



**TRAILER WOODSPLITTER  
MODEL SE50**

**ASSEMBLY INSTRUCTION MANUAL**

**Please review and understand the  
operators manual before attempting  
to operate this machinery.**

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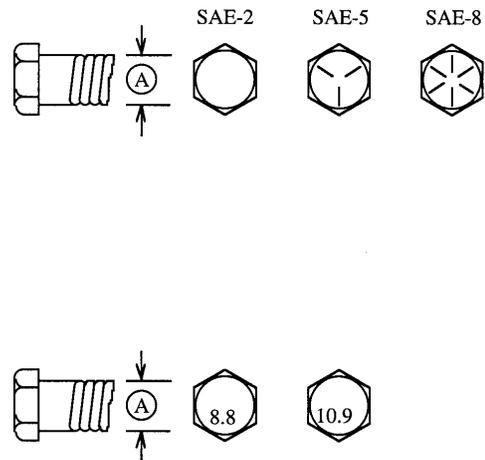
## 1.0 ASSEMBLY SAFETY

1. Read and understand the Assembly Manual and all safety signs before starting.
2. Follow good safety practices:
  - Keep service area clean and dry.
  - Be sure electrical outlets and tools are properly grounded.
  - Use adequate light for the job at hand.
3. Use properly sized tools, stands, jacks and hoists at all times.
4. Use two men to handle heavy and/or bulky components.
5. Position in a large open area to allow access from all sides during assembly.
6. Keep the assembly area neat and clean to prevent slipping or tripping.
7. Place safety stands or large blocks under the machine or components before going underneath the component for assembly.
8. Stay away from overhead power lines and obstructions when lifting the machine during assembly. Contact with power lines can cause electrocution. Contact with obstructions can damage components or cause them to fail.
9. Tighten all fasteners to their specified torque before using the machine.

## 2.0 BOLT TORQUE

### ENGLISH TORQUE SPECIFICATIONS

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



Torque figures indicated above are valid for non-greased or non-oiled threads and heads unless otherwise specified. Therefore, do not grease or oil bolts or capscrews unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

\* Torque value for bolts and capscrews are identified by their head markings.

### 3.0 ASSEMBLY

The machine is shipped from the factory in a partially disassembled configuration and attached to a pallet that provides easy moving and handling. Always use tools, equipment and fork lifts of appropriate size and capacity for the job.

**When the machine is shipped, follow this procedure when preparing for the customer:**

1. Clear the area of bystanders, especially small children.
2. Be sure you have all the required tools before you start.
3. Move the shipping package into an area where it is accessible from all sides.



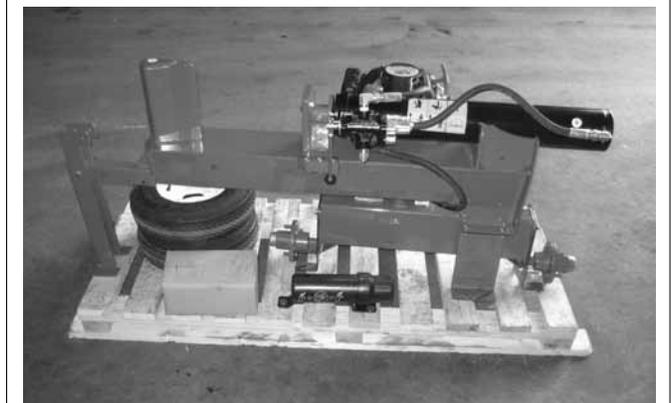
**Fig. 1 SHIPPING PACKAGE**

4. Remove the screws holding the lid to the shipping pallet.



**Lifting**

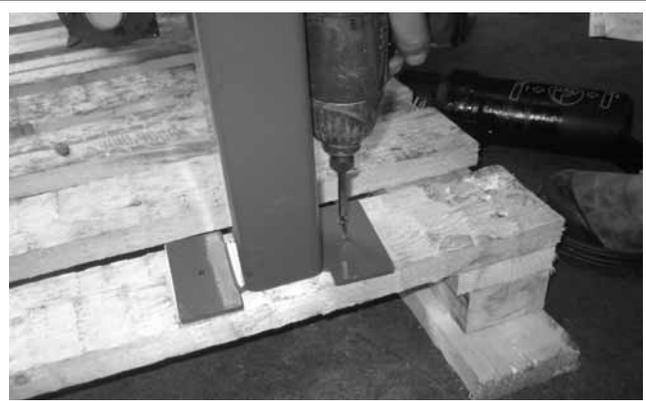
5. Remove the lid and set to one side.



**Off**

**Fig. 2 LID REMOVAL**

6. Remove the screws securing the components to the pallet lay out.



**Support Leg**



**Support Bracket (Cylinder Frame)**

**Fig. 3 COMPONENTS**

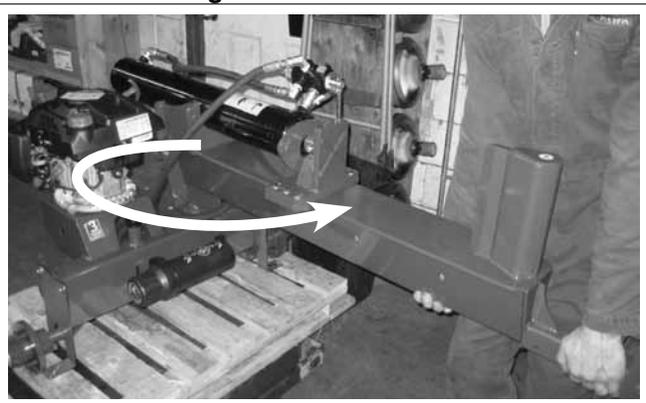
7. Open fastener box and remove the bag of fasteners.



**Open Box**

**Fig. 4 FASTENERS**

8. Turn the frame at 90° to the axle.



**Fig. 5 TURNING FRAME**

- Secure cylinder frame to axle tank with 4 bolts. Tighten fasteners as specified on the torque chart (pg 2).



- Undo the bolt that holds the support leg to the tongue channel. Remove the leg from the tongue channel.



**Fig. 6 LEG AND TONGUE CHANNEL**

- Move the support leg to the support leg mounting holes on the tongue channel. Do not overtighten - bolt should allow the support leg to rotate for transportation. Install snapper pin to secure the support leg in the down position for the remainder of the assembly procedure.



**Fig. 7 FRAME AND LEG ASSEMBLY**

12. Install hitch, taking care to insert safety transport chains individually over each bolt.



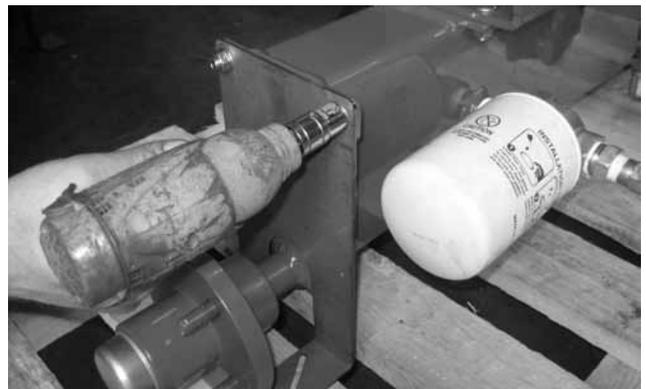
**Install Hitch, Bolts, and Chains**

**Fig. 8 HITCH HARDWARE**



**Remove Fasteners from Axle Shipping Brackets**

13. Support the axle to prevent it from dropping unexpectedly, then carefully remove shipping brackets to free the axles from the pallet.



**Support Bracket (Axle)**

**Fig. 10 REMOVE SHIPPING BRACKETS**

14. Carefully, lift the axle and support it to allow tire installation. Assemble tire to the hub and tighten lugnuts to their specified torque.



**Tire**

**Fig. 11 TIRE INSTALLATION**

15. Slide cylinder backwards until it contacts the collar stop. Rotate cylinder, if necessary, to position valve to preferred operating angle.



**Saddle**

16. Place the saddle on top of the cylinder collar mount as shown, align the bolt holes and insert the 1/2 x 1 1/2 bolt through the saddle (one on each side)

Assemble 1/2" hex locknut on each bolt and tighten as specified on the torque chart (pg 2)



**Securing Saddle Over Cylinder**

**Fig. 12 SADDLE INSTALLATION**

17. Insert the 1/2 x 3" bolt (one on each side) through the gland clamp and through the saddle and cylinder mount, assemble 1/2" hex locknut on each bolt and tighten as specified on the torque chart (Pg 2)



**Gland Clamp Plate**

**Fig. 13 CYLINDER**

18. Assemble any loose hose into hose clamps (already attached to the unit). Do not overtighten the clamps or hose damage will result.



**Secure Hose Clamp**

**Fig. 14 HOSE CLAMP**

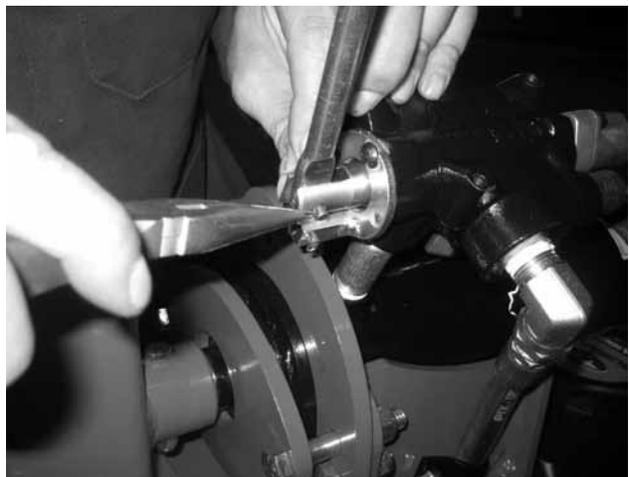
19. Finally the hydraulic control handle must be installed. Using a pair of needle nose pliers, remove the cotter pin that secures the handle pivot pin to the valve. Remove the pivot pin. Once the pivot pin is removed, then the handle will come free.



20. Fit the slotted end of the handle into the lower pivot, position the handle so that the hole in the handle lines up with the pivot hole. Carefully insert the pivot pin.



21. Using needle nose pliers, secure the pivot pin by re-inserting the cotter pin. Test the function of the handle to ensure everything is assembled properly.



**Congratulations on  
successfully completing assembly of  
the  
SE50 Woodsplitter**