



Timothy A. Blubaugh
Director
Government Technical Affairs

Freightliner LLC
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April 18, 2006

Dan Smith
Associate Administrator for Vehicle Safety
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, D.C. 20590

**Re: Defect Information Report – supplemental information
(FL-453), NHTSA no. 05V-284, Holland AD Rear Suspension**

Mr. Smith:

In accordance with Part 573 of Title 49 of the Code of Federal Regulations, Freightliner LLC herewith submits supplemental defect information and copies of documents to be distributed to dealers and purchasers.

Please contact me if you have any questions.

Sincerely yours,

Timothy Blubaugh

Cc: Michael Mason, CAL-OSHA
DOSH, Legal Unit
10th Floor
455 Golden Gate Avenue
San Francisco, CA 94102

Enclosure

Certified Mail Article Number: 7002 2260 0001 8403 7452

Section 573.6 Defect Information Report
FL-453, Holland AD Suspension; NHTSA no. 05V0284
Supplement No.: 01

April 18, 2006

(c) (1) Manufacturer: FREIGHTLINER LLC

P.O. BOX 3849
Portland, Oregon 97208
(503) 745-5219

(c)(2) Vehicles identification:

Model(s) Affected:

Freightliner - Argosy, Business Class M2, Century S/T, Classic, Columbia, Condor, FLD
Western Star - 4900 and 6900

American LaFrance - Eagle and Metropolitan

Thomas Built Buses - HDX

Model Years: 2004 and 2005

Manufacture Dates: between January 6, 2004 and February 1, 2005,

Basis for Determining Population: Vehicles manufactured with Holland Neway AD-123, AD-124, AD-126, AD-127, AD-246, AD-248, AD-252, AD-254, AD-369, and AD-378 rear suspensions

Component manufacturer if other than the vehicle manufacturer:

Holland USA, Inc.
1950 Industrial Blvd.
Muskegon, MI 49443-0425
Phone 616/396-6501

(c) (3) Total number of vehicles potentially affected: (Revise to read) 369

(c) (9) Communications sent to dealers:

Freightliner – attached, posted for dealers April 8, 2006

Thomas Built Buses – attached, sent January 27, 2006

Communications sent to owners:

Freightliner - attached, mailed April 14, 2006

Thomas Built Buses – attached, mailed February 10, 2006

Subject: Holland AD Series Transverse Beam End Castings

Models Affected: Specific Freightliner Argosy, Business Class M2, Century S/T, Classic, Columbia, Condor, FLD vehicles; Western Star 4900 and 6900 vehicles; and American LaFrance Eagle and Metropolitan vehicles manufactured between January 6, 2004, and February 1, 2005, with certain Holland AD Series rear suspensions.

General Information

Freightliner LLC, on behalf of its Freightliner Trucks Division and American LaFrance, has decided that a defect which relates to motor vehicle safety exists on the vehicles mentioned above.

There are approximately 300 vehicles involved in this campaign.

The transverse beam end castings on certain Holland AD rear suspensions may not have been manufactured to the correct material specification and could fracture under normal loads. Should this happen, the transverse beam could drop low enough to contact the road surface, generating sparks that could cause a fire or pieces of the end casting could create a hazard for people or other vehicles on the road.

The transverse beam assemblies containing the defective end castings will be replaced. **IMPORTANT: This is a small recall with many vehicles outside the U.S. and Canada. Please do not over-order kits.**

Additional Repairs

Dealers must complete all outstanding recall and field service campaigns prior to the sale or delivery of a vehicle. A Dealer will be liable for any progressive damage that results from its failure to complete campaigns before sale or delivery of a vehicle.

Owners may be liable for any progressive damage that results from its failure to complete campaigns within a reasonable time after receiving notification.

Work Instructions

Please refer to the attached work instructions. Prior to performing the campaign, check the vehicle for a completion sticker (Form WAR260).

Replacement Parts

Replacement kits are now available and can be obtained by ordering the kit number(s) listed below from your facing Parts Distribution Center.

If our records show your dealership has ordered any vehicles involved in campaign number FL453A, a list of the customers and vehicle identification numbers will be available on AccessFreightliner.com. Please refer to this list when ordering parts for this recall.

IMPORTANT: This is a small recall with many vehicles outside the U.S. and Canada. Please do not over-order kits.

Recall Campaign

April 2006
 FL453A-F
 NHTSA #05V-284

Vehicles in this recall may need 1, 2, or 3 kits. The number of kits needed for vehicles in each of the condition codes is as follows:

- FL453A - 52 vehicles - use 2 kits per vehicle (25-FL453-000)
- FL453B - 5 vehicles - use 1 kit per vehicle (25-FL453-000)
- FL453C - 1 vehicle - use 3 kits per vehicle (25-FL453-000)
- FL453D - 55 vehicles - use 2 kits per vehicle (25-FL453-001)
- FL453E - 22 vehicles - use 1 kit per vehicle (25-FL453-001)
- FL453F - 21 vehicles - use 3 kits per vehicle (25-FL453-001)

Table 1 - Replacement Kits for FL453A-F

Campaign Number	Kit Number	Part Description	Part Number	Qty.	Suggested Wholesale*
FL453A - Use 2 kits per vehicle FL453B - Use 1 kit per vehicle FL453C - Use 3 kits per vehicle	25-FL453-000	Transverse Beam Assembly and Fastener Kit	Holland Kit #48100469	1 kit	\$634.51 U.S. \$923.44 CAN
Completion Sticker (WAR260)			1 ea		
FL453D - Use 2 kits per vehicle FL453E - Use 1 kit per vehicle FL453F - Use 3 kits per vehicle	25-FL453-001	Transverse Beam Assembly and Fastener Kit	Holland Kit #48100470	1 kit	\$634.51 U.S. \$923.44 CAN
Completion Sticker (WAR260)			1 ea		

* Please charge all Direct Warranty Customers the above-listed price for the kit, as they are authorized to perform their own Recalls.

Table 1

Removed Parts

Please follow Warranty Failed Parts Tracking shipping instructions for the disposition of all removed parts.

Labor Allowance

Table 2 - Labor Allowance

Campaign Number	Procedure	Time Allowed (hours)	SRT Code	Damage Code
FL453A-F	Remove and replace one transverse beam assembly (Enter once for each kit installed)	1.5	996-0666A	000-Modifiedx
FL453A-F	Destroy one to three removed beams (Enter once per vehicle)	0.5	996-0666B	000-Modifiedx

Table 2

IMPORTANT: When the recall has been completed, locate the base completion label in the appropriate location on the vehicle, and attach the red completion sticker provided in the recall kit (Form WAR260). If the vehicle does not have a base completion label, clean a spot on the appropriate location of the vehicle and first attach the base completion label (Form WAR259). If a recall kit is not required or there is no completion sticker in the kit, write the recall number on a blank sticker and attach it to the base completion label.

Claims for Credit

You will be reimbursed for your parts, labor, and handling by submitting your claim through the Warranty system within 30 days of completing this campaign. Please reference the following information in QuickClaim[®]:

- Claim type is **Recall**.
- In the FTL Authorization field, enter the campaign number and appropriate condition code (e.g. **FL453A, FL453B, etc.**).
- In the Primary Failed Part Number field, enter **25-FL453-000**.
- In the Parts field, enter the appropriate kit number(s) as shown in the Replacement Parts Table. **IMPORTANT:** This is a small recall with many vehicles outside the U.S. and Canada. Please do not over-order kits.
- **IMPORTANT: Removed transverse beams must be destroyed and disposed of so that they cannot be used on another vehicle. Take digital photos of all destroyed beams and keep them on file. Be prepared to provide them upon request.**
- In the Labor field, first enter the appropriate SRT from the Labor Allowance Table. For administrative time, enter SRT 939-0010A for 0.3 hours.
- **T-Beam Painting** When required, the new T-beams may be painted to match the chassis. (Most beams do not need to be color matched.) The painting allowance is \$65.00 U.S./\$75.00 CAN. To include this on your recall claim:
 - Submit a ticket to Warranty Campaigns requesting this. (The color of the new T-beams and the chassis must be significantly different.)
 - You will be asked to email digital photos illustrating the need for painting to WarrantyCampaigns@Freightliner.com.
 - When approved, you will be given an authorization number for the Comments section of your claim.
 - You will list the approved painting allowance in the "Other Charges Claimed" section of your claim.

NOTE: ServicePro[®]/Service Advisor[®] must be viewed prior to performing the recall to ensure the vehicle is involved and the campaign has not been previously completed. Also, check for a completion sticker prior to beginning work.

Contact the Warranty Campaigns Department at (800) 547-0712, from 7:00 a.m. to 4:00 p.m. Pacific Time, Monday through Friday, Web inquiry at AccessFreightliner.com / Support / Submit an Inquiry, or the Customer Assistance Center at (800) 385-4357, after normal business hours, if you have any questions or need additional information.

To return excess kit inventory related to this campaign, U.S. dealers must submit a Parts Authorization Return (PAR) to the Memphis PDC. Canadian dealers must submit a PAR to their facing PDC. All kits must be in resalable condition. PAR requests must include the original purchase invoice number.

The letter notifying vehicle owners is included for your reference.

Please note that the National Traffic and Motor Vehicle Safety Act, as amended (Title 49, United States Code, Chapter 301), requires the owner's vehicle(s) be corrected within a reasonable time after parts are available to you. The Act states that failure to repair a vehicle within 60 days after tender for repair shall be prima facie evidence of an unreasonable time. However, circumstances of a particular situation may reduce the 60 day period. Failure to repair a vehicle within a reasonable time can result in either the obligation to (a) replace the vehicle with an identical or reasonably equivalent vehicle, without charge, or (b) refund the purchase price in full, less a reasonable allowance for depreciation. The Act further prohibits dealers from selling a vehicle unless all outstanding recalls are performed. Also, any lessor is required to send a copy of the recall notification to the lessee.

Finally, the Act states that a remedy need not be provided without charge if the vehicle was bought by the first purchaser more than ten (10) calendar years before notice is given.

Recall Campaign



April 2006
FL453A-F
NHTSA #05V-284

Copy of Letter to Owner

Subject: Holland AD Series Transverse Beam End Castings

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act. This notice is also sent in accordance with the Canadian Motor Vehicles Safety Act.

Freightliner LLC, on behalf of its Freightliner Trucks Division and American LaFrance, has decided that a defect which relates to motor vehicle safety exists on specific Freightliner Argosy, Business Class M2, Century S/T, Classic, Columbia, Condor, FLD vehicles; Western Star 4900 and 6900 vehicles; and American LaFrance Eagle and Metropolitan vehicles manufactured between January 6, 2004, and February 1, 2005, with certain Holland AD Series rear suspensions.

The transverse beam end castings on certain Holland AD rear suspensions may not have been manufactured to the correct material specification and could fracture under normal loads. Should this happen, the transverse beam could drop low enough to contact the road surface, generating sparks that could cause a fire or pieces of the end casting could create a hazard for people or other vehicles on the road.

The transverse beam assemblies containing the defective end castings will be replaced.

Repair kits are now available for authorized dealers to order. Contact your authorized dealer to arrange to have your vehicle(s) modified and to assure that parts are available at the dealer. To locate a dealer, search online at www.FreightlinerTrucks.com, WesternStarTrucks.com, or contact the Warranty Campaigns Department for assistance.

When you contact your dealer, refer to campaign number **FL453A-F**. Once kit(s) are received at the dealership, the modification will take between approximately three hours and a full day, depending on the work needed, and will be performed at no charge to you.

IMPORTANT: When the recall has been completed, please ensure that a label has been affixed to your vehicle referencing **FL453A-F**.

If you do not own the vehicle that corresponds to the identification number(s) which appears on the Recall Notification, please return the notification to the Warranty Campaigns Department with any information you can furnish that will assist us in locating the present owner. If you have leased this vehicle, please make sure this notification is immediately forwarded to the lessee.

If you are not able to have the defect remedied without charge and within a reasonable time, which is not longer than 60 days after you tender the vehicle for repair, please contact the Warranty Campaigns Department at (800) 547-0712, 7:00 a.m. to 4:00 p.m. Pacific Time, Monday through Friday, e-mail address WarrantyCampaigns@freightliner.com, or the Customer Assistance Center at (800) FTL-HELP or (800) STL-HELP, after normal business hours. You may also wish to submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 7th Street S.W., Washington, D.C. 20590; or call the Vehicle Safety Hotline at (888) 327-4236 (TTY: 800-424-9153); or to <http://www.safercar.gov>. If your vehicle is involved in the Canadian portion, you may wish to notify Transport Canada, ASFAD, Place de Ville Tower C, 330 Sparks Street, Ottawa, ON K1A 0N5, or phone (800) 333-0510.

We regret any inconvenience this action may cause but feel certain you understand our interest in motor vehicle safety.

WARRANTY CAMPAIGNS DEPARTMENT

Enclosure

Work Instructions

Subject: Holland AD Series Transverse Beam End Castings

Models Affected: Specific Freightliner Argosy, Business Class M2, Century S/T, Classic, Columbia, Condor, FLD vehicles; Western Star 4900 and 6900 vehicles; and American LaFrance Eagle and Metropolitan vehicles manufactured between January 6, 2004, and February 1, 2005, with certain Holland AD Series rear suspensions.

IMPORTANT: Removed transverse beams must be destroyed and disposed so that they cannot be used on another vehicle. Take digital photos of all destroyed beams and keep them on file. Be prepared to provide them upon request.

IMPORTANT: This is a small recall with many vehicles outside the U.S. and Canada. Please do not over-order kits.

Vehicles in this recall may need 1, 2, or 3 kits. The number of kits needed for vehicles in each of the condition codes is as follows:

- FL453A - 52 vehicles - use 2 kits per vehicle (25-FL453-000)
- FL453B - 5 vehicles - use 1 kit per vehicle (25-FL453-000)
- FL453C - 1 vehicle - use 3 kits per vehicle (25-FL453-000)
- FL453D - 55 vehicles - use 2 kits per vehicle (25-FL453-001)
- FL453E - 22 vehicles - use 1 kit per vehicle (25-FL453-001)
- FL453F - 21 vehicles - use 3 kits per vehicle (25-FL453-001)

Transverse Beam Replacement Procedure

1. Check the base label (Form WAR259) for a completion sticker for FL453 (Form WAR260) indicating this work has been done. The base label is usually located on the passenger-side door about 12 inches (30 cm) below the door latch. If a completion sticker is present, no further work is needed. If there is no completion sticker, go to the next step.
2. Park the vehicle on a level surface. Shut down the engine, set the parking brake, and chock the tires.

WARNING

Always use jack stands of sufficient strength. Failure to do so may cause the vehicle to fall, resulting in personal injury and/or vehicle damage.

NOTE: The height control valves can be used to raise the vehicle.

3. Raise the vehicle frame two inches above its standard ride height and support it with adequate jack stands.
4. Exhaust the air from the air springs and air system using the manual dump valve (if the vehicle is so equipped) or by using the height control valve(s). To exhaust the air using the height control valves, disconnect the valve linkage at the lower connection and rotate the valve control arms down to the air exhaust position.
5. If not already done, disconnect the height control valve(s) linkage at the transverse beam connection.
6. Remove the nuts and washers located under the lower air spring mounting plates and remove the air springs from the lower air spring mounting plates. See Fig. 1. Save the fasteners.

Recall Campaign

April 2006
 FL453A-F
 NHTSA #05V-284

7. Clean the transverse beam fasteners and the equalizer beam pin shafts prior to disassembly to help protect the threads. **Give special attention to the space between the lower flat surface of the pin shaft and the heavy hexnut threads.** A piece of wire can be used to help loosen trapped dirt and debris. See **Fig. 2**.

NOTE: Do not use an impact wrench to remove or install the heavy hexnuts.

8. Bend the locking tab out of the way, then remove the heavy hexnut from the end of each equalizing beam. See **Fig. 1**. Then remove and discard the tab washers, and the locking spacer assemblies.

NOTE: Be sure to note the orientation of the linkage tabs welded to the top of the transverse beam. See **Fig. 3**. You will need to orient the replacement transverse beam so that the tabs are in the same positions as the original.

9. Remove the transverse beam from the pin shafts.

10. If the transverse beam bushings remain on the pin shaft, use a screwdriver or small chisel to separate the metal bushing core. This bushing is a split design to facilitate removal.

11. Remove the large spacer washers located behind the transverse beam ends. Save the spacer washers for installation.

NOTE: The pin shafts and their threads are Dacromet-coated during manufacturing. Dacromet is a hard, silver-colored coating that protects the pin shafts from rust. Most of the pin shafts are also painted. This paint serves no purpose and is only there due to the paint dip process. Paint that is scratched, chipped, or removed is of no concern since the underlying Dacromet coating is the primary protection for the pin shaft.

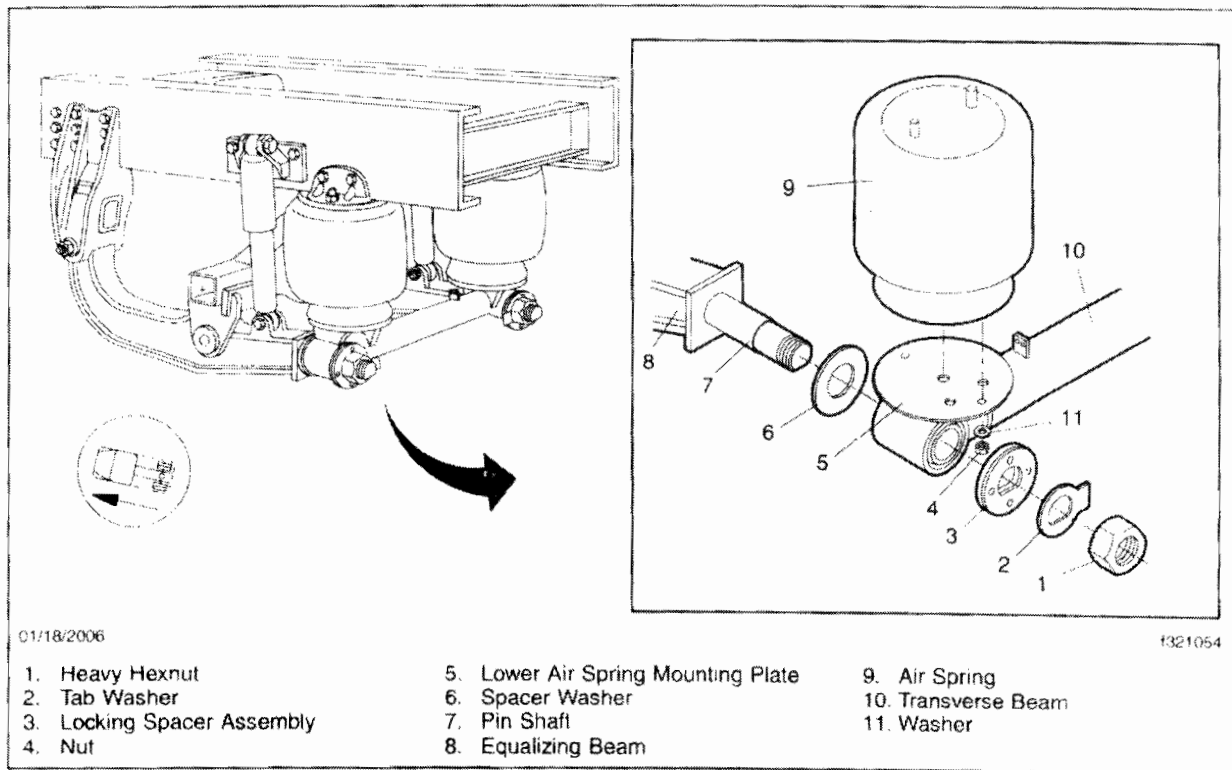


Fig. 1. Holland Neway Ad Series Suspension Assembly

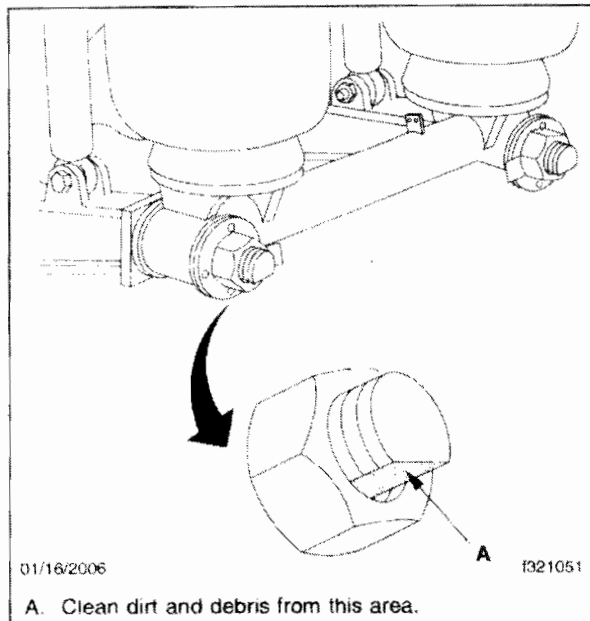


Fig. 2, Pin Shaft (detail)

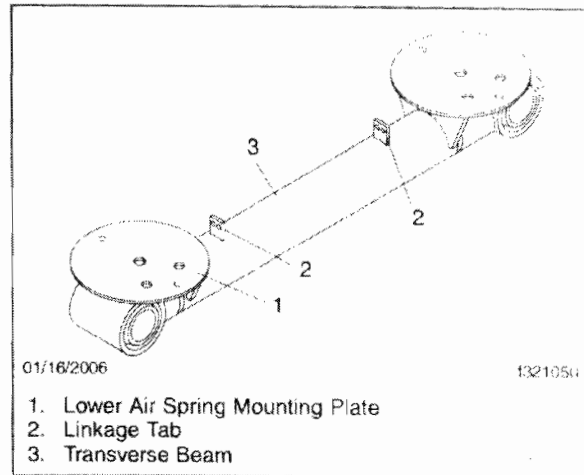


Fig. 3, Note Tab Orientation Before Removal

12. Clean the exposed pin shafts; remove any rust left behind from the metal bushing cores and any other dirt and debris.
 13. Install the spacer washers on the pin shafts.
- NOTE:** The replacement transverse beam already has new bushings pressed into the ends.
14. Verify the orientation of the linkage tabs and install the replacement transverse beam over the pin shafts. See **Fig. 1**.
 15. Make sure that the pin shaft threads are clean, then install a new locking spacer assembly, tab washer, and hexnut on each pin shaft.
- IMPORTANT:** Do not use an air impact wrench for applying final torque to the connection. Use a torque wrench of the appropriate capacity.
16. Tighten the heavy hexnuts to 550 lbf ft (745 N·m).
 17. Bend the tab portion of each tab washer over the hexnut.
 18. Attach the air springs to the lower air spring mounting plate using the washer and nut removed earlier. Tighten the nut to 30 lbf ft (40 N·m). If the air spring has more than one mounting stud protruding through the mounting plate, install the washer and nut on the rearmost stud only.
 19. If applicable, connect the height control valve linkages to the tabs on the transverse beam.
 20. Remove the jackstands.
 21. Start the engine and allow the air system to build to normal operating pressure, then check for proper ride height.

NOTE: Realignment of the axle is not required after replacing the transverse beam.

Recall Campaign



April 2006
FL453A-F
NHTSA #05V-284

22. Clean a spot on the base label (Form WAR259). The base label is usually located on the passenger-side door about 12 inches (30 cm) below the door latch. Attach a completion sticker (Form WAR260) for Recall FL453 to the base label.

23. Remove the chocks from the tires.

NOTE: When required, the new T-beams may be painted to match the chassis. (Most beams don't need to be color matched.) The painting allowance is \$65.00 U.S./\$75.00 CAN. See the "Claims for Credit" section of this bulletin for instructions.



A Subsidiary of **FREIGHTLINER**
CORPORATION

Product Recall

To: ALL DEALERS

From: TRACY SAUERBREY - CUSTOMER SUPPORT DIVISION

Subject: RECALL 05V-284 Transverse Beam Replacement

Date: January 27, 2006

Enclosed are copies of the customer notification letter and the repair procedure for Recall 05V-284. This recall involves certain Thomas units manufactured from January 2004 through December 2004 with certain Holland suspensions. Some of the transverse beam castings were not made to specification and may fracture under normal loads.

This is a universal notification sent to all dealers. You may or may not have customers in your area affected by this recall. If owners in your area are subject to this recall, we have enclosed a printout listing those customers' names and addresses. If there is not a printout enclosed according to our records there are no units in your area involved. **If you have a printout and any of the units on it are still in your possession it is your responsibility to ensure the recall is performed before the unit is delivered to the customer.**

The repair will consist of replacing the transverse beam assemblies. The labor allowance for this repair is 1.5 hours per unit (FI at Rate Code 90-51). **You will need to order your repair kit directly from the Parts Distribution Center. The repair kit number is 85490065. You must return the defective beams to Holland.**

Thomas Built Buses has elected to notify all customers directly. Your customers will be contacting you to schedule an appointment for repairs. Reimbursement for parts and labor (if requested) may be obtained by filing a warranty claim.

If you know of any customers who own or operate a Thomas bus in this recall, whose name and address is NOT listed or is INCORRECTLY listed on the enclosed printout, please promptly notify Thomas Built Buses of that additional information in writing. Thank you for your cooperation and assistance.

Tracy



A Subsidiary of FRETCHLINER LLC

Thomas Built Buses, Inc.
PO Box 2452 (24261)
1408 Quaker Hollow
High Point, NC 27269
(336) 889-1871 Phone
(336) 889-9589 Fax

February 10, 2006

Recall 05V-284

Dear Thomas Bus Owner,

This notice is sent to you in accordance with the requirements of the National Traffic and Motor Vehicle Safety Act. Based on information provided by Holland USA, Thomas Built Buses, Inc. has decided that a defect, which relates to motor vehicle safety, exists in the vehicle identified on the enclosed postcard (Form PSD 304).

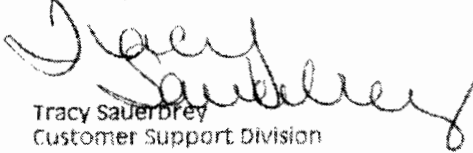
This recall involves certain Thomas Built units manufactured from January 2004 through December 2004 with certain Holland suspensions. Some of the transverse beam castings were not made to specification and may fracture under normal loads. If a casting breaks while the unit is in motion there is the potential for pieces of the casting to become projectiles and the suspension's transverse beam may drop low enough to contact the road surface causing sparks that could potentially ignite a fire.

You should immediately contact your Thomas Built Buses dealer for an appointment to have your vehicle modified. Thomas Built Buses will remedy this defect without charge. It will take approximately 1.5 hours per unit for the repair. To arrange for repairs, contact your local Thomas Built Buses dealer. After the repair is made, please complete each postage paid card separately and return it to Thomas Built Buses to verify completion.

In addition to being used to verify repair completion, the postcard must be completed and returned if the vehicle does not need repair, if you no longer own the vehicle, or the vehicle identified on the postcard has been exported, stolen, or destroyed/totaled. Federal law requires that any vehicle lessor receiving the recall notice must forward a copy of this notice to the lessee within 10 days.

If the defect is not remedied without charge and within a reasonable time, which is not longer than 60 days after you tender the vehicle for repair, please contact the Customer Support Office at (336)-889-4871, 8 a.m. to 5 p.m. eastern standard time Monday through Friday, e-mail address Tracy.Sauerbrey@Thomasbus.com. You may also submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 7th Street S.W., Washington, DC 20590, or phone 1-888-327-4236 (TTY: 1-800-424-9153) or go to <http://www.safercar.gov>. If your vehicle is involved in the Canadian portion, you may notify the Manager, Recall and Public Compliance, Road and Motor Vehicle Traffic Safety Branch, Transport Canada, Ottawa, Ontario or phone (613)-993-9851.

Sincerely,



Tracy Sauerbrey
Customer Support Division

/ts
Enclosures Postcard

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All rights reserved.

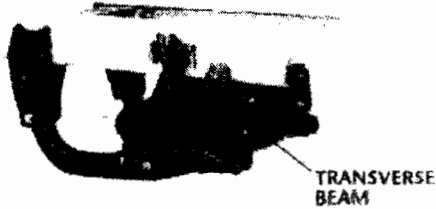
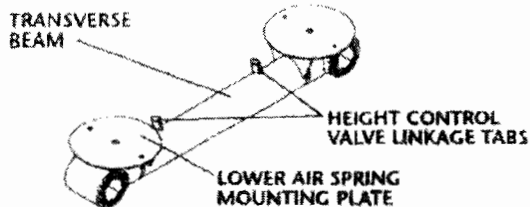


Figure 1



IMPORTANT:
DO NOT DESTROY THE BOX THAT THE NEW TRANSVERSE BEAM IS SHIPPED IN.
THE BOX WILL BE RE-USED TO RETURN THE OLD TRANSVERSE BEAM TO HOLLAND.

TIME REQUIRED

Holland recommends a maximum of 1.5 hours per axle for the transverse beam replacement procedure.

TOOLS REQUIRED

1. Torque Wrench - minimum 600 ft. lb. capacity
2. Torque Wrench Extension (for leverage)
3. 3-1/2" socket for 2-1/4" Heavy Hex Nut

NOTE: Use of pneumatic impact guns is not recommended for removal or installation of the Heavy Hex Nut.

TRANSVERSE BEAM REPLACEMENT AND RETURN PROCEDURE MANUAL

NEW, X AD Series Air-Ride Suspensions

Special Replacement T-Beam Kit

Part Numbers

- 48100435
- 48100436
- 48100437
- 48100438
- 48100439

Kit Contents

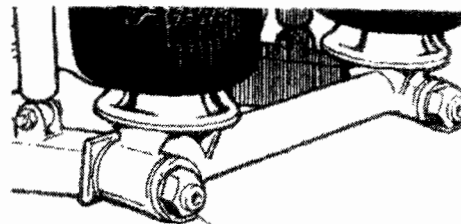
- 1 - T-Beam with Bushings
- 1 - Fastener Kit
- 1 - Procedure Manual / Return Tags / Return Labels

CLEANING PRIOR TO DISASSEMBLY

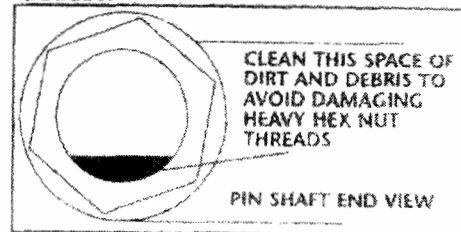
1. Clean the fasteners and pin shafts of the Transverse Beam connections prior to disassembly to help protect the threads.
2. Clean out the space between the Pin Shaft and the Heavy Hex Nut to remove dirt and debris. A piece of wire can help loosen trapped debris (Figures 2 and 4).

CAUTION Always wear safety glasses when working on the suspension or eye injuries may occur.

Figure 2



DETAIL A



CLEAN THIS SPACE OF DIRT AND DEBRIS TO AVOID DAMAGING HEAVY HEX NUT THREADS

PIN SHAFT END VIEW

TRANSVERSE BEAM REPLACEMENT

REMOVING THE TRANSVERSE BEAM

1. It is recommended the vehicle be unloaded and wheels properly chocked prior to Transverse Beam replacement. Be sure you have adequate clearance beneath the vehicle to perform the work.

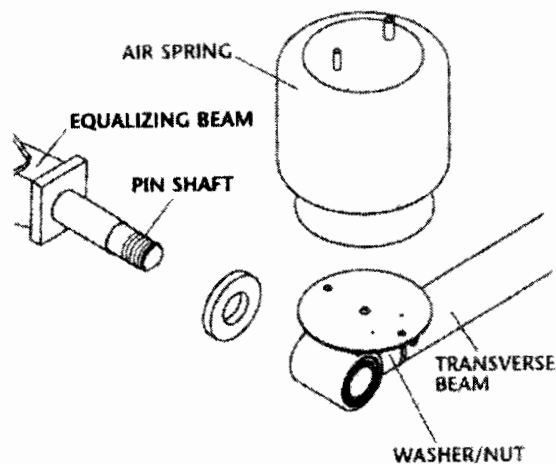
Raise vehicle's frame 2" above its standard ride height and support with adequate jack stands.

Note that the height control valves can be used to raise the vehicle.

WARNING Always use jack stands of sufficient strength and position them according to OEM recommendations. Failure to do so may cause the vehicle to fall, resulting in vehicle damage and/or personal injury.

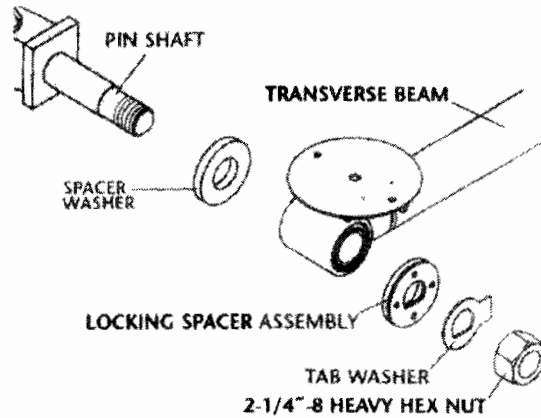
2. Exhaust the air in the air springs and air system using the manual dump valve (if vehicle is so equipped) or by using the height control valve(s). To exhaust the air using the height control valves, disconnect the valves linkage at the lower connection. Then rotate the valve's control arm down to the air exhaust position.
3. With the air exhausted from the air springs, remove the air springs from the Lower Air Spring Mounting Plate by removing the nut and washer located under the mounting plate (Figure 3). Save this hardware for re-installation.

Figure 3



4. With the air springs disconnected, you can now remove the Transverse Beam. This is accomplished by removing the Heavy 2-1/4" Hex Nuts located at the end of each equalizing beam (Figure 4).

Figure 4



5. With the Heavy Hex Nuts, Tab Washers, and Locking Spacer Assemblies removed, the Transverse Beam can now be removed from the ends of the Pin Shafts. Be sure to note the orientation of the Linkage Tabs welded to the top of the Transverse Beam (Figure 1). These may be used for mounting the linkage that controls the Height Control Valves. You'll want to orientate the tabs on the replacement Transverse Beam into the same position(s) if the tabs are used for this purpose.
If the Transverse Beam Bushings remain on the Pin Shafts, use a screwdriver or small chisel to separate the metal bushing core. This bushing is a split design to facilitate removal.
6. Be sure to save the large Spacer Washer located behind the Transverse Beam ends. This washer will be needed for re-installation of the replacement Transverse Beam.
7. Clean the exposed Pin Shafts to remove any rust left behind from the metal bushing cores, plus any other dirt and debris. The Pin Shafts and their threads are Dacromet coated during manufacturing. Dacromet is a hard, silver-colored coating that protects the Pin Shafts from rust. Most of the Pin Shafts that will be encountered during the replacement are also painted. This paint serves no purpose and is only there due to our paint dip process. Paint that is scratched, chipped or removed is of no concern since the underlying Dacromet coating is the primary protection for the pin shaft.

INSTALLING THE REPLACEMENT TRANSVERSE BEAM

8. Once the Pin Shaft is clean, replace the Spacer Washers (saved from Step 6.), one over each Pin Shaft. Now install the replacement Transverse Beam over the Pin Shafts. The replacement Transverse Beam already has new bushings pressed into the ends. Be sure to orientate the Linkage Tabs on the Transverse Beam in the up position (*Figure 1*). Also check for the proper orientation of these tabs as described in Step 5.
9. With the Spacer Washers and Transverse Beam installed over the Pin Shafts, install the new fasteners provided in the Fastener Kit that comes with each replacement Transverse Beam.
First, install a new Locking Spacer Assembly over each Pin Shaft.
Second, install a new Tab Washer over each Pin Shaft.
Third, make sure that the Pin Shaft threads are clean and then install the new Hex Nuts. There is no need to lubricate the threads prior to installing the nut. The Dacromet coating on the threads reduces friction; treat the connection as non-lubricated.
10. Torque the Hex Nuts to 550 ft. lbs. (745 Nm). **Do not** use an air impact wrench for applying the final torque to the connection; rather, use a torque wrench of the appropriate capacity. A "cheater bar" may be needed to generate sufficient torque with the wrench.
11. With a hammer, bend the tab portion of the Tab Washer over the Hex Nut.
12. Reinstall the air spring to the Lower Air Spring Mounting Plate using the washer and nut removed in Step 3. Torque nut to 30 ft. lbs. (40 Nm). If the air spring has more than one mounting stud protruding through the mounting plate, install the washer and nut to the rear-most stud only. Reconnect any Height Control Valve linkages as necessary.

Once the replacement is complete and the vehicle is started, allow the system to air-up and then check for the proper ride height.

Upon completing the Transverse Beam installation, no realignment to the axle is required due to replacement of the Transverse Beam.

TRANSVERSE BEAM RETURN INSTRUCTIONS

Holland requests that all Transverse Beams removed as a result of this recall be returned to Holland for registration and disposal. Please re-use the box from the replacement beam for this return shipment. Easy to use tags and labels are provided in the Instructions Envelope. Shipping is pre-paid so there is no cost to you for the return shipment.

Follow these steps:

1. Remove the red registration tag from the Information Envelope. Complete the tag by printing the requested information on the tag. With the information complete, firmly attach the tag to the old beam using the wire.
2. Place the tagged Transverse Beam into the box that the new beam was shipped in. Securely tape, strap or staple the box closed for return shipment.
3. Label the box with one of the three shipping labels provided in the Information Envelope.
 - For return shipments originating in the U.S., use the Muskegon, Michigan shipping label.
 - For return shipments originating in Canada, use one of two shipping labels, depending on which Canadian return center is closest to your location, Surrey, BC or Woodstock, Ontario.Remove the backing from this self-adhering label and place it over the original shipping label.
4. Once the box is securely sealed and labeled, contact Evans Transportation Services toll free at 1-800-886-7799 to arrange for the return shipment. Please reference Holland Campaign # RC321 when making shipping arrangements with Evans. Return shipments are pre-paid by Holland.

HOLLAND INFORMATION SOURCES

For direct Holland assistance regarding recall related inquiries between the hours of 8am - 5pm Eastern Standard Time.

For Holland Customer Service:

Phone toll free 1-888-396-6501 and ask for Kay Duram at ext. 8555.

For Holland Technical Service:

Phone toll free 1-888-396-6501 and ask for the Tech Group.

Recall information is also located on our web site at www.thehollandgroupinc.com.

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Phone 888-396-6501 • Fax 604-574-2494
www.thehollandgroupinc.com

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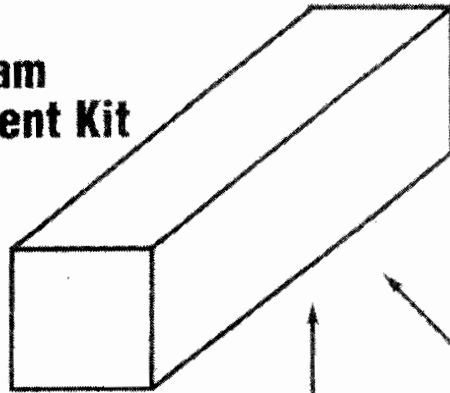
Holland USA, Inc.
Muskegon, MI
Phone: 616-396-6501
Fax: 616-396-1511

Holland Hitch of Canada, Ltd.
Woodstock, Ontario • Canada
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Fax: 800-565-7753

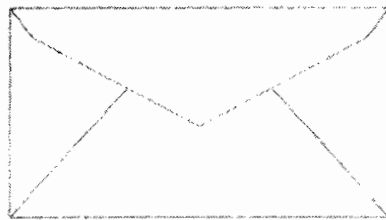
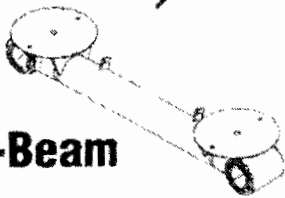
Holland Hitch Western, Ltd.
Surrey, British Columbia • Canada
Phone: 604-574-7494
Fax: 604-574-0244



T-Beam Replacement Kit

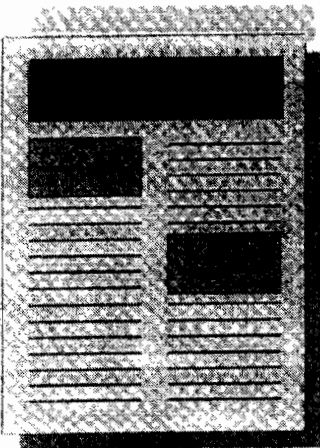
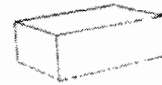


T-Beam

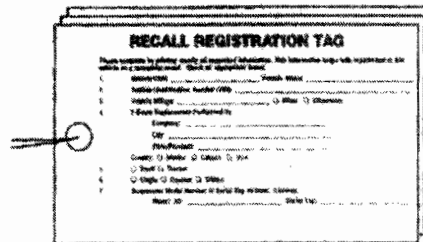


Instructions Packet
P/N XM-RC001

Fastener Kit
P/N 33005311



Replacement Procedure



3 Registration Tags



3 Return Labels