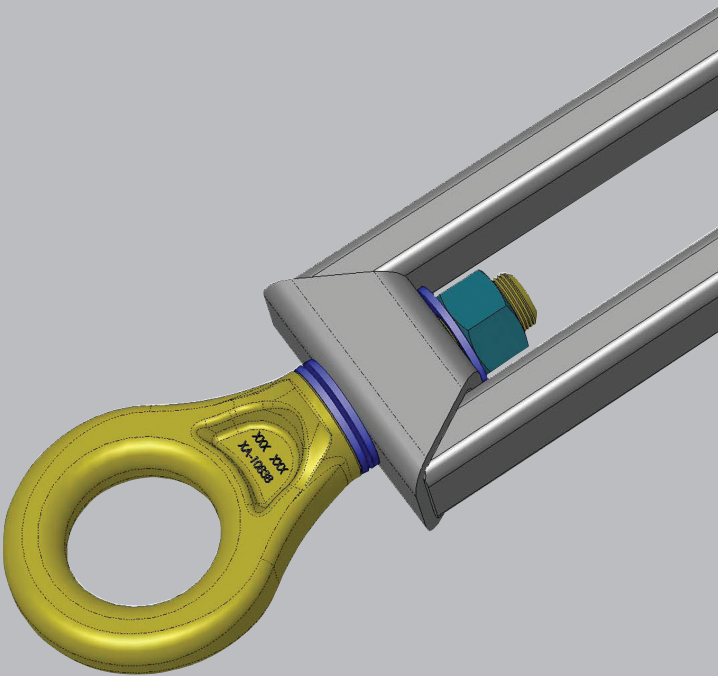


Rebuild/Repair Manual

Towbar Eye
RK-TB20PKS



Introduction

This manual provides the information necessary for the proper rebuild/repair of the Holland RK-TB20PKS Replacement Towbar Eye.

NOTE: For Holland replacement components contact SAF-HOLLAND Customer Service: 1-888-396-6501.

Notes, Cautions, and Warnings

You must read and understand all of the procedures presented in this manual before operating or starting work on any Holland product.

NOTE: In the United States, work shop safety requirements are defined by federal and/or state Occupational Safety and Health Acts. 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.

Proper tools must be used to perform the maintenance and repair procedures described in this manual.

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, 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.

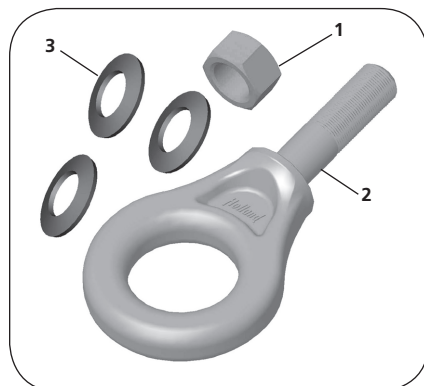
1. Supplied Parts and Required Tools

The RK-TB20PKS kit contains the parts listed in the chart below (**Figure 1**). You will need access to basic tools for removing and installing the eye such as permanent Loctite® and a grinder. Access to a MIG welder is preferred for the new installation but is not required.

RK-TB20PKS Kit Contents

ITEM	DESCRIPTION	PART #	QTY.
1	1"-14 Lock Nut	93400503	1
2	Towbar Eye, Yellow	XA-10838-11	1
3	Belleville Washers	XA-11318	3

Figure 1



2. Removal of existing Towbar Eye

1. Remove the old towbar eye, nut, and washers by either cutting off the front of the eye, or removing the nut by grinding off the weld holding it to the towbar eye. Discard the existing towbar eye, washers, and nut. Do not reuse.

IMPORTANT: Make sure you do not damage the towbar when removing the eye. If damage occurs, discard and replace.

2. Visually inspect the towbar front tube to see if it is bent or cracked.

3. Installation Instructions

NOTE: The convex face of a Belleville washer is the side that has the elevated center when the outside edge of the washer is placed flat on a table.

1. Place two (2) of the Belleville washers onto the threaded shank of the towbar eye. Belleville washers have a concave face and a convex face. The convex faces are placed towards each other and the concave faces against the towbar eye and front tube (**Figure 2**).
2. Insert the towbar eye with the two Belleville washers through the hole in the front tube.
3. Install the third Belleville washer onto the threaded shank of the towbar eye behind the front tube (**Figure 2**). Place the concave face of the washer against the front tube.
4. Place a line of permanent Loctite® on the towbar threads, approximately 1/2" (13mm) long (**Figure 3**).

Figure 2

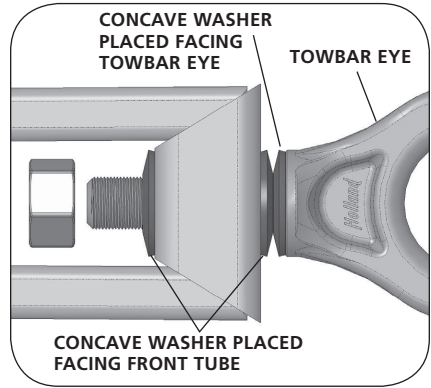
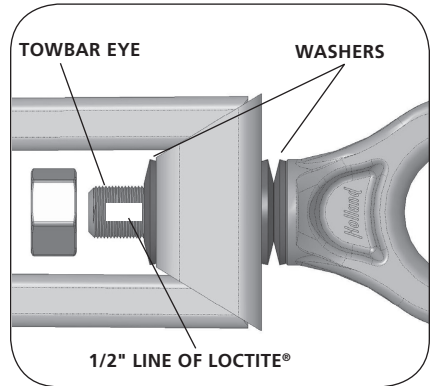
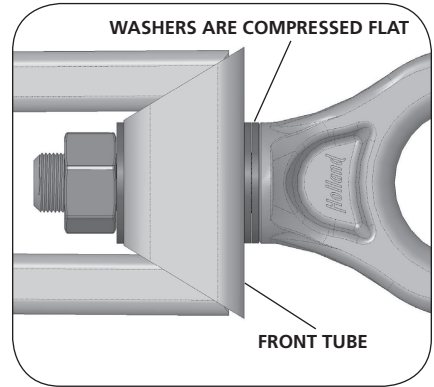


Figure 3



5. Install the lock nut keeping the towbar eye parallel to the ground. Tighten the lock nut until all three (3) Belleville washers are compressed flat (**Figure 4**). Torque the lock nut to 150 to 200 ft.-lbs. (203 - 271 N•m).
6. Verify the towbar eye is parallel to the ground. It can be rotated with the aid of a large lever if it moved during final installation of the lock nut. Re-verify proper torque of the lock nut if towbar eye was rotated.

Figure 4

7. Add a 3/16" (5mm) spot weld between the towbar eye and the lock nut (**Figure 5**). As an alternative to welding, deform the threads on the towbar eye with a hammer and punch (**Figure 6**). Deform a minimum of three (3) threads in four (4) places directly against the lock nut.

Figure 5

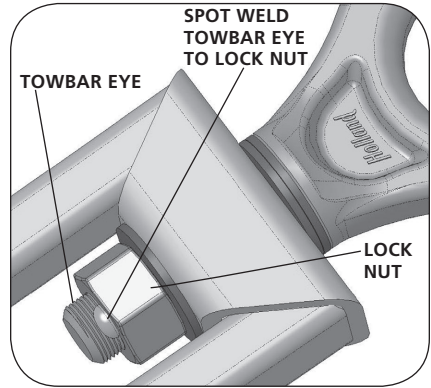
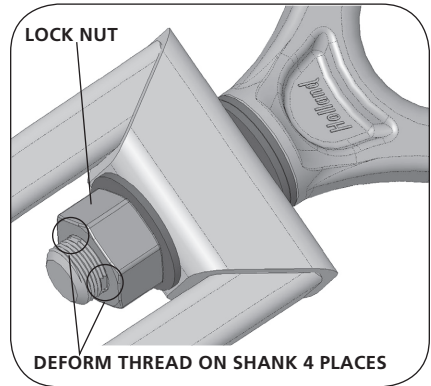


Figure 6





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.

SAF-HOLLAND USA • 888.396.6501 • Fax 800.356.3929
www.safholland.us

SAF-HOLLAND CANADA • 519.537.3494 • Fax 800.565.7753
WESTERN CANADA • 604.574.7491 • Fax 604.574.0244
www.safholland.ca

SAF-HOLLAND MEXICO • 52.1.55.5456.8641 • Fax 52.55.58162230
www.safholland.com.mx

info@safholland.com

SAF-HOLLAND USA, INC.
1950 Industrial Blvd, Muskegon, MI 49443
www.safholland.com

