



THE HOLLAND GROUP, INC.

SPEC. NUMBER:

NS-65-83

PART NUMBER:

94100686

TITLE:  
WELDING RECOMMENDATION FOR NEWAY  
ROUND AXLE ADAPTER ROUND AXLE  
NS-SERIES, SA-SERIES, RL-228, RL-230, RL-250-SB

CHANGE RECORD

LTR	WAS	BY	ECN	CHK	ENG	DATE
A	REF PCN 100					
A1	ADDED RL-228 PER 3288C / REMOVED RL-228 PER 3288H		3288C			20APR01
R	ADDED PART NO 94100686		3632			
C	UPDATED WELD SPEC		3982			
B	UPDATED WELD SPEC PICTORIAL LY		4297A			
D	REMOVED THE WORDS & PAINTER (NOTE 4 ROTATED FIG. 180°)	DS	4360			
E	ADDED NS-200 REMOVE RL-196A		8451A			
H	ADDED NOTATION: BACKFILL WELD END .50	JO	9063			
J	ADDED XL-AR339-01, & NS & SA-SERIES, RL-228 & 230	CJS	X-1077	BJB	SH	26NOV01
K	ADDED RL-250-SB TO TITLE	CR	26723	SH	MJE	22APR03

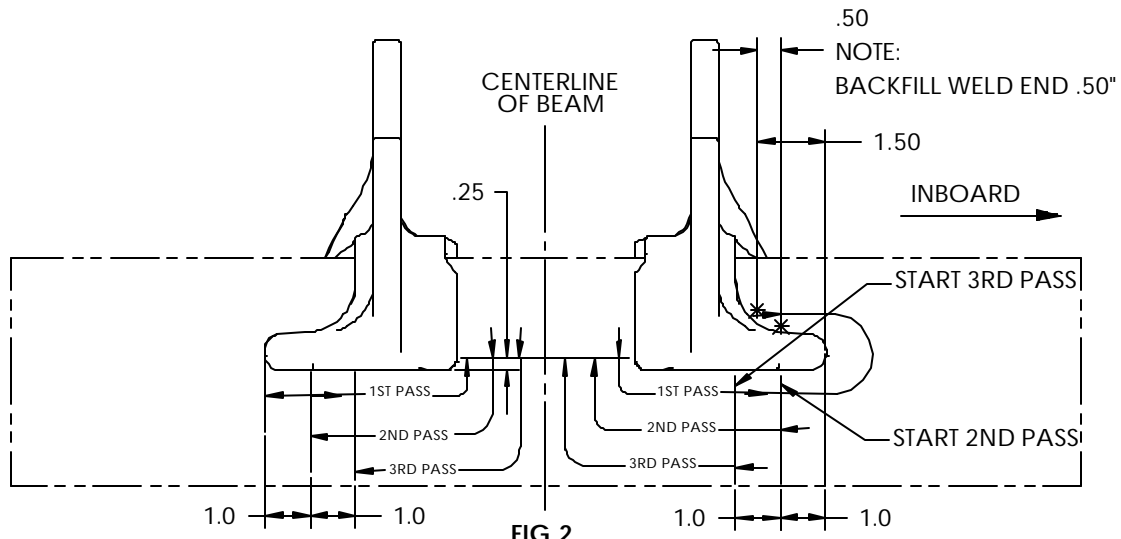
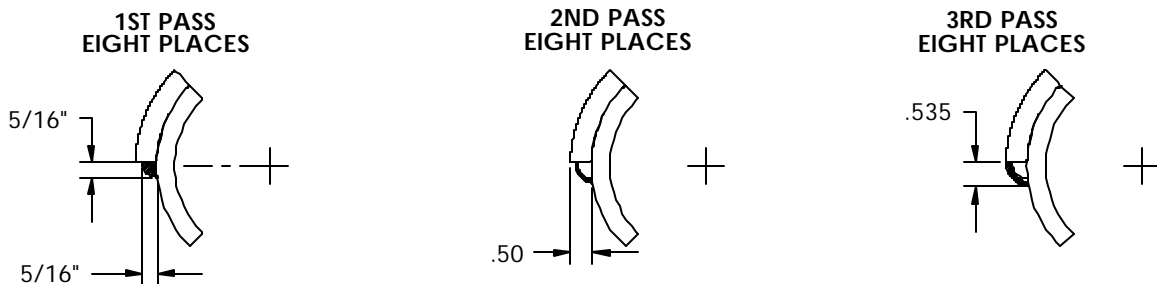
THE FOLLOWING WELDING RECOMMENDATIONS ARE FOR THE INSTALLATION OF A NEWAY AXLE ADAPTER FOR THE ABOVE LISTED MODELS. WELDING SHOULD BE PERFORMED BY A QUALIFIED WELDER.

- ADAPTER MUST BE BOLTED TO EQUALIZING BEAM BEFORE WELDING TO PREVENT HARDWARE DISTORTION DURING WELDING.
- THE ADAPTERS MUST BE CLAMPED SECURELY IN THE PROPER POSITION. (NO GAPS MAY EXIST BETWEEN TOP CENTER OF AXLE AND AXLE ADAPTER.)  
NOTE: TESTING HAS SHOWN THAT EVEN A SLIGHT GAP BETWEEN TOP OF AXLE AND ADAPTER CAN SEVERLY REDUCE SERVICE LIFE OF AXLE AND ATTACHMENTS.
- THE AXLE TUBE AND ADAPTER MUST BE 70° F MINIMUM AND BE FREE FROM DIRT, SCALE & GREASE.
- THE ELECTRODE OR WIRE SELECTED MUST CONFORM TO ONE OF THE FOLLOWING SPECIFICATION:

- ELECTRODE AWS E-8018-C3 (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.
- WIRE SPEC. E71T-1 (OUTERSHIELD 71H)  
GAS 25% CO2 75% ARGON  
VOLTS 29 - 30 DCRP  
AMPS 210 - 250  
WIRE DIA. .045  
WIRE FEED SPEED 300 - 400 IN./MIN.

- APPLY WELDS IN THE SIZES AND SEQUENCES SHOWN IN FIG. 1 & 2. DO NOT BREAK THE ARC AT THE END OF THE WELD. BACK UP ALL FINISH WELDS AT LEAST 1/2" OR A SUFFICIENT AMOUNT TO PREVENT CRATERS BEING FORMED AT THE END OF THE WELD.  
NOTE: EACH PASS IS TO BE COMPLETED WITH ONE SINGLE PASS.

FIG 1





# NS-Series, RL-228/230 & SA-Series

## Axle Adapter Welding Procedures *(See Reverse Side First)*

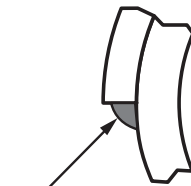
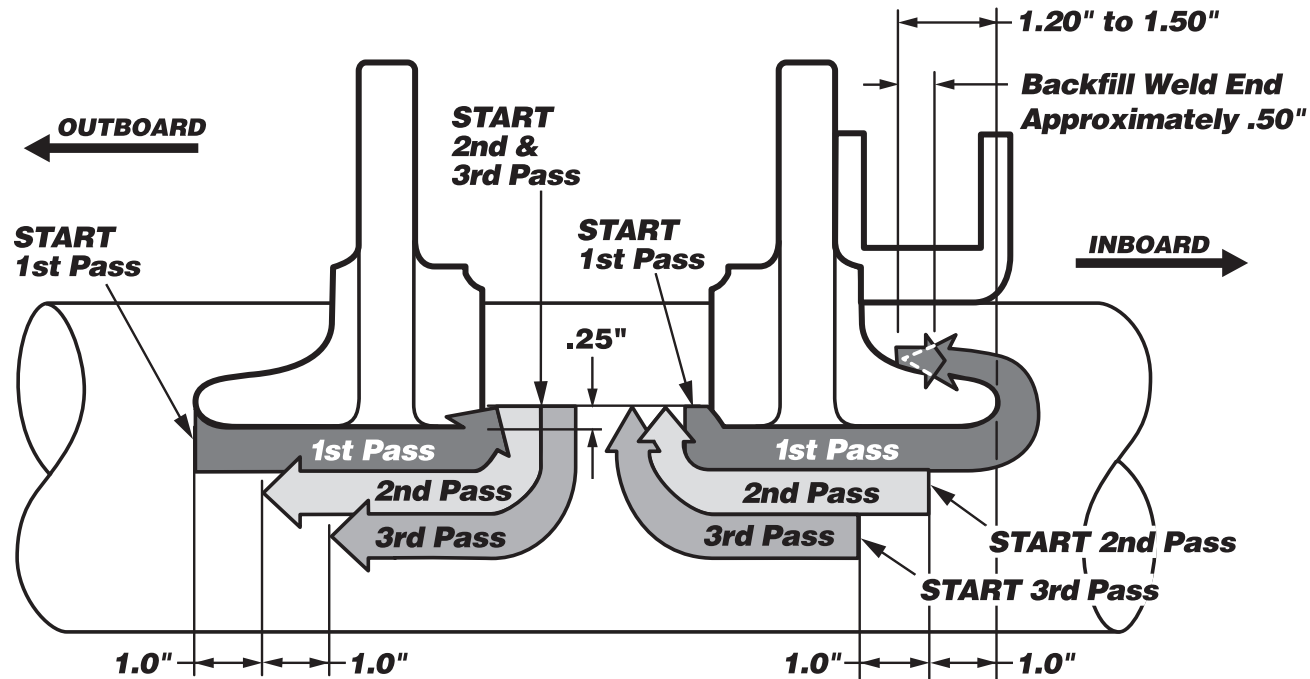
**SPEC. NS-65-83**

**Step 1. Apply welds in sequence**

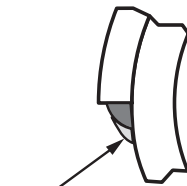
**Step 2. Clean the weld between passes**

**Step 3. Grind excess flush with adapter**

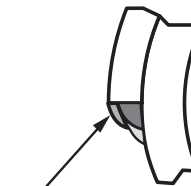
**NOTE: Each weld is to be completed with one single pass.**



**1st Pass**  
*(Eight places per axle)*



**2nd Pass**  
*(Eight places per axle)*



**3rd Pass**  
*(Eight places per axle)*