



CHANCE RIDES MANUFACTURING, INC.
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U.S.A.
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Bulletin No:	B387CRM171-0
Release Date:	October 25, 2011
Effective Date:	October 25, 2011
Supersedes:	N / A
Completion Date:	November 25, 2011
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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Units

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

Abstract of Issue:
Mast Inspection

Reason For Release:

After many years of operation, the structural integrity of steel ride components can become compromised by deterioration including corrosion. Operation in coastal or other wet locations can make this condition more likely.

The vehicle (boat) on the SEA DRAGON amusement ride is equipped with a mast. Based on reports from the field and considering the age of these rides, CHANCE RIDES MANUFACTURING, INC. has determined that the structural integrity of the masts may have been compromised due to corrosion. If the mast is weakened sufficiently, it can fail, resulting in personal injury to passengers, operators or bystanders.

This bulletin describes the inspection procedure required for the mast.

Action to be Taken:

All owner/operators of the above noted amusement rides must inspect the mast for damage and/or deterioration as described on the following pages of this bulletin. This inspection must be performed initially within 30 days of the receipt of this bulletin. Thereafter, the mast must be inspected annually using the same procedure.

If damage, corrosion or other problems with the mast are found, contact CHANCE RIDES MANUFACTURING, INC.

As an alternative to inspection, the mast can be permanently removed from the ride. The function of the mast is decorative and it is not required for the operation of the ride. If the mast is removed, properly remove or shield all electrical connections at the mast mounting area to prevent accidental contact with any hazardous component. Do not operate the ride with the mast if the required inspections have not been performed.

Observe all safety information contained in the manufacturer's manuals. Make available this bulletin and all related technical information to personnel using the equipment.



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Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

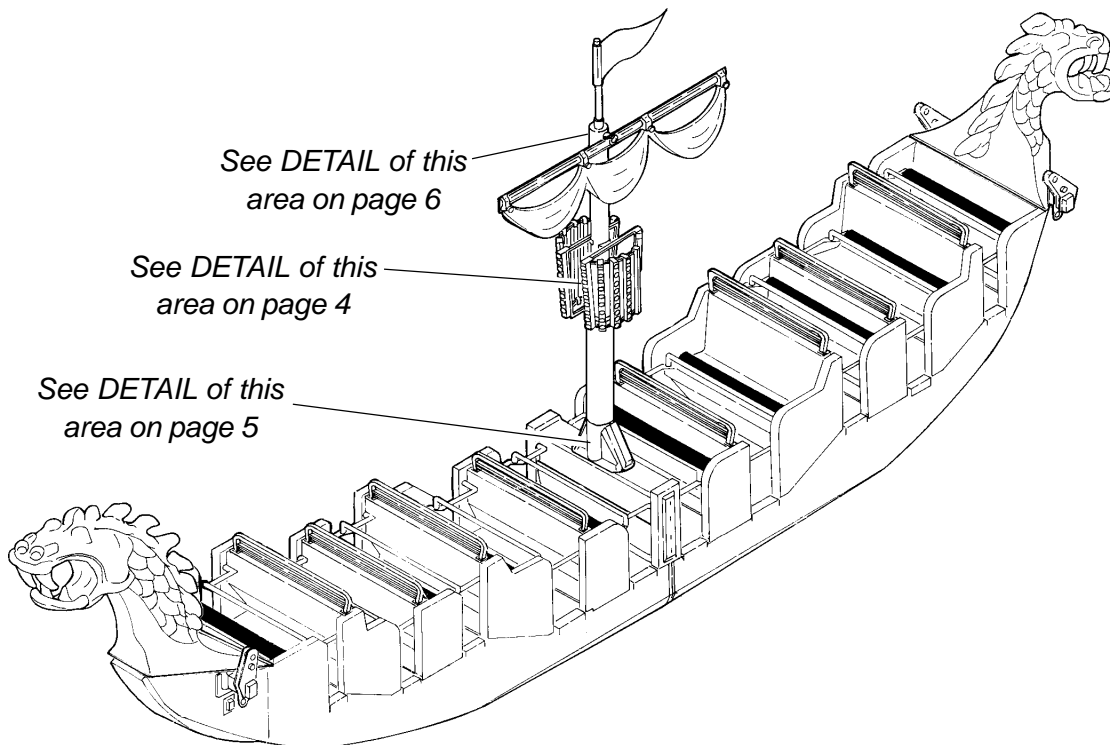
Model No.: 387

Detail of Issue (continued):

Mast Inspection

Inspection of the mast consists of visual inspection (VT), magnetic particle inspection (MT), and ultrasonic inspection (UT) as described on the next page.

IMPORTANT: This is an annual inspection.





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Model No.: 387

Detail of Issue (continued):

- **Visual Inspection**

Carefully inspect the entire mast for signs of damage, corrosion or other deterioration. Look for missing parts and/or openings which can allow moisture to enter the mast. Pay particular attention to the areas noted in the illustrations.

- **Magnetic Particle Inspection***

Inspect the welded joints in the areas shown at the top, center and bottom of the mast. Look for indications in the welds and the parent metal.

**IMPORTANT: This procedure must be performed by NDT personnel qualified in accordance with the American Society of Non-Destructive Testing (ASNT), SNT-TC-1A, certified as Level II or greater.*

- **Ultrasonic Inspection***

Inspect the material thickness in the area shown at the center and bottom of the mast. The original wall thickness of the tube is 1/8 inch (0.125 inch).

The minimum allowable thickness as determined by UT is 0.100 inch.

**IMPORTANT: This procedure must be performed by NDT personnel qualified in accordance with the American Society of Non-Destructive Testing (ASNT), SNT-TC-1A, certified as Level II or greater.*



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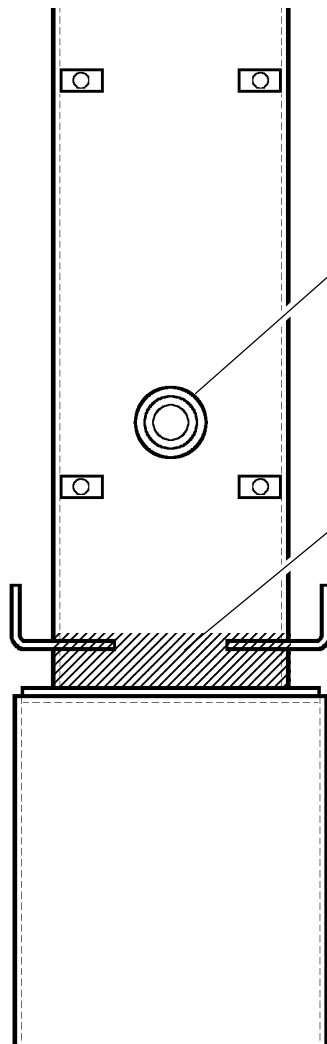
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Affected Serial Nos.: All Units

Model No.: 387

Detail of Issue (continued):

Inspection at Center of Mast



Inspect all openings in the mast. They must be properly sealed or plugged to prevent moisture from entering the mast. Where electrical wiring enters the mast, make sure there is a good seal around the wires or conduit.

Use UT to measure the thickness of the tube wall at the base of the tube next to the edge of the weld. Check all the way around the in a 1" band in the area indicated.

Use MT to check for indications at the weld between the tube and the cap.



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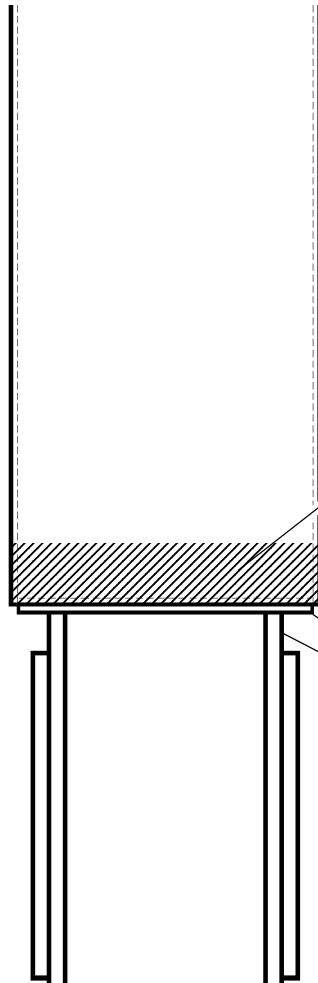
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Detail of Issue (continued):

Inspection at Base of Mast



Use UT to measure the thickness of the tube wall at the base of the tube next to the edge of the weld. Check all the way around the in a 1" band in the area indicated.

Use MT to check for indications at all welds, including the cap and the mounting ears.



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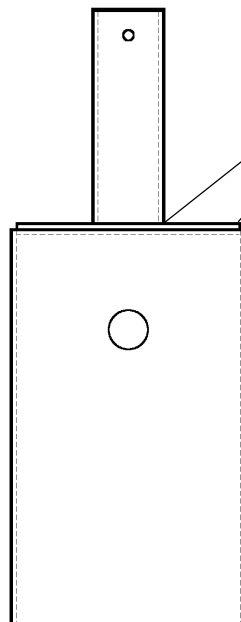
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Detail of Issue (continued):

Inspection at Top of Mast



Use MT to check for indications at all welds, including the cap and the socket

Chance Rides Manufacturing, Inc. issues notifications for the benefit of owners of amusement rides manufactured by Chance Rides Manufacturing, Inc. As a service to the industry, and in the interest of employee and public safety, Chance Rides Manufacturing, Inc. also issues notifications for the benefit of owners of amusement ride equipment for which the manufacturer no longer exists, such as the Allan Herschell Company, Chance Manufacturing Co., Inc., Chance Rides, Inc., etc. In doing so, Chance Rides Manufacturing, Inc. does not assume liability for losses associated with amusement ride equipment built by manufacturers other than Chance Rides Manufacturing, Inc.