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**SAFETY RECALL RVXX0503
AUGUST 2005**

SAFETY RECALL BULLETIN

**ATTENTION: SERVICE MANAGERS
PARTS MANAGERS**

SUBJECT: Holland AD Series Air Suspension

SAFETY RECALL INFORMATION:

Holland has determined that certain AD Series suspensions produced in 2004 have transverse beams (T-Beams) manufactured with end castings that do not conform to Holland material specifications. These non-conforming end castings may fracture and fail under normal loads. If a casting breaks when the vehicle is traveling on a roadway, the suspension's transverse beam may drop down low enough to contact the road surface.

VEHICLES AFFECTED:

Volvo VH, VN, and VT Heavy-Duty Class 8 vehicles manufactured with certain Holland AD Series Air Suspensions from February 2004 through November 2004.

There are 20 vehicles (10 of the 20 are domiciled in Canada) that need to have the transverse beams replaced.

NOTE: To verify or determine if a particular vehicle is affected by this recall (or any other recall), you should consult the DCS, Service/Warranty screen. By entering the Vehicle Identification Number into the VEHINQ segment, the screen will display any outstanding recall.

If a "Dealer Listing" is enclosed it identifies the vehicles that were sold or shipped to your dealership. Be sure to check the VEHINQ screen before performing the recall to verify that the recall is still open.

REPAIR:

The recall repair will consist of replacement of the transverse beams.

Note: The new transverse beams are to be painted by the dealer.



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TIME ALLOWANCE:

Inspection: Not required for this recall.

Repair (including take charge time): - 3.7 hours per 6 x 4 vehicle.

Repair (including take charge time): - 5.4 hours per 8 x 4 or 8 x 6 vehicle.

RECALL PARTS:

The parts required to modify a particular vehicle are identified as modification A or B. The recall modification code is found to the right of the recall number for each vehicle, for example "RVXX0503A" or "RVXX0503B".

IMPORTANT NOTE: Parts must be ordered according to the modification code assigned to the particular vehicle.

<u>Modification Code</u>	<u>REPAIR KIT#</u>	<u>REQ'D QTY</u>	<u>TOTAL VEHICLES</u>
<u>"A"</u>	HOH48100436WARRANTY	2 for 6x4	16
		3 for 8x6	2
<u>"B"</u>	HOH48100437WARRANTY	2 for 6x4	1
		3 for 8x4	1

PART ORDERING PROCEDURES:

Place all orders for Holland Safety Recall Repair Kits through Volvo Vision Direct Ship order entry process. Place orders using special Holland Program Number 309. Only the two kits involved in the subject recalls can be ordered on this special program. The kits will be shipped freight prepaid.

Volvo part number for RVXX0503A - HOH48100436WARRANTY

Volvo part number for RVXX0503B - HOH48100437WARRANTY

DEALER INVENTORY:

Dealer inventory is not affected by this recall.

REMOVED PARTS:

All removed T-Beams **MUST** be returned to Holland. Shipments of returned T-Beams will be coordinated through Evans Transportation Services. Specific instructions for the return are provided on page 8 of this bulletin.

Holland will pay all freight costs associated with the return of the recalled T-Beams.



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CLAIMS FOR CREDIT:

Expenses associated with the performance of this recall will be reimbursed based on the guidelines identified in this bulletin, and section 10-7-4-9 of the Service Operations Manual and chapter 20 of the Parts Operations Manual.

CLAIM CODING INFORMATION:

Type: P

Authorization Number: - RVXX0503

Repair (including take charge time): - 72620-0-02 3.7 hours per 6 x 4 vehicle.

Repair (including take charge time): - 72620-0-07 5.4 hours per 8 x 4 or 8 x 6 vehicle.

IMPORTANT NOTE:

- Claims for a recall repair **MUST** be submitted within 2 working days from the repair date.
- Claims will be paid after removed beams are received by Holland.

OWNER RECALL RESPONSE CARD:

The "Owner Recall Response Card" is to provide the vehicle owner with a convenient way to notify Volvo Trucks North America, Inc. of changes affecting the ownership of the subject vehicle. The owner recall response card is not intended for dealer usage other than to assist you in the preparation of the repair orders necessary to perform the applicable recall on the subject vehicle. Please do not use the card as a way to inform Volvo Trucks North America, Inc. that the vehicle has been inspected or modified. Your DCS claim on line is the appropriate means of informing Volvo Trucks North America, Inc. that the vehicle has been inspected or modified.

DEALER RECALL RESPONSIBILITY:

Dealers are to perform the recall on all vehicles subject to the recall at no charge to the owner regardless of mileage, age of vehicle, or ownership from this time forward. Whenever a vehicle subject to this recall is taken into or is in your vehicle inventory or dealership for service, we **strongly recommend** you make every effort to perform the recall correction before the vehicle is sold or released to the owner.



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IMPORTANT NOTICE:

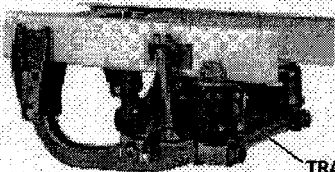
Please note that the National Traffic and Motor Vehicle Safety Act requires that the owner's vehicle(s) be corrected at no charge and within a reasonable time after parts are available to you. The law states that failure to repair a vehicle within sixty (60) days after tender for repair shall be a prima facie evidence of unreasonable time. However, circumstances of a particular situation may reduce the sixty-day period. If an owner's vehicle is not repaired within a reasonable time, he or she may be entitled, without charge, to a reasonable equivalent vehicle or refund of the purchase price, less reasonable allowance for depreciation.

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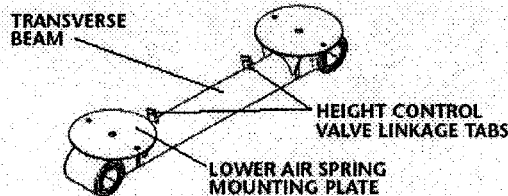
AD SERIES

TRANSVERSE BEAM REPLACEMENT AND RETURN PROCEDURE MANUAL



TRANSVERSE
BEAM

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.



**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

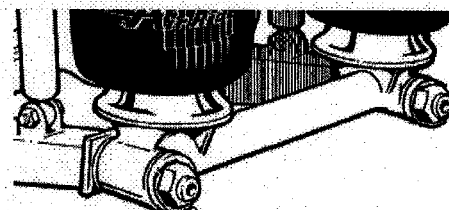
CLEANING PRIOR TO DISASSEMBLY

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



SEE DETAIL A

DETAIL A



PIN SHAFT END VIEW

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TRANSVERSE BEAM REPLACEMENT

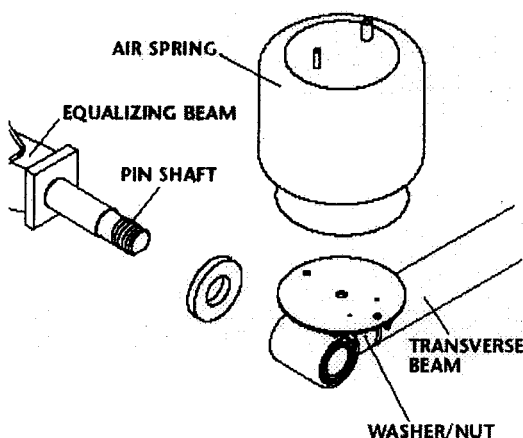
REMOVING THE TRANSVERSE BEAM

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.

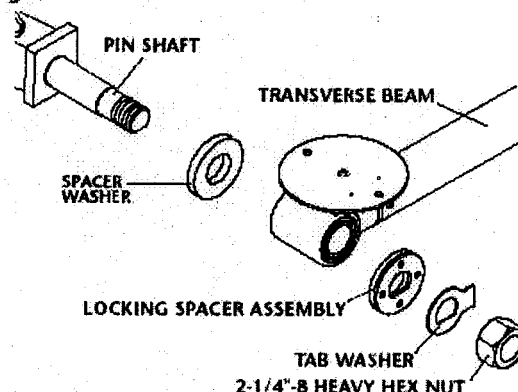
2. Exhaust the air in the air springs and air system using the manual dump valve (if vehicle is so equipped) or by using the height control valve(s). To exhaust the air using the height control valves, disconnect the valves linkage at the lower connection. Then rotate the valve's control arm down to 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 Shaft, 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.

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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.

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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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