



**CHANCE**  
MANUFACTURING CO., INC.

Number: 872-209-00  
Date: 7-22-80

America's Largest Manufacturer of Amusement Rides

# Service Information

ALL UNITS

**Effective Serial Numbers:**

**Ride:** SEA DRAGON

**Subject:** LAP BAR CYLINDERS

Chance Manufacturing Co., Inc. has been made aware of the fact that there may be defective seals on Sea Dragon lap bar cylinders.

Therefore, we request all Sea Dragon owners make a thorough inspection of the lap bar cylinders and Bellofram diaphragms for hydraulic fluid leakage. This simple procedure is accomplished by removing seat end panels and checking for the presence of hydraulic fluid on or around lap bar components.

If fluid is present on either cylinders or diaphragms, Chance Manufacturing Co., Inc. has available through our parts department, replacement cylinders (#272-21708) or a diaphragm kit (which replaces a set of Bellofram diaphragms) #K72-0209-00.

Full credit will be issued upon return of defective parts, if returned to Chance Manufacturing Co., Inc. before 12-31-80.

If you have any questions concerning this inspection, please contact Chance Manufacturing Co., Inc.

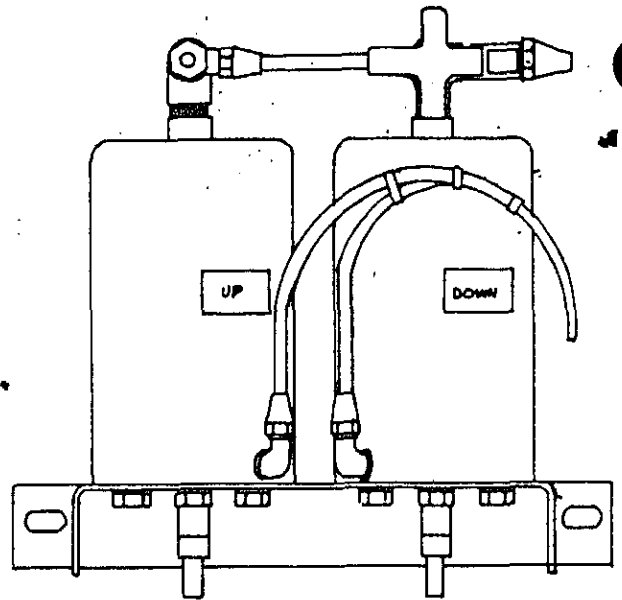
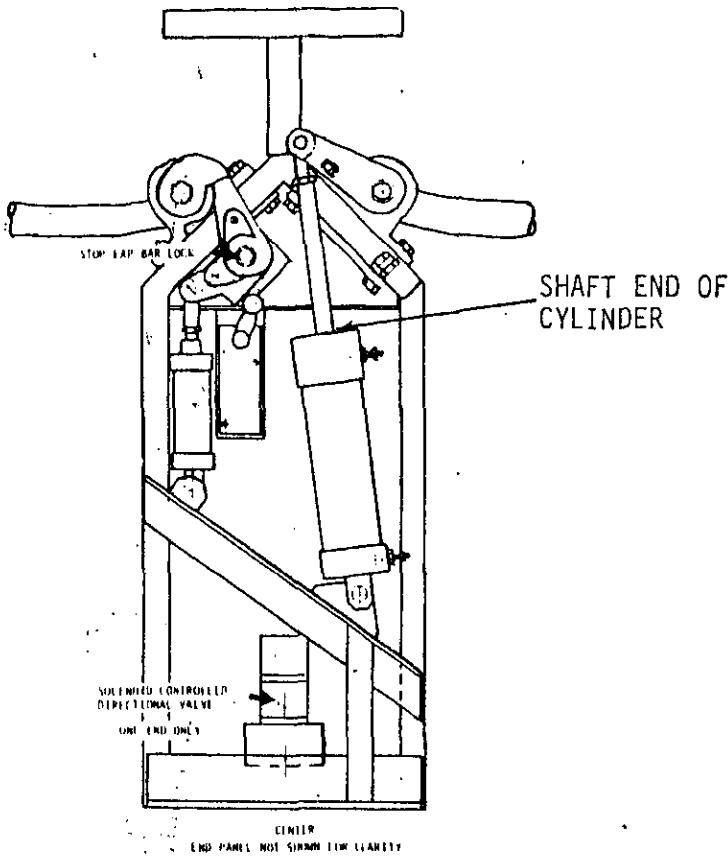
Factory and General Office, 4219 Irving, P.O. Box 12328 Wichita, Kansas 67277

Sales Office:

1103 Ross Ave., Dallas, Texas 75202

Area Code (316) 942-7411

Area Code (214) 742-3802



BELLOFRAM DIAPHRAGMS

NOTE: This kit replaces one set only, 5 sets must be ordered for complete boat change.

PARTS LIST

QUANTITY	DESCRIPTION	PART NUMBER
1.....	DRAWING. (387-161A).....	SHEET 2
1.....	DRAWING (K72-0209-00).....	SHEET 1
4.....	1/2-20 x 3/4" HEX HEAD BOLTS.....	686-08274
4.....	1/2 to 3/8" REDUCER BUSHINGS.....	688-27010
1.....	3/8" CLOSE NIPPLE .....	688-27662
1.....	"UP" DECAL.....	272-21935
1.....	"DOWN" DECAL.....	272-21936
2.....	ADVANCE BRAND CYLINDERS.....	272-21713
2.....	1/2-13 HEX NUTS.....	691-47516
1.....	BLEED SCREW.....	685-64366
1.....	BLEED PLUG.....	372-54531
1.....	1/2 to 1/8" NPT BUSHING REDUCER.....	688-27006
1.....	DRILL TEMPLATE (ONE TO CUSTOMER).....	372-78220



Number:

Date: B72-0211-00

9-9-80

Supersedes:

*America's Largest Manufacturer of Amusement Rides*

# SERVICE BULLETIN

Effective Serial Numbers:

Ride:

ALL UNITS

Subject:

SEA DRAGON

KEEL INSPECTION

A condition has occurred on one ride in which cracks occurred in the welds on the underside of the boat keel. We are requesting that all owners of Sea Dragons immediately inspect the areas described in the following illustration, and report your findings to Chance Manufacturing Co., Inc.

These areas should be established as "Special Care Areas" and given regular weekly visual inspections by qualified individuals.

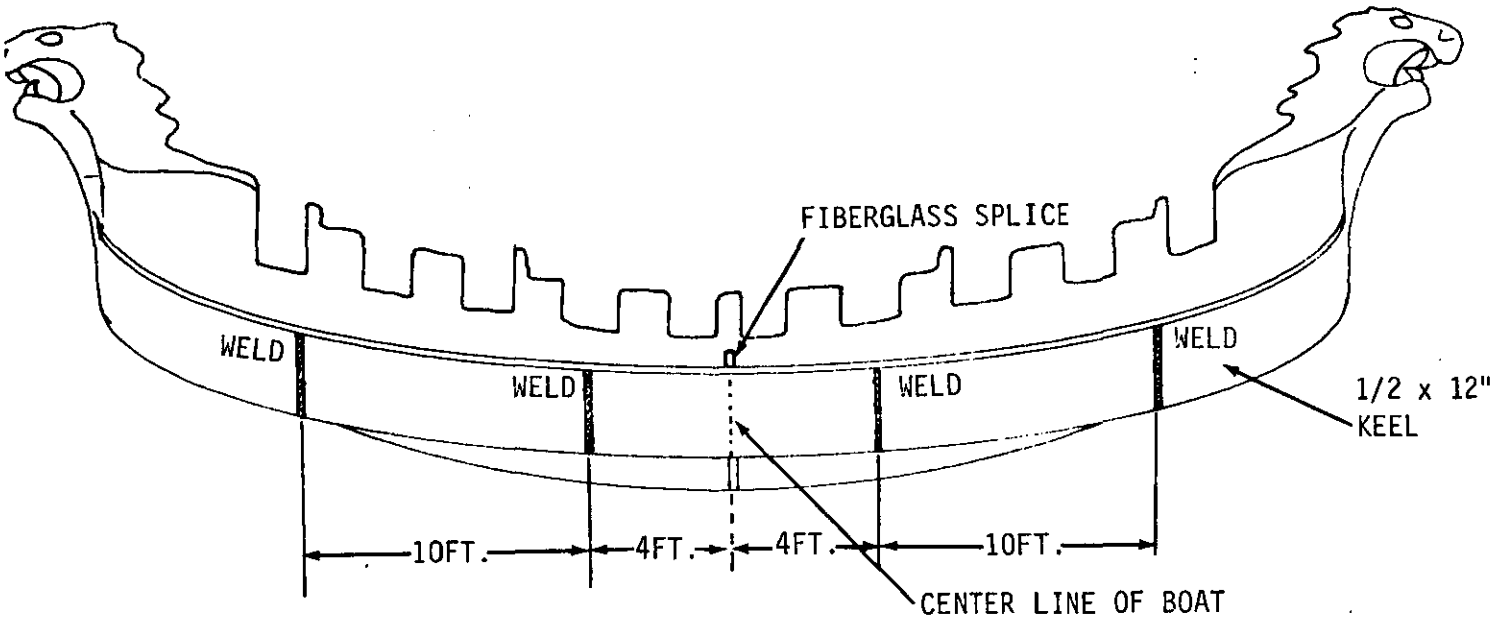
All inspections must be performed by competent, qualified mechanics capable of understanding the function of the parts.

The attached Certification of Compliance must be completed and returned to Chance Manufacturing Co., Inc. within seven (7) days of receipt of this bulletin.

If you have any questions concerning this bulletin, please contact Chance Manufacturing Co., Inc. for assistance.

Inspection of the four welds on the bottom of the keel should be made. Welds are located one to each side of center, approximately four (4) feet, and one approximately fourteen (14) feet either side of center (or ten (10) feet from first weld).

All welds should be visually inspected for cracks or signs of stress on a weekly basis.



BOAT TILTED TO SIDE FOR EASE OF ILLUSTRATION



**CHANCE**  
MANUFACTURING CO., INC.

Number: B72-0214-00

Date: 2-11-81

Supersedes:

America's Largest Manufacturer of Amusement Rides

# Service Bulletin

Effective Serial Numbers: UNITS 4 THROUGH 11

Ride: SEA DRAGON

Subject: LAP BAR SYSTEM

Chance Manufacturing Co., Inc. has developed a lap bar conversion kit (K72-0214-00) for the Sea Dragon. This kit replaces the air over hydraulic actuation of the lap bars to improve reliability and reduce maintenance. The new system retains the automatic locking features of the original system, but actuation of the bars is controlled by the passengers with a spring retraction for release.

The kit has been designed for field installation by the ride owner with no welding or cutting required. This kit is offered at no charge provided original components are returned to Chance.

The kit should be ordered from our parts department. Field service of factory installation will be available at a nominal cost.

LAP BAR CONVERSION KIT NUMBER K72-0214-00

CONSISTING OF:

QUANTITY	DESCRIPTION	D.P. NUMBER
1	SERVICE BULLETIN	B72-0214-00
10	AIR CYLINDER - SMT 1-1/8 x 1	273-21715
10	EXTENSION SPRING #68	272-72217
9	ADAPTOR CONNECTOR TEE #205106	685-01814
10	ADAPTOR CONNECTOR 90° #205522	685-01612
50	TUBING INSERT 3/8" #246089	685-01700
1	ADAPTOR CONNECTOR 90° #205102	685-01606
1	BUSHING REDUCER 1/2 x 1/4 NPT	688-27008
1	CLOSE NIPPLE 1/4 NPT	688-27658
10 FT.	1/2" SYN FLEX, BLACK #3250-0810	490-80120
60 FT.	3/8" SYN FLEX, RED #3250-0612	490-80102
6	TUBING INSERT 1/2" #246090	685-01702
10	LOCK, LAP BAR 387-040-1	372-41756
10	STOP, LAP BAR 387-041-1	372-74213
10	MOUNT 387-042-1	372-45052
10	ARM 387-043-1	372-02737
10	SLEEVED PILLOW BLOCK ASSY. 387-046-1	372-06357
10	HEX HEAD CAPSCREW 1/2-13 x 2-1/4"	686-08426

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10.....	HEX HEAD CAPSCREW	3/8-16 x 1-1/2"	.....686-07670
10.....	HEX HEAD CAPSCREW	1/4-20 x 1"	.....686-07004
10.....	WROT WASHER	1/2"	.....696-85312
10.....	FLAT WASHER	SAE 1/2"	.....696-85318
10.....	CLEVIS PIN	1/2 DIA x 1-1/4"	.....290-52355
10.....	CLEVIS PIN	1/2 DIA x 1-1/2"	.....290-53356
10.....	HEX LOCK NUT	1/2-13	.....691-47824
10.....	HEX JAM NUT	3/8-16	.....691-47604
10.....	HEX LOCK NUT	1/4-20	.....691-47808
20.....	COTTER PIN	1/8 x 1"	.....699-51630
	(Install in 387-041 before shipping)		
1.....	OPERATOR	10250T-4011	.....273-48416
1.....	COVER	7420-B	.....272-20794
1.....	KNOB	10250T KB	.....273-38976
1.....	#K72-0214-00 SHEETS: 1,2,3,4,5,6 SEAT KIT		
1.....	#388-440 LAP BAR CONTROL INSTALLATION		
1.....	#387-161B - LAP BAR AIR SCHEMATIC		

Before installing this kit, read the instructions completely and familiarize yourself with the parts in the kit. Make certain all parts have been received. If any parts are missing, notify Chance Manufacturing Co., Inc. immediately. Do not substitute an inferior grade or material or parts.

All work must be performed by competent, qualified mechanics capable of understanding the functions of these parts and their proper installation.

If any questions arise concerning the installation of this kit, please contact Chance Manufacturing Company for assistance.

#### INSTALLATION INSTRUCTIONS

To change from the self-operating air over oil lap bar system to air and manual system, use the following steps:

1. Remove the seat end covers and lower kick panels from all seats.
2. See Sheet #2 of K72-0214-00 for existing configuration of hydraulic and air components.
3. See Sheet #3 of K72-0214-00 and remove or disconnect all parts of hydraulic or air system not shown. Replace existing air cylinders with those provided in kit. Remove rod end and jam nut from old cylinders and reuse.
4. See sheet #4 of K72-0214-00 for new plumbing installation. Use parts provided in kit to plumb. See Drawing #387-161B, lap bar air schematic.
5. See Sheet #5 of K72-0214-00 and install all new component parts as shown. Only one end of center lap bar stand is shown, but installation is typical for all lap bar stands. If for any reason the spline shaft on either end of the lap bar has been twisted, it must be straightened, or a new lap bar installed. Lap bars may be returned to factory for straightening. After installation of new components, check height of lap bar in the down and locked position. From the bottom of the lap bar, to the top of the seat, measured vertically, should be 5 1/2" + 1/2".

6. See Sheet #6 of K72-0214-00 for new electrical central switch mounting and conduit re-routing as well as new electrical schematic. See drawing #388-440-2 Assembly for Installation of New Switch and Cover.
7. Before replacing end panels and kick panels, cycle lap bars several times to be sure of proper operation.
8. Replace end panels and kick panels.



Number: B387R1053-0

Date: March 23, 1990

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## SERVICE BULLETIN

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Effective Serial Number: All Units - Chance Rides, Inc.

All Units - Chance Manufacturing Co. Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing company, Inc.

Ride: SEA DRAGON

Subject: Seat Back Grab Rails  
and Safety Decals

A kit is now available to provide additional safety to passengers as they enter and exit the SEA DRAGON. Chance Rides, Inc. requires that each owner of SEA DRAGON amusement rides install this kit and return the attached Certification Of Compliance within 15 days from receipt of the kit.

Order kit number K387R1053-0, which includes all necessary parts and hardware for one complete ride. Install the kit using the instructions provided on the reverse side of this bulletin.

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.



PARTS LIST

The following parts are included in Kit No. K387R1053-0:

<u>Item Number</u>	<u>Part Number</u>	<u>Description</u>	<u>Quantity Required</u>
1	3-7822300	Template	1
2	3-0378512	Support Braces	4
2	3-0378513	Support Braces	4
3	3-3096500	Grab Rail	4
4	6-1144300	1/4-20 x 1-1/4 P.H.	32
5	2-2193002	Safety Decal Seat Back (387-104-001)	10
6	2-2193003	Safety Decal Seat Back (387-104-002)	10
7	2-2193004	Safety Decal Seat Back (387-104-003)	10

INSTALLATION INSTRUCTIONS

1. Remove both seat sides from the seats indicated in Illustration A.

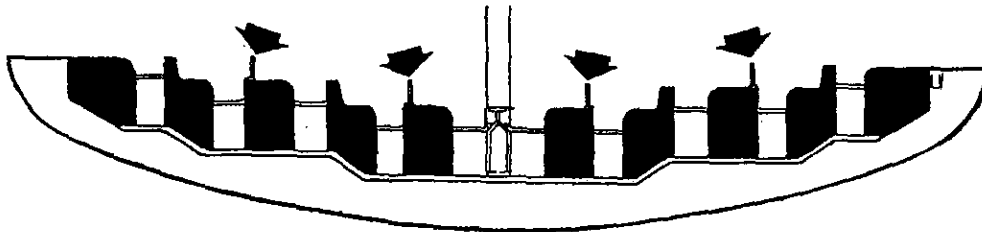


ILLUSTRATION A

2. Position template (Item #1) over seat back, as shown in Illustration B. Center template and drill holes (8 places) marked by template using a 9/32" drill bit.

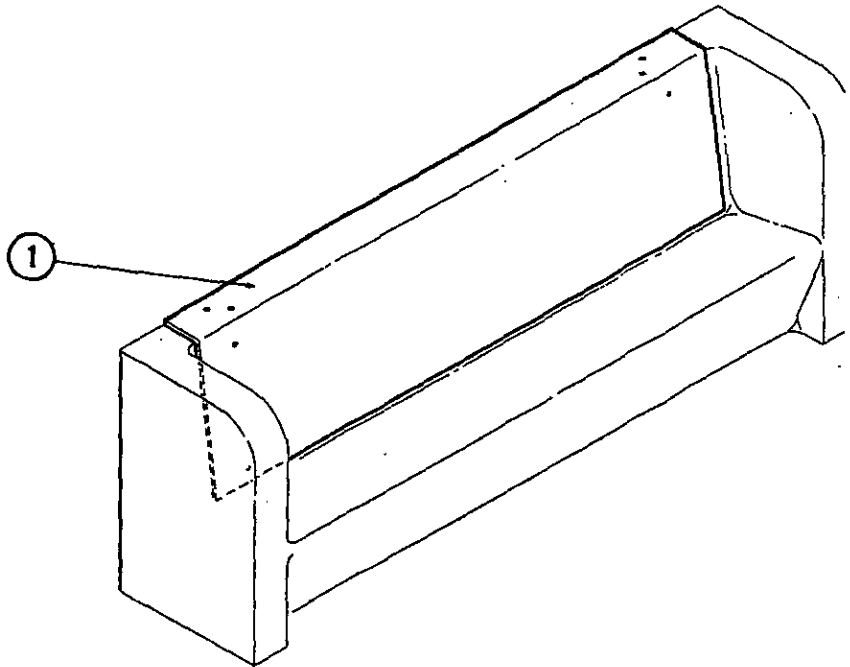


ILLUSTRATION B

3. Install grab rail support braces (Item #2) as shown in Illustration C, on inside of seats with 1/4-20 x 1-1/4 bolts supplied with the kit (Item #4). Braces have tapped holes. Remove any rivet which prevents brace from sitting flush with seat back.
4. Mount grab rail (Item #3) on top of seat back as shown in Illustration C. Use 1/4-20 x 1-1/4 bolts to secure in place.
5. Repeat this procedure on the other three remaining seats as identified in Illustration A.

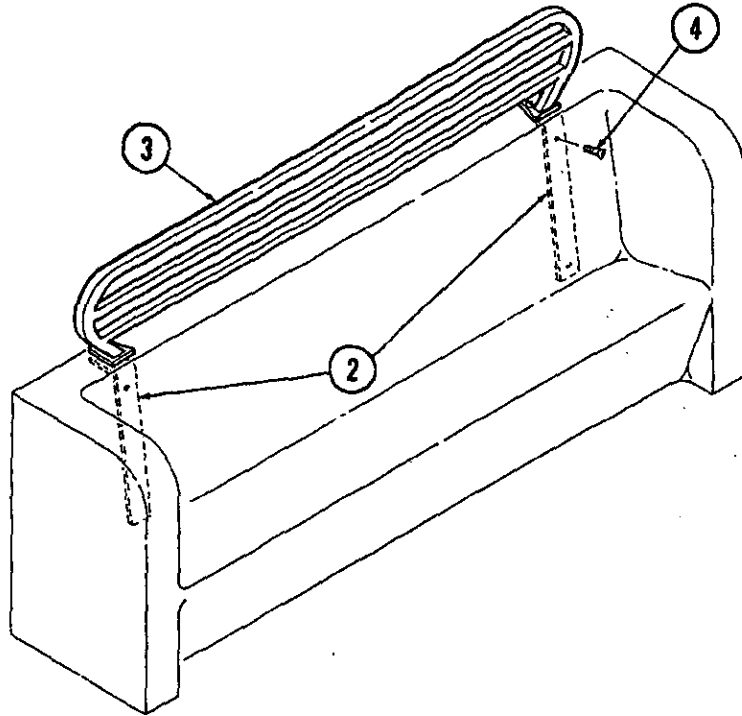


ILLUSTRATION C

6. Mount safety decals (Item #5, 6, and 7) over old decals on seat backs and at mast area so that it is visible to the passengers, as shown in Illustration D.

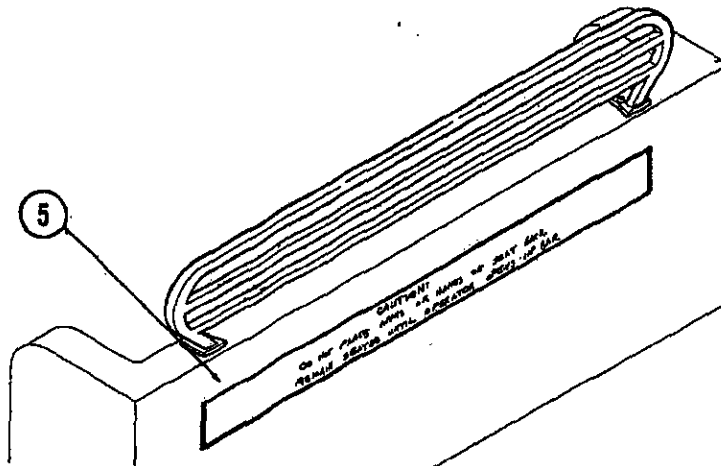


ILLUSTRATION D



NUMBER: B387R1078-0

DATE: MAY 16, 1990

SUPERSEDES: B72-0238-00

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## SERVICE BULLETIN

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Effective Serial Number: All Units - Chance Rides, Inc.  
All Units - Chance Manufacturing Co., Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing Company, Inc.

Ride: SEA DRAGON Subject: Lap Bar Adjustment

Chance Rides, Inc. requires all owners of SEA DRAGON amusement rides to inspect the lap bars for proper adjustment. If the lap bars are not adjusted properly cracks can develop adjacent to the weld joining the stainless steel lap bar to the main cross tube, as shown, as point "A" in the following illustration. If upon inspection it is found that the lap bars are out of adjustment, they must be inspected at both ends at point "A" for small cracks adjacent to the weld on the cross tube or the stainless steel tube. Report any cracks to Chance Rides, Inc.

Inspect the release of each lap bar to see that it does not slam into the "UP LOCK" position when released. Proper adjustment releases the bar from the "DOWN LOCK" position and lifts it upward so that it stops at approximately 45 degrees as shown in "C" allowing the passengers to move it on into the "UP LOCK" position.

Remove the left hand seat cover, "when sitting in the seat", to gain access to the return spring for adjustment.

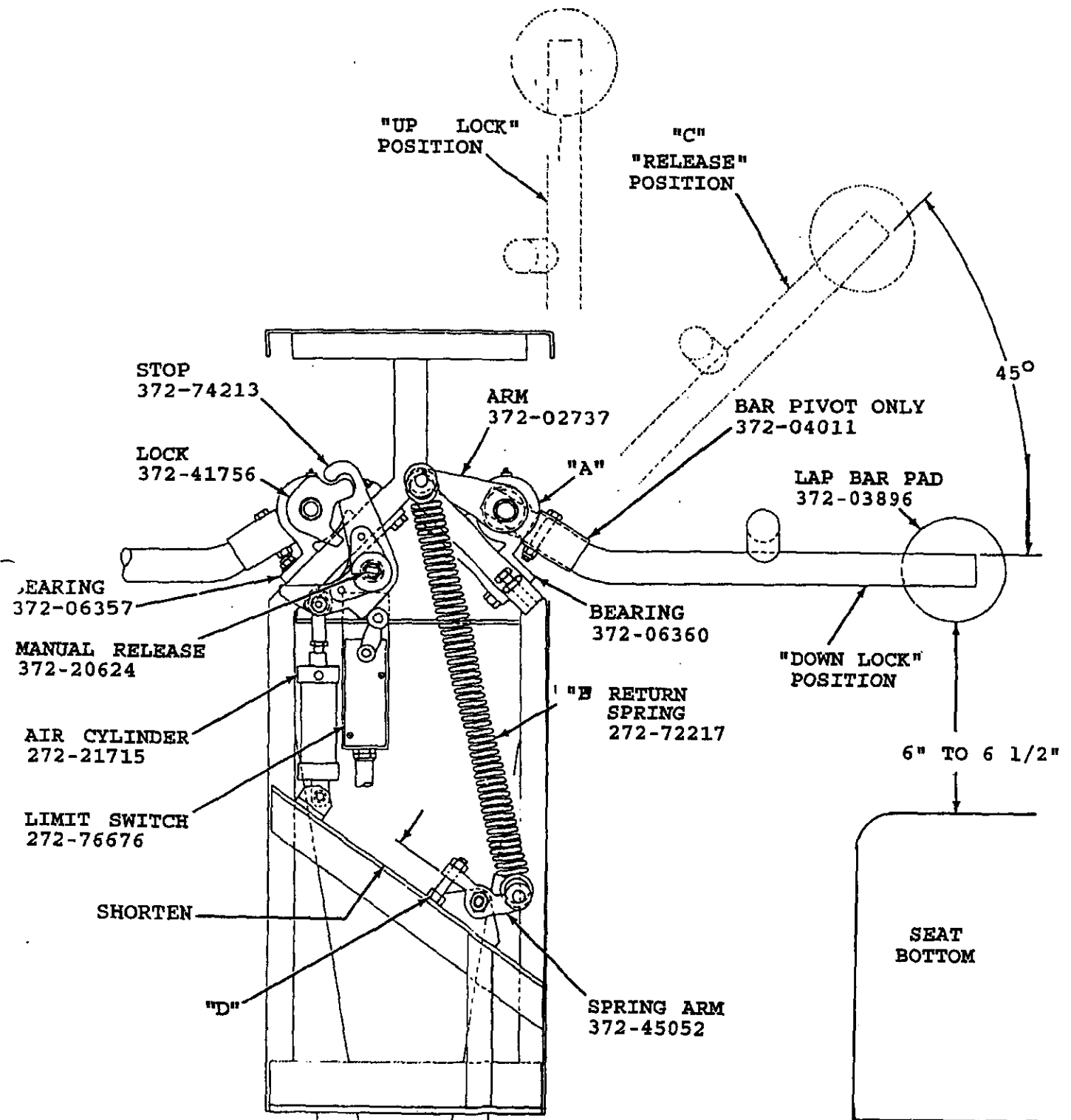
Shorten the length of the stop bolt "D" to reduce the tension on return spring "B" until release of the lap bar is reduced so that it does not move directly into "UP LOCK" but swings up and settles at approximately 45 degrees as shown at "C".

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.



INSPECT FOR CRACKS AT "A"



NUMBER: B387R1082-0

DATE: JULY 27, 1990

SUPERSEDES:

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## SERVICE BULLETIN

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Effective Serial Number: All Units - Chance Rides, Inc.

All Units - Chance Manufacturing Co., Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing Company, Inc.

Ride: SEA DRAGON

Subject: Caution Step - Decals

Chance Rides, Inc. has become aware that it is possible for a person to step between the vehicle and the platform on the SEA DRAGON ride. This may result in injury to the person. ALL OPERATORS MUST VERBALLY CAUTION PERSONS AS THEY STEP INTO AND OUT OF THE SEA DRAGON VEHICLE.

The space between the vehicle and the platform is required in order to maintain a minimum safe clearance during operation. This clearance may vary due to wind or other external factors.

A safety decal kit has been developed to help alert persons, as they enter and exit the vehicle. Rides, Inc. requires all owners/operators of SEA DRAGON amusement rides to order the following kit and to install it as shown on the reverse side of this bulletin. Order kit number K387R1082-0 which contains the following decals. This kit is being offered free of charge, if ordered within 90 days of the date on this bulletin.

<u>Item No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Quantity Required</u>
1	22197902	Caution - Watch Your Step	10
2	22197904	Caution - Step Down	10
3	22197903	Caution - Watch Your Step	10

Complete the attached Certification Of Compliance and return it to Chance Rides, Inc. within fifteen (15) days from the receipt of the kit.

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

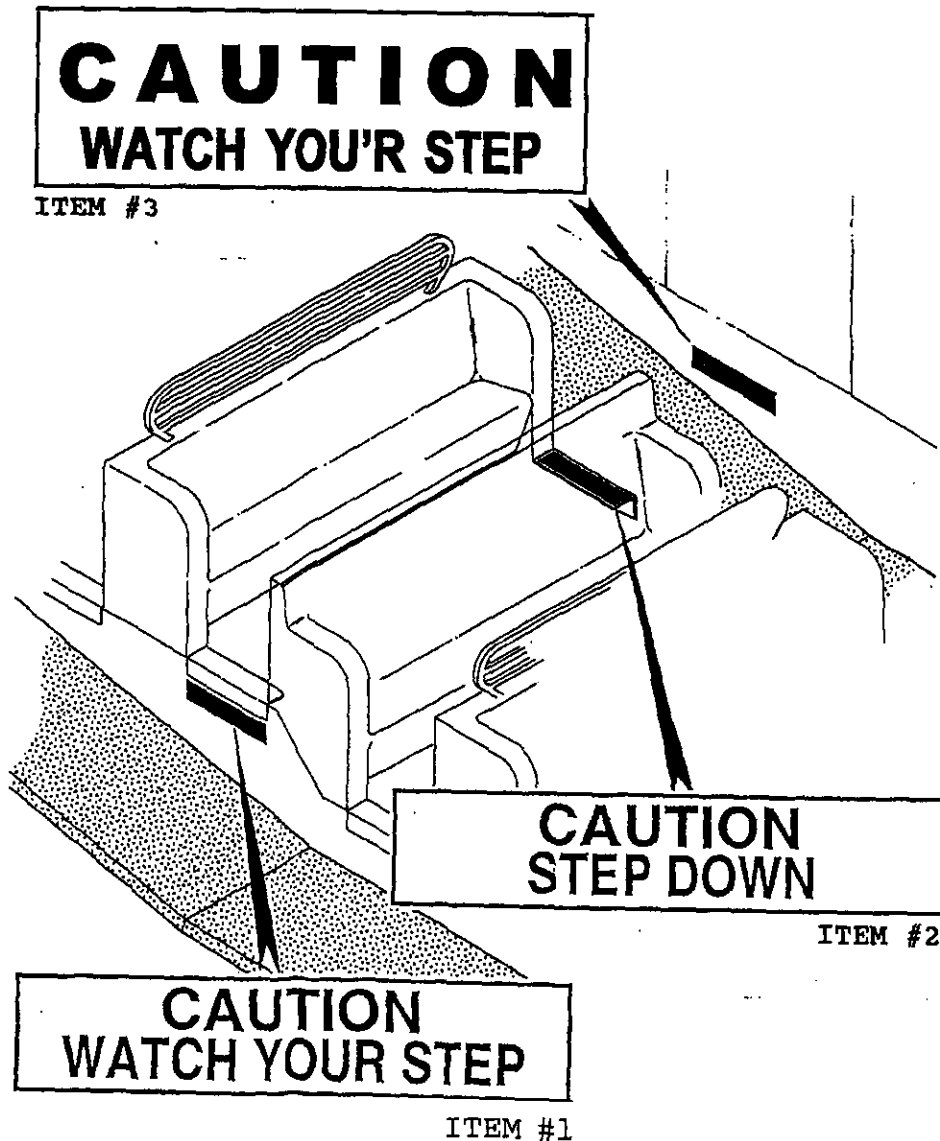
NOTICE

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Installation Instruction for Kit No. K387R1082-0.

1. Apply one CAUTION - WATCH YOUR STEP (ITEM #1) decal just below the step sill of each of the 10 entrances to the vehicle.
2. Apply one CAUTION - STEP DOWN (ITEM #2) decal on the top of the step sill of each of the 10 exits from the vehicle.
3. Apply one CAUTION - WATCH YOUR STEP (ITEM #3) decal on the back drop just opposite and in line with each of the 10 exits of the vehicle.





NUMBER: B387R1097-0

DATE: MAY 17, 1991

SUPERSEDES:

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## SERVICE BULLETIN

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Effective Serial Number: 387-02486 thru 387-03489 Excluding Park Models  
Chance Rides, Inc.

79-46001 thru 84-4623 Excluding Park Models  
Chance Manufacturing Co., Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY  
LIABILITY for losses associated with rides  
produced by Chance Manufacturing Company, Inc.

Ride: SEA DRAGON Subject: Spread Cylinder Support Weldment

Chance Rides, Inc. has become aware that if the spread cylinders on the tower legs of the SEA DRAGON are fully extended or retracted with pressure still being applied to the cylinder, that damage to the cylinder attaching weldment and injury to personnel may occur. Chance Rides, Inc. has developed a kit which when properly installed increases the welded area of the cylinder attaching weldment to the tower leg.

Chance Rides, Inc. requires all owners of the above noted SEA DRAGON amusement rides to order and install kit number K387R1097-0, using the instructions supplied with the kit. The Certification Of Compliance must be returned to Chance Rides, Inc. within 15 days from receipt of the kit. This kit includes all necessary parts to rework one ride.

In addition to this kit, proper set-up and tear-down procedures must be followed. Extend and retract the cylinders slowly, making sure that the cylinders and the clevises do not bind. Never extend or retract spread cylinders with tower legs resting on the stub towers. If the cylinders are fully extended or retracted the pressure to the cylinders must be stopped immediately. Never utilize more than 2500 psi when operating spread cylinder. Stay clear of tower legs when extending or retracting the spread cylinders. All owners of SEA DRAGON amusement rides are to order and install four (4) decals number 22193005 as shown on this bulletin, one per stub tower.

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

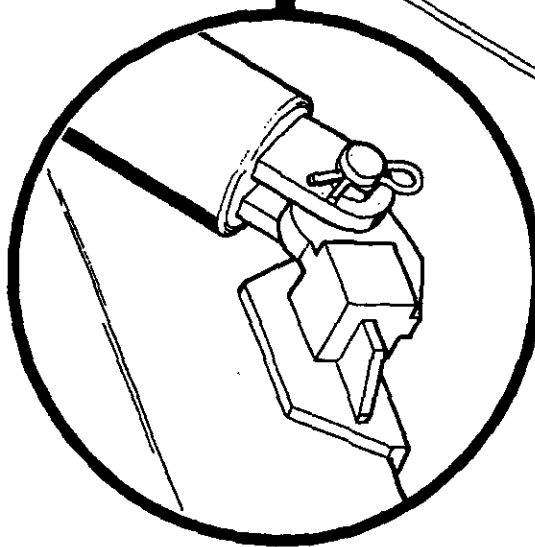
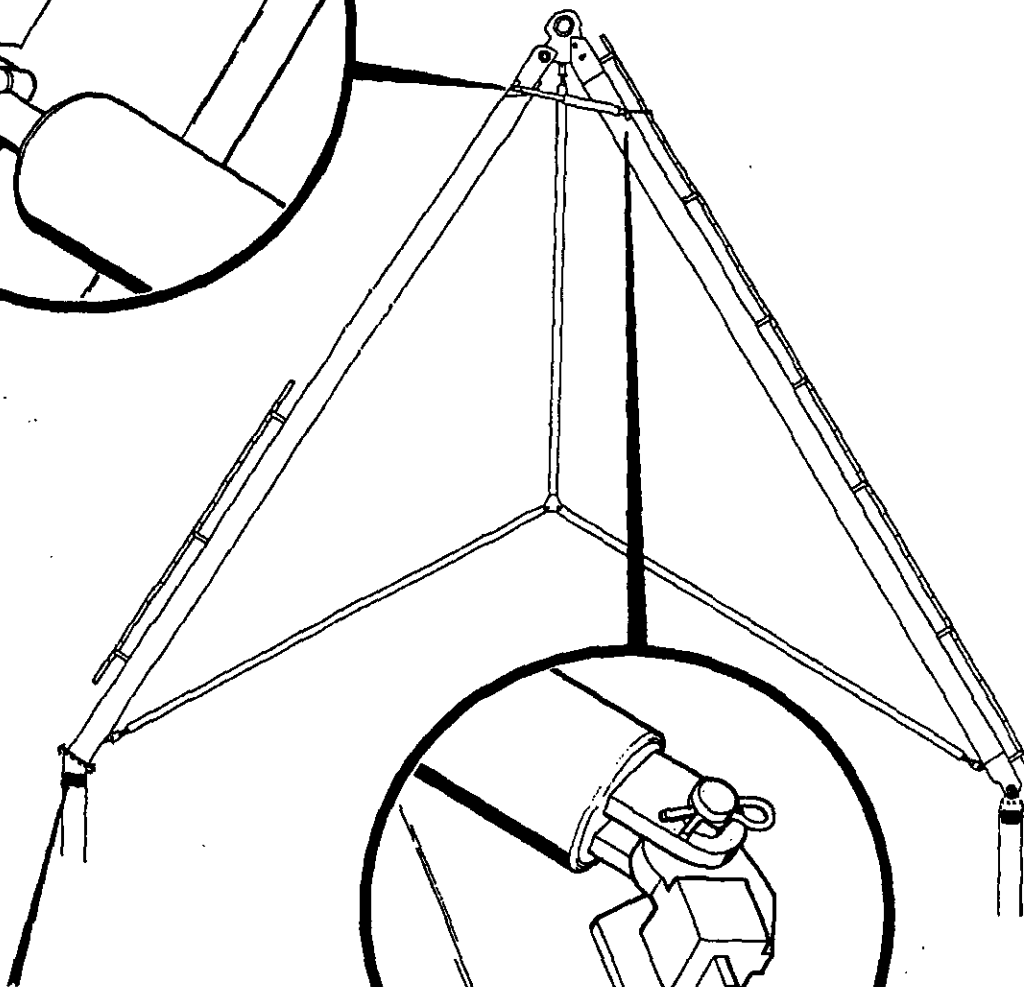
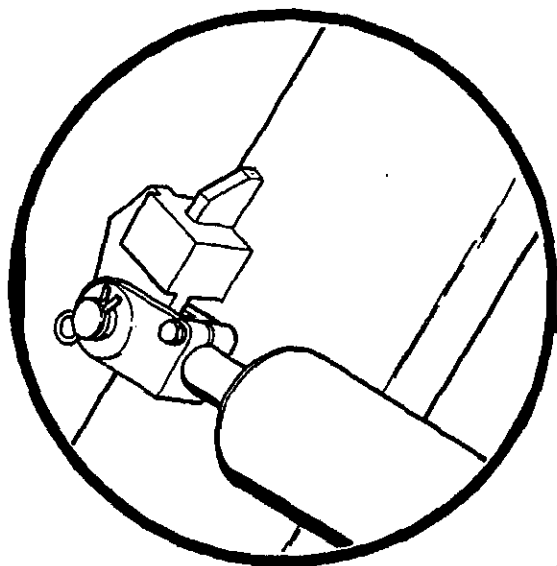
### NOTICE

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NEW STYLE  
SPREAD CYLINDER SUPPORT WELDMENTS



**CAUTION**  
MOVING OBJECTS  
CAN CAUSE INJURY  
STAY CLEAR  
OF TOWER LEGS DURING  
SET-UP AND TEAR-DOWN.

APPLY DECAL TO STUB TOWERS  
(4 PLACES)



NUMBER: B387R1099-0

DATE: MAY 24, 1991

SUPERSEDES:

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## SERVICE BULLETIN

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Effective Serial Number: All Units - Chance Rides, Inc.

All Units - Chance Manufacturing Co., Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing Company, Inc.

Ride: SEA DRAGON

Subject: Lap Bar Air Pressure

Chance Rides, Inc. has had reports of the bottom mounting eye of the lap bar air cylinders breaking. These cylinders activate the lap bar locks. The breaks occur at the point where the cylinder is pinned to the seat frame. All owner/operators of SEA DRAGON amusement rides are required to visually inspect the air cylinder attaching points for cracks. If any cracks in the cylinder attaching points are found, the cylinder must be replaced. This inspection must be done on an annual basis

If any cylinders have been replaced, due to either the above inspection or due to previous breakage in this area, adjustment to the air pressure may be required. It has been determined that failure of the cylinders may be due to improperly regulated air pressure. The air pressure at the boat should not exceed 45 psi.

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

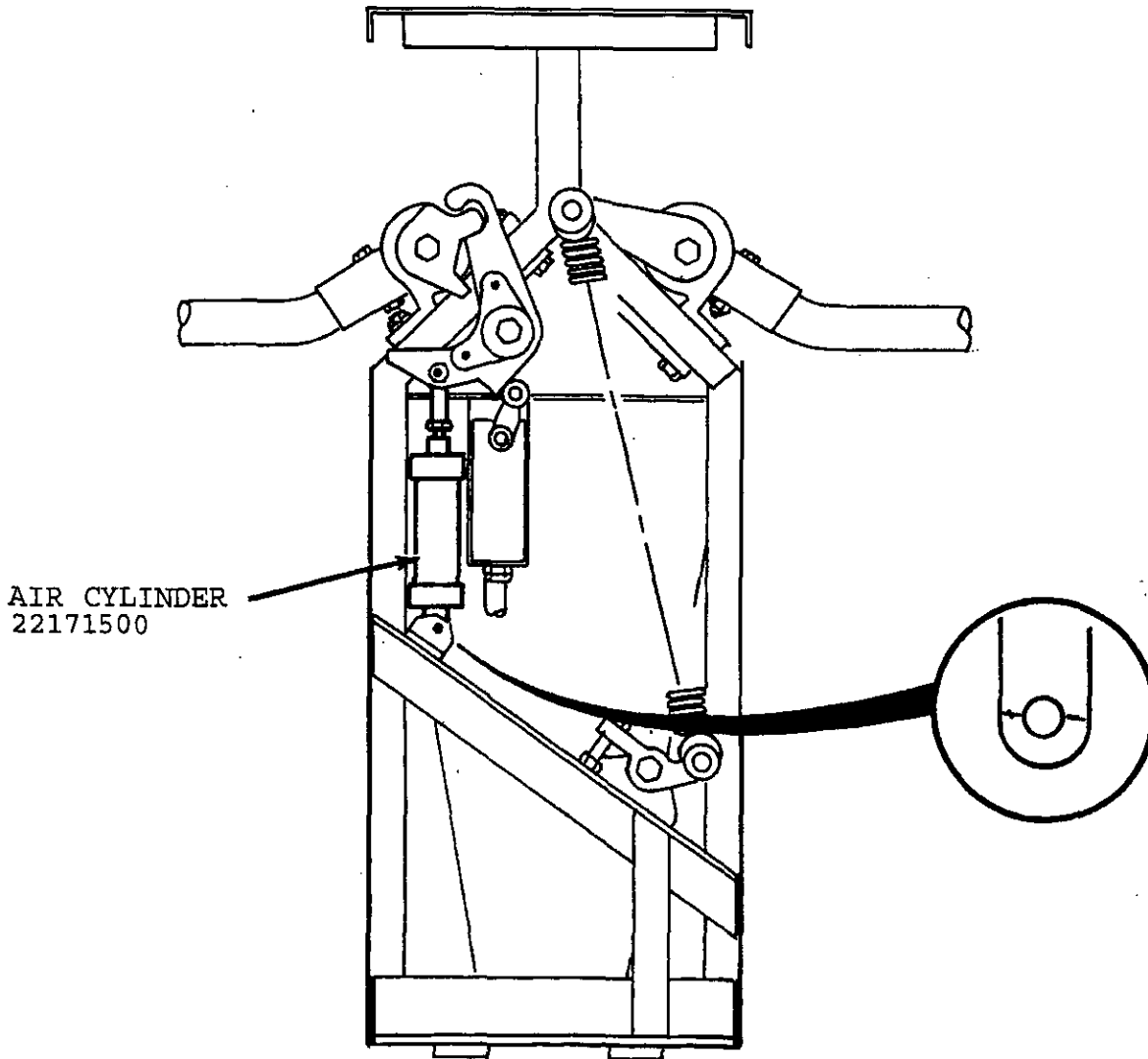
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## AIR CYLINDER INSPECTIONS

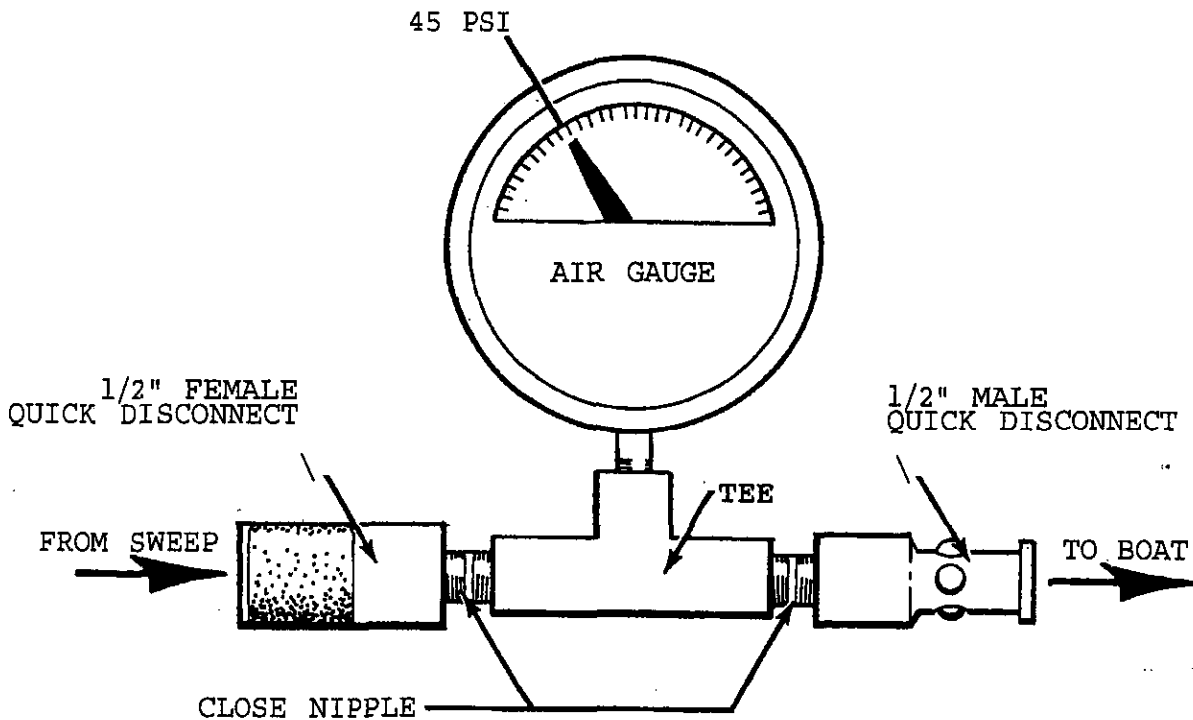
NOTE: Lap bars must be in the up position and air cylinders unpinned at bottom in order to perform inspection. Cylinder must be repinned before operating ride.



## SAMPLE GAUGE INSTALLATION

If regulation of air pressure is required the following instructions can be followed in order to determine the air pressure at the boat.

Connect one side of air gauge to the quick disconnect in the back side of the boat. Connect the air line coming down the sweep to the other side of the gauge.



NOTE: Do not operate ride with this gauge connected to the boat. Remove gauge and reconnect air line to boat before operating ride.



RECEIVED  
APR 23 AM '94  
STANDARDS

NUMBER: B387R1155-0

DATE: APR. 29, 1994

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

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# SERVICE BULLETIN

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Effective Serial Number: All Units - Chance Rides, Inc.  
All Units - Chance Manufacturing Co., Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing Company, Inc.

Ride: SEA DRAGON

Subject: Safety Notice

In an effort to maintain the highest level of safety, Chance Rides, Inc. has reviewed the action of the SEA DRAGON amusement ride and the standard operating safety practices. For the safety of all passengers, Chance Rides, Inc. has revised its standard operating policy for the SEA DRAGON. Chance Rides, Inc. requires all owner/operators of the SEA DRAGON rides to adopt the new safety policies, outline in this bulletin, into practice.

All safety announcements given to passengers as they load should include, but not be limited to the following:

1. Watch your step while entering and existing vehicle.
2. Secure all lose articles.
3. Keep hand and feet inside vehicle.
4. To properly ride this ride, all passengers should be able to sit upright and hold onto lap bar.

In addition to the above safety announcement items, persons who are pregnant or have conditions that can be aggravated by this ride should view this ride for potential risks before riding. Persons who are visibly ill or under the influence of drugs or alcohol are not permitted to ride. Persons who cannot be properly secured are not permitted to ride.

Chance Rides, Inc. has also increased the height restrictions for passengers on the SEA DRAGON ride. **NO ONE UNDER 48 INCHES IN HEIGHT SHALL BE PERMITTED TO RIDE.**

Chance Rides, Inc. has developed a NOTICE TO PASSENGERS decal, part number 22181608, available at no charge if ordered within 90 days of the date on this bulletin. All owner/operators of the SEA DRAGON amusement rides are required to either order and install this decal on the entrance fence or to post signage of similar working in a predominate location.

# **NOTICE TO PASSENGERS**

- 1. NO ONE UNDER 48 INCHES IN HEIGHT MAY RIDE.**
- 2. PERSONS WHO ARE PREGNANT OR HAVE A CONDITION THAT COULD BE AGGRAVATED BY THIS RIDE SHOULD VIEW THIS RIDE FOR POTENTIAL RISKS BEFORE RIDING.**
- 3. PERSONS WHO ARE VISIBLY ILL OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL ARE NOT PERMITTED TO RIDE.**
- 4. KEEP HANDS AND FEET INSIDE VEHICLE.**
- 5. TO PROPERLY RIDE THIS RIDE, ALL PASSENGERS SHOULD BE ABLE TO SIT UPRIGHT AND HOLD ONTO THE LAP BAR.**
- 6. PERSONS WHO CANNOT BE PROPERLY SECURED ARE NOT PERMITTED TO RIDE.**



NUMBER: B387R1155-A

DATE: MAY 9, 1994

SUPERSEDES: B387R1155-0

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## SERVICE BULLETIN

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4. To properly ride this ride, all passengers should be able to sit upright and hold onto lap bar.

In addition to the above safety announcement items, persons who are pregnant or have conditions that can be aggravated by this ride should view this ride for potential risks before riding. Persons who are visibly ill or under the influence of drugs or alcohol are not permitted to ride. Persons who cannot be properly secured are not permitted to ride.

Chance Rides, Inc. has also increased the height restrictions for passengers on the SEA DRAGON ride. **NO ONE UNDER 48 INCHES IN HEIGHT SHALL BE PERMITTED TO RIDE UNLESS ACCOMPANIED BY A RESPONSBLE ADULT.**

Chance Rides, Inc. has developed a NOTICE TO PASSENGERS decal, part number 22181608, available at no charge if ordered within 90 days of the date on this bulletin. All owner/operators of the SEA DRAGON amusement rides are required to either order and install this decal on the entrance fence or to post signage of similar working in a predominate location.

# **NOTICE TO PASSENGERS**

- 1. NO ONE UNDER 48 INCHES IN HEIGHT MAY RIDE UNLESS ACCOMPANIED BY A RESPONSIBLE ADULT.**
- 2. PERSONS WHO ARE PREGNANT OR HAVE A CONDITION THAT COULD BE AGGRAVATED BY THIS RIDE SHOULD VIEW THIS RIDE FOR POTENTIAL RISKS BEFORE RIDING.**
- 3. PERSONS WHO ARE VISIBLY ILL OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL ARE NOT PERMITTED TO RIDE.**
- 4. KEEP HANDS AND FEET INSIDE VEHICLE.**
- 5. TO PROPERLY RIDE THIS RIDE, ALL PASSENGERS SHOULD BE ABLE TO SIT UPRIGHT AND HOLD ONTO THE LAP BAR.**
- 6. PERSONS WHO CANNOT BE PROPERLY SECURED ARE NOT PERMITTED TO RIDE.**





NUMBER: B387R1172-0

DATE: AUG. 11, 1995

SUPERSEDES:

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## SERVICE BULLETIN

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Effective Serial Number: ALL PARK MODEL UNITS -  
CHANCE MANUFACTURING CO., INC.  
CHANCE RIDES, INC.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY  
LIABILITY for losses associated with rides  
produced by Chance Manufacturing Company, Inc.

Ride: PARK MODEL SEA DRAGON      Subject: DRIVE ASSEMBLY

Chance Rides, Inc. has become aware that the drive assembly on some park model SEA DRAGON amusement rides may not be welded adequately. If the drive assembly was not welded adequately to the customer-furnished base plate, damage to the ride and injury to passengers or personnel may occur. This bulletin specifies the minimum length, size and location of weld required to secure the drive assembly.

Chance Rides, Inc. requires all owners of the above noted park model SEA DRAGONS to inspect the welds connecting the drive assembly to the customer furnished base plate. If the weld does not meet the specifications described in this bulletin, DISCONTINUE OPERATION OF THE RIDE. Inspect and weld per the instructions outlined in this bulletin. If you have any questions concerning this procedure, please contact the Chance Customer Service Department at 1-800-CHANCEL.

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

### NOTICE

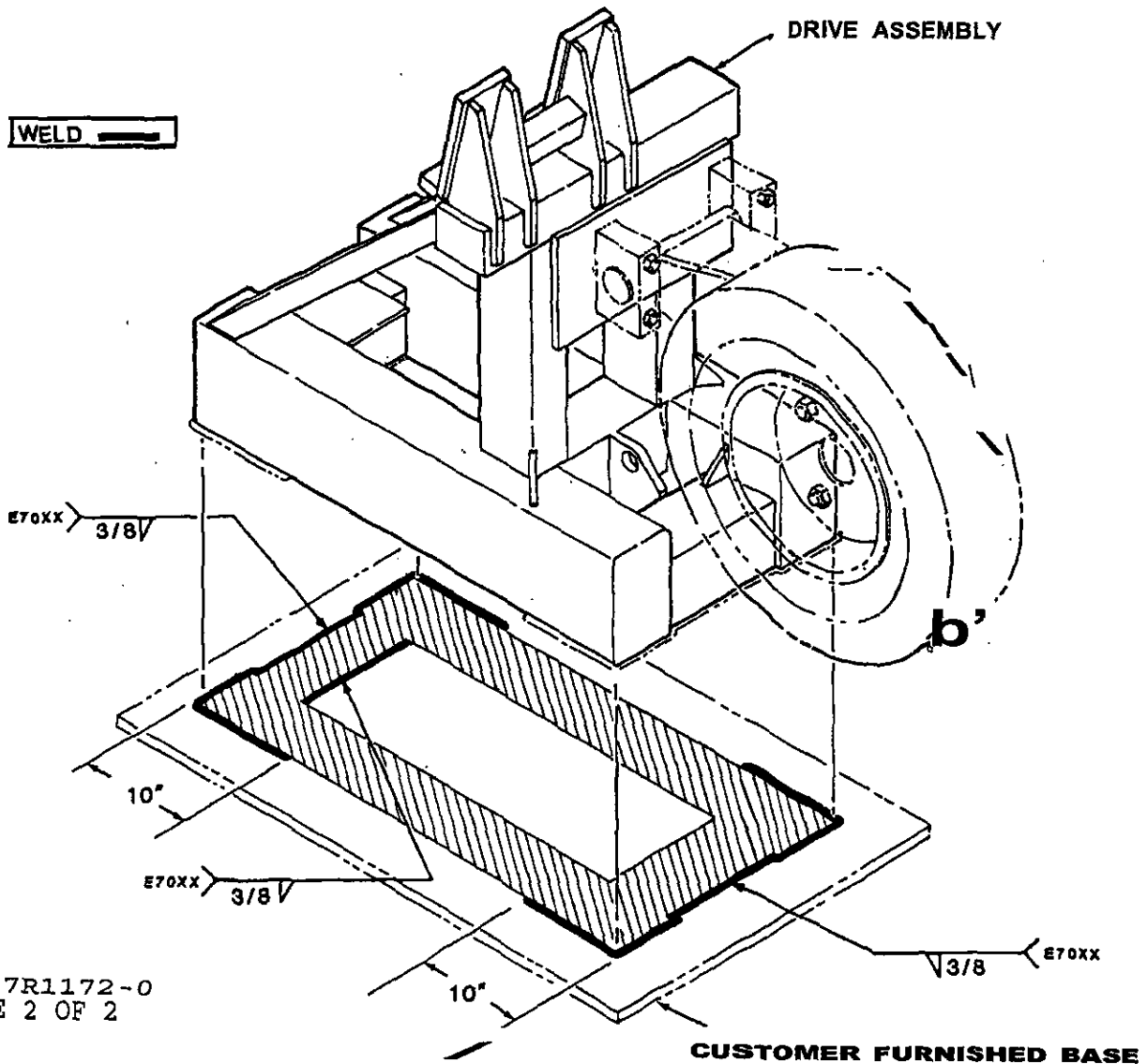
Use only those components authorized, specified or provided by Chance Rides, Inc.

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

## INSTRUCTIONS

1. Check to determine if drive assembly has been welded per the specifications shown.
2. Visually inspect existing welds and drive assembly for cracks.
3. If no cracks are found and if the welding does not meet or exceed the specifications shown below, re weld as shown.
4. If cracks are found in existing welds, grind out welds and re weld per the specifications. If cracks are found in the drive assembly structure, contact the Chance Rides, Inc. Customer Service Department.

NOTE: VIEW EXPLODED FROM BASE





**CHANCE RIDES, INC.**  
4219 Irving  
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Website: [www.rides.com](http://www.rides.com)  
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Bulletin No:	B387R1265-0
Release Date:	December 20, 2001
Effective Date:	December 20, 2001
Supersedes:	N/A
Completion Date:	See Text
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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

Abstract of Issue:

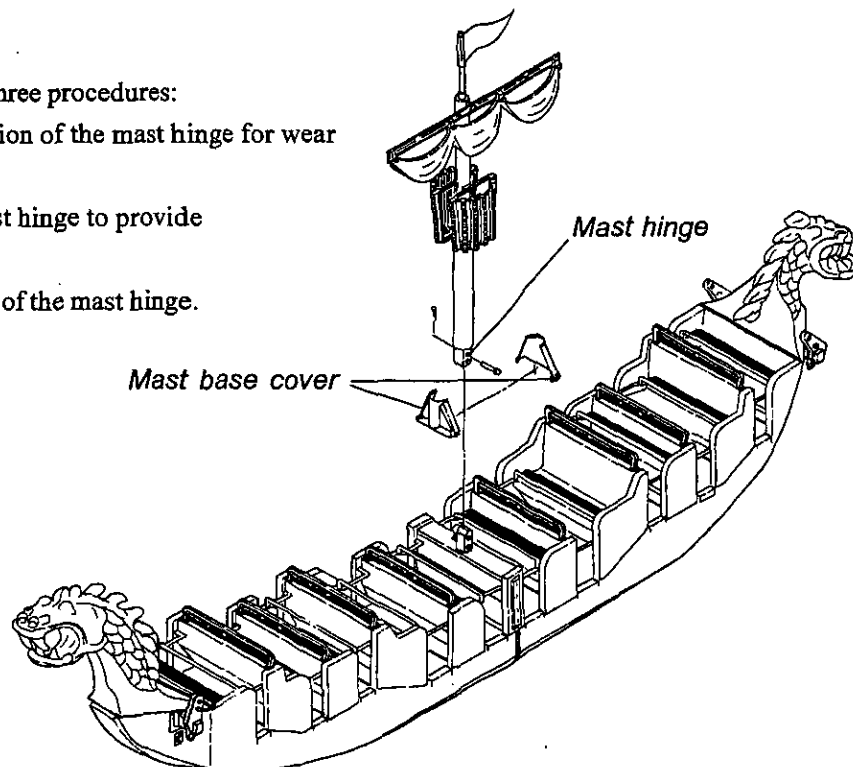
**Mast Hinge Inspection and Rework**

Reason For Release:

The vehicle (boat) on the SEA DRAGON amusement ride is equipped with a hinged mast which can be lowered during transportation and/or maintenance of the ride. It is possible after years of operation for the holes in the mast hinge to become worn, and/or cracks to form in the area where the hinge is welded to the main mast structure. If the hinge or its welds break, the mast could fall, causing personal injury to passengers, operators or bystanders.

This bulletin describes three procedures:

- Immediate inspection of the mast hinge for wear or damage.
- Rework of the mast hinge to provide longer service life.
- Annual inspection of the mast hinge.



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Bulletin No: B387R1265-0

Release Date: December 20, 2001

Effective Date: December 20, 2001

Supersedes: N/A

Completion Date: See Text

Page: 2 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

**Detail of Issue:**

Chance Rides, Inc. requires all owner/operators of the above noted SEA DRAGON amusement rides to inspect the mast hinge immediately on receipt of this bulletin. Thereafter, inspect the mast hinge annually.

Additionally, Chance Rides, Inc. requires all owner operators of the above SEADRAGON amusement rides to rework the mast hinge as described within 30 days of the receipt of this bulletin. Order the Mast Hinge Rework Kit, part number K387R1265-0, which contains all necessary parts to rework one ride. Install the kit using the instructions provided on the following pages of this bulletin.

The Mast Hinge Rework Kit, part number K387R1265-0, consists of the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K387R1265-1	PLATE - Doubler	2
CSN10A07-18	PIN - Taper (1 x 8 G/L)	2

**NOTE:** The mast is a theming component, and is not required for safe operation of the ride. At the owner/operator's option, the mast can be removed completely from the ride. If the ride is operated with the mast in place, it must be inspected and reworked as described in this bulletin.

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

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

Action to be taken:

### Inspection Procedure

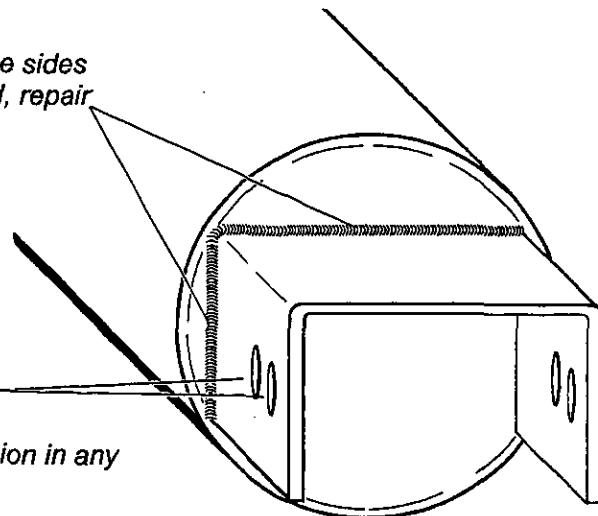
Perform the following inspection procedure immediately upon receipt of this bulletin.

1. Remove the mast base cover to gain access to the mast hinge.
2. Remove the top pin and lower the mast to the roading position. Secure the mast in this position and remove the other pin.
3. Inspect the pin holes for wear as shown. Measure each hole in all directions. If any measurement exceeds 1.150", do not operate the ride with the mast in place until the rework described in this bulletin has been completed.
4. Inspect the existing welds around the outside of all three sides of the hinge as shown. If any cracks are found, do not operate the ride with the mast in place until welds have been repaired and the rework described in this bulletin has been completed.

*Inspect the existing welds on all three sides of the hinge. If indications are found, repair as described in this bulletin.*

*Inspect all four holes for wear.*

*The maximum allowable dimension in any direction is 1.150".*





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Bulletin No: B387R1265-0

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

Action to be taken (continued):

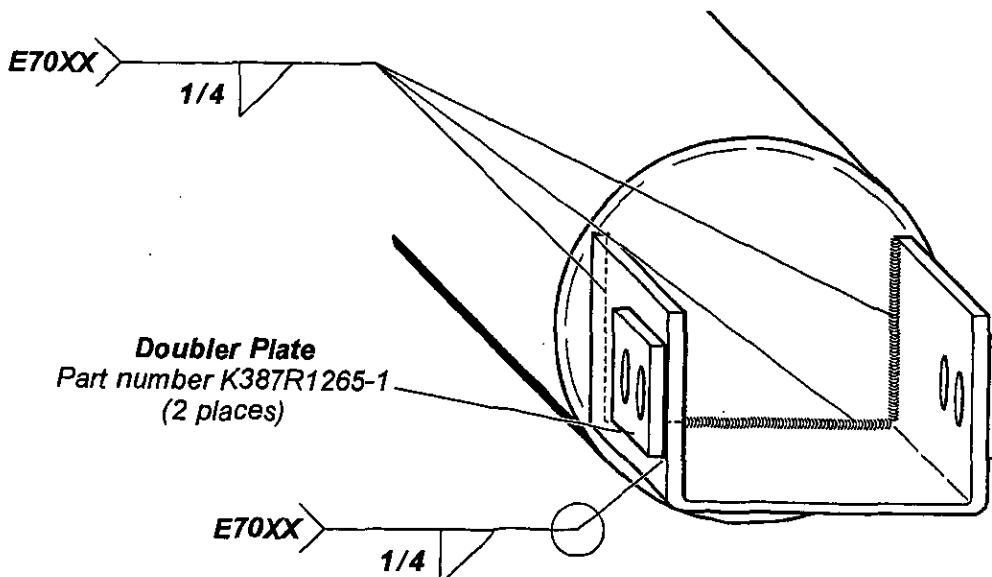
**Rework Procedure**

After the mast hinge has been inspected as described, rework as follows:

1. If cracks were found in the existing weld around the outside of the hinge, repair as follows:
  - Completely remove the indication by grinding.
  - Weld using E70XX welding rod.
2. If no cracks were found, or after cracks are repaired, weld the inside of all three sides of the hinge as shown.
3. Locate the doubler plates on the mast hinge and weld as shown. Use the new, longer pins provided in the kit to align the doubler plates.

**NOTE:** Be careful to correctly align the doubler plates, especially if the original holes were excessively worn.

4. Assemble the mast to the vehicle with the new pins and existing hairpins and install the mast base cover.





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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

Action to be taken (continued):

**Annual Inspection of Mast Hinge**

Perform the following inspection on the mast hinge annually.

1. Remove the mast base cover to gain access to the mast hinge.
2. Remove the top pin and lower the mast to the roading position. Secure the mast in this position and remove the other pin.
3. Inspect the pin holes for wear as shown. Measure each hole in all directions. If any measurement exceeds 1.150", contact the CHANCE RIDES Customer Service Department. Do not operate the ride with the mast in place if any hole is excessively worn.
4. Inspect all welds around the inside and outside of the hinge, including the welds on the doubler plates. If any cracks are found, contact the CHANCE RIDES Customer Service Department. Do not operate the ride with the mast in place if any indication is found.
5. Reassemble the mast to the vehicle and install the mast base cover.