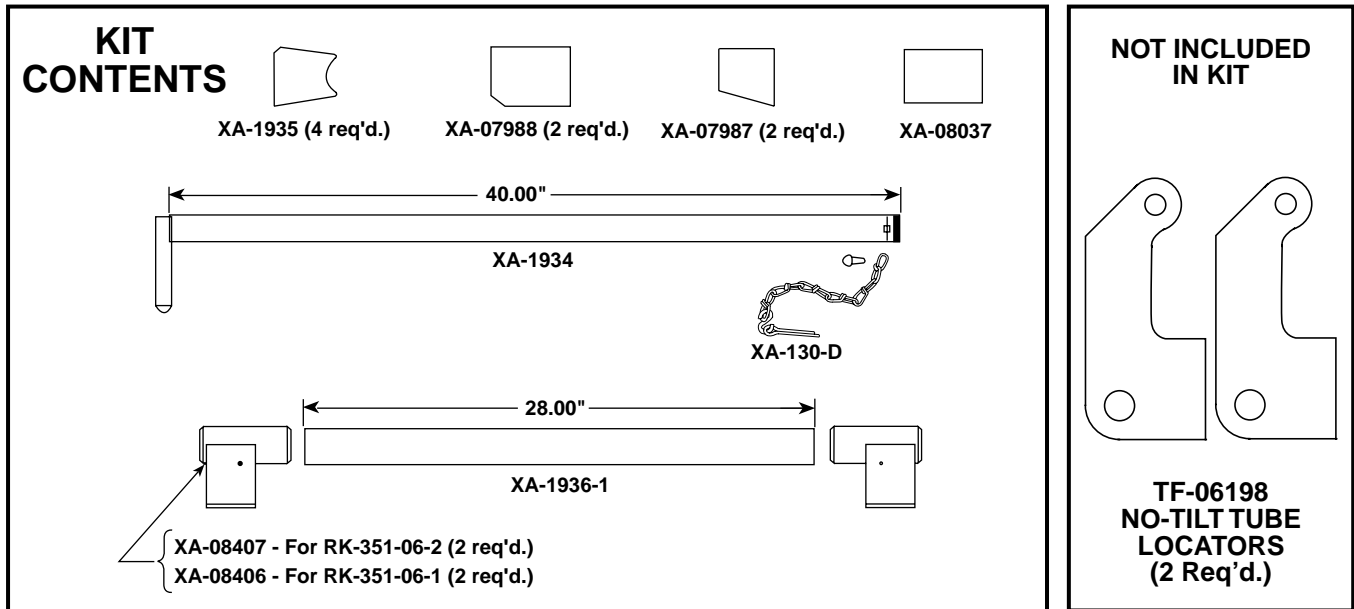




# XA-351 STATIONARY FIFTH WHEEL NO-TILT INSTALLATION INSTRUCTIONS

For Use with kits RK-351-06-2 (7.69") and RK-351-06-1 (8.69")



## 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 7.69" and 8.69" 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:

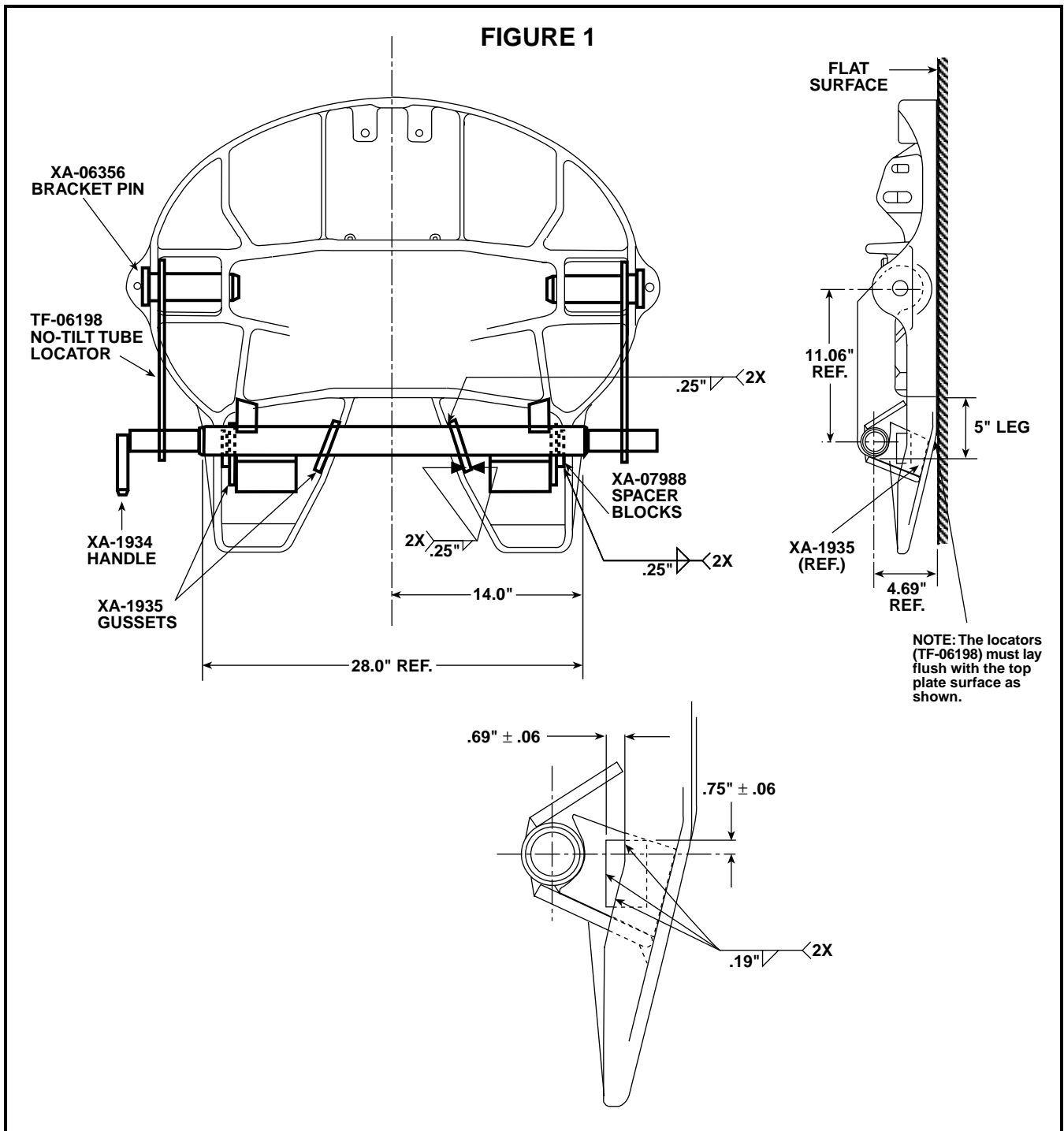
1. Remove the fifth wheel top plate.
2. Remove all dirt and excess debris away from the welding areas of the fifth wheel.
3. Using the existing bracket pins, insert the pin through both ears and the 1.12" diameter hole of the TF-06198 No-Tilt Tube Locator as shown in figure 1 on page 2.
4. Assemble the 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. 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.

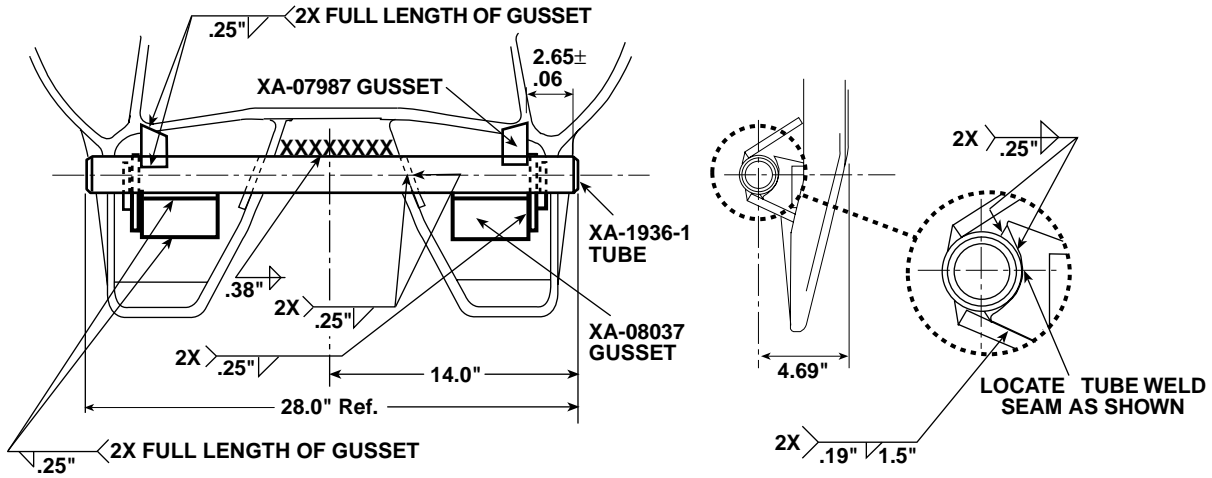
6. Locate four (4) XA-1935 gussets and (2) XA-07988 spacer blocks so as to allow proper placement of the XA-1936-1 tube. Use .25" fillet welds and .19" fillet welds to attach gussets and spacer blocks to the top plate as shown in figure 1 below.

**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-08037 gussets and the two XA-07987 gussets using .25" fillet welds, and .19" fillet welds as shown in figure 2.



**FIGURE 2**



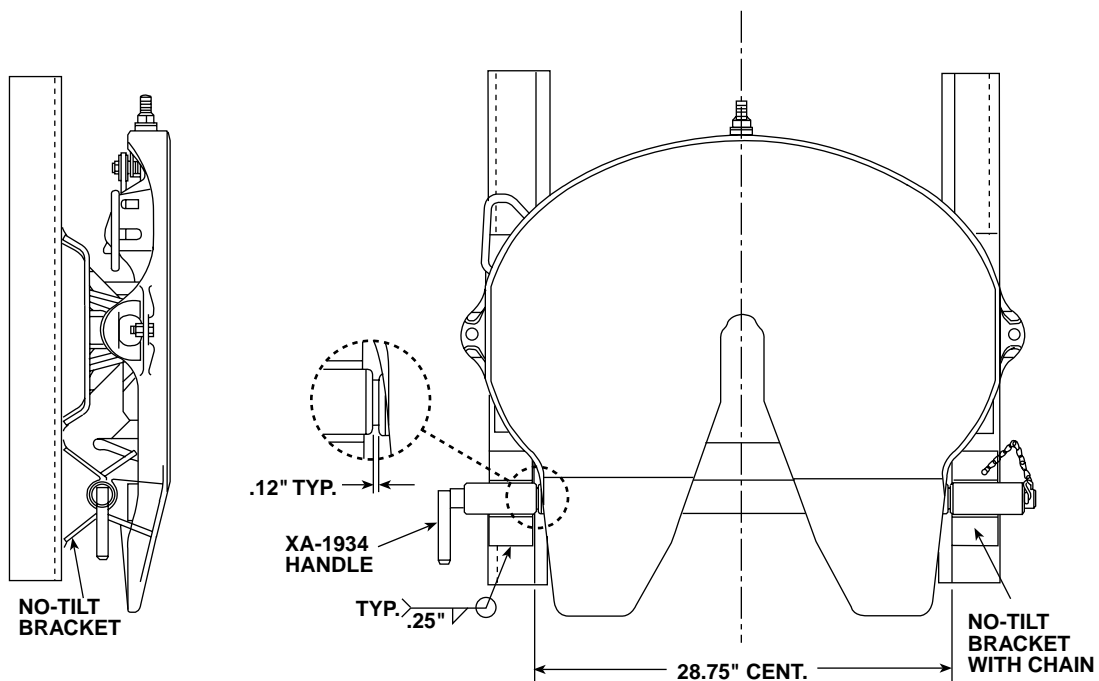
**NO-TILT ASSEMBLY MOUNTING ON BRACKETS:**

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-08406 or XA-08407) as shown in figure 3.

**FIGURE 3**



Copyright © November 1999 Holland Hitch Company



★ Holland Hitch Co.  
Holland, MI 49423  
(616) 396-6501  
(888) 396-6501  
FAX (800) 769-3299

★ Holland Hitch of New Jersey  
Whitehouse Station, NJ 08889  
(908) 534-4162  
(888) 396-6501  
FAX (800) 769-3299

★ Holland Atlantic Hitch Co.  
Denmark, SC 29042  
(803) 793-3313  
(888) 396-6501  
FAX (800) 769-3299

★ Holland Hitch of Texas, Inc.  
Wylie, TX 75098  
(972) 442-3556  
(888) 396-6501  
FAX (800) 769-3299

★ Holland Pacific Hitch Co.  
Milpitas, CA 95035  
(408) 262-2550  
(888) 396-6501  
FAX (800) 769-3299

▲ Holland Binkley Co.  
Warrenton, MO 63383  
(314) 456-3455  
FAX (314) 456-6790

▲ Holland Axle Products, Inc.  
Delphos, OH 45833  
(419) 692-6015  
FAX (419) 692-5815

★ Holland Hitch of Canada, Ltd.  
Woodstock, Ontario N4S 7Z5  
(519) 537-3494  
FAX (800) 565-7753

▲ Holland Equipment, Ltd.  
Norwich, Ontario N0J 1P0  
(519) 863-3414  
FAX (519) 863-2398  
FAX (05207) 895656

★ Holland Hitch Western, Ltd.  
Surrey, BC V3S 5K1  
(604) 574-7491  
FAX (604) 574-0244  
FAX (021) 520-6070

✦ Eurohitch, GmbH.  
Schloss Holte  
Germany  
(05207) 89560  
FAX (03) 736-5588

✦ Eurohitch (U.K.), Ltd.  
Tipton, West Midlands  
United Kingdom  
(021) 520-6116

Holland Transtrade  
Far East Sdn. Bhd.  
Kuala Lumpur, Malaysia  
(03) 734-2888

Nippon Holland, Ltd.  
Tokyo, Japan  
(03) 3461-9130  
FAX (03) 3463-1407

✦ Holland Hitch (Aust.), Ltd.  
Melton, Victoria, Australia  
(03) 9743-6799  
FAX (03) 9747-9617