



# ART SERIES

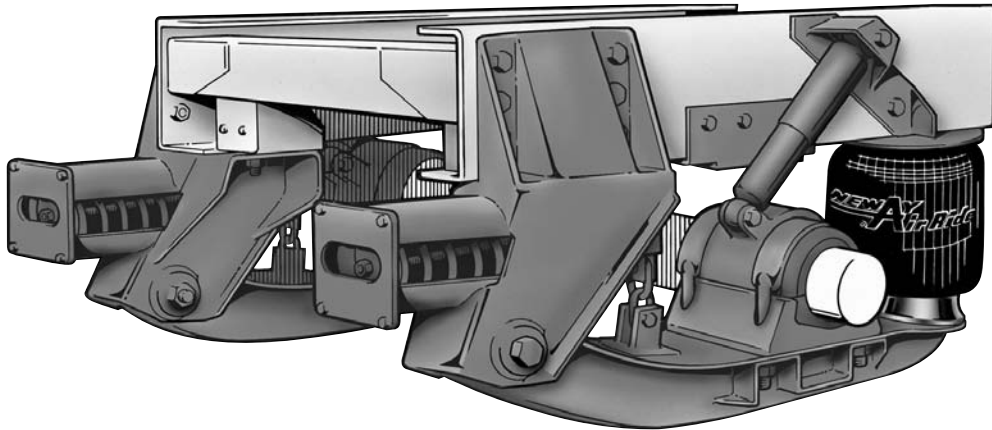
## MAINTENANCE AND PARTS LIST

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### ART Series Air Ride Suspensions

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ART-500-US	ART-500-B
ART-500-US-A	ART-505-B & -C
ART-550-US	ART-551-B
ART-551-US	ART-555-B & -C



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## INTRODUCTION

This manual provides you information necessary for the care, maintenance, inspection, and safe operation of the SAF-HOLLAND ART Series Truck/Tractor air ride suspensions.

The SAF-HOLLAND ART Series air ride suspension is designed and engineered to provide trouble-free service. In the event of minor breakdown, such as a loss of air in the air springs, there are safety features designed into the suspension that will allow the vehicle to be driven CAUTIOUSLY at slow speed, to the nearest service facility.

This suspension uses air drawn from the tractor air system to pressurize the air springs. A manual control valve and calibrated air gauge are utilized to control and determine the air pressures required for varying loads. A feature of this suspension is the ability to provide a cushioned ride throughout the load range, from empty to fully loaded.

The suspension also provides a traction control feature by reducing the air pressure in the air springs when needed.

## WARRANTY

Refer to the complete warranty for the country in which the product will be used. A copy of the written warranty is included with the product as well as on the SAF-HOLLAND Web Site ([www.safholland.us](http://www.safholland.us))

A warranty certificate may also be ordered by calling 1-888-396-6501.

## NOTES, CAUTIONS, AND WARNINGS

You must read and understand all of the safety procedures presented in this manual before starting any work on the suspension.

Proper tools must be used to perform the maintenance and repair procedures described in this manual. Many of these procedures require special tools.

Failure to use the proper equipment could result in personal injury and/or damage to the suspension.

**Safety glasses must be worn at all times when performing the procedures covered in this manual.**

Throughout this manual, you will notice the terms “NOTE,” “IMPORTANT,” “CAUTION” and “WARNING” followed by important product information. So that you may better understand the manual, those terms are as follows:

**NOTE:** Includes additional information to enable accurate and easy performance of procedures.

**IMPORTANT:** Includes additional information that if not followed could lead to hindered product performance.

**CAUTION** Used without the safety alert symbol, indicates a potentially hazardous situation which, if not avoided, may result in property damage.

**▲ CAUTION** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

**▲ WARNING** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

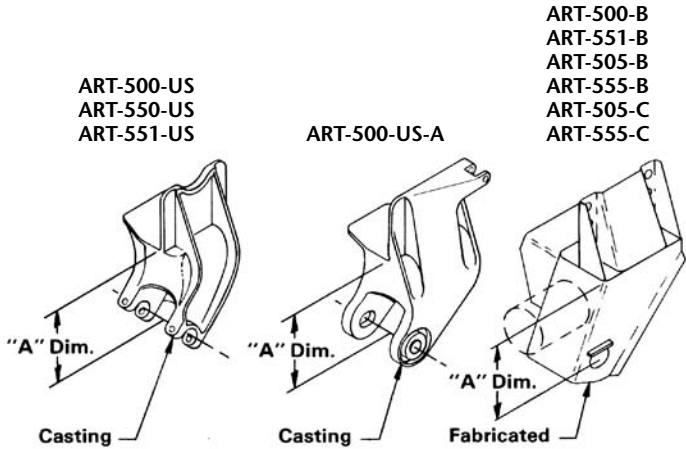
## MODEL IDENTIFICATION

To determine your "ART" model when ordering replacement parts or for service information, compare the frame brackets on the unit to those shown below. (FIGURE 1).

The basic ART-500 Series has a total axle travel of 8-1/2". The basic ART-550 and ART-551 Series have 10" of axle travel.

**NOTE:** The frame to centerline of pivot dimensions on the various models. The shock absorbers and air springs are different for each model.

FIGURE 1 ART Series Frame Brackets



### "A" Dimension

SERIES	"A" DIMENSION	PARTS LIST
ART-500-US	8-3/8"	Page 7
ART-550-US	11-1/2"	Page 9
ART-551-US	11-1/2"	Page 10
ART-500-US-A	8-1/2"	Page 8
ART-551-B	11-1/2"	Page 11
ART-500-B	8-1/2"	Page 11
ART-505-B	8-1/2"	Page 12
ART-555-B	11-1/2"	Page 12
ART-505-C	8-1/2"	Page 14
ART-555-C	11-1/2"	Page 14

## MODEL NOMENCLATURE

**ART-500-US, ART-550-US, ART-551-US** - cast frame bracket with bar pin bushing in frame bracket (all are non-liftable suspensions); compare the frame brackets on the unit to those shown (FIGURE 1).

**ART-500-US-A** - cast frame bracket with through bolt bushing in frame bracket (all are non-liftable suspensions); compare the frame brackets on the unit to those shown (FIGURE 1).

**ART-500-B/-551-B** - 8.5" (500-B) pivot height (bottom of rail to center of bushing), 11.5" (551-B). Fabricated frame bracket (all are non-liftable suspensions); compare the frame brackets on the unit to those shown (FIGURE 1).

**ART-505-B/-555-B** - 8.5" (505-B) pivot height (bottom of rail to center of bushing), 11.5" (555-B). Fabricated frame bracket (all are liftable suspensions, including coil lift spring); compare the frame brackets on the unit to those shown (FIGURE 1).

**ART-505-C/-555-C** - 8.5" (505-C) pivot height (bottom of rail to center of bushing), 11.5" (555-C). Fabricated frame bracket (all are liftable suspensions, including coil lift spring); compare the frame brackets on the unit to those shown (FIGURE 1).

**NOTE:** Generally speaking, the higher the dash number (-3), the greater the up travel in the suspension.

FIGURE 2 Serial Number Tag

# HOLLAND USA, INC.

MANUFACTURED UNDER ONE OR MORE OF THE FOLLOWING U.S. PATENTS:

5,639,110	5,588,665	4,595,216	4,615,539	5,354,091
5,393,096	5,088,763	5,083,812	5,203,585	5,470,096
5,201,898	5,288,100	6,241,266	5,924,712	4,838,578
6,073,946	6,062,578	6,116,626	6,328,322	4,838,566
6,398,236	4,871,188			

**MODEL NO.**

**CAPACITY (LBS)**

**PART NO.**

**SERIAL NO.**

CONSULT SPECIFICATION FOR CAPACITY AND RECOMMENDED APPLICATION.

PART NO. 938 00 269

Model Number \_\_\_\_\_

Parts List Number \_\_\_\_\_

Serial Number \_\_\_\_\_

In Service Date \_\_\_\_\_

## SERVICE NOTES

The service life of component parts will vary from application to application, due to the severity of the operation, etc. The following information is offered as a guideline only to help prevent extensive repairs and down time. The pre-operation check list and periodic inspection list must be followed to obtain maximum service life from your suspension components.

**⚠️ WARNING** For any service procedure, failure to chock tires prior to beginning maintenance could allow vehicle rollaway which, if not avoided, could result in death or serious injury.

**⚠️ WARNING** Failure to properly support suspension during maintenance may allow suspension to fall which, if not avoided, could result in death or serious injury.

- 1.\* **Front Pivot Connection.** Inspect front rubber bushings, delrin liners and rod bolts at 100,000 miles. Excessive play in this area can cause premature tire wear and erratic handling characteristics. A loose bolt will cause the rubber pivot bushing connection to wear out prematurely.
- 2.\* **Axle Connections.** Inspect rubber wrappers and lower rubber pads at 100,000 miles. Before installing, inspect axle adapters and beam seats for excessive wear. Replace axle adapters or beam seats, if necessary. Worn or loose parts

will allow the axle to shift laterally and excessive vehicle roll could occur, causing the vehicle to be unstable. **Do not** operate vehicle in this condition.

3. **Air Springs.** Air springs should provide service in excess of 500,000 miles. Do not operate vehicle with the air springs in a deflated or over-extended position. If a suspension air system failure should occur, temporary steps can be taken (refer to Troubleshooting section in this manual) to continue careful operation of vehicle to nearest place of service. Check the air springs periodically for signs of chafing or wear created by interference with other objects. Correct interference; replace if worn.
4. **Shock Absorbers.** Shock absorbers should be inspected at 50,000 miles or at the first sign of leaking hydraulic fluid. Worn or broken shocks could allow tire hop and poor handling characteristics.
5. **Hand Control Valve.** The hand control valve controls the air pressure required in the air springs to maintain proper axle load. Maintain a clean air system; drain air tanks periodically.
- 6.\* **Coil Spring Lift.** Inspect bolts and bearings at 75,000 - 100,000 miles.

**\*NOTE:** Complete Service Repair Kits (SRKs) available. Refer to page 19.

## PERIODIC OPERATION INSPECTION CHECKLIST

After your SAF-HOLLAND Air Ride Suspension has been in operation for approximately 3,000 miles, perform requirements listed.

### Torque Chart (Cleaned)

SUSPENSION		COIL SPRING LIFT	
1"	680 ft. lbs.	1/2"	50 ft. lbs.
1-1/8"	600 ft. lbs.	5/8"	50 ft. lbs.
1/2"	35 ft. lbs.	3/4"	150 ft. lbs.
3/4"	35 ft. lbs.		
3/4"	150 ft. lbs.		

\*bolt requires lower torque when silver-colored Dacromet (extra lubrication) coating is present; however, bolts with other coatings typically require higher torque.

\*\*Air Spring Connections Only.

\*\*\*Lower Cam Pin Coil Spring Lift.

**Note:** 5/8" Frame Attachment – 150 ft. lbs.

### TORQUE NOTE:

Torque specifications are with **clean** threads.

### IMPORTANT:

Use of special lubricants with friction modifiers, such as Anti-Seize or Never-Seize, without written approval from SAF-HOLLAND Engineering, will void warranty and could lead to bolt failure or other component issues.

### First 3,000 Mile Requirements

1. Check all nuts, bolts and air line fittings for proper torque. Assure metal-to-metal condition exists at axle cap to beam seat connection.
2. With tractor on level surface and air pressure in excess of 65 psig, activate hand control valve and check air system for leaks.
3. Check air spring for proper clearance, 1-3/4" all around.

### 50,000 Mile Requirements

1. Check all items listed under First 3,000 Mile Requirements.
2. Block up tractor frame, allowing axle to hang down, and check air springs for any signs of chafing or wear.
3. Articulate axle up and down, checking for any signs of looseness due to worn parts at the front pivot connections. Also, check axle connections for side to side movement of axle during articulation, which can be caused by worn parts. (See note below.)
4. Check axle connection welds (beam seat to equalizing beam and axle adapter to axle) visually for sound welds. If beam is cracked, always replace beam.

**IMPORTANT:** NEVER repair a cracked equalizing beam. **DO NOT** weld cracks. Secondary weld failures during use may cause loss of vehicle control.

**⚠️ WARNING** Failure to replace a cracked equalizing beam could allow weld failures and loss of vehicle control which, if not avoided, could result in death or serious injury.

5. Check shock absorbers for any signs of leaking hydraulic fluid, broken end connections and worn rubber bushings.

**NOTE:** If a worn condition exists, Service Repair Kits (SRK) are available. Refer to page 19.

# OPERATING INSTRUCTIONS

**⚠️ WARNING** Do not overload the axle or the suspension or suspension components damage may occur which, if not avoided, could result in vehicle damage and/or death or serious injury.

Maximum ART Series suspension capacity is 20,000 lbs. The ART air ride suspension is controlled by a manually-operated hand valve, which controls the air pressure in the air springs to support the load being carried. Before operation, the tractor air pressure must be in excess of 65 psig to inflate the air springs.

If the loss of air pressure in the suspension air system occurs, an air brake protection valve is provided to automatically maintain a safe air brake pressure of 65 psig.

A minimum and maximum adjusting nut is provided and should be set prior to operation. A minimum of 3 psig must be maintained to prevent air spring damage. If air pressure is varying during operation, it may be necessary to adjust friction disc under valve handle. Refer to page 18 for instructions.

**TABLE 1**  
**Air Pressure VS Load Guide\***

AXLE LOAD	ART SERIES NO COIL SPRING LIFT PSI	ART SERIES WITH COIL SPRING LIFT PSI
5,000	14	30
10,000	39	50
13,000	53	70
16,000	66	80
18,000	75	90
20,000	83	100

**\*NOTE:** Table 1 above is to be used only as a guide.

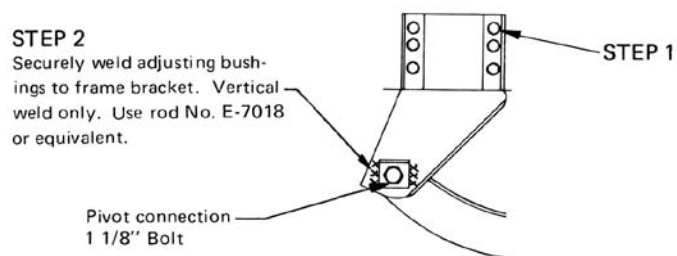
**NOTE:** The air pressure versus load table is approximate and may vary. The variations will depend upon maintaining the proper suspension design height and/or the levelness of the surface on which the vehicle is sitting. To obtain an accurate load reading versus air pressure reading, it is recommended that the unit be calibrated over a flat and accurate scale. Holland assumes no responsibility as to the accuracy of loads based on Table 1.

# PRE-OPERATIONAL CHECKLIST

**Before the tractor is placed into service, the following items should be inspected carefully.**

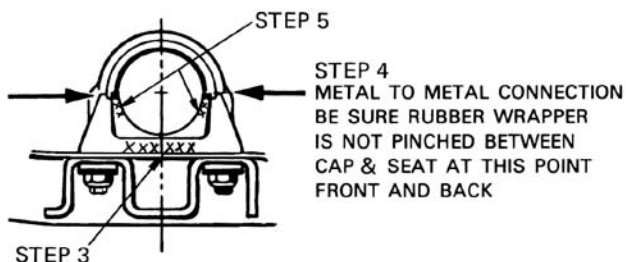
1. Check for proper attachment of suspension to frame. All fasteners must be properly installed and torqued in accordance with Holland installation instructions (**FIGURE 3**).
2. Check axle alignment. Axle **must** be within 1/8" of each other. Adjusting bushings **must** be welded securely to frame bracket. The 1-1/8" bolts at the front pivot connections must be torqued per Torque Chart on page 4 (**FIGURE 3**).

**FIGURE 3**



3. Check welding of beam seat to equalizing beam for proper welds (**FIGURE 4**).
4. Inspect axle connections: axle cap to beam seat must be metal-to-metal contact front and rear of cap. Tighten U-bolt nuts per Torque Chart on page 4 (**FIGURE 4**). Torque if necessary.
5. Visually check welding of axle adapter to axle, 3/8" minimum fillet weld, 3/4" maximum down from top of axle adapter (**FIGURE 4**).

**FIGURE 4**



6. With tractor on level surface, no load, and air pressure in excess of 65 psig, actuate hand control valve to assure proper air flow to air springs. Check minimum air pressure in suspension system. Air pressure should be at 3 psig. If it is not 3 psig, adjust minimum adjusting nut on hand control valve. Refer to page 18.
7. Check air springs:
  - Air springs should be of equal firmness when pressurized.
  - Check suspension air system for leaks.
  - Clearance around air springs should be 1-3/4" when pressurized to 83 psig.
  - Ride height (underside of frame to center line of axle) **must** be within Operating Range of model installed to protect air springs and shock absorbers from over-extension.
  - On coil spring lift models: grease cam pin. See note on page 22.

## Ride Height Chart

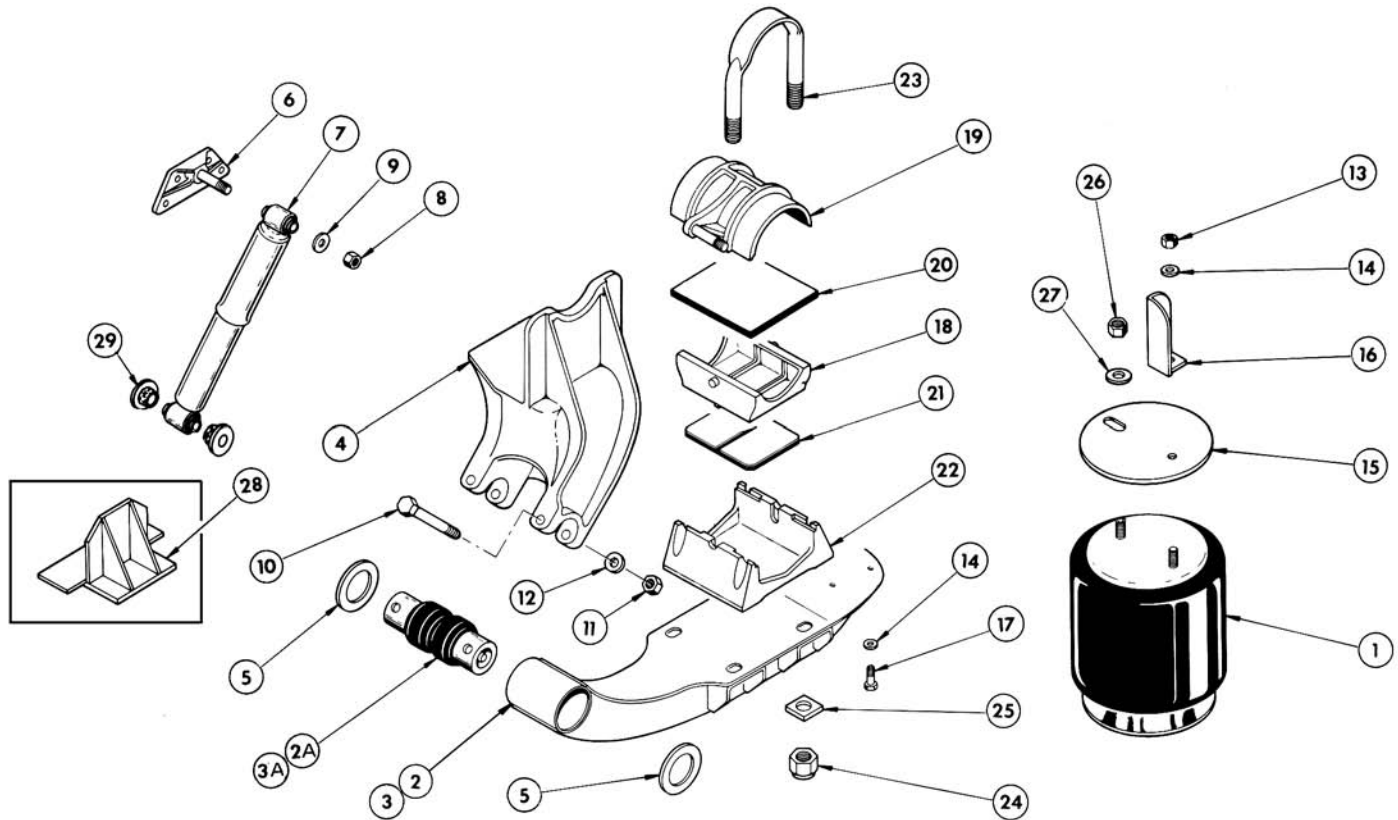
MODEL NO.	RIDE HEIGHT DIM.
ART-500-B-1, ART-505-B-1 With 3-3/8" Drop Tube Axle	6" - 7-1/2"
ART-500-B-1, ART-505-B-1, ART-505-C-1	8-1/2" - 10"
ART-500-B, ART-505-B, ART-505-C	9-1/2" - 11"
ART-551-B-1, ART-555-B-1, ART-555-C-1	10-1/2" - 11-1/2"
ART-551-B-2, ART-555-B-2, ART-555-C-2	11-1/2" - 13"
ART-551-B-3, ART-555-B-3, ART-555-C-3	13" - 14-1/2"

**NOTE:** If any of these items **do not** pass pre-operational check, contact installer or qualified Holland Service Center.

# ART-500-US SUSPENSION PARTS LIST

**FIGURE 5**  
**ART-500-US Parts List**

**IMPORTANT:** All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. Suspension components vary by assembly part number and OEM/Chassis builder specifications. To ensure proper part number identification before placing order, refer to OEM/Chassis builder's specifications or visually check component to be replaced for part number. If part number can not be identified or confirmed please contact SAF-HOLLAND technical service for assistance - 888-396-6501.



## ART-500 US Suspension Components

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Air Spring	905 57 006	2
2	Equalizing Beam Assy LH (roadside - includes)	905 15 061	1
2A	Rubber Bushing	900 08 005	1
3	Equalizing Beam Assy RH (curbside - includes)	905 15 062	1
3A	Rubber Bushing	900 08 005	1
4	Frame Bracket LH	*	1
	Frame Bracket RH	*	1
5	Spacer Washer	900 36 003	4
6	Upper Shock Mount Bracket	905 18 010	2
7	Shock Absorber	900 44 008	2
8	Lock Nut 3/4" -10	934 00 492	4
9	H.T. Washer 3/4"	936 00 005	4
10	H.T. Hex Hardened Bolt 7/8"-9 x 5.50"	930 03 855	4
11	Lock Nut 7/8" - 9	934 00 498	4
12	H.T. Washer 7/8"	936 00 162	4
13	Regular Hex Nut 1/2" - 13	934 00 136	2
14	Lock Washer 1/2"	936 00 072	10

ITEM NO.	DESCRIPTION	PART NO.	QTY.
15	Air Spring Mounting Plate	900 31 027	2
16	Air Spring Mounting Bracket	900 18 018	2
17	Hex Hardened Bolt 1/2" - 13 x 1"	930 02 893	8
18	Axle Adapter, 5" Dia. Rod	900 01 082	2
19	Axle Cap & Lower Shock Mount Bracket LH	**	1
	Axle Cap & Lower Shock Mount Bracket RH	**	1
20	Rubber Wrapper, 5" Dia. Rod	900 28 007	2
21	Rubber Pad	900 28 016	2
22	Axle Beam Seat	900 01 006	2
23	1" - 8 x 9" U-Bolt	900 41 878	4
24	1" - 8 Lock Nut	934 00 502	8
25	1" Flat Square Washer	936 00 028	8
26	3/4" - 16 Regular Hex Nut	934 00 149	2
27	3/4" Lock Washer	936 00 077	2
28	Axle Stop	905 44 005	2
29	Replacement Bushing (4 per shock)	905 08 004	8

\*For frame bracket replacement, refer to page 27.

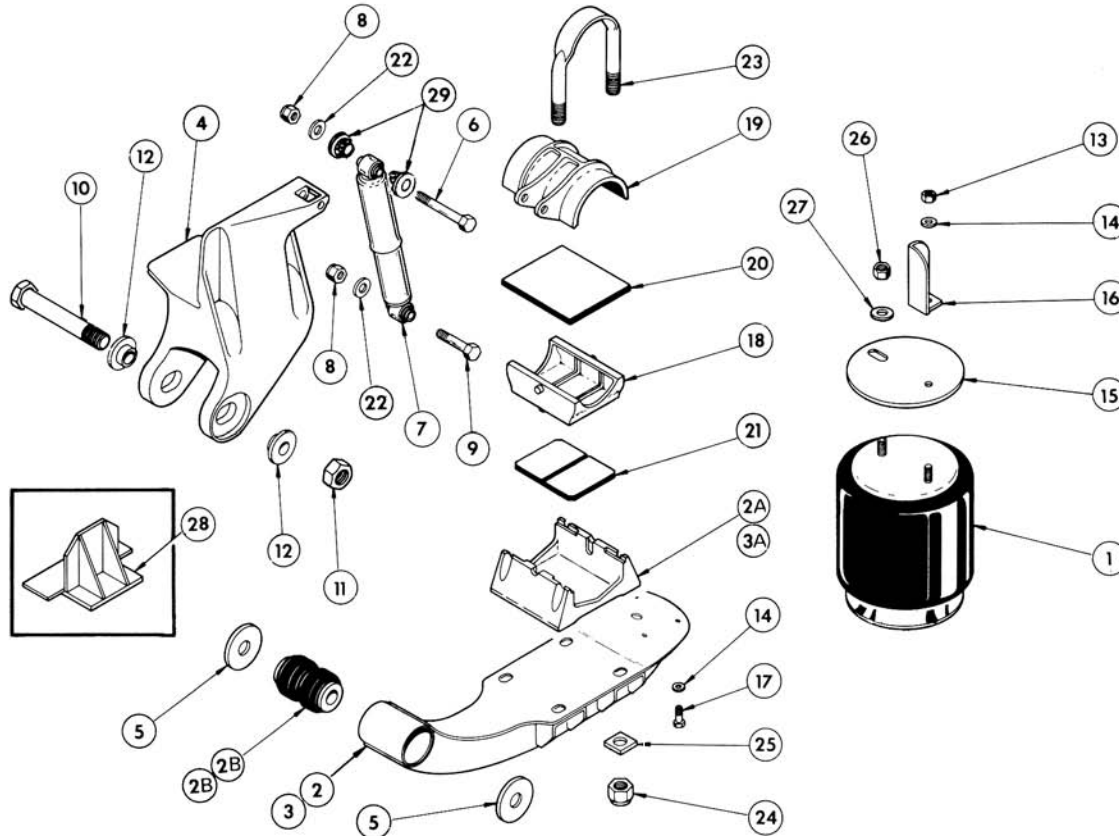
\*\*For axle cap replacement, refer to page 27.

**NOTE:** Service Repair Kits (SRKs) are available for servicing the suspension. Refer to page 19.

# ART-500-US-A SUSPENSION PARTS LIST

**FIGURE 6**  
ART-500-US-A Parts List

**IMPORTANT:** All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. Suspension components vary by assembly part number and OEM/Chassis builder specifications. To ensure proper part number identification before placing order, refer to OEM/Chassis builder's specifications or visually check component to be replaced for part number. If part number can not be identified or confirmed please contact SAF-HOLLAND technical service for assistance - 888-396-6501.



## ART-500-US-A Suspension Components

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Air Spring Assembly	905 57 006	2
2	Equalizing Beam Assy LH (roadside - includes)	905 15 235	1
2A	Beam Seat	900 01 006	1
2B	Rubber Bushing	900 08 013	1
3	Equalizing Beam Assy RH (curbside - includes)	905 15 236	1
3A	Beam Seat	900 01 006	1
3B	Rubber Bushing	900 08 013	1
4	Frame Bracket LH	*	1
	Frame Bracket RH	*	1
5	Spacer Washer	900 36 006	4
6	3/4"-10 x 5.50" Hex Head Bolt	930 03 645	2
7	Shock Absorber	900 44 008	2
8	Lock Nut 3/4" - 10	934 00 492	4
9	Hex Head Bolt 3/4"-10 x 3.50"	930 03 597	2
10	Hex Head Bolt 1-1/4"-7 x 9.25"	930 04 785	2
11	Lock Nut 1-1/4" - 7	934 00 508	2
12	Alignment Bushing	900 08 012	4
13	Regular Hex Nut 1/2" - 13	934 00 136	2

ITEM NO.	DESCRIPTION	PART NO.	QTY.
14	Lock Washer 1/2"	936 00 072	10
15	Air Spring Mounting Plate	900 31 027	2
16	Air Spring Mounting Bracket	900 31 051	2
17	Hex Head Bolt 1/2" - 13 x 1"	930 02 893	8
18	Axle Adapter, 5" Dia. Rod	900 01 082	2
19	Axle Cap & Lower Shock Mount Bracket LH	**	1
	Axle Cap & Lower Shock Mount Bracket RH	**	1
20	Rubber Wrapper, 5" Dia. Rod	900 28 007	2
21	Rubber Pad	900 28 016	2
22	H.T. Washer 3/4"	936 00 005	4
23	1"- 8 x 9" U-Bolt	900 41 878	4
24	1"- 8 Lock Nut	934 00 502	8
25	1" Flat Washer	936 00 028	8
26	3/4"- 16 Regular Hex Nut	934 00 149	2
27	3/4" Lock Washer	936 00 077	2
28	Axle Stop - Upper	905 44 005	2
29	Replacement Bushing (4 per shock)	905 08 004	8

\*For frame bracket replacement, refer to page 27.

\*\*For axle cap replacement, refer to page 27.

**NOTE:** Service Repair Kits (SRKs) are available for servicing the suspension. Refer to page 19.

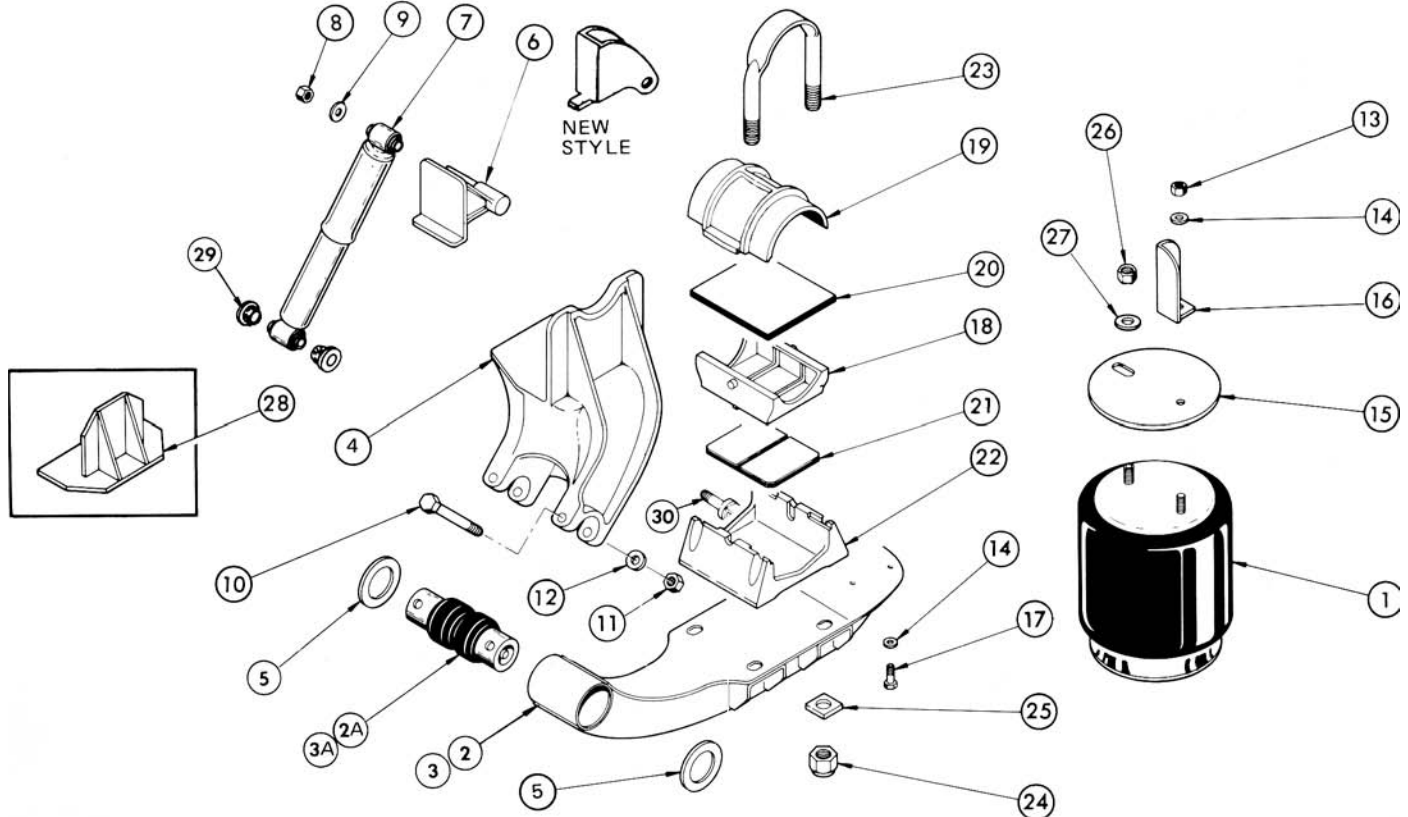


# ART-550-US-1, -2, -3 SUSPENSION PARTS LIST

FIGURE 7

## ART-550-US-1, -2, -3 Parts List

**IMPORTANT:** All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. Suspension components vary by assembly part number and OEM/Chassis builder specifications. To ensure proper part number identification before placing order, refer to OEM/Chassis builder's specifications or visually check component to be replaced for part number. If part number can not be identified or confirmed please contact SAF-HOLLAND technical service for assistance - 888-396-6501.



### ART-550-US-1, -2, -3 Suspension Components

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Air Spring Assembly	905 57 008	2
2	Equalizing Beam Assy LH (roadside - includes)	905 15 067	1
2A	Rubber Bushing	900 08 005	1
3	Equalizing Beam Assy RH (curbside - includes)	905 15 068	1
3A	Rubber Bushing	900 08 005	1
4	Frame Bracket LH	*	1
	Frame Bracket RH	*	1
5	Spacer Washer	900 36 003	4
6	Upper Shock Mount Bracket LH	***	1
	Upper Shock Mount Bracket RH.	***	1
7	Shock Absorber	900 44 012	2
8	Lock Nut 3/4" - 10	934 00 492	4
9	H.T. Washer 3/4"	936 00 005	4
10	Hex Head Bolt 7/8" - 9 x 5.50"	930 03 855	4
11	Lock Nut 7/8" - 9	934 00 498	4
12	H.T. Washer 7/8"	936 00 162	4
13	Regular Hex Nut 1/2" - 13	934 00 136	2
14	Lock Washer 1/2"	936 00 072	10
15	Air Spring Mounting Plate	900 31 027	2

ITEM NO.	DESCRIPTION	PART NO.	QTY.
16	Air Spring Mounting Bracket	900 18 018	2
17	Hex Head Bolt 1/2" - 13 x 1"	930 02 893	8
18	Axle Adapter, 5" Dia. Rod	900 01 082	2
19	Axle Connection Cap	**	2
20	Rubber Wrapper	900 28 007	2
21	Rubber Pad	900 28 016	2
22	Axle Beam Seat (-1 Models only)	900 01 008	2
	Axle Beam Seat (-2 Models only)	900 01 007	2
	Axle Beam Seat (-3 Models only)	900 01 006	2
23	1" - 8 x 12" U-Bolt (-1 Models only)	900 41 890	4
	1" - 8 x 12" U-Bolt (-2 Models only)	900 41 886	4
	1" - 8 x 12" U-Bolt (-3 Models only)	900 41 878	4
24	1" - 8 Lock Nut	934 00 502	8
25	1" Flat Washer	936 00 028	8
26	3/4" - 16 Regular Hex Nut	934 00 149	2
27	3/4" Lock Washer	936 00 077	2
28	Axle Stop	905 44 006	2
29	Replacement Bushing (4 per shock)	905 08 004	8
30	Lower Shock Mounting Bracket	905 18 027	2

\*For frame bracket replacement, refer to page 27.

\*\*For axle cap replacement, refer to page 27.

\*\*\*This style bracket has been superseded by a clevis style bracket (P/N 900 18 301). When ordering this style bracket: you must also order one (per bracket) 930 03 597 bolt.

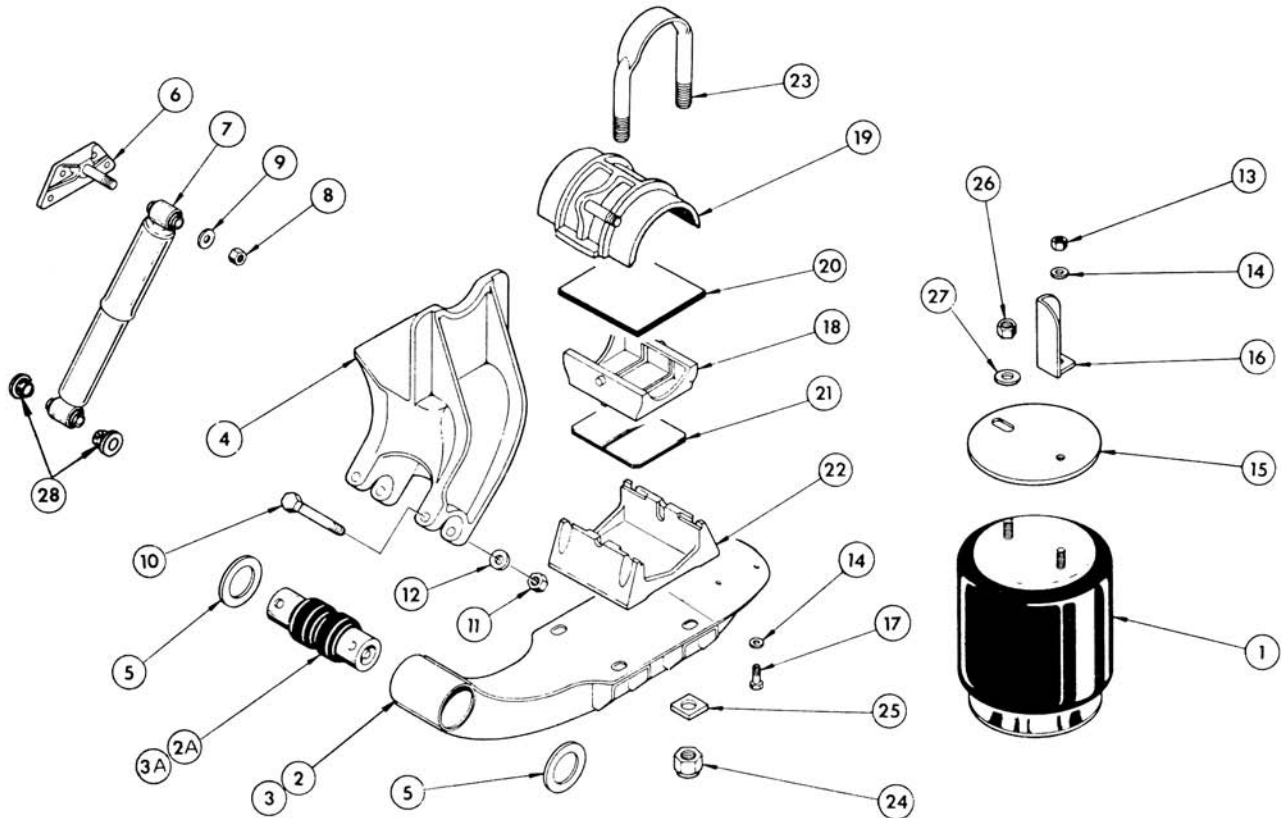
**NOTE:** Service Repair Kits (SRKs) are available for servicing the suspension. Refer to page 19.

# ART-551-US-1, -2, -3 SUSPENSION PARTS LIST

FIGURE 8

## ART-551-US-1, -2, -3 Parts List

**IMPORTANT:** All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. Suspension components vary by assembly part number and OEM/Chassis builder specifications. To ensure proper part number identification before placing order, refer to OEM/Chassis builder's specifications or visually check component to be replaced for part number. If part number can not be identified or confirmed please contact SAF-HOLLAND technical service for assistance - 888-396-6501.



### ART-551-US-1, -2, -3 Suspension Components

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Air Spring Assembly	905 57 008	2
2	Equalizing Beam Assy LH (roadside - includes)	905 15 061	1
2A	Rubber Bushing	900 08 005	1
3	Equalizing Beam Assy RH (curbside - includes)	905 15 062	1
3A	Rubber Bushing	900 08 005	1
4	Frame Bracket LH	*	1
	Frame Bracket RH	*	1
5	Spacer Washer	900 36 003	4
6	Upper Shock Mount Bracket	905 18 010	2
7	Shock Absorber	900 44 017	2
8	Lock Nut 3/4" - 10	934 00 492	4
9	H.T. Washer 3/4"	936 00 005	4
10	Hex Head Bolt 7/8" - 9 x 5.50"	930 03 855	4
11	Lock Nut 7/8" - 9	934 00 498	4
12	H.T. Washer 7/8"	936 00 162	4
13	Regular Hex Nut 1/2" - 13	934 00 136	2
14	Lock Washer 1/2"	936 00 072	10
15	Air Spring Mounting Plate	900 31 027	2

ITEM NO.	DESCRIPTION	PART NO.	QTY.
16	Air Spring Mounting Bracket	900 18 018	2
17	Hex Head Bolt 1/2" - 13 x 1"	930 02 893	8
18	Axle Adapter, 5" Dia. Rod	900 01 082	2
19	Axle Cap & Lower Shock Mount Bracket LH	**	1
	Axle Cap & Lower Shock Mount Bracket RH	**	1
20	Rubber Wrapper, 5" Dia. Rod	900 28 007	2
21	Rubber Pad	900 28 016	2
22	Axle Beam Seat (-1 Models only)	900 01 008	2
	Axle Beam Seat (-2 Models only)	900 01 007	2
	Axle Beam Seat (-3 Models only)	900 01 006	2
23	1" - 8 x 12" U-Bolt (-1 Models only)	900 41 890	4
	1" - 8 x 12" U-Bolt (-2 Models only)	900 41 886	4
	1" - 8 x 12" U-Bolt (-3 Models only)	900 41 878	4
24	1" - 8 Lock Nut	934 00 502	8
25	1" Flat Square Washer	936 00 028	8
26	3/4" - 16 Regular Hex Nut	934 00 149	2
27	3/4" Lock Washer	936 00 077	2
28	Replacement Bushing (4 per shock)	905 08 004	8

\*For frame bracket replacement, refer to page 27.

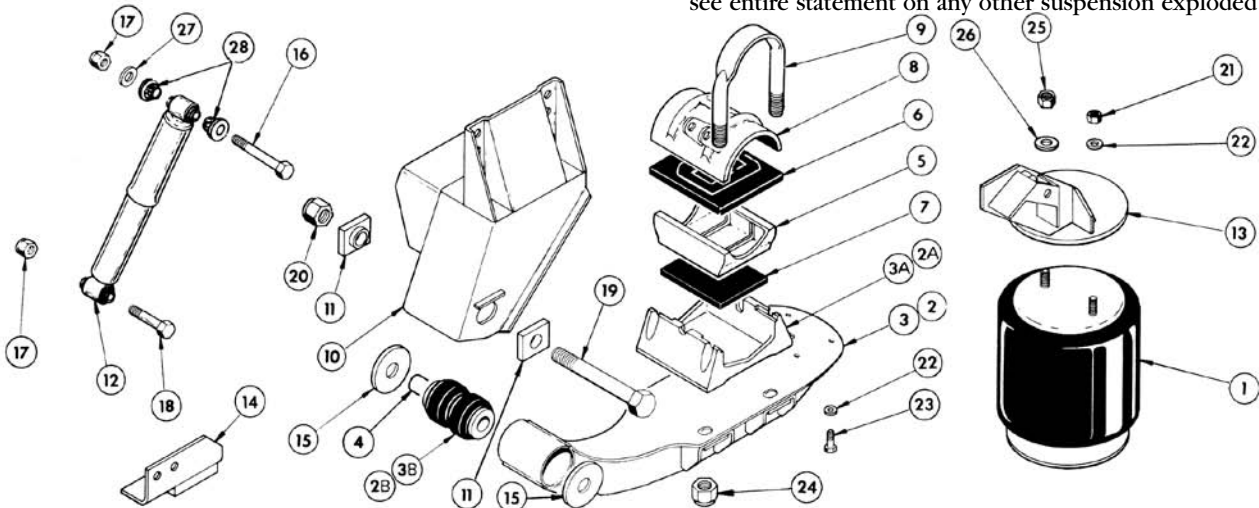
\*\*For axle cap replacement, refer to page 27.

**NOTE:** Service Repair Kits (SRKs) are available for servicing the suspension. Refer to page 19.

# ART-500-B, ART-500-B-1, ART-551-B-1, -2, -3 SUSPENSION PARTS LIST

**FIGURE 9**  
ART-500-B, ART-500-B-1, ART-551-B-1, -2, -3 Parts List

**IMPORTANT:** All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. For further information regarding parts availability, see entire statement on any other suspension exploded view.



## ART-500, ART-500-B-1, ART-551-B-1, -2, -3 Suspension Components

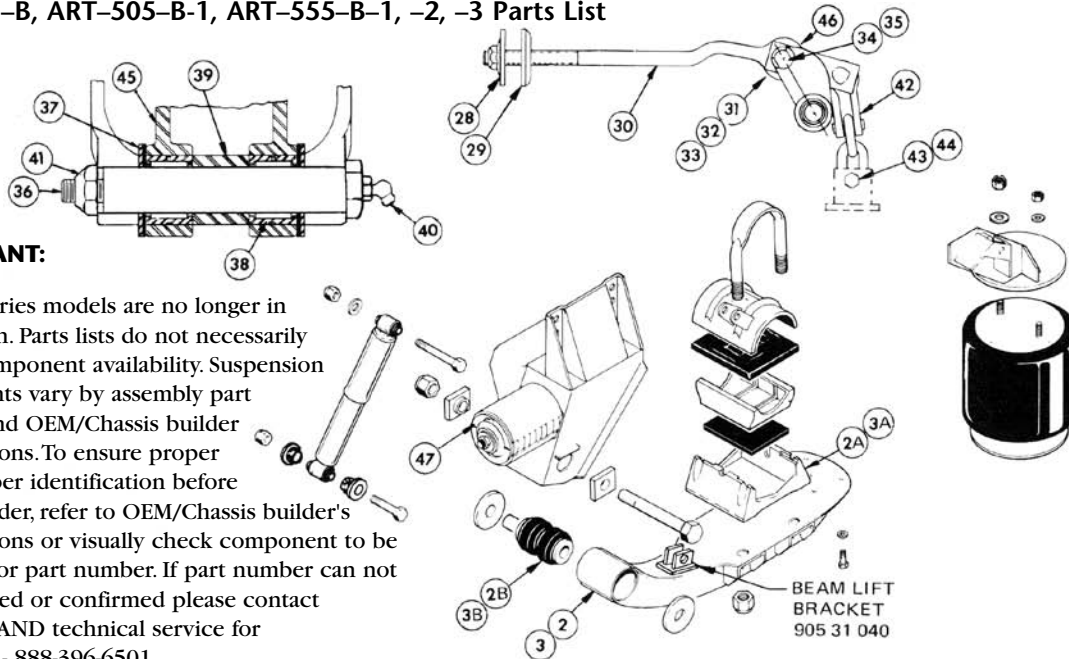
ITEM NO.	DESCRIPTION	ART-500-B PART NO.	ART-500-B-1 PART NO.	ART-551-B-1 PART NO.	ART-551-B-2 PART NO.	ART-551-B-3 PART NO.	QTY.
1	Air Spring Assembly	905 57 006	905 57 006	905 57 008	905 57 008	905 57 008	2
2	Equalizing Beam Assembly, LH (includes)	905 15 235	905 15 241	905 15 251	905 15 241	905 15 235	1
2A	Beam Seat	900 01 006	905 01 037	900 01 008	905 01 037	900 01 006	1
2B	Rubber Bushing	900 08 013	900 08 013	900 08 013	900 08 013	900 08 013	1
3	Equalizing Beam Assembly, RH (includes)	905 15 236	905 15 242	905 15 252	905 15 242	905 15 236	1
3A	Beam Seat	900 01 006	905 01 037	900 01 008	905 01 037	900 01 006	1
3B	Rubber Bushing	900 08 013	900 08 013	900 08 013	900 08 013	900 08 013	1
4	Inner Sleeve	900 08 037	900 08 037	900 08 037	900 08 037	900 08 037	2
5	Axle Adapter 5" Round	900 01 082	900 01 082	900 01 082	900 01 082	900 01 082	2
	Axle Adapter 5" Square	900 01 083	900 01 083	900 01 083	900 01 083	900 01 083	2
6	Rubber Wrapper 5" Round	900 28 047	900 28 047	900 28 047	900 28 047	900 28 047	1
	Rubber Wrapper 5" Square	900 28 073	900 28 073	900 28 073	900 28 073	900 28 073	1
7	Rubber Pad	900 28 075	900 28 075	900 28 075	900 28 075	900 28 075	2
8	Axle Cap Assembly LH 5" Round without Stops	905 10 061	905 10 061	905 10 061	905 10 061	905 10 061	1
	Axle Cap Assembly LH 5" Square without Stops	905 10 054	905 10 054	905 10 054	905 10 054	905 10 054	1
	Axle Cap Assembly LH 5" Round with Stops	905 10 063	905 10 063	905 10 063	905 10 063	905 10 063	1
	Axle Cap Assembly RH 5" Round without Stops	905 10 062	905 10 062	905 10 062	905 10 062	905 10 062	1
	Axle Cap Assembly RH 5" Square without Stops	905 10 055	905 10 055	905 10 055	905 10 055	905 10 055	1
	Axle Cap Assembly RH 5" Round with Stops	905 10 064	905 10 064	905 10 064	905 10 064	905 10 064	1
9	U-Bolt 1" - 8 x 9" Long 5" Round	900 41 878	—	—	—	900 41 878	4
	U-Bolt 1" - 8 x 10" Long 5" Round	—	900 41 882	—	900 41 882	—	4
	U-Bolt 1" - 8 x 12" Long 5" Round	—	—	900 41 890	—	—	4
	U-Bolt 1" - 8 x 9-1/2" Long 5" Square	900 41 997	—	—	—	900 41 997	4
	U-Bolt 1" - 8 x 10-1/2" Long 5" Square	—	900 42 001	—	900 42 001	—	4
	U-Bolt 1" - 8 x 12" Long 5" Square	—	—	900 42 007	—	—	4
10	Frame Bracket Assembly LH Adjustable with holes	905 18 459	905 18 459	905 18 463	905 18 463	905 18 463	1
	Frame Bracket Assembly RH Fixed with holes	905 18 460	905 18 460	905 18 464	905 18 464	905 18 464	1
11	Adjusting Bushing	900 01 045	900 01 045	900 01 045	900 01 045	900 01 045	2
12	Shock Absorber	900 44 162	900 44 162	900 44 162	900 44 017	900 44 017	2
13	Air Spring & Shock Bracket Assembly LH	905 18 319	905 18 321	905 18 319	905 18 321	905 18 319	1
	Air Spring & Shock Bracket Assembly RH	905 18 320	905 18 322	905 18 320	905 18 322	905 18 320	1
14	Axle Stop Assembly LH 5" Round	905 44 241	905 44 243	905 44 243	905 44 245	905 44 247	1
	Axle Stop Assembly RH 5" Round	905 44 242	905 44 244	905 44 244	905 44 246	905 44 248	1
15	Spacer Washer	900 36 006	900 36 006	900 36 006	900 36 006	900 36 006	4
16	Hex Head Bolt 3/4" - 10 x 5-1/2"	930 03 645	930 03 645	930 03 645	930 03 645	930 03 645	4
17	Hex Lock Nut 3/4" - 10	934 00 492	934 00 492	934 00 492	934 00 492	934 00 492	4
18	Hex Head Bolt 3/4" - 10 x 3-1/2"	930 03 597	930 03 597	930 03 597	930 03 597	930 03 597	2
19	Hex Head Bolt 1-1/8" - 7 x 9-1/4"	932 00 961	932 00 961	932 00 961	932 00 961	932 00 961	2
20	Lock Nut 1-1/8" - 7	934 00 504	934 00 504	934 00 504	934 00 504	934 00 504	2
21	Hex Nut 1/2" - 13	934 00 136	934 00 136	934 00 136	934 00 136	934 00 136	2
22	Lock Washer 1/2"	936 00 072	936 00 072	936 00 072	936 00 072	936 00 072	8
23	Hex Head Bolt 1/2" - 13 x 1"	930 02 893	930 02 893	930 02 893	930 02 893	930 02 893	6
24	Lock Nut 1" - 8	934 00 502	934 00 502	934 00 502	934 00 502	934 00 502	8
25	Hex Nut 3/4" - 16	934 00 149	934 00 149	934 00 149	934 00 149	934 00 149	2
26	Lock Washer 3/4"	936 00 077	936 00 077	936 00 077	936 00 077	936 00 077	2
27	HT Washer 3/4"	936 00 005	936 00 005	936 00 005	936 00 005	936 00 005	2
28	Replacement Bushing (4 per shock)	905 08 004	905 08 004	905 08 004	905 08 004	905 08 004	8

**NOTE:** Service Repair Kits (SRKs) of pivot connection and axle connection, refer to page 19.

# ART-505-B, ART-505-B-1, ART-555-B-1, -2, -3 SUSPENSION PARTS LIST

FIGURE 10

ART-505-B, ART-505-B-1, ART-555-B-1, -2, -3 Parts List



**IMPORTANT:**

All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. Suspension components vary by assembly part number and OEM/Chassis builder specifications. To ensure proper part number identification before placing order, refer to OEM/Chassis builder's specifications or visually check component to be replaced for part number. If part number can not be identified or confirmed please contact SAF-HOLLAND technical service for assistance - 888-396-6501.

**ART-505-B, ART-505-B-1, ART-555-B-1, -2, -3 Suspension Components**

**NOTICE:** Parts for these models same as models without Coil Spring Lift except for items listed below.

ITEM NO.	DESCRIPTION	ART-505-B PART NO.	ART-505-B-1 PART NO.	ART-555-B-1 PART NO.	ART-555-B-2 PART NO.	ART-555-B-3 PART NO.	QTY.
2	Equalizing Beam Assembly, LH (includes)	905 15 327	905 15 364	905 15 541	905 15 364	905 15 327	1
2A	Beam Seat	900 01 006	905 01 037	900 01 008	905 01 037	900 01 006	1
2B	Rubber Bushing	900 08 013	900 08 013	900 08 013	900 08 013	900 08 013	1
3	Equalizing Beam Assembly, RH (includes)	905 15 328	905 15 365	905 15 542	905 15 365	905 15 328	1
3A	Beam Seat	900 01 006	905 01 037	900 01 008	905 01 037	900 01 006	1
3B	Rubber Bushing	900 08 013	900 08 013	900 08 013	900 08 013	900 08 013	1
10	Frame Bracket Assembly LH Adjustable with holes	905 18 466	905 18 466	905 18 646	905 18 646	905 18 646	1
	Frame Bracket Assembly RH Fixed with holes	905 18 467	905 18 467	905 18 647	905 18 647	905 18 647	1
28	Adjusting Lock Nut	939 00 151	939 00 151	939 00 151	939 00 151	939 00 151	2
29	Yoke Grommet	900 44 218	900 44 218	900 44 218	900 44 218	900 44 218	2
30	Yoke Rod	900 06 342	900 06 342	900 06 342	900 06 342	900 06 342	2
31	Bearing Seal (Yoke Rod)	900 44 575	900 44 575	900 44 575	900 44 575	900 44 575	4
32	Inner Sleeve	900 38 222	900 38 222	900 38 222	900 38 222	900 38 222	2
33	Roller Bearing (Yoke Rod)	900 38 220	900 38 220	900 38 220	900 38 220	900 38 220	2
34	Lock Nut 1/2" - 13	934 00 541	934 00 541	934 00 541	934 00 541	934 00 541	2
35	Upper Cam Pin	900 44 481	900 44 481	900 44 481	900 44 481	900 44 481	2
36	Lower Cam Pin	905 44 661	905 44 661	905 44 661	905 44 661	905 44 661	2
37	Lower Bearing Seal (Cam)	900 44 574	900 44 574	900 44 574	900 44 574	900 44 574	4
38	Roller Bearing (Cam)	900 38 219	900 38 219	900 38 219	900 38 219	900 38 219	4
39	Lower Bearing Seal (Inner Cam)	900 44 576	900 44 576	900 44 576	900 44 576	900 44 576	2
40	Grease Fitting	938 00 228	938 00 228	938 00 228	938 00 228	938 00 228	4
41	Lock Nut 3/4" - 10	934 00 494	934 00 494	934 00 494	934 00 494	934 00 494	2
42	Linkage Assembly	905 44 545	905 44 545	905 44 545	905 44 545	905 44 545	2
43	Hex Head Bolt 5/8" - 11 x 2-1/2"	930 03 359	930 03 359	930 03 359	930 03 359	930 03 359	2
44	Lock Nut 5/8" - 11	934 00 490	934 00 490	934 00 490	934 00 490	934 00 490	2
45	Cam (with bearings)	905 44 701	905 44 701	905 44 701	905 44 701	905 44 701	2
46	Grease Fitting	938 00 229	938 00 229	938 00 229	938 00 229	938 00 229	2
47	Decal	900 44 244	900 44 244	900 44 244	900 44 244	900 44 244	2

**NOTES:** The coil spring lift (1" dia. lower cam pin) shown is for units produced after September 1, 1977. For units produced prior to this date or conversions refer to pages 22-25. ART 505-C models supersede ART 505-B. Unless specific components on your installation match illustration above, refer to ART 505-C model for spring lift units.

Grease yoke rod and cam at routine maintenance or every 5,000 miles.

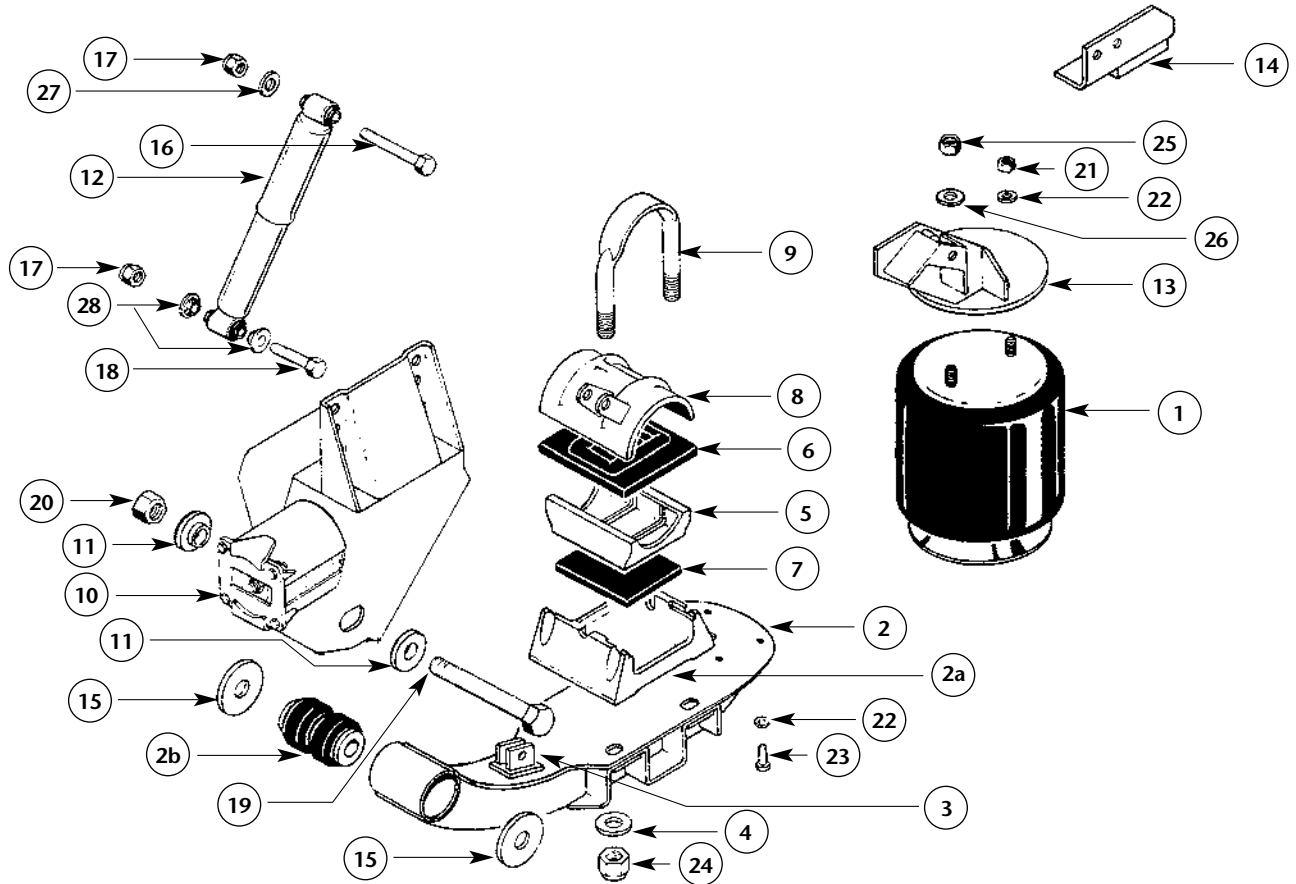
For Service Repair Kits (SRKs) of the coil spring lift, pivot connection & axle connection, refer to page 19.

# ART-505-C, -1, ART-555-C-1, -2, -3 SUSPENSION PARTS LIST

FIGURE 11

ART-505-C, -1, ART-555-C-1, -2, -3 Parts List

**IMPORTANT:** All ART Series models are no longer in production. Parts lists do not necessarily reflect component availability. Suspension components vary by assembly part number and OEM/Chassis builder specifications. To ensure proper part number identification before placing order, refer to OEM/Chassis builder's specifications or visually check component to be replaced for part number. If part number can not be identified or confirmed please contact SAF-HOLLAND technical service for assistance - 888-396-6501.



# ART-505-C, -1, ART-555-C-1, -2, -3 SUSPENSION PARTS LIST

## ART-505-C, -1, ART-555-C-1, -2, -3 Suspension Components

ITEM NO.	DESCRIPTION	ART-505-C PART NO.	ART-505-C-1 PART NO.	ART-555-C-1 PART NO.	ART-555-C-2 PART NO.	ART-555-C-3 PART NO.	QTY.
1	Air Spring Assembly	905 57 027	905 57 027	905 57 009	905 57 009	905 57 009	2
2	Equalizing Beam Assembly, LH (includes key 2a, 2b, 3)	905 16 335	905 16 337	905 16 341	905 16 337	905 16 335	1
	Equalizing Beam Assembly, RH (includes key 2a, 2b, 3)	905 16 336	905 16 338	905 16 342	905 16 338	905 16 336	1
2A	Beam Seat	900 01 006	905 01 037	900 01 008	905 01 037	900 01 006	2
2B	Rubber Bushing	900 08 139	900 08 139	900 08 139	900 08 139	900 08 139	2
3	Beam Lift Bracket	905 31 040	905 31 040	905 31 040	905 31 040	905 31 040	2
4	Washer 1"	939 00 027	939 00 027	939 00 027	939 00 027	939 00 027	8
5	Axle Adapter	900 01 082	900 01 082	900 01 082	900 01 082	900 01 082	2
6	Rubber Wrapper	900 28 047	900 28 047	900 28 047	900 28 047	900 28 047	2
7	Rubber Pad	900 28 083	900 28 083	900 28 083	900 28 083	900 28 083	2
8	Axle Cap Assembly LH - without axle stops	905 10 061	905 10 061	905 10 061	905 10 061	905 10 061	1
	Axle Cap Assembly RH - without axle stops	905 10 062	905 10 062	905 10 062	905 10 062	905 10 062	1
	Axle Cap Assembly LH - with axle stops	905 10 063	905 10 063	905 10 063	905 10 063	905 10 063	1
	Axle Cap Assembly RH - with axle stops	905 10 064	905 10 064	905 10 064	905 10 064	905 10 064	1
9	U-Bolt 1" - 8 x 9"	900 41 878	-	-	-	900 41 878	4
	U-Bolt 1" - 8 x 10.5"	-	900 42 791	-	900 42 791	-	4
	U-Bolt 1" - 8 x 12.5"	-	-	900 42 792	-	-	4
10	Frame Bracket Assembly LH Adjustable	905 19 995	905 19 995	905 19 993	905 19 993	905 19 993	1
	Frame Bracket Assembly RH Fixed	905 19 996	905 19 996	905 19 994	905 19 994	905 19 994	1
11	Adjusting Bushing	900 08 147	900 08 147	900 08 147	900 08 147	900 08 147	2
12	Shock Absorber	900 44 162	900 44 162	900 44 162	900 44 642	900 44 642	2
13	Air Spring & Shock Bracket Assembly LH	905 18 319	905 18 321	905 18 319	905 18 321	905 18 319	1
	Air Spring & Shock Bracket Assembly RH	905 18 320	905 18 322	905 18 320	905 18 322	905 18 320	1
14	Axle Stop Assembly LH 5" Round	905 44 241	905 44 243	905 44 243	905 44 245	905 44 247	1
	Axle Stop Assembly RH 5" Round	905 44 242	905 44 244	905 44 244	905 44 246	905 44 248	1
15	Spacer Washer	900 36 177	900 36 177	900 36 177	900 36 177	900 36 177	4
16	Hex Head Bolt 3/4" - 10 x 5-1/2" Gr 5	930 03 645	930 03 645	930 03 645	930 03 645	930 03 645	2
17	Hex Lock Nut 3/4" - 10 Gr B	934 00 492	934 00 492	934 00 492	934 00 492	934 00 492	4
18	Hex Head Bolt 3/4" - 10 x 3-1/2" Gr 5	930 03 597	930 03 597	930 03 597	930 03 597	930 03 597	2
19	Hex Head Bolt 1-1/8" - 7 x 9-1/4" Gr 8	932 01 055	932 01 055	932 01 055	932 01 055	932 01 055	2
20	Lock Nut 1-1/8" - 7 Gr C	934 00 506	934 00 506	934 00 506	934 00 506	934 00 506	2
21	Hex Nut 1/2" - 13 Gr B	934 00 136	934 00 136	934 00 136	934 00 136	934 00 136	2
22	Lock Washer 1/2"	936 00 072	936 00 072	936 00 072	936 00 072	936 00 072	8
23	Hex Head Bolt 1/2" - 13 x 1" Gr 2	930 02 893	930 02 893	930 02 893	930 02 893	930 02 893	6
24	Lock Nut 1" - 8 Gr C	934 00 502	934 00 502	934 00 502	934 00 502	934 00 502	8
25	Hex Nut 3/4" - 16 Gr B	934 00 149	934 00 149	934 00 149	934 00 149	934 00 149	2
26	Lock Washer 3/4"	936 00 077	936 00 077	936 00 077	936 00 077	936 00 077	2
27	HT Washer 3/4"	936 00 005	936 00 005	936 00 005	936 00 005	936 00 005	2
28	Replacement Bushing (4 per shock)	905 08 004	905 08 004	905 08 004	905 08 004	905 08 004	8

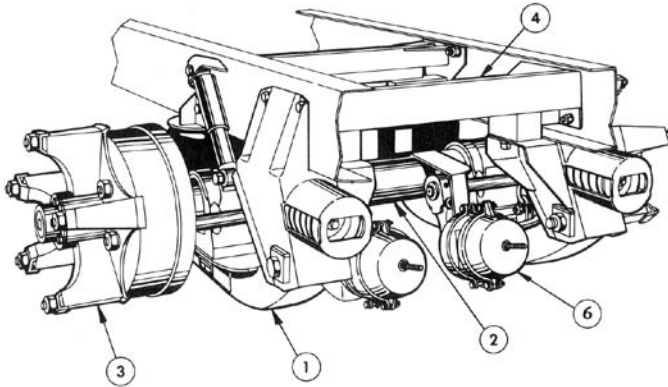
**NOTES:** The coil spring lift (1" dia. lower cam pin) shown is for units produced after September 1, 1977. For units produced prior to this date or conversions refer to pages 22-25.

Grease yoke rod and cam at routine maintenance or every 5,000 miles.

For Service Repair Kits (SRKs) of the coil spring lift, pivot connection & axle connection, refer to page 19.

# ARTA-5000 SERIES PARTS LIST

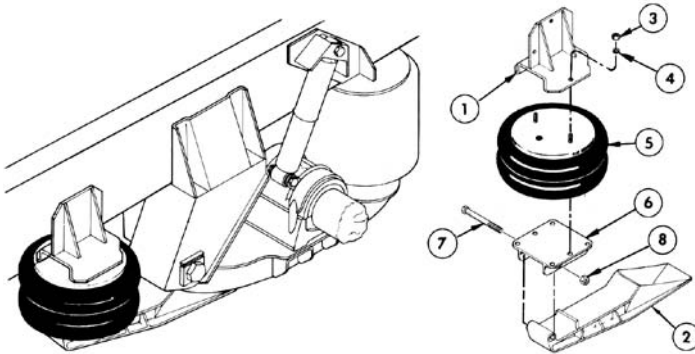
**FIGURE 12**  
ARTA-5000 Series Parts List



1. **Suspension.** Refer to Model Identification, page 3. When you identify the model suspension, then refer to the standard suspension parts list.
2. **Axle.** Determine Brand, then refer to the Axle Distributor for service.
3. **Wheels.** Determine Brand, then refer to the Wheel Distributor for service.
4. **Crossmember Kit.** Holland Neway CMK-600 for ARTA with or without Coil Spring Lift. Holland Neway CMK-700-1 for ARTA with AL-75-B Air Lift.
5. **Air Controls (not shown).** ACN-5500 with Coil Spring Lift; ACN-5600 without Coil Spring Lift; AC-84-M/S-1 with AL-75-B Air Lift.
6. **Spring Brakes (24").** Refer to Spring Brake Distributor for service.

# ALT-40 & ALT-40-L AXLE AIR LIFT PARTS LIST

**FIGURE 13**  
ALT-40 & ALT-40-L Parts List



## ALT-40 Axle Air Lift ALT-40 (Drawing 440 00 004)

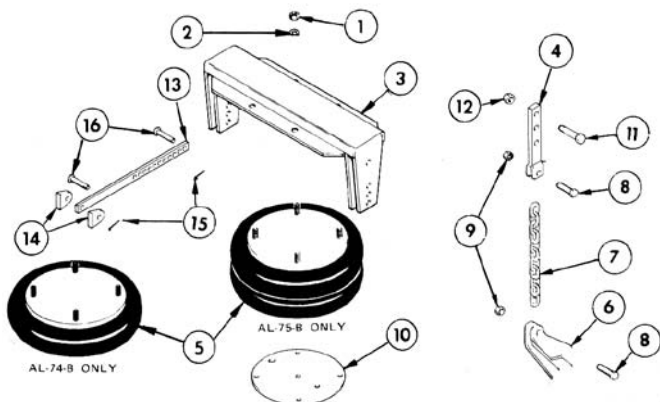
ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Air Spring Mounting Bracket Assembly	905 18 368	2
2	Lift Beam	900 44 203	2
3	Hex Nut 1/2" - 13	934 00 136	8
4	Lock Washer 1/2"	936 00 073	8
5	Air Spring Assembly	905 57 014	2
6	Air Spring Mounting Bracket	900 01 012	2
7	Hex Bolt 3/4" - 10 x 6" GR 5	930 03 657	2
8	Hex Lock Nut 3/4" - 10 GR B	934 00 492	2

## ALT-40-L Axle Air Lift ALT-40-L (Drawing 440 00 004)

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Air Spring Mounting Bracket Assembly	905 18 372	2
2	Lift Beam	900 44 203	2
3	Hex Nut 1/2" - 13	934 00 136	8
4	Lock Washer 1/2"	936 00 073	8
5	Air Spring Assembly	905 57 014	2
6	Air Spring Mounting Bracket	900 01 012	2
7	Hex Bolt 3/4" - 10 x 6" GR 5	930 03 657	2
8	Hex Lock Nut 3/4" - 10 GR B	934 00 492	2

## AL-74-B & AL-75-B AXLE AIR LIFT PARTS LIST

FIGURE 14  
AL-74-B & AL-75-B Parts List



**AL-74-B Axle Air Lift (Service Only)**  
Truck/Tractor Application – AL-74-B (Drawing 440 00 005)

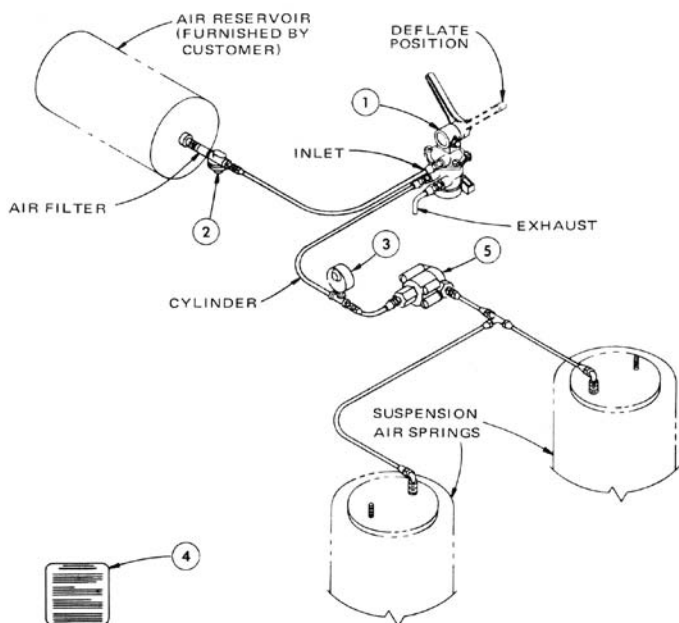
ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Hex Nut 1/2" - 13	934 00 136	8
2	Lock Washer 1/2"	936 00 072	8
3	Air Spring Yoke Lift Assembly	905 01 083	1
4	Yoke Half	900 18 218	4
5	Air Spring	905 57 028	1
6	Bracket Assembly	905 18 201	2
7	3/8" H. T. Chain	900 44 111	2
8	Bolt 1/2" - 13 x 1-3/4"	939 00 031	4
9	Lock Nut 1/2" - 13	934 00 543	4
10	Air Spring Mounting Plate	900 31 027	1
11	Hex Head Cap Screw 5/8" - 11 x 2"	939 00 039	2
12	Lock Nut 5/8" - 11	934 00 551	2

**AL-75-B Axle Air Lift**  
Truck/Tractor Application – AL-75-B (Drawing 440 00 005)

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Hex Nut 1/2" - 13	934 00 136	8
2	Lock Washer 1/2"	936 00 072	8
3	Air Spring Yoke Lift Assembly	905 01 083	1
4	Yoke Half	900 18 218	4
5	Air Spring	905 57 001	1
6	Bracket Assembly	905 18 201	2
7	3/8" H. T. Chain	900 44 111	2
8	Bolt 1/2" - 13 x 1-3/4"	939 00 031	4
9	Lock Nut 1/2" - 13	934 00 543	4
10	Air Spring Mounting Plate	900 31 027	1
11	Hex Head Cap Screw 5/8" - 11 x 2"	939 00 039	2
12	Lock Nut 5/8" - 11	934 00 551	2
13	Control Link	900 06 283	2
14	Stabilizer End Bracket	900 31 007	4
15	Cotter Pin 1/8" x 1"	938 00 001	4
16	Yoke Pin	900 44 164	4

## ACN-5500 AIR CONTROL PIPING AND PARTS LIST

FIGURE 15  
ACN-5500 Parts List



**ACN-5500 Air Control Parts List**

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Hand Valve	900 54 082	1
2	Air Brake Protection Valve & Air Filter	900 54 001	1
3	Air Gauge (Non-Illuminated)	900 54 280	1
4	Decal "Operating Instructions"	900 44 021	1
5	Quick Release Valve	900 54 096	1

**NOTE:** All tubing and fittings to be furnished by customer.

For hand control valve information refer to page 18.

Pressure protection valve & air filter maintain safe air brake pressure & clean air; set to 65 psig at factory.

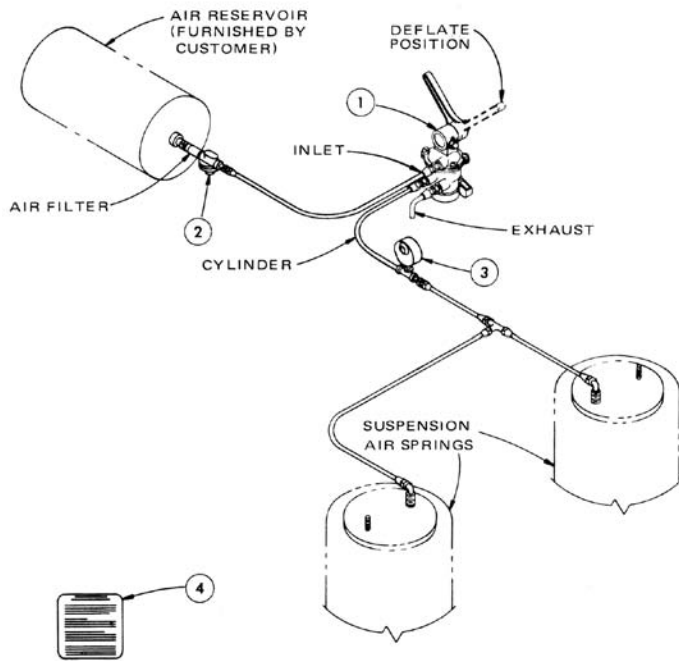
All piping connections 1/4 N.P.T. 3/8" (min.) tubing recommended.

The operating instructions decal is attached so it is visible to the driver.



# ACN-5600 AIR CONTROL PIPING AND PARTS LIST

**FIGURE 16**  
ACN-5600 Parts List



## ACN-5600 Air Control Parts List

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Hand Valve	900 54 082	1
2	Air Brake Protection Valve & Air Filter	900 54 001	1
3	Air Gauge (Non-Illuminated)	900 54 280	1
4	Decal "Operating Instructions"	900 44 021	1

**NOTE:** All tubing and fittings to be furnished by customer.

For hand control valve information refer to page 18.

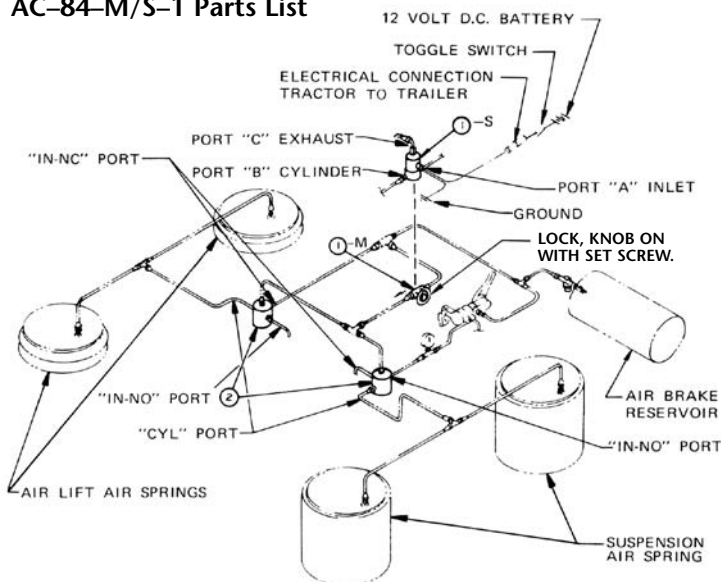
Pressure protection valve & air filter maintain safe air brake pressure & clean air; set to 65 psi at factory.

All piping connections 1/4 N.P.T. 3/8" (min.) tubing recommended.

The operating instructions decal is attached so it is visible to the driver.

# AC-84-M/S-1 AIR CONTROL PIPING AND PARTS LIST (Typical Installation)

**FIGURE 17**  
AC-84-M/S-1 Parts List



SKETCH SHOWS LIFT CONTROL KIT WHEN USED WITH AIR CONTROL KIT NO. AC-5600 or ACN-5600

## AC-84-M/S-1 Air Control Kit Parts List

ITEM NO.	DESCRIPTION	MODEL	PART NO.	QTY.
1	Valve-Manually Operated Selector	AC-84-M-1	900 54 088	1
	Valve-Solenoid Operated - 12 V.D.C.	AC-84-S-1	900 54 074	1
2	Valve-Air Pilot Operated	AC-84-M/S-1	900 54 079	2
		AC-84-S-1	900 44 234	1
3	Operating Instructions Decal	AC-84-M-1	900 44 233	1
		AC-84-S-1	900 44 234	1
4	No. 10 - 32 x 1/2" Machine Screw	AC-84-S-1	932 00 724	2
5	No. 10 Lock Washer	AC-84-S-1	936 00 442	2

**NOTE:** The "S" denotes Electric Solenoid operated valve.

The "M" denotes Manually operated valve.

# HAND CONTROL VALVE (\*Part No. 900 54 082)

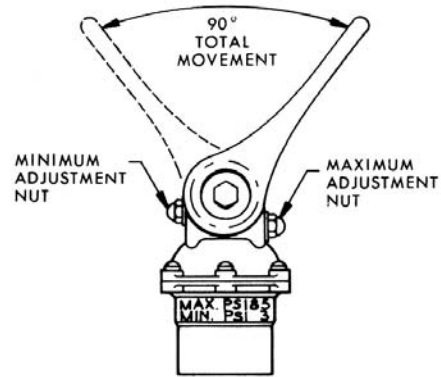
## General Information

FIGURE 18

### Adjustment Instructions

Maximum Pressure (Range 35 psig to 85 psig) - Loosen lower acorn nut and adjust until desired maximum pressure setting is achieved, then tighten acorn nut securely.

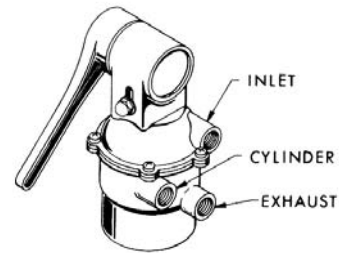
Minimum Pressure (Range 0 psig to 30 psig) - Loosen upper acorn nut and adjust until desired minimum pressure setting is achieved, then tighten acorn nut securely. **Do not** operate unit without air - 3 psig minimum.



## Air Piping

FIGURE 19

**Do not** pressurize exhaust port. Care should be taken to assure air lines are piped to proper hand valve port. Air pressure injected into the exhaust port will unseat an internal "U" type seal causing leakage and malfunction of valve. Valve must be disassembled to reseal.



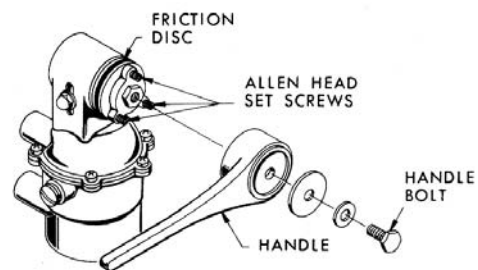
## Hand Valve Handle Tension Adjustment

FIGURE 20

Remove valve handle by turning out handle bolt.

Using allen wrench, tighten (3) allen head set screws equal amounts until desired tension is obtained.

Replace valve handle and tighten handle bolt securely.

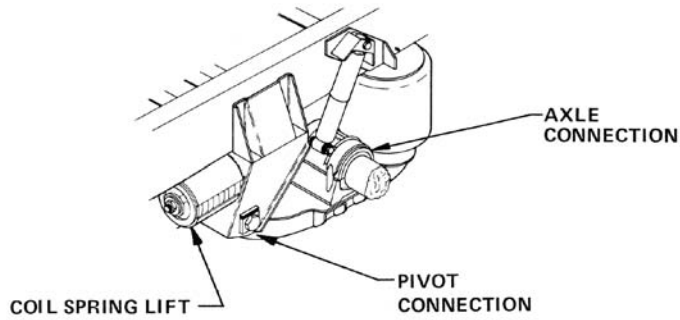


\* Part No. 900 54 082 is hand valve and decal.  
Part No. 900 54 081 is hand valve only.

# SERVICE REPAIR KITS (SRK)

**NOTE:** These SRK's will service only one (1) axle.

FIGURE 21



MODEL	PIVOT CONN.	AXLE CONNECTION**				COIL SPRING LIFT
		OLD STYLE		NEW STYLE		
		5" RD.	5" SQ.	5" RD.	5" SQ.	
ART-500-US	—	SRK-4	—	SRK-64	SRK-68	—
ART-500-US-A	SRK-12	SRK-4	—	SRK-64	SRK-68	—
ART-550-US-1	—	—	—	SRK-128	—	—
ART-550-US-2	—	—	—	SRK-66	—	—
ART-550-US-3	—	SRK-4	—	SRK-64	SRK-68	—
ART-551-US-1	—	—	—	ARK-128	—	—
ART-551-US-2	—	—	—	SRK-66	—	—
ART-551-US-3	—	SRK-4	—	SRK-64	SRK-68	—
ART-500-B	SRK-145	—	—	SRK-64	SRK-68	—
ART-500-B-1	SRK-145	—	—	SRK-66	—	—
ART-505-B	SRK-145	—	—	SRK-64	SRK-68	*
ART-505-B-1	SRK-145	—	—	SRK-66	—	*
ART-551-B-1	SRK-145	—	—	SRK-128	—	—
ART-551-B-2	SRK-145	—	—	SRK-66	—	—
ART-551-B-3	SRK-145	—	—	SRK-64	SRK-68	—
ART-555-B-1	SRK-145	—	—	SRK-128	—	*
ART-555-B-2	SRK-145	—	—	SRK-68	—	*
ART-555-B-3	SRK-145	—	—	SRK-64	SRK-68	*

\*Refer to pages 22-25 for Coil Spring Lift Repair Kit.

\*\*Refer to page 27 for New Style and Old Style connection definition.

## SERVICE REPAIR KITS (SRK) *continued*

### PIVOT CONNECTION REPLACEMENT KIT CHARTS

#### Pivot Connection

SRK-12 Holland part number 481 00 023

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Washer Flat 1.141"	900 36 177	4
2	Bushing	900 08 139	2
3	Bolt Hex 1.125" x 9.53" GR 8	932 01 055	2
4	Nut Hex 1.125" -7 GR C	934 00 506	2
5	Alignment Block with rust inhibitor	900 08 147	4

**Note:** Used on Model ART-500-A-US.

#### Pivot Connection

SRK-145 Holland part number 481 00 202

ITEM NO.	DESCRIPTION	PART NO.	QTY.
	Torque Spec Decal	XL-AR355-02	1
1	Bolt Hex 1.125" - 7 x 9.53" GR 8	932 01 055	2
2	Nut Hex 1.125" - 7 GR C	934 00 506	2
3	Bushing	900 08 139	2
4	Washer Flat	900 36 177	4
6	ART SRK-145 Literature Instruction	XL-AK406	1
7	Decal ART Series Torque Spec's	XL-AK402-01	1

**Note:** Used on Model ART-500-B, ART- 505-B, ART- 505-C, ART-551-B, ART-555-B, ART-555-C.

### AXLE CONNECTION REPLACEMENT KIT CHARTS

#### 5" Round Axle

SRK-4 Holland part number 481 00 008

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Pad Rubber	900 28 016	2
2	U-Bolt 1" - 8 x 9" GR 8	900 41 878	4
3	Nut Hex Lock 1" - 8 GR C	934 00 502	8
4	Washer Square for 1" (25.4mm) Bolt	936 00 028	8
5	Washer Flat 1"	939 00 027	8
6	Wrapper Rubber	900 28 007	2
7	Literature Instruction	XL-AR451	1

**Note:** Used on Model ART-500-US, ART-500-US-A, ART-550-US-3.

#### 5" Round Axle

SRK-64 Holland part number 481 00 108

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Wrapper Rubber	900 28 047	2
2	Pad Rubber	900 28 083	2
3	U-Bolt 1" - 8 x 9" GR 8	900 41 878	4
4	Nut Hex Lock 1" - 8 GR C	934 00 502	8
5	Washer Square for 1" (25.4mm) Bolt	936 00 028	8
6	Washer Flat 1"	939 00 027	8
7	Literature Instruction	XL-AR451	1

**Note:** Used on Model ART-500-US, ART-500-US-A, ART-550-US-3, ART-551-US-3, , ART-500-B, ART-505-B, ART-551-B-3, ART-555-B-3.

### AXLE CONNECTION REPLACEMENT KIT CHARTS

*continued*

#### 5" Round Axle

SRK-66 Holland part number 481 00 110

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Wrapper Rubber	900 28 047	2
2	Pad Rubber	900 28 083	2
3	U-Bolt 1" - 8 x 10.5" GR 8	900 42 791	4
4	Nut Hex Lock 1" - 8 GR C	934 00 502	8
5	Washer Square for 1" (25.4mm) Bolt	936 00 028	8
6	Washer Flat 1"	939 00 027	8
7	Literature Instruction	XL-AR451	1

**Note:** Used on Model Used on Model ART-550-US-2, ART-551-US-2, ART-500-B-1, ART-505-B-1, ART-551-B-2.

#### 5" Round & Square Axle

SRK-68 Holland part number 481 00 112

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Wrapper, Rubber	900 28 005	2
2	Wrapper, Rubber	900 28 073	2
3	Pad, Rubber	900 28 083	2
4	U-Bolt 1" - 8 x 9.5" GR 8	900 41 997	4
5	Nut Hex Lock 1" - 8 GR C	934 00 502	8
6	Washer Square for 1" (25.4mm) Bolt	936 00 028	8
7	Washer Flat 1"	939 00 027	8
8	Literature Instruction	XL-AR451	1

**Note:** Used on Model ART-500-US, ART-500-US-A, ART-550-US-3, ART-551-US-3, ART-500-B, ART-505-B, ART-551-B-3, ART-555-B-3.

#### 5" Round Axle

SRK-128 Holland part number 481 00 181

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Wrapper Rubber	900 28 047	2
2	Pad Rubber	900 28 083	2
3	U-Bolt 1" - 8 x 12.5" GR 8	900 42 792	4
4	Nut Hex Lock 1" - 8 GR C	934 00 502	8
5	Washer Square for 1" (25.4mm) Bolt	936 00 028	8
6	Washer Flat 1"	939 00 027	8
7	Literature Instruction	XL-AR451	1

**Note:** Used on Model ART-550-US-1, ART-551-US-1, ART-551-B-1, and ART-555-B-1.

# SERVICE REPAIR KITS (SRK) *continued*

## Cam Assembly Service Repair Kits & Components

ITEM NO.	DESCRIPTION	ART-505-B ART-555-B ARTA-505 ARTA-555 1" Cam Assy SRK-96	ART-505-B ART-555-B 1/2" Cam Assy SRK-103	ART-505-C ART-555-C ARTA-505 ARTA-555 1" Cam Assy SRK-158	ART-140 ARTA-140 1" Cam Assy SRK-187	ART-505-C ART-555-C Lower Cam SRK-161	ART-505-C ART-555-C Upper Cam SRK-162	QTY.
1	Plate End	90031785	90031785					2
2	0.81" Washer Spacer			90036161		90036161	90036161	2
3	Bearing Roller					90038219		4
4	Bearing Roller						90038220	2
5	Bushing Sleeve						90038222	2
6	Yoke Grommet Rubber	90044218	90044218	90044218		90044218	90044218	2
7	Literature Decal	90044244	90044244	90044244	90044244	90044244	90044244	2
8	Pin Cam Upper						90044481	2
9	Washer, Half	90044572	90044572					2
10	Seal Coil Lift	90044574	90044574	90044574	90044574	90044574		4†
11	Seal Coil Lift						90044575	4
12	Seal Coil Lift	90044576	90044576	90044576	90044576	90044576		2†
13	Spacer Pipe		90044586					2
14	Literature Label	90044587		90044587	90044587	90044587	90044587	2§
15	Pin Cam Lower	90044664		90044664	90044664	90044664		2†
16	Bushing Yoke	90044776		90044776	90044776	90044776	90044776	2
17	Cam Assembly		90544498*					2
18	Rod Yoke Assembly	90544670		90544670				2
19	Coil Lift Cam				90544960**			1
20	Cam Assembly					90545210***		1
21	Package Bag					92010025	92010025	1
22	Bolt Hex 0.5"-13 x 6" GR 8		93003017					2
23	Bolt Hex 0.62"-11 x 2.5" GR 8					93003359	93003359	2
24	Nut Hex 0.5"-13 GR C		93400482					2
25	Nut Hex Lock 0.625"-11 GR C					93400490	93400490	2
26	Nut Hex Lock 0.75"-10 GR C	93400494		93400494	93400494	93400494		2†
27	Nut Hex Lock Thin 0.5"-13 GR A						93400541	2
28	Washer Flat 0.531"		93600138					2
29	Washer Flat 0.9"			93600508	93600508	93600508	93600508	2†
30	Fitting Grease	93800228		93800228	93800228	93800228		2†
31	Washer Flat 1"		93900027					4
32	Nut Hex 0.75"-10 GR 5	93900151	93900151					2
33	Nut Hex Lock 0.75"-10 GR 8			93900195	93900195	93900195	93900195	2†
34	Literature Label		94100347					1

\* Cam has two grease zerks; no zerk in end of 1/2" cam bolt.

\*\* Same cam Assy as 90544670 except for a small cross plate added between the cam ribs.

\*\*\* Same cam Assy as 90544960 except with 5.5" long link plates versus 4.75".

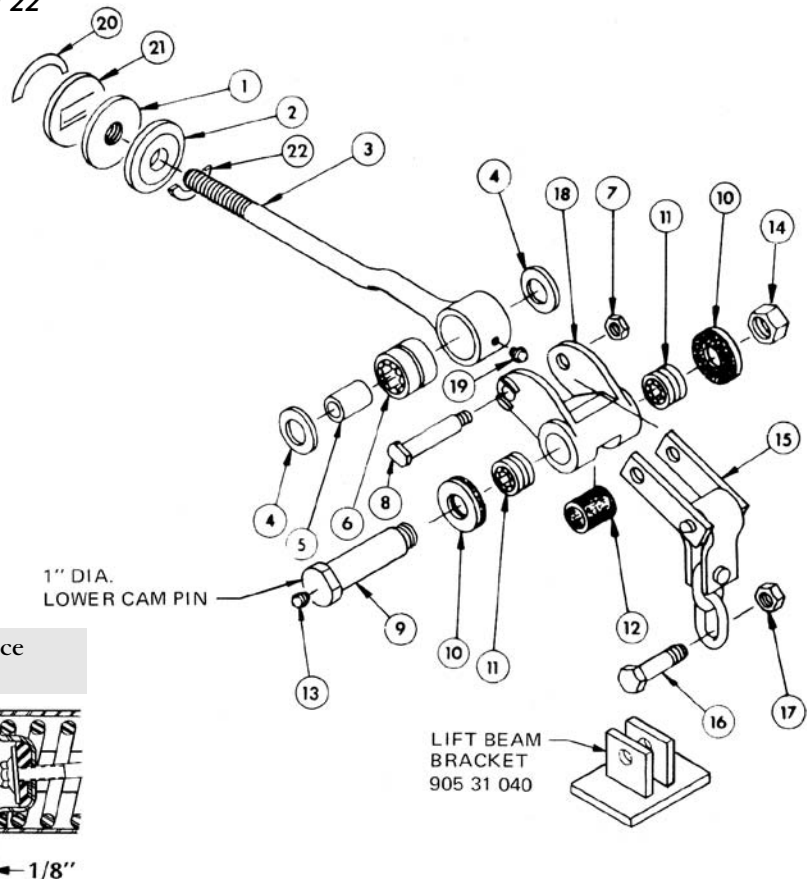
† Quantity 1 in SRK 187.

‡ Quantity 2 in SRK 187.

§ Quantity 1 in SRK 96, 187.

**FIGURE 22**

\*Table items 3-8, 11 and 15-19 come assembled as a Yoke Rod Assembly, part number 905 44 670.



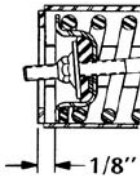
**Cam Assembly  
SRK-96**

The SRK-96 was released for production as of September 1, 1977, on all coil spring lifts, which incorporated a 1" diameter lower cam pin (item 9).

This Service Repair Kit is also available to convert coil spring lifts produced prior to September 1, 1977. If conversion to the SRK-96 is to be performed, contact Holland Technical Service.

**NOTE:** Grease yoke rod and cam at routine maintenance or every 5,000 miles. Items 13 & 19.

**NOTE:** Axle Lift Adjustment - Adjusting tension beyond dimension shown will **NOT** increase lift, but can cause failures by bottoming coil springs. **Do not exceed dimension shown.** (Axle up - No Air)



Refer to replacement instructions for installation, page 29.

**SRK-96 Holland part number 481 00 144**

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Nut Hex 0.75" - 10 GR 5 (Adj Lock Nut)	939 00 151	2
2	Yoke Grommet Rubber	900 44 218	2
3*	Yoke Rod	900 06 342	-
4*	Seal Coil Lift	900 44 575	-
5*	Bushing Sleeve	900 38 222	-
6*	Roller Bearing	900 38 220	-
7*	Nut Hex Lock Thin 0.5" - 13 GR A	934 00 541	-
8*	Upper Cam Pin	900 44 481	-
9	Lower Cam Pin	900 44 664	2
10	Lower Bearing Seal	900 44 574	4
11*	Roller Bearing	900 38 219	-
12	Lower Bearing Seal	900 44 576	2
13	Grease Fitting	938 00 228	2
14	3/4"- 10 Lock Nut	934 00 494	2
15*	Linkage Assembly	905 44 545	-
16*	Bolt Hex 0.62" - 11 x 2.5" GR 8	930 03 359	-
17*	Nut Hex Lock 0.625" - 11 GR C	934 00 490	-
18*	Coil Lift Cam	900 44 674	-
19*	Grease Fitting	938 00 229	-
20	Decal	900 44 244	2
21	End Plate	900 31 785	2
22	Washer Half	900 44 572	2
-	Literature Label	900 44 587	1
-	Installation Instructions	300 00 031	1

**Note:** Used on Model ART- 505-B, ART-555-B, ARTA-505 and ARTA-555.

\*Component of assembly 90544670.

**NOTE:** One kit per suspension.

**Cam Assembly**

**SRK-103**

**(Lower cam pin – 1/2" dia. hex hd. bolt)**

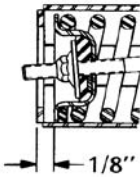
The SRK-103, which includes the current production design, updated the coil spring lifts produced prior to September 1, 1977. The SRK-103 has a 1/2" diameter lower cam pin.

If a conversion to a SRK-103 is to be performed, contact Holland Technical Service.

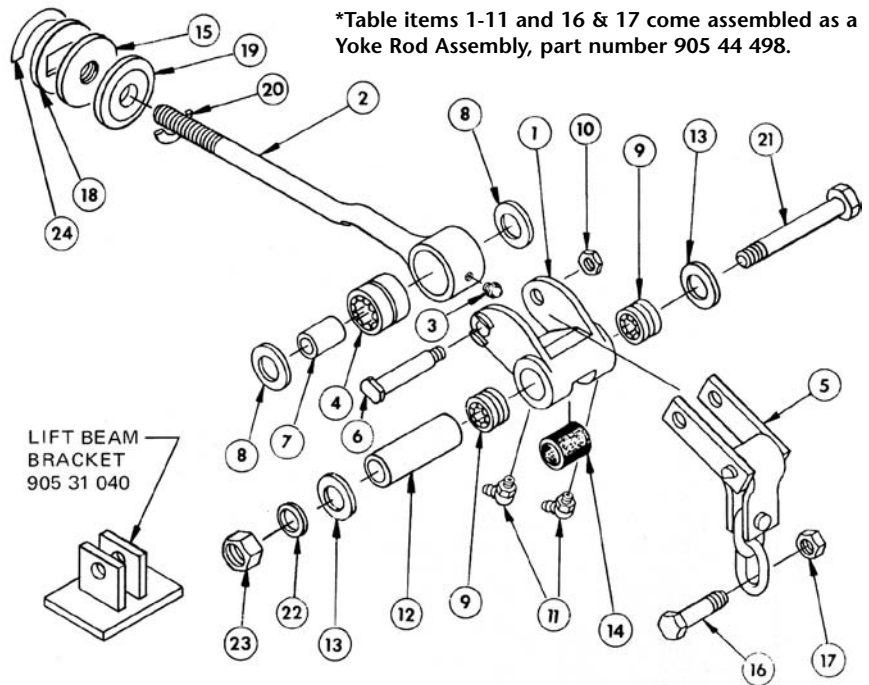
**NOTE:** Before installing a SRK-103, refer to Removal Procedure (FIGURE 23).

**NOTE:** Grease yoke rod and cam at routine maintenance or every 5,000 miles. Items 3 & 11.

**NOTE:** Axle Lift Adjustment - Adjusting tension beyond dimension shown will **NOT** increase lift, but can cause failures by bottoming coil springs. **Do not exceed dimension shown.** (Axle up - No Air)

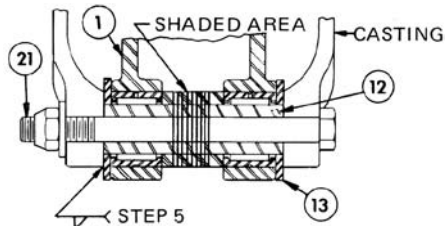


**FIGURE 24**



\*Table items 1-11 and 16 & 17 come assembled as a Yoke Rod Assembly, part number 905 44 498.

**FIGURE 23**



**Removal Procedure**

**NOTE:** Item 13 is welded when assembled. To service, refer to removal procedure.

1. To remove cam assembly, remove 1/2" hex head bolt, Item 21.
2. Using a torch, cut out shaded area as shown. (**Do not** torch cam body, Item 1).
3. Remove the remaining pieces of inner sleeve, Item 12, then the cam assembly.
4. Chisel off the welded washers, Item 13, then install new parts. Refer to replacement instructions for installation, page 29.
5. Weld new washers, Item 13, after lock nut, Item 23, has been torqued.

**Cam Assembly - 1/2"**

**SRK-103 Holland part number 481 00 151**

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1*	Coil Lift Cam	900 44 577	-
2*	Yoke Rod	900 06 342	-
3*	Grease Fitting	938 00 229	-
4*	Roller Bearing	900 38 220	-
5*	Linkage Assembly	905 44 545	-
6*	Upper Cam Pin	900 44 481	-
7*	Inner Sleeve	900 38 222	-
8*	Yoke Rod Bearing Seal	900 44 575	-
9*	Roller Bearing	900 38 219	-
10*	1/2" - 13 Light Thin Lock Nut	934 00 541	-
11*	Grease Fitting	938 00 228	-
12	Spacer Pipe	900 44 586	2
13	Washer	939 00 027	4
14	Lower Cam Bearing Inner Seal	900 44 576	2
15	Adjustment Lock Nut	939 00 151	2
16*	5/8" - 11 x 2-1/2" Hex Hd. Screw	930 03 359	-
17*	5/8" - 11 Lock Nut	934 00 490	-
18	End Plate	900 31 785	2
19	Yoke Grommet	900 44 218	2
20	Half Washer	900 44 572	2
21	1/2" - 13 x 6" Hex Hd. Screw	930 03 017	2
22	1/2" Washer	936 00 138	2
23	1/2" - 13 Lock Nut	934 00 482	2
24	Decal	900 44 244	2
-	Installation Instructions	300 00 033	1

**Note:** Used on Model ART-505-B, ART-555-B.

\*Component of assembly 90544498, coil lift cam assembly, quantity 2 - in SRK-103.

**NOTE:** One kit per suspension.

# SERVICE REPAIR KITS (SRK) *continued*

## CAM ASSEMBLY REPLACEMENT KIT CHARTS *continued*

### Cam Assembly - 1"

SRK-158 Holland part number 481 00 215

ITEM NO.	DESCRIPTION	PART NO.	QTY.
	Literature Decal	900 44 244	2
	Literature Label	900 44 587	2
1	Rod Yoke Assembly	905 44 670	2
3	Seal Coil Lift	900 44 574	4
4	Seal Coil Lift	900 44 576	2
5	Nut Hex Lock 0.75" - 10 GR C	934 00 494	2
8	Nut Hex Lock 0.75" - 10 GR 8	939 00 195	2
9	Bushing Yoke	900 44 776	2
10	Washer Flat 0.9"	936 00 508	2
11	Yoke Grommet Rubber	900 44 218	2
12	Washer Spacer 0.81"	900 36 161	2
13	Pin Cam Lower	900 44 664	2
14	Fitting Grease	938 00 228	2
-	Installation Drawing & Instructions	300 00 050	1
-	Installation Instructions	XL-AK443	1

**Note:** Used on Model ART-505-C, ART-555-C, ARTA-505, ARTA-555.

### Cam Assembly

SRK-187 Holland part number 481 00 244

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Coil Lift Cam	905 44 960	1
1-A*	Coil Lift Cam	905 44 962	-
1-B*	Rod Yoke Assembly	905 06 009	-
1-C*	Fitting Grease	938 00 228	-
1-D*	Bearing Roller	900 38 220	-
1-E*	Link Assembly Coil Lift	905 44 545	-
1-F*	Pin Cam Upper	900 44 481	-
1-G*	Bushing Sleeve	900 38 222	-
1-H*	Seal Coil Lift	900 44 575	-
1-I*	Bearing Roller	900 38 219	-
1-J*	Nut Hex Lock Thin 0.5"-13 GR A	934 00 541	-
3	Seal Coil Lift	900 44 574	2
4	Seal Coil Lift	900 44 576	1
5	Nut Hex Lock 0.75" - 10 GR C	934 00 494	1
8	Nut Hex Lock Adjustment 0.75" - 10 GR 8	939 00 195	1
9	Bushing Yoke	900 44 776	1
10	Washer Flat 0.9"	936 00 508	1
11	Literature Decal	900 44 244	1
12	Literature Label	900 44 587	1
13	Pin Cam Lower	900 44 664	1
14	Fitting Grease	938 00 228	1
-	Installation Drawing & Instructions	300 00 072	1
-	Installation Instructions	XL-AK443	1

**Note:** Used on Model ART-140, and ARTA-140.

\*Component of assembly 90544960.



# SERVICE REPAIR KITS (SRK) *continued*

## LOWER CAM PIVOT REPLACEMENT KIT CHARTS

### Lower Cam Pivot

SRK-161 Holland part number 481 00 218

ITEM NO.	DESCRIPTION	PART NO.	QTY.
	Literature Decal	900 44 244	2
	Literature Label	900 44 587	2
1	Nut Hex Lock Adjustment 0.75" - 10 GR 8	939 00 195	2
2	Bushing Yoke	900 44 776	2
3	Washer Flat 0.9"	936 00 508	2
10	Seal Coil Lift	900 44 574	4
11	Bearing Roller	900 38 219	4
12	Seal Coil Lift	900 44 576	2
14	Nut Hex Lock 0.75" - 10 GR C	934 00 494	2
16	Bolt Hex 0.62"-11 x 2.5" GR 8	930 03 359	2
17	Nut Hex Lock 0.625"-11 GR C	934 00 490	2
18	Washer Thrust 0.88"	900 44 218	2
19	Washer Spacer 0.81"	900 36 161	2
20	Pin Cam Lower	900 44 664	2
21	Fitting Grease	938 00 228	2
-	Installation Drawing & Instructions	300 00 053	1
-	Installation Instructions	XL-AK443	1

**Note:** Used on Model ART-505-C, ART-555-C.

## UPPER CAM PIVOT REPLACEMENT KIT CHARTS

### Upper Cam Pivot

SRK-162 Holland part number 481 00 219

ITEM NO.	DESCRIPTION	PART NO.	QTY.
	Decal	900 44 244	2
	Decal	900 44 587	2
1	Safety Adjustment Lock Nut	939 00 199	2
2	Bushing Yoke	900 44 776	2
4	Seal Coil Lift	900 44 575	4
5	Bushing Sleeve	900 38 222	2
6	Roller Bearing	900 38 220	2
7	Nut Hex Lock Thin 1/2" - 13 GR A	934 00 541	2
8	Upper Cam Pin	900 44 481	2
9	Washer Flat 0.9"	936 00 508	2
16	Bolt Hex 0.62" - 11 x 2-1/2" GR 8	930 03 359	2
17	Nut Hex Lock 0.625" - 11 GR C	934 00 490	2
18	Yoke Grommet Rubber	900 44 218	2
19	Washer Spacer 0.81"	900 36 161	2
-	Installation Drawing & Instructions	300 00 054	1
-	Installation Instructions	XL-AK443	1

**Note:** Used on Model ART-505C, ART-555-C.

## COIL SPRING LIFT REPLACEMENT KIT CHARTS

### Coil Spring Lift

SRK-159 Holland part number 481 00 216

ITEM NO.	DESCRIPTION	PART NO.	QTY.
	Literature Label	900 44 587	1
1	Spring Coil	900 57 034	1
2	Washer Flat 0.9"	936 00 508	1
3	Coil Lift Retainer	905 44 802	1
4	Bushing Yoke	900 44 776	1
5	Nut Hex Lock Adjustment 0.75" - 10 GR 8	939 00 195	1
6	Bracket	900 44 777	4
7	Spring Cup Assembly	905 46 434	1
8	Bolt Hex 0.38" - 16 x 1.25" GR 5	930 02 577	4
9	Nut Hex 0.38" - 16 GR B	934 00 128	4
10	Rod Bolt	505 06 001	1
11	Nut Hex Heavy 0.75" - 10 GR A	934 00 604	1
12	Bracket	505 44 002	1
13	Washer Flat Narrow 0.75"	936 00 156	1
-	Installation Drawing & Instructions	300 00 051	1
-	Installation Instructions	300 00 060	1

**Note:** Used on Model ART-505-B, ART-555-B.

### Coil Spring Lift\*

SRK-173 Holland part number 481 00 230

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Spring Coil	900 57 034	1
2	Washer Flat 0.9"	936 00 508	1
4	Bushing Yoke	900 44 776	1
5	Nut Hex Lock Adjustment 0.75" - 10 GR 8	939 00 195	1
7	Spring Cup Assembly	905 44 800	1
8	Bolt Hex 0.38" - 16 x 1.25" GR 5	930 02 577	4
9	Nut Hex 0.38" - 16 GR B	934 00 128	4
10	Rod Bolt	505 06 001	1
11	Nut Hex Heavy 0.75" - 10 GR A	934 00 604	1
12	Bracket	505 44 002	1
13	Washer Flat Narrow 0.75"	936 00 156	1
	SRK-173 Installation Drawing	941 00 913	1

\* with installation tool.

**Note:** Used on Model ART-505-C, ART-555-C.

### Coil Spring Lift\*

SRK-173-1 Holland part number 481 00 250

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Spring Coil	900 57 034	1
2	Washer Flat 0.9"	936 00 508	1
4	Bushing Yoke	900 44 776	1
5	Nut Hex Lock Adjustment 0.75" - 10 GR 8	939 00 195	1
7	Spring Cup Assembly	905 44 800	1
8	Bolt Hex 0.38" - 16 x 1.25" GR 5	930 02 577	4
9	Nut Hex 0.38" - 16 GR B	934 00 128	4
-	Installation Drawing & Instructions	941 00 913	1

\* without installation tool.

**Note:** Used on Model ART-505-C, ART-555-C.

**WEAR BAND**

**SRK-163 Holland part number 481 00 220**

**IMPORTANT:** Do not operate air suspension with less than 30 psig to prevent possible damage to lift mechanism.

The above Series suspensions incorporate a replaceable wear band on the coil spring lift retainer cup. This band provides a wear surface between the frame bracket canister and coil spring retainer cup, similar to a brake shoe lining and must be routinely inspected for wear. A visual inspection of the wear band is recommended during each normal servicing of the vehicle to assure adequate band thickness is maintained. Inspection must be performed by applying a minimum of 30 psig to (unloaded vehicle) air suspension. The coil spring will compress and the wear pad can then be observed through the front end opening of the spring canister.

Improved features of the Coil Lift Spring are:

- a replaceable wear pad for noise reduction.
- a tapered coil spring to accommodate the replaceable wear pad.
- a bolt-on spring retaining plate for ease of servicing.
- a plastic washer to achieve a more accurate adjustment of Coil Spring.

For proper operation and to prevent possible damage to structural components, the wear band thickness must exceed 1/16". If inspection of the wear band indicates that it has worn to a thickness of 1/16" or less, the band should be replaced using Service Repair Kit No. 163.

**Wear Pad Replacement Kit**

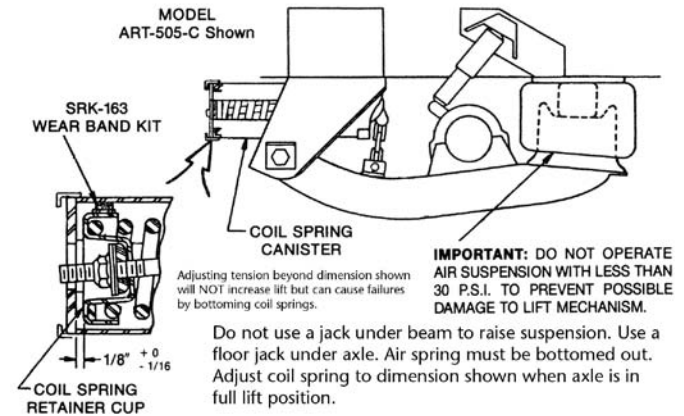
**SRK-163 Holland part number 481 00 220**

ITEM NO.	DESCRIPTION	PART NO.	QTY.
1	Pad Wear Assembly	905 44 893	2
2	10-32 x 0.38" Self Tap Screw	939 00 206	8
3	Literature Instructions	300 00 055	1

**Note:** Used on Model ART-505-C, ART-555-C.

**FIGURE 25**

For use on ART-505-C/555-C and ARTA-505-C/555-C Series suspensions.



1. It is recommended the vehicle be unloaded. Block the vehicle to prevent rolling. To properly obtain correct adjustment of the Coil Spring, it will be necessary to raise the axle to its maximum lifted position (exhaust all the air pressure from the Air Springs).
2. With the lift chains connected to the Equalizing Beam Brackets, raise axle to the maximum lifted position as shown.

**IMPORTANT:** The Air Spring should be bottomed out on the internal rubber bumper with a portion of the weight of the unloaded vehicle on suspension.

3. Be sure the air cell is not pinched between the piston and the internal bumper.
4. The adjustment of the Coil Spring Lift can now be completed by turning the 3/4" adjusting nut until the spring is compressed to a 1/8" maximum dimension as shown in cross section above.

# COMPONENT REPLACEMENT INSTRUCTIONS

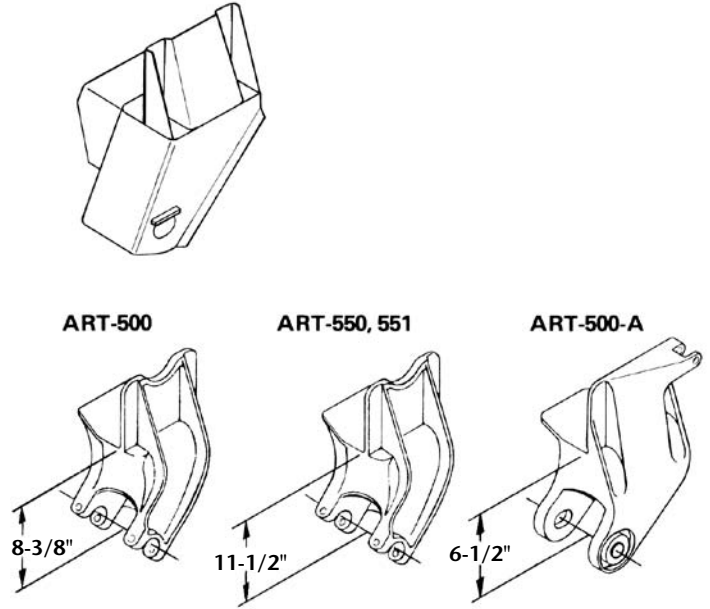
## ART Frame Bracket Replacement

In the event it becomes necessary to replace cast front frame brackets on Holland models ART-500-US, ART-500-US-A, ART-550-US Series, or ART-551-US Series, a service repair kit (SRK) using a fabricated frame bracket **must** be specified (FIGURE 26).

These kits are available to replace the frame brackets in pairs or singles, right- or left-hand brackets. However, we recommend they be replaced as pairs for uniformity. Refer to the selection chart below for proper SRK requirements.

The frame brackets supplied with these kits will not be pre-drilled, so present frame holes can be used as guides.

FIGURE 26



## Axle Cap Replacement

- ART-500-US
- ART-500-US-A
- ART-550-US-1, -2 & -3
- ART-551-US-1, -2 & -3

### Axle Cap (New Style vs Old Style)

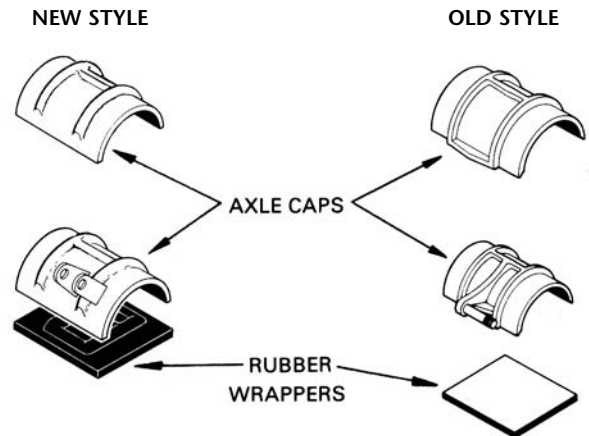
MODEL	WITHOUT AXLE STOPS		WITH AXLE STOPS	
	LEFT HAND	RT. HAND	LEFT HAND	RT. HAND
ART-500-US*	905 10 100**	905 10 101**	905 10 102**	905 10 103**
ART-500-US-A	905 10 100**	905 10 101**	905 10 102**	905 10 103**
ART-550-US-1, -2 & -3	900 10 003	900 10 003	905 10 005	905 10 005
ART-551-US-1, -2 & -3*	905 10 074	905 10 075	905 10 076	905 10 077

When converting to this new style cap, you must also order a new style rubber wrapper, part number 900 28 047.

\*When ordering new caps for these models, also order a 3/4"-10 x 3 1/2" Hex Head Screw, part number 930 03 597 and 3/4"-10 Lock Nut, part number 934 00 492, for lower shock absorber connection.

\*\*These are new style caps:  
 905 10 100 Replaces 905 10 001 & 905 10 016  
 905 10 101 Replaces 905 10 002 & 905 10 017  
 905 10 102 Replaces 905 10 014 & 905 10 018  
 905 10 103 Replaces 905 10 015 & 905 10 019.

FIGURE 27



# COMPONENT REPLACEMENT INSTRUCTIONS *continued*

**NOTE:** Service Repair Kits (SRK) are available for the ART suspensions, see page 19. For further information, contact your Holland distributor.

## Air Spring Assembly

1. Remove load; tractor with mechanical suspension will maintain proper clearance for removal of air spring. If air suspension is not combined with a mechanical suspension or load is not removed, then adequate jacks or stand must be used to support tractor frame.
2. If all air is not exhausted from the suspension air system, then exhaust at this time.

**IMPORTANT:** Do not have anyone in the path of the axle when the axle is raised or lowered.

**WARNING** If suspension is a coil spring model, exhausting all air in suspension system raises the axle immediately which, if not avoided, could result in death or serious injury.

**NOTE:** To lower axle, apply hydraulic jack (5-ton minimum) between suspension or axle and frame. Push axle down to approximate ride height and insert adequate steel spacer blocks between suspension or axle and frame. Release pressure from hydraulic jack and remove.

3. Disconnect air supply line from top of air spring.
4. Remove fasteners and old air spring assembly.
5. Install new air spring assembly and properly torque fastener. Then reconnect air supply line. See Torque Chart page 4.
6. If suspension is coil spring lift model, build tractor air pressure in excess of 65 psig and apply sufficient air pressure to air springs to remove spacer blocks. Check for air leaks.

**CAUTION** While vehicle air system pressure capabilities may be in excess of 120 psig, the air spring pressure must not be set above 100 psig for normal static vehicle conditions. Operating with static pressure greater than 100 psig may shorten the life of an air spring.

## Shock Absorbers

1. Position tractor frame at approximate suspension ride height to relieve all tension on shock absorbers.
2. Remove upper and lower shock mounting bolts.
3. Install new shocks and reinstall mounting bolts.
4. Torque fasteners per Torque Chart on page 4.

## Axle Connection Pads and Wrappers

When replacing the axle connection rubber pads and wrappers, it is recommended to also replace the U-bolts and nuts with new ones. Refer to page 27 for selection of New or Old style parts. It may be an advantage to rebuild the front pivot connection at this time. Refer to page 19 for proper service repair kit (SRK).

1. Exhaust all air from the suspension air system.

**IMPORTANT:** Do not have anyone in the path of the axle when the axle is raised or lowered.

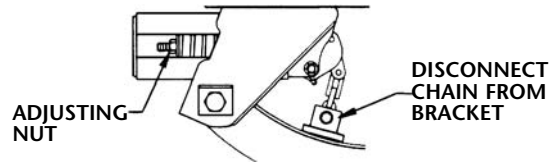
**WARNING** If suspension is a coil spring model, exhausting all air in suspension system raises the axle immediately which, if not avoided, could result in death or serious injury.

2. Support axle with jacks. Then remove tires and disconnect the shock absorber and air spring at the lower end.

**NOTE:** If coil spring lift model, turn adjusting nut on yoke rod to release tension on chain. With tension released, disconnect chain from bracket (FIGURE 28).

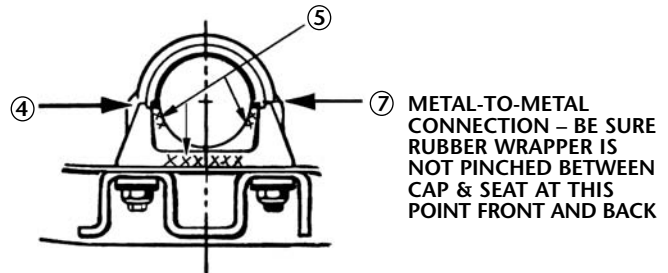
3. On coil spring lift models, lower axle to approximate ride height. Place a jack under each equalizing beam.

FIGURE 28



4. If new U-bolts are to be used, cut the old U-bolts at contact point between axle cap and beam seat. With U-bolts removed, lower equalizing beam away from axle (FIGURE 29).

FIGURE 29



**NOTE:** Refer to page 30 for axle adapter welding.

5. Inspect axle adapters, beam seats and equalizing beams for wear, cracks and failed welds. Axle adapters should have a 3/8" fillet weld. Repair or replace all worn or broken beam seats and axle adapters.

**IMPORTANT:** Never repair a cracked equalizing beam. If cracks are detected anywhere on a beam, replace the beam or secondary weld failures may occur.

**WARNING** Failure to replace a cracked equalizing beam could allow weld failures, and loss of vehicle control which, if not avoided, could result in death or serious injury.

6. Refer to page 27 to assure proper rubber wrapper is installed; refer to pages 7-13 for exploded views showing both upper, rubber wrappers and lower, rubber pads. Insert new lower pad and properly fit wrapper into axle cap.

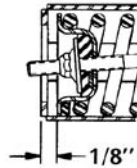
**NOTE:** If a rubber lubricant is used, it must be an approved commercial rubber lubricant, not an oil base.

7. Reassemble axle connection. Lubricate U-bolt threads; then torque U-bolt nuts evenly until axle cap and beam seat is metal-to-metal across front and rear per Torque Chart on page 4. Be sure rubber wrapper **does not** become pinched between the axle cap and beam seat.

# COMPONENT REPLACEMENT INSTRUCTIONS *continued*

- Reinstall air springs and shock absorber and properly torque fasteners. If coil spring lift model, raise axle to complete "up position" and reconnect chain to beam bracket. Readjust adjusting nut to 1/8" dimension only as shown (FIGURE 30). If camshafts were removed, reinstall. Reinstall tires.

FIGURE 30



- Remove jacks and stands. Apply air pressure in excess of 65 psig but not over 100 psig (maximum, allowable operating pressure) to air suspension system.

## Equalizing Beam or Pivot Bushing

**NOTE:** If replacing the pivot bushing only — you can use a Holland Bushing Service Tool. Purchase Part No. 505 44 001 at your Holland Distributor.

**NOTE:** It may be an advantage to replace the rubber wrappers and pads at this time. If so, see instructions on page 27. Refer to page 19 for proper SRK.

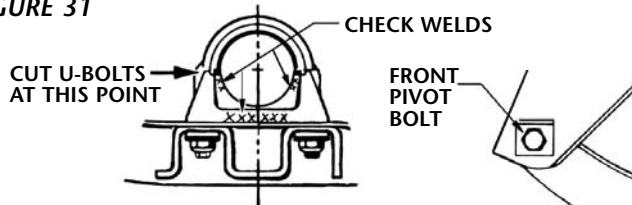
- Follow the same disassembling procedure for Axle Connection Pads and Wrappers through Step 3 on page 28.
- If new U-bolts are to be used, cut the old U-bolts at contact point between axle cap and beam seat (FIGURE 31).
- If not replacing rubber pads and rubber wrappers at this time and are using a torch to cut U-bolts, **do not overheat** the pads and wrappers.

**NOTE:** Overheated rubber pads or wrappers must be replaced.

**WARNING** Failure to replace overheated rubber pads and wrappers could result in U-bolt failure and separation of axle and suspension which, if not avoided, could result in death or serious injury.

- Remove front pivot bolt and, with U-bolts removed (notice position of spacer washers), lower equalizing beam away from axle.

FIGURE 31



- Set rubber pads and rubber wrappers aside for reinstalling if not using new ones. Inspect all parts to be reused. Repair or replace all worn and broken parts. Check for sound welds; axle adapters should have a 3/8" fillet weld.

**IMPORTANT:** Never repair a cracked equalizing beam. If cracks are detected anywhere on a beam, replace the beam or secondary weld failures may occur.

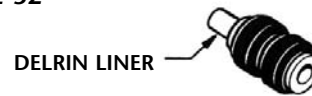
**WARNING** Failure to replace a cracked equalizing beam could allow weld failures, and loss of vehicle control which, if not avoided, could result in death or serious injury.

- If replacing the pivot bushings only, press out old bushing with hydraulic press of 5-ton capacity minimum. Clean out bushing receptacle, Lubricate new bushing with approved lubricant, not oil based. Press new bushing in bushing receptacle past center. Turn beam over and center bushing in receptacle.

**NOTE:** If a rubber lubricant is used, it must be an approved commercial rubber lubricant, not an oil base.

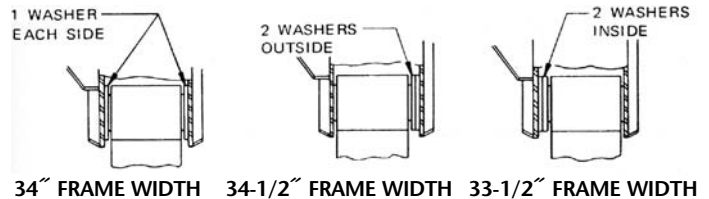
- Install new Delrin Liner (FIGURE 32). Some models may not include this part.

FIGURE 32



- Insert new or rebushed beam into frame bracket. Install spacer washers in same location removed from (frame width of 34" one each side, 33-1/2" both to inside or 34-1/2" both to outside). Attach equalizing beam to frame bracket. Torque 1-1/8" nut per Torque Chart on page 4 (FIGURE 33).

FIGURE 33



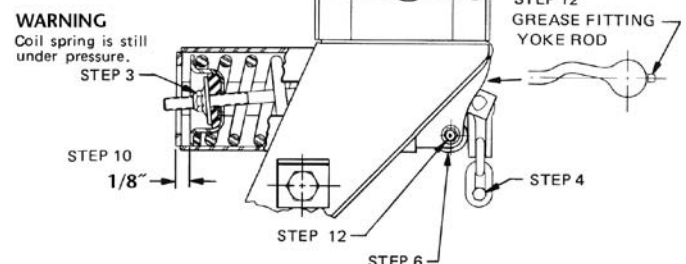
- See Steps 7 through 9 of Axle Connection Pads and Wrappers instructions, to reassemble axle connection.

## Coil Spring Cam Assembly

**NOTE:** Refer to page 21 for list of Coil Spring SRKs.

**NOTE:** To assure proper Service Repair Kit has been selected, refer to pages 22-25.

FIGURE 34



- Release air in suspension system.

**IMPORTANT:** Do not have anyone in the path of the axle when the axle is raised or lowered.

**WARNING** If suspension is a coil spring model, exhausting all air in suspension system raises the axle immediately which, if not avoided, could result in death or serious injury.

## COMPONENT REPLACEMENT INSTRUCTIONS *continued*

2. With axle in lift position, remove tires. Then place jack under axle and lift until jack supports vehicle weight.
3. Relieve tension on Yoke Rod by removing adjusting nut from yoke rod.
4. Disconnect chain from beam bracket; then lower axle to approximate ride height.
5. Remove cam assembly and replace necessary parts.
6. Install cam assembly in frame bracket and torque  $3/4"$  lower cam pin nut to 150 ft. lbs. torque lubricated.
7. Jack axle up until jack supports vehicle weight. Then reconnect linkage assembly to beam bracket; torque to 50 ft. lbs. lubricated.
8. Install yoke grommet and adjusting nut. Tighten only enough to put a slight compression to coil spring.
9. Install tires; then remove jacks.
10. Adjust coil spring lift to  $1/8"$ , only as shown.
11. Apply and release air pressure with the hand control valve to assure proper lift operation. Readjust if necessary.
12. Grease yoke rod and cam bearings, repeating every 5,000 miles minimum.

### Axle Adapter Welding Specification

The following welding recommendations are for the field installation of a Holland air ride axle adapter and should be performed by a qualified welder.

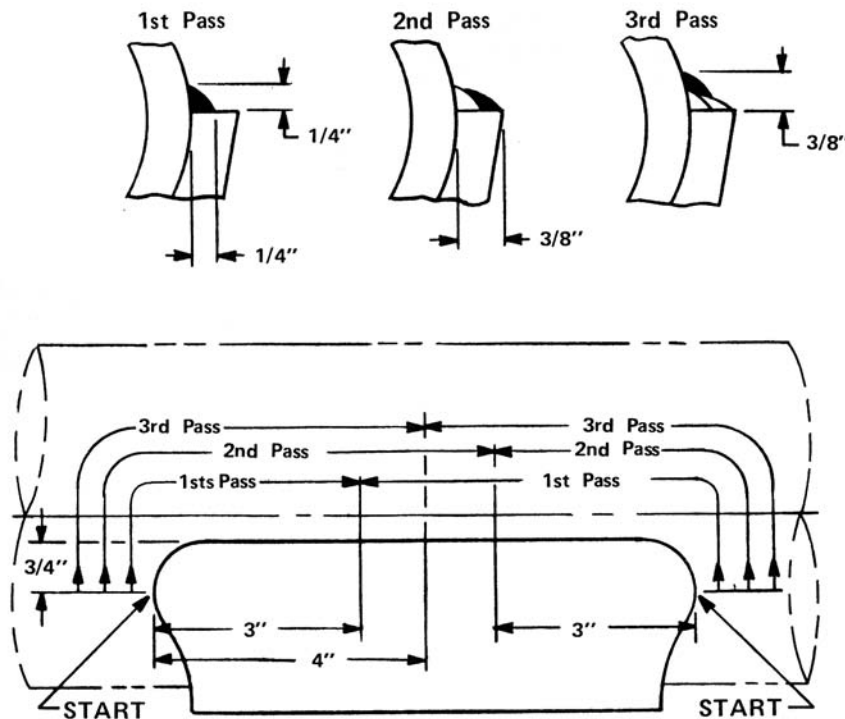
1. The adapter should be clamped securely in the proper position.
2. The axle tube and adapter must be  $70^{\circ}$  F minimum and be free from dirt, scale and grease.
3. The electrode or wire selected must conform to one of the following specifications:
  - a. Electrode AWS E-7018 (Oven-Dried)
 

$5/32"$ Dia.	120-190 Amps D.C. + 135-225 Amps A.C.
$3/16"$ Dia.	170-280 Amps D.C. + 200-300 Amps A.C.
  - b. Wire
 

AWS E-70S-3	AWS E-70T-1
Gas C-25	CO <sub>2</sub>
Volts 19-20	21-23
Amps 180-200	200-220
Wire Dia. $.045"$	$.062"$ Flux Cored
4. Apply welds in the sizes and sequence shown in (FIGURE 35). Fill the crater at the end of the weld, and clean the weld between passes.

**NOTE:** Each weld pass is to be completed in two segments.

FIGURE 35



# TROUBLESHOOTING

Problem	Possible Remedy
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## Air Spring Problems

**NOTE:** If loss of air exists in air suspension system, there is an internal rubber bumper built into the air spring, which makes it possible to operate vehicle to a service center. Turn hand valve to deflate position (0 psig or 3 psig minimum pressure setting) and proceed carefully to the nearest service center.

**⚠️ WARNING** Do not overload the axle or the suspension or suspension component damage may occur which, if not avoided, could result in vehicle damage and/or death or serious injury.

<p><b>Insufficient air pressure to suspension.</b></p>	<p>Build tractor air pressure in excess of 65 psig.</p> <p>Defective brake protection valve; replace.</p> <p>Check air compressor.</p> <p>Adjust hand valve to minimum setting of 3 psig. See page 18.</p>
<p><b>Air leak or damaged line.</b></p>	<p>Locate and repair.</p>
<p><b>Air spring punctured, cut or leaking.</b></p>	<p>Replace with proper air spring. Then check for proper clearance around air spring, 1-3/4" minimum.</p>
<p><b>Tires or tire rim rubbing air spring.</b></p>	<p>Check inside to inside tire dimension. It may be necessary to reinstall suspension.</p> <p>Use tire rim back spacers to provide more clearance.</p>
<p><b>Air brake chamber rubbing air cell.</b></p>	<p>Relocate chamber or clamp ring for more clearance.</p>
<p><b>Continual over-extension of air springs.</b></p>	<p>Suspension riding too high unloaded; reduce air pressure to 3 psig when empty or bob-tailing.</p> <p>Shock absorbers and/or connections broken - replace.</p> <p>Wrong length shock absorbers.</p> <p>Mislocation of upper shock brackets (Models ART-500, -550 &amp; -551); relocate. Reduce air pressure before disconnecting.</p> <p>Improper installation or application of suspension, such as improper ride height or component parts. Check and replace if necessary.</p>

*continued*

## TROUBLESHOOTING *continued*

<b>Problem</b>	<b>Possible Remedy</b>
<b>Front Pivot Bushing Worn Prematurely</b>	
<b>Alignment bushing(s) not welded.</b>	Weld per installation instructions.
<b>Front pivot bolt loose.</b>	Torque nut per Torque Chart on page 4.
<b>Excessive lateral axle walk.</b>	
	Axle beam seat(s) not welded; weld properly.
	Axle connection U-bolts loose; tighten. Follow proper instructions.
	Worn axle adapter(s); shim on rear side or replace.
<b>Excessive U-Bolt Failures</b>	
<b>Axle beam seat(s) not welded.</b>	Realign axle and weld beam seat(s) to equalizing beam.
<b>Insufficient torque (loose axle connection).</b>	Torque nut (clean and oiled) per Torque Chart on page 4; assure metal-to-metal condition. See page 28.
<b>Suspension overloaded due to operating conditions, such as rough terrain.</b>	Install axle stops.
<b>Repeated Shock Absorber Failures</b>	
<b>Over-extending shock absorbers.</b>	Reduce air pressure when light or bob-tailing, 3 psig.
<b>Suspension mounted at wrong ride height.</b>	Check Specification sheet.
<b>Wrong length or improper replacement shock absorber(s).</b>	Replace with proper part(s).
<b>Mislocation of upper shock mount bracket(s) (Models ART-500, -550 &amp; -551).</b>	Relocate if necessary. Reduce air pressure before disconnecting.
<b>Axle Misaligned</b>	
<b>Index aligning blocks not welded.</b>	Realign to drive axle and weld to specifications.
<b>Front bushing worn. Delrin liner worn or missing.</b>	Replace worn or missing parts as required.
<b>Insufficient Lifted Tire Clearance</b>	
<b>Excessive drive axle spring leaf deflection.</b>	Add spring leaves as required or relocate overload brackets.
<b>Misadjusted lift mechanism.</b>	Adjust to specification. Refer to installation instructions.

*continued*



## **TROUBLESHOOTING** *continued*

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<b>Problem</b>	<b>Possible Remedy</b>
<b>Axle Off Tracking</b>	
<b>Loose or worn axle connection.</b>	If loose, tighten connection, page 28. Then check axle alignment; realign if necessary. If worn, shim rear side of axle adapter or replace. See page 19 for SRK.
<b>Axle misaligned.</b>	Align axle; then properly weld alignment bushings and tighten pivot connection bolts.
<b>Worn axle adapter.</b>	Shim rear side of adapter or replace.
<b>Alignment bushing(s) not welded or broken.</b>	If broken, replace. If not welded properly, weld alignment bushing(s) after axle alignment.

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