THE HOLLAND GROUP, INC.

SPEC. NUMBER: NS-65-112

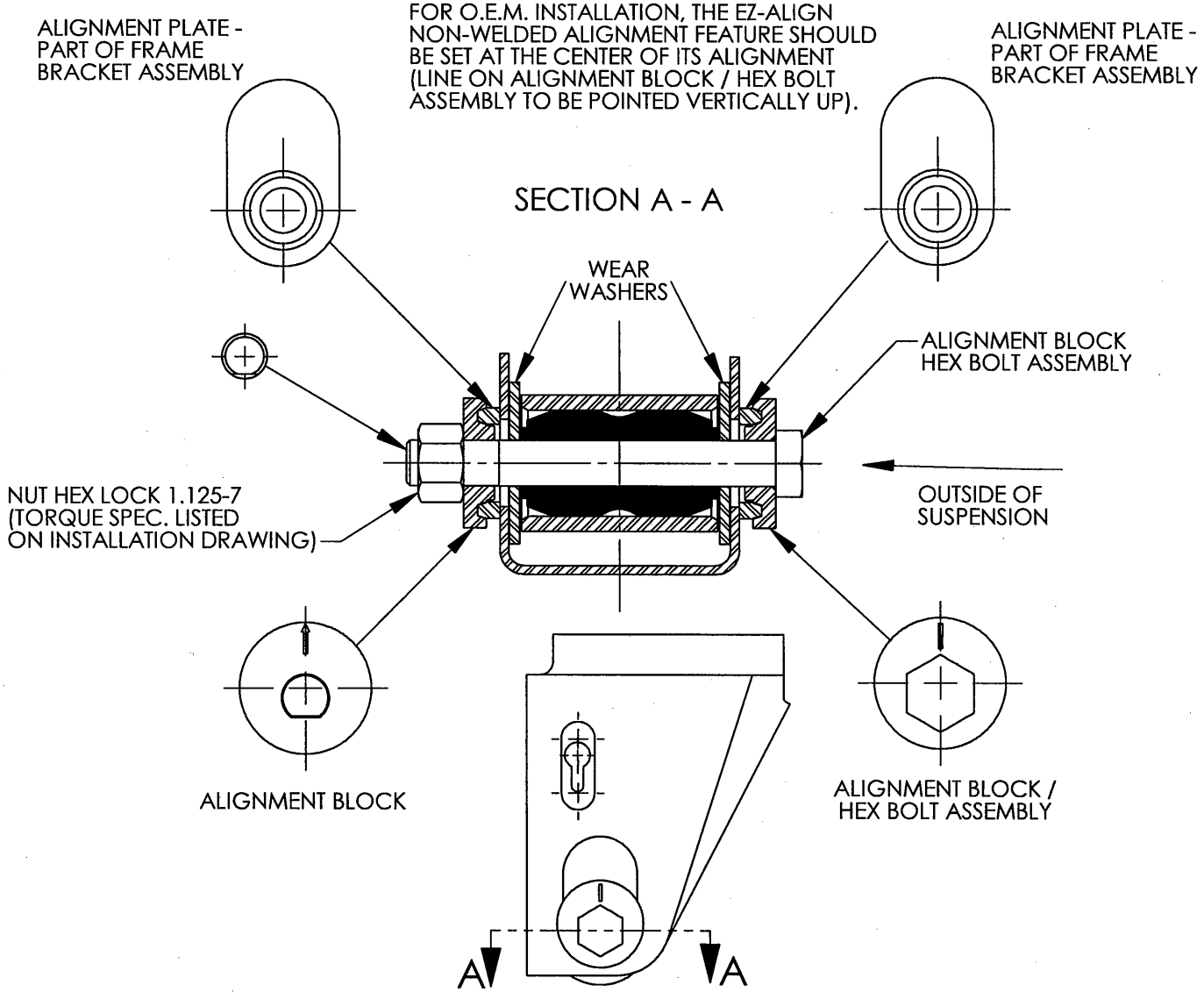
PART NUMBER: 95300002

TITLE:

NS-SERIES EZ-ALIGN NON-WELD AXLE ALIGNMENT

CHANGE RECORD

LTR	WAS	BY	ECN	CHK	ENG	DATE
A	CREATED	SH	9167A	SH	HP	22MAY01
B	REMOVED PART NUMBERS 90508019, 90008238, & 93400506 FROM NOTES	CJS	X-1076	BJB	SH	27OCT01
C	UPDATED VERBAGE PER MARK-UPS	CJS	X-1090	SH	SH	11DEC01



TO CENTER ALIGNMENT FEATURE, THE FLAT OF "D" SHAPED HOLE ON ALIGNMENT BLOCK TO BE POSITIONED DOWNWARD AS SHOWN. LINE ON ALIGNMENT BLOCK / HEX BOLT ASSEMBLY TO BE POINTED VERTICALLY UP.

FOR AXLE ALIGNMENT, LOOSEN THE LOCKNUT AND ROTATE THE HEAD OF THE ALIGNMENT BLOCK/HEX BOLT ASSEMBLY. FOR AXLE ALIGNMENT FOREWARD, ROTATE BOLT HEAD CLOCKWISE. FOR AXLE ALIGNMENT REARWARD, ROTATE BOLT HEAD COUNTER -CLOCKWISE. AFTER AXLE IS ALIGNED, RE-TORQUE NUT TO SPECIFICATIONS LISTED ON INSTALLATION DRAWING.

THE HOLLAND GROUP, INC.

SPEC. NUMBER:	PART NUMBER:
NS-65-111	95300001

TITLE:

NS SERIES WELDED AXLE ALIGNMENT

CHANGE RECORD

LTR	WAS	BY	ECN	CHK	ENG	DATE
A	CREATED	SH	9167A	SH	HP	22MAY01
B	UPDATED NOTES PER MARK-UPS; REMOVED ITEM BALLOONS	CJS	X-1076	BJB	SH	27OCT01
C	UPDATED VERBAGE PER MARK-UPS	CJS	X-1090	SH	SH	11DEC01

THE FOLLOWING WELDING RECOMMENDATIONS ARE FOR CUSTOMER INSTALLED ALIGNMENT BLOCKS. WELDING SHOULD BE PERFORMED BY A QUALIFIED WELDER.

1) INSTALL COMPONENTS AS SHOWN IN SUSPENSION FRAME BRACKET (SEE SECTION "A-A"). TORQUE CONNECTION TO SPECIFICATION LISTED ON INSTALLATION DRAWING.

2) WELD PROCEDURE
   A) FRAME BRACKETS AND ALIGNMENT PLATES MUST BE AT LEAST 70° F AND FREE FROM EXCESS DIRT, SCALE, GREASE, OIL AND PAINT.

THE ELECTRODE OR WIRE SELECTED MUST CONFORM TO ONE OF THE FOLLOWING SPECIFICATIONS:

   B) 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.

C) WIRE	AWS ER-80S-D2	OR	AWS ER-70S-6
GAS	C-25		C-25
VOLTS	19-21 DCRP		25-26 DCRP
AMPS	210-215		300
WIRE DIA.	.045		.0523
WIRE FEED SPEED	210-300 IN/MIN		

3) AFTER WELDS HAVE COOLED DOWN RE-TORQUE NUT TO SPECIFICATIONS LISTED ON INSTALLATION DRAWING .