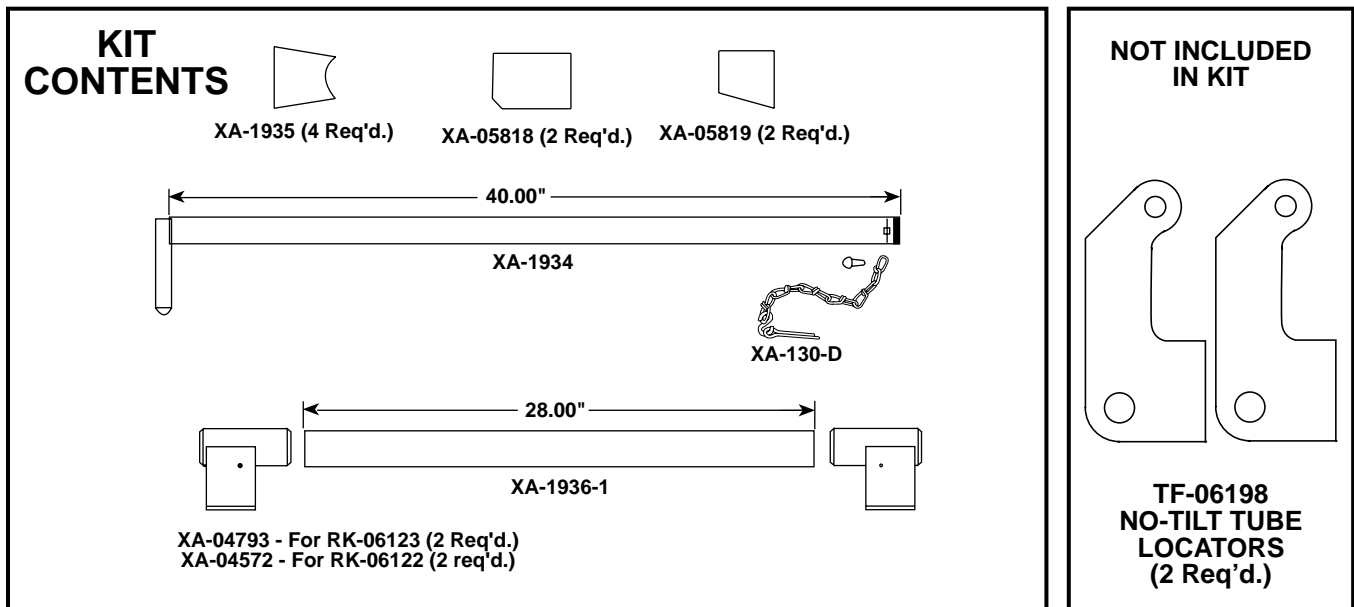




GO THE DISTANCE.

# STATIONARY FIFTH WHEEL NO-TILT INSTALLATION INSTRUCTIONS

For Use with kits RK-06122 (7.88") and RK-06123 (8.88")



## INSTALLATION:

**NOTE:** This kit requires the use of the TF-06198 No-Tilt Tube Locator to help in locating the no-tilt tube on the fifth wheel casting. TF-06198 must be ordered separately.

## GENERAL RECOMMENDATIONS:

1. Every user and installer using Holland products either recommended or not recommended by Holland must thoroughly satisfy himself that the installation procedure used is appropriate for the vehicle.
2. Consult the Holland literature for fifth wheel capacities and applications.
3. The following procedure is applicable only for 7.88" and 8.88" height standard capacity stationary fifth wheels.
4. The installation of this kit requires the use of full length mounting angles, ASTM A36, 4" x 4" x .31" minimum section, extending a minimum of 18" on either side of the fifth wheel pivot pin.

**WARNING: DO NOT ATTEMPT TO INSTALL A NO-TILT KIT IF THE TOP PLATE IS CRACKED OR DISTORTED.**

## CONVERSION PROCEDURE:

### TOP PLATE:

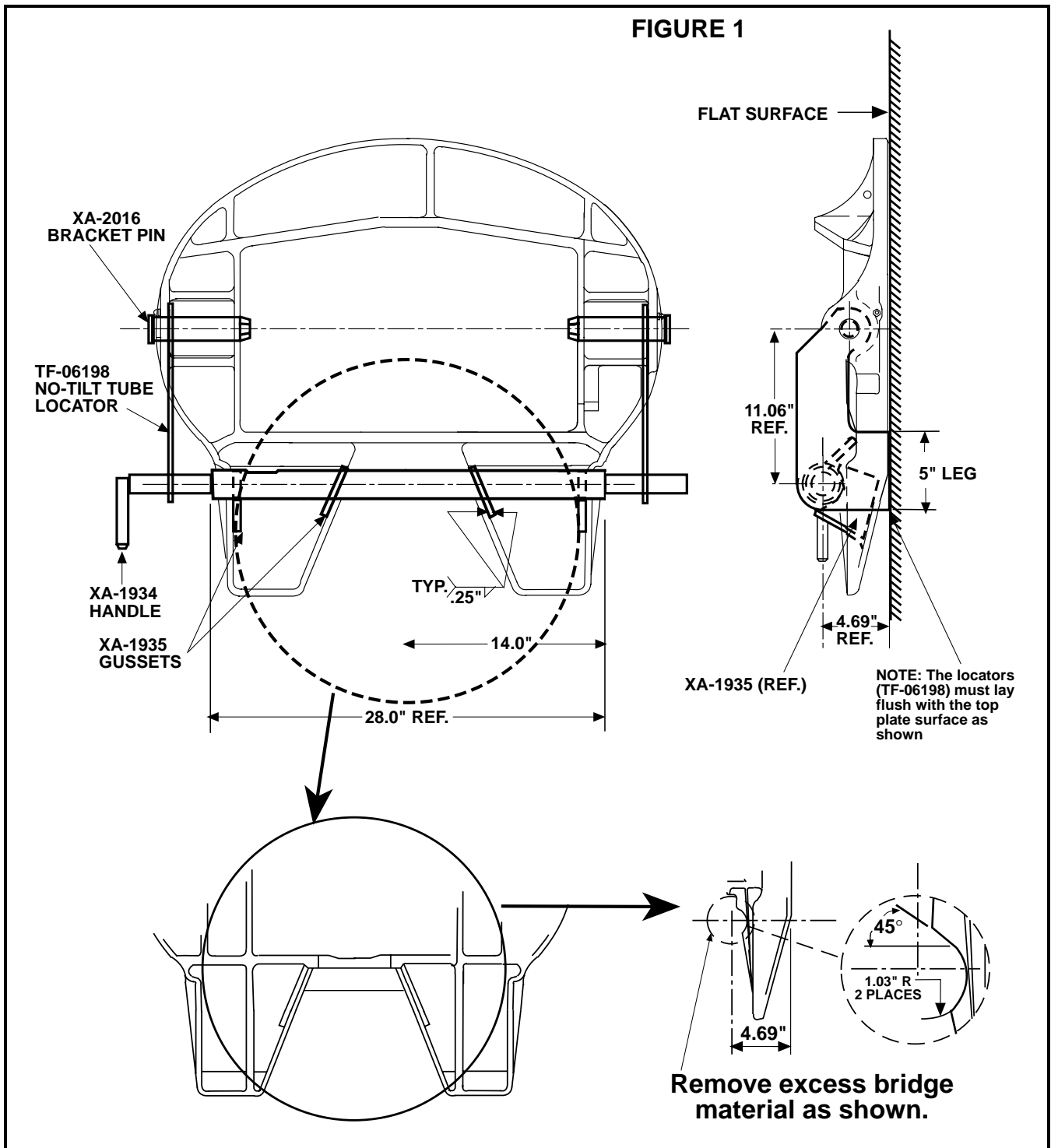
1. Remove the fifth wheel top plate.
2. Remove all dirt and excess debris away from the welding areas of the fifth wheel.
3. Using the existing bracket pins, insert the pin through both ears and the 1.12" diameter hole of the TF-06198 No-Tilt Tube Locator as shown in figure 1 on page 2.
4. Assemble the shaft handle (XA-1934), tube (XA-1936-1), and two locators (TF-06198) as shown in figure 1.
5. Check to see if the 5" bottom leg of the locators come in contact with the flat surface which the top plate is laying on. If they do not, remove excess bridge material of the fifth wheel casting as shown in the bottom drawing of figure 1. Cut and grind the casting until sufficient space is cleared to allow the leg of the locators to contact the flat surface.

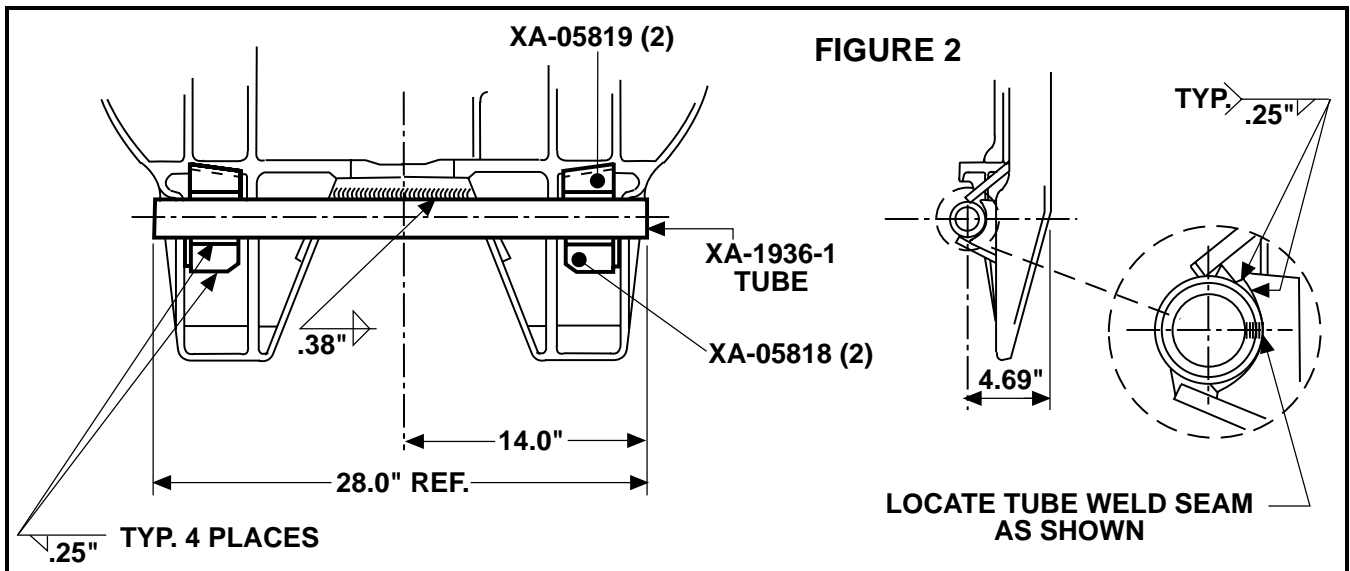
DO NOT REMOVE MORE MATERIAL THAN IS NECESSARY.

6. Locate four (4) XA-1935 gussets so as to allow proper placement of the XA-1936-1 tube. Use .25" fillet welds to attach gussets to the top plate as shown in figure 1 below.

**WARNING: WHEN WELDING, USE A PROCEDURE WHICH ASSURES A SOUND, GOOD QUALITY WELD AND WHICH PROTECTS THE OPERATOR AND OTHERS. OVERWELDING MAY CAUSE DISTORTION AND DAMAGE AND UNDERWELDING MAY NOT DEVELOP SUFFICIENT STRENGTH. A LOW HYDROGEN PROCESS AND AWS E70XX FILLER METAL ARE RECOMMENDED. TAKE PRECAUTIONS TO INSURE THAT THE TRACTOR ELECTRICAL SYSTEM IS NOT DAMAGED BY THE WELDING.**

7. Locate the tube seam into the pocket of the gussets as shown in figure 2. Weld the XA-1936-1 tube to the top plate and the four gussets. Use .25" and .38" fillet welds as shown in figure 2.
8. Locate and weld the two XA-05818 gussets and the two XA-05819 gussets as shown in figure 2, using .25" fillet welds.



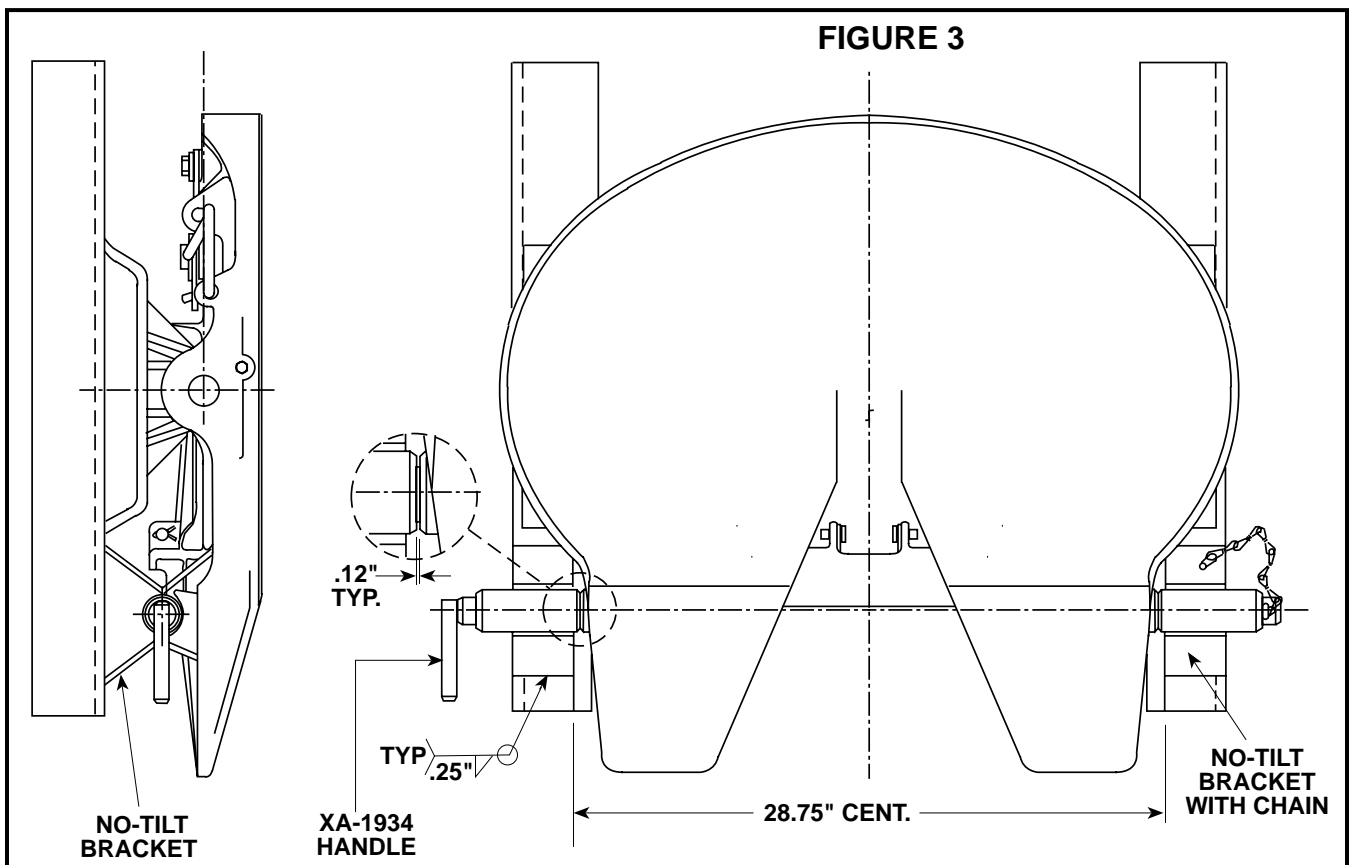


**NO-TILT ASSEMBLY MOUNTING ON BRACKETS:**

1. Reattach the modified top plate to the fifth wheel bracket assembly.
2. Locate and orient the brackets on the mounting angles as shown in figure 3 below. Make sure that the right bracket has the chain assembly positioned on the outside of the assembly as shown. Slide the shaft assembly (XA-1934) through the left bracket, through the top plate tube, and the right bracket.

**CAUTION: DO NOT WELD ON THE TRACTOR FRAME. BRACKETS SHOULD BE ATTACHED TO THE FIFTH WHEEL MOUNTING ANGLE.**

3. Verify that there is sufficient area on the mounting angles in which to weld on the brackets. Be sure that all surfaces involved are cleaned in preparation for welding.
4. Position the brackets with a 1/8" gap between the bracket tube and top plate tube as shown in figure 3. Tack weld the brackets to the mounting angles.
5. Remove the shaft assembly (XA-1934) and check for free articulation.
6. Weld the brackets as shown in figure 3.
7. Attach chain assembly (XA-130-D) to bracket (XA-04572 or XA-04793) as shown in figure 3.



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