

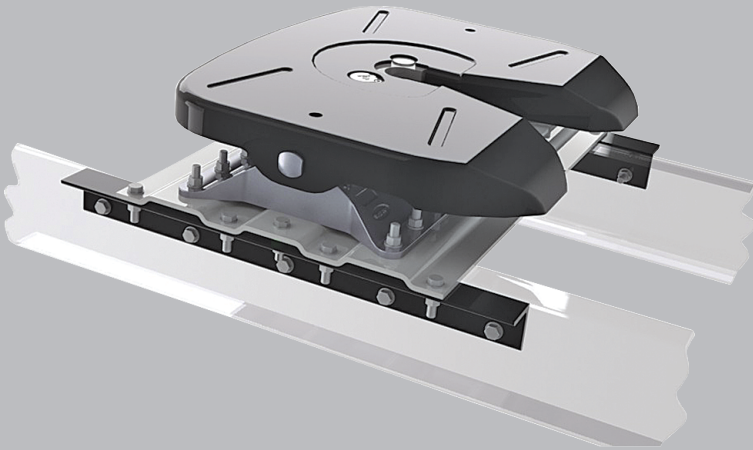
安装手册 Installation Manual

FW20 和 FW28 鞍座安装支架

■ ISO 安装固定

FW20 and FW28 Fifth Wheel
Mounting Bracket

■ ISO Mount Stationary



中文

English

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简介

本手册为您提供正确安装华兰德 FW20 和 FW28 鞍座所必须的信息。

注： 如需技术支持，或需要原厂出品的华兰德鞍座更换组件，请拨打此电话与赛夫-华兰德客服联系：

- 1.888.396.6501
- +86.592.6388.891

注释、注意和警告

通读本手册，您会发现“注”、“重要提示”、“注意”和“警告”等词，后跟实用的产品信息。为使您更好地理解本手册，这些词的定义如下：

注： 提供有助于准确、轻松地执行程序的信息。

重要提示： 提供额外信息，如不遵循，可能无法充分利用产品性能。



不含安全提醒标志时，表示如不避免该潜在危险情况，可能会造成财产损失。



表示如不避免该潜在危险情况，可能会导致轻微或中度人身伤害。



表示如不避免该潜在危险情况，可能会导致严重人员伤亡。

请阅读并遵守本文档中所有“警告”和“注意”下的危险警示信息。这些信息有助于防止发生严重人身伤害和/或部件损坏。

1. 型号识别

鞍座的识别标签位于靠近挂接坡板，用作锁止机构解锁把手的鞍座同侧，或在鞍座安装支架销之上（图 1）。

识别标签上列出了产品序列号和型号等重要信息（图 2）。记录这些编号，以供日后快速查阅。

图 1

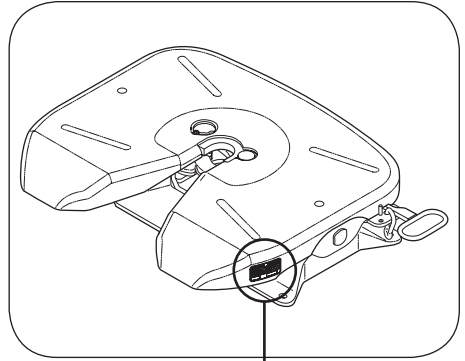
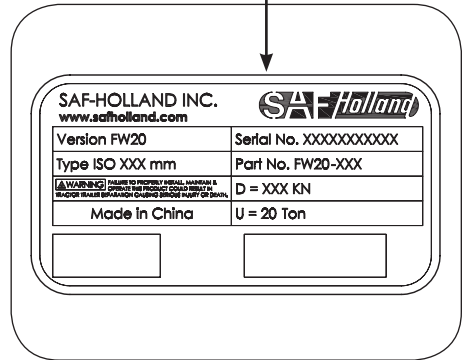


图 2



2. 一般安全说明

重要提示： 在开始安装华兰德鞍座之前，您应该首先阅读并理解本手册中展示的全部程序。

重要提示： 请将本手册存放在安全的地方，以供日后查阅。

重要提示： 鞍座的全部安装工作都必须由一名合格的技术人员使用适当的工具并遵循安全操作程序来完成。

重要提示： 我们强烈建议只使用赛夫-华兰德原厂配件。

注： 在美国，车间的安全要求由联邦和/或州的职业安全与健康法定义。其他国家可能也有等效法律。本手册编写时基于的假设是：职业安全与健康法或其他适用员工安全法规在工作进行的地点得以遵循。

警告 如不遵守本手册中包含的所有安装程序，可能会造成潜在危险；若不加以避免，可能会造成严重人员伤亡。

重要提示： 开始操作鞍座之前，您必须仔细确认鞍座已经正确安装到车辆上。

警告 如果鞍座安装不当，可能会导致牵引车和挂车分离；如不可避免，可能会造成严重人员伤亡。

3. 一般安装建议

■ 安装华兰德鞍座之前，请务必查看产品标识标签上指定的型号，并确认该规格符合所需的车辆要求。

■ 查阅《华兰德鞍座产品目录和规格指南》中的鞍座牵引能力和应用。

安装赛夫-华兰德产品的技术人员必须确信所使用的安装程序适用于该车辆、产品和应用。

■ 请如需了解本地和监管性的标准和安装要求，请查阅 ISO 3842、欧洲议会和欧洲理事会的 94/20/EL 指令和中华人民共和国的 GB/T/20070 国家标准等。

■ 请查阅牵引车制造商的车体制造商手册、最新 SAE 和 D.O.T. 标准，以及 T.M.C. Practice 603 B 中有关安装程序的说明。

■ 确定正确的鞍座位置。鞍座的正确定位对于车辆的重量分布、摆动间隙、铰接和操作特性很重要。查阅 SAEJ701 和牵引车制造商的车体制造商手册/车辆要求。

■ 鞍座必须先于后轴中心线和/或转向架中心线进行安装 (图 3)。

警告 如未能这样做，可能会对转向稳定性产生不利影响，可能导致司机失去对车辆的控制；如不可避免，可能会造成严重人员伤亡。

重要提示： 鞍座安装时切勿使用 U 型螺栓。

警告 在鞍座安装时使用 U 型螺栓可能会导致鞍座总成发生灾难性故障；如果不能避免，可能造成严重人员伤亡。

- 建议在牵引车车架后部接挂车挂接坡板。
- 安装到铝质框架上时，遵照牵引车制造商的建议。赛夫-华兰德有一个用于铝质框架的固定安装角。联系赛夫-华兰德或华兰德品牌产品的经销商了解是否有这种安装角。

4. 选择安装角

外侧 ISO 固定

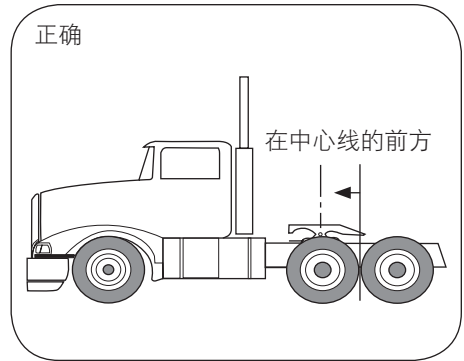
出于方便和易于安装的考虑，有些华兰德鞍座制造时没有附加安装角。以下是有关如何选择和准备安装角用于安装的建议：

- 建议的最小厚度在下面的 **表 1** 中列出，其中包括 ASTM A36 或 ASTM A588 钢规格。
- 最小水平支腿尺寸 3" (76 mm)。
- 最小垂直支腿尺寸 3-1/2" (89 mm)。
- 角的最小长度必须等于或长于鞍座安装基座的长度，且总长度不短于 36" (914 mm)。

表 1

鞍座	最小安装角厚度
FW20	3/8" (10 mm)
FW28	1/2" (12 mm)

图 3



5. 准备安装角

出于安装方便考虑，将切口和安装孔位置等几何信息从车架转到安装角也许更好。赛夫-华兰德建议的顺序：

1. 将安装角和鞍座安装基座牢牢地放置到牵引车车架上的适当位置，该位置应适于将鞍座安装到车上。
2. 将总成在此位置牢牢夹住，并以鞍座安装板为模板定位安装孔的位置 (图 4)。

鞍座必须先于后轴中心线和/或转向架中心线进行安装 (图 5)。

警告 如未能先于后轴中心线和/或转向架中心线安装鞍座，可能会对转向稳定性产生不利影响，可能导致司机失去对车辆的控制；如不可避免，可能会造成严重人员伤亡。

重要提示： 开始定位安装角时，安装角的整个长度应与牵引车车架轨道的顶表面和侧表面齐平，从而防止安装角发生弯曲，并将重量沿车轨均匀分布 (图 4)。

图 4

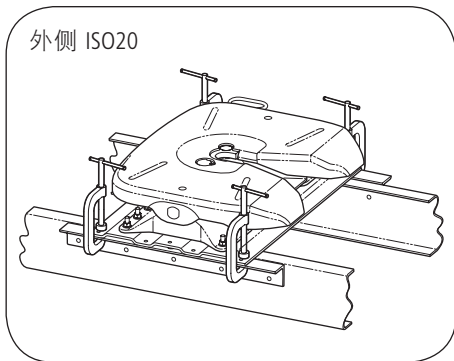
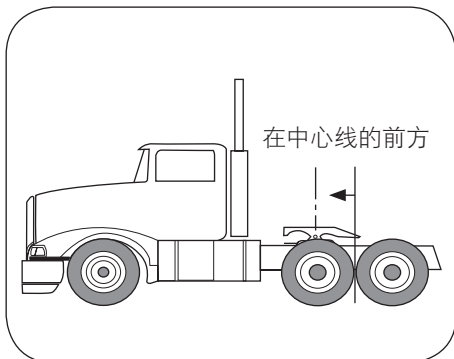


图 5



3. 从车上转移安装孔位置和总成的何处需要切口等几何信息。
- 安装孔的直径应为 21/32" (16.75 mm)。需能容纳 5/8" (16 mm) 安装螺栓。
 - 安装螺栓时，从安装角的底部到螺栓孔中心的距离不应短于 1" (25 mm)。
 - 将每个鞍座安装角连接到牵引车车架轨道上时，至少需要用五 (5) 个螺栓。
 - 除了在安装角上需要切口的地方，安装螺栓之间的距离不应超过 8" (203 mm)。
 - 每当在安装角上做出一个切口（如需要绕过弹簧吊架），最小切口半径应为 1" (25 毫米)。
 - 安装螺栓应位于距切口 1" (25mm) - 1-1/2" (38 毫米) 之间处，前后均可。
 - 螺栓孔距安装角端部不应超过 4" (102 毫米)。



未正确定位螺栓孔可能导致鞍座总成的灾难性故障；若不加以避免，可能导致严重人员伤亡。

4. 加工安装角

重要提示： 一定要打碎/整平所有尖锐的边缘、边角和加工痕迹。

重要提示： 斜切或整平与牵引车车架接触处安装角上的尖锐边角。

6. 准备安装板

华兰德外侧固定 ISO 安装和脚安装鞍座旨在使用波纹或平板安装板进行安装：

零件编号示例：

- FWXX-185
- FWXX-150

注： 您可从赛夫-华兰德购买华兰德波纹安装板；请拨打以下电话与客服联系：

- 1.888.396.6501
- +86.592.6388.891

安装板的推荐厚度取决于所使用具体型号的鞍座的垂直牵引能力。

安装板由 ASTM A36 或 ASTM A572 GR. 50 规格钢制成。

注： 所有安装板上的所有支架接触表面必须平坦，不到 .060" (1.5 mm)。

请参阅以下 **表 2** 查看最小推荐厚度。

表 2

鞍座	最小安装板厚度
FW20	3/8" (10 mm)
FW28	1/2" (12 mm)

7. 将安装角连接到牵引车车架

为将安装角正确固定到牵引车车架上，需要使用以下零部件：

- 最小直径为 5/8" SAE 8 级 或 16 mm ISO 10.9 级的新螺栓。
- 新的 SAE "C" 等级锁紧螺母。
- 在螺栓和锁紧垫圈之下使用的新淬硬钢垫圈。

警告

如未遵循指定紧固件作业建议，可能导致鞍座总成的灾难性故障；如果不能避免，可能导致严重人员伤亡。

1. 将安装角用指定的紧固件牢固地连接到牵引车车架上，与其顶部齐平（图6）。按照建议的顺序连接螺栓、螺母等紧固件（图7）。将每个安装角连接到牵引车车架轨道上时，至少需要用五（5）个紧固件。

注意

未将连接角与牵引车车架顶部平齐，可能会导致潜在危险情况；如果不能避免，可能导致严重人员伤亡。

2. 按建议的顺序拧紧紧固件（紧固件应符合制造商规定的规格）（图7）。

注： 先拧紧位于中心的紧固件，然后从中心向外推进，交替拧紧两边的紧固件。

图 6

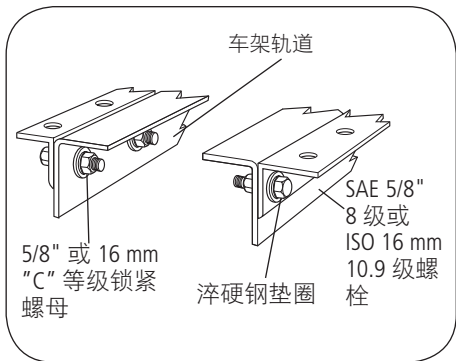
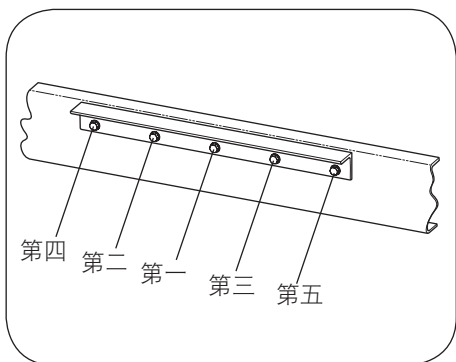


图 7



8. 将鞍座连接到牵引车车架

以下是关于如何将鞍座正确紧固到牵引车车架上的建议：

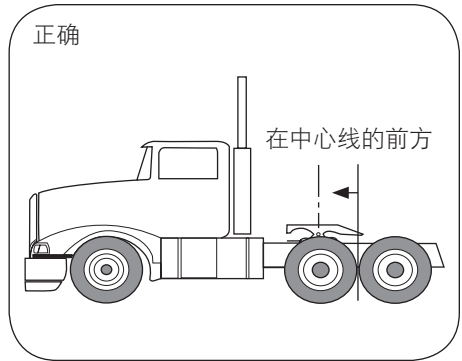
- 只使用最小直径为 5/8" SAE 8 级 或 16 mm ISO 10.9 级的新螺栓。
- 只使用新的 SAE "C" 等级锁紧螺母。
- 对于将鞍座总成连接到外侧安装角时所用的螺栓，要求在螺栓和锁紧螺母之下同时使用淬硬钢垫圈。
- 对于将鞍座总成连接到安装板时所用的螺栓，要求在螺栓和锁紧螺母之下同时使用厚度至少 6 mm，且外径为 40 mm 的淬硬钢垫圈。

警告 如未遵循指定紧固件作业建议，可能导致鞍座总成的灾难性故障；如果不能避免，可能导致严重人员伤亡。

鞍座必须先于后轴中心线和/或转向架中心线进行安装（图 8）。

警告 如未能先于后轴中心线和/或转向架中心线安装鞍座，可能会对转向稳定性产生不利影响，可能导致司机失去对车辆的控制；如不可避免，可能会造成严重人员伤亡。

图 8



1. 将安装板上的所有安装孔紧紧固定到鞍座总成上 (图 9)。将安装板连接到鞍座总成上需要使用至少十二 (12) 个紧固件。

警告

如未紧固安装板上的所有安装孔，可能导致鞍座总成的灾难性故障；如果不能避免，可能导致严重人员伤亡。

2. 按制造商的建议拧紧紧固件。
3. 将鞍座和安装板置于安装角上。将鞍座安装板的孔与外侧角安装孔对齐。
4. 将鞍座上的所有安装孔紧固到安装角上 (图 10)。将鞍座安装到每个角上要求使用最少十 (10) 个紧固件，每侧五 (5) 个。

警告

如未将鞍座上的所有安装孔紧固到安装角上，可能导致鞍座总成的灾难性故障；如果不能避免，可能导致严重人员伤亡。

5. 按建议的顺序拧紧紧固件 (紧固件应符合制造商规定的规格) (图 10)。

注： 先拧紧位于中心的紧固件，然后从中心向外推进，交替拧紧两边的紧固件。

图 9

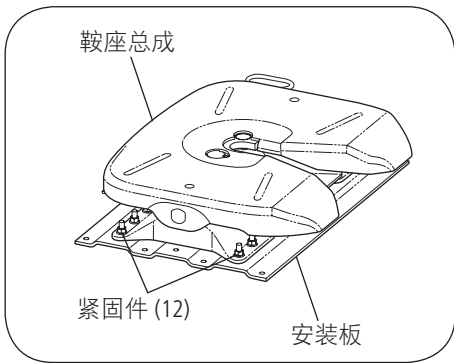
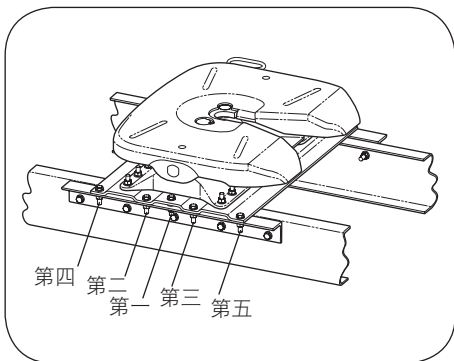


图 10





SAF-HOLLAND Group

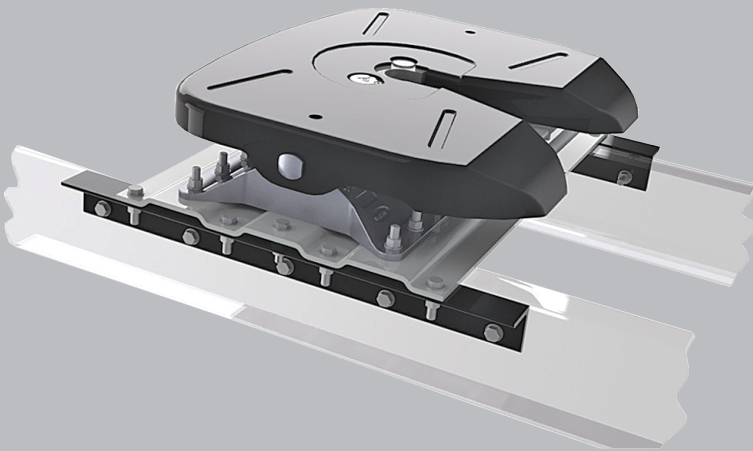
注

中文

Installation Manual

FW20 and FW28 Fifth Wheel Mounting Bracket

- ISO Mount Stationary



English

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Introduction

This manual provides you information necessary for the proper installation of FW20 and FW28 HOLLAND® Fifth Wheels.

NOTE: For technical support and genuine HOLLAND® fifth wheel replacement components contact SAF-HOLLAND® Customer Service at:

- 1.888.396.6501
- +86.592.6388.891

Notes, Cautions, and Warnings

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

Read and observe all Warning and Caution hazard alert messages in this publication. They provide information that can help prevent serious personal injury, damage to components, or both.

1. Model Identification

Fifth wheel Identification tags are located on the same side of the fifth wheel as the lock mechanism release handle near the pickup ramps, or above the fifth wheel mounting bracket pin (**Figure 1**).

Important information such as the product serial and model number, are listed on the Identification tag (**Figure 2**). Record these numbers for future quick reference.

Figure 1

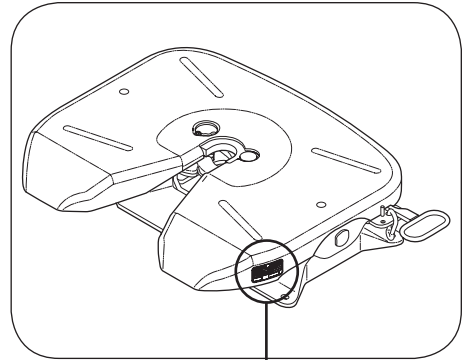
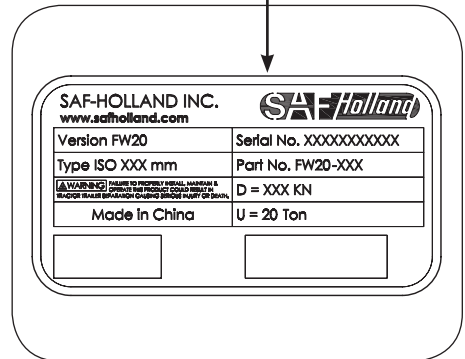


Figure 2



2. General Safety Instructions

IMPORTANT: You **MUST** read and understand all of the procedures presented in this manual before starting the process of installing a HOLLAND® fifth wheel.

IMPORTANT: Keep this manual in a safe location for future reference.

IMPORTANT: All fifth wheel installation **MUST** be performed by a qualified technician using proper tools and safe procedures.

IMPORTANT: We highly recommend the use of only SAF-HOLLAND® Original Parts.

NOTE: In the United States, workshop safety requirements are defined by federal and/or state Occupational Safety and Health Act. Equivalent laws may 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.

⚠️ WARNING Failure to follow all of the installation procedures contained in this manual could cause a hazardous condition to develop which, if not avoided, could result in death or serious injury.

IMPORTANT: Prior to operation of the fifth wheel you must be thoroughly satisfied that the fifth wheel has been properly installed on the vehicle.

⚠️ WARNING Failure to properly install the fifth wheel could result in tractor-trailer separation which, if not avoided, could result in death or serious injury.

3. General Installation Recommendations

- Before installing your HOLLAND® fifth wheel, be sure to review the model number specified on the product identification tag, and confirm that the specification meets the desired vehicle requirements.

- Consult the HOLLAND® Fifth Wheel Catalog and Specification Guide for fifth wheel capacities and applications.

The technician installing a SAF-HOLLAND® product must be confident that the installation procedure used is appropriate for the vehicle, product and application.

- Consult ISO 3842, Directive 94/20/EL of the European Parliament and of the Council and GB/T/20070 National standard of P.R.C. for local and regulatory standards installation requirements.

- Consult the tractor manufacturer's body builder book, the latest SAE and D.O.T. standards, and the T.M.C. Practice 603 B for installation procedures.

- Determine the proper fifth wheel position. Proper positioning of the fifth wheel is important for weight distribution, swing clearance, articulation, and handling characteristics of the vehicle. Consult SAEJ701 and the tractor manufacturer's body builder book/vehicle requirements.

- The fifth wheel **MUST** be installed ahead of the rear axle centerline and/or bogie centerline (**Figure 3**).

⚠️ WARNING Failure to do so can adversely affect steering stability potentially causing the driver to lose control of the vehicle which, if not avoided, could result in death or serious injury.

IMPORTANT: **DO NOT** use U-bolts in fifth wheel installations.

⚠️ WARNING The use of U-bolts in fifth wheel installations could result in catastrophic failure of the fifth wheel assembly, which if not avoided, could result in death or serious injury.

- Trailer pick-up ramps are recommended at the rear of the tractor frame.
- When mounting to aluminum frames, follow the tractor manufacturer's recommendations. SAF-HOLLAND® has available a stationary mounting angle intended for use with aluminum frames. Contact SAF-HOLLAND® or distributors of HOLLAND® brand products for availability.

4. Mounting Angle Selection

Outboard ISO Stationary

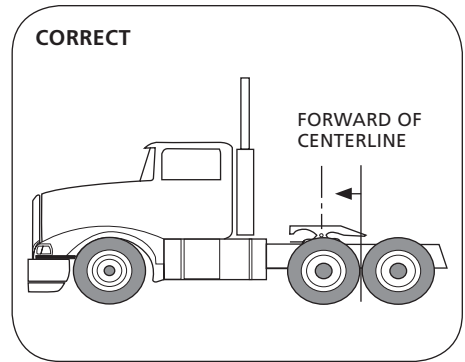
For convenience and ease of installation, some HOLLAND® fifth wheels are manufactured without mounting angles attached. The following are recommendations on how to select and prepare your mounting angles for installation:

- Minimum recommended thickness listed in **Table 1** below and comprised of steel specification ASTM A36 or ASTM A588.
- Minimum Horizontal leg size of 3" (76 mm).
- Minimum vertical leg size of 3-1/2" (89 mm).
- The minimum angle length **MUST** be equal to or longer than the length of the fifth wheel mounting base, and not less than 36" (914 mm) in total length.

Table 1

Fifth Wheel	Minimum Mounting Angle Thickness
FW20	3/8" (10 mm)
FW28	1/2" (12 mm)

Figure 3



5. Mounting Angle Preparation

For ease of installation, it may be beneficial to transfer geometric information such as cutouts and mounting hole locations from the vehicle frame to the mounting angle. SAF-HOLLAND® recommends using the following sequence:

1. Securely position the mounting angle and fifth wheel mounting base to the tractor frame in the appropriate position for mounting the fifth wheel to the vehicle.
2. Clamp the assembly in place and use the fifth wheel mounting plate as a template to transfer the mounting hole location (**Figure 4**).

The fifth wheel **MUST** be installed ahead of the rear axle centerline and/or bogie centerline (**Figure 5**).

⚠ WARNING Failure to mount the fifth wheel ahead of the rear axle centerline and/or bogie centerline can adversely affect steering stability potentially causing the driver to lose control of the vehicle which, if not avoided, could result in death or serious injury.

IMPORTANT: When initially positioning the mounting angles, the full length of the mounting angles should seat flush with the top and side surfaces of the tractor frame rails to prevent flexing of the mounting angle and to give uniform weight distribution along the truck rail (**Figure 4**).

Figure 4

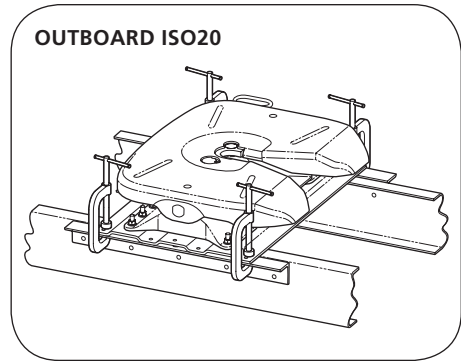
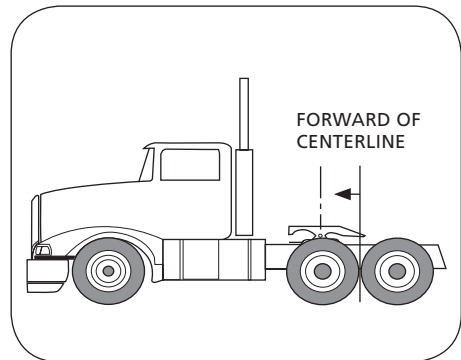


Figure 5



3. Transfer geometric information from the vehicle such as the mounting hole locations and where cut outs are necessary for assembly.
 - Mounting holes should be 21/32" (16.75 mm) in diameter. To accommodate 5/8" (16 mm) mounting bolts.
 - Mounting bolts should be located no closer than 1" (25 mm) from the bottom of the mounting angle to the center of the bolt hole.
 - A minimum of five (5) bolts are required to attach each fifth wheel mounting angle to the tractor frame rail.
 - The distance between mounting bolts should not exceed 8" (203 mm) except where cutouts are required in the mounting angle.
 - Whenever a cutout is made on the mounting angle, such as required to bypass spring hangers, a 1" (25 mm) minimum radius should be used in the cutout.
 - Mounting bolts should be placed within 1-1/2" (38 mm), but no closer than 1" (25mm) of the cutout, before and after.
 - Bolt holes MUST be located within 4" (102 mm) from the ends of the mounting angle.

⚠ WARNING Failure to properly locate bolt holes could result in catastrophic failure of the fifth wheel assembly, which if not avoided, could result in death or serious injury.

4. Machine the Mounting Angle.

IMPORTANT: Be sure to break/smooth all sharp edges, corners, and machining marks.

IMPORTANT: Chamfer and smooth sharp edges and corners of the mounting angle where contact is made with the tractor frame.

6. Mounting Plate Preparation

HOLLAND® outboard stationary ISO mount and foot mount fifth wheels are intended to be installed with a corrugated or flat mounting plate:

Example Part Numbers:

- FWXX-185
- FWXX-150

NOTE: HOLLAND® corrugated mounting plates can be purchased from SAF-HOLLAND® by contacting Customer Service at:
 ■ 1.888.396.6501
 ■ +86.592.6388.891

Recommended mounting plate thickness is determined by the vertical capacity of the specific model fifth wheel being used.

Mounting plates are to be comprised of steel specification ASTM A36 or ASTM A572 Gr. 50.

NOTE: All bracket contact surfaces on all mounting plates MUST be flat within .060" (1.5 mm).

Refer to **Table 2** below for the minimum recommended thickness.

Table 2

Fifth Wheel	Minimum Mounting Plate Thickness
FW20	3/8" (10 mm)
FW28	1/2" (12 mm)

7. Attaching Mounting Angles to the Tractor Frame

The following is required to properly secure mounting angles to the tractor frame:

- New 5/8" SAE Grade 8 or 16 mm ISO Grade 10.9 minimum diameter bolts.
- New SAE Grade "C" lock nuts.
- New hardened steel washers for use under both the bolt and the lock washer.

WARNING Failure to comply to specified fastener recommendations could result in catastrophic failure of the fifth wheel assembly, which if not avoided, could result in death or serious injury.

1. Securely attach the mounting angles flush with the top of the tractor frame with the specified fasteners (**Figure 6**). Follow the bolting recommendations sequence (**Figure 7**). A minimum of five (5) fasteners are required to attach each mounting angle to the tractor frame rail.

CAUTION Failure to attach angles flush with top of the tractor frame could result in a potentially hazardous situation which, if not avoided, could result in property damage.

2. Torque fasteners to manufacturer's specifications using the recommended sequence (**Figure 7**).

NOTE: Tighten the center fastener first, then using an alternating pattern, tighten the fasteners on either side working from center outward.

Figure 6

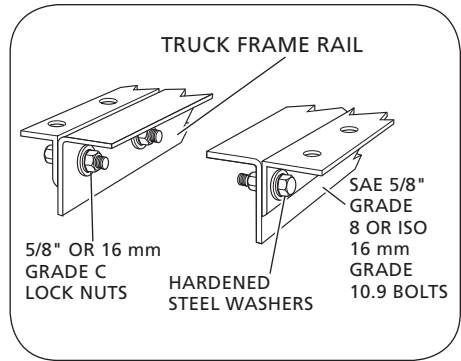
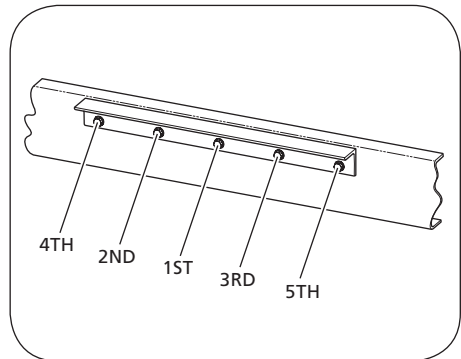


Figure 7



8. Attaching Fifth Wheel to the Tractor Frame

The following are recommendations on how to properly secure the fifth wheel to the tractor frame:

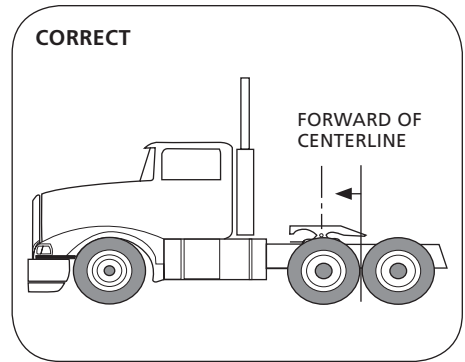
- Use only new 5/8" SAE Grade 8 or 16 mm ISO Grade 10.9 minimum diameter bolts.
- Use only new SAE Grade "C" lock nuts.
- Bolts attaching the fifth wheel assembly to the outboard mounting angles require hardened steel washers under both the bolt and the lock nut.
- Bolts attaching the fifth wheel assembly to the mounting plate require hardened steel washers that are a minimum of 6 mm thick and 40 mm O.D. under both the bolt and lock nut.

⚠ WARNING Failure to comply to specified fastener recommendations could result in catastrophic failure of the fifth wheel assembly, which if not avoided, could result in death or serious injury.

The fifth wheel **MUST** be installed ahead of the rear axle centerline and/or bogie centerline (**Figure 8**).

⚠ WARNING Failure to mount the fifth wheel ahead of the rear axle centerline and/or bogie centerline can adversely affect steering stability potentially causing the driver to lose control of the vehicle which, if not avoided, could result in death or serious injury.

Figure 8



Mounting Procedures

1. Securely fasten all mounting holes in the mounting plate to the fifth wheel assembly (**Figure 9**). A minimum of twelve (12) fasteners are required to attach the mounting plate to the fifth wheel assembly.

WARNING Failure to fasten all mounting holes in the mounting plate could result in catastrophic failure of the fifth wheel assembly which, if not avoided, could result in death or serious injury.

2. Torque fasteners to manufacturer's recommendations.
3. Place fifth wheel and mounting plate on mounting angle. Align the holes in the fifth wheel mounting plate with the outboard angle mounting holes.
4. Securely fasten all the mounting holes in the fifth wheel to the mounting angle (**Figure 10**). A minimum of ten (10) fasteners, five (5) on each side, are required to attach the fifth wheel mount to each angle.

WARNING Failure to fasten all the mounting holes in the fifth wheel to the mounting angle could result in catastrophic failure of the fifth wheel assembly, which if not avoided, could result in death or serious injury.

5. Torque fasteners to manufacturer's specifications using the recommended sequence (**Figure 10**).

NOTE: Tighten the center fastener first, then using an alternating pattern, tighten the fasteners on either side working from center outward.

Figure 9

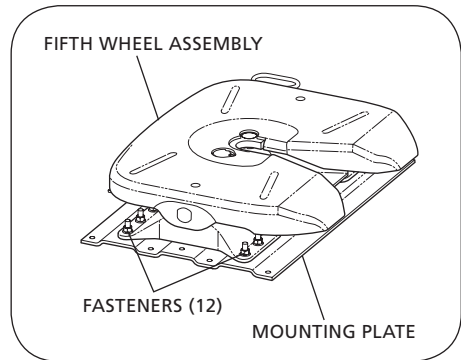
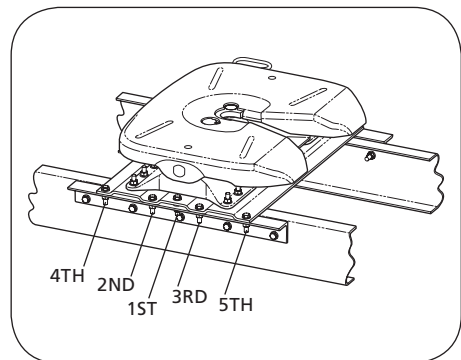


Figure 10





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