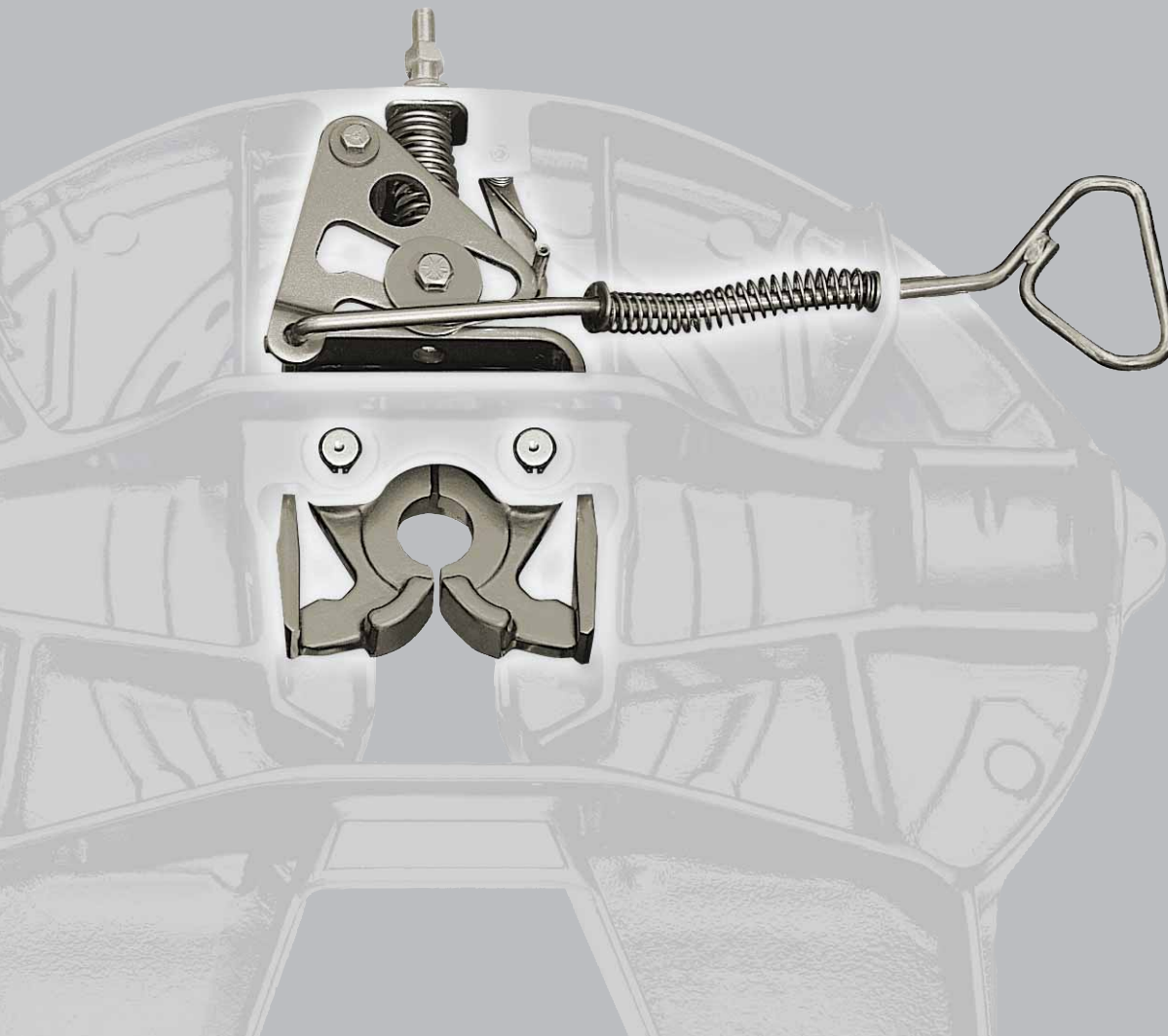


Rebuild/Repair Manual

35 Series Fifth Wheels

- FW35/XA-351, FW33/XA-331 and FW31/XA-311 Series
- FW35/XA-351-A-80-L, FW33/XA-331-A-80-L and FW31/XA-311-A-80-L Air Release Series



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Introduction

This manual provides the information necessary to properly rebuild the FW35/XA-351, FW33/XA-331 and FW31/XA-311 Series fifth wheels and FW35/XA-351-A-80-L, FW33/XA-331-A-80-L and FW31/XA-311-A-80-L Air Release Series fifth wheels manufactured after May 1, 1996.

Read this manual before using or servicing this product and keep it in a safe location for future reference. Updates to this manual, which are published as necessary, are available on the internet at www.safholland.us.

When replacement parts are required, SAF-HOLLAND® highly recommends the use of only SAF-HOLLAND® Original Parts. A list of technical support locations that supply SAF-HOLLAND® Original Parts and an Aftermarket Parts Catalog are available on the internet at www.safholland.us or contact Customer Service at 888-396-6501.

Notes, Cautions, and Warnings

Before starting any work on the unit, read and understand all the safety procedures presented in this manual. This manual contains the terms "NOTE", "IMPORTANT", "CAUTION", and "WARNING" followed by important product information. These terms are defined 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, could result in property damage.

⚠ CAUTION Indicates a potentially hazardous situation which, if not avoided, could result in minor or moderate injury.

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

1. Model Identification

Fifth wheel serial tags are located on the handle side of the fifth wheel top plate above the fifth wheel bracket pin, or on the pickup ramps as illustrated (**Figure 1**).

The part number and serial number are listed on the tag as illustrated (**Figure 2**).

Use the following rebuild kits for FW35/XA-351, FW33/XA-331 and FW31/XA-311 Series fifth wheels and FW35/XA-351-A-80-L, FW33/XA-331-A-80-L and FW31/XA-311-A-80-L Air Release Series fifth wheels.

REBUILD KIT	FIFTH WHEEL/TOP PLATE	RELEASE
RK-351-A-L	FW35/XA-351 and FW33/XA-331 (Low Lube) Manual Release	Left-Hand
RK-351-A	FW35/XA-351 and FW33/XA-331 (Low Lube) Manual Release	Right-Hand
RK-351-A-02-L	FW35/XA-351 and FW33/XA-331 (Low Lube) Manual Release with Manual Secondary Lock	Left-Hand
RK-351-A-02	FW35/XA-351 and FW33/XA-331 (Low Lube) Manual Release with Manual Secondary Lock	Right-Hand
RK-351-A-80-L (Stainless Steel Air Cylinder) and RK-351-A-80-L-1 (Aluminum Air Cylinder)	FW35/XA-351-A-80-L and FW33/XA-331-A-80-L (Low Lube) Air Release	Left-Hand
RK-311-A-L	FW31/XA-311 NoLube™ Manual Release	Left-Hand
RK-311-A	FW31/XA-311 NoLube™ Manual Release	Right-Hand
RK-311-A-02-L	FW31/XA-311 NoLube™ Manual Release with Manual Secondary Lock	Left-Hand
RK-311-A-02	FW31/XA-311 NoLube™ Manual Release with Manual Secondary Lock	Right-Hand
RK-311-A-80-L (Stainless Steel Air Cylinder) and RK-311-A-80-L-1 (Aluminum Air Cylinder)	FW31/XA-311-A-80-L NoLube™ Air Release	Left-Hand

Figure 1

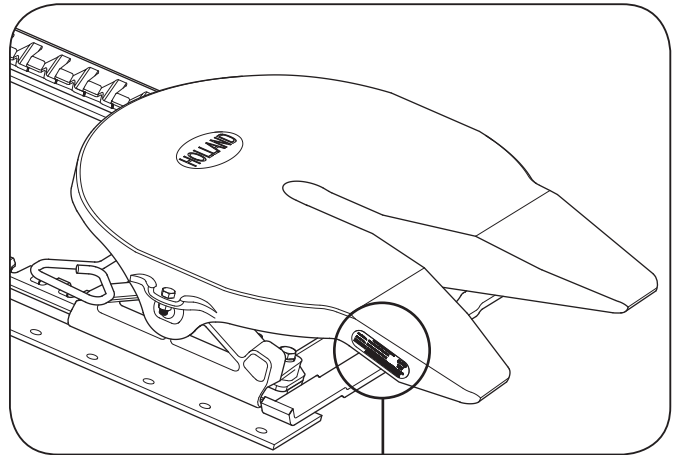
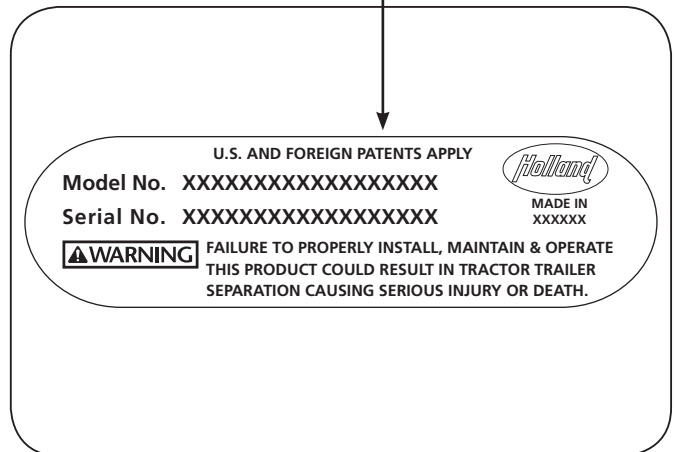


Figure 2



2. General Safety Instructions

- Read and observe all Warning and Caution hazard alert messages. The alerts provide information that can help prevent serious personal injury, damage to components, or both.

⚠ WARNING

Failure to follow the instructions and safety precautions in this manual could result in improper servicing or operation leading to component failure which, if not avoided, could result in death or serious injury.

- All repair and maintenance should be performed by a properly trained technician using proper/special tools, and safe procedures.

NOTE: In the United States, workshop safety requirements are defined by federal and/or state Occupational Safety and Health Act (OSHA). Equivalent laws could exist in other countries. This manual is written based on the assumption that OSHA or other applicable employee safety regulations are followed by the location where work is performed.

NOTE: Before rebuilding the HOLLAND® Fifth Wheel review the model number on the identification tag. This rebuild procedure applies only to model numbers starting with FW35/XA-351, FW33/XA-331 and FW31/XA-311.

IMPORTANT: All maintenance MUST be performed while the tractor is uncoupled from the trailer.

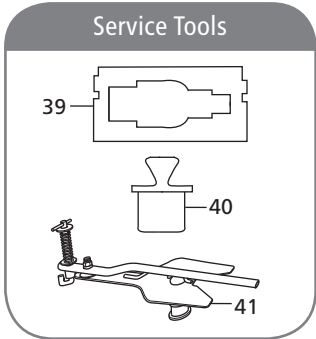
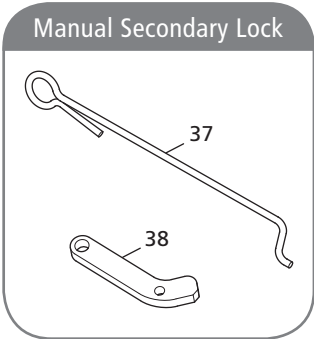
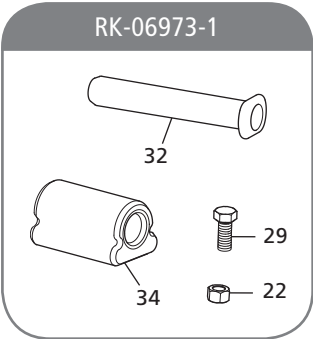
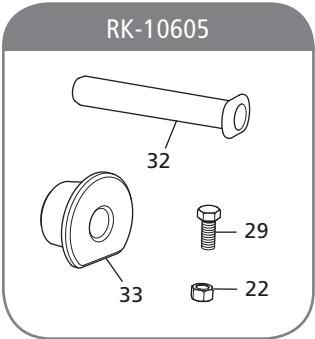
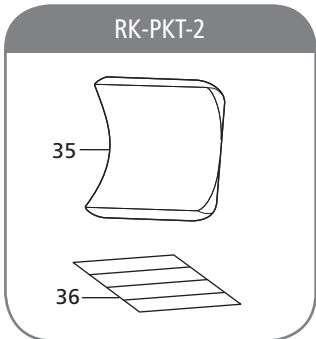
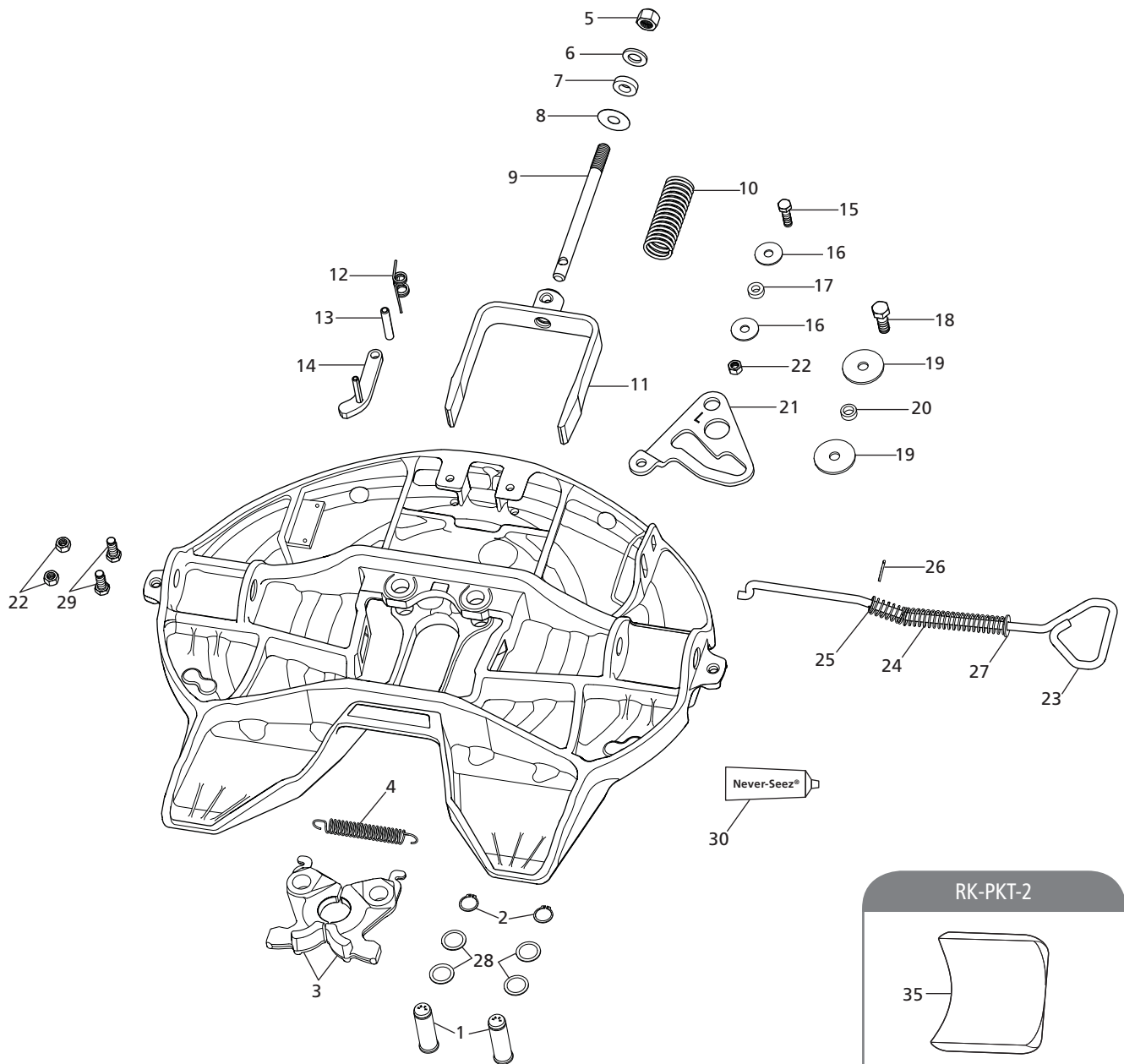
IMPORTANT: These instructions apply to the proper rebuild of FW35/XA-351, FW33/XA-331, and FW31/XA-311 Series Fifth Wheels and FW35/XA-351-A-80-L, FW33/XA-331-A-80-L and FW31/XA-311-A-80-L Air Release Series fifth wheels only. There are other important checks, inspections, and procedures not listed here that are necessary, prudent, and/or required by law.

- For proper installation procedures, refer to Installation Manual XL-FW10008BM-en-US available on the internet at www.safholland.us.

IMPORTANT: Prior to operation of the fifth wheel, verify that the fifth wheel has been properly installed on the vehicle.

⚠ WARNING

Failure to properly repair and install the fifth wheel could adversely affect performance resulting in tractor trailer separation which, if not avoided, could result in death or serious injury.



RK-351-A-L AND RK-351-A PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
1	Lock Pin	XA-07292-1	2
2	Retaining Ring	XB-07398	2
3	Lock Set	XA-07296-P	1
4	Extension Spring	XB-07628-P	1
5	Lock Nut, 3/4" -16	XB-HNH-34-F	1
6	Washer, 1-1/2" O.D. x 13/16" I.D.	XB-PW-1316-112-P	1
7	Rubber Washer	XB-1127	1
8	Lock Adjustment Tag	XB-02312	1
9	Yoke Shaft	XA-1706	1
10	Compression Spring	XB-1505-1	1
11	Yoke	XA-07295-P	1
12	Torsion Spring	XB-2149	1
13	Roll Pin, Ø1/2" x 2-3/4"	XB-21-S-500-2750P	1
14L	Secondary Lock, Left-Hand (included with RK-351-A-L kit)	XA-3542-L-P	1
14R	Secondary Lock, Right-Hand (included with RK-351-A kit)	XA-3542-R-P	1
15	Hex Head Cap Screw, 1/2" -20 x 1-3/4"	XB-2083	1
16	Washer, 1-3/4" O.D. x 9/16" I.D.	XB-08559-P	2
17	Roller, 1/2" I.D.	XA-1029	1
18	Hex Head Cap Screw, 5/8"-18 x 1-3/4"	XB-CX-58-F-134	1
19	Washer, 2-5/8" O.D. x 21/32" I.D., Stainless Steel	XB-10259	2
20	Roller, 5/8" I.D.	XA-1507	1
21L	Cam Plate, Left-Hand (included with RK-351-A-L kit)	XA-07150-L-P	1
21R	Cam Plate, Right-Hand (included with RK-351-A kit)	XA-07150-R-P	1
22	Lock Nut, 1/2" -20	XB-T-69-A	3
23	Release Handle	XA-10344	1
24	Compression Spring	XB-07291	1
25	Washer, 1-1/16" O.D. x 17/32" I.D.	XB-PW-016-17	1
26	Cotter Pin, Ø1/8" x 1-1/4"	XB-07508	1
27	Washer, 1-3/8" O.D. x 9/16" I.D.	XB-T-49-P	1
28	Washer, 1-19/32" O.D. x 1-3/16" I.D.	XB-05859-1	4
29	Hex Head Cap Screw, 1/2" -20 x 1-1/4"	XB-C-95	2
30	Never-Seez®, 7.5 Tube	XB-02967	1
*31	Lube Fitting	XB-H-38	2

*Only for use on XA-351 top plates without pocket inserts.

Note: Kits available from your local SAF-HOLLAND® Distributor.

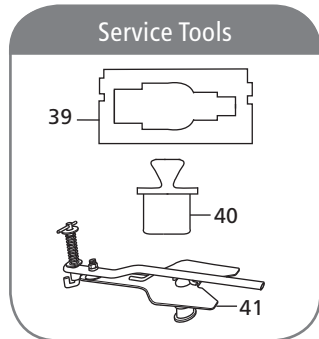
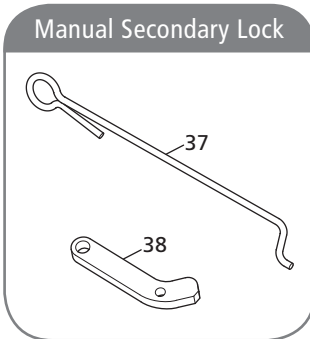
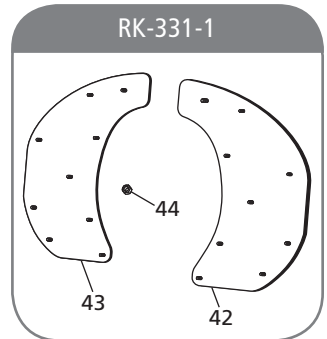
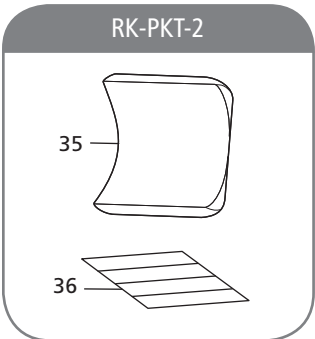
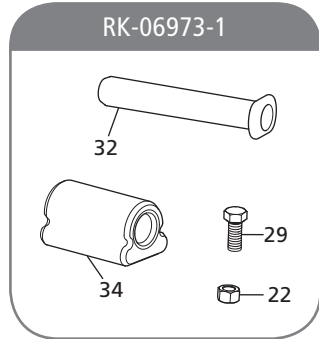
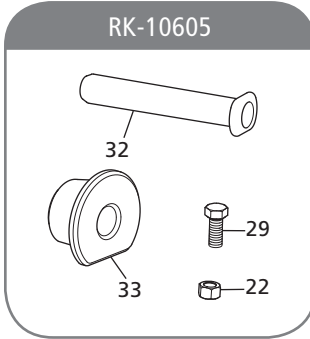
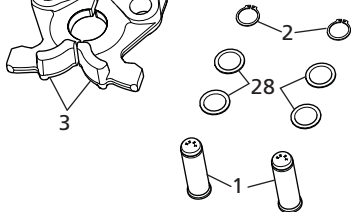
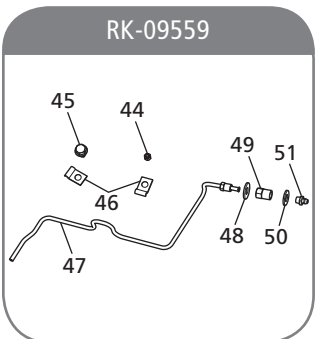
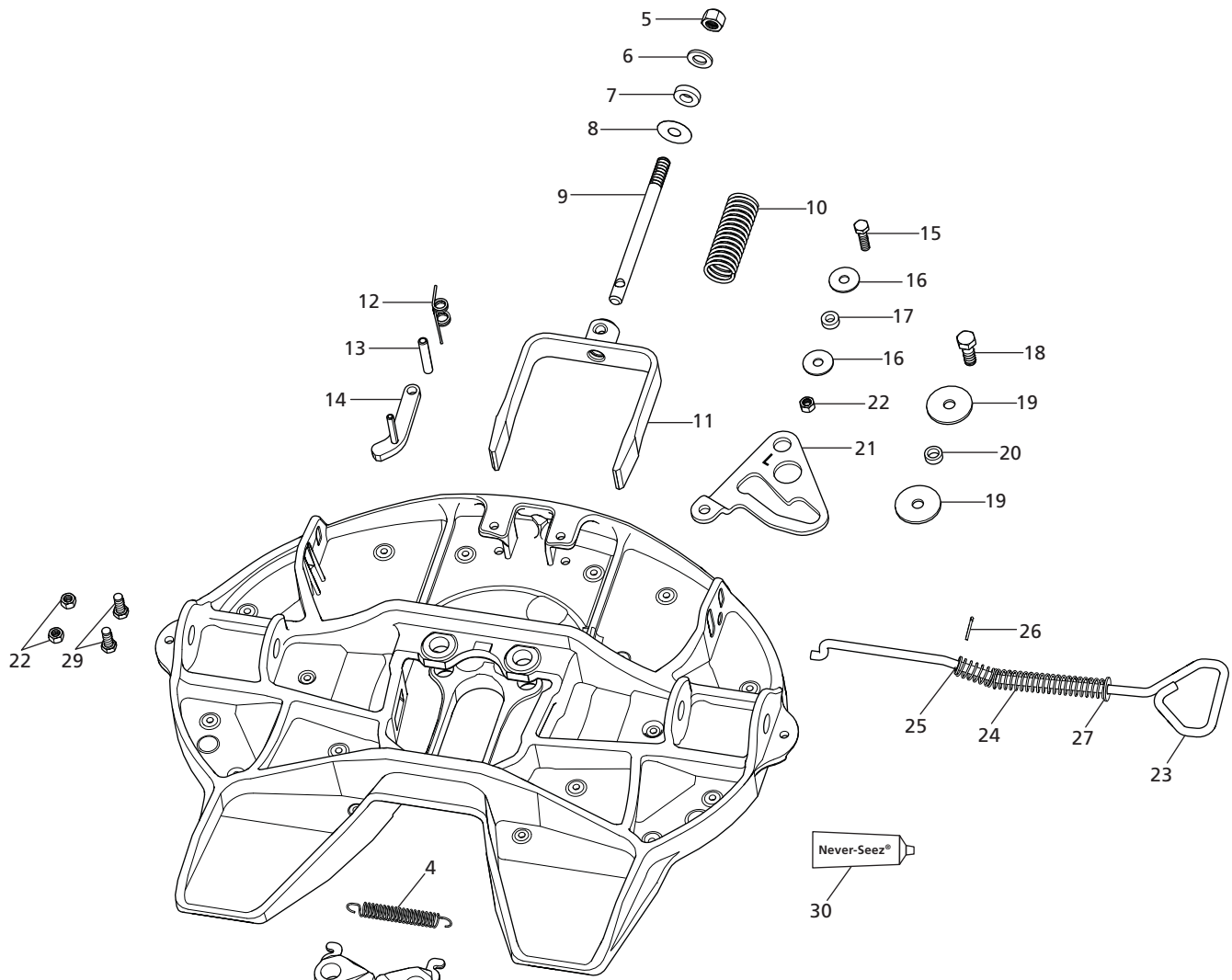
RK-10605 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2" -20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2" -20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
33	Rubber Bushing (cast brackets)	XB-10605	4

RK-06973-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2" -20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2" -20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
34	Rubber Bushing (fabricated brackets)	XB-0011-2	2

RK-PKT-2 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
35	Pocket Insert	XD-08908	2
36	Double Face Tape	XB-09422	4

MANUAL SECONDARY LOCK			
ITEM	DESCRIPTION	PART NUMBER	QTY.
37	Manual Secondary Lock Release Handle (included with RK-351-A- 02-L and RK-351-A-02 kits)	XA-3542-M-P	1
38	Manual Secondary Lock (included with RK-351-A-02-L and RK-351-A-02 kits)	XA-3528-P	1

SERVICE TOOLS			
ITEM	DESCRIPTION	PART NUMBER	QTY.
39	Kingpin Gauge	TF-0110	1
40	Lock Gauge, 2" (Plug)	TF-0237	1
41	Kingpin Lock Tester	TF-TLN-5001	1





RK-351-A-L AND RK-351-A PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
1	Lock Pin	XA-07292-1	2
2	Retaining Ring	XA-07398	2
3	Lock Set	XA-07296-P	1
4	Extension Spring	XB-07628-P	1
5	Lock Nut, 3/4"-16	XB-HNH-34-F	1
6	Washer, 1-1/2" O.D. x 13/16" I.D.	XB-PW-1316-112-P	1
7	Rubber Washer	XB-1127	1
8	Lock Adjustment Tag	XB-02312	1
9	Yoke Shaft	XA-1706	1
10	Compression Spring	XB-1505-1	1
11	Yoke	XA-07295-P	1
12	Torsion Spring	XB-2149	1
13	Roll Pin, Ø1/2" x 2-3/4"	XB-21-S-500-2750P	1
14L	Secondary Lock, Left-Hand (included with RK-351-A-L kit)	XA-3542-L-P	1
14R	Secondary Lock, Right-Hand (included with RK-351-A kit)	XA-3542-R-P	1
15	Hex Head Cap Screw, 1/2"-20 x 1-3/4"	XB-2083	1
16	Washer, 1-3/4" O.D. x 9/16" I.D.	XB-08559-P	2
17	Roller, 1/2" I.D.	XA-1029	1
18	Hex Head Cap Screw, 5/8"-18 x 1-3/4"	XB-CX-58-F-134	1
19	Washer, 2-5/8" O.D. x 21/32" I.D., Stainless Steel	XB-10259	2
20	Roller, 5/8" I.D.	XA-1507	1
21L	Cam Plate, Left-Hand (included with RK-351-A-L kit)	XA-07150-L-P	1
21R	Cam Plate, Right-Hand (included with RK-351-A- kit)	XA-07150-R-P	1
22	Lock Nut, 1/2"-20	XB-T-69-A	3
23	Release Handle	XA-10344	1
24	Compression Spring	XB-07291	1
25	Washer, 1-1/16" O.D. x 17/32" I.D.	XB-PW-016-17	1
26	Cotter Pin, Ø1/8" x 1-1/4"	XB-07508	1
27	Washer, 1-3/8" O.D. x 9/16" I.D.	XB-T-49-P	1
28	Washer, 1-19/32" O.D. x 1-3/16" I.D.	XB-05859-1	4
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
30	Never-Seez®, 7.5g Tube	XB-02967	1

Note: Kits available from your local SAF-HOLLAND® Distributor.

RK-331-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
42	Lube Plate, Left-Hand	XA-08125-L	1
43	Lube Plate, Right-Hand	XA-08125-R	1
44	Lock Nut, 5/16"-18	XB-08931	18

RK-10605 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2"-20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
33	Rubber Bushing (cast brackets)	XB-10605	4

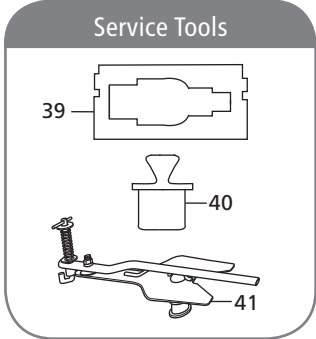
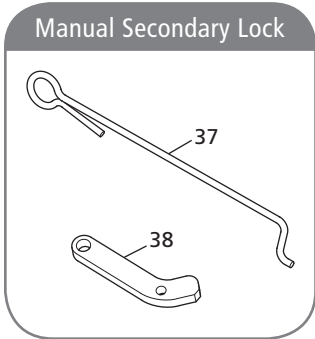
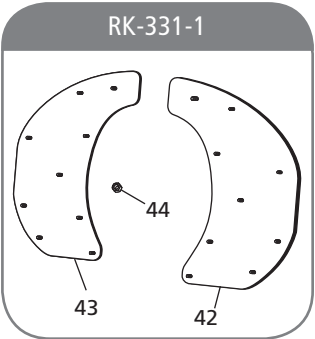
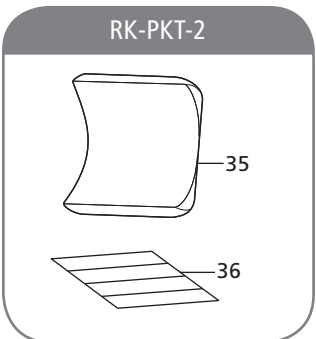
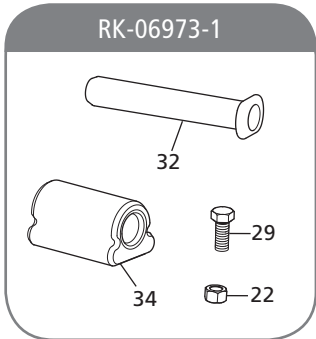
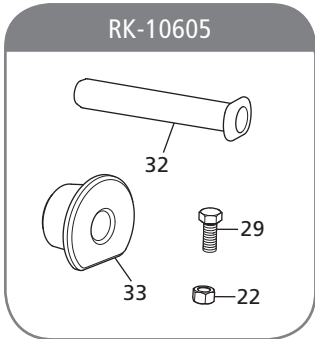
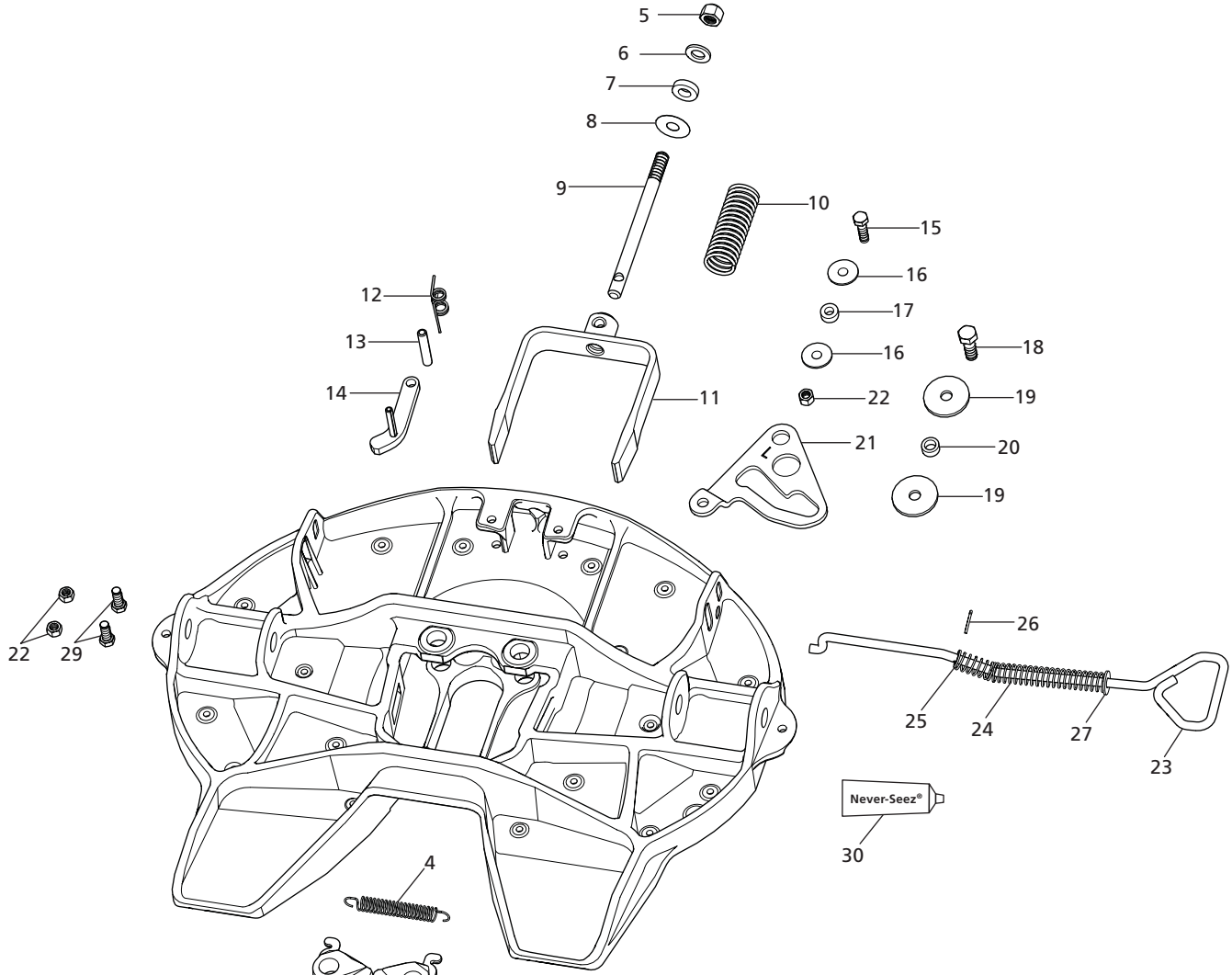
RK-06973-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2"-20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
34	Rubber Bushing (fabricated brackets)	XB-0011-2	2

RK-PKT-2 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
35	Pocket Insert	XD-08908	2
36	Double Face Tape	XB-09422	4

RK-09559 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
44	Lock Nut, 5/16"-18	XB-08931	1
45	Thread-Cutting Screw, 5/16"-18 x 1/2"	XB-09185	1
46	Tube Clip	XB-09184-1	2
47	Lube Tube	XA-09181	1
48	Washer, 7/8" O.D. x 3/8" I.D.	XB-05635	1
49	Female Connector Fitting	XB-09183	1
50	Washer, 13/16" O.D. x 13/32" I.D.	XB-PWM-38-78	1
51	Lube Fitting	XB-H-38	1

MANUAL SECONDARY LOCK			
ITEM	DESCRIPTION	PART NUMBER	QTY.
37	Manual Secondary Lock Release Handle (included with RK-351-A-02-L and RK-351-A-02 kits)	XA-3542-M-P	1
38	Manual Secondary Lock (included with RK-351-A-02-L and RK-351-A-02 kits)	XA-3528-P	1

SERVICE TOOLS			
ITEM	DESCRIPTION	PART NUMBER	QTY.
39	Kingpin Gauge	TF-0110	1
40	Lock Gauge, 2" (Plug)	TF-0237	1
41	Kingpin Lock Tester	TF-TLN-5001	1





RK-311-A-L AND RK-311-A PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
1	Lock Pin	XA-10256	2
2	Retaining Ring	XB-07398	2
3	Lock Set	XA-11692	1
4	Extension Spring	XB-07628-P	1
5	Lock Nut, 3/4"-16	XB-HNH-34-F	1
6	Washer, 1-1/2" O.D. x 13/16" I.D.	XB-PW-1316-112-P	1
7	Rubber Washer	XB-1127	1
8	Lock Adjustment Tag	XB-02312	1
9	Yoke Shaft	XA-1706	1
10	Compression Spring	XB-1505-1	1
11	Yoke	XA-10257	1
12	Torsion Spring	XB-2149	1
13	Roll Pin, Ø1/2" x 2-3/4"	XB-21-S-500-2750P	1
14L	Secondary Lock, Left-Hand (included with RK-311-A-L kit)	XA-10261	1
14R	Secondary Lock, Right-Hand (included with RK-311-A kit)	XA-10451	1
15	Hex Head Cap Screw, 1/2"-20 x 1-3/4"	XB-2083	1
16	Washer, 1-3/4" O.D. x 9/16" I.D., Stainless Steel	XB-10294	2
17	Roller, 1/2" I.D.	XA-10265	1
18	Hex Head Cap Screw - 5/8"-18 x 1-3/4"	XB-CX-58-F-134	1
19	Washer, 2-5/8" O.D. x 21/32" I.D. Stainless Steel	XB-10259	2
20	Roller, 5/8" I.D.	XA-10343	1
21L	Cam Plate, Left-Hand (included with RK-311-A-L kit)	XA-10258	1
21R	Cam Plate, Right-Hand (included with RK-311-A kit)	XA-10450	1
22	Lock Nut, 1/2"-20	XB-T-69-A	3
23	Release Handle	XA-10344	1
24	Compression Spring	XB-07291	1
25	Washer, 1-1/16" O.D. x 17/32" I.D.	XB-PW-016-17	1
26	Cotter Pin, Ø1/8" x 1-1/4"	XB-07508	1
27	Washer, 1-3/8" O.D. x 9/16" I.D.	XB-T-49-P	1
28	Washer, 1-19/32" O.D. x 1-3/16" I.D.	XB-05859-1	4
29	Hex Head Cap Screw - 1/2"-20 x 1-1/4"	XB-C-95	2
30	Never Seez®, 7.5g Tube	XB-02967	2

Note: Kits available from your local SAF-HOLLAND® Distributor.

RK-10605 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2"-20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
33	Rubber Bushing (cast brackets)	XB-10605	4

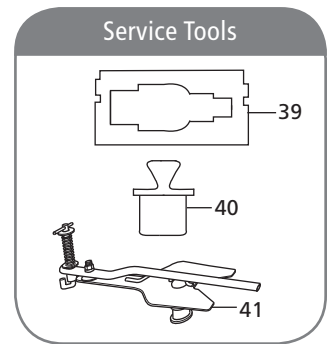
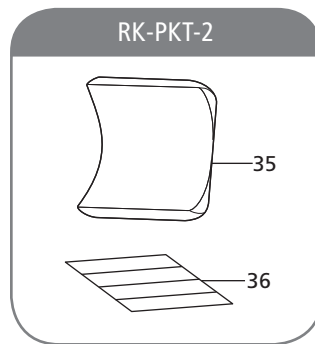
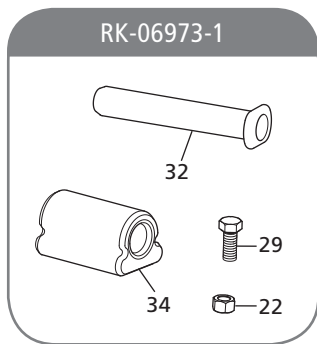
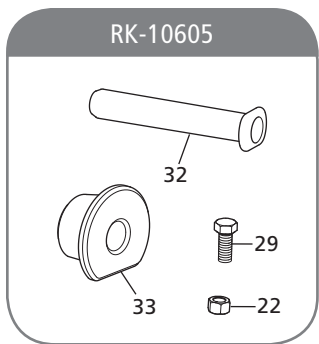
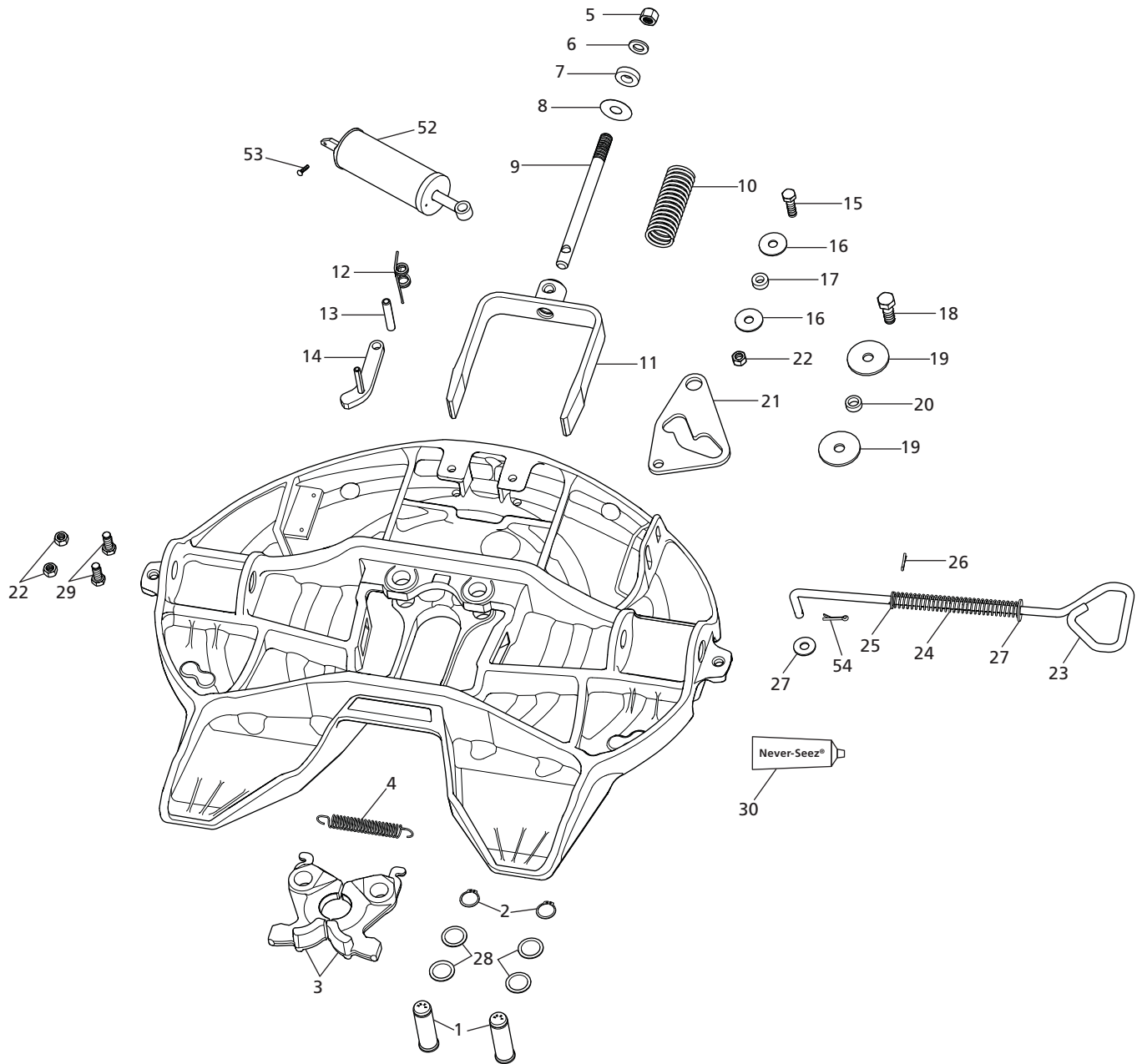
RK-06973-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2"-20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
34	Rubber Bushing (fabricated brackets)	XB-0011-2	2

RK-PKT-2 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
35	Pocket Insert	XD-08908	2
36	Double Face Tape	XB-09422	4

RK-331-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
42	Lube Plate, Left-Hand	XA-08125-L	1
43	Lube Plate, Right-Hand	XA-08125-R	1
44	Lock Nut, 5/16"-18	XB-08931	18

MANUAL SECONDARY LOCK			
ITEM	DESCRIPTION	PART NUMBER	QTY.
37	Manual Secondary Lock Release Handle (included with RK-311-A-02-L and RK-311-A-02 kits)	XA-10459	1
38	Manual Secondary Lock (included with RK-311-A-02-L and RK-311-A-02 kits)	XA-10498	1

SERVICE TOOLS			
ITEM	DESCRIPTION	PART NUMBER	QTY.
39	Kingpin Gauge	TF-0110	1
40	Lock Gauge, 2" (Plug)	TF-0237	1
41	Kingpin Lock Tester	TF-TLN-5001	1





RK-351-A-80-L AND RK-351-A-80-L-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
1	Lock Pin	XA-07292-1	2
2	Retaining Ring	XB-07398	2
3	Lock Set	XA-07296-P	1
4	Extension Spring	XB-07628-P	1
5	Lock Nut, 3/4" -16	XB-HNH-34-F	1
6	Washer, 1-1/2" O.D. x 13/16" I.D.	XB-PW-1316-112-P	1
7	Rubber Washer	XB-1127	1
8	Lock Adjustment Tag	XB-02312	1
9	Yoke Shaft	XA-1706	1
10	Compression Spring	XB-1505-1	1
11	Yoke	XA-07295-P	1
12	Torsion Spring	XB-2149	1
13	Roll Pin, Ø1/2" x 2-3/4"	XB-21-S-500-2750P	1
14	Secondary Lock, Left-Hand (included with RK-351-A-L kit)	XA-3542-L-P	1
15	Hex Head Cap Screw, 1/2"-20 x 1-3/4"	XB-2083	1
16	Washer, 1-3/4" O.D. x 9/16" I.D.	XB-08559-P	2
17	Roller, 1/2" I.D.	XA-1029	1
18	Hex Head Cap Screw, 5/8"-18 x 1-3/4"	XB-CX-58-F-134	1
19	Washer, 2-5/8" O.D. x 21/32" I.D., Stainless Steel	XB-10259	2
20	Roller, 5/8" I.D.	XA-1507	1
21	Cam Plate	XA-1705-P	1
22	Lock Nut, 1/2" -20	XB-T-69-A	3
23	Release Handle	XA-07766-1-P	1
24	Compression Spring	XB-07974-P	1
25	Washer, 1-1/16" O.D. x 17/32" I.D.	XB-PW-016-17	1
26	Cotter Pin, Ø1/8" x 1-1/4"	XB-07508	1
27	Washer, 1-3/8" O.D. x 9/16" I.D.	XB-T-49-P	2
28	Washer, 1-19/32" O.D. x 1-3/16" I.D.	XB-05859-1	4
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
30	Never-Seez®, 7.5g Tube	XB-02967	1
*31	Lube Fitting	XB-H-38	2
52	Air Cylinder (Stainless Steel)- (included in RK-351-A-80-L)	XA-2524-R-16-L	1
	Air Cylinder (Aluminum)- (included in RK-351-A-80-L-1)	XA-11713	1
53	Drive Screw, #12 x 3/4"	XB-09155	1
54	Cotter Pin, Ø3/16" x 1-1/4"	XB-06336	1

RK-10605 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2" -20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
33	Rubber Bushing (cast brackets)	XB-10605	4

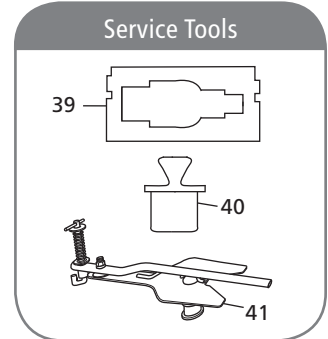
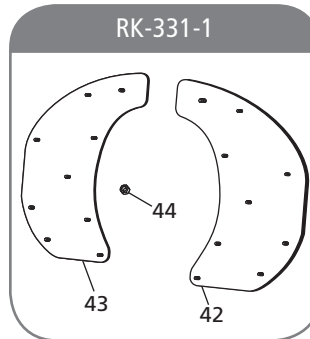
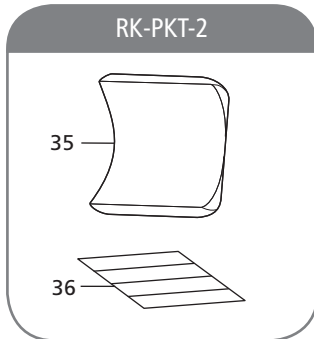
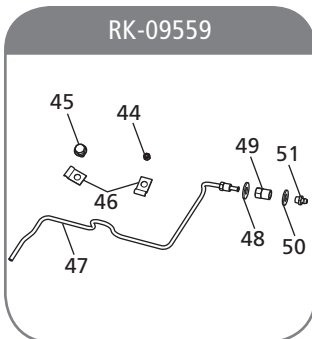
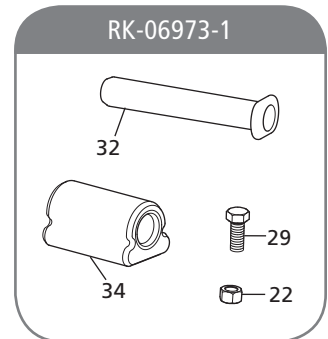
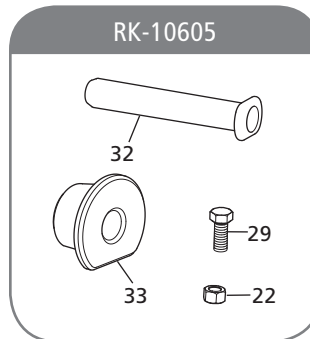
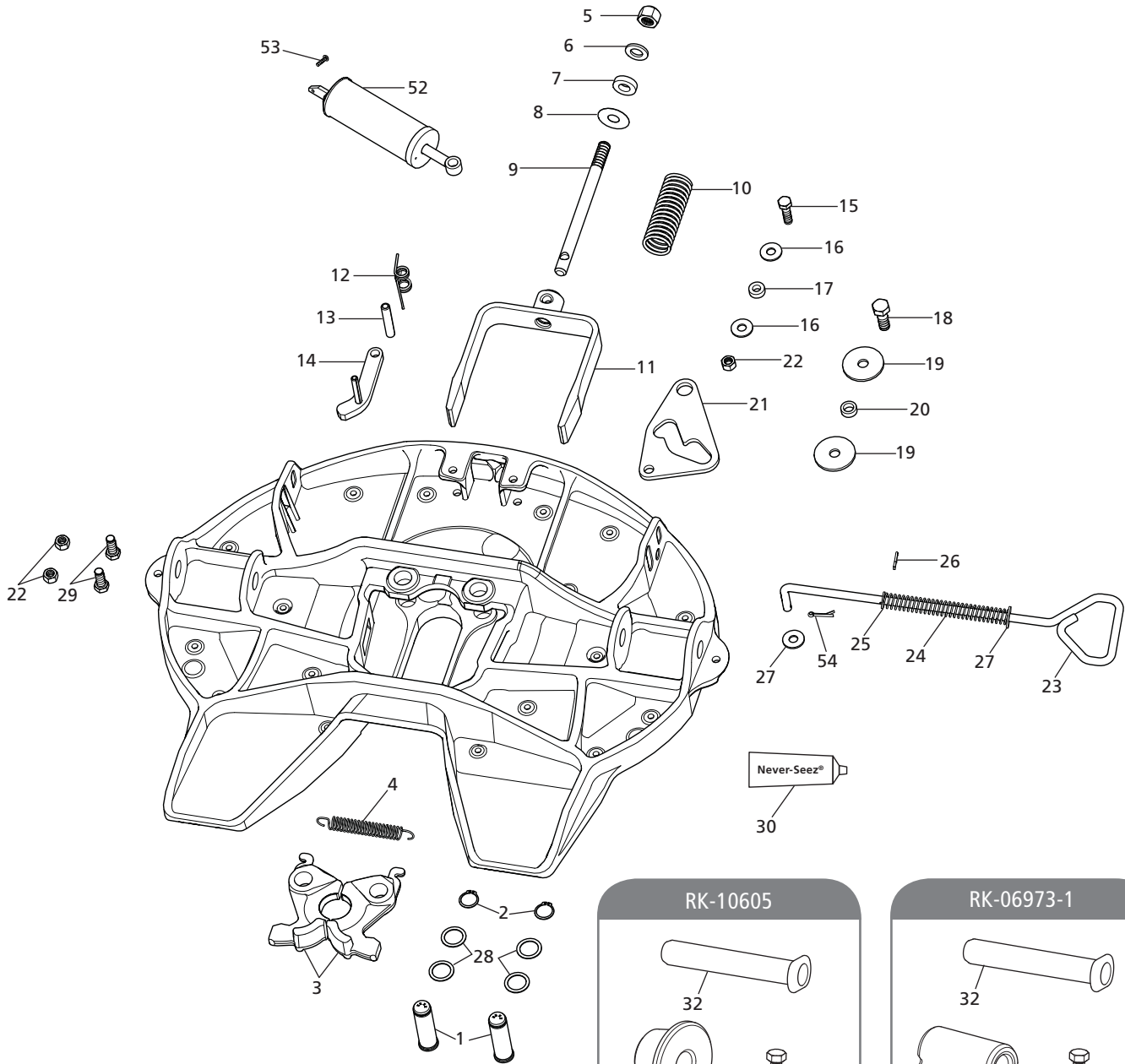
RK-06973-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2" -20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
34	Rubber Bushing (fabricated brackets)	XB-0011-2	2

RK-PKT-2 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
35	Pocket Insert	XD-08908	2
36	Double Face Tape	XB-09422	4

SERVICE TOOLS			
ITEM	DESCRIPTION	PART NUMBER	QTY.
39	Kingpin Gauge	TF-0110	1
40	Lock Gauge, 2" (Plug)	TF-0237	1
41	Kingpin Lock Tester	TF-TLN-5001	1

*Only for use on XA-351 top plates without pocket inserts.

Note: Kits available from your local SAF-HOLLAND® Distributor.





RK-351-A-80-L AND RK-351-A-80-L-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
1	Lock Pin	XA-07292-1	2
2	Retaining Ring	XB-07398	2
3	Lock Set	XA-07296-P	1
4	Extension Spring	XB-07628-P	1
5	Lock Nut, 3/4" -16	XB-HNH-34-F	1
6	Washer, 1-1/2" O.D. x 13/16" I.D.	XB-PW-1316-112-P	1
7	Rubber Washer	XB-1127	1
8	Lock Adjustment Tag	XB-02312	1
9	Yoke Shaft	XA-1706	1
10	Compression Spring	XB-1505-1	1
11	Yoke	XA-07295-P	1
12	Torsion Spring	XB-2149	1
13	Roll Pin, Ø1/2" x 2-3/4"	XB-21-S-500-2750P	1
14	Secondary Lock, Left-Hand (included with RK-351-A-L kit)	XA-3542-L-P	1
15	Hex Head Cap Screw, 1/2" -20 x 1-3/4"	XB-2083	1
16	Washer, 1-3/4" O.D. x 9/16" I.D.	XB-08559	2
17	Roller, 1/2" I.D.	XA-1029	1
18	Hex Head Cap Screw, 5/8" -18 x 1-3/4"	XB-CX-58-F-134	1
19	Washer, 2-5/8" O.D. x 21/32" I.D., Stainless Steel	XB-10259	2
20	Roller, 5/8" I.D.	XA-1507	1
21	Cam Plate	XA-1705-P	1
22	Lock Nut, 1/2" -20	XB-T-69-A	3
23	Release Handle	XA-07766-1-P	1
24	Compression Spring	XB-07974-P	1
25	Washer, 1-1/16" O.D. x 17/32" I.D.	XB-PW-016-17	1
26	Cotter Pin, Ø1/8" x 1-1/4"	XB-07508	1
27	Washer, 1-3/8" O.D. x 9/16" I.D.	XB-T-49-P	2
28	Washer, 1-19/32" O.D. x 1-3/16" I.D.	XB-05859-1	4
29	Hex Head Cap Screw, 1/2" -20 x 1-1/4"	XB-C-95	2
30	Never Seez®, 7.5g Tube	XB-02967	1
52	Air Cylinder (Stainless Steel)- (included in RK-351-A-80-L)	XA-2524-R-16-L	1
	Air Cylinder (Aluminum)- (included in RK-351-A-80-L-1)	XA-11713	1
53	Drive Screw, #12 x 3/4" LG	XB-09155	1
54	Cotter Pin, Ø3/16" x 1-1/4"	XB-06336	1

Note: Kits available from your local SAF-HOLLAND® Distributor.

RK-10605 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2" -20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2" -20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
33	Rubber Bushing (cast brackets)	XB-10605	4

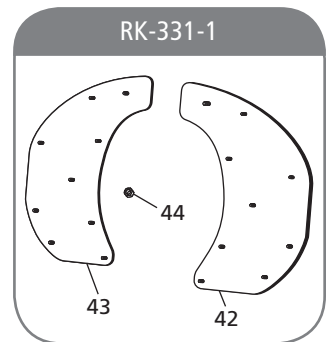
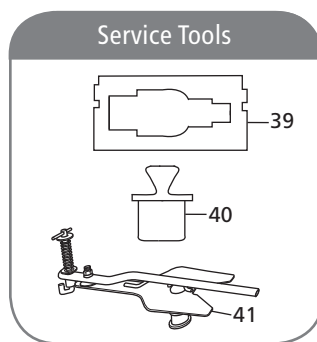
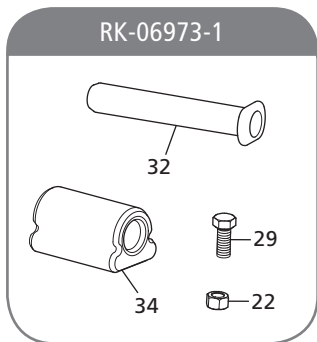
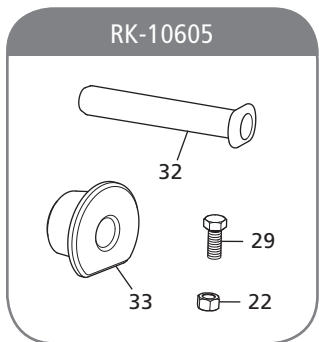
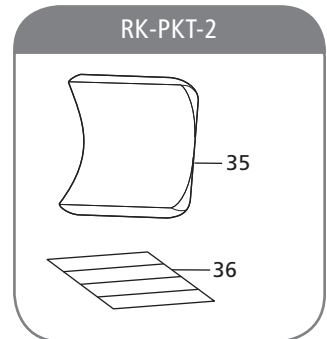
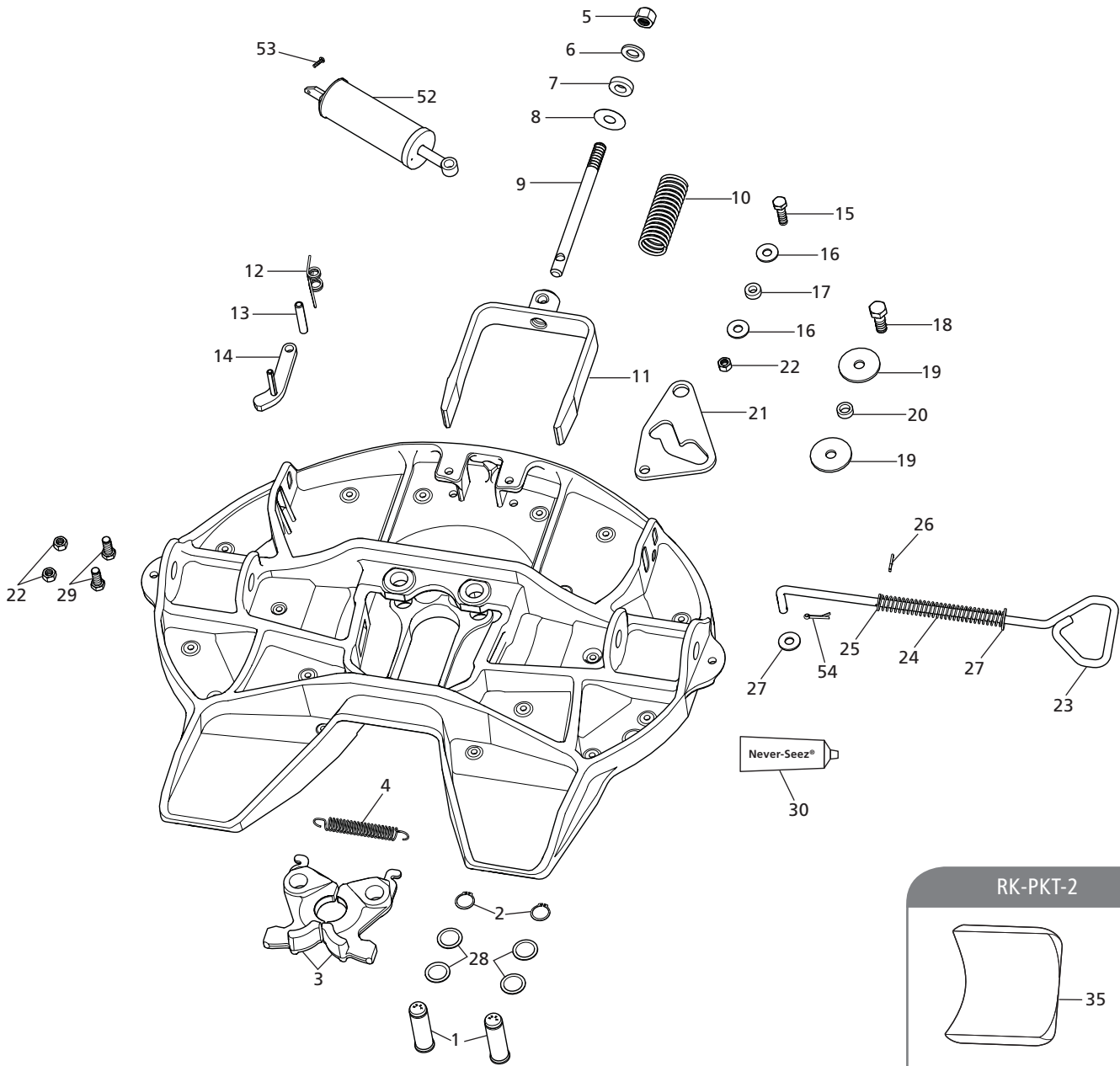
RK-06973-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2" -20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2" -20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
34	Rubber Bushing (fabricated brackets)	XB-0011-2	2

RK-09559 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
44	Lock Nut, 5/16" -18	XB-08931	1
45	Thread-Cutting Screw, 5/16" -18 x 1/2"	XB-09185	1
46	Tube Clip	XB-09184-1	2
47	Lube Tube	XA-09181	1
48	Washer, 7/8" O.D. x 3/8" I.D.	XB-05635	1
49	Female Connector Fitting	XB-09183	1
50	Washer, 13/16" O.D. x 13/32" I.D.	XB-PWM-38-78	1
51	Lube Fitting	XB-H-38	1

RK-PKT-2 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
35	Pocket Insert	XD-08908	2
36	Double Face Tape	XB-09422	4

RK-331-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
42	Lube Plate, Left-Hand	XA-08125-L	1
43	Lube Plate, Right-Hand	XA-08125-R	1
44	Lock Nut, 5/16" -18	XB-08931	18

SERVICE TOOLS			
ITEM	DESCRIPTION	PART NUMBER	QTY.
39	Kingpin Gauge	TF-0110	1
40	Lock Gauge, 2" (Plug)	TF-0237	1
41	Kingpin Lock Tester	TF-TLN-5001	1





RK-311-A-80-L AND RK-311-A-80-L-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
1	Lock Pin	XA-10256	2
2	Retaining Ring	XB-07398	2
3	Lock Set	XA-11692	1
4	Extension Spring	XB-07628-P	1
5	Lock Nut, 3/4" -16	XB-HNH-34-F	1
6	Washer, 1-1/2" O.D. x 13/16" I.D.	XB-PW-1316-112-P	1
7	Rubber Washer	XB-1127	1
8	Lock Adjustment Tag	XB-02312	1
9	Yoke Shaft	XA-1706	1
10	Compression Spring	XB-1505-1	1
11	Yoke	XA-10257	1
12	Torsion Spring	XB-2149	1
13	Roll Pin, Ø1/2" x 2-3/4"	XB-21-S-500-2750P	1
14	Secondary Lock	XA-10261	1
15	Hex Head Cap Screw, 1/2"-20 x 1-3/4"	XB-2083	1
16	Washer, 1-3/4" O.D. x 9/16" I.D.	XB-10456	2
17	Roller, 1/2" I.D.	XA-10265	1
18	Hex Head Cap Screw, 5/8"-18 x 1-3/4"	XB-CX-58-F-134	1
19	Washer, 2-5/8" O.D. x 21/32" I.D., Stainless Steel	XB-10259	2
20	Roller, 5/8" I.D.	XA-10343	1
21	Cam plate	XA-10453	1
22	Lock Nut, 1/2"-20	XB-T-69-A	1
23	Release Handle	XA-10452	1
24	Compression Spring	XB-07974-P	1
25	Washer, 1-1/16" O.D. x 17/32" I.D.	XB-PW-116-17	1
26	Cotter Pin, Ø1/8" x 1-1/4"	XB-07508	1
27	Washer, 1-3/8" O.D. x 9/16" I.D.	XB-T-49-P	2
28	Washer, 1-19/32" O.D. x 1-3/16" I.D.	XB-05859-1	4
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
30	Never Seez®, 7.5g Tube	XB-02967	2
52	Air Cylinder (Stainless Steel)- (included in RK-311-A-80-L)	XA-2524-R-16-L	1
	Air Cylinder (Aluminum)- (included in RK-311-A-80-L-1)	XA-11713	1
53	Drive Screw, #12 x 3/4" LG	XB-09155	1
54	Cotter Pin, Ø3/16" x 1-1/4"	XB-06336	1

Note: Kits available from your local SAF-HOLLAND® Distributor.

RK-10605 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2"-20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
33	Rubber Bushing (cast brackets)	XB-10605	4

RK-06973-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
22	Lock Nut, 1/2"-20	XB-T-69-A	2
29	Hex Head Cap Screw, 1/2"-20 x 1-1/4"	XB-C-95	2
32	Bracket Pin	XE-06356-P	2
34	Rubber Bushing (fabricated brackets)	XB-0011-2	2

RK-PKT-2 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
35	Pocket Insert	XD-08908	2
36	Double Face Tape	XB-09422	4

RK-331-1 PARTS LIST			
ITEM	DESCRIPTION	PART NUMBER	QTY.
42	Lube Plate, Left-Hand	XA-08125-L	1
43	Lube Plate, Right-Hand	XA-08125-R	1
44	Lock Nut, 5/16"-18	XB-08931	18

SERVICE TOOLS			
ITEM	DESCRIPTION	PART NUMBER	QTY.
39	Kingpin Gauge	TF-0110	1
40	Lock Gauge, 2" (Plug)	TF-0237	1
41	Kingpin Lock Tester	TF-TLN-5001	1

3. Top Plate Removal

NOTE: Some fifth wheel assemblies have replaceable pocket inserts installed between the fifth wheel top plate and mounting base. Take care when removing the fifth wheel top plate not to lose the pocket inserts.

CAUTION Failure to prevent pocket inserts from falling out of the top plate could cause a potentially hazardous situation which, if not avoided, could result in minor or moderate injury.

1. Remove the bracket pin retention bolts and nuts from both sides of the fifth wheel top plate and discard (**Figure 3**).
2. Using a pry bar, pull the bracket pins out of the fifth wheel top plate and set aside (**Figure 3**).
3. Using a lifting device capable of lifting 500 lbs. (227 kg), remove the top plate from the mounting base. Place the fifth wheel upside down on a flat, clean working area.

NOTE: Follow the instructions published by the lifting device manufacturer for proper operation of the lifting device.

4. Completely remove all components except the pocket inserts from the fifth wheel and discard.

NOTE: For newer model standard right-hand FW35/XA-351-A fifth wheels and newer model FW35/XA-351-A-80-L air release fifth wheels, DO NOT remove the bracket that is bolted to the fifth wheel top plate casting.

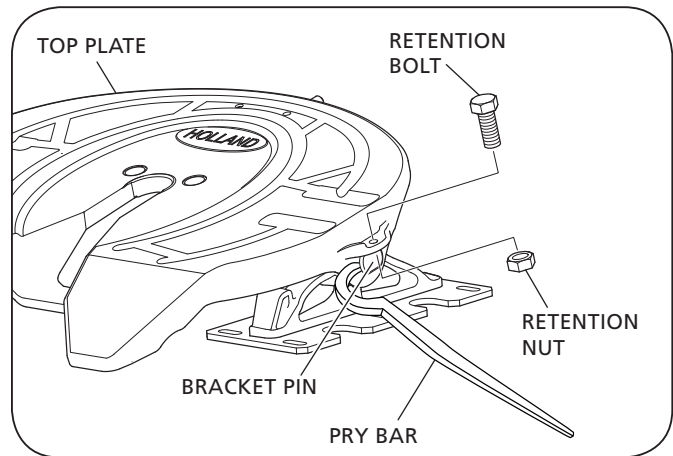
IMPORTANT: Rebuild kits contain all components necessary to completely rebuild the fifth wheel top plate. DO NOT reuse old parts.

IMPORTANT: DO NOT remove the pocket inserts unless they are cracked or worn. Refer to Section 11 for inspection information.

NOTE: Lock pins could be difficult to dislodge and could require force to remove.

CAUTION DO NOT hit steel parts with a steel hammer as parts could break, sending flying steel fragments in any direction creating a hazard which, if not avoided, could result in minor to moderate injury.

Figure 3



5. Thoroughly steam clean the top plate.
6. Inspect the fifth wheel top plate for cracks and for loose lock pin holes. Fifth wheels with cracks or loose lock pin holes **MUST** be replaced.

⚠ WARNING Failure to replace fifth wheels with cracks or loose lock pin holes could result in tractor-trailer separation which, if not avoided, could result in death or serious injury.

NOTE: Follow the lubrication procedures in this manual for all fifth wheel models to assure proper function.

4. Lock Installation

1. Lubricate the lock pin holes of the locks with Never-Seez[®] (provided in kit, **Figure 4**).

IMPORTANT: ONLY use Never-Seez[®] when lubricating the lock pin holes of the locks. DO NOT use a substitute lubricant.

2. With the fifth wheel top plate upside down, align the lock pin holes of the locks with the lock pin holes in the top plate casting. Be certain to position the locks with the kingpin guides facing away from the top plate casting (**Figure 5**).
3. Insert shims (1-19/32" O.D. x 1-3/16" I.D. washers) between the top of the locks and the top plate casting. Position the shims to align with the lock pin holes. Use one (1) to two (2) shims per lock to fill the gap between the lock and the casting (**Figure 6**).
4. With the locks and shims properly positioned in the top plate casting, drive the lock pins through the locks, shims and casting holes until the heads of the lock pins are flush with the casting (**Figure 6**).
5. Install the retaining rings on the lock pins (**Figure 6**).

Figure 4

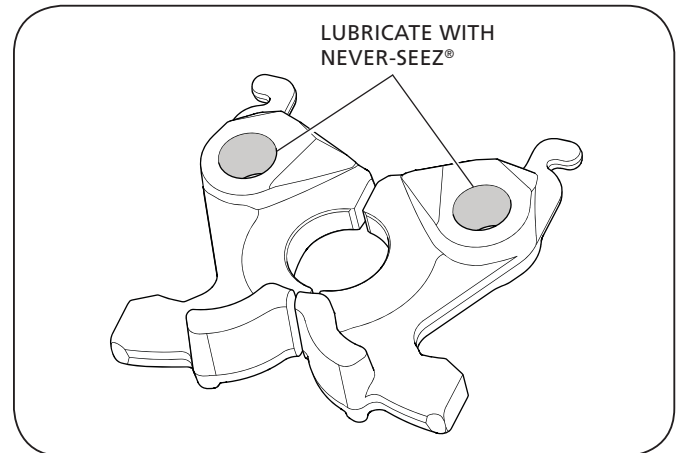


Figure 5

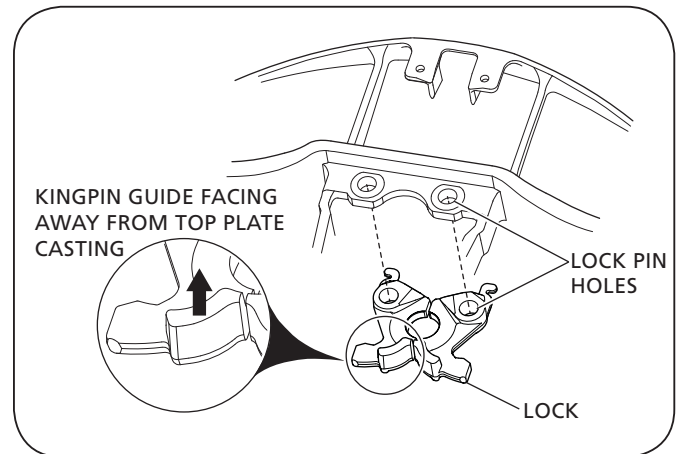
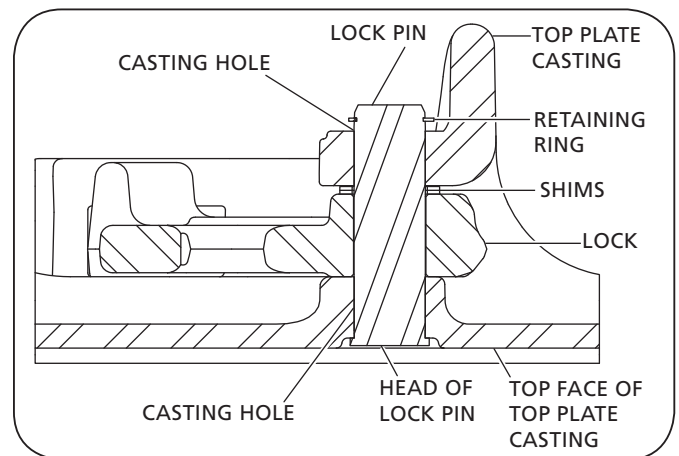


Figure 6



6. Insert a 2" (50.8 mm) diameter precision plug or the HOLLAND® Lock Gauge (Part No. TF-0237) into the locks (**Figure 7**).

NOTE: A HOLLAND® Lock Gauge (TF-0237) or a precision plug that is 2.000 +/- .005" (50.80 mm +/- 0.13 mm) in diameter **MUST** be used for proper installation of the locking mechanism.

5. Yoke Installation

1. Lubricate the tips of the yoke with a water-resistant lithium-based grease (**Figure 8**).
2. With the threaded hole facing up, slide the yoke into the casting. Tap lightly to seat the yoke around the locks (**Figure 8**).
3. Inspect the amount of yoke tip engagement. The yoke tips **MUST** be flush with the end of each lock or extend less than 1/2" (12 mm) beyond each lock (**Figure 9**).

NOTE: If the new yoke extends more than 1/2" (12 mm) beyond each lock, **DO NOT USE**. Discard it and order HOLLAND® part number XA-07295-THK.

Figure 7

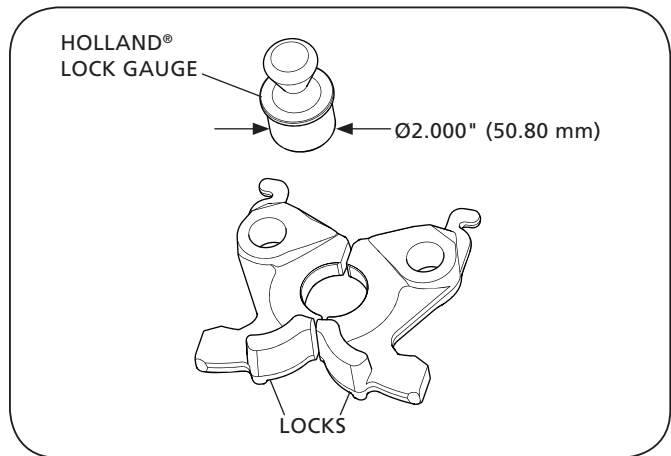


Figure 8

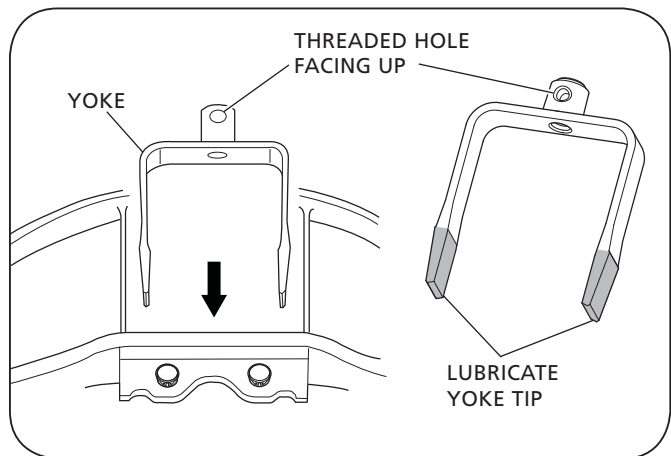
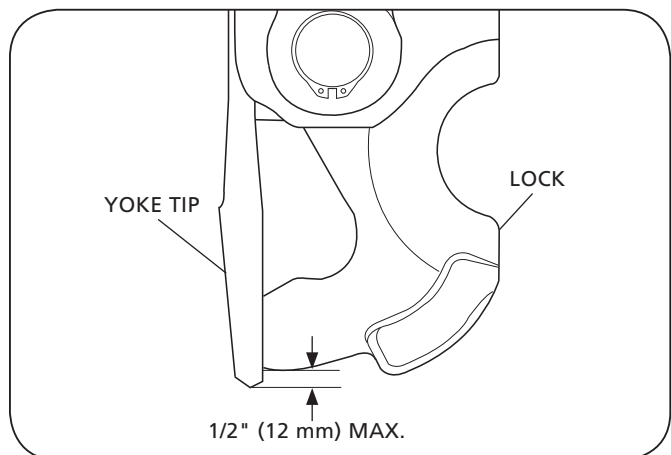


Figure 9



4. Install the lock spring onto the locks (**Figure 10**).
5. Align the yoke spring (**Figure 11**).
6. Slide the yoke shaft through the hole at the front of the top plate casting, through the yoke spring, and into the hole at the end of the yoke. Align the recessed hole in the yoke shaft with the threaded hole in the yoke (**Figure 11**).
7. Slide the lock adjustment tag (instructions facing outward), rubber washer and 1-1/2" O.D. x 13/16" I.D. washer onto the yoke shaft (**Figure 11**).
8. Attach the 3/4"-16 lock nut to the end of the yoke shaft and turn by hand until tight (**Figure 11**).
9. Remove the HOLLAND® Lock Gauge (or plug) from between the locks.

6. Release Handle Installation

For standard Left-Hand Release and Right-Hand Release:

1. Slide the release handle through the hole indicated in **Figure 12**.
 - Left-Hand Release – Use Hole A
 - Right-Hand Release – Use Hole B

Figure 10

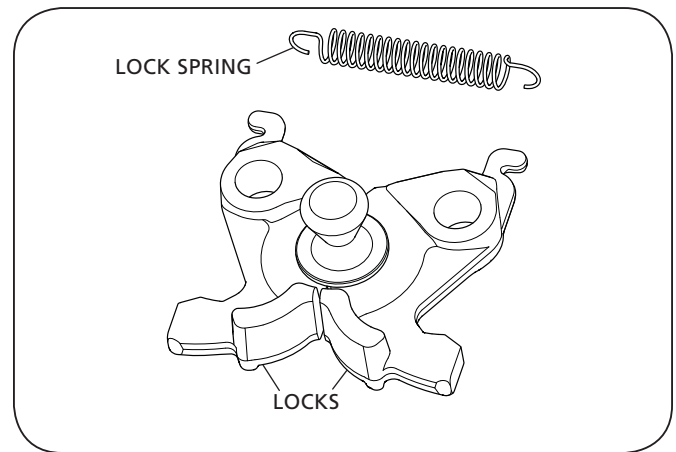


Figure 11

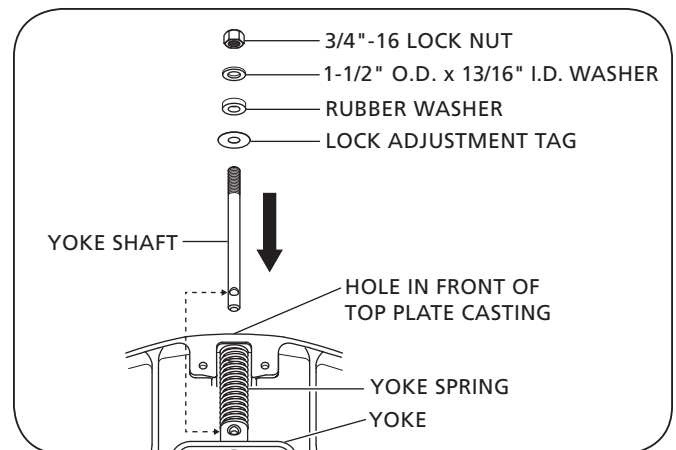
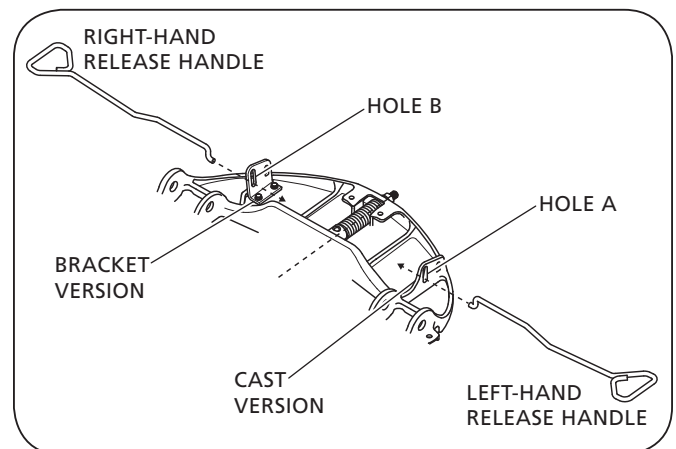


Figure 12



2. Slide the 1-3/8" O.D. x 9/16" I.D. washer, handle spring, and 1-1/16" O.D. x 17/32" I.D. washer, in order, over the "S" bend of the release handle (**Figure 13**).
3. Compress the handle spring using the 1-1/16" O.D. washer until the cotter pin hole is exposed (**Figure 13**).
4. Insert the Ø1/8" cotter pin into the hole on the release handle. Spread the cotter pin ends and wrap them completely around the release handle, as illustrated (**Figure 13**).

For Air Release:

1. Slide the "L" bend of the release handle through the hole indicated in **Figure 14**.
2. Slide the 1-3/8" O.D. x 9/16" I.D. washer, handle spring, and 1-1/16" O.D. x 17/32" I.D. washer, in order, over the "L" bend of the release handle. (Reference handle assembly in **Figure 13**.)
3. Compress the handle spring using the 1-1/16" O.D. washer until the cotter pin hole is exposed (**Figure 13**).
4. Insert the Ø1/8" cotter pin into the hole on the release handle. Spread the cotter pin ends and wrap them completely around the release handle, as illustrated (**Figure 13**).
5. Insert the flat mounting tab of the air cylinder through the front top plate casting hole or bracket hole in **Figure 14**, with the tapered end of the air cylinder tab facing up. Secure with the drive screw through the hole in the air cylinder tab until the drive screw head bottoms out.

Figure 13

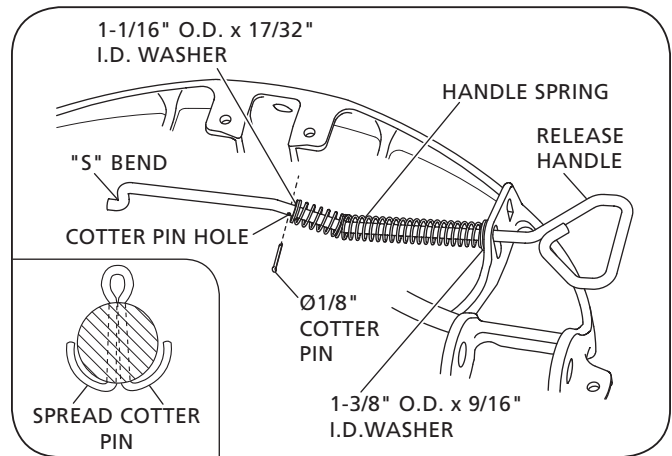
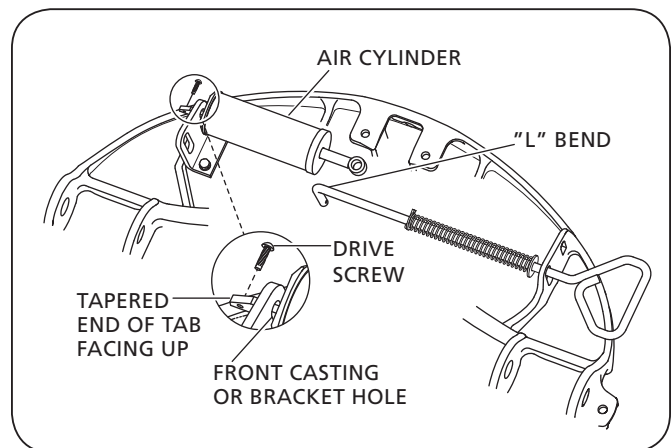


Figure 14



7. Cam Plate Installation

1. Inspect the cam plate for burrs and machine off as necessary.
2. Lubricate the cam plate track and pivot hole with a water-resistant lithium-based grease (**Figure 15**).
3. For standard Left-Hand and Right-Hand Release, install the cam plate onto the handle "S" bend (**Figure 15**).

For Air Release, insert the "L" bend of the release handle through the hole at the end of the air cylinder rod and then through the cam plate. Place the 1-3/8" O.D. x 9/16" I.D. washer over the end of the handle, insert the Ø3/16" cotter pin, and spread the cotter pin ends, wrapping them completely around the release handle.

Figure 15

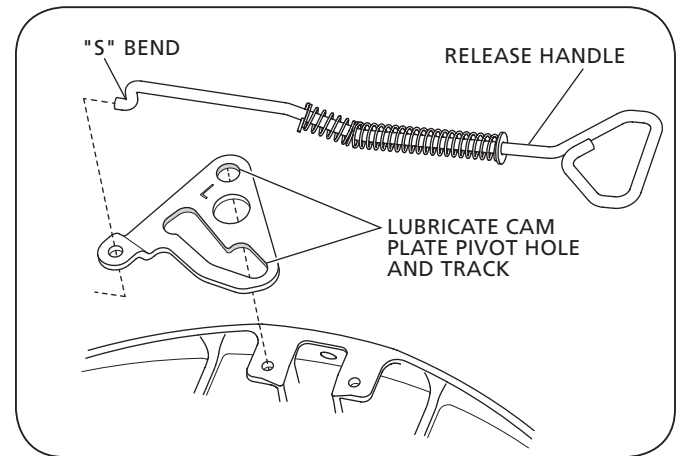
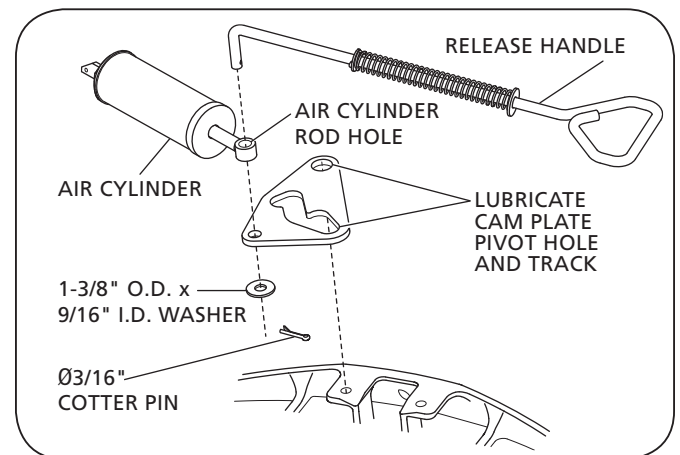


Figure 16



4. Position the cam plate attachment hole over the top plate casting lug hole, as illustrated (**Figure 17**).
5. Place one of the 1-3/4" O.D. x 9/16" I.D. washers between the cam plate and the lug hole with the rounded side of the washer facing the cam plate (**Figure 17**).

NOTE: When installing the 1-3/4" O.D. washers, the rounded edge of the washers **MUST** always face the cam plate.

6. Install the 1/2" I.D. roller into the cam plate attachment hole and place the second 1-3/4" O.D. x 9/16" I.D. washer on top of the roller with the rounded side of the washer facing the cam plate (**Figure 18**).
7. Install the 1/2"-20 x 1-3/4" hex head cap screw through the washers, roller, cam plate attachment hole and lug hole, and secure with the 1/2"-20 lock nut (**Figure 18**). Torque to 65 ft.-lbs. (88 N•m). Check for free movement of the cam plate.

8. Align the cam plate track over the threaded hole in the yoke (**Figure 19**).
9. Place one of the 2-5/8" O.D. x 21/32" I.D. washers between the yoke and the cam plate, with the rounded side of the washer facing the cam plate (**Figure 19**).
10. Place the 5/8" I.D. roller into the cam plate track and place the second 2-5/8" O.D. x 21/32" I.D. washer on top of the roller with the rounded side of washer facing the cam plate (**Figure 19**).
11. Check for alignment with the threaded hole in the yoke and the recessed hole in the yoke shaft.
12. Install the 5/8"-18 x 1-3/4" hex head cap screw through the washers, roller, cam plate track and into the threaded hole in the yoke (**Figure 19**).

Figure 17

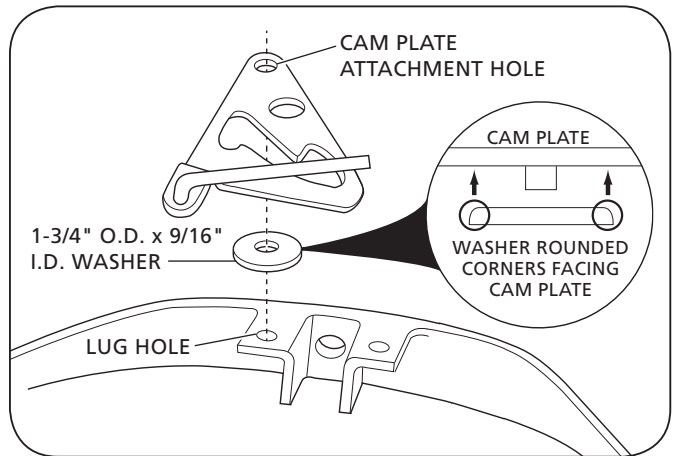


Figure 18

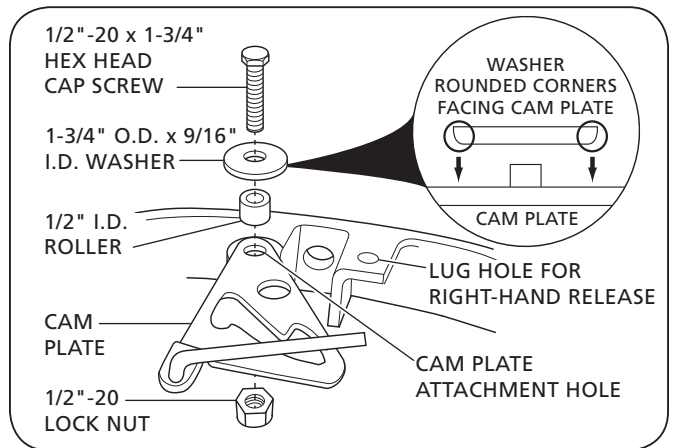
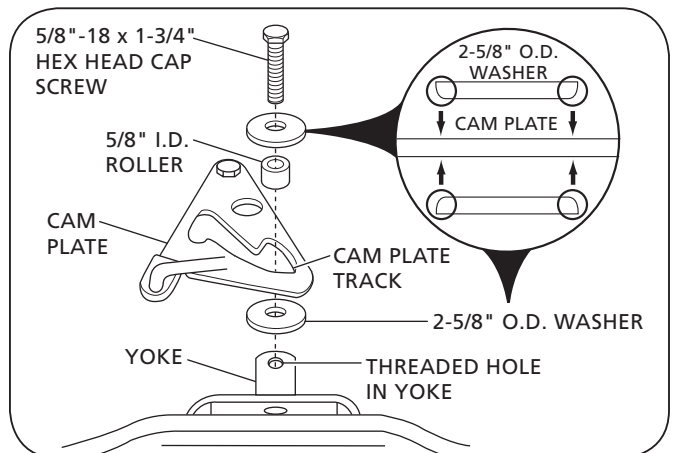


Figure 19



13. Make sure the hex head cap screw enters the recessed hole in the yoke shaft (**Figure 20**).
14. Tighten the hex head cap screw securely. Make sure the gap between the washer and the cam plate is no more than .120" (3.04 mm) and no less than .06" (1.52 mm). Then check for free movement of the cam plate (**Figure 20**).

8. Secondary Lock Installation (Automatic Version)

1. Start the roll pin into the hole in the top plate casting, opposite of the cam attachment bolt (**Figure 21**).
2. Assemble the secondary lock and torsion spring (**Figure 21**).
3. Drive the roll pin through the spring and secondary lock until flush with the top plate casting (**Figure 21**).
4. Check the lock spring for tension and the lock for free movement.

9. Secondary Lock Installation (Left-Hand and Right-Hand Manual Secondary Locks)

1. Slide the "S" bend of the manual secondary lock handle through the hole indicated in **Figure 22**.
 - Left-Hand Release – Use Hole C
 - Right-Hand Release – Use Hole D
2. Slide the "S" bend of the manual secondary lock handle through the small hole in the secondary lock (**Figure 22**).
3. Start the roll pin into the hole in top plate casting, opposite of the cam attachment bolt (**Figure 21**).
4. Assemble the secondary lock and torsion spring (**Figure 21**).
5. Drive the roll pin through the spring and secondary lock until flush with the top plate casting (**Figure 21**).
6. Check for proper spring tension and operation by pulling the secondary release handle and hooking it on the top plate casting. Then unhook the secondary release handle and allow the torsion spring to snap it closed.

Figure 20

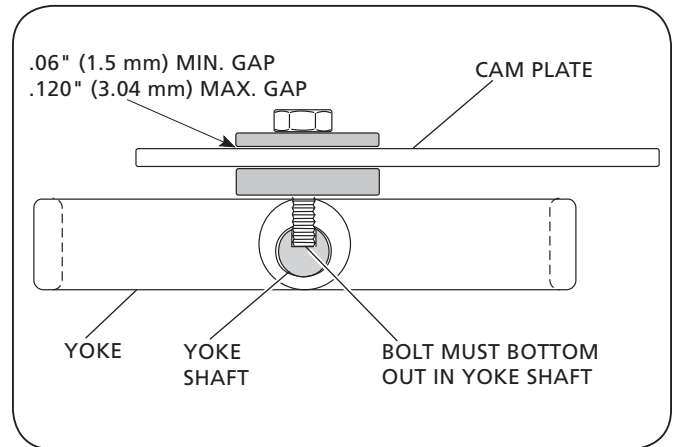


Figure 21

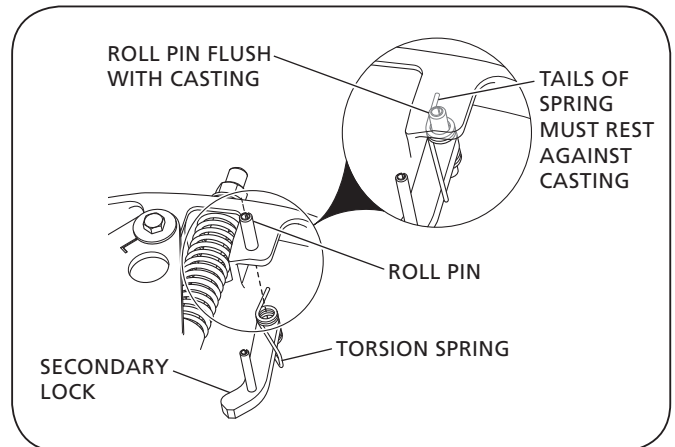
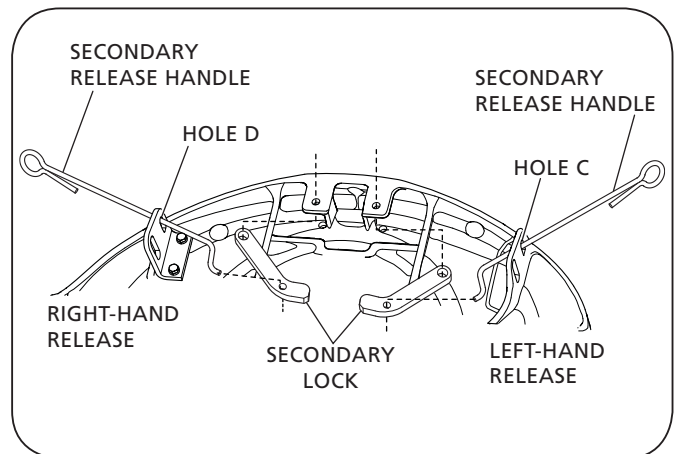


Figure 22



10. Lube Tube Installation (for FW33/XA-331 fifth wheels only)

1. With the lube tube positioned vertically, insert the tube under the yoke and handle as illustrated (**Figure 23**). Slide the open end of the tube past the yoke and into the throat area of the fifth wheel.
2. Rotate the lube tube down toward the side of the fifth wheel so that the bend in the tube fits over the top plate casting rib (**Figure 24**).
3. Position the lube tube so that the end of the tube and the hole in the rib line up (**Figure 25**).

Figure 23

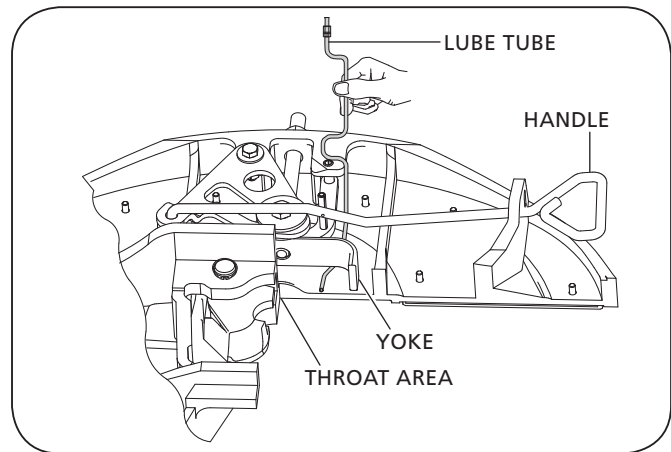


Figure 24

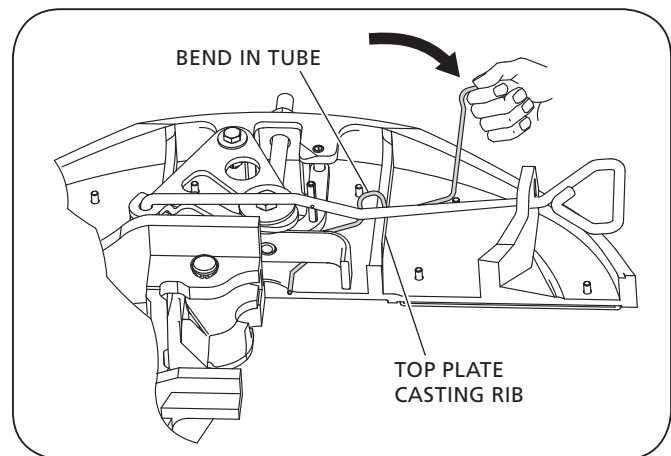
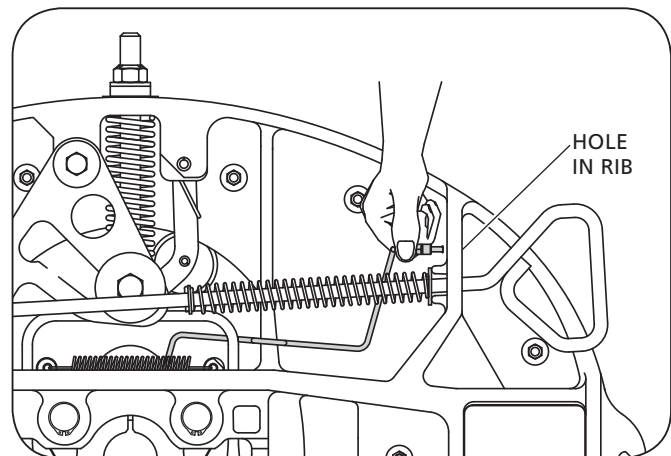


Figure 25



4. Attach the fittings to the lube tube so that the rib is trapped between the two (2) washers as illustrated (**Figure 26**).
5. Place the end of the lube tube into the lock area with clearance between the locks and the tube. The tube MUST be flush with the top plate and positioned as illustrated (**Figure 27**).
6. Clamp the lube tube down with the 5/16"-18 x 1/2" thread-cutting screw, 5/16"-18 lock nut, and tube clips as illustrated (**Figure 28**). Torque to 12ft.-lb. (16 N•m) maximum.

Figure 26

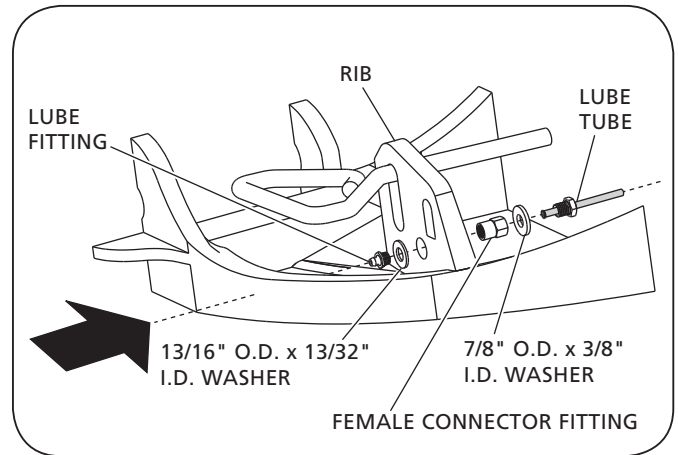


Figure 27

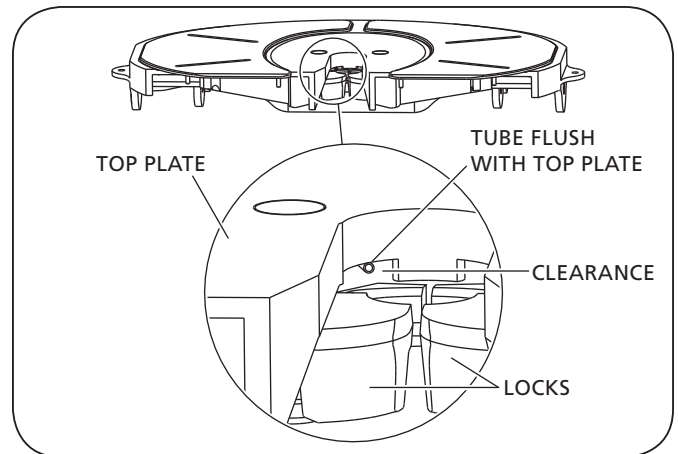
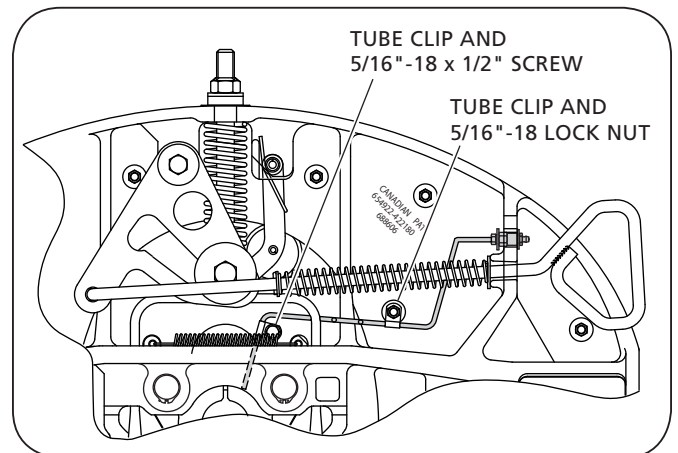


Figure 28



11. Pocket Insert Inspection

1. Replace the pocket inserts (Pocket Inserts Kit, RK-PKT-2) if:
 - The pocket insert thickness is 1/16" (1.59 mm) or less.
 - The free vertical movement of the top plate on the bracket is 1/2" (12.70 mm) or greater, without compressing the rubber bushings (**Figure 29**).
 - The pocket inserts are severely chipped, cracked or gouged.

12. Top Plate Installation

1. If the top plate inserts are dislodged from the top plate casting, clean the pocket areas of the casting and apply a strip of double face tape into the bottom of each pocket. Install the pocket inserts by pressing them down firmly into the pocket areas (**Figure 30**).
2. Using a lifting device capable of lifting 500 lbs. (227 kg), install the fifth wheel top plate onto its mounting base.

NOTE: Follow the instructions published by the lifting device manufacturer for proper operation of the lifting device.

3. Install the bracket pins through the top plate casting and mounting base and secure with the 1/2"-20 x 1-1/4" hex head cap screws and the 1/2"-20 lock nuts (**Figure 31**). Torque the hex head cap screws, NOT to exceed 50-60 ft.-lbs. (68-81 N•m).

Figure 29

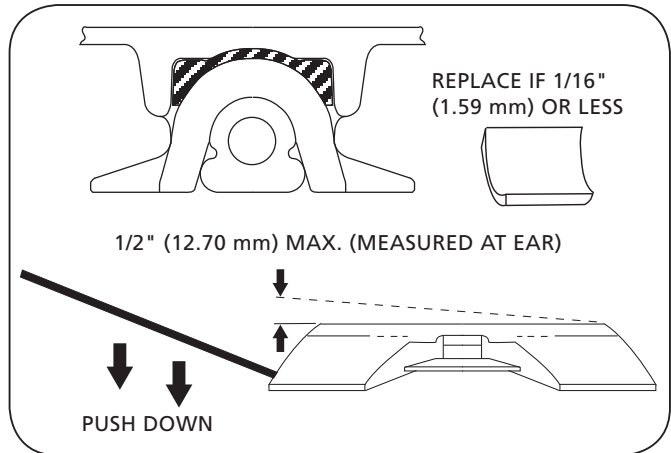


Figure 30

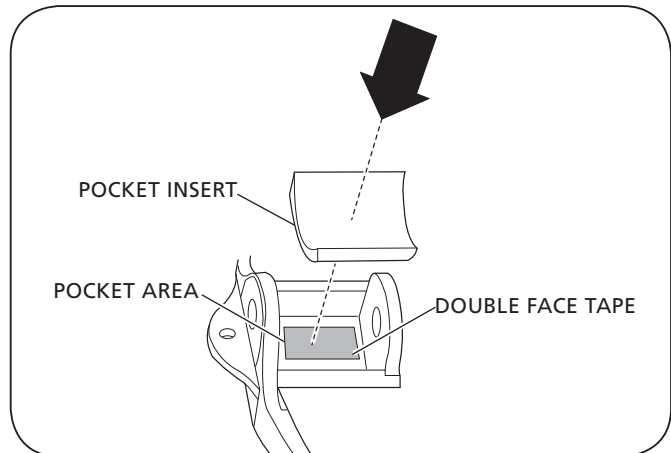
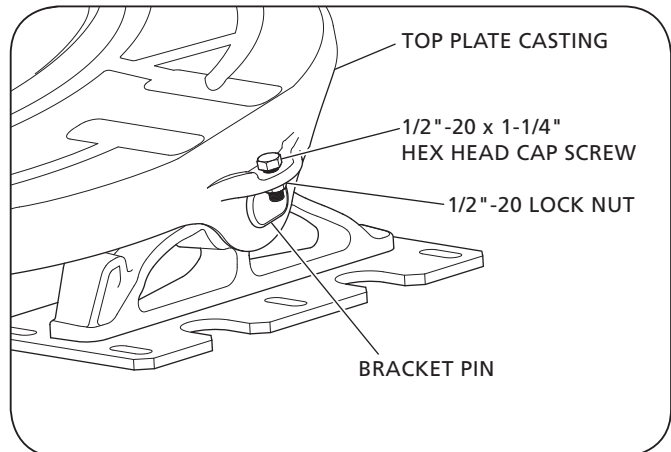


Figure 31



13. Fifth Wheel Adjustment

⚠ WARNING Failure to maintain proper fifth wheel adjustment could result in loss of vehicle control which, if not avoided, could result in death or serious injury.

NOTE: To obtain proper fifth wheel adjustment, SAF-HOLLAND® recommends the use of HOLLAND® lock tester Part No. TF-TLN-5001, available from a local HOLLAND® distributor.

1. Back off the adjustment nut five to six (5-6) turns (**Figure 32**).
2. If the fifth wheel is locked, pull the release handle to unlock the fifth wheel. If equipped with a manual secondary lock, first pull the secondary release handle and hook on the casting.
3. Use the lock tester to couple and uncouple the fifth wheel two to three (2-3) times to help "seat" the yoke. (Refer to Document No. XL-FW10082ST-en-US, available on the internet at www.safholland.us, which contains specific lock tester instructions.)
4. With the locks closed around lock tester, position the adjustment nut on the yoke shaft so that it is slightly compressing the rubber washer, making it difficult to turn by hand (**Figure 33**).
5. Turn the adjustment nut one (1) additional turn clockwise to further compress the rubber washer (**Figure 33**).

IMPORTANT: Over-compressing the rubber washer with additional turns will take the fifth wheel out of proper alignment and degrade the performance of the fifth wheel.

6. Repeat the coupling and uncoupling process with the lock tester at least twice to help "seat" the yoke.
7. Confirm the rubber washer cannot be turned by hand. If it can, repeat the adjustment procedures.
8. Remove the lock tester from the fifth wheel.

IMPORTANT: Before using your fifth wheel, visually inspect all components of the fifth wheel for proper operation while coupling and uncoupling the fifth wheel with the lock tester.

⚠ WARNING Failure to repair an improperly operating fifth wheel could result in tractor-trailer separation which, if not avoided, could result in death or serious injury.

Figure 32

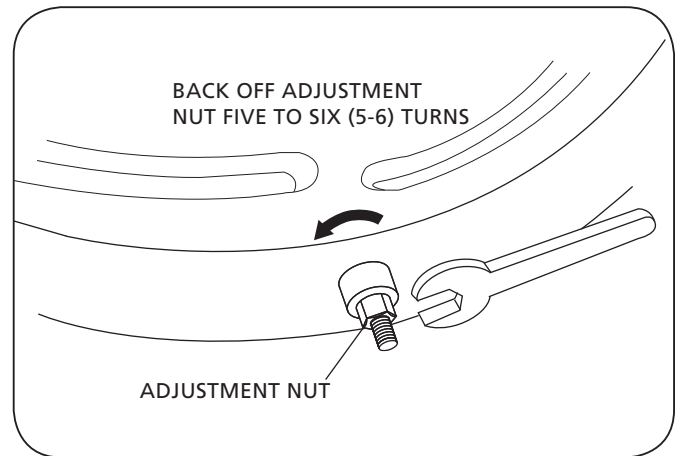
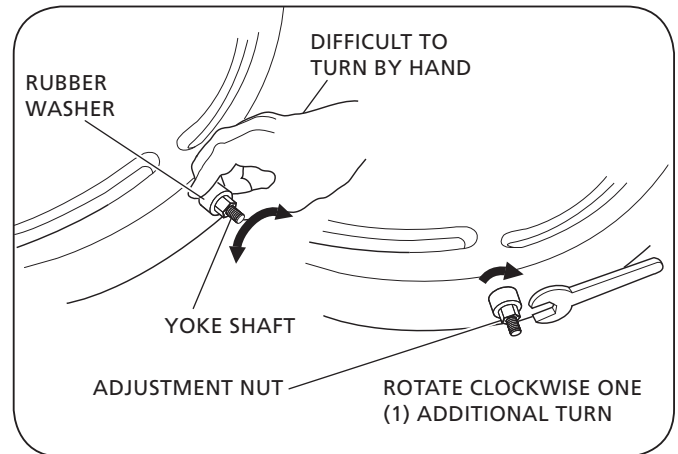


Figure 33









From fifth wheel rebuild kits to suspension bushing repair kits, SAF-HOLLAND Original Parts are the same quality components used in the original component assembly.

SAF-HOLLAND Original Parts are tested and designed to provide maximum performance and durability. Will-fits, look-alikes or, worse yet, counterfeit parts will only limit the performance potential and could possibly void SAF-HOLLAND's warranty. Always be sure to spec SAF-HOLLAND Original Parts when servicing your SAF-HOLLAND product.

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