



CHANCE RIDES, INC.
4219 Irving
Wichita, KS 67277-2328
U.S.A.
Phone: 1-800-242-6231 • FAX: 1-316-942-7416
Website: www.rides.com
E-mail: rides@rides.com

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| Bulletin No: | B414R1266-0 |
| Release Date: | February 12, 2002 |
| Effective Date: | February 12, 2002 |
| Supersedes: | N/A |
| Completion Date: | See Text |
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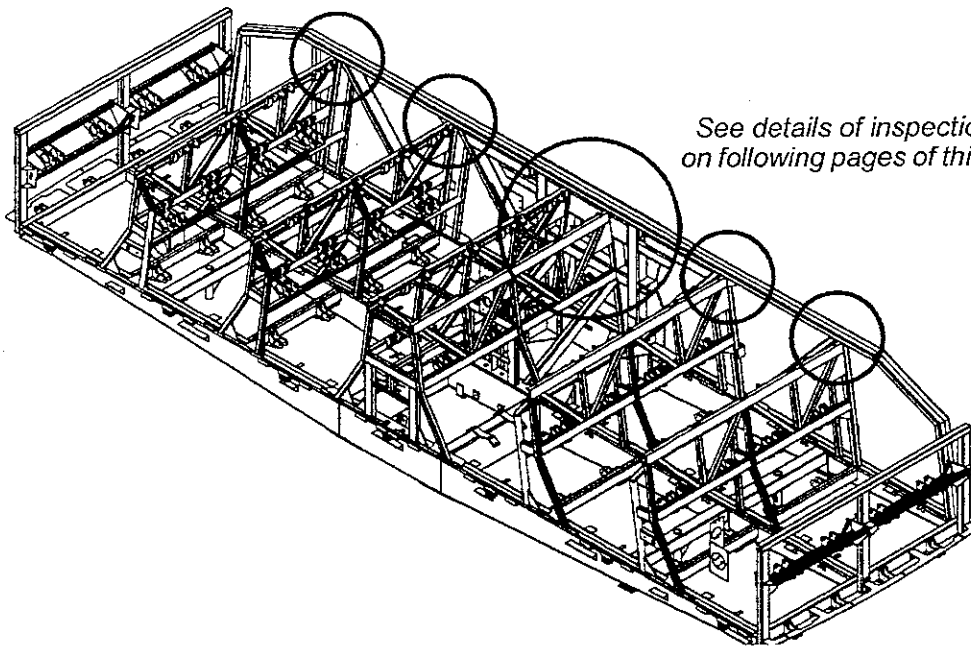
SERVICE BULLETIN

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|--------------------|--|----------------------------|--|
| Ride Manufacturer: | CHANCE RIDES, INC. | Affected Production Dates: | All Prior to 2002 |
| Ride Name: | INVERTER (Park Model) DOUBLE INVERTER | Affected Serial Nos.: | 414-004S99 through 414-012S00 414-001D99 through 414-013D01 |
| Model No.: | 414 | | |

Abstract of Issue:
Vehicle Frame Inspection and Rework

Reason For Release:
Chance Rides, Inc. has become aware that cracks can form in certain areas of the vehicle frame on the above noted INVERTER amusement rides. A rework kit has been developed to reinforce these areas.

Action to be Taken:
Chance Rides, Inc. requires all owner/operators of these rides to immediately inspect the vehicle frame as described in this bulletin. Thereafter, perform the inspection annually. The rework kit must be installed before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque.



*See details of inspection areas
on following pages of this bulletin.*



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Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model) Affected Serial Nos.: 414-004S99 through 414-012S00
DOUBLE INVERTER 414-001D99 through 414-013D01

Model No.: 414

Detail of Issue

Perform the inspection described on the following pages of this bulletin.

- **If any indications are found, DO NOT CONTINUE OPERATION OF THE RIDE.** Contact the Chance Customer Service Department immediately for instructions on further action to be taken.

DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE VEHICLE FRAME, EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES INC.

- **If no indications are found,** perform the inspection annually. Order and install the Vehicle Frame Rework Kit, part number K414R1266-1 before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque (two kits are required for DOUBLE INVERTER). Detailed installation instructions are provided with the kit.

DO NOT INSTALL THE REWORK KIT IF THERE ARE CRACKS IN THE VEHICLE FRAME UNTIL REPAIRS SPECIFIED BY CHANCE RIDES, INC. ARE MADE.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation.

NOTICE

Use only those components authorized, specified or provided by Chance Rides, Inc.

Chance Rides, Inc. **SPECIFICALLY DISCLAIMS ANY LIABILITY** for losses associated with any unauthorized alterations and/or modifications or additions and installations of unauthorized components.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-004S99 through 414-012S00
414-001D99 through 414-013D01

Model No.: 414

Detail of Issue (continued):

PREPARATION OF VEHICLE FOR INSPECTION

To inspect the vehicle, it is necessary to remove the two center seats, modify the existing openings in the other four seats, and remove two panels from the outside of the back wall of the vehicle (on each side of the main arm).

Removal of Two Center Seats

The following are the major steps required to remove the seats. Refer to the illustration on the next page. This procedure requires at least two people. As parts are removed, note exactly how each component is installed. Label all components clearly so they can be installed in the same location as they were removed.

1. Remove the access panels from the bottom of the vehicle.
2. Remove the headrest pads and headrests.
3. Disconnect the air cylinder and hydraulic lock cylinder from each shoulder restraint bar. Pay attention to the location of the bushings and all mounting hardware.
4. Remove the retainer caps which secure the shoulder bar pivot tubes in the pivot ears.
5. Slide the pivot tubes out and remove the shoulder bars. If necessary, loosen the capscrews which mount the pivot ears to the vehicle frame.
6. Drill out the rivets which secure the step valve guard and the control panel frame.
7. Remove the capscrews and rivets which secure the fiberglass seats to the frame.
8. Carefully remove the seats from the ride, being careful not to bind or damage any wires, hoses or other components.

IMPORTANT: Install the seats in the reverse order of the disassembly procedure. Be sure to tighten all fasteners to the correct torque as specified in the INVERTER Service Manual. Thoroughly check the operation of all components of the passenger restraint system before putting the ride back into service.



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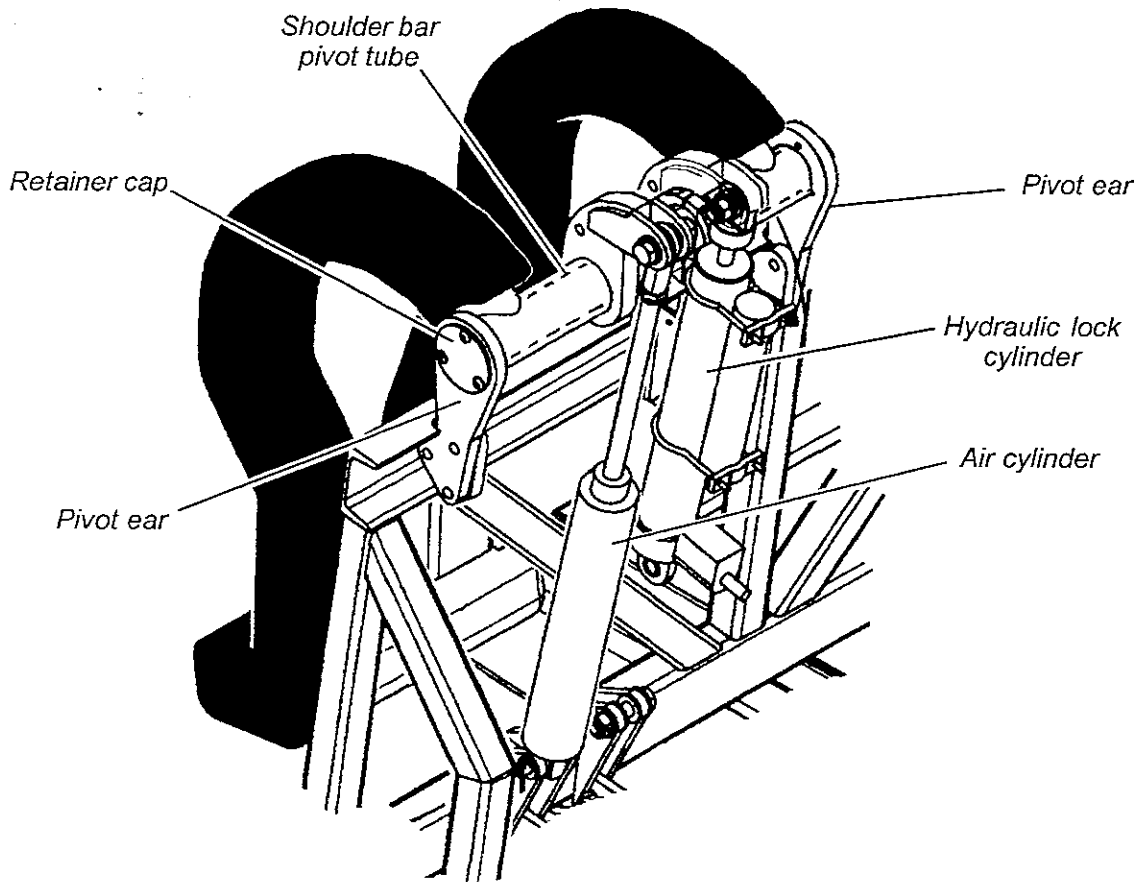
Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-004S99 through 414-012S00
414-001D99 through 414-013D01

Model No.: 414

Detail of Issue (continued):





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Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-004S99 through 414-012S00
414-001D99 through 414-013D01

Model No.: 414

Detail of Issue (continued):

Modification of Four Outer Seats (two seats at each end of the vehicle)

It is necessary to enlarge the existing openings in the four outer seats and aluminum panels along the inside of the back wall. This will allow access to the vehicle frame for inspection in these areas. Use a die grinder or rotary trimming tool for this procedure.

IMPORTANT: *When cutting the fiberglass seats and aluminum back wall panel, BE EXTREMELY CAREFUL NOT TO CUT INTO THE STEEL VEHICLE FRAME MEMBERS. This will severely weaken the frame and require extensive repair before the ride can be operated.*

After trimming, remove all burrs or sharp edges from the cutout areas to prevent injury.

1. Raise the shoulder bar fully to gain access to the area to be trimmed.
2. Using a suitable cutting bit, enlarge the opening for the shoulder bar support nearest the back wall as shown in the first photo.
3. After the fiberglass has been trimmed, the aluminum panel will be visible. Trim the aluminum panel as shown in the second photo.

NOTE: *Before trimming the aluminum panel, grind off the rivet head securing the end of the panel and pry the panel slightly away from the frame. This allows trimming without damaging the steel frame underneath.*

Removal of Back Cover Panels

Remove the screws which secure the back cover panels to the vehicle on each side of the main arm.



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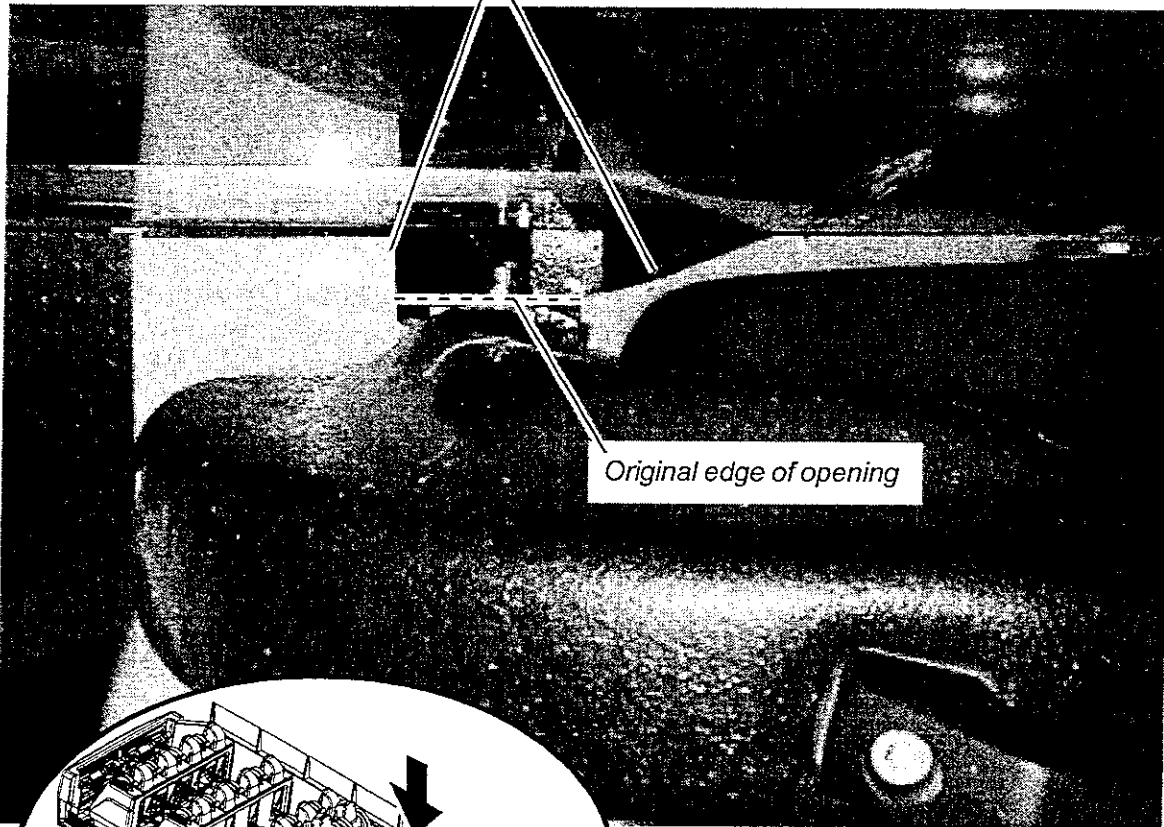
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DOUBLE INVERTER

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414-001D99 through 414-013D01

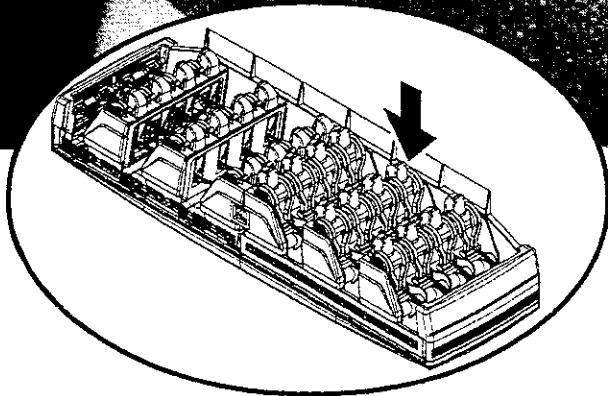
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Detail of Issue (continued):

Cut fiberglass to enlarge opening



Original edge of opening



TOP VIEW OF SEAT AT BACK WALL



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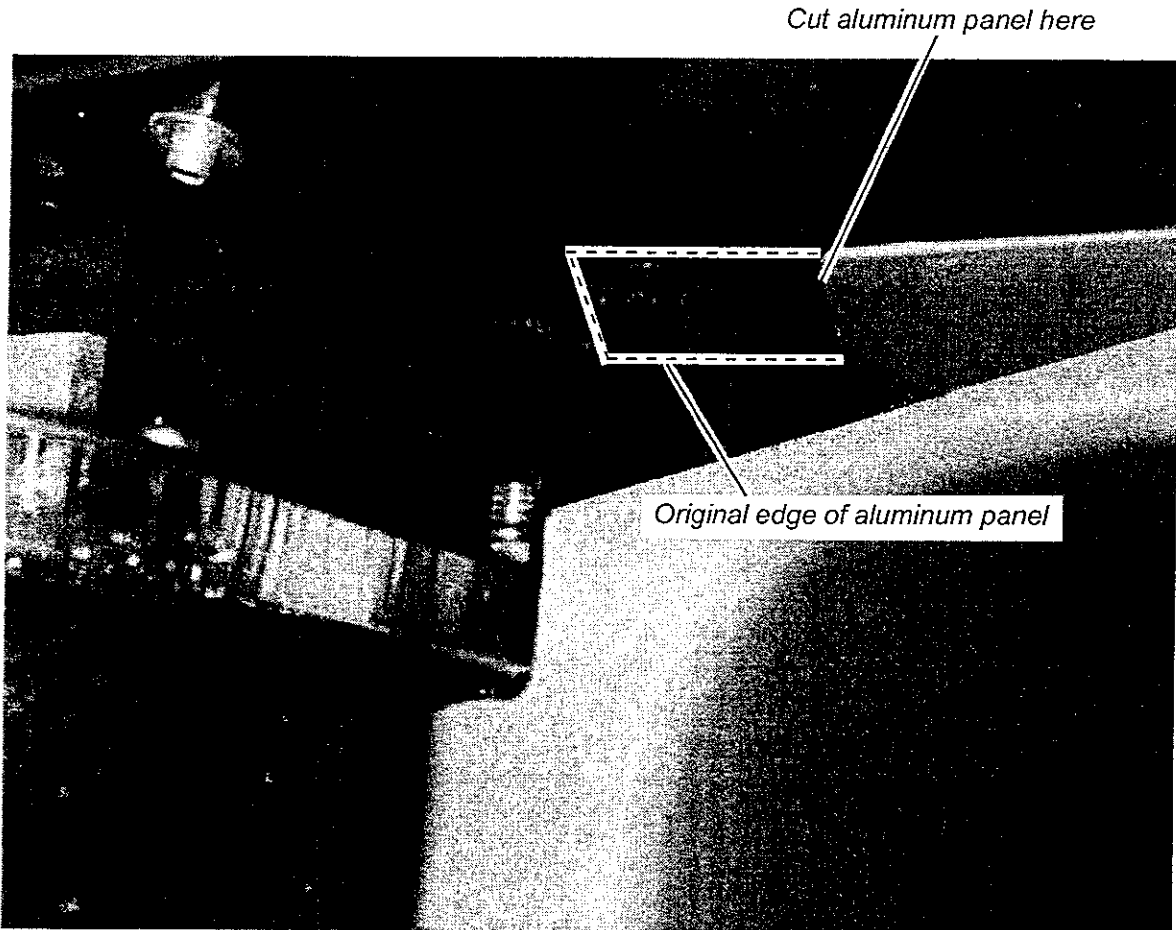
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DOUBLE INVERTER

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Detail of Issue (continued):



SAME AREA AFTER FIBERGLASS SEAT HAS BEEN TRIMMED



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DOUBLE INVERTER Affected Serial Nos.: 414-004S99 through 414-012S00
414-001D99 through 414-013D01

Model No.: 414

Detail of Issue (continued):

INSPECTION PROCEDURE

Visually inspect the vehicle frame structure in the areas indicated in the illustrations on the following pages.

1. In the center section of the vehicle frame, inspect all sides of each joint, looking for indications in the welds or the parent metal.
2. Inspect the cutouts in the two channels in the center of the vehicle frame. Note whether the cutouts have round or square corners. Inspect the area around the cutouts for indications.
3. Inspect the cutouts in the channels in the four outer seats (two seats at each end of vehicle). Note whether the cutouts have round or square corners. Inspect the area around the cutouts for indications. This inspection is similar to Step #2.

NOTE: *The cutouts are visible through the existing openings in the fiberglass, so disassembly of the seats is not required. If necessary, enlarge the openings slightly to permit inspection of these areas. Be careful not to cut into the vehicle frame structure.*

4. With the aid of an inspection mirror and light, thoroughly inspect the welded joints between the channel and the horizontal frame member at the four outer seats. Inspect all sides of each joint, looking for indications in the welds or the parent metal. Repeat the inspection on all four seats.



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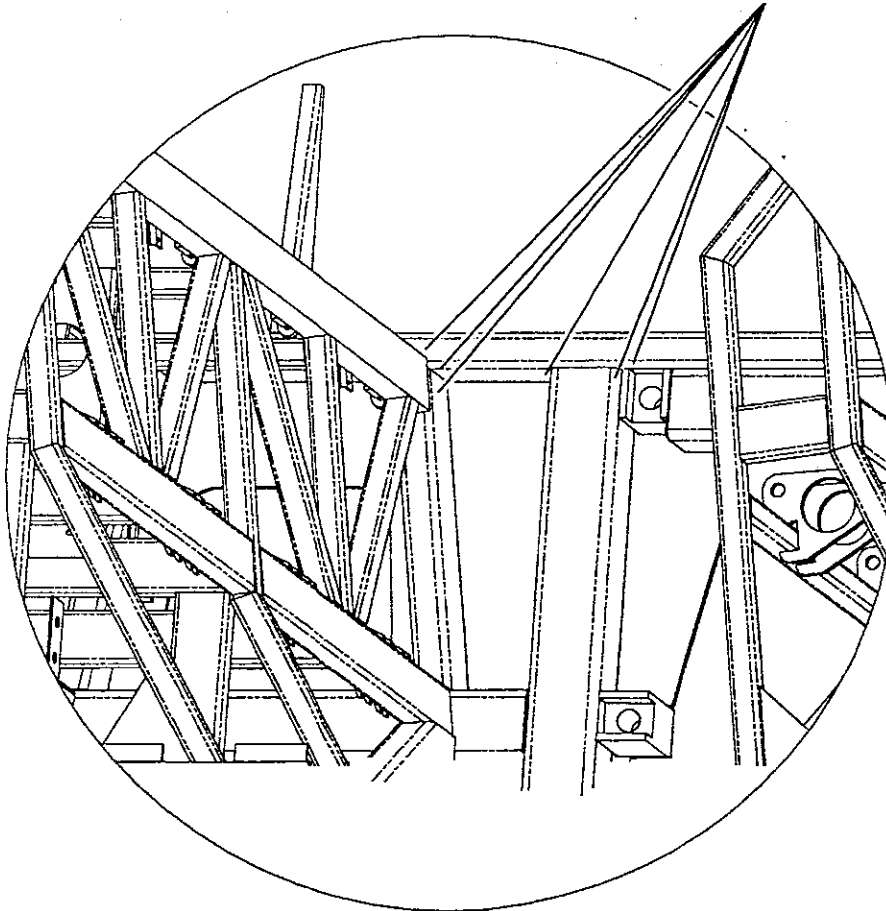
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DOUBLE INVERTER

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414-001D99 through 414-013D01

Model No.: 414

Detail of Issue (continued):

Inspect for cracks in these areas on both sides of the vehicle mounting plate. Carefully inspect all sides of each joint, looking for indications in the welds and the parent metal.



NOTE: For clarity, fiberglass seats and back panel are not shown in some views.



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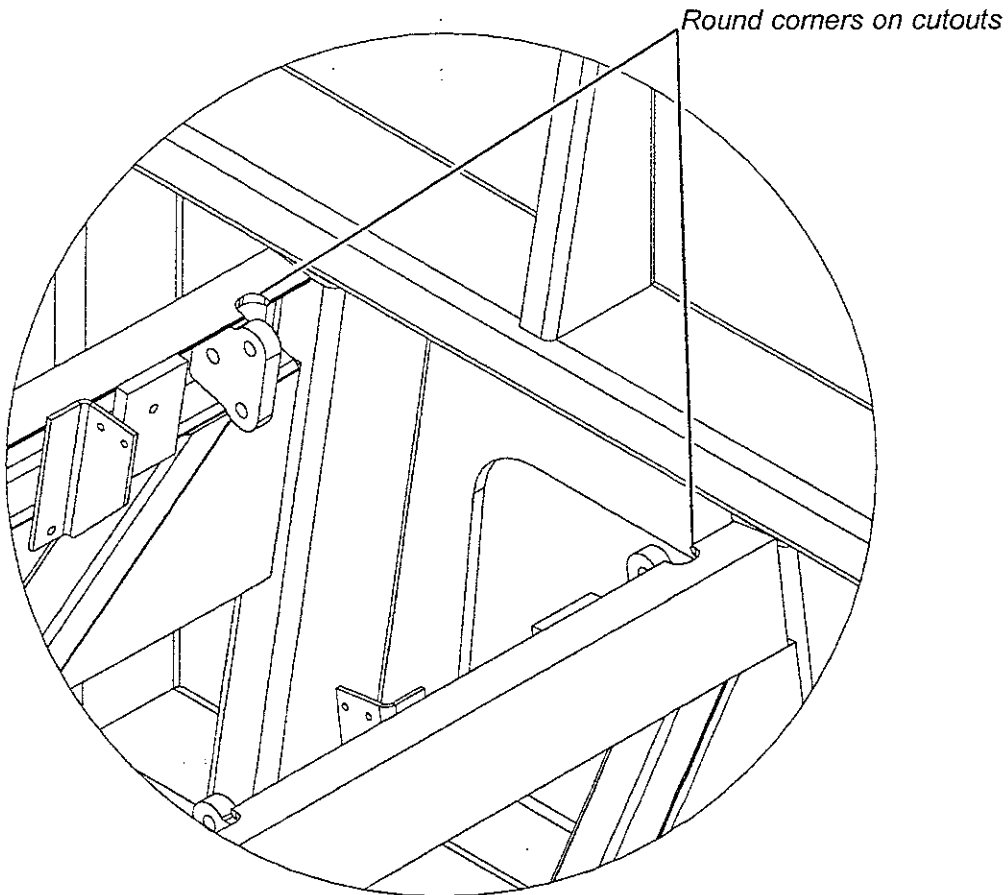
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Detail of Issue (continued):





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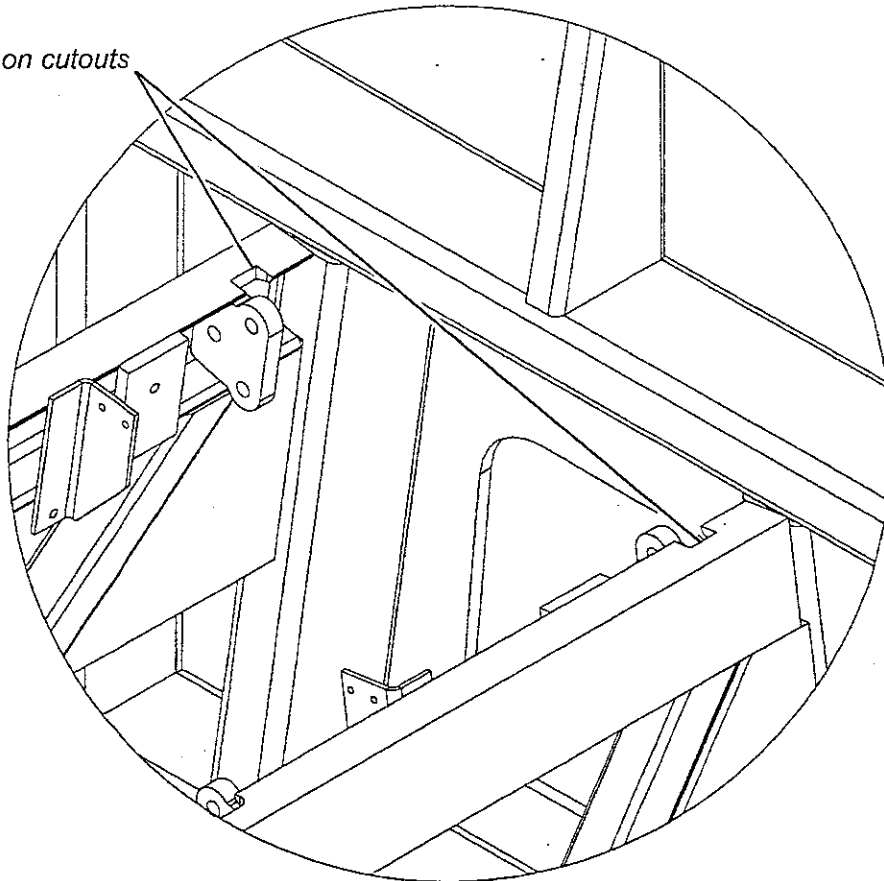
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Detail of Issue (continued):

Square corners on cutouts





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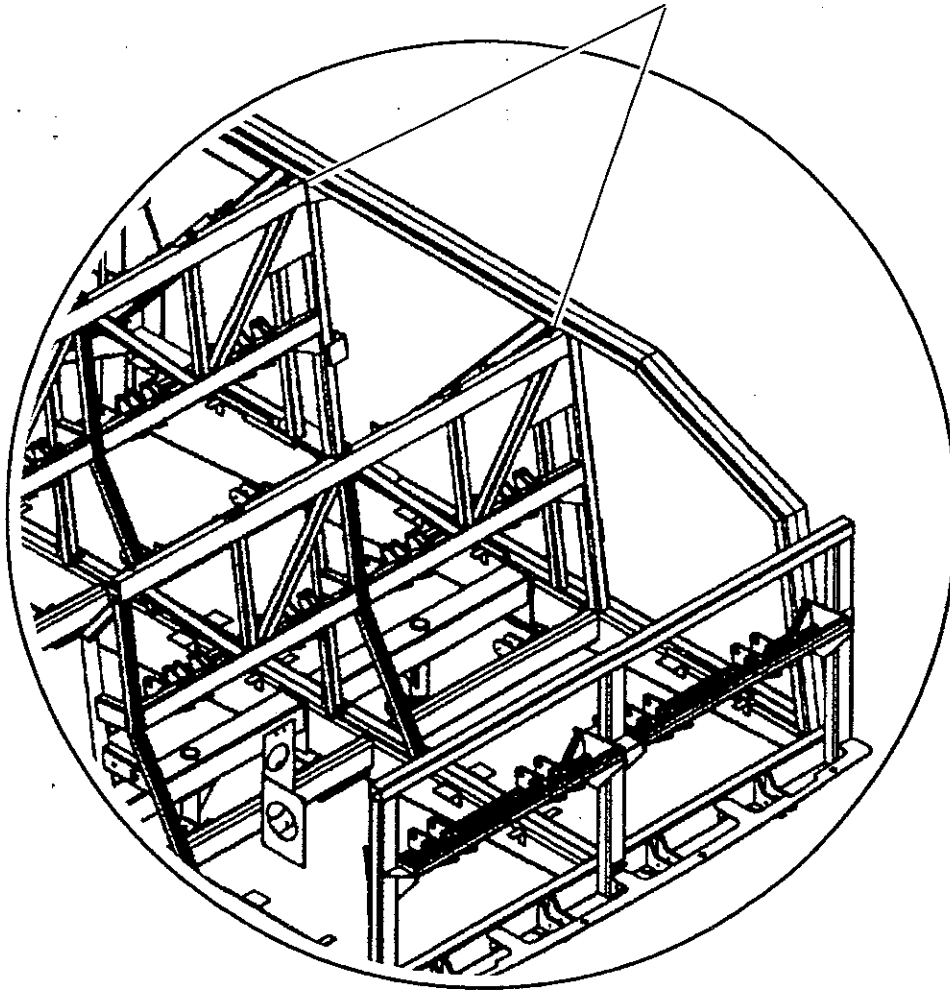
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DOUBLE INVERTER

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Detail of Issue (continued):

*Inspect the welded joints on
these channels at both ends
of vehicle*





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DOUBLE INVERTER 414-001D99 through 414-013D01

Model No.: 414

Detail of Issue (continued):

VEHICLE FRAME REWORK

IMPORTANT: *The Vehicle Frame Rework Kit must be installed before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque.*

After inspection is complete, order and install the Vehicle Frame Rework Kit, part number K414R1266-1. The kit includes all necessary parts to rework one complete vehicle, and includes detailed installation instructions. Two kits are required for DOUBLE INVERTER.

DO NOT INSTALL THE REWORK KIT IF THERE ARE CRACKS IN THE VEHICLE FRAME UNTIL REPAIRS SPECIFIED BY CHANCE RIDES, INC. ARE MADE.

ANNUAL INSPECTION

Inspect the vehicle annually, using the same procedure as outlined in this bulletin. If any indications are found, contact the Chance Customer Service Department immediately. **DO NOT CONTINUE OPERATION OF THE RIDE.**