Keystone RV Company

10/14/2015

SAFETY ADVISORY # 15-238

Lippert A Frame Detachable Hitch

Keystone is conducting a voluntary RECALL notification campaign in accordance with the National Highway Transportation and Safety Act. It has been decided the vehicles in this recall population may have been manufactured with an insufficient weld on the rear mounting plate that the detachable A frame is bolted to.

Model and Serial Numbers Included:

2016 Retreat Models:	**All**
Serial Numbers:	**G7260040 – G7260046** **GW260000 – GW260091**
2016 Residence Models:	**All**
Serial Numbers:	**G3160000 – G3160146** **GW160147 – GW160148**
Parts Required:	Black Spray Paint – Local Supplier
Tools Required:	Welder, Welder Goggles or Face Shield, Grinder, Fire Extinguisher, Water Bottle

INSPECTION & REPAIR INSTRUCTIONS:

Inspection - See LCI Instructions on Page 2

Repair - See LCI Instructions on Pages 3 & 4

WARRANTY REIMBURSEMENT:

ONLY ONE OP CODE CAN BE USED PER VIN

INSPECTION ONLY - NO REPAIR NEEDED
Submit claim on Key Express using **Flat Rate Code # 7123842F** with **Safety Advisory # 15-238** noted in the customer complaint section of the form. Amount of time authorized for this inspection is 0.3 hours.

INSPECT AND REPAIR
Submit claim on Key Express using **Flat Rate Code # 7123842A** with **Safety Advisory # 15-238** noted in the customer complaint section of the form. Amount of time authorized for this repair is 1.0 hour.

Please call Keystone RV Customer Service at the number below for any questions.

Residence (866) 273-1452 Retreat (866) 273-1454

KEYSTONE A-FRAME INSPECTION - RETREAT AND RESIDENCE MODELS

Inspection

To inspect for insufficient welds on the rear A- frame mounting plates, first locate the mounting plate on the main frame rail (Fig. 1 - Inspection Area). Find the weld bead (Fig. 2 - Weld Bead). Check the weld bead for cracks or separation from either the mounting plate or the main frame rail. Figure 3 below shows a weld bead rolled over and not penetrating into the mounting plate (Fig. 3). If any of these conditions are present, the weld **MUST** be repaired. See the Keystone A-Frame Repair - Retreat and Residence Models document for the full repair instructions.

Fig. 1

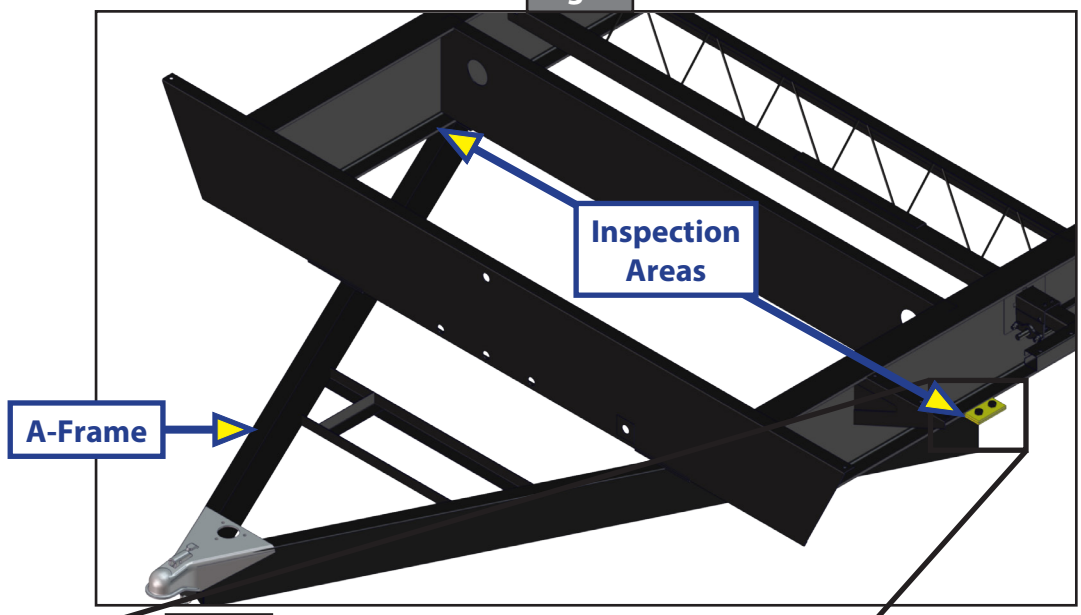


Fig. 2

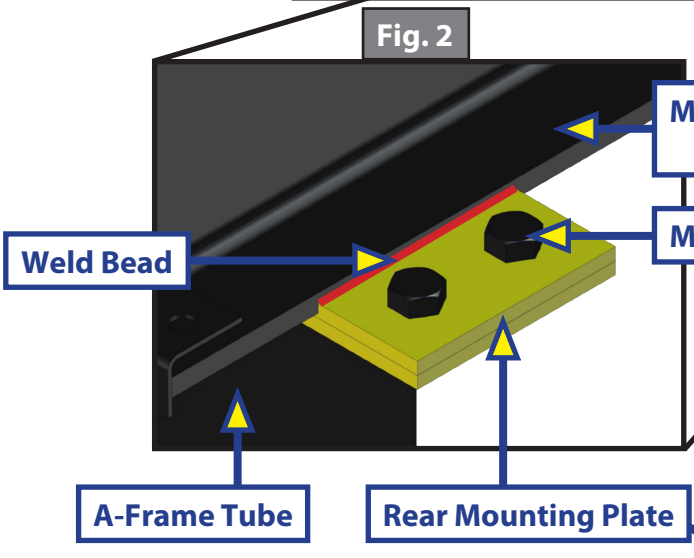
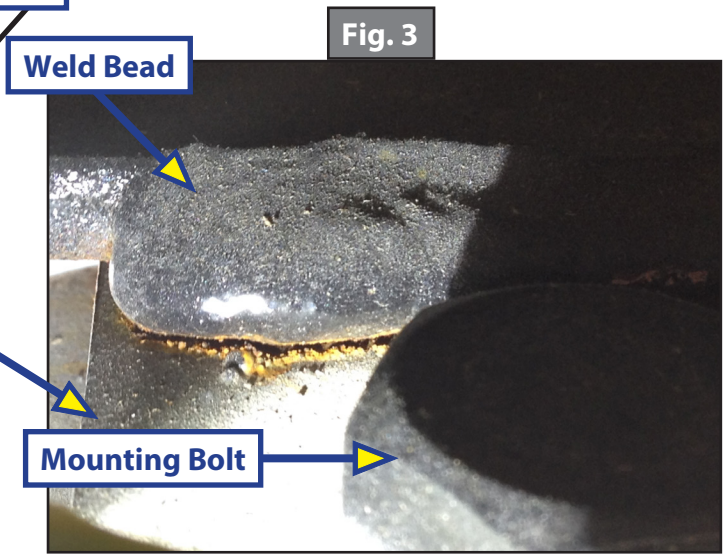


Fig. 3



NOTE: Mounting plates (Figs. 1 and 2) shown in yellow for clarity purposes.

Preparation

Tools Required

- Welder
- Welding goggles or face shield
- Grinder
- Fire extinguisher
- Water bottle
- Black spray paint

Safety

⚠WARNING **Failure to follow the instructions provided in this document may result in death, serious injury, vehicle damage, or voiding of the component warranty.**

⚠WARNING **Always wear eye protection when performing service or maintenance to the vehicle. Other safety equipment to consider would be hearing protection, gloves and possibly a full face shield, depending on the nature of the service.**

1. Support the coach according to manufacturer's instructions.

⚠WARNING **The coach MUST be supported per manufacturer's specifications before working underneath. Failure to do so may result in death or serious injury.**

2. Remove any flammable materials from the area where welding and grinding will occur. Protect any non-removable items with ¼" thick sheet metal shields.

⚠WARNING **Failure to remove or protect flammable materials may result in a fire, which may result in death, serious injury, or damage to the coach.**

Procedure

1. Locate the faulty weld(s) as determined during the inspection procedure.
2. Use the grinder to remove the faulty weld(s) from the mounting plate and main frame rail.

NOTE: Use jack stands to ensure the A-frame remains in position while the faulty weld is ground off (Fig. 1).

Fig. 1

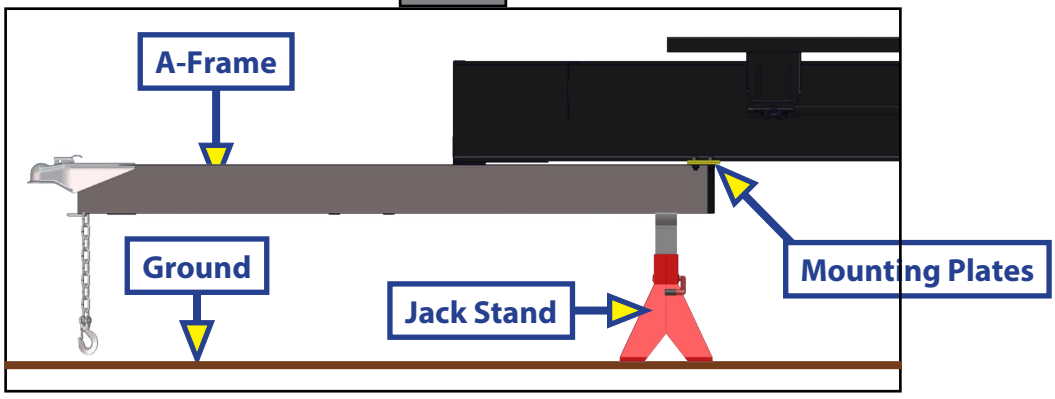
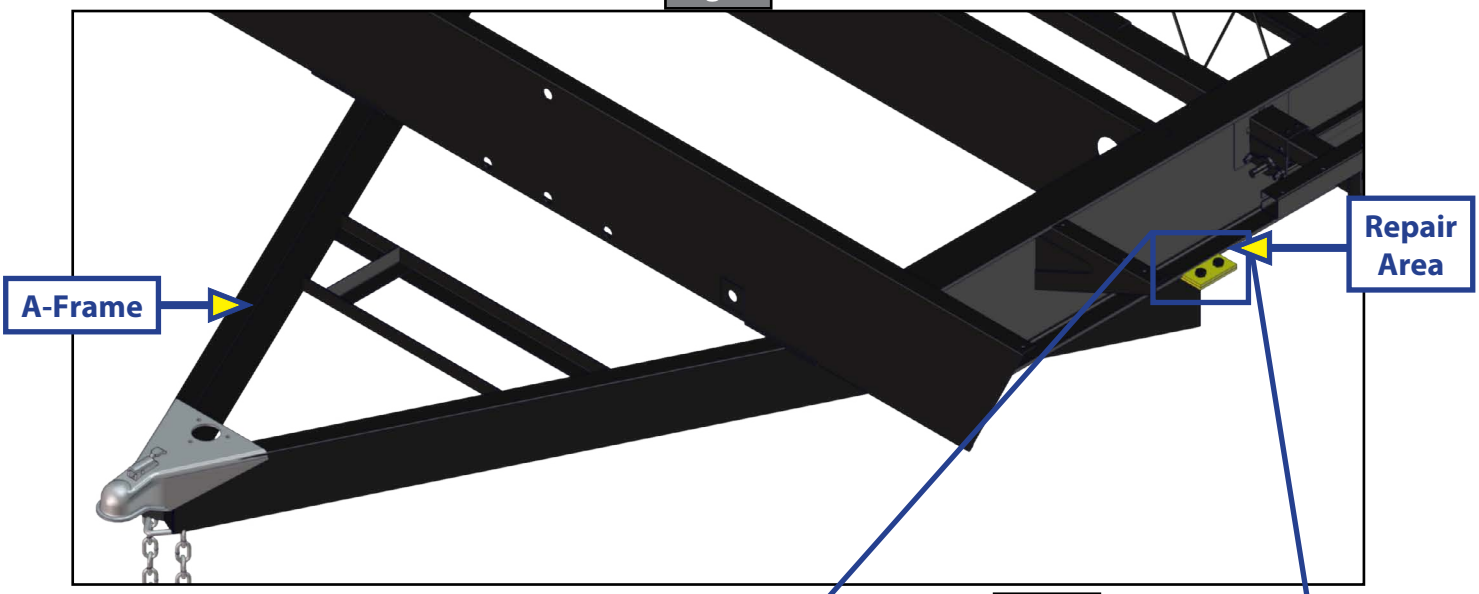


Fig. 2



NOTE: Mounting plates shown in yellow for clarity purposes only.

3. Once the old weld has been ground out, ensure the area is cleared of any burrs or metal shavings.
4. Use a continuous weld bead along the path of the previous weld, ensuring sufficient weld penetration between the mounting plate and the main frame rail flange (Fig. 3 - Weld Line).
5. Next add additional welds on the front and rear sides of the mounting plate where they contact the main frame rail. Use a continuous weld bead, ensuring sufficient weld penetration between the mounting plate and the main frame rail flange (Fig. 4 - Weld Line).
6. Repeat steps 2 through 5 for any additional welds as is necessary.
7. Once all welding has been completed and the welded areas have cooled, spray all the affected areas with black spray paint.

Fig. 3

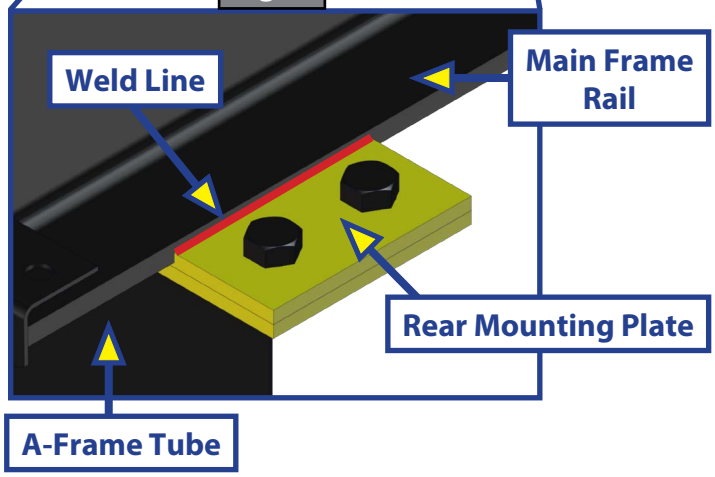


Fig. 4