

RIDE THE DUCKS INTERNATIONAL
Fleet Operations & Safety
2320 West Highway 76
Branson MO 65616

Bulletin No. SB-00-14-13
Release Date: 10/01/13
Effective Date: 10/01/13
Supersedes: N/A
Completion Date: **Prior 2014**
Applicable to: All Stretch Ducks
Total Pages: 10

SERVICE BULLETIN

REASON FOR RELEASE: To avoid axle fractures and to strengthen the connection where the knuckle housing ball connects to the axle housing. [See Fig 1](#)

Urgency: As soon as practical and prior to operating 2014. Until such time this bulletin is reconciled, all maintainers are to add the daily visual inspection of the front wheels.

Daily Inspection: Due to the axle knuckle boots covering the connection in question, the visual detection of a failing axle housing is not possible. However, during visual examination, with the (front wheels straight) you identify a wheel or wheels as being (vertically canted) the Duck should be removed from service, the damaged axle housing removed (scrapped) and replaced with an axle housing that has been modified in accordance with this Service Bulletin.

Directions: Provide below are instructions of the modification that once completed will reconcile this Bulletin.

1. Parts required for modification [Fig 2](#)
2. Preparations for modification [Fig 3](#)
3. Example of parts fit-up [Fig 4](#)
4. Welding [Fig 5](#)
5. View of mods complete [Fig 6](#)

NOTE: All work must be performed by qualified personnel. Use only authorized components, specified or provided by Ride The Ducks. All applicable OSHA safety standards and safe industry practices must be observed. Observe all safety information contained in the manufacturers manuals. Make available this bulletin and all related technical information to personnel using the equipment.

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RTDI FLEET OPS HOTLINE: 417 266 7676
RTDI PARTS: 417 266 7626

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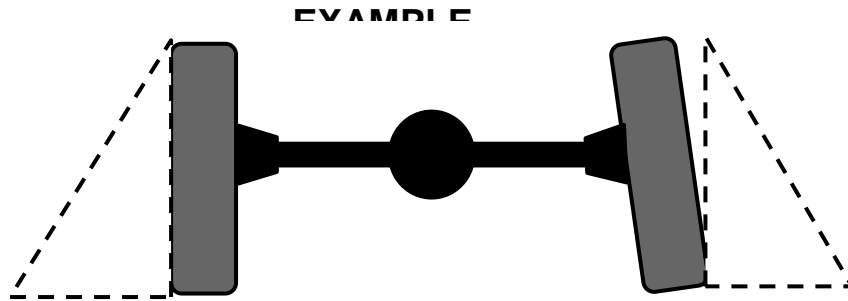


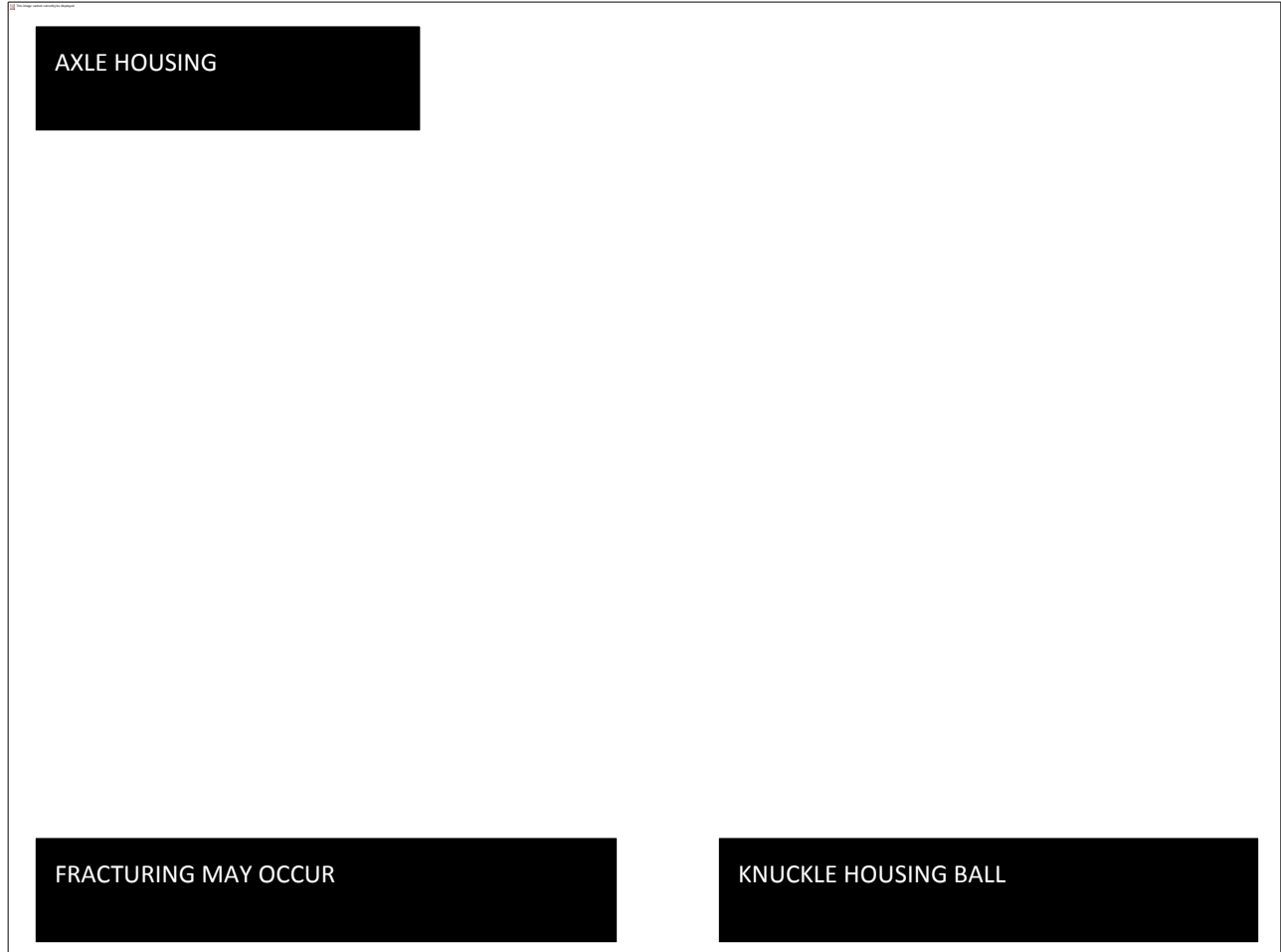
Fig 1

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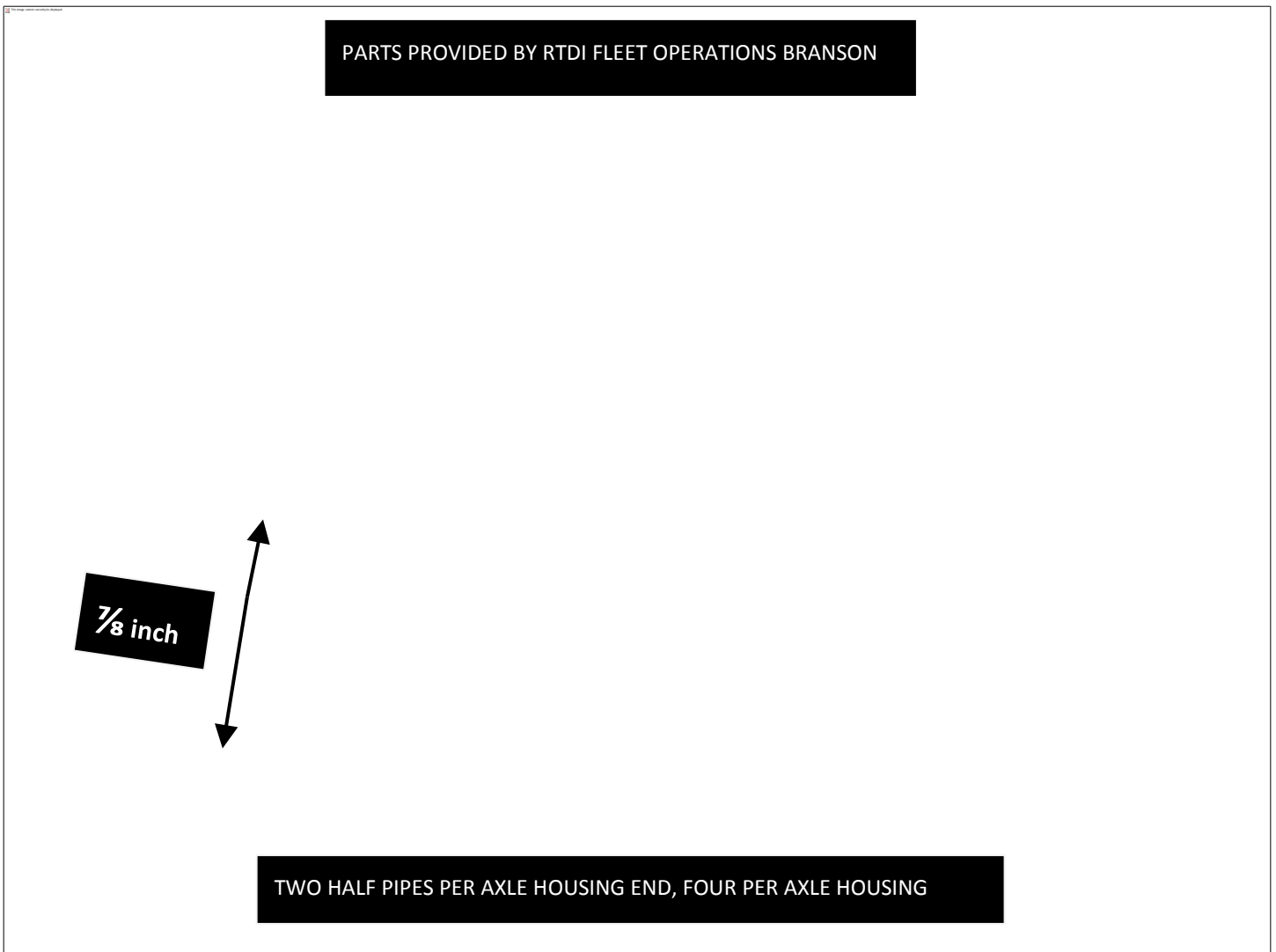
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Fig 2



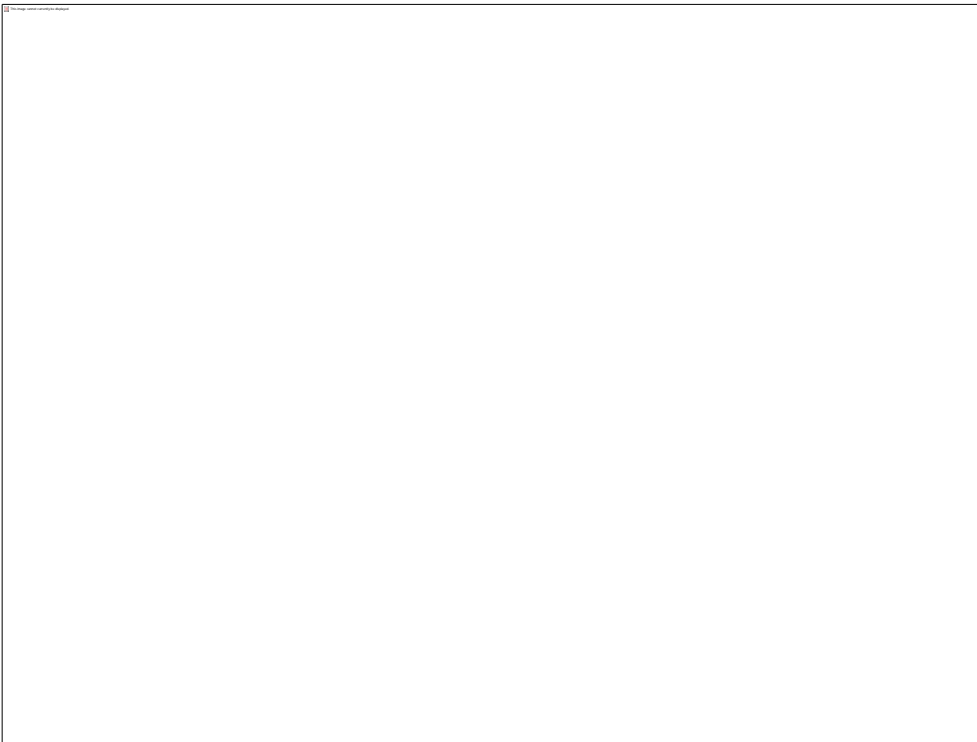
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Fig 3



1. Remove axle from the Duck
2. Set axle housing on a secure stand
3. Remove Boot and hardware
4. Thoroughly clean (remove all grease)
5. Examine axle housing for fractures

Note: Bent or fractured axle housings are not to be modified

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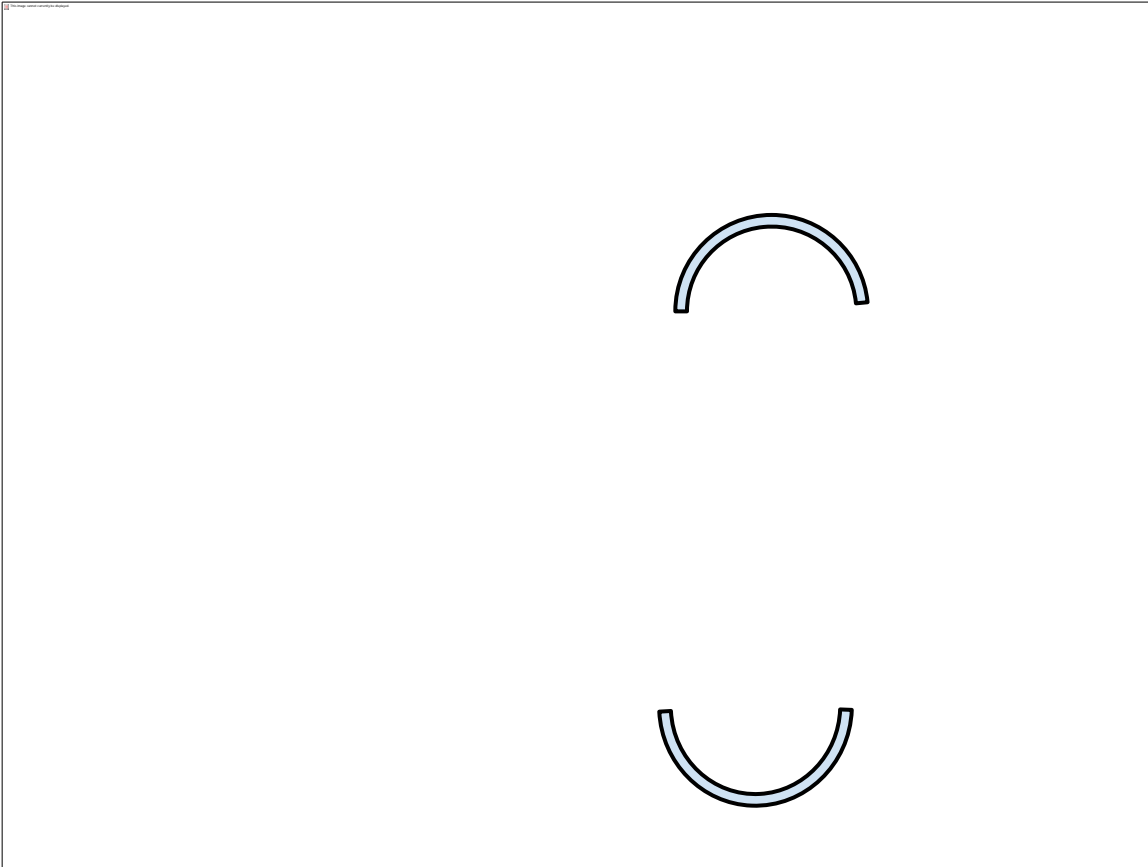
Fig 4

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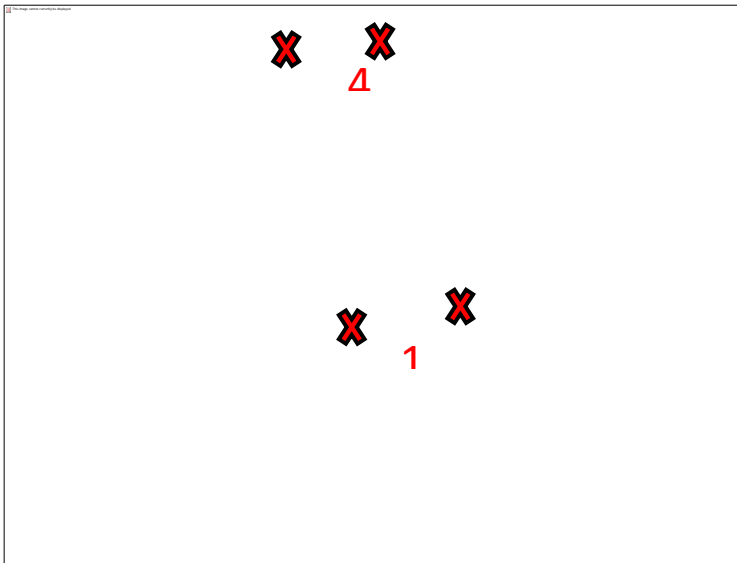
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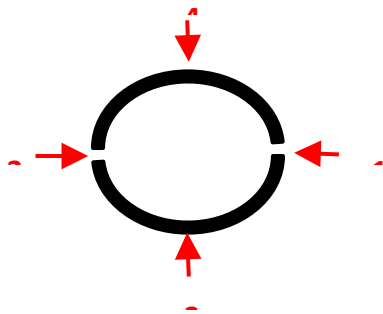
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Fig 5

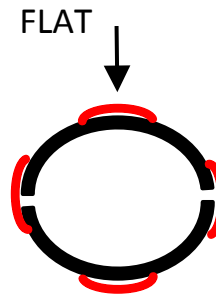


Tack weld half pipes in place as shown in photo

1. Center half pipe in detent gap between ball end and axle housing
2. Secure pipes in place with (vise grip) finger clamp
3. Tack weld in the sequence provided below
4. Ensure the axle housing stand is capable to allow the axle housing to rotate
5. All welds must be done in a flat position
6. Welder setting (copy and paste)



TACK



WELDING

1. Apply 2 inches of weld in flat position then rotate axle housing 180 degrees.
2. Continue step (1) until all weld joints are

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Fig 6

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