLINDERS

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

**KEEP SYSTEM CLEAN - USE ONLY CLEAN OIL**



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

All internal parts to the hydraulic system of your brush grapple 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!**

# HYDRAULIC CYLINDER PARTS LIST

## “2” CYLINDER PARTS LIST

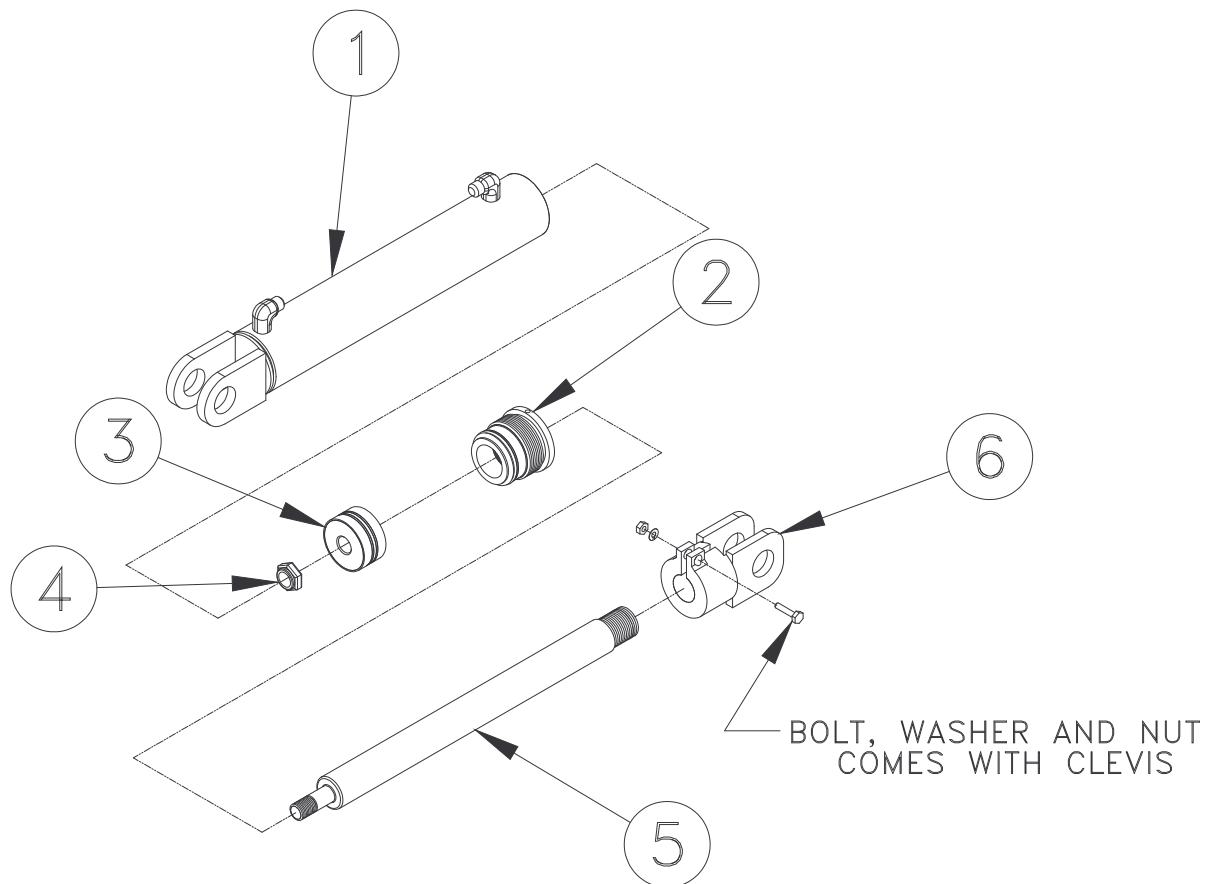
### **BIG BRUSH GRAPPLE CYLINDER** (Part No. 678708)

| Key    | Part No.    | Description           | Quantity |
|--------|-------------|-----------------------|----------|
| 1..... | 678709..... | Tube Weldment .....   | 1        |
| 2..... | 760165..... | Gland Assembly .....  | 1        |
| 3..... | 760167..... | Piston Assembly ..... | 1        |
| 4..... | 669994..... | Locknut .....         | 1        |
| 5..... | 678711..... | Rod .....             | 1        |
| 6..... | 678714..... | Clevis-Rod End.....   | 1        |

### **SMALL BRUSH GRAPPLE CYLINDER** (Part No. 678738)

| Key    | Part No.    | Description           | Quantity |
|--------|-------------|-----------------------|----------|
| 1..... | 678742..... | Tube Weldment .....   | 1        |
| 2..... | 760165..... | Gland Assembly .....  | 1        |
| 3..... | 760167..... | Piston Assembly ..... | 1        |
| 4..... | 669994..... | Locknut .....         | 1        |
| 5..... | 678740..... | Rod .....             | 1        |
| 6..... | 678714..... | Clevis-Rod End.....   | 1        |

# HYDRAULIC CYLINDER PARTS DIAGRAM



## LIMITED WARRANTY

Thank you for purchasing a quality product from Koyker Manufacturing Company (Koyker). Your satisfaction with Koyker's products is very important to us. This manual will help you understand the function, service intervals, and warranty of your new Koyker product(s). It is the retail customer's responsibility to inspect the Koyker product(s) or part(s) before using. Before operating or allowing anyone to operate a Koyker product, please take time to read the manual thoroughly. Failure to do so may result in injury or death and is considered misuse. If your manual has been lost or destroyed, please contact Koyker at (800) 456-1107 or (605) 647-2811 for a new copy.

### **Koyker Manufacturing Company** **Limited Warranty**

Koyker warrants to the retail customer of any new Koyker product, purchased from an authorized Koyker dealer, that the product manufactured by Koyker is free from defects in material and workmanship. This warranty is limited to one (1) year from the date of retail sale to the retail customer for all non-commercial, state, county, or city use. A six (6) month period from the date of retail sale to the retail customer is warranted for all commercial use.

Koyker reserves the right to inspect any products or parts which are claimed to be defective, have defective material, or have less than satisfactory workmanship before Koyker repairs or replaces any products or parts. A retail customer must notify Koyker of a claim by registered or certified mail, return receipt requested, within 30 days after discovery of a problem, or the claim shall be deemed waived. Defective products or parts must be returned to the Koyker factory, at the customer's expense, for inspection by Koyker. Koyker's obligation is limited to repairing or replacing, at its factory, any part or component it determines is defective. Koyker's replacement parts are manufactured with the same precision and skill as its original equipment. All warranted or replacement parts purchased or provided by Koyker will have, at a minimum, a 90-day warranty from the date of installation. If the expiration of the original warranty on a new Koyker product is longer than 90 days, the warranted parts will be covered until the original, new product warranty expiration date.

All cylinder claims shall be handled through Koyker's dealers or distributors. All hydraulic cylinders are thoroughly inspected before shipment from the Koyker factory. Therefore, no claim may be granted where a cylinder has been damaged or abused (including, but not limited to, bent tubes, dents, nicks, abused threads, attempted alterations, or welding), or unless the claim is made to Koyker within one (1) year from the sale to the original purchaser.

Any defective cylinder reported to Koyker within one (1) year from the sale by the dealer to the original purchaser may be repaired or replaced after Koyker's inspection and approval. In such case, notify a Koyker dealer for proper instructions. If after inspection, Koyker finds that the cylinder is not defective and has been abused or otherwise damaged, any transportation charges shall be paid by the original purchaser immediately after receiving notification of Koyker's inspection results.

## LIMITED WARRANTY

Cylinders requiring factory repair more than one (1) year after sale to an original purchaser shall be given to a Koyker dealer for return to Koyker with transportation charges prepaid by the purchaser. The purchaser shall be responsible for all service and repair charges. Leaks around the shaft seal and internal bypass leaks may be field repaired. Service kits are available for those repairs.

### Warranty Limitations and Exclusions.

**THE WARRANTIES SET FORTH ABOVE ARE EXCLUSIVE AND ARE IN LIEU OF, AND PURCHASER HEREBY WAIVES, ALL OTHER CONDITIONS, REPRESENTATIONS AND WARRANTIES, EXPRESS OR IMPLIED BY STATUTE, USAGE, CUSTOM OF TRADE OR OTHERWISE, INCLUDING, WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. NOTWITHSTANDING ANY OTHER OR PRIOR STATEMENT, WRITTEN OR ORAL, KOYKER MAKES NO OTHER WARRANTIES REGARDING THE QUALITY OF THE PRODUCTS OR THE MATERIALS CONTEMPLATED HEREUNDER.**

No warranty is given by Koyker for parts, components, or trade accessories furnished by Koyker but not manufactured by it. Those items are covered by the warranty of their manufacturer, if any. No person, firm, or corporation, including the selling dealer, is authorized to assume for Koyker any other liability in connection with the sale of these goods.

**KOYKER SHALL NOT BE LIABLE FOR INDIRECT, SPECIAL, INCIDENTAL, CONSEQUENTIAL OR PUNITIVE DAMAGES DIRECTLY OR INDIRECTLY ARISING FROM THE DESIGN, CONSTRUCTION, INSTALLATION, MANUFACTURE, OR USE OF KOYKER'S PRODUCTS, PARTS, COMPONENTS, OR TRADE ACCESSORIES.** Such incidental and consequential damages shall include, but not be limited to: non-associated taxes or duties; charges for normal maintenance or service; loss of crops, property damage, or any other income loss; freight charges, other than normal freight charges associated with Koyker products or parts; other installation charges not approved by Koyker; rental charges of any substitute equipment; expenses due to lost, damaged, or delayed products or parts resulting from acts beyond the control of Koyker; and personal injury or death of operator or bystanders by misappropriated use of Koyker products or parts.

A user shall notify Koyker in writing within 30 days of any accident or occurrence involving Koyker products resulting in personal injury or property damage and shall cooperate fully with Koyker in investigating and determining the cause of such accident or occurrence. In the event that a user fails to give such notice to Koyker and so cooperate, such user agrees to indemnify and hold Koyker harmless from all loss or damage arising from such accident or occurrence.

## LIMITED WARRANTY

Among other conditions, Koyker's warranty will not apply:

1. Products or parts that are subject to misuse, abuse, and/or negligence.
2. For surface wear, scheduled maintenance parts, and other items that Koyker deems expendable.
3. If products or parts not manufactured by Koyker or approved by Koyker are connected to or used in conjunction with the Koyker products or parts and if Koyker deems the non-Koyker products or parts affect the performance, safety, reliability, or life of the Koyker products or parts.
4. If products or parts sold by, but not manufactured by Koyker, have their own vendor warranties.

Koyker reserves the right to implement new designs for the continual improvement of their products. These product improvements will be ongoing, and Koyker will not be responsible for incurring cost or obligation for installations or upgrades to previously sold products.

No employee or representative of Koyker may change or amend any part of this limited warranty or make exceptions to this limited warranty, unless such changes are made in writing by Koyker's legal counsel.

**All goods being returned to the Koyker factory must have a Returned Goods Authorization (RGA) number from Koyker. To obtain an RGA number, call (800) 456-1107 or e-mail Koyker at [koyker@koykermfg.com](mailto:koyker@koykermfg.com).**

**Returned parts will not be accepted without an RGA number written on the outside of the box of the returned goods. 30 days are allowed for shipping, from the day the RGA number was issued by Koyker. If the return item(s) is not received into the Koyker system within 30 days, no credit will be issued. Upon request only, a second RGA number will be issued and an additional 30 days may be allowed. No credit will be issued if the return item(s) are not received into the Koyker system 30 days after the second RGA number was issued.**

Should you require additional information or assistance, please contact Koyker Manufacturing Company at (800) 456-1107, (605) 647-2811, or e-mail Koyker at [koyker@koykermfg.com](mailto:koyker@koykermfg.com).

# 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 |       | Dry  |           | Lubricated |       | Dry  |       |
|          | N*m        | Lb-ft | N*m  | Lb-ft     | N*m        | Lb-ft | N*m  | 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 |       | Dry  |           | Lubricated |       | Dry  |       |
|            | N*m        | Lb-ft | N*m  | Lb-ft     | N*m        | Lb-ft | N*m  | 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.