Ride The Ducks International

RTDI - TECHNICAL SERVICE BULLETIN

TSB TITLE: Exterior Lighting: Lowering Headlights	**DATE:** 10/11/17

RTDI BULLETIN NO. TSB-04-17 **NHTSA RECALL NO:** 17V-164	**MODEL:** Stretch Duck

REASON: To adjust headlights that are currently mounted 56" above the ground to a distance of 54" above the ground.

ACTION: RTDI will ship the components and fixtures and procedures in order for the affected vehicles to be updated. RTDI will conduct onsite training and/or complete the TSB at the request of the Licensee. Refer to the following SERVICE PROCEDURE below for techniques/instructions.

PRODUCTION #	VIN	USCG O.N.	LOCATION
SD-08	1R9RS0AH	374388	Branson MO
SD-03	1R9RS0AH	458284	Branson MO
SD-04	1R9RS0AH7	248287	Branson MO
SD-12	1R9RS0AH	279363	Branson MO
SD-06	1R9RS0AH	Non-Navigable Waterway	Stone Mountain GA
SD-07	1R9RS0A	248292	Branson MO
SD-09	1R9RS0AH	393621	Branson MO
SD-10	1R9RS0AH	Non-Navigable Waterway	Stone Mountain GA
SD-11	1R9RS0AH	Non-Navigable Waterway	Stone Mountain GA
SD-13	1R9RS0	Non-Navigable Waterway	Stone Mountain GA
SD-14	1R9RS0A	40194	Branson MO
SD-17	1R9RS0A	30659	Branson MO
SD-15	1R9RS0A	Non-Navigable Waterway	Stone Mountain GA

PART NUMBER	DESCRIPTION	QUANTITY per unit	TOTAL SERVICING LABOR HRS
003002	Headlight Buckets	2	N/A
007465	Insert sheet (Pre-rolled & cut to size)	2	N/A
003838	Ribs / 1-¼" angle iron material	6FT	N/A
003002	Paint	1 Quart	30
	Fit-up & Welding		60

RTDI - TECHNICAL SERVICE BULLETIN

SERVICE PROCEDURE:

1. Remove headlights and secure electrical wires away from hot work.

2. Crop and remove the section of bow skin as detailed in fig #1 & 2.

3. Prep and clean the cut out openings (prepare for welding)

4. Tack weld insert into place. See detail in fig #3. Insert plate is a replacement in kind 14GA.
    - NOTE: When fitting the new insert into place, there should be no weld seam gaps greater than ½ the material thickness or .03735.

5. Utilize the provided magnetic headlight fixtures to locate the new location of the headlights: see detail fig #4
    - NOTE: See details in fig# 5. Ground up to the center of headlights is 51”
    - Set headlight fixtures as far forward as practical.

6. Once the fixtures are properly located, mark the sheet metal around the fixture.

7. Cut out marks on sheet metal and grind/prep for welding.

8. Install new headlight buckets into cut outs and tack weld into place.
    - NOTE: When fitting the new insert into place, there should be no gaps greater than ½ the material thickness or .03735.

9. Check headlight height and overall alignment before welding. Adjust if necessary.

10. Weld interior weld seams first.

11. Backgauge exterior weld seams and air/soap pressure test.

12. Weld exterior weld seams and conduct prior

13. All welding is to conducted in accordance with AWS Welding procedure Specification (pWPS) pg. 4 - 5

RTDI - TECHNICAL SERVICE BULLETIN

FIG #1

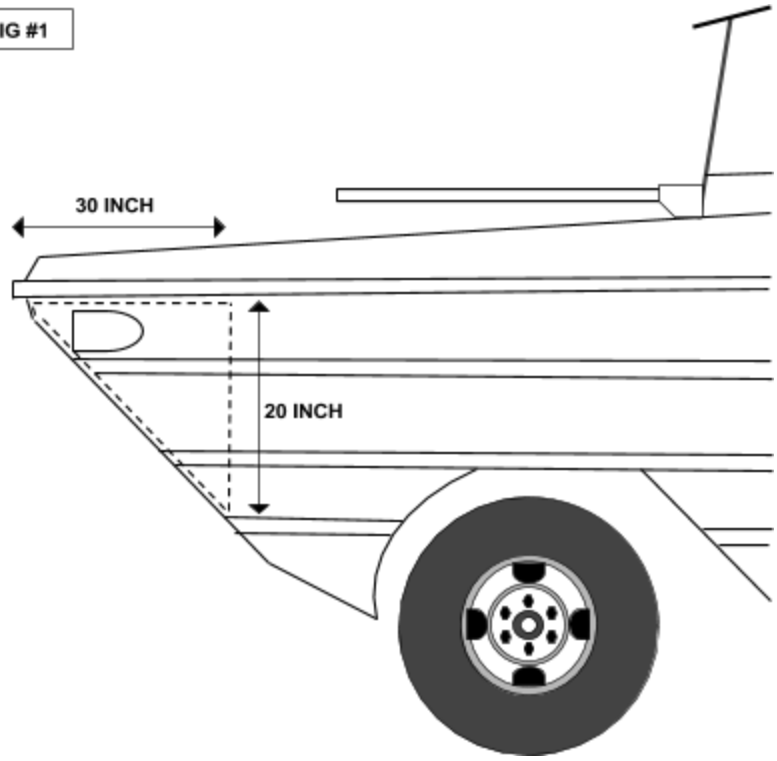
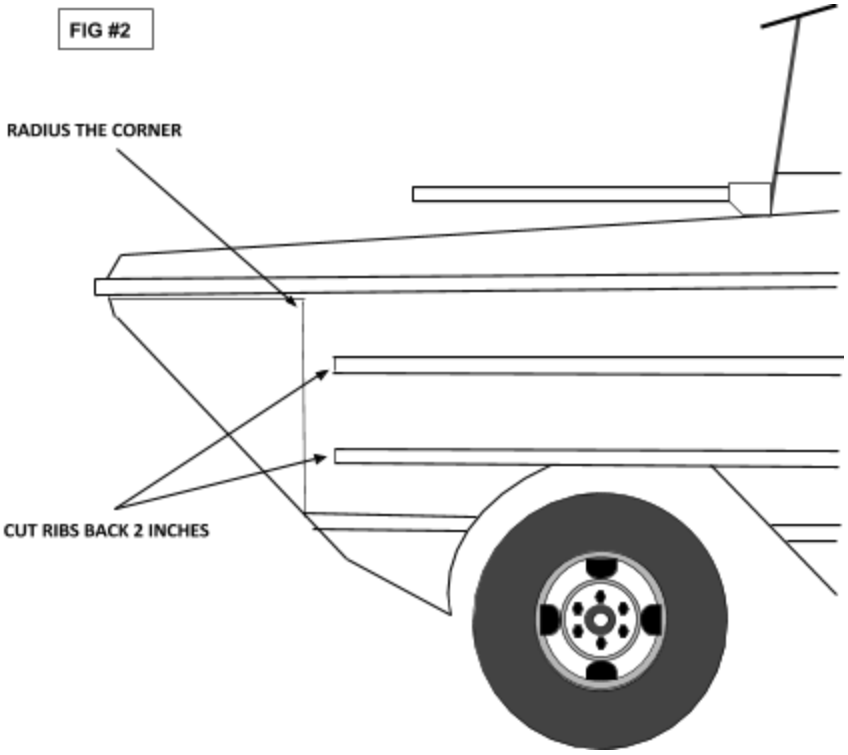


FIG #2



NOTE: the information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ride The Ducks International reserves the right to supercede this information with updates. The most recent information is available through Ride The Ducks International “DUCK CENTRAL” company website.

RTDI - TECHNICAL SERVICE BULLETIN

FIG #3

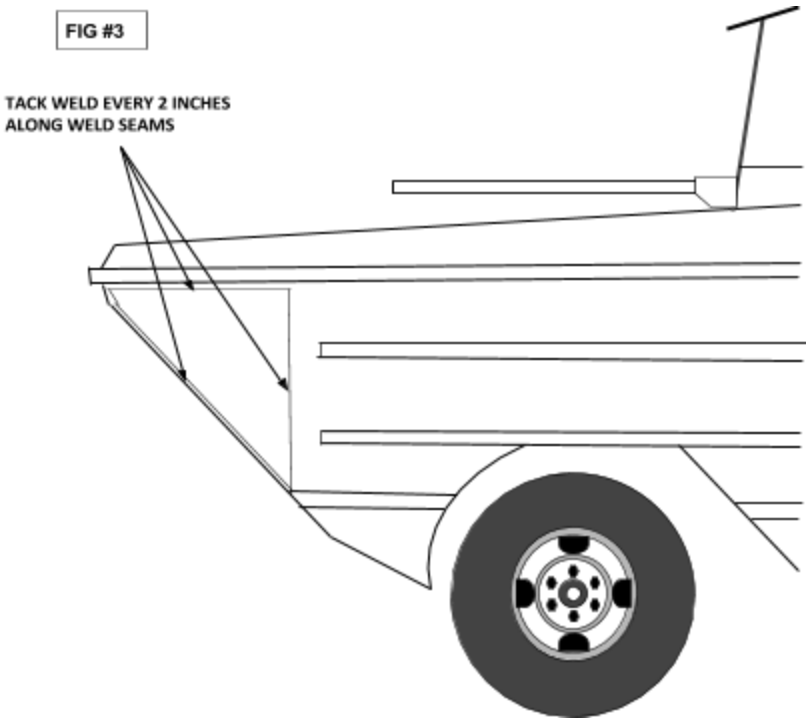
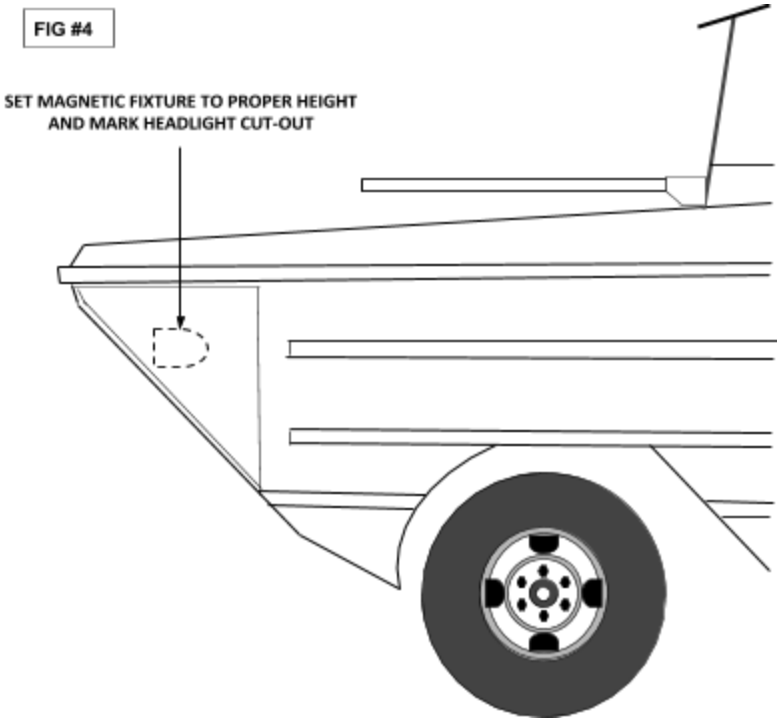


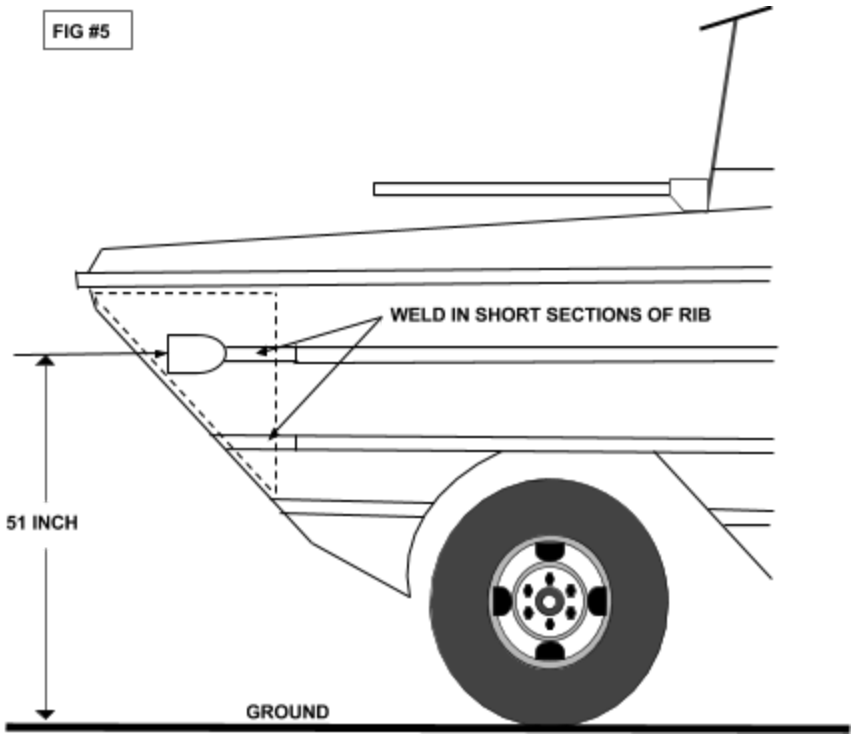
FIG #4

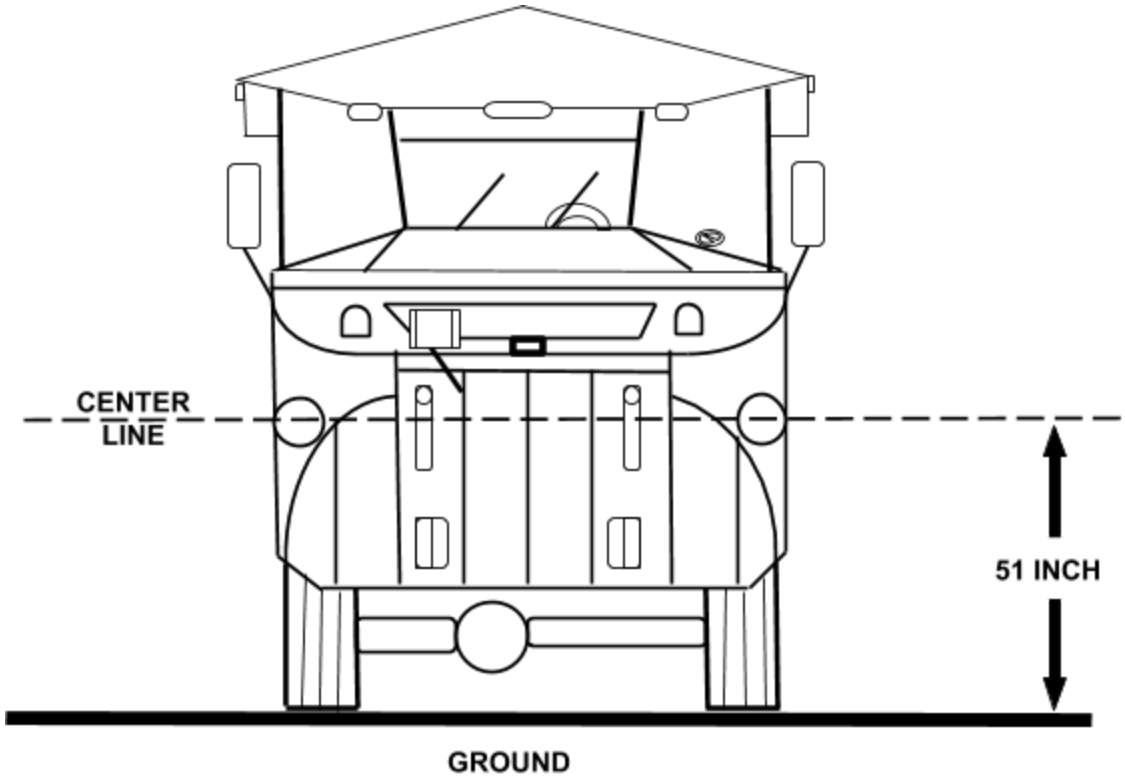


NOTE: the information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ride The Ducks International reserves the right to supercede this information with updates. The most recent information is available through Ride The Ducks International “DUCK CENTRAL” company website.

RTDI - TECHNICAL SERVICE BULLETIN

FIG #5





NOTE: the information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ride The Ducks International reserves the right to supercede this information with updates. The most recent information is available through Ride The Ducks International “DUCK CENTRAL” company website.

RTDI - TECHNICAL SERVICE BULLETIN

WELDING QUALITY CONTROL PROCEDURES (WQCP)

AWS Welding Procedure Specification (pWPS)

Company name	Ride The Ducks
Welding Process	GMAW-S
Process Type	Semi-Automatic

pWPS Identification #	HFE-GMAWS-3G
PQR Identification #	N/A
Authorized by	Jeff Borba
Date	6/8/11
Qualification Code	AWS D1.3 2008

Joint design used

Joint type	SBG
Joint designation	Square
Root Opening (R) (in.)	< 0" Min. - t/2 Max. >
Root Face (f) (in.)	N/A
Groove Angle (a) (deg.)	0 (deg)
Radius (J-U) (deg.)	N/A
Backing/Material	N/A
Back Gouging/Method	N/A

Position

Welding Position	Groove	F,H,V
	Fillet	N/A
Vertical Progression		Up/Down

Electrical characteristics

Transfer mode	(GMAW only)	Short Circuiting
Current type		DCEP (DC+)
Machine	(CV/CC)	Constant Voltage (CV)

Base metals

Spec., type or grade	D1.3 Table 1.2 (Group I & II)
Thickness Groove (in.)	*t1 or t2 = 16 Gauge* min. 3/16" max
Fillet (in.)	N/A
Sheet Dimension (in.)	N/A

Technique

Stringer or weave bead		Both
Multi/single pass	(per side)	Single
Interpass cleaning		N/A
Contact tube to work	(CTWD)	3/8" – ½"

Filler Metal / Shielding

AWS Specification	5.18
AWS Classification	ER70S-6
Gas Composition	100% CO2 & 75/25 CO2/Argon
Gas flow rate (cfh)	40 cfh (+/- 25%)
Gas cup size (in.)	½" – 5/8"

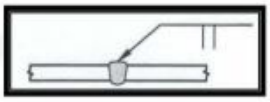
Preheat/Post Weld Treatment

Preheat temp.	min. (F)	60 Degrees
Interpass temp.	min. - max (F)	60 Degrees
Post temp	(F)	N/A
Post time	(Hrs.)	N/A

Welding procedure

Pass		1	
Process		GMAW - Short Circuit	
Filler metal class		ER70S-6	
Filler metal diameter		.035 (0.9 mm)	
Electrode Manufacturer		Hobart & Lincoln	
Current type/Polarity		DCEP (DC+)	
Amps	80	**100**	120
Volts	18	**18.5**	19
Wire speed (ipm)	120	**135**	155
Travel speed		*25 ipm (+/- 20%)*	

Joint Details



Square Butt Groove

Notes: ***All electrode parameters may only be adjusted 5% from displayed values unless otherwise noted. Displayed parameters are for 100% CO2 gas only. Volts may be reduced 1 to 2 for 75/25 Argon/Co2 mix gas.***

CWI/AWS Stamp

Company Name	Date	Name	Signature
PRECISIONEERING LLC.	6/8/11	Jeffrey A. Borba *CWI/CWE*	Jeffrey A Borba

NOTE: the information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ride The Ducks International reserves the right to supercede this information with updates. The most recent information is available through Ride The Ducks International "DUCK CENTRAL" company website.

RTDI - TECHNICAL SERVICE BULLETIN

WELDING QUALITY CONTROL PROCEDURES (WQCP)

AWS Welding Procedure Specification (pWPS)

Company name	Ride The Ducks
Welding Process	GMAW-S
Process Type	Semi-Automatic

pWPS Identification #	HFE-GMAWS-4F
PQR Identification #	N/A
Authorized by	Jeff Borba
Date	7/5/11
Qualification Code	AWS D1.3 2008

Joint design used

Joint type	Fillet
Joint designation	Lap, Tee, Corner
Root Opening (R) (in.)	N/A
Root Face (f) (in.)	N/A
Groove Angle (a) (deg.)	N/A
Radius (J-U) (deg.)	N/A
Backing/Material	N/A
Back Gouging/Method	N/A

Position

Welding Position	Groove	N/A
	Fillet	All
Vertical Progression		Down

Electrical characteristics

Transfer mode	(GMAW only)	Short Circuiting
Current type		DCEP (DC+)
Machine	(CV/CC)	Constant Voltage (CV)

Base metals

Spec., type or grade	D1.3 Table 1.2 (Group I & II)
Thickness Groove (in.)	*N/A*
Fillet (in.)	*t1 or t2 – 16 Gauge min. 3/16" max*
Pipe/Tube (in.)	N/A

Technique

Stringer or weave bead		Both
Multi/single pass	(per side)	Single
Interpass cleaning		N/A
Contact tube to work	(CTWD)	3/8" – ½"

Filler Metal / Shielding

AWS Specification	5.18
AWS Classification	ER70S-6
Gas Composition	100% CO2 & 75/25 CO2/Argon
Gas flow rate (cfh)	40 cfh (+/- 25%)
Gas cup size (in.)	3/8" – 5/8"

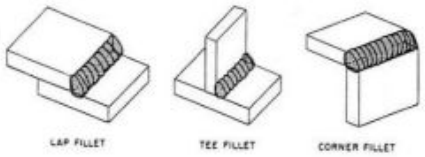
Preheat/Post Weld Treatment

Preheat temp	min. (F)	60 Degrees
Interpass temp.	min. - max (F)	60 Degrees
Post temp	(F)	N/A
Post time	(Hrs.)	N/A

Welding procedure

Pass		1	
Process		GMAW - Short Circuit	
Filler metal class		ER70S-6	
Filler metal diameter		.035 (0.9 mm)	
Electrode Manufacturer		Hobart & Lincoln	
Current type/Polarity		DCEP (DC+)	
Amps	80	**100**	120
Volts	18	**18.5**	19
Wire speed (ipm)	120	**135**	155
Travel speed		*25 ipm (+/- 20%)*	
Fillet weld size		1/8" – 5/16"	

Joint Details



Notes: ***All electrode parameters may only be adjusted 5% from displayed values unless otherwise noted. Displayed parameters are for 100% CO2 gas only. Volts may be reduced 1 to 2 for 75/25 Argon/Co2 mix gas.***

CWI/AWS Stamp

Company Name	Date	Name	Signature
PRECISIONEERING LLC.	7/6/11	Jeffrey A. Borba *CWI/CWE*	Jeffrey A Borba

NOTE: the information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ride The Ducks International reserves the right to supercede this information with updates. The most recent information is available through Ride The Ducks International "DUCK CENTRAL" company website.

RTDI - TECHNICAL SERVICE BULLETIN

Ride The Ducks International

RTDI - TECHNICAL SERVICE BULLETIN

Notification of Completion Form

DIRECTIONS: After the repair procedure described above has been fully completed, complete the form below, scan and email the completed form back to RTDI at the following email address. fleetoperations@ridetheducks.com

RTDI TSB No. 04-17 Exterior Lighting: lowering Headlights	**NHTSA RECALL NO:** 17V-164

RTD LICENSEE NAME:

DUCK VIN#:

DUCK LOCAL NUMBER/NAME:

My signature certifies that I have followed all required Service Procedures and that the RTDI Technical Service Bulletin No. TSB-04-17 has been completed on the vehicle listed above.

PRINT NAME:

SIGNATURE:	**REPAIR COMPLETION DATE** :

NOTE: the information in Technical Service Bulletins is intended for use by trained, professional technicians with the knowledge, tools, and equipment to do the job properly and safely. It informs these technicians of conditions that may occur on some vehicles, or provides information that could assist in proper vehicle service. The information in this Technical Service Bulletin (TSB) was current at the time of printing. Ride The Ducks International reserves the right to supercede this information with updates. The most recent information is available through Ride The Ducks International "DUCK CENTRAL" company website.