



**MONACO**  
**COACH CORPORATION**

November 8, 2004

Assoc. Administrator for Enforcement  
National Highway Traffic Safety Admin  
U.S. Dept of Transportation  
400 Seventh Street SW  
Washington DC 20590

RE: Recalls 04V476000 Aqua Hot  
04V483000 Venture Frame

Enclosed is Monaco Coach Corporation's final Dealer and Owner notification letters for recall 04V476000 and 04V483000. Dealer notification for 04V476000 was released 10-22-04 and the Owner notification 10-27-04. Dealer notification for 04V483000 was released 10-22-04 and the Owner notification 10-29-04. Please use for information on your NHTSA web site. If you have any questions, please contact me at 1-574-389-4061.

Sincerely,

Terri Tobias  
Recall Administrator  
Monaco Coach Corporation

DEPT. OF TRANSPORTATION  
OFFICE OF INVESTIGATION

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**MONACO**  
COACH CORPORATION

October 2004

**VEHICLE SAFETY DEFECT SERVICE BULLETIN**

**Recall Campaign No. 04V483000 US Units**

**04-373 Canadian Units**

Monaco File # R02233

**Re: Recall- Venture Frame Enhancement**

Dear Monaco Coach Corporation Dealer:

Monaco Coach Corporation has decided that a defect which relates to motor vehicle safety exists in certain Fifth Wheels manufactured June 15, 1998 through July 11, 2003.

The affected Fifth Wheels are:

- 1999 – 2004 Holiday Rambler Alumascap
- 1999 – 2000 Holiday Rambler Aluma-Lite
- 1999 – 2000 Holiday Rambler Imperial
- 2001 – 2004 Holiday Rambler Presidential
- 2000 – 2004 McKenzie Lakota
- 2000 – 2001 McKenzie Grand Medallion
- 1999 – 2004 McKenzie Medallion

*Federal law requires that any vehicle lessor receiving this recall notice must forward a copy of this notice to the lessee within ten days.*

**The National Traffic and Motor Vehicle Safety Act provides that each vehicle that is subject to a recall campaign of this type must be adequately repaired within a reasonable time after the owner has tendered it for repair. Generally, failure to repair within sixty (60) days after the owner's first delivery for repair is assumed to be an unreasonable delay.**

**THE ISSUE**

Monaco Coach Corporation became aware of a deficiency in the structural integrity of the main frame rails that were used in the manufacturing process for specific floor plans of fifth wheels. The deficiency could result in the frame rails cracking and axles shifting, causing the fifth wheel to pull erratically. This could prompt the tow vehicle to lose control and create the potential for an accident, resulting in personal injury. The affected fifth wheel floor plans fall within the 34', 35', and 36' model units are designated as SKT, RLT, RKT, CKT, SKQ, and FKT, RET, SIT, SST and RT.

## **AFFECTED UNITS**

Please see **Attachment A** for the affected unit listing for recall 04V483000 and 04-373 .

If our records indicate that you have any of the affected vehicles in your inventory, you will also receive an owner notification letter identifying those units.

## **THE REPAIR**

The remedy will involve the addition of gusset plates and cross tubes to enhance the axle spring hangers. Please review the repair instructions for the labor operation code and labor time allowance. Parts are readily available by faxing the enclosed Recall Parts Purchase Order to 1-800-498-9478. If you have any questions concerning the repair procedure, please contact a member of our Technical Support staff toll free at 877-332-9239.

## **DEALER CAMPAIGN RESPONSIBILITY**

**All unsold new vehicles in dealer's possession and subject to this campaign must be held and inspected/repaired per the service procedure of this campaign bulletin before owners take possession of these vehicles. Dealers are to service all vehicles subject to this campaign at no charge to owners, regardless of mileage, age of vehicle, or ownership, from this time forward.**

**Owners of vehicles recently sold from your new vehicle inventory for which the dealer receives the owner recall notification are to be contacted by the dealer, and arrangements made to make the required correction according to the instructions enclosed with this bulletin. This could be done by mailing to such owners a copy of the applicable owner letter accompanying this bulletin.**

In Summary, whenever a vehicle subject to this campaign enters your vehicle inventory, or is in your dealership for service in the future, please take the steps necessary to be sure the campaign correction has been made before selling or releasing the vehicle.

In addition to a letter, owners will receive a recall notification/dealer claim form. The vehicle owner will present this form to you upon arrival for the service appointment. Please review the instructions on the face of the notification form and fill in the claim portion when the repair is completed.

Sincerely,



Michael R. Becker  
Customer Service Manager  
Monaco Coach Corporation

## **Attachment A**

### **Venture Frame Enhancement**

#### **04V483000 US Units 04-373 Canadian Units**

##### **Affected Unit Listing**

**1999 Holiday Rambler Alumascape** with a starting serial number of 990312303470113-105917 through 990312303470113-111131 with the VIN range of 1KB331N27XE105917 through 1KB331N2XXE111131.

**2000 Holiday Rambler Alumascape** with a starting serial number of 000312303470113-111362 through 000312303470213-118981 with the VIN range of 1KB331N25YE111362 through 1KB331N22YE118981.

**2001 Holiday Rambler Alumascape** with a starting serial number of 010312303470113-118640 through 010312303670113-125382 with the VIN range of 1KB331N211E118640 through 1KB331R241E125382.

**2002 Holiday Rambler Alumascape** with a starting serial number of 020312303440396-124784 through 020312303440307-133263 with the VIN range of 1KB331N292E124784 through 1KB331P282E133263.

**2003 Holiday Rambler Alumascape** with a starting serial number of 030312303440306-133501 through 030312303440306-139647 with the VIN range of 1KB331R203E133501 through 1KB331R233E139647.

**2004 Holiday Rambler Alumascape** with a starting serial number of 040312303540397-139358 through 040312303440309-140744 with the VIN range of 1KB331R254E139358 through 1KB331R244E140744.

**1999 Holiday Rambler Aluma-Lite** with a starting serial number of 990312883470113-106821 through 990312883470113-111121 with the VIN range of 1KB381N28XE106821 through 1KB381N25XE111121.

**2000 Holiday Rambler Aluma-Lite** with a starting serial number of 000312883570113-110204 through 000312883570113-119172 with the VIN range of 1KB381P26YE110204 through 1KB381P29YE119172.

**1999 Holiday Rambler Imperial** with a starting serial number of 990312573670113-106179 through 990312573670113-111101 with the VIN range of 1KB371R24XE106179 through 1KB371R23XE111101.

**2000 Holiday Rambler Imperial** with a starting serial number of 000312573670113-110532 through 000312573670213-118270 with the VIN range of 1KB371R21YE110532 through 1KB371R24YE118270.

**2001 Holiday Rambler Presidential** with a starting serial number of 010312333470119-117794 through 010312333670113-125390 with the VIN range of 1KB371N261E117794 through 1KB311R261E125390.

**2002 Holiday Rambler Presidential** with a starting serial number of 020312333640397-124461 through 020312333440306-133176 with the VIN range of 1KB311R272E124461 through 1KB311R292E133176.

**2003 Holiday Rambler Presidential** with a starting serial number of 030312333440309-130464 through 030312333640397-140316 with the VIN range of 1KB311R283E130464 through 1KB311S273E140316.

**2004 Holiday Rambler Presidential** with a starting serial number of 040312333640395-137850 through 040312333440309-140750 with the VIN range of 1KB311S2X4E137850 through 1KB311R224E140750.

**2000 McKenzie Lakota** with a starting serial number of 001412413670113-500597 through 001712413670113-501111 with the VIN range of 4K0311R21Y3500597 through 4K0331R26Y3501111.

**2001 McKenzie Lakota** with a starting serial number of 010312413470113-119167 through 010312413670113-124508 **AND** 011712413470113-501135 through 011712413670113-501767 with the VIN range of 4K0331N271E119167 through 4K0331R271E124508 **AND** 4K0331N2413501135 through 4K0331R2513501767.

**2002 McKenzie Lakota** with a starting serial number of 020312413440396-125489 through 020312413440306-132514 **AND** 021712413440306-501928 through 021712413440396-701985 with the VIN range of 4K0331N222E125489 through 4K0331R272E132514 **AND** 4K0331N2423501928 through 4K0331R2523701985.

**2003 McKenzie Lakota** with a starting serial number of 030312413440306-132390 through 030312413440396-139520 with the VIN range of 4K0331R223E132390 through 4K0331R223E139520.

**2004 McKenzie Lakota** with a starting serial number of 040312413540307-139789 through 040312413440306-140730 with the VIN range of 4K0331Q264E139789 through 4K0331R254E140730.

**2000 McKenzie Grand Medallion** with a starting serial number of 001412423450100-500486 through 001712423450100-501158 with the VIN range of 4K0331N26Y3500486 through 4K0321N29Y3501158.

**2001 McKenzie Grand Medallion** with a starting serial number of 011412423650100-500702 through 011712423450100-501496 with the VIN range of 4K0321R2113500702 through 4K0321N2X13501496.

**1999 McKenzie Medallion** with a starting serial number of 991412403550100-993211 through 991412403550100-993787 with the VIN range of 4K0311P23X3993211 through 4K0311P22X3993787.

**2000 McKenzie Medallion** with a starting serial number of 001412403450100-500010 through 001712403450100-501118 with the VIN range of 4K0311N21Y3500010 through 4K0311N24Y3501118.

**2001 McKenzie Medallion** with a starting serial number of 010312403670113- 118676 through 010312403670113-125241 **AND** 011712403470119-501114 through 011712403670113-501857 with the VIN range of 4K0311R211E118676 through 4K0311R211E125241 **AND** 4K0311N2X13501114 through 4K0311R2913501857.

**2002 McKenzie Medallion** with a starting serial number of 020312403440306-124161 through 020312403640397-132970 **AND** 021712403440306-501820 through 021712403640397-702264 with the VIN range of 4K0311N2X2E124161 through 4K0311S202E132970 **AND** 4K0311N2923501820 through 4K0311S2723702264.

**2003 McKenzie Medallion** with a starting serial number of 030312403440399-131306 through 030312403640396-140120 with the VIN range of 4K0311R273E131306 through 4K0311S223E140120.

**2004 McKenzie Medallion** with a starting serial number of 040312403640395-138693 through 040312403640307-140752 with the VIN range of 4K0311R274E138693 through 4K0311S244E140752.



**Caution/Safety**

Please have fire extinguisher near by in case of a fire. Protect underbelly from any fire damage. Chock wheels on unit on level area. Isolate lp gas tank. Take nessary precautions to protect gas line.

**Instructions**

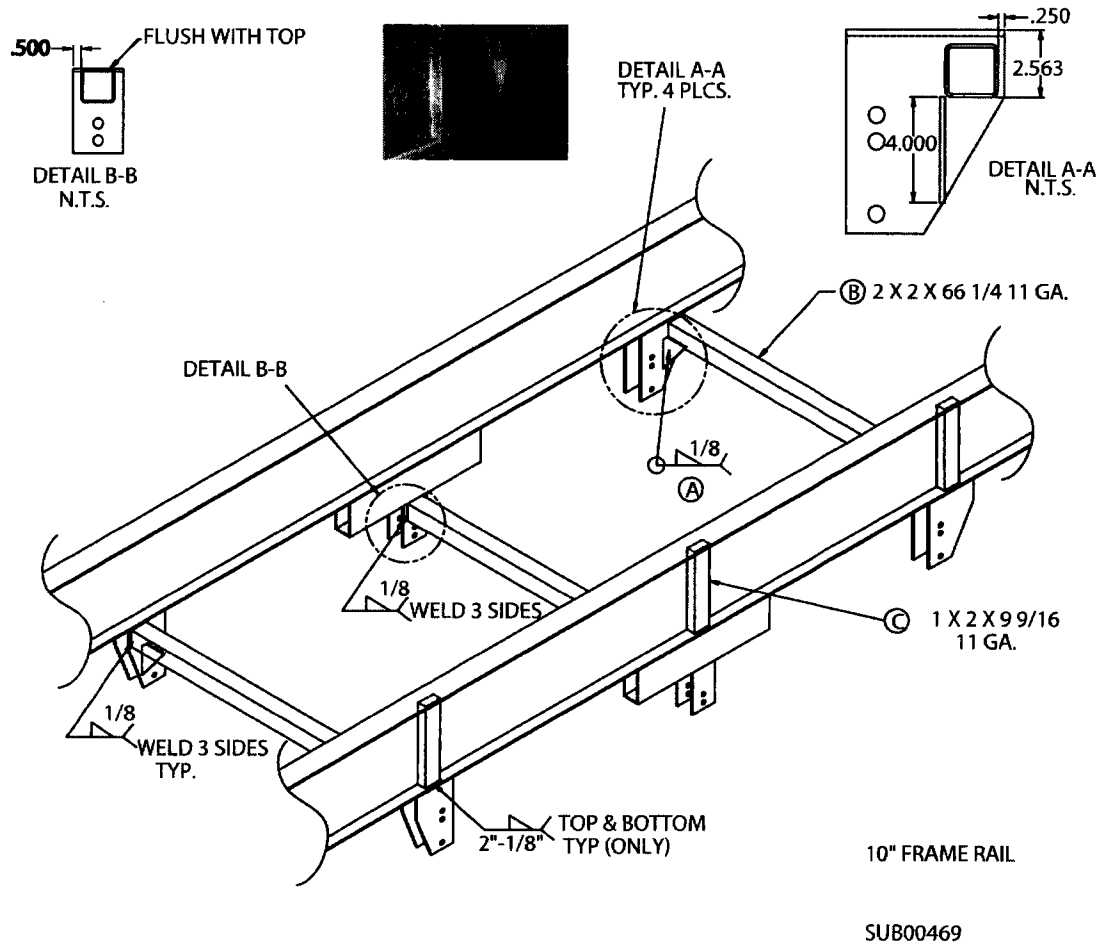
- (1) Tires do not need to be removed.
- (2) (B) Add tube to the unit weld both ends. See detail, A-A and B-B
- (3) Add gussets (A) 4 places. See detail A-A
- (4) Center tube (C) over spring hangers. Weld top and bottom flange only, to the outside of frame. Typ. both sides.
- (5) Allow all welds to cool properly then apply 'touch-up' paint.

**Bill of material**

- (A) RVPL0657 4pcs. 4 X 3 gusset
- (B) CJ00088 3pcs. 2 X 2 X 66 1/4 11 GA. Tube
- (C) CJ00089 6pcs. 1 X 2 X 9 9/16 11 GA. Tube

**Weld**

MIG  
 .035 Weld wire with CO gas 200 to 300 Amperes  
 .045 Weld wire with CO gas 200 to 300 Amperes  
 STICK (A.C/D.C.)  
 1/8 round stick E-6010 125-150 Amperes  
 1/8 round stick E-6011 125-150 Amperes  
 1/8 round stick E-7014 125-150 Amperes



# MONACO COACH CORPORATION

## RECALL PARTS PURCHASE ORDER

Recall 04V483000 / 04-373 Venture Frame Enhancement

Confirming Order Number: \_\_\_\_\_

Date: \_\_\_\_\_

Ship To: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Attention \_\_\_\_\_

PO Number: \_\_\_\_\_

Parts Ordered:     Kit - 04V483000 U.S. Units  
                          or 04-373 Canadian Units

Contents:           4 - 4" x 3" gusset plates  
                          3 - 2" x 2" x 66 1/4" 11 ga. tubes  
                          6 - 1" x 2" x 9 9/16" 11 ga. tubes

Customer Name: \_\_\_\_\_

Serial Number(s): \_\_\_\_\_

All parts will be shipped RPS ground unless other arrangements  
are made in advance.

**FAX TO: 1-800-498-9478**

MONACO COACH CORPORATION  
P.O. Box 4313 Elkhart, IN 46514-0313  
1809 W. Hively Ave Elkhart, IN 46517



**MONACO**  
**COACH CORPORATION**

October 2004

**VEHICLE SAFETY DEFECT SERVICE BULLETIN**

**Recall Campaign No. 04V483000**

**Monaco File # R02233**

**Re: Safety Recall – Venture Frame Enhancement**

Dear Owner:

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

Monaco Coach Corporation has decided that a defect which relates to motor vehicle safety exists in certain Fifth Wheels manufactured June 15, 1998 through July 11, 2003.

The affected Fifth Wheels are:

1999 – 2004 Holiday Rambler Alumascap  
1999 – 2000 Holiday Rambler Aluma-Lite  
1999 – 2000 Holiday Rambler Imperial  
2001 – 2004 Holiday Rambler Presidential  
2000 – 2004 McKenzie Lakota  
2000 – 2001 McKenzie Grand Medallion  
1999 – 2004 McKenzie Medallion

According to our information, your Fifth Wheel identified on the enclosed form is affected. *Federal law requires that any vehicle lessor receiving this recall notice must forward a copy of this notice to the lessee within ten days.*

Monaco Coach Corporation became aware of a deficiency in the structural integrity of the main frame rails that were used in the manufacturing process for specific floor plans of fifth wheels. This defect could result in the frame rails cracking and axles shifting, causing the fifth wheel to pull erratically. Under certain conditions, this could cause the driver of the tow vehicle to lose control creating the potential for an accident resulting in personal injury. The affected fifth wheel floor plans fall within the 34', 35', and 36' model units are designated as SKT, RLT, RKT, CKT, SKQ, and FKT, RET, SIT, SST and RT.

The remedy will involve the addition of gusset plates and cross tubes to strengthen the axle spring hangers. The correction will be provided at no charge to you. If you had this repair completed at your expense prior to receiving this letter, you may be eligible for reimbursement by Monaco for your remedy costs.

Please contact your Monaco Coach Corporation dealer to arrange for a service appointment. Instructions for making this correction have been sent to your dealer and parts are readily available.

The labor time necessary to perform this recall campaign is approximately 1.5 hours. Please ask your dealer if you wish to know how much additional time may be needed to schedule and process your fifth wheel.

The enclosed Recall Notification Form identifies your fifth wheel and will serve as an authorization and claim form to have the correction made. Presentation of this form to your dealer will assist in making the necessary correction in the shortest possible time. If you have sold or traded your vehicle, or for any reason cannot have this recall service performed, please let us know by completing the postage paid reply card and returning it to us promptly.

Your Monaco Coach Corporation dealer is best equipped to provide service to ensure your vehicle is corrected as promptly as possible. If, however, you take your fifth wheel to your dealer on the agreed service date and the dealer does not remedy this condition on that date or within three (3) days, please call our toll free Recall Hotline (800) 685-6545 or our toll free number for Technical Service (877) 466-6226.

If, after contacting your dealer, and the recall assistance service line, you believe Monaco Coach Corporation has failed or has been unable to remedy the noncompliance without charge or there has been an unreasonable delay in securing the remedy, you may submit a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street, SW, Washington, DC 20590 or call the toll free Auto Safety Hotline at (888) 327-4236.

We apologize for this inconvenience. However, we have taken this action in the interest of your safety and continued satisfaction with your fifth wheel.

Sincerely,



Michael R. Becker  
Customer Service Manager  
Monaco Coach Corporation