



SERVICE BULLETIN

Subject: Transfer Seat Base
Applicable Products: R12XX Series Products
Affectivity: All units with date codes between January 2006 and May 14, 2007

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Introduction

This bulletin provides a brief description of the technical issue plus a brief description of what is needed to deal with it.

Incorporation

Ricon requires the incorporation of this service bulletin as soon as possible.

Information

Units have been found wherein the weld that retains the main pivot shaft of the 6-Way Power transfer seat base (Figure 1) has failed, allowing the pivot shaft to fall out of the seat base. Figure 2 illustrates the swivel plate assembly and the defective weld location. Defective welds of this nature may have occurred on up to 770 units made during the above mentioned date range.

Caution

With the main pivot shaft removed, the vehicle driver's seat will become detached from the seat base.

Corrective Action

Inspect units for proper weld penetration.

General Inspection

1. Sharp transitions between the fillet and the parent metal are indicative of poor penetration. Refer to Figure 3.
2. Smooth transitions between the fillet and the parent metal indicative of a good penetration. Refer to Figure. 4.
3. Deformation of the inside diameter of the bushing indicate areas of good penetration. Refer to Figure. 5.

Inspection of Welds Between the Pivot Pin and The Bushings

1. Smooth transition and/or evidence of deformation on the inside diameter of the bushing must be present on at least 75% of the diameter.
2. Smooth transition must be present on at least 75% of the small inner diameter (between the fillet and the pin).

For units that do not meet the above criteria, replace the swivel plate.

Parts Involved

Swivel plate weldment..... p/n16018

Labor

Inspection involves the removal and replacement of the OEM seat and requires approximately ½ hour. Replacement of the swivel plate assembly requires an additional ½ hour.

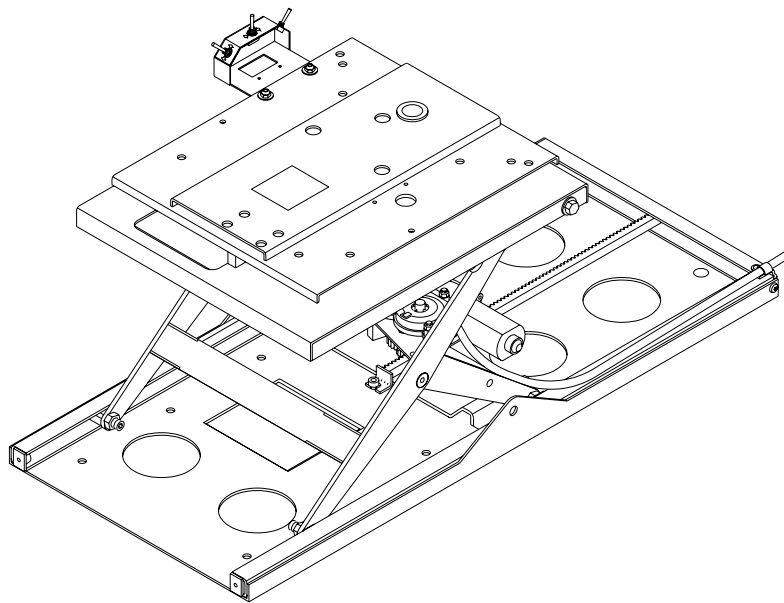


FIG. 1

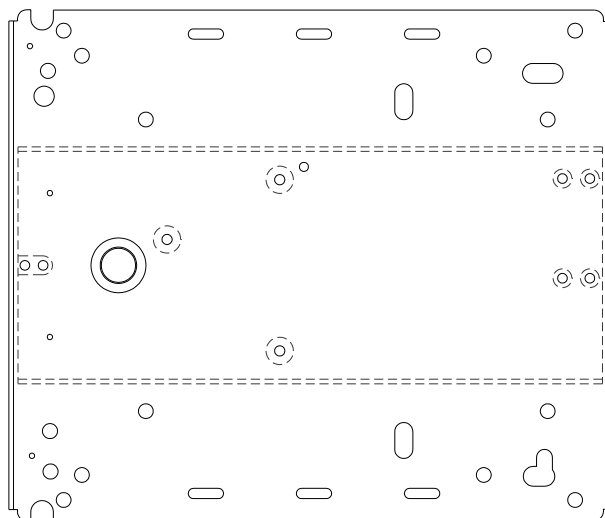
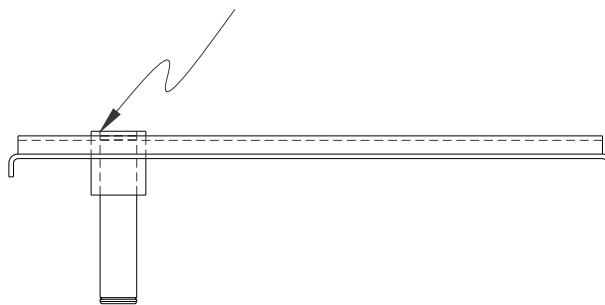
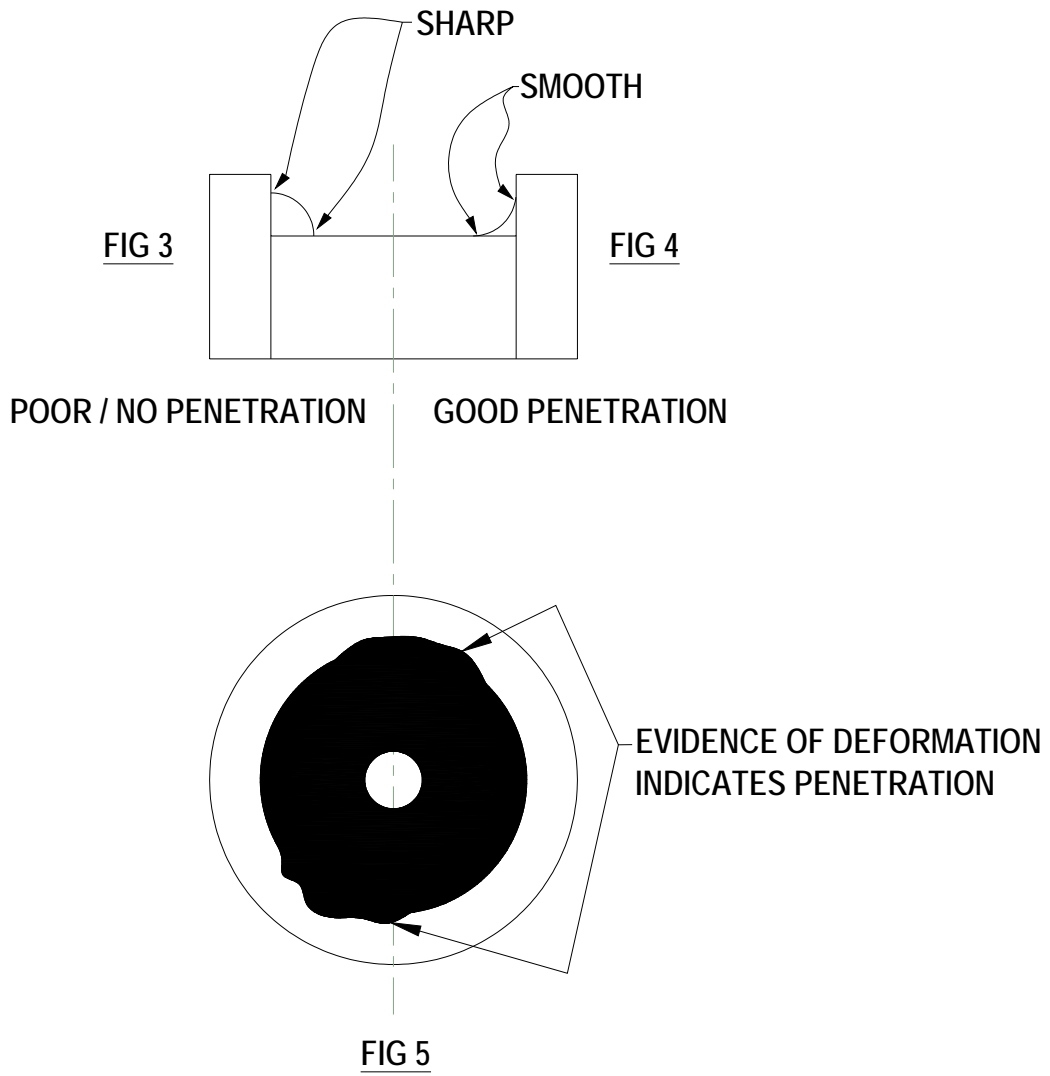


FIG. 2



NOTES: