



Aux Fuel Tank Instructions

MTZ 1220

Instruction Sheet: P4732 Loader: MTZL2596E

The fuel tank needs to be removed before the mount kit can be installed.

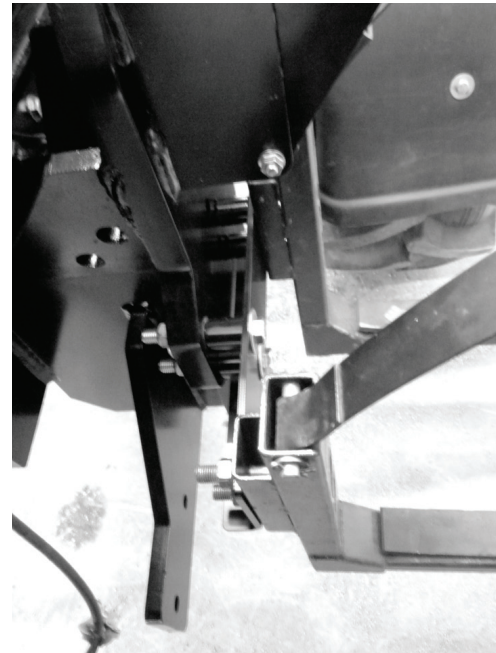
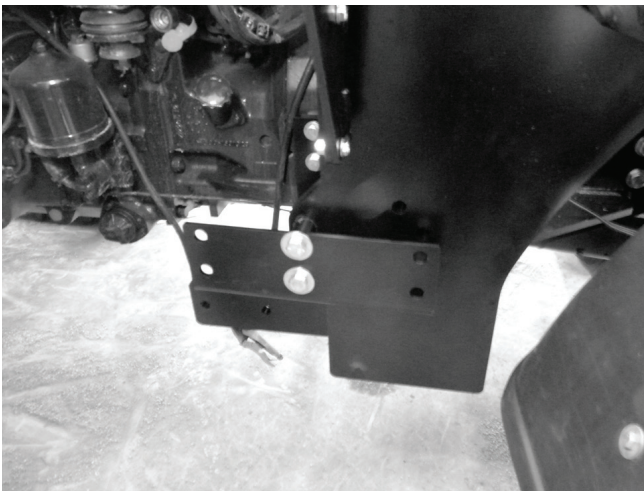
- A. Drain the fuel from the tank using the petcock at the bottom of the tank.
- B. Clamp off lines going to the banjo bolt at the bottom of the tank.
- C. Remove the banjo bolt.
- D. Remove the vent lines from the top of the tank.
- E. Disconnect the leads for the fuel sending unit. It may be necessary to cut some of the cable ties holding the leads to the main wire harness.
- F. Secure the tank from falling and loosen the two bolts in the clamps holding the tank to its mounting brackets.
- G. Remove the tank from its mount.
- H. Remove the four bolts holding the tank and its brackets to the frame of the tractor.
- I. The two long rectangular tubes are re-used when re-installing the tank to the tractor, the plate with the 90° bend is replaced with one included in the kit.

At this time the mount kit should be installed on the tractor before proceeding with the aux tank installation.

After the mount kit has been installed, proceed with the aux tank installation as follows:

1. Slip two of the 0.625" washers (5) through the top of one of the rectangular tubes.
2. Place one of the 6.00" bolts (3) through each of the holes (and washers) in the rectangular tube of the previous step.
3. Using two of the bolts removed in **Step H** above, place the bolts through the holes (and washers) in the remaining tube. This tube will be used toward the rear of the tractor.
4. Using the 4.50" bolts (6) and two washers (5), place the bolts and washers in the center two holes of the bracket (1). (Note that the 90° bend is placed so it is at the bottom and faces toward the tractor. Slip two spacers (2) unto the bolts and place the bracket on the mount using the rear most pair of holes on the tower plate of the mount. Place washers and nuts on the bolts. Tighten but leave some play in the joint. **See Graphic 1.**
5. Place the tube assembly with the 6.00" bolts on the forward pair of bracket holes and place the two remaining spacers between the bracket and the mount. (Also note that the long end of the rectangular tubes goes up.).
6. Place washers and nuts on the bolts and tighten leaving some play in joint.
7. Place the remaining rectangular tube assembly in the remaining rear holes in the bracket and use two of the nuts and washers from **Step H** above to secure the tube to the bracket. Finger tighten the hardware. **See Graphic 2.**

8. Level the bracket so the tank will be level and tighten the bolts. Do not tighten so as to crush the tubes. Prevailing torque nuts (4) are provided for the 0.625" bolts. The existing hardware used on the rearmost bolts use locking washers.
9. Re-install the tank in the straps, making sure to place the rubber pads correctly; then tighten the two bolts in the straps to secure the tank.
10. Reconnect the vent and return lines to the tank. It may be necessary to add hose to the lines.
11. Reconnect the fuel lines at the bottom of the tank.
12. Reconnect the fuel sending unit to the main wiring harness. (It may be necessary to remove some additional cable ties and to re-route the harness.) Secure with cable ties (7).
13. Make sure the petcock is fully closed and re-fill the tank.



Parts List for X3946

Item	Part Number	Description	Qty
1	816604	Bracket Aux Fuel Tank	1
2	816620	Spacer 1.25 Od x .765 Id x 1.5 Lg	4
3	812087	Bolt Hex 0.625 Nc x 6.00 Gr5 (PI)	2
4	812482	Nut Lock (Steel) 0.625 Nc GrB (PI)	4
5	81678	Washer Flat Std 0.688 Hs (PI)	8
6	81672	Bolt Hex 0.625 Nc x 4.50 Gr5 (PI)	2
7	812962	Ty-Rap 7-1/4" Lg Black (Ty-25mx)	6

Bolt Torque Chart

Standard						
Bolt Size (in)	Grade 2		Grade 5		Grade 8	
	Torque		Torque		Torque	
	ft-lb	NM	ft-lb	NM	ft-lb	NM
0.25	6	7	8	11	12	16
0.313	11	15	17	23	25	33
0.375	20	27	31	41	44	60
0.438	32	43	49	66	70	95
0.5	49	66	76	103	106	144
0.563	70	95	109	148	153	207
0.625	97	131	150	203	212	287
0.75	144	195	266	360	376	509
0.875	166	225	430	583	606	821
1	250	339	644	873	909	1232
1.125	354	480	795	1077	1288	1745
1.25	500	678	1120	1518	1817	2462
1.375	655	887	1470	1992	2382	3228
1.5	870	1179	1950	2642	3161	4283

Metric								
Bolt Size (mm)	Class 5.6		Grade 8.8		Grade 10.9		Grade 12.9	
	Torque		Torque		Torque		Torque	
	ft-lb	NM	ft-lb	NM	ft-lb	NM	ft-lb	NM
6	3.1	4.3	7.3	9.9	10.3	14	12.1	16.5
8	7.7	10.5	17.7	24	25	34	29	40
10	15	21	35	48	49	67	59	81
12	26	36	61	83	86.2	117	103	140
14	42	58	97	132	136	185	162	220
16	64	88	147	200	210	285	250	340
18	89	121	202	275	287	390	346	470
20	126	171	287	390	405	550	486	660
22	169	230	390	530	549	745	656	890
24	217	295	497	675	708	960	840	1140
27	320	435	733	995	1032	1400	1239	1680
30	435	590	995	1350	1401	1900	1681	2280
33	590	800	1349	1830	1902	2580	2278	3090
36	759	1030	1740	2360	2441	3310	2935	3980
39	988	1340	2249	3050	3163	4290	3798	5150

Dash Size	Thread Size	Jam Nut or Straight		SAE 37° (JIC)	
		ORB Fitting Torque		Swivel Nut Torque	
		ft-lb	NM	ft-lb	NM
-04	7/16-20	14-16	20-22	10-11	13-15
-05	1/2-20	18-20	24-27	13-15	18-20
-06	9/16-18	24-26	33-35	17-19	23-26
-08	3/4-16	50-60	68-78	34-38	47-52
-10	7/8-14	72-80	98-110	50-56	69-76
-12	1-1/16-12	125-135	170-183	70-78	96-106
-14	1-3/16-12	160-180	215-245	80-90	110-122
-16	1-5/16-12	200-220	270-300	94-104	127-141
-20	1-5/8-12	210-280	285-380	124-138	169-188
-24	1-7/8-12	270-360	370-490	156-173	212-235



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