



Pivot Pocket Rebuild Procedures for XA-3501-UB Fifth Wheel Top Plate Sub-Assemblies

DETERMINE IF REBUILDING IS REQUIRED:

Determine if rebuilding is necessary by prying up on each pivot ear, using a small bar. If, after prying, more than 1/2" vertical movement is noted, (see Figure 1), rebuilding should be considered.

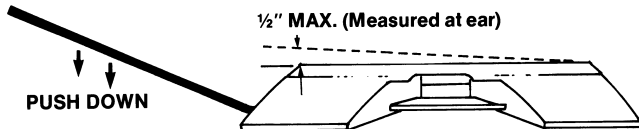


Figure 1

Pocket Rebuild Procedures:

1. Remove the tip plate sub-assembly, saving the pivot pins or pivot bolts supplied. Next, turn the top plate upside-down with the pivot pockets facing up.
2. Apply grease through grease zerks provided on the side of the top plate until grease comes out of the hole in the pocket. If grease does not come out, it may be necessary to remove the grease zerk and drill out any obstruction.
3. Place the thickest shims supplied in the rebuild kit into each pocket, with the slot toward the front of the casting, centering the shims in the pocket. (See Figure 2).
4. Place the pocket liner (P/N XA-03423) on top of the shims.
5. Place the new bracket bearing caps supplied into the pocket on top of the pocket liner. (See Figure 2).

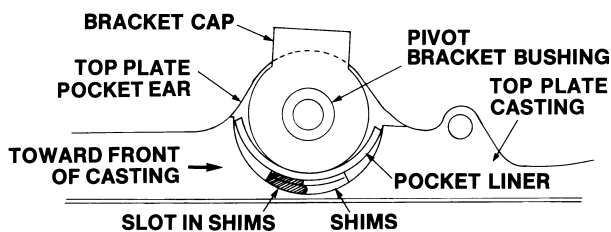


Figure 2

6. Visually sight through the top plate pocket ears to determine if the ear holes line up with the pivot bracket bushing.

7. If the holes appear to line up, install a pivot pin through the ears and check for proper fit. Proper fit is achieved when the bracket cap fits snugly but can be rotated forward and back freely.
8. If improper fit is attained, disassemble and add or remove additional shims as required.
9. Once proper fit is attained, disassemble the bracket cap and pocket liners and tack weld the shims into the center of the pocket, making sure that the tack welds do not protrude above the shims.
10. Reassemble the pocket liner and bracket cap and install the pivot pins.
11. Move the bracket cap forward and tack weld the rear of the pocket liner to the top plate casting.
12. Move the bracket cap rearward and tack weld the front of the bracket liner to the top plate casting.
13. Remove the pivot pins and bracket caps and weld the pocket liner to the top plate casting, using skip-weld process (ie. similar to tightening lug bolts on a wheel) until a continuous 3/16" fillet weld is attained. See Figure 3.

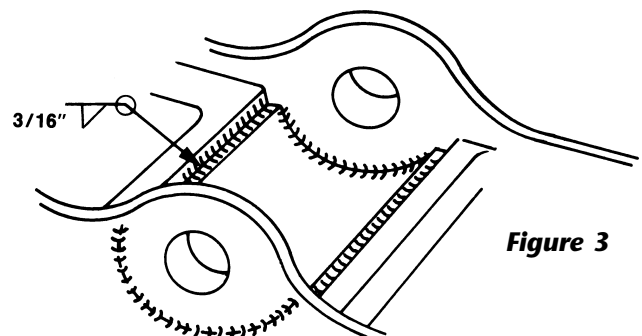


Figure 3

CAUTION:

When welding, use a procedure and filler metal which assures a sound, good quality weld which protects the welding operator and others. Over-welding may cause distortion, damage or poor part fit-up, and under-welding may not develop sufficient strength. An AWS E60XX or E70XX filler metal used in conjunction with either GMAW (gas shielded solid wire), FCAW (gas shielded flux core wire) or SMAW (AC or DC stick) is recommended.

Bracket Cap Replacement Procedures:

1. Clean and mark the existing bracket caps $1\frac{1}{2}$ " above the base, as shown in *Figure 4*.

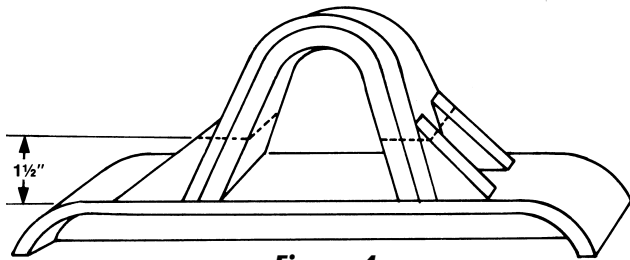


Figure 4

2. Using an oxyacetylene torch, cut off the top of the old bracket caps flush with the lines marked in **Step 1**, above.
3. Chamfer the inside of the remaining portion of the bracket cap, as shown in *Figure 5*.

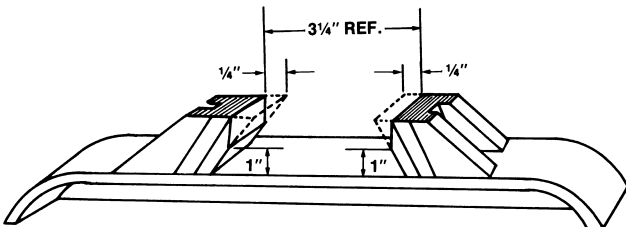


Figure 5

4. Clean up the remaining portion of the bracket cap with a small disc or die grinder, removing any slag that was developed in the cutting process.
5. Slide the new bracket caps supplied in the rebuild kit between the remaining bracket cap sections. *See Figure 6*.
6. Adjust the new bracket caps in and out until they are $33\frac{7}{8}$ " across the outside of the new bracket caps. *See Figure 6*.

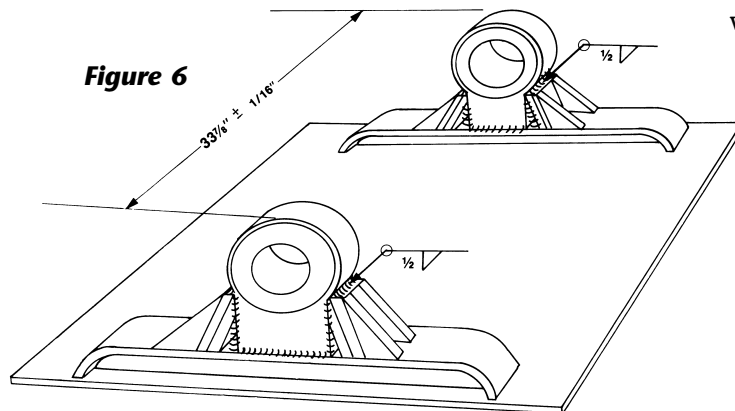


Figure 6

7. Tack weld the bracket caps, making sure they rest securely on the bracket base.
8. It may be desirable to mount the top plate onto the brackets to assure proper spacing before finish welding.
9. Finish welding, as outlined in *Figure 6*, developing a continuous $1/2$ " fillet weld.

CAUTION:

When welding, use a procedure and filler metal which assures a sound, good quality weld which protects the welding operator and others. Over-welding may cause distortion, damage or poor part fit-up, and under-welding may not develop sufficient strength. An AWS E60XX or E70XX filler metal used in conjunction with either GMAW (gas shielded solid wire), FCAW (gas shielded flux core wire) or SMAW (AC or DC stick) is recommended.

10. Apply grease through grease zerks provided on the side of the top plate until grease comes out of the hole in the pocket liner. If grease does not come out, it may be necessary to remove the grease zerk and drill out any obstruction in-between the pocket and liner.
11. After attaining free grease flow, install the top plate onto the bracket cap and secure with the original pivot pins or pivot bolts supplied.
12. Finally, lubricate the pivot pockets through the grease zerks provided on the side of the top plate.

NOTE:

This rework procedure should provide additional life for your HOLLAND XA-3501-UB top plate. In the future, should it become necessary to replace the top plate, the new top plate (XA-3501-03505) will fit this bracket repair.

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