



CHANCE RIDES MANUFACTURING, INC.
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Bulletin No: B414CRM103-0
Release Date: September 23, 2002
Effective Date: September 23, 2002
Supersedes: B414R1224-0,
P414R1253-0 and P414R1254-0
Completion Date: December 23, 2002
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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: Prior to May, 2001
Ride Name: INVERTER (Portable Model) Affected Serial Nos.: Prior to Ride Serial No. 414-03201
Model No.: 414

Abstract of Issue:
Mandatory Tower Hinge Bracket and Leveling Strut Rework

Reason For Release:
Chance Rides, Inc. service bulletin B414R1224-0, and notifications P414R1253-0 and P414R1254-0 are superseded by this bulletin and are no longer in effect.

Chance Rides Manufacturing, Inc. has determined that cracks can develop in the tower hinge on the above noted INVERTER amusement rides. An improved tower hinge design has been developed to strengthen the components in the hinge area.

Also, an improved leveling strut has been developed to replace the existing turnbuckle used during the set-up and tear-down of the ride. The new design provides additional strength in the leveling strut and its attaching lugs, and is easier to install and use correctly at every set-up and tear-down.

These improvements are not to be considered an alternative to the correct set-up and tear-down procedures. It is the owner/operator's responsibility to ensure that set-up/tear-down personnel are familiar with the procedures specified and that these procedures are followed. If the proper procedures are not followed, serious personal injury to workers and severe structural damage to the ride can occur.

Instructions on the use of the new components for set-up and tear-down are included with this bulletin. The remainder of the procedure in the *INVERTER Service Manual* is unchanged.

Action to be Taken:
All owner/operators of the above noted INVERTER amusement rides are required to order and install the tower hinge rework kit (part number K414R1253-0) and the Leveling Strut Kit (part number K414R1254-0) within 90 days of the issue date of this bulletin.

These kits include all necessary parts to rework one complete ride, with complete instructions for installation.



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Ride Name: INVERTER (Portable Model) Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Detail of Issue

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. Use only those components authorized, specified or provided by Chance Rides Manufacturing, Inc. All applicable OSHA safety standards and safe industry practices must be observed.

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

The Tower Hinge Bracket Kit, part number K414R1253-0, contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K414R1253-0	Drawing - Installation Instructions	1
414-0780-002	Center Ear Weldment	1
414-0780-003	Center Ear Weldment	1
414-0780-011	Plate - Formed Channel	1
414-0780-013	Plate - Side Hinge Ear	2
414-0780-015	Bar - Spacer	2
414-0780-005	Hinge Pin Weldment	2
60843000	Hex Head Capscrew (1/2-13 x 2-3/4 Grade 5)	2
64782400	Lock Nut (1/2-13 Nylon Insert)	2
68531800	Flat Washer (1/2)	4
68980600	Grease Zerk (1/8 PT x 90 Deg).	2



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Ride Manufacturer: CHANCE RIDES, INC.

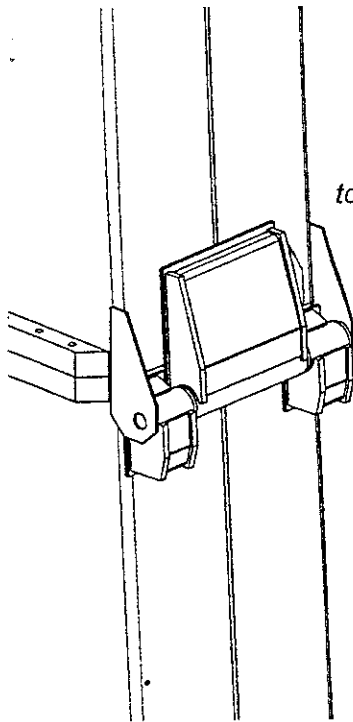
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Ride Name: INVERTER (Portable Model)

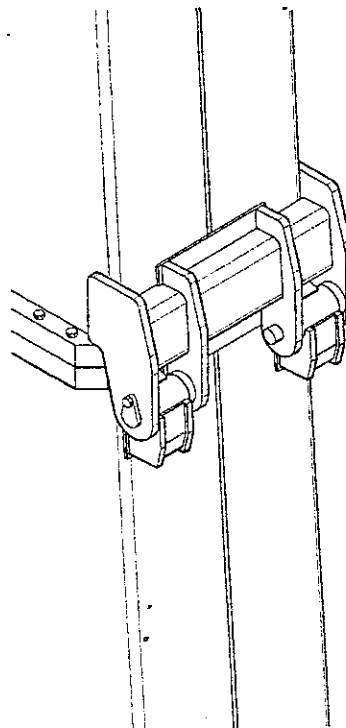
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Detail of Issue (continued):



Existing towerhinge



Reworked towerhinge



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Ride Name: INVERTER (Portable Model) Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Detail of Issue (continued):

The Leveling Strut Kit, part number K414R1254-0, contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K414R1254-0	Drawing - Installation Instructions	1
414-0952-001	Leveling Strut Assembly (Turnbuckle)	1
414-0515-028	Plate - Leveling Strut Ear	1
414-0730-063	Plate - Leveling Strut Ear	1
CSN10A10-01	Pin - 1-1/2 x 5.6875 G/L	2
65190500	Hairpin - 1/4"	2
414-0010-047	Decal - Set-Up	6
414-0010-048	Decal - Tear-Down	6



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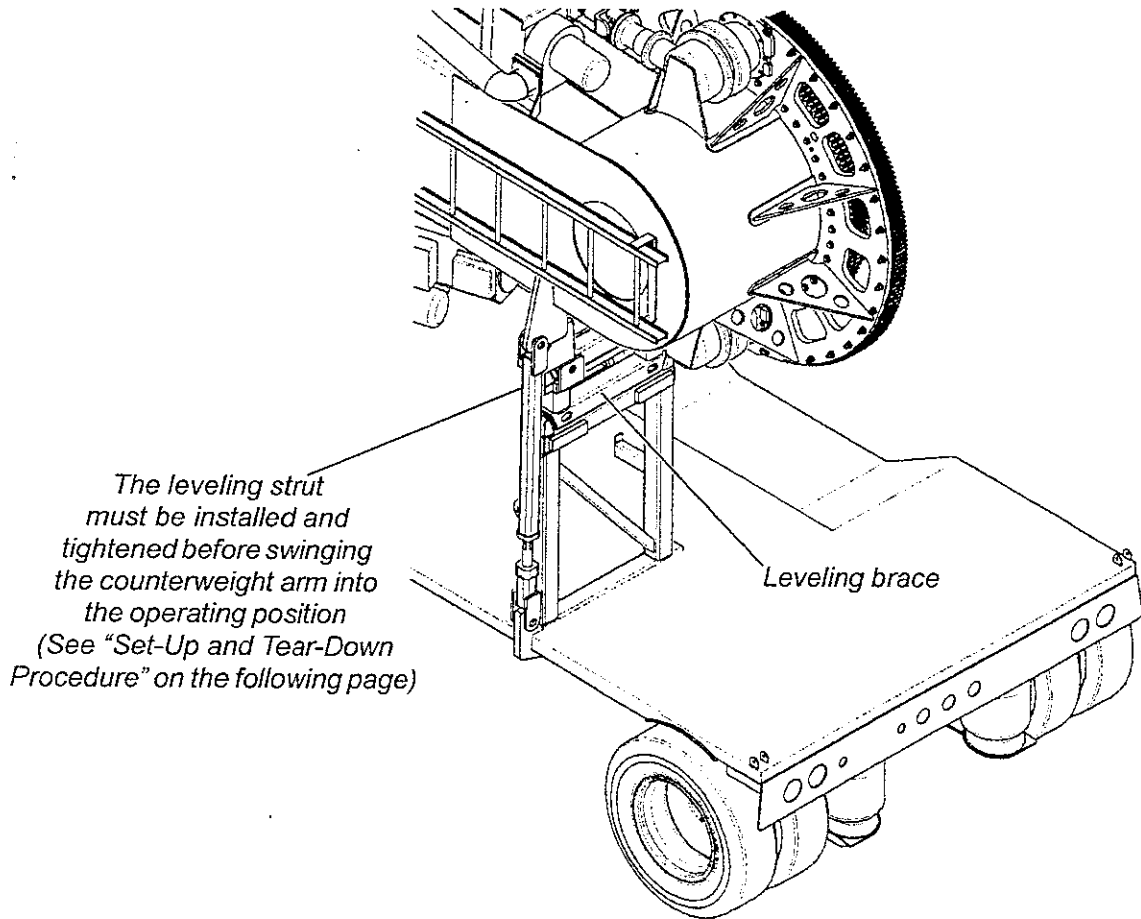
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Detail of Issue (continued):





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Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Detail of Issue (continued):

Set-Up and Tear-Down Procedure

Once the rework is completed, the leveling strut must be used during every set-up and tear-down. The existing turnbuckle will be used only to secure the tower in the roading position.

Revision pages for the *INVERTER Service Manual* are included with this bulletin, and provide detailed instructions on the procedures which are affected by the installation of this kit. Install the revision pages in your manual as soon as the rework is completed. If you have more than one copy of the service manual, order additional revision pages from the Customer Service Department at Chance Rides Manufacturing, Inc.

All owners must establish a training program which emphasizes the manufacturer's specifications as to how to correctly set-up and tear-down the ride and the hazards if the manufacturer's specifications are not followed. Never allow personnel under the counterweight arm or any other suspended load during set-up or tear-down of the ride.

Read the "Set-Up" section of the *INVERTER Service Manual*, and be thoroughly familiar with all safety information prior to erecting or dismantling the ride. This includes all warnings and cautions printed in the manual, service bulletins, and all safety signs and decals on the ride.

NOTE: To help insure the safety of the set-up/tear-down personnel, Chance Rides Manufacturing, Inc. supplies two decals which must be properly located on the ride. These decals, along with the instructions in the Set-Up Manual, will alert personnel to specific steps in the procedure.

These decals are included in the Leveling Strut Kit. The following pages show the decals and their proper placement on the ride.



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Model No.: 414

Detail of Issue (continued):



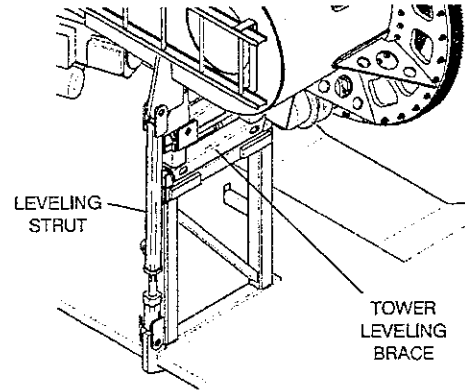
WARNING

DURING SET-UP

BEFORE REMOVING THE ARM-TO-ARM LOCKING BRACE AND UNFOLDING THE COUNTERWEIGHT ARM, INSTALL THE TOWER LEVELING BRACE AND SECURE WITH ALL PINS. THE LEVELING STRUT MUST BE INSTALLED AS SHOWN AND TIGHTENED. THE OUTRIGGERS MUST BE EXTENDED AND THE COUNTERWEIGHT SECTIONS FOLDED TOGETHER AND PROPERLY SECURED.

IF THIS PROCEDURE IS NOT FOLLOWED, THE COUNTERWEIGHT ARM, BEING HEAVIER AT THE UPPER END, WILL IMMEDIATELY SWING OUTWARD OUT-OF-CONTROL. SERIOUS PERSONAL INJURY AND/OR EQUIPMENT DAMAGE CAN RESULT.

FOR COMPLETE INSTRUCTIONS, SEE THE SET-UP MANUAL.



414-0010-047



WARNING

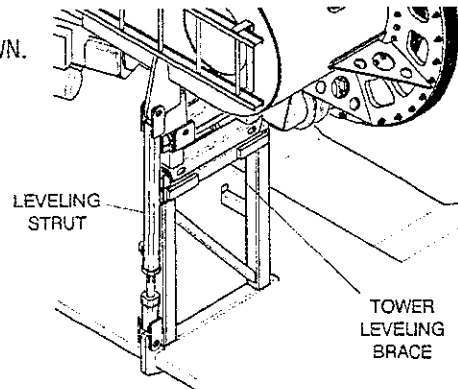
DURING TEAR-DOWN

INSTALL THE MAIN ARM SAFETY PIN BEFORE STARTING TEAR-DOWN.

BEFORE REMOVING THE CAPSCREWS AND PIN WHICH SECURE THE COUNTERWEIGHT ARM TO THE MAIN ARM, LOWER THE TOWER ONTO THE LEVELING BRACE AND SECURE WITH ALL PINS AND HAIRPINS. INSTALL THE LEVELING STRUT AS SHOWN AND TIGHTEN.

IF THIS PROCEDURE IS NOT FOLLOWED, THE COUNTERWEIGHT ARM, BEING HEAVIER AT THE UPPER END, WILL IMMEDIATELY SWING OUTWARD OUT-OF-CONTROL. SERIOUS PERSONAL INJURY AND/OR EQUIPMENT DAMAGE CAN RESULT.

FOR COMPLETE INSTRUCTIONS, SEE THE SET-UP MANUAL.



414-0010-048



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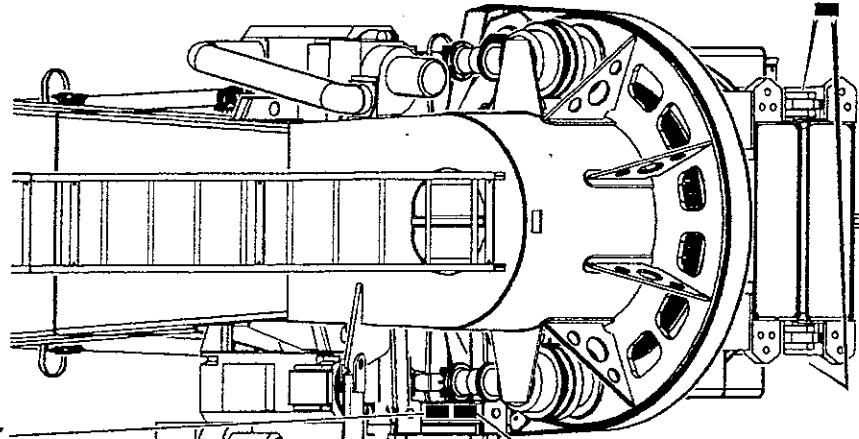
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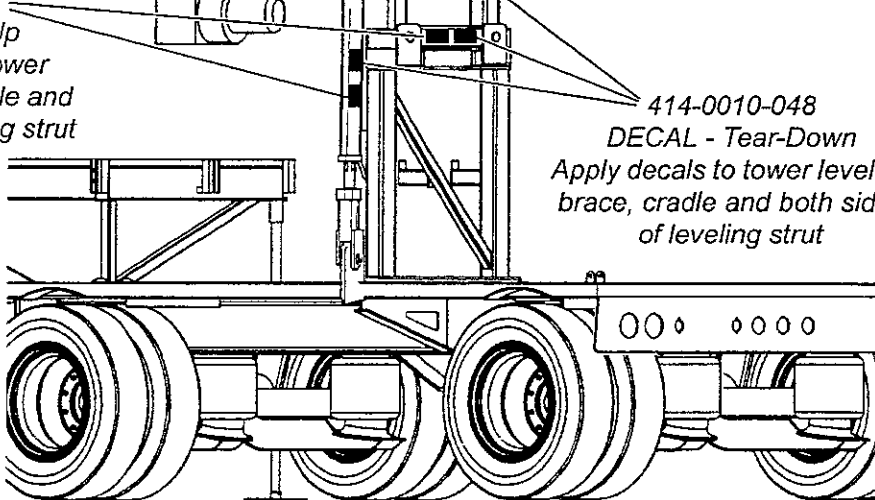
Model No.: 414

Detail of Issue (continued):

*414-0010-048 DECAL - Tear-Down
Apply decal to both sides of
counterweight arm near bolting flanges*



*414-0010-047
DECAL - Set-Up
Apply decals to tower
leveling brace, cradle and
both sides of leveling strut*



*414-0010-048
DECAL - Tear-Down
Apply decals to tower leveling
brace, cradle and both sides
of leveling strut*



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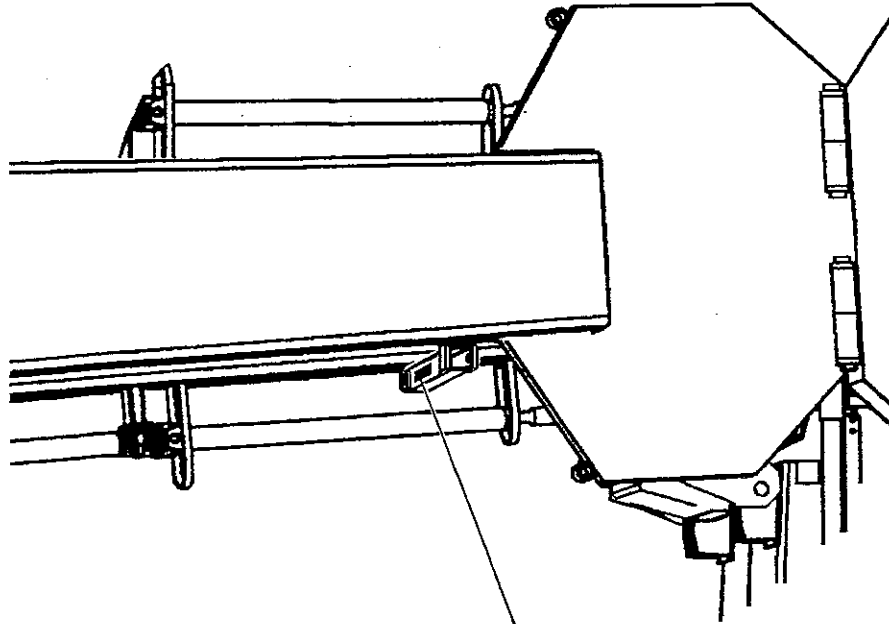
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Detail of Issue (continued):



*414-0010-048 DECAL - Set-Up
Apply decals to both sides of arm-to-arm brace*

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.