



NUMBER: B408R1178-0

DATE: June 6, 1997

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

## SERVICE BULLETIN

Effective Serial Number: 408-96002 through 408-97019

Ride: CHAOS

Subject: Hydraulic System Rework

Chance Rides, Inc. has become aware of at least one case on a CHAOS amusement ride when the rod seal on the boom lift cylinder failed. The failure of the seal was caused by operating the ride in cold weather. The failure of the seal did not result in a safety problem, but rather allowed excessive leakage of hydraulic fluid from the system. Chance Rides, Inc. has designed a rework kit that, when properly installed will prevent excessive internal oil pressure from building up in the cylinder, reducing the possibility of failure of the seal.

All owner/operators of the above noted amusement rides are required to order and install kit number K408R1178-0, using the installation instructions furnished with this bulletin. Each kit contains all necessary parts to rework one ride. Kits are available at no charge if ordered within 90 days of the day on this bulletin. Failure to order and install this kit will cause any warranty on the lift cylinder to be voided.

Kit number K408R1178-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
62701000	Reducer Bushing (1/2"MP-3/8"FP)	1
60274000	Plug - hex head pipe	1
60104600	Adapter (1/4"MOR-1/2"F 37 degree)	2
60095200	Adapter O-ring boss (3/8"FP-1/2"OR)	1
60078800	Adapter 90 degree elbow	1
60078600	Adapter 90 degree elbow	1
28464902	Relief valve cartridge (3500psi)	1
28467901	Valve body	1
408-661-020	Hose assembly	1

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

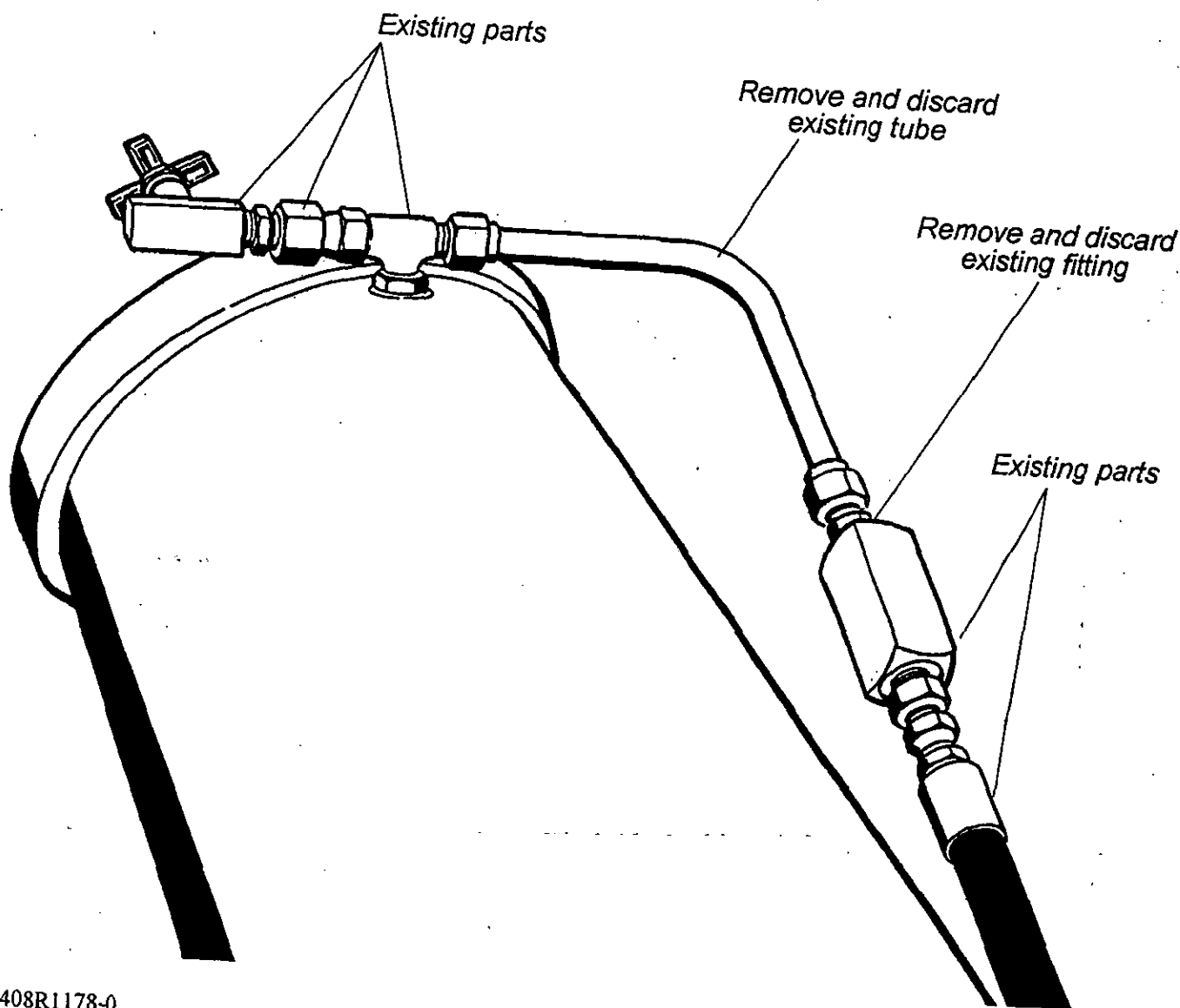
**NOTICE**  
Use only those components authorized, specified or provided by Chance Rides, Inc.

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

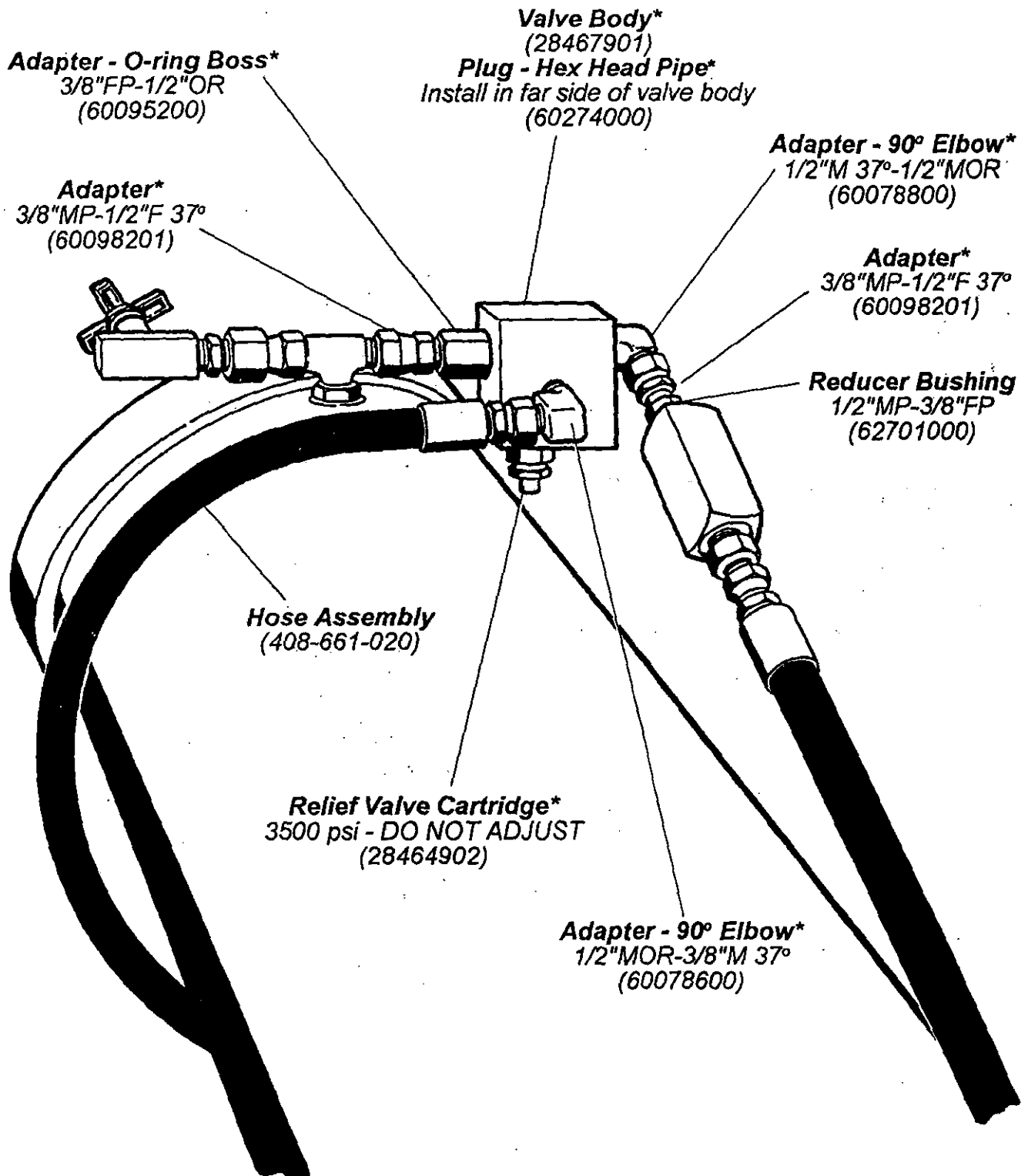
## INSTALLATION INSTRUCTIONS

### Hydraulic System Rework Kit

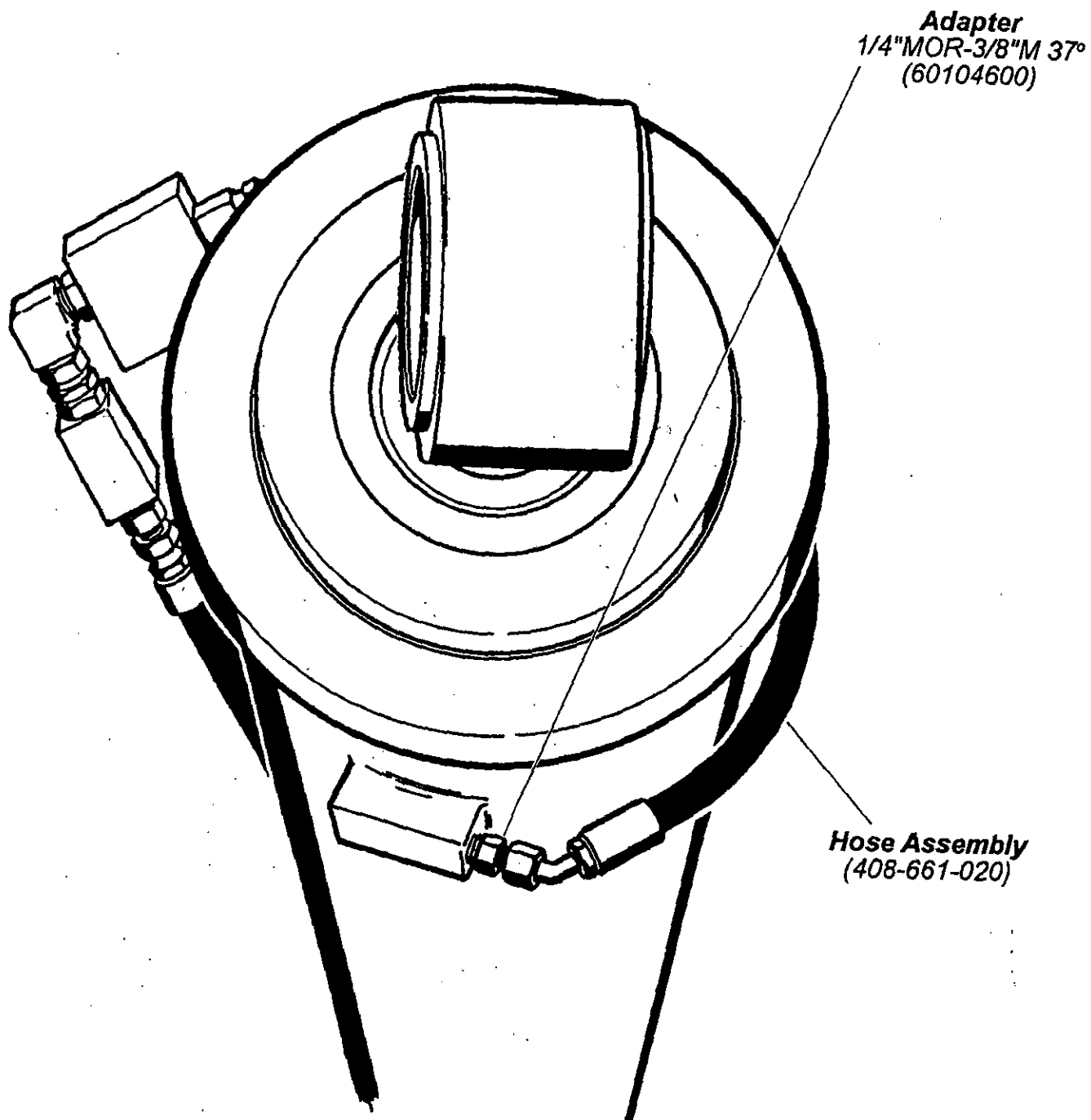
1. Lower the boom completely, stop the hydraulic pump, and shut off the power at the main breakers.
2. Locate the tube at the "T" fitting at the rod end of the boom lift hydraulic cylinder. Remove and discard the tube. Loss of hydraulic fluid will be minimal.



3. Install the parts provided in the kit as shown in the following illustrations.
4. After all parts are installed, operate the ride, then check for leaks at all hoses, tubes and fittings.



\* These parts can be sub-assembled prior to installation on the ride.



**VIEW OF UNDERSIDE OF BOOM LIFT CYLINDER**



NUMBER: B408R1180-0

DATE: June 20, 1997

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

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# SERVICE BULLETIN

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Effective Serial Number: All Units

Ride: CHAOS

Subject: Lap Bar Indicator Light  
Wiring Rework

Chance Rides, Inc., has developed a rework procedure for the lap bar indicator light wiring for the CHAOS amusement ride. The rework consists of securing the wire harness at the light to restrict movement of the wires and prevent fatiguing and breaking of the wires.

All owner/operators of the above noted amusement rides are required to perform the rework, using the installation instructions and parts furnished with this bulletin.

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

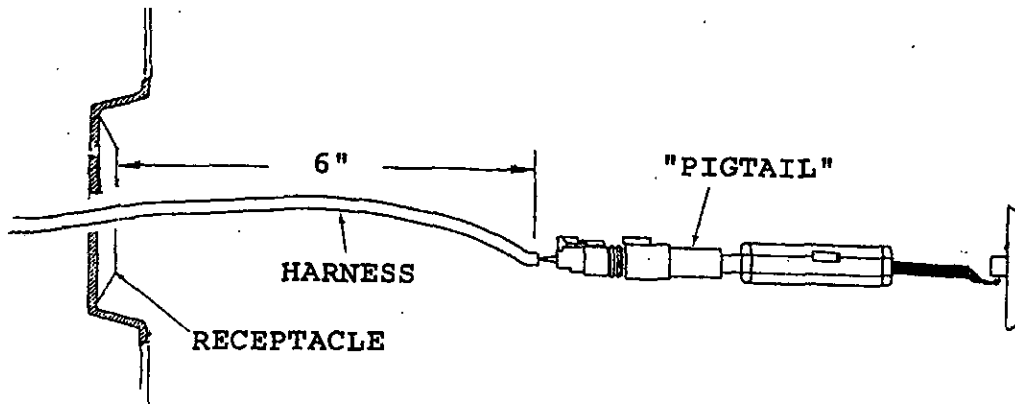
## NOTICE

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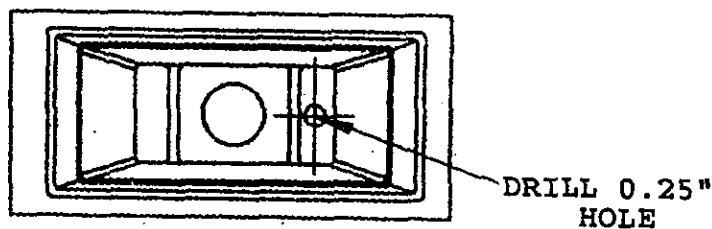
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## INSTALLATION INSTRUCTIONS

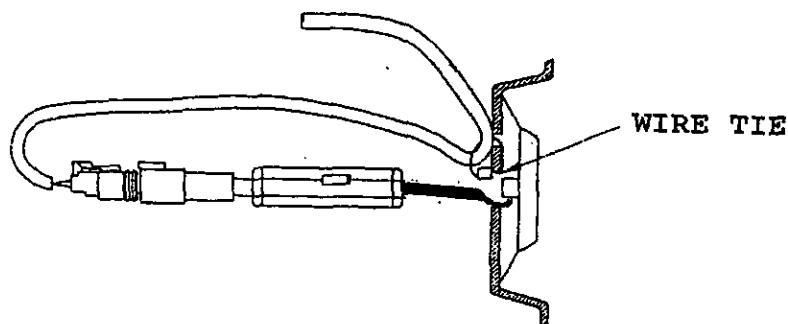
1. Turn off power to the ride, or open the lap bars to turn all lap bar indicator lights off. The indicator lights are located at the center of each vehicle near the passengers' feet.
2. Remove the light using a screw driver. Pull the "pigtail" and harness out of the receptacle until about six inches of the harness are outside the vehicle.



3. Drill a 0.25" hole through the fiberglass behind the receptacle as shown. Be careful not to damage any wiring behind the opening.



4. Insert a wire tie (part number 68855200) through the small hole and pull back through the large opening. Needle-nose pliers work well.



5. Attach the wire tie around the harness (not the "pigtail") and pull until snug. Cut off excess wire tie.
6. Push the wire tie head and harness back through the large opening.
7. Feed the remainder of the pigtail back inside the vehicle and install the light.
8. Remove the cover from the back of the vehicle. Locate the same harness and pull up gently to remove any slack from the harness. Secure the harness to the vehicle frame with another wire tie.



NUMBER: B408R1181-0

DATE: July 25, 1997

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

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# SERVICE BULLETIN

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Effective Serial Number: All Units

Ride: CHAOS

Subject: Hub Capscrew Torque Check

The center hub section on the CHAOS amusement ride is secured to the bearing turntable on the tilt head by 28 Grade 8 hex-head capscrews. It is essential for the care of the equipment and safety of the passengers to maintain the proper torque on these capscrews. Chance Rides, Inc. requires all owner/operators of the above noted rides to perform the following check immediately and at least once per month thereafter during the operating season.

1. Verify that the 28 hardened washers under the capscrews securing the center hub section to the bearing turntable on the tilt head fit flush to the hub.
2. Using a torque wrench, check for proper torque of all 28 capscrews. Torque value for checking these capscrews must be 80 ft-lbs.

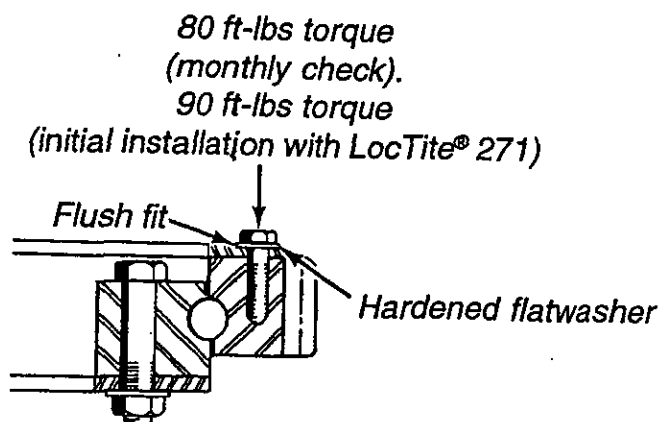
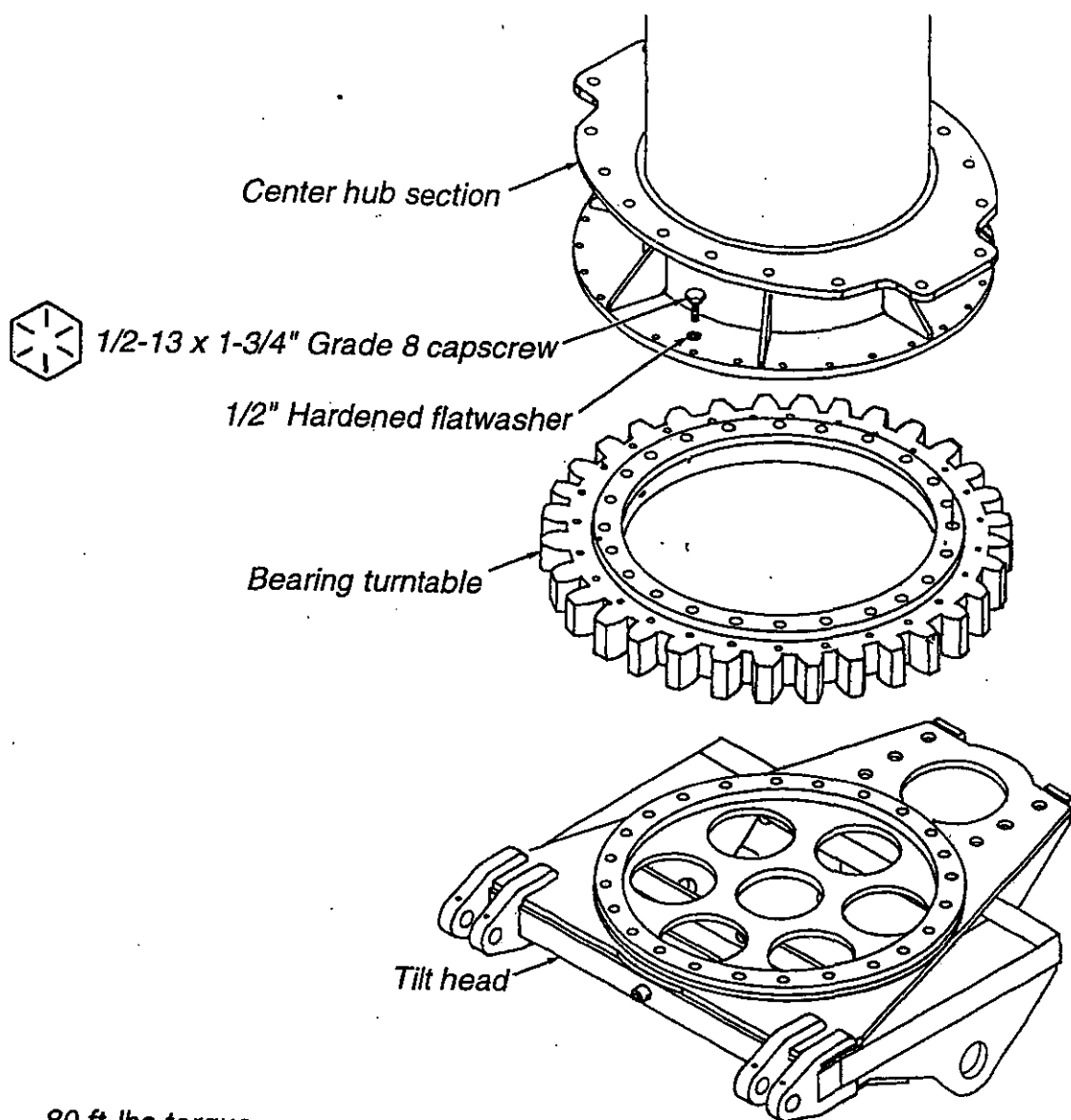
If any capscrew is found to be loose, remove it and replace with a new capscrew. Clean the threads on the new capscrew and in the bearing, then apply Loctite 271 (red). Tighten the new capscrew to 90 ft-lbs.

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.

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NUMBER : B408R1184-0

DATE : Sept. 12, 1997

SUPERSEDES:

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## SERVICE BULLETIN

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Effective Serial Number: All Units

Ride: CHAOS

Subject: Inspection of Cylinder  
Support Frames

Chance Rides, Inc. has become aware that it is possible for cracks to develop in the structural frame members which supports the main hydraulic lift cylinder on the CHAOS amusement rides noted above.

Chance Rides, Inc. requires all owner/operators to perform an annual visual inspection of all support frame members as outlined on the back of this bulletin. If any indications are found, contact Chance Customer Service for a repair procedure.

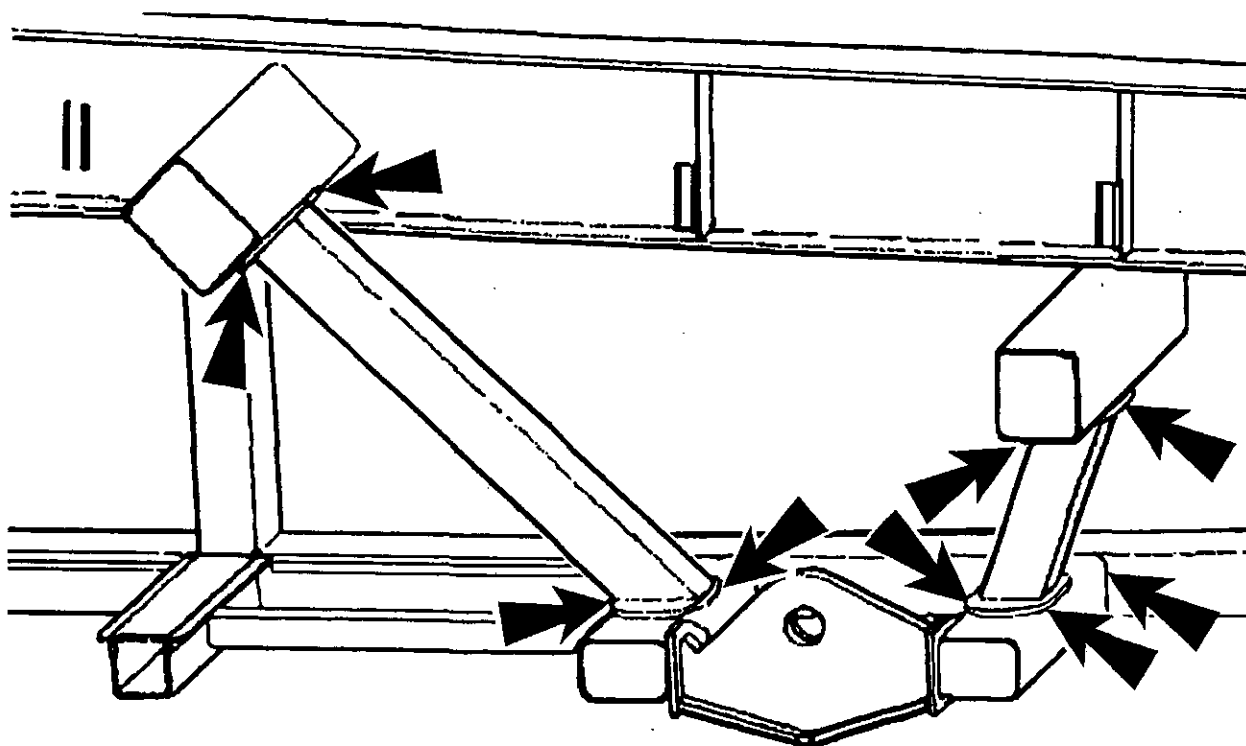
All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation.

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*INSPECT ALL WELDS IN THE AREAS INDICATED BY ARROWS*





NUMBER: B408R1182-0

DATE: Dec. 1, 1997

SUPERSEDES:

Dec 9 9 44 AM '97  
RECEIVED

America's Largest Manufacturer of Amusement Rides

## SERVICE BULLETIN

Effective Serial Number: 408-96002 through 408-97019

Ride: CHAOS

Subject: Latching Rod Rework

Chance Rides, Inc. has become aware that the latching rods on the above noted CHAOS amusement rides can be put into a bending load causing the rod to break at the jam nut. If this happens, injury to passengers can result. All owner/operators of the CHAOS rides identified above are required to perform the rework described in this bulletin.

Order and install kit number K408R1182-0, using the installation instructions on the reverse side of this bulletin. Each kit contains enough parts to rework one ride.

The following parts are included in kit K408R1182-0.

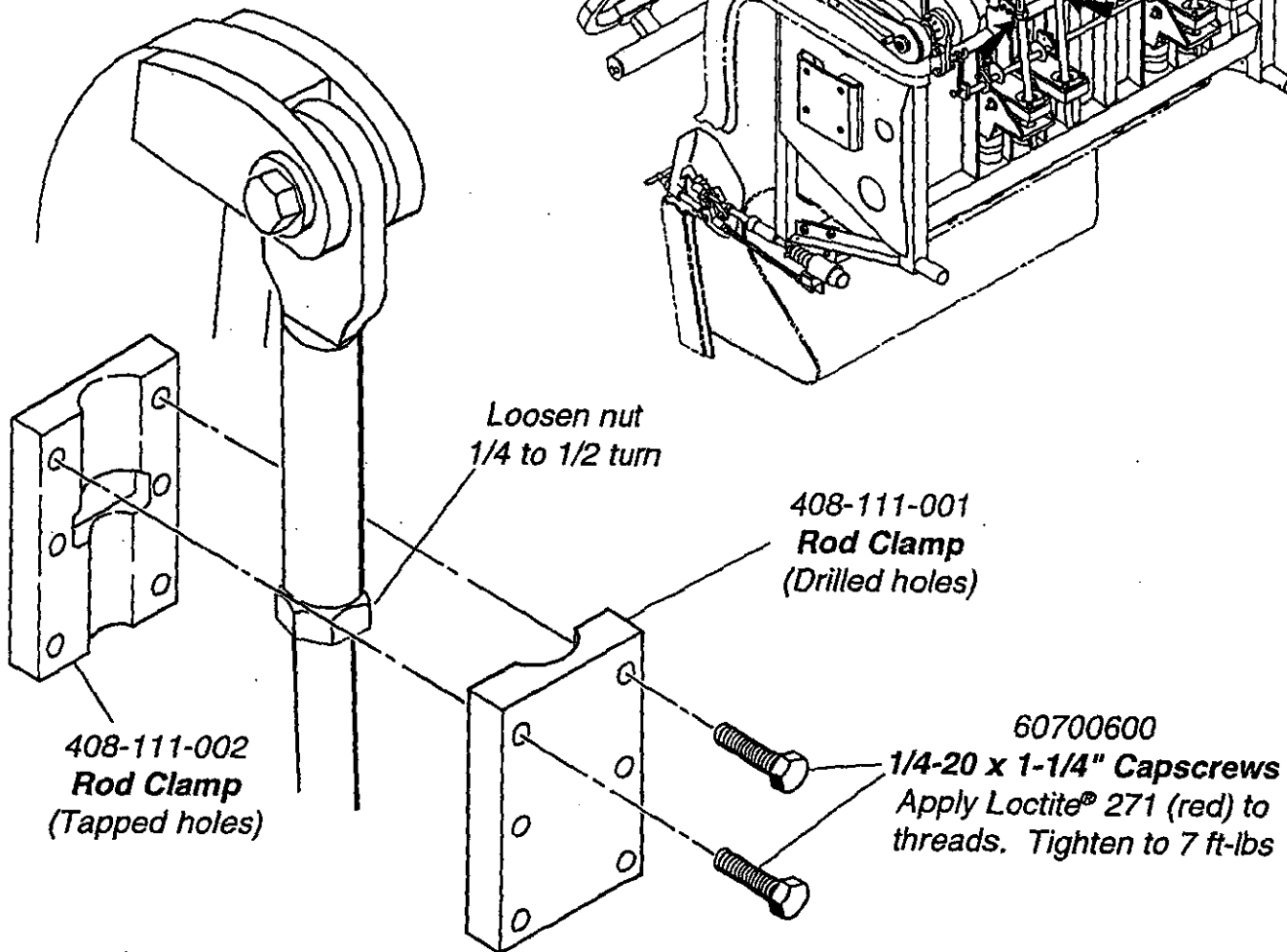
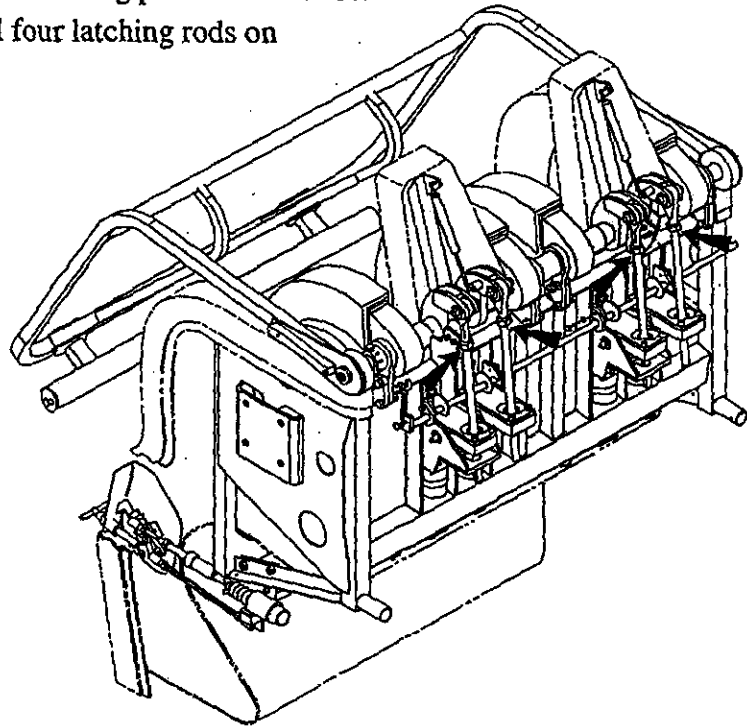
<u>Item No.</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
1	408-111-001	Rod Clamp Half (drilled holes)	72
2	408-111-002	Rod Clamp Half (tapped holes)	72
3	60700600	1/4-20 x 1-1/4 Hex Head Cap Screw	432

## INSTALLATION INSTRUCTIONS - Kit K408R1182-0 (Latching Rod Rework Kit)

1. Remove the back cover from the vehicles. Locate the four latching rods, indicated by arrows in the following illustration.
2. Loosen the four nuts  $1/4$  to  $1/2$  turn.
3. Install one **Rod Clamp with tapped holes** and one **Rod Clamp with drilled holes** over each of the four latching rods.

**IMPORTANT:** Each rod clamp has recessed areas to mate with the latching rod, rod end and jam nut. All parts must be installed correctly to function properly. Be sure the large radius recess is at the top, to mate with the rod end.

4. Secure the rod clamps with six  $1/4$ -20 x  $1\text{-}1/4$ " Capscrews provided. Apply Loctite® 271 to the threads and tighten the six screws in an alternating pattern to 7 ft-lbs.
5. Install the rod clamps as described on all four latching rods on every vehicle.



**CHANCE RIDES, INC.**

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U.S.A.

Phone: 1-800-242-6231 • FAX: 1-316-942-7416

Website: [www.rides.com](http://www.rides.com)

Bulletin No: B408R1202-0

Release Date: October 1, 1998

Effective Date: B408R1202-0

Supersedes: N/A

Completion Date: November 1, 1998

Page: 1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

Model No.: 408

**Abstract of Issue:****PASSENGER RESTRAINTS****Reason For Release:**

Chance Rides, Inc. specifies in the CHAOS amusement ride Operation Manual the correct way in which passengers are to be secured before the ride is started. The manual states that to avoid serious personal injury, passengers must keep their hands and feet inside the vehicle. It is the operator's responsibility to give safety instructions to the passengers and to make sure that they have their hands, arms, and feet inside the vehicle while the lap bar is being closed and locked.

**Action to be Taken:**

All owners of the above noted amusement rides must establish a training program which emphasizes the manufacturer's specifications as to how passengers are to be properly seated and secured. Operators must be instructed as to the dangers to the passengers if not secured per the manufacturer's specifications. All owners/operators of the CHAOS ride must read the Operation Manual and be familiar with all warnings and cautions printed in the manual prior to operating the ride.

**Detail of Issue:**

To help insure the safety of the passengers, Chance Rides, Inc. has developed a decal which, along with the operator's safety instructions, will alert the passengers to the proper way in which to be secured in the seat. All owner/operators of the above noted CHAOS rides are required to order and install these decals, part number 408-172-001. A total of 36 decals is required, two per vehicle. Follow the instructions contained in this bulletin for proper installation of the decals.

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

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Bulletin No: B408R1202-0

Release Date: October 1, 1998

Effective Date: October 1, 1998

Supersedes: N/A

Completion Date: November 1, 1998

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

Model No.: 408

Detail of Issue (continued):

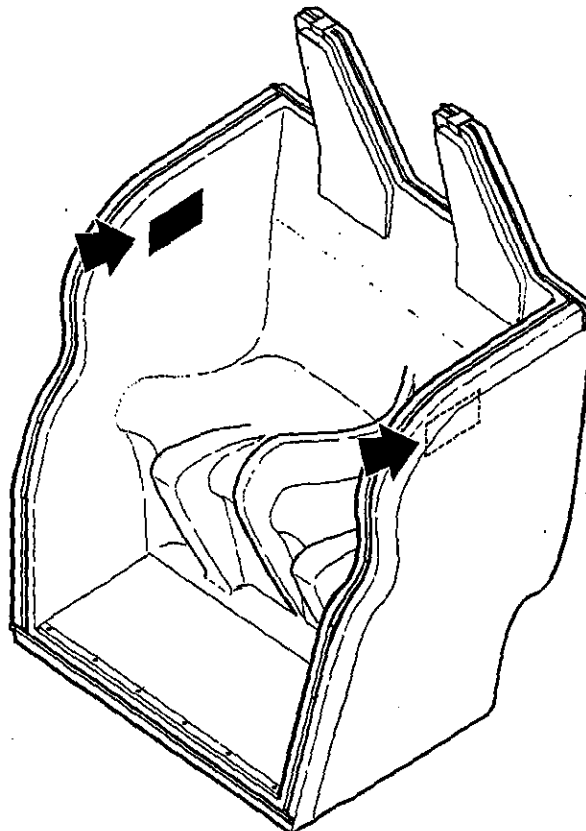
**NOTICE**

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.

**INSTALLATION INSTRUCTIONS**

Thoroughly clean the vehicle surface before applying the decals, then install decals in locations shown. Replace decals immediately if they are removed, damaged, or otherwise become illegible.



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Website: [www.rides.com](http://www.rides.com)

Bulletin No: B408R1204-0

Release Date: November 30, 1998

Effective Date: November 30, 1998

Supersedes: N/A

Completion Date: Immediate

Page: 1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Portable Units

Model No.: 408

**Abstract of Issue:****Boom Lift Cylinder Blocking****Reason For Release:**

Chance Rides, Inc. has become aware that the boom lift cylinder on the above noted CHAOS amusement rides needs to be supported with blocking while the ride is being operated. Failure to block under the ride's boom lift cylinder can cause undue stresses to the trailer frame in the cylinder pivot point area. These stresses can result in the cracking of structural members of the trailer frame in the area where the boom lift cylinder pins.

**Action to be Taken:**

All owner/operators of trailer-mounted CHAOS amusement rides must install blocking as described in this bulletin at each set-up in order to correctly support the boom lift cylinder.

**Detail of Issue:**

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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Website: [www.rides.com](http://www.rides.com)

Bulletin No: B408R1204-0

Release Date: November 30, 1998

Effective Date: November 30, 1998

Supersedes: N/A

Completion Date: Immediate

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

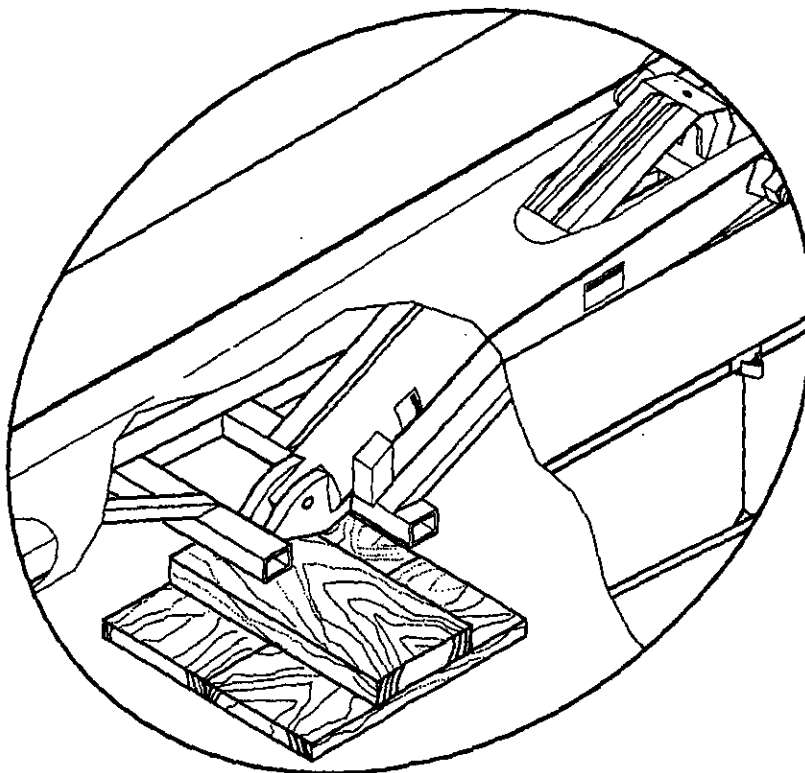
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Portable Units

Model No.: 408

Detail of Issue (continued):



1. Recommended use is a minimum of two blocks stacked on top of each other in a cross block style.
2. Recommended blocking size is 3" x 12" x 48" blocks on the bottom and 3" x 12" x 24" blocks on top.
3. Install blocks centered under lowest point of boom lift cylinder mounting ears.
4. Shim blocks as required to bring blocking within 1/8 to 1/4 inch of the boom lift cylinder mounting ears.



**CHANCE RIDES, INC.**

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Website: <http://www.rides.com>

Bulletin No: B408R1203-0

Release Date: January 11, 1999

Effective Date: January 11, 1999

Supersedes: N/A

Completion Date: February 1, 1999

Page: 1 of 5

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 40802097 and  
408-02297 through 408-03998

Model No.: 408

Abstract of Issue:  
Hub Gusset Kit

**Reason For Release:**

Chance Rides, Inc. has become aware that cracks can form in and around the gussets on the hub of the above noted CHAOS amusement rides.

**Action to be Taken:**

Chance Rides, Inc. requires all owner/operators to perform the following inspection and to order and install kit number K408R1203-0. This kit includes all of the parts needed to rework one ride. Kit K408R1203-0 is offered at no charge if ordered within 60 days of the issue date of this bulletin.

Kit number K408R1203-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K408R1203-2	GUSSET WELDMENT	7
60849700	HEX HEAD CAPSCREW ( 1/2-13 x 2-1/4" Grade 8)	14

**Detail of Issue:**

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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**CHANCE RIDES, INC.**

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Website: [www.rides.com](http://www.rides.com)

Bulletin No: B408R1203-0

Release Date: January 11, 1999

Effective Date: January 11, 1999

Supersedes: N/A

Completion Date: February 1, 1999

Page: 2 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

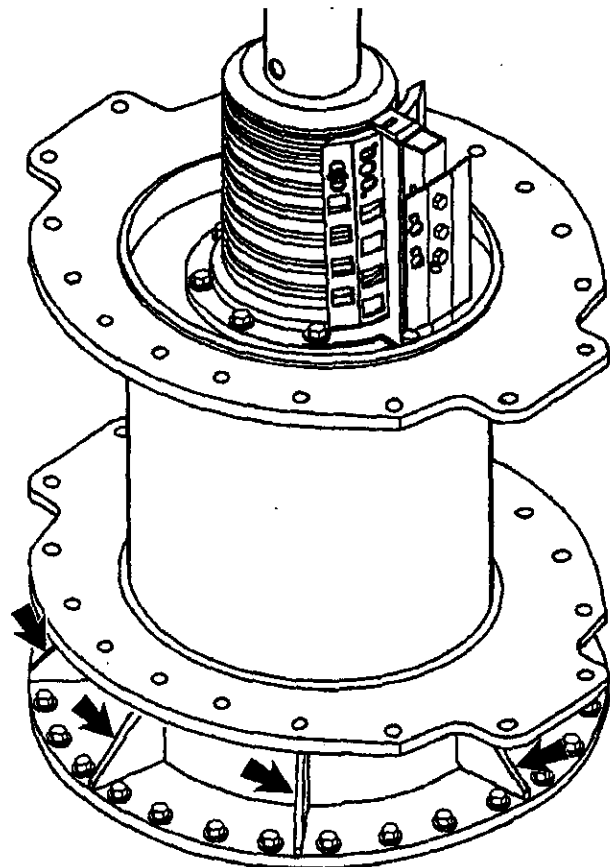
Affected Serial Nos.: 408-00196 through 40802097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

**INSPECTION PROCEDURE**

1. Visually inspect the seven existing gussets and the weld area around each gusset as shown.
2. If any cracks are found, contact Chance Rides, Inc. Customer Service Department for a repair procedure. If no cracks are found, install Kit number K408R1203-0.



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Bulletin No: B408R1203-0

Release Date: January 11, 1999

Effective Date: January 11, 1999

Supersedes: N/A

Completion Date: February 1, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

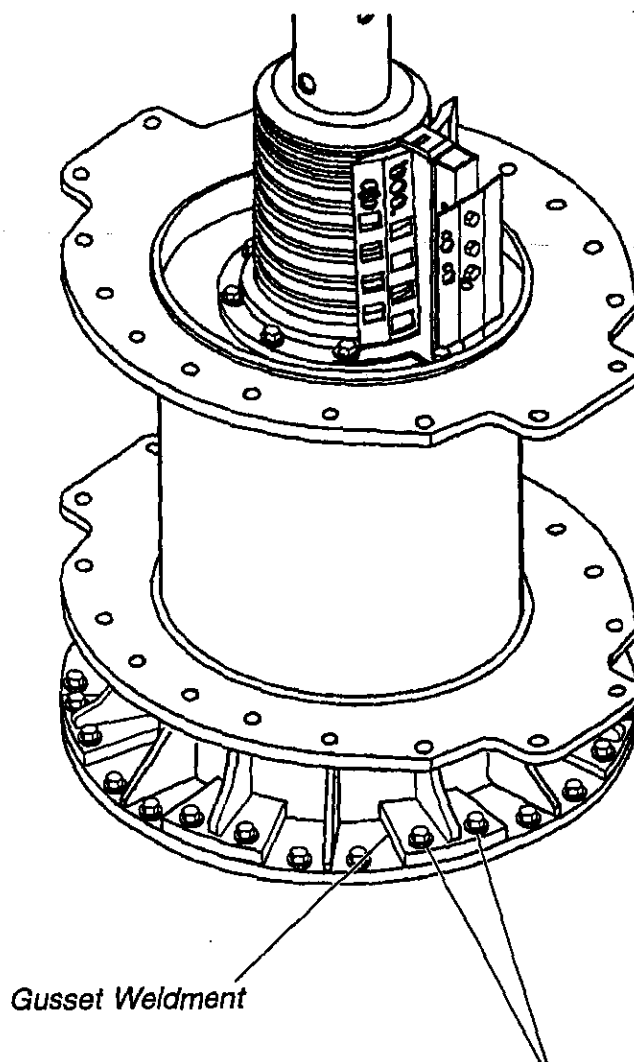
Affected Serial Nos.: 408-00196 through 40802097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

**INSTALLATION INSTRUCTIONS -****Kit Number K408R1203-1**

1. Remove and discard the two center hex head capscrew between two of the existing gussets. Retain the existing hardened washers which will be reused during installation of the new gusset weldments.
2. Clean the threaded holes of the bearing where the capscrews were removed.
3. Position one of the new gusset weldments in place. Using the existing hardened washers and the new 1/2-13 x 2-1/4" hex head capscrews, secure the gusset weldment in place. Apply Loctite® 271 (red) to the capscrew threads before installation. Using a torque wrench, tighten these capscrews to 90 ft-lbs.
4. Repeat Steps 1 and 2 above until all gusset weldments have been installed.



Gusset Weldment

1/2-13 x 2-1/4" hex head capscrews  
with existing hardened washers.  
Apply Loctite® 271 (red) and tighten to 90 ft-lbs.

**CHANCE RIDES, INC.**

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Bulletin No: B408R1203-0

Release Date: January 11, 1999

Effective Date: January 11, 1999

Supersedes: N/A

Completion Date: February 1, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

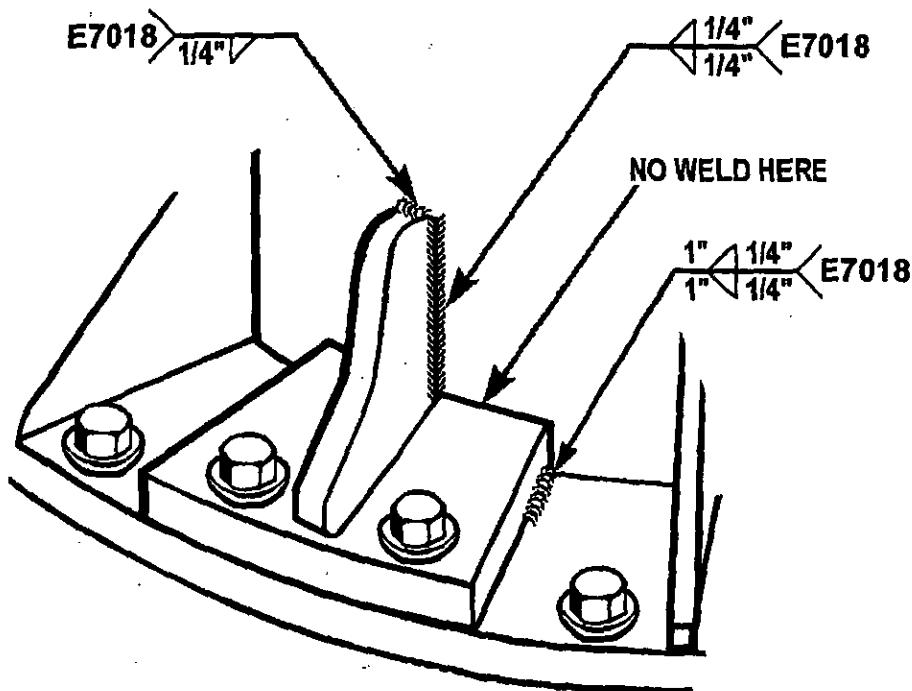
Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 40802097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

5. Weld the gussets in place using E-7018 welding rod. Weld only in the areas shown below.



6. Material surface to be welded must be above 70°F before welding. To avoid heat distortion of the hub, welds must be performed in the sequence shown on the following page.

**NOTE:** All welding must be done by a certified welder, following the sequence and procedure as outlined in this bulletin.

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Bulletin No: B408R1203-0

Release Date: January 11, 1999

Effective Date: January 11, 1999

Supersedes: N/A

Completion Date: February 1, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

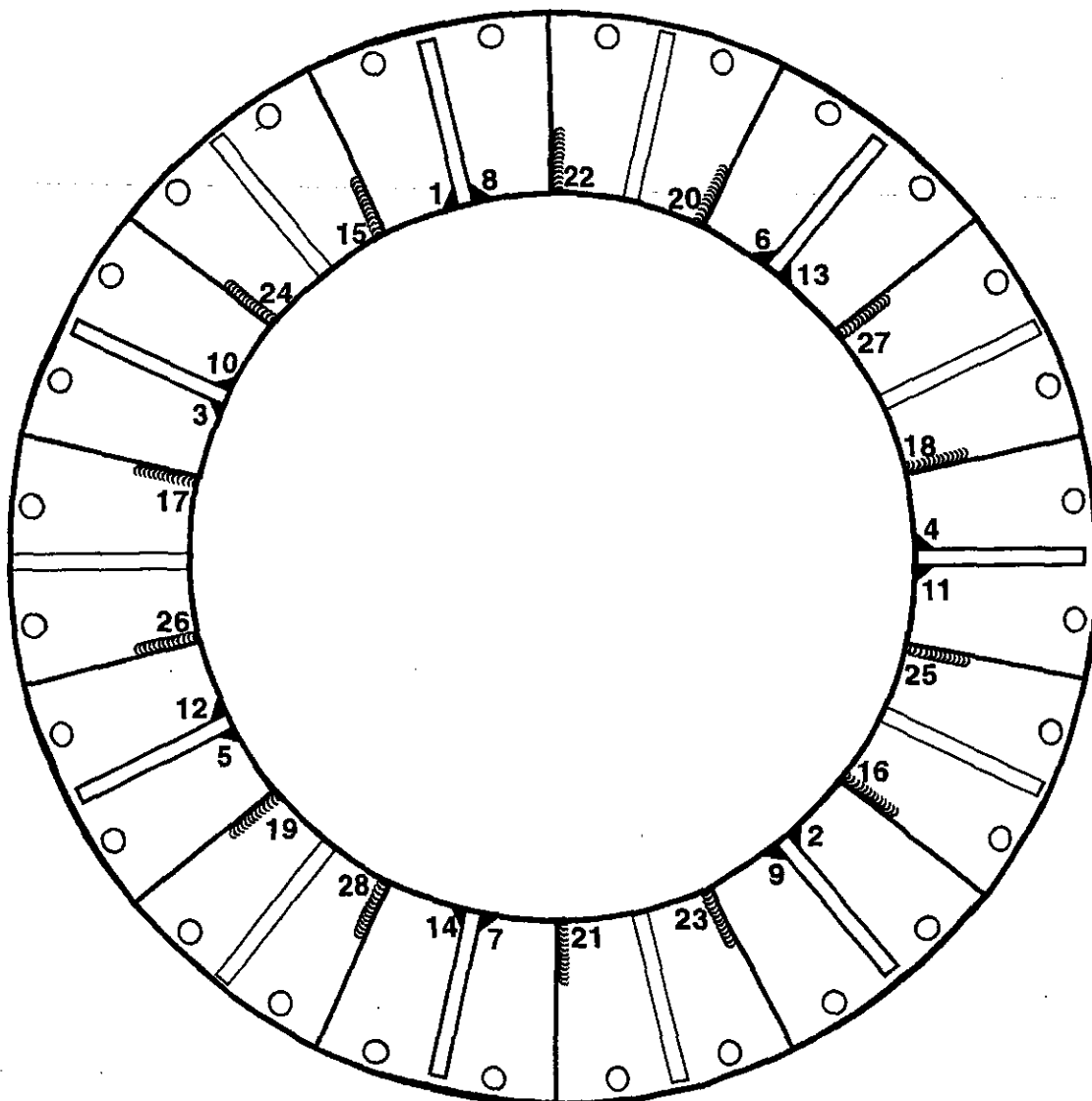
Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 40802097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

**Weld Sequence**



**CHANCE RIDES, INC.**  
 4219 Irving  
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 Phone: 1-800-242-6231 FAX: 1-316-942-7416  
 Website: <http://www.rides.com>

Bulletin No: P408R1207-0  
 Release Date: March 18, 1999  
 Effective Date: March 18, 1999  
 Supersedes: N/A  
 Completion Date: N/A

# NOTIFICATION

Ride Manufacturer: **CHANCE RIDES, INC.**

Affected Production Dates: All prior to 12/31/98

Ride Name: **CHAOS**

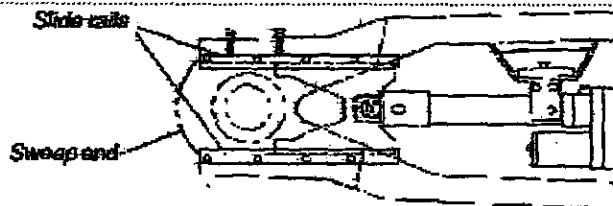
Affected Serial Nos.: All Prior to 408-04099

Model No.: **408**

Abstract of Issue: **VEHICLE LOCK SLIDE RAIL REWORK**

## Reason For Release:

Chance Rides, Inc. has developed a new slide rail for the vehicle lock mechanism on the CHAOS amusement ride. The new design incorporates adjustment for accurate rail alignment, and steel rails for long service life.



## Action to be Taken:

This product improvement can be made to the above amusement rides at the owner's option.

## Detail of Issue:

Order and install kit number K408R1207-0. The kit includes all necessary parts to rework one complete ride, with complete instructions for installation. The kit will be offered at a reduced price if ordered within 90 days of the release date of this bulletin.

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

Kit K408R1207 consists of the following:

<u>Part Number</u>	<u>Description</u>	<u>Quantity</u>
408-235A-001	VEHICLE LOCK SLIDE RAIL (Tapped holes)	18
408-235A-002	VEHICLE LOCK SLIDE RAIL (Slotted holes)	18
60767600	HEX HEAD CAPSCREW (3/8-16 x 2-1/4, Grade 5)	72
64781600	LOCK NUT - Nylon Insert (3/8-16)	72
68531000	FLAT WASHER - SAE (3/8)	144
60749400	HEX HEAD CAPSCREW (5/16-18 x 1, Grade 5)	36
64760000	JAM NUT (5/16-18)	36
60767000	HEX HEAD CAPSCREW (3/8-16 x 1-1/2, Grade 5)	72
68537400	LOCK WASHER (3/8)	72
408-240-002	SHIM - SLIDE RAILS (0.014)	576
K408R1207-0	INSTALLATION INSTRUCTIONS (drawing)	1

**NOTICE**

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

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Website: <http://www.rides.com>

Bulletin No: B408R1208-0

Release Date: March 18, 1999

Effective Date: March 18, 1999

Supersedes: N/A

Completion Date: Immediate

Page: 1 of 1

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

Model No.: 408

**Abstract of Issue:**

Vehicle Lock Slide Rail Lubrication

**Reason For Release:**

Chance Rides, Inc. has revised the lubricant specification for the vehicle lock slide rails and actuator yoke and cam on the CHAOS amusement ride. The new lubricant provides several benefits over the previously specified lubricant - better lubrication, longer maintenance intervals and better protection in extreme operating conditions.

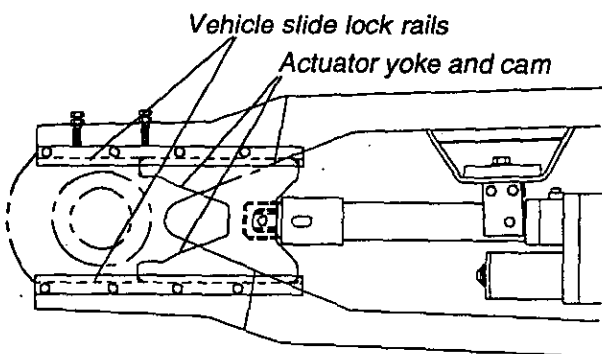
**Action to be Taken:**

All owner/operators of CHAOS amusement rides must use the lubricant specified in this bulletin to provide maximum service life of the slide lock components.

**Detail of Issue:**

Apply Loctite® Anti-Seize Lubricant (or equivalent) on the vehicle lock slide rails and actuator yoke and cam weekly, or at every set-up, whichever occurs first. This product can be obtained from most lubricant suppliers, and is available in an aerosol container. This allows application through the access holes in the sweep end covers. Apply lubricant in the areas shown on all sweeps.

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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Bulletin No: B408R1209-0

Release Date: March 18, 1999

Effective Date: March 18, 1999

Supersedes: N/A

Completion Date: April 18, 1999

Page: 1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02297 through 408-03998

Model No.: 408

Abstract of Issue:

Arm Guard Kit

Reason For Release:

Chance Rides, Inc. specifies in the CHAOS Operation Manual the correct way in which passengers are to be secured before the ride is started. The manual states that to avoid serious personal injury, passengers must keep their hands and feet inside the vehicle. It is the operator's responsibility to give safety instructions to the passengers and to make sure that they have their hands, arms, and feet inside the vehicle while the lap bar is being closed and locked. To further ensure that passengers' arms remain in the correct position, a caution decal\* and an arm guard kit have been developed.

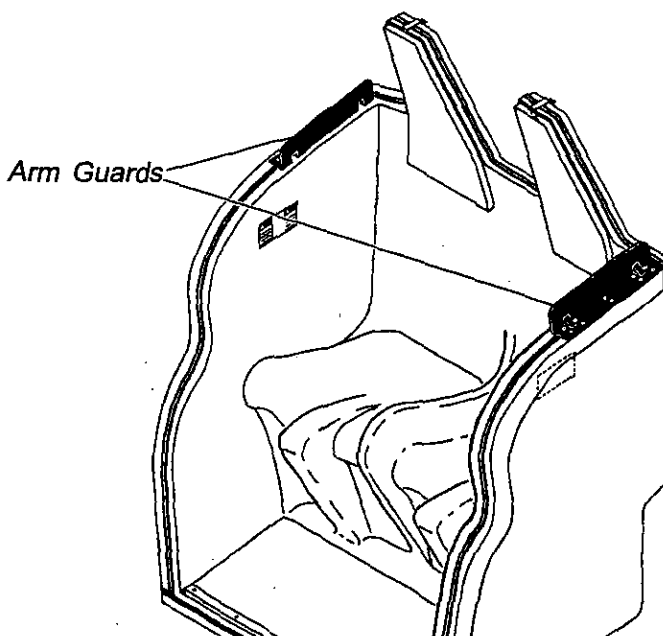
Action to be Taken:

All owners of the above noted amusement rides are required to order and install the Arm Guard Kit, number K408R1209-0.

This kit will be provided at no cost if ordered within 30 days of the release date of this bulletin.

The installation of this kit is in addition to following the recommendations in the CHAOS Operation Manual.

\* Refer to Chance Rides, Inc.  
service bulletin B408R1202-0



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Bulletin No: B408R1209-0

Release Date: March 18, 1999

Effective Date: March 18, 1999

Supersedes: N/A

Completion Date: April 18, 1999

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02297 through 408-03998

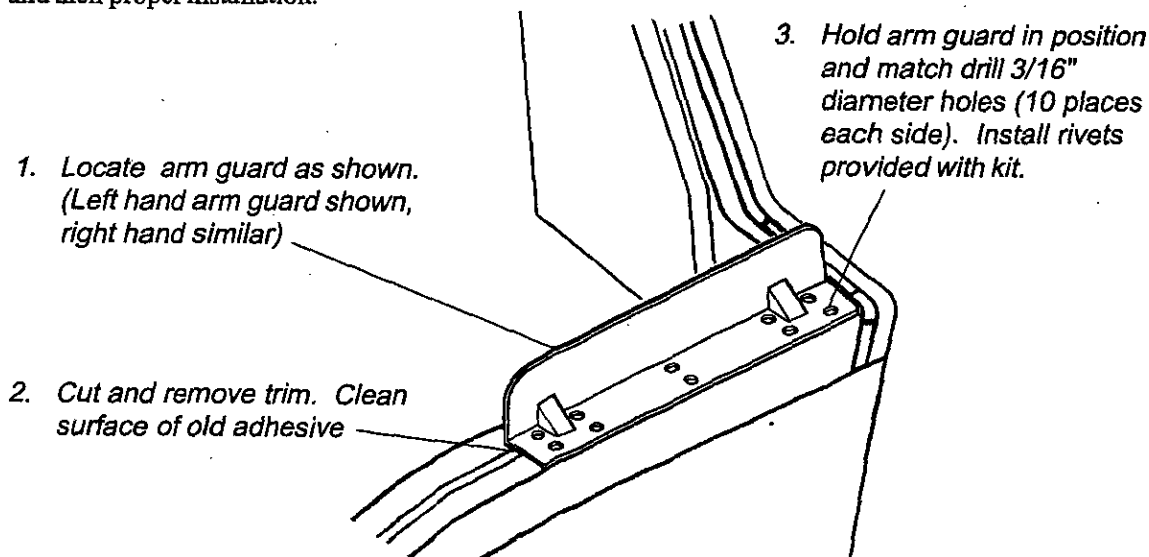
Model No.: 408

**Detail of Issue (continued):**

Install kit number K408R1209-0 using the instructions provided in this bulletin. Kit number K408R1209-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
408-178-001	ARM GUARD - Left Hand	18
408-178-002	ARM GUARD - Right Hand	18
66149000	RIVET - AD66BS (3/16")	360

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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Bulletin No: B408R1212-0

Release Date: July 7, 1999

Effective Date: July 7, 1999

Supersedes: N/A

Completion Date: August 7, 1999

Page: 1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

Model No.: 408

**Abstract of Issue:**

Inspection of Primary Restraint Bars

**Reason For Release:**

Chance Rides, Inc. has become aware that cracks can form in and around the ears on the back of the primary restraint bars on the CHAOS amusement ride.

**Action to be Taken:**

Chance Rides, Inc. requires all owner/operators to perform the inspection described in this bulletin. The inspection must be made annually.

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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Bulletin No: B408R1212-0

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Effective Date: July 7, 1999

Supersedes: N/A

Completion Date: August 7, 1999

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

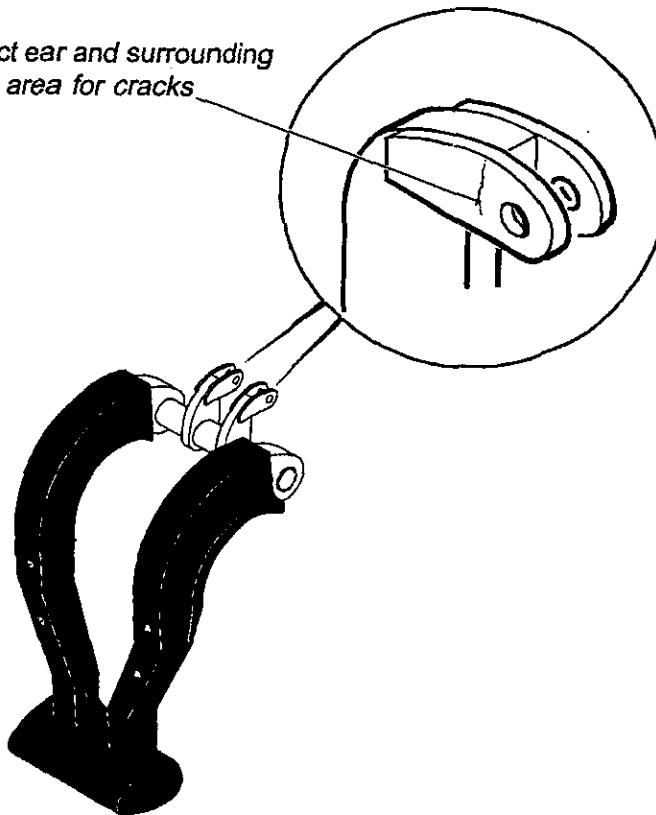
Model No.: 408

Detail of Issue (continued):

**Annual Inspection Procedure**

Visually inspect both primary restraint bars on all vehicles (36 total) as shown. If any cracks are found, contact the Chance Customer Service Department immediately. **DO NOT ATTEMPT TO REPAIR THE CRACK.**

Inspect ear and surrounding  
area for cracks



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Bulletin No: B408R1217-0

Release Date: July 7, 1999

Effective Date: July 7, 1999

Supersedes: N/A

Completion Date: August 7, 1999

Page: 1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 6/1/99

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-04499

Model No.: 408

**Abstract of Issue:****Boom Inspection****Reason For Release:**

Chance Rides, Inc. has become aware that cracks can form in and around the tilt head mounts on the boom of the above noted CHAOS amusement rides.

**Action to be Taken:**

Chance Rides, Inc. requires all owner/operators of these rides to inspect the boom in the area of the tilt head mount. This is an annual inspection.

**Detail of Issue:**

Perform the inspection described on the next page of this bulletin. If any indications are found, contact the CHANCE Customer Service Department immediately for instructions on further action to be taken. DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE BOOM, EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES, INC.

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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Bulletin No: B408R1217-0

Release Date: July 7, 1999

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Supersedes: N/A

Completion Date: August 7, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 6/1/99

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-04499

Model No.: 408

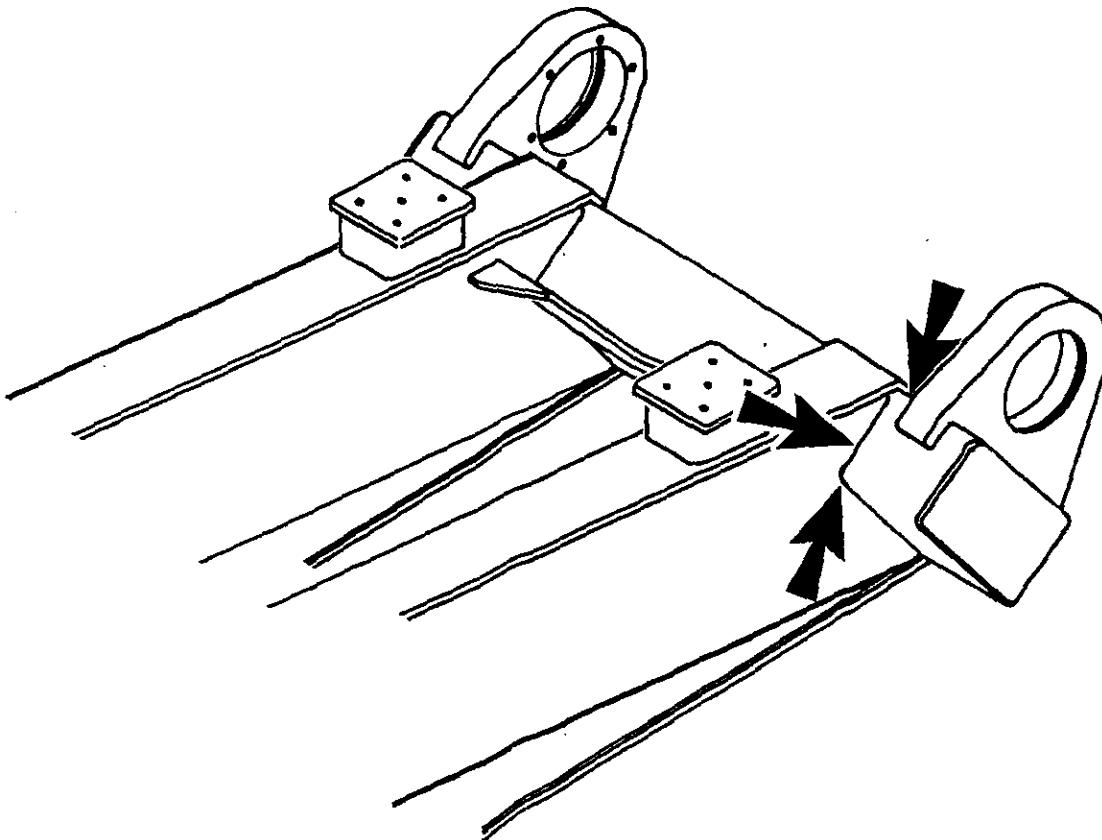
Detail of Issue (continued):

**ANNUAL INSPECTION PROCEDURE**

1. Visually inspect both sides of the boom in the areas shown.

~~NOT REPEATED BY CHANCE, TO BE DONE YEARLY;~~

2. If any cracks are found, contact the CHANCE Customer Service Department.



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Website: [www.rides.com](http://www.rides.com)

Bulletin No: B408R1210-0

Release Date: August 18, 1999

Effective Date: August 18, 1999

Supersedes: N/A

Completion Date: September 18, 1999

Page: 1 of 4

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

Model No.: 408

**Abstract of Issue:****Inspection, Replacement and Operation of Hydraulic Lock Cylinders****Reason For Release:**

The passenger restraint system on the above noted CHAOS amusement rides incorporates three hydraulic lock cylinders on each vehicle - one for each lap bar and one for the secondary restraint bar. In the event a hydraulic lock cylinder fails, a redundant mechanical lock prevents the restraint bar from opening.

Chance Rides, Inc. has become aware of a manufacturing defect which can affect the reliability and/or service life of the hydraulic lock cylinders. Although the defect has been corrected by the manufacturer, some defective cylinders have been shipped on new products and as replacement parts.

**Action to be Taken:**

All owners of the above noted amusement rides are required to inspect all hydraulic lock cylinders per the instructions on the following page of this bulletin. If any defective cylinders are found, order and install part number 22162104 in the appropriate quantity to replace all defective cylinders.

The parts will be provided at no charge if ordered within 30 days of the release date of this bulletin, subject to the return of the defective cylinders.

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.

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Bulletin No: B408R1210-0

Release Date: August 18, 1999

Effective Date: August 18, 1999

Supersedes: N/A

Completion Date: September 18, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

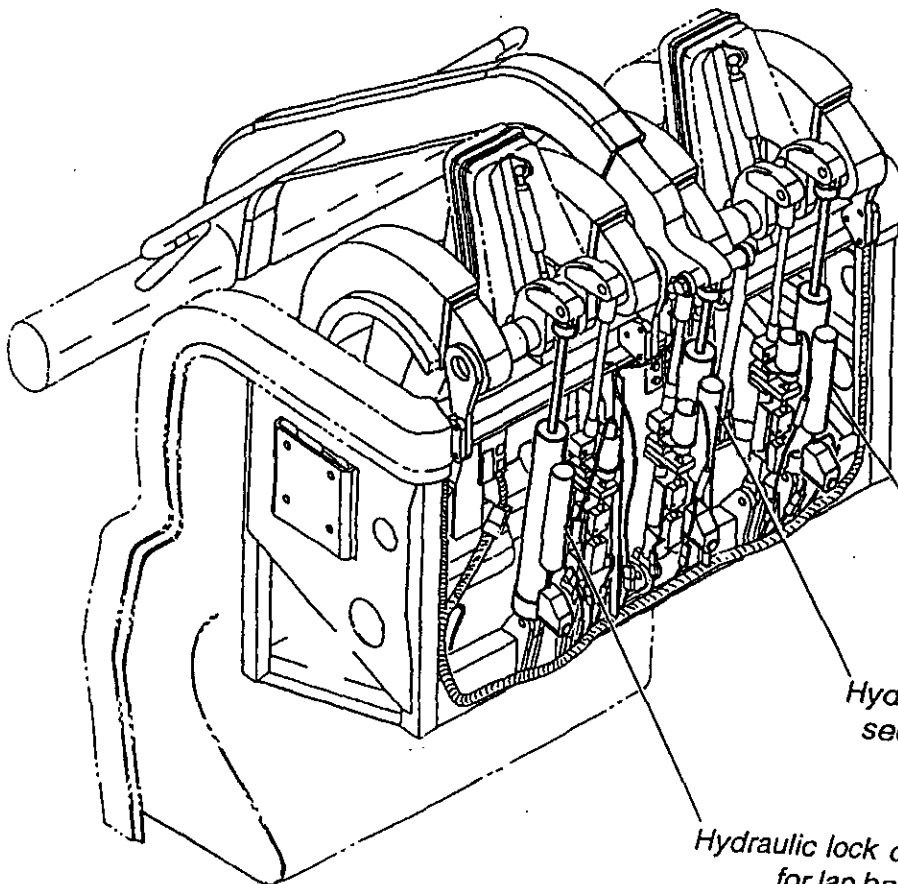
Model No.: 408

Detail of Issue (continued):

### Inspection Procedure

Inspect the three hydraulic lock cylinders on all vehicles (54 total). Identify the cylinders based on the distinguishing characteristics detailed on the next page.

**IMPORTANT:** Note the location at which each cylinder is installed. Pay particular attention to the cylinder for the secondary restraint bar (center position).



Hydraulic lock cylinder  
for lap bar

Hydraulic lock cylinder for  
secondary restraint bar

Hydraulic lock cylinder  
for lap bar





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Bulletin No: B408R1210-0

Release Date: August 18, 1999

Effective Date: August 18, 1999

Supersedes: N/A

Completion Date: September 18, 1999

Page: 3 of 4

Ride Manufacturer: CHANCE RIDES, INC.

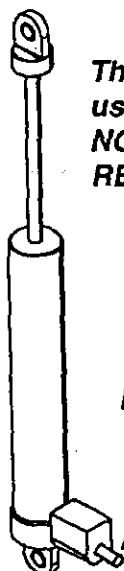
Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

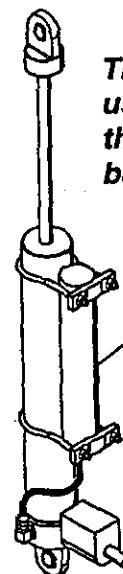
Model No.: 408

Detail of Issue (continued):



*These cylinders can be used on the lap bars, but **NOT THE SECONDARY RESTRAINT BAR (center)***

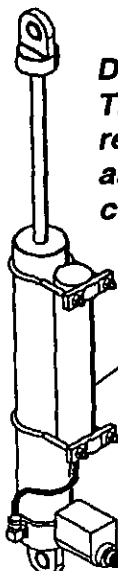
Red release plunger



*These cylinders can be used on the lap bars and the secondary restraint bars*

Accumulator

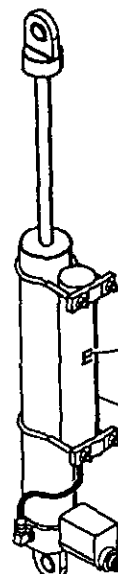
Red release plunger



**DO NOT USE.**  
*These cylinders must be returned to the factory and replaced with the correct cylinder.*

Accumulator

Black release button



*These cylinders can be used on the lap bars and the secondary restraint bars. They are visually the same as the cylinder at left, except for the stamped letter as shown.*

Letter "E" stamped on accumulator

Accumulator

Black release button

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Completion Date: September 18, 1999

Page: 4 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

Model No.: 408

## Detail of Issue (continued):

**Operation - Manually releasing passenger restraints**

Use the following information in conjunction with the procedure in the CHAOS Operation Manual.

**To manually release the LAP BAR on this side of the vehicle:**

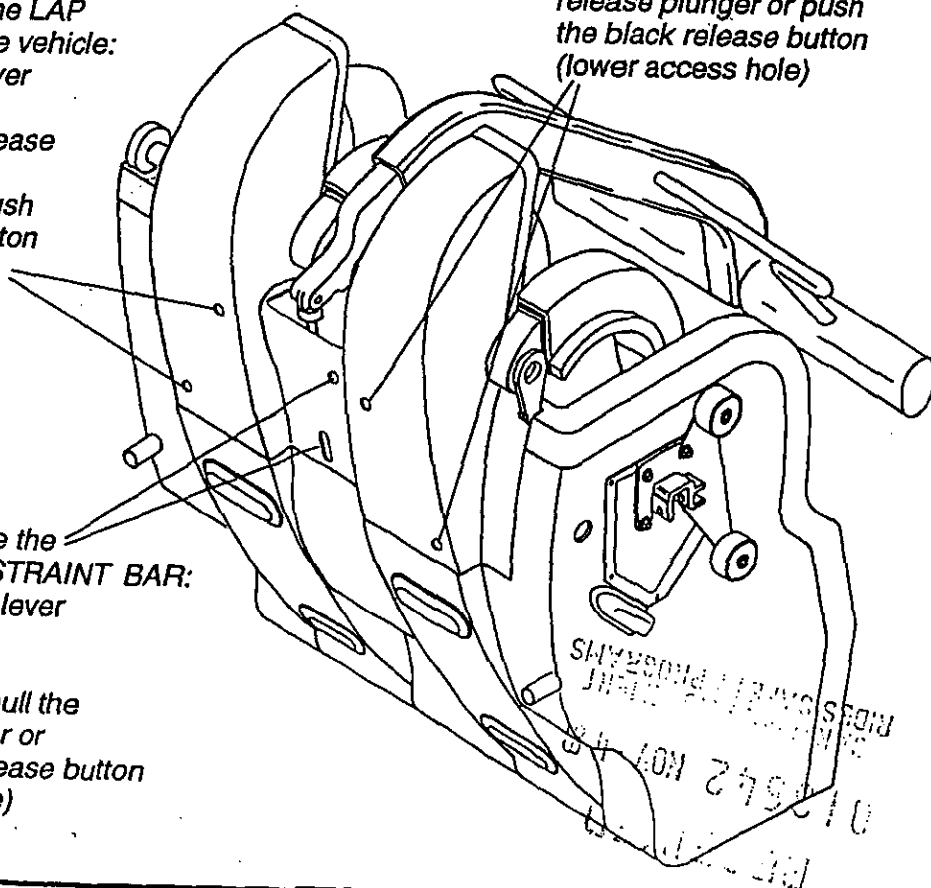
- Raise the release lever (top access hole).
- While holding the release lever up, pull the red release plunger or push the black release button (lower access hole)

**To manually release the LAP BAR on this side of the vehicle:**

- Raise the release lever (top access hole).
- While holding the release lever up, pull the red release plunger or push the black release button (lower access hole)

**To manually release the SECONDARY RESTRAINT BAR:**

- Raise the release lever (top access hole).
- While holding the release lever up, pull the red release plunger or push the black release button (lower access hole)



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Bulletin No: B408R1214-0

Release Date: September 10, 1999

Effective Date: September 10, 1999

Supersedes: N/A

Completion Date: October 10, 1999

Page: 1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 4/1/99

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-04399

Model No.: 408

**Abstract of Issue:**

Sweep Insert Panel Rework

**Reason For Release:**

Chance Rides, Inc. has become aware that the sweep insert panels on the CHAOS amusement ride can wear at the guide pins. If the wear becomes severe, the panel can separate from the ride, causing possible damage to the ride or injury to the passengers and/or bystanders.

**Action to be Taken:**

All owners of the above noted amusement rides are required to order and install the Sweep Insert Modification Kit, part number K408R1214-0. The kit will be provided at a reduced cost if ordered within 30 days of the release date of this bulletin.

Install the kit using the instructions provided in this bulletin.

Kit number K408R1214-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K408R1214-003	GUIDE PIN WELDMENT	36
408-269-018	GUIDE PIN	36
60700600	HEX HEAD CAPSCREW (1/4-20 x 1-1/4")	36
60700800	HEX HEAD CAPSCREW (1/4-20 x 1-1/2")	36
68530200	FLAT WASHER (1/4")	72
68537000	LOCK WASHER (1/4")	36
64780800	LOCK NUT (1/4-20, Nylon Insert)	72

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

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Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 4/1/99

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-04399

Model No.: 408

Detail of Issue (continued):

**NOTICE**

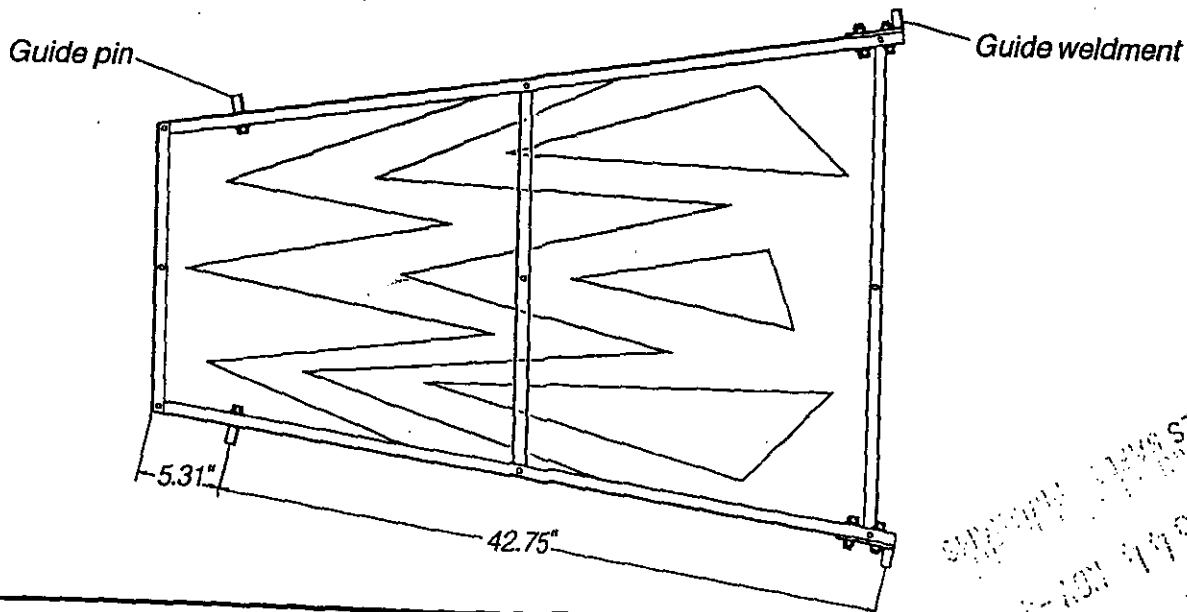
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**INSTALLATION INSTRUCTIONS**

1. Cut off existing guide pins and grind smooth (4 places each insert panel).
2. Locate the holes for the guide pins at the narrow end of the insert panel and the guide weldments as shown. Drill 0.28" diameter (6 places each insert panel).
3. Install guide pins with 1/4-20 x 1-1/2" hex head capscrews, flat washers and lock washers. Install the guide weldments with 1/4-20 x 1-1/4" hex head capscrews, flat washers and lock nuts. Install all capscrews from the inside, pointing out.

**IMPORTANT:** Inspect all components of the sweep insert panels, including the rivets which secure the molded panel to the frame. Replace any worn or damaged parts before installing the sweep insert panels on the ride.



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Completion Date: October 10, 1999

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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 6/28/96 through 1/28/97

Ride Name: CHAOS

Affected Serial Nos.: 408-00296 through 408-01997

Model No.: 408

**Abstract of Issue:****Lap Bar Lock Inspection, Repair and Maintenance****Reason For Release:**

The lap bars on the CHAOS amusement ride each incorporate two latch mechanisms. In addition to the redundant latches, the secondary restraint bar further secures the lap bars.

Chance Rides, Inc. has become aware that the lap bar latches and related components can wear after extended use. If the wear becomes severe, the lap bar cannot be securely locked. This can result in serious personal injury to the passenger.

**DO NOT OPERATE THE RIDE UNLESS ALL LAP BAR LOCKING DEVICES ARE IN GOOD OPERATING CONDITION.** This includes both latches on each lap bar, the lap bar padding, and all components of the secondary restraint bar.

**Action to be Taken:**

All owners of the above noted amusement rides are required to inspect and maintain all lap bars as instructed in this bulletin. Any worn, damaged or missing parts must be repaired or replaced immediately.

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

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Bulletin No: B408R1216-0

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Completion Date: October 10, 1999

Page: 2 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 6/28/96 through 1/28/97

Ride Name: CHAOS

Affected Serial Nos.: 408-00296 through 408-01997

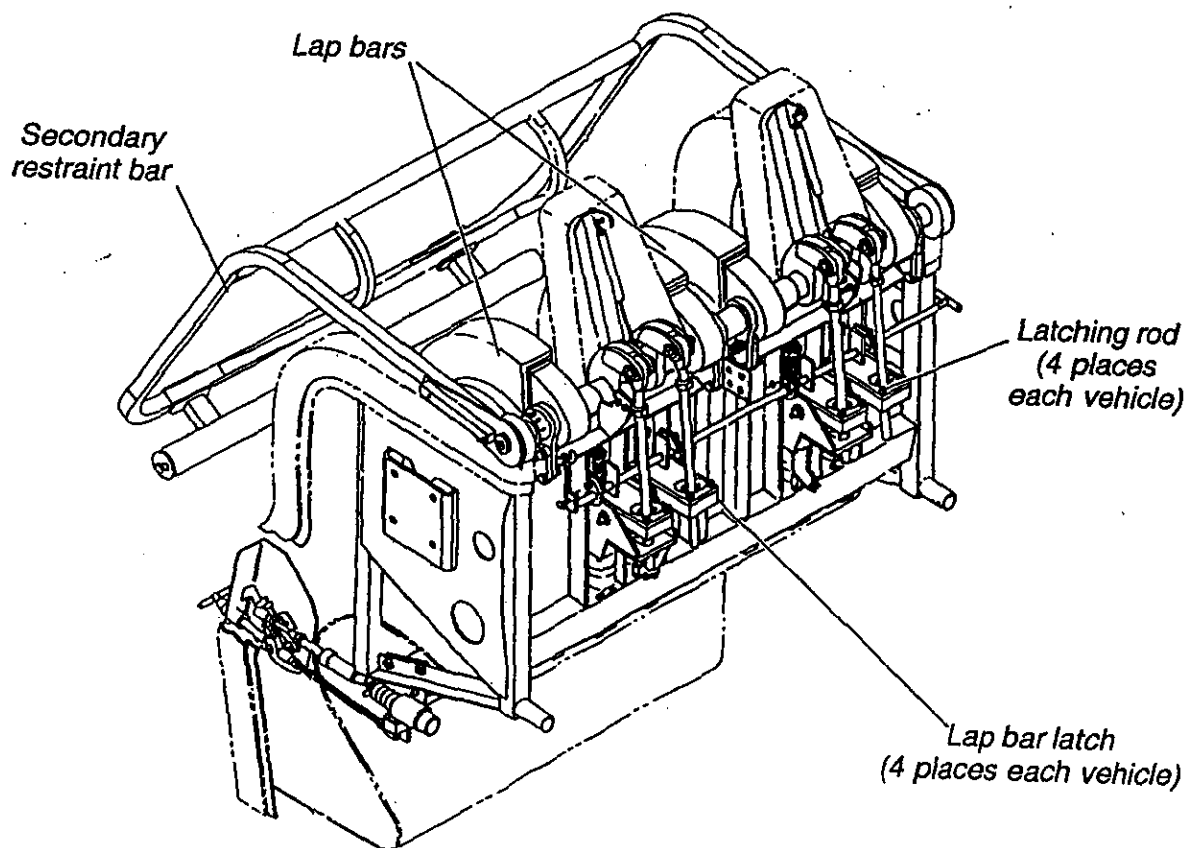
Model No.: 408

Detail of Issue (continued):

**INSPECTION PROCEDURE**

Inspect the lap bar lock components as described on the following pages of this bulletin. Replace any components that are worn or damaged.

The components are identified in the illustration below.



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Bulletin No: B408R1216-0

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Supersedes: N/A

Completion Date: October 10, 1999

Page: 3 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 6/28/96 through 1/28/97

Ride Name: CHAOS

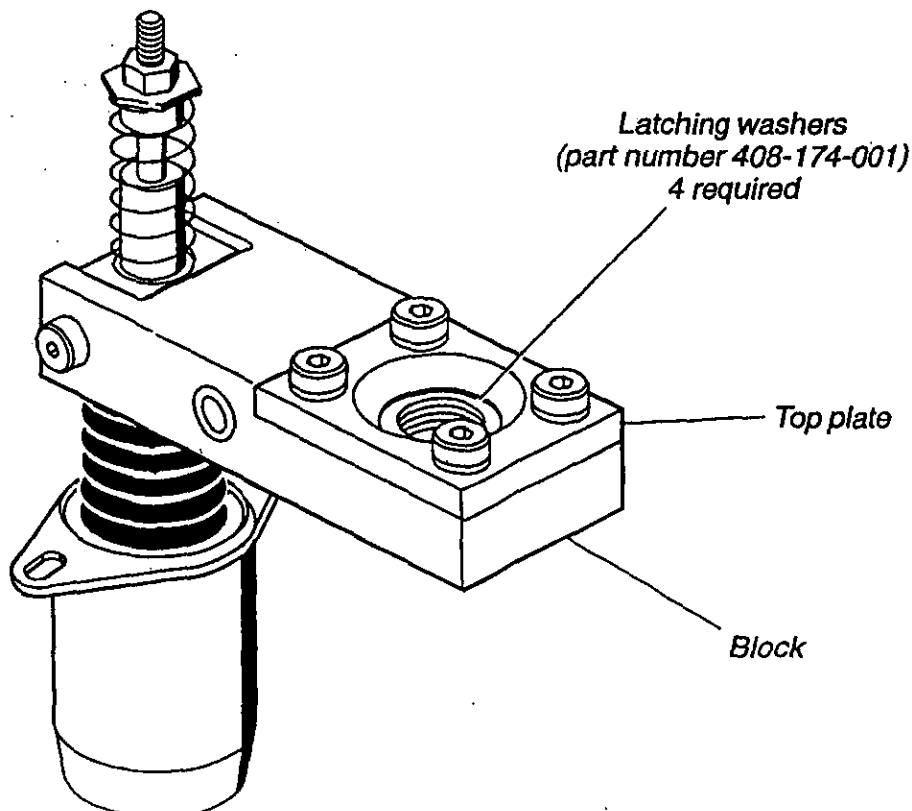
Affected Serial Nos.: 408-00296 through 408-01997

Model No.: 408

Detail of Issue (continued):

1. Inspect the lap bar latches for the following:

- The inside diameter of the four latching washers must not show signs of chamfering. The inside edges must be square, with no elongation of the holes.
- If the holes in the top plate or block show signs of contact with the latching rod, this indicates wear of the latching washers.
- All parts must be clean and free of lubricants or any other residue. When assembled, the washers must move freely in the block.





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Bulletin No: B408R1216-0

Release Date: September 10, 1999

Effective Date: September 10, 1999

Supersedes: N/A

Completion Date: October 10, 1999

Page: 4 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 6/28/96 through 1/28/97

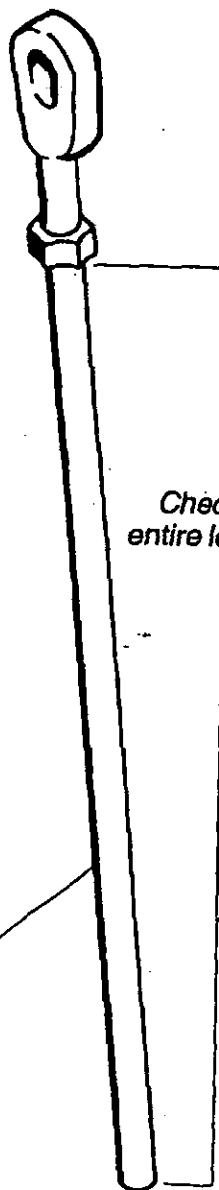
Ride Name: CHAOS

Affected Serial Nos.: 408-00296 through 408-01997

Model No.: 408

**Detail of Issue (continued):**

2. Inspect the latching rods. The entire length of the rod must be clean, smooth and free of corrosion or other damage



*Check condition along  
entire length of latching rod*

*Latching rod  
(part number  
408-152-001)*



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 6/28/96 through 1/28/97

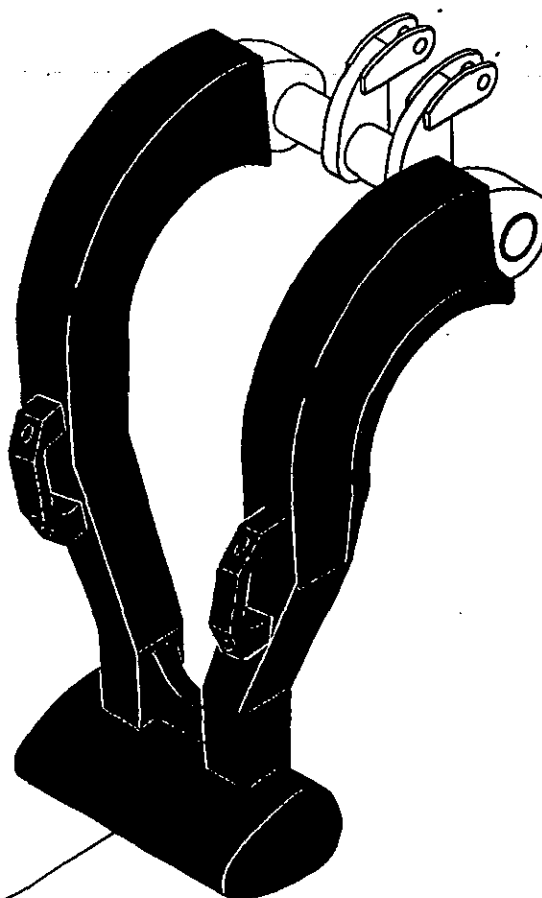
Ride Name: CHAOS

Affected Serial Nos.: 408-00296 through 408-01997

Model No.: 408

Detail of Issue (continued):

3. Inspect the lap bar padding where it contacts the secondary restraint bar. If the padding has a groove matching the contact area of the secondary restraint bar, this indicates the latching washers are worn. The lap bar padding must be in good condition.



*Inspect padding in this  
area for grooves matching  
the contact area with the  
secondary restraint bar*

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Bulletin No: B408R1216-0

Release Date: September 10, 1999

Effective Date: September 10, 1999

Supersedes: N/A

Completion Date: October 10, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 6/28/96 through 1/28/97

Ride Name: CHAOS

Affected Serial Nos.: 408-00296 through 408-01997

Model No.: 408

Detail of Issue (continued):

**WEEKLY OPERATIONAL CHECK**

With the cover removed from the rear of the vehicle, watch the operation of the two lap bar latches. Repeat the process for both lap bars on every vehicle. This check must be made weekly or at every set-up, whichever occurs first.

1. Make sure the latching washers move freely. DO NOT LUBRICATE THE WASHERS OR LATCH RODS.
2. As the lap bar is raised, the left hand latch must fully engage and lock on the latching rod before the right hand latch engages.
3. Manually hold the left hand latch up to prevent it from engaging on the latch rod. As the bar is raised, the right hand latch must fully engage on the latching rod.
4. Check the operation of the secondary restraint bar. With the secondary restraint bar closed, manually release and raise each lap bar. Check for solid contact between the lap bar padding and the secondary restraint bar.

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64-101 549812  
11/10/99

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Bulletin No: P408R1232-0

Release Date: November 10, 1999

Effective Date: November 10, 1999

Supersedes: N/A

Completion Date: N/A

Page: 1 of 2

# NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 4/1/99

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-04399

Model No.: 408

**Abstract of Issue:****Sweep Insert Panel Mounting Channels****Reason For Release:**

Chance Rides, Inc. has become aware that the sweep insert panel mounting channels on the CHAOS amusement ride can wear after years of operation. If the wear becomes severe, the panel can separate from the ride, causing possible damage to the ride or injury to the passengers and/or bystanders. The mounting channels can be replaced if wear is found during regular inspections of the ride.

**Action to be Taken:**

Chance Rides, Inc. has re-designed the sweep insert mounting channels. The new design is made of stainless steel, to provide longer service life and reduced maintenance costs.

Owner/operators of the above noted amusement rides can make this product improvement at their option. Order Kit number K408R1232-0, which contains all parts necessary to rework one complete ride. Install the kit using the instructions provided 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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Bulletin No: P408R1232-0

Release Date: November 10, 1999

Effective Date: November 10, 1999

Supersedes: N/A

Completion Date: N/A

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 11/1/99

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-04799

Model No.: 408

## **Detail of Issue**

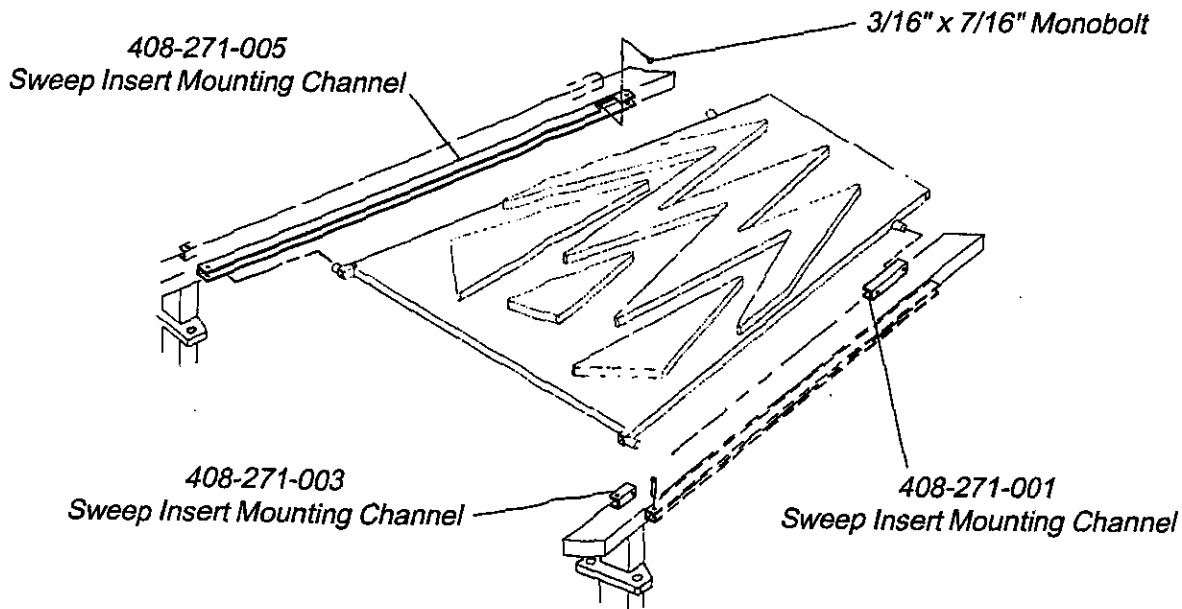
Kit number K408R1232-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
408-271-001	SWEEP INSERT MOUNTING CHANNEL	18
408-271-003	SWEEP INSERT MOUNTING CHANNEL	18
408-271-005	SWEEP INSERT MOUNTING CHANNEL	18
66166200	MONOBOLT (3/16 x 7/16 Steel)	180

**NOTE:** The above parts can also be ordered individually as replacement parts. The old design parts are no longer available.

## **INSTALLATION INSTRUCTIONS**

1. Drill out the existing rivets to remove the old mounting channels. Discard the channels.
2. Locate the new channels as shown in the same positions as the channels which were removed.
3. Attach the new channels with the fasteners provided with the kit.



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Website: [www.rides.com](http://www.rides.com)

Bulletin No: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-02097 and  
408-02297 through 408-03998

Model No.: 408

**Abstract of Issue:**

Hub Gusset Kit

**Reason For Release:**

Chance Rides, Inc. has become aware that cracks can form in and around the gussets on the hub of the above noted CHAOS amusement rides.

**Action to be Taken:**

Chance Rides, Inc. requires all owner/operators to perform the following inspection and to order and install kit number K408R1203-0. This kit includes all of the parts needed to rework one ride. Kit K408R1203-0. is offered at no charge if ordered within 60 days of the issue date of this bulletin.

Kit number K408R1203-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K408R1203-2	GUSSET WELDMENT	7
60849700	HEX HEAD CAPSCREW ( 1/2-13 x 2-1/4" Grade 8)	14

**NOTE:** If the main bearing has been replaced, 1/2-13 x 3-1/4" Grade 8 capscrews (part number 60850600) may be required. See details in this bulletin.

**Detail of Issue:**

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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Bulletin No: B408R1203-A

Release Date: December 8, 1999

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Supersedes: B408R1203-0

Completion Date: January 8, 2000

Page: 2 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

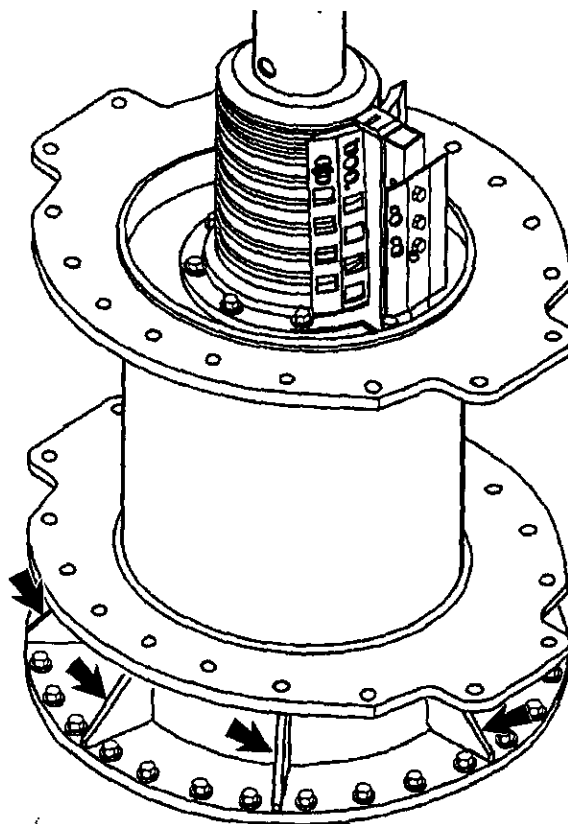
Affected Serial Nos.: 408-00196 through 408-02097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

**INSPECTIONPROCEDURE**

1. Visually inspect the seven existing gussets and the weld area around each gusset as shown.
2. If any cracks are found, contact Chance Rides, Inc. Customer Service Department for a repair procedure. If no cracks are found, install Kit number K408R1203-0.



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Release Date: December 8, 1999

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

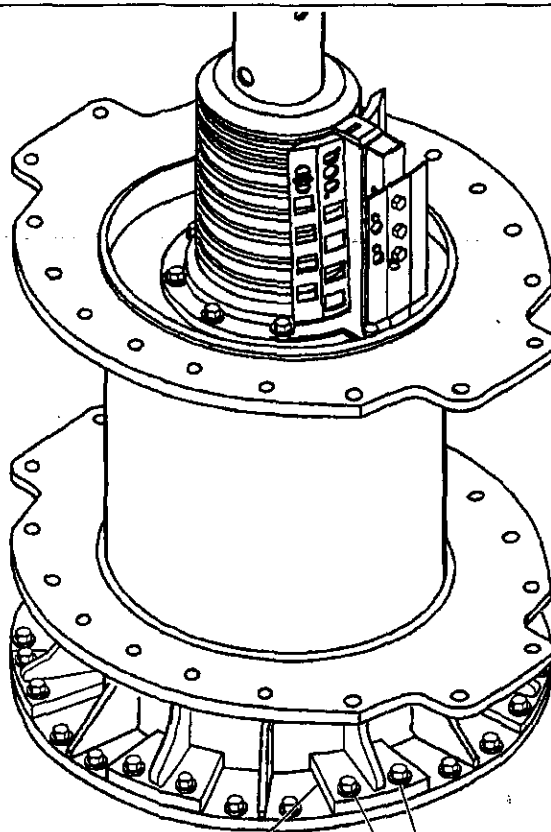
Affected Serial Nos.: 408-00196 through 408-02097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

**INSTALLATION INSTRUCTIONS -****Kit Number K408R123-1**

1. Remove and discard the two center hex head capscrew between two of the existing gussets. Retain the existing hardened washers which will be reused during installation of the new gusset weldments.
2. Clean the threaded holes of the bearing where the capscrews were removed.
3. Position one of the new gusset weldments in place. Using the existing hardened washers and the new 1/2-13 x 2-1/4" hex head capscrews, secure the gusset weldment in place. Apply Loctite® 271 (red) to the capscrew threads before installation. Using a torque wrench, tighten these capscrews to 90 ft-lbs.
4. Repeat Steps 1 and 2 above until all gusset weldments have been installed.



Gusset Weldment

1/2-13 x 2-1/4" hex head capscrews  
- or -

1/2-13 x 3-1/4" hex head capscrews  
(see detail on following page)

Use existing hardened washers.

Apply Loctite® 271 (red) and tighten to 90 ft-lbs.

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Completion Date: January 8, 2000

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

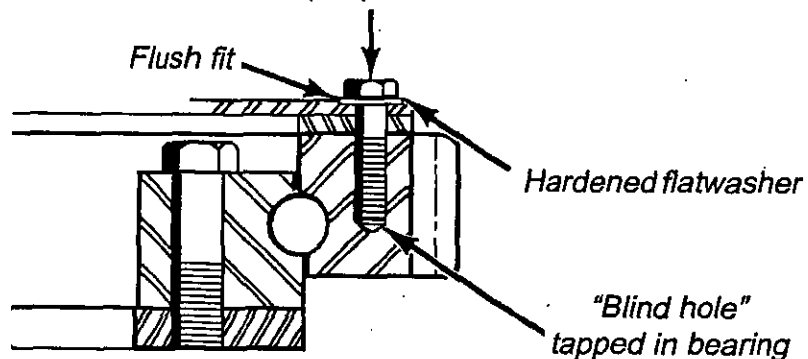
Affected Serial Nos.: 408-00196 through 408-02097 and  
408-02297 through 408-03998

Model No.: 408

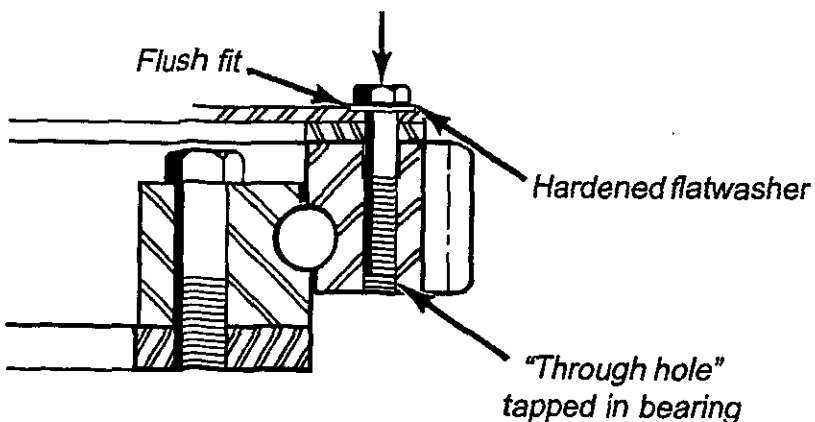
## Detail of Issue (continued):

**IMPORTANT:** Inspect the tapped holes  
in the bearing as shown  
to determine the correct  
length of capscrew.

**1/2-13 x 2-1/4" long Grade 8 Capscrew**  
80 ft-lbs torque (monthly check).  
90 ft-lbs torque (initial installation with Loctite® 271)



**1/2-13 x 3-1/4" long Grade 8 Capscrew**  
80 ft-lbs torque (monthly check).  
90 ft-lbs torque (initial installation with Loctite® 271)





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Bulletin No: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

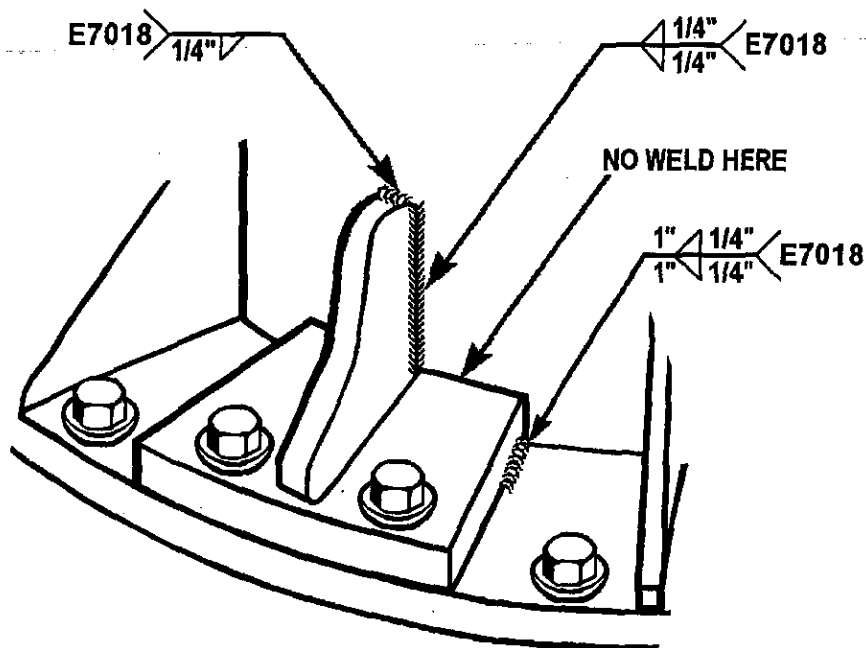
Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-02097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

5. Weld the gussets in place using E-7018 welding rod. Weld only in the areas shown below.



6. Material surface to be welded must be above 70° F before welding. To avoid heat distortion of the hub, welds must be performed in the sequence shown on the following page.

**NOTE:** All welding must be done by a certified welder, following the sequence and procedure as outlined in this bulletin.

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Ride Manufacturer: CHANCE RIDES, INC.

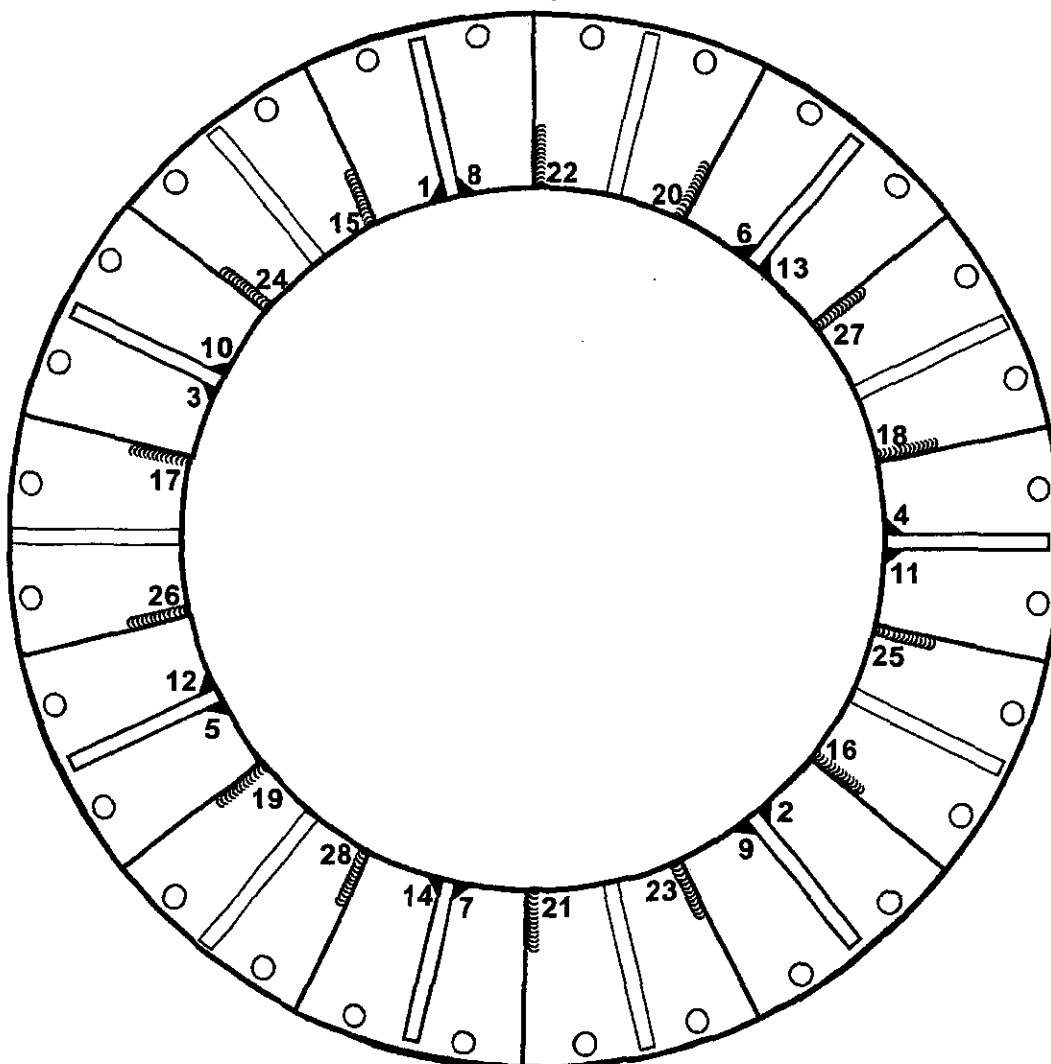
Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-02097 and  
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

**Weld Sequence**

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Bulletin No: P408R1219-0

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Effective Date: August 1, 2000

Supersedes: N/A

Completion Date: N/A

Page: 1 of 3

# NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS (Portable models only)

Affected Serial Nos.: All units

Model No.: 408

**Abstract of Issue:**

Ramp Support Brace Kit

**Reason For Release:**

The normal flexing of the entrance/exit ramps on the CHAOS amusement ride can, after an extended time, result in weakening of the ramp. To extend the service life of the ramps, CHANCE RIDES, Inc. has developed a kit which, when properly installed, provides additional support to the ramps.

**Action to be Taken:**

All owner/operators of the above noted portable model CHAOS amusement rides can, at their option, order and install the ramp support kit as described in this bulletin at each set-up in order to support the entrance and exit ramps.

Order the Ramp Support Kit, part number K408R1219-0, which provides all parts necessary for one complete ride. The kit will be provided at a reduced price if ordered within 30 days of the release date of this bulletin.

Kit number K408R1219-0 contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
408-865-001	RAMP BRACE ASSEMBLY - Short	2
408-865-002	RAMP BRACE ASSEMBLY - Long	2

Installation instructions are provided on the following pages of this bulletin, as well as replacement parts ordering information.

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



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Effective Date: August 1, 2000

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Completion Date: N/A

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS (Portable models only)

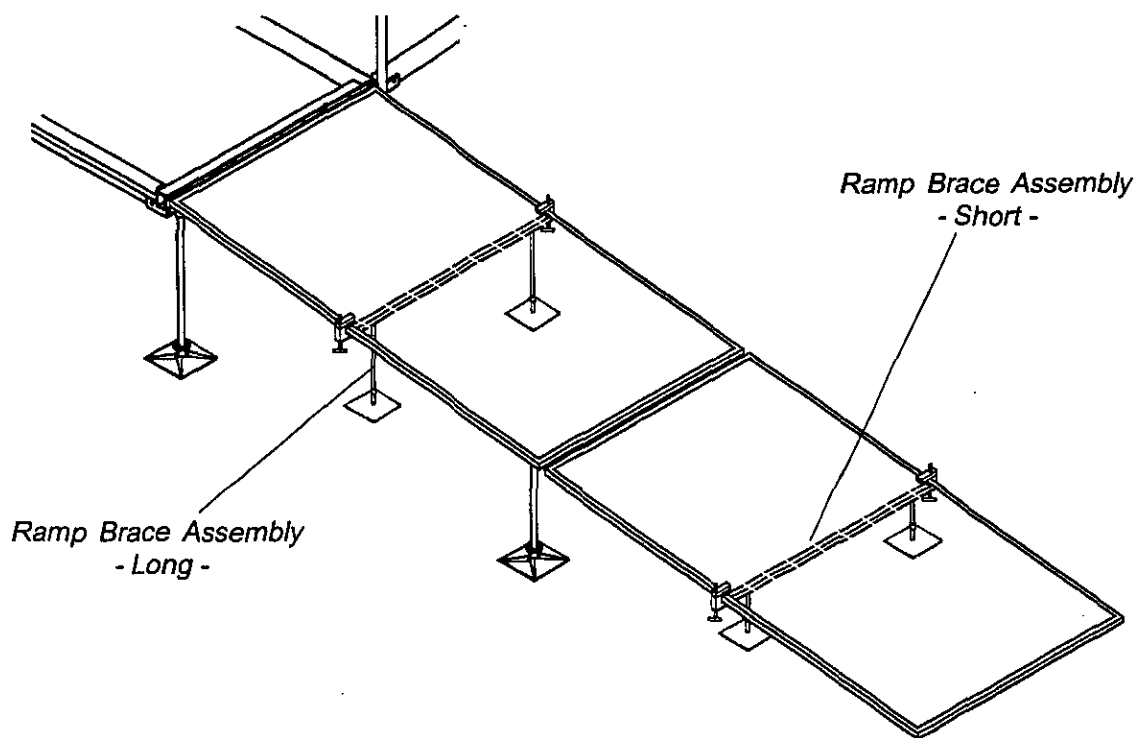
Affected Serial Nos.: All units

Model No.: 408

Detail of Issue (continued):

## **Installation Instructions - Ramp Brace Kit K408R1219-0**

Install the ramp braces at every set-up using the following procedure.



1. Install the ramp braces under the entrance and exit ramps as shown. Locate the ramp braces in the center of each ramp section.
2. Extend or retract the screw jacks as required to support the ramps.
3. Tighten the clamps to secure the braces to the ramps.

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Completion Date: N/A

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS (Portable models only)

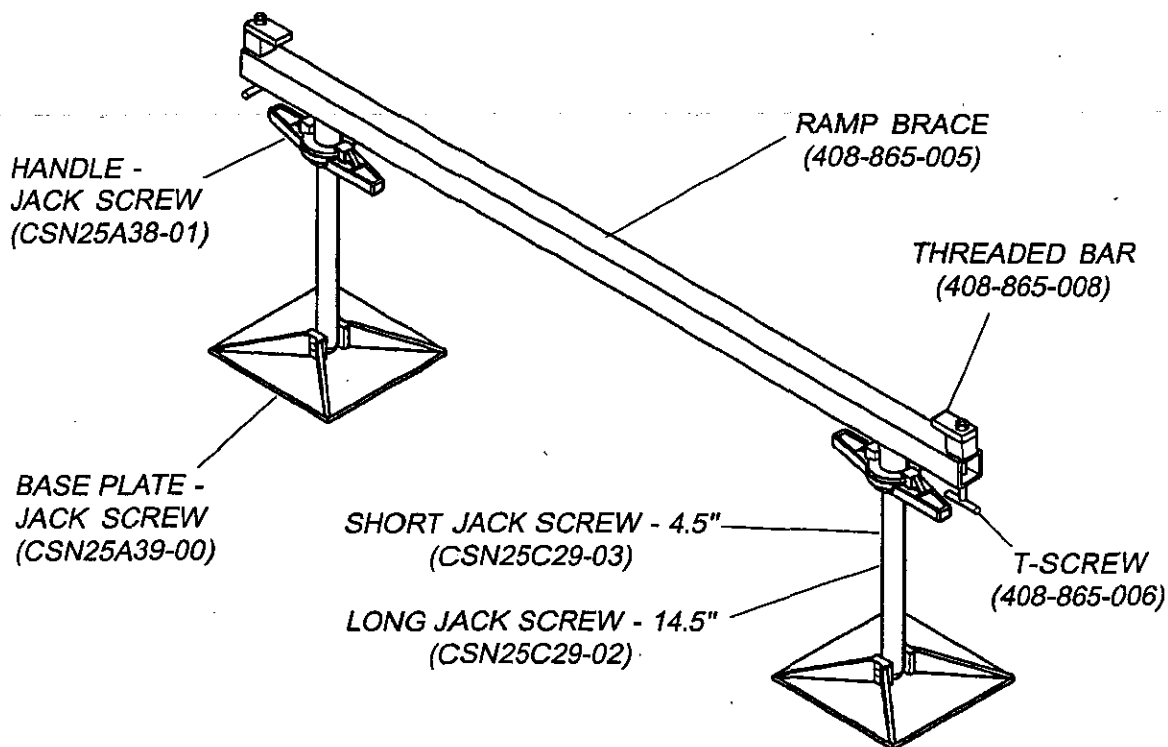
Affected Serial Nos.: All units

Model No.: 408

Detail of Issue (continued):

**Parts List - Ramp Brace Kit**

Use the following information if replacement of individual parts is required.

**NOTICE**

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

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Bulletin No: B408R1222-A

Release Date: August 1, 2000

Effective Date: August 1, 2000

Supersedes: B408R1222-0

Completion Date: September 1, 2000

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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 and on

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

**Abstract of Issue:**

Inspection of Secondary Restraint Bars

**Reason For Release:**

Chance Rides, Inc. has become aware of a single occurrence where a crack developed in the curved area of the secondary restraint bars of the CHAOS amusement ride. A break in the secondary restraint bar can possibly result in personal injury to the operator, passengers, and/or bystanders.

This bulletin revision is being issued to provide information on the inspection boot, which can be installed at the owner/operator's option. This removable boot facilitates the required annual inspection of the secondary restraint bars.

**Action to be Taken:**

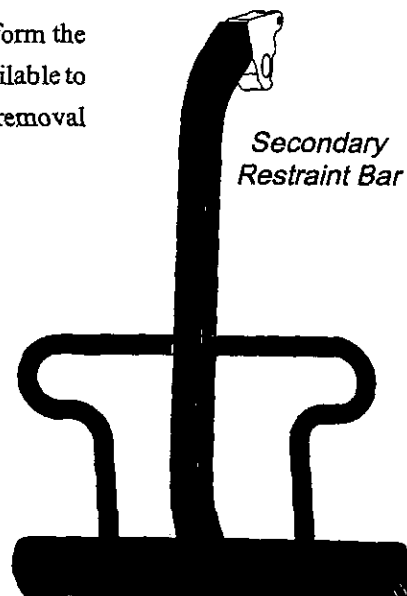
All owners of the above noted amusement rides are required to perform the inspection described in this bulletin annually. If desired, a boot is available to cover the inspection area. Subsequent annual inspection requires the removal of the boot.

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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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 and on

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

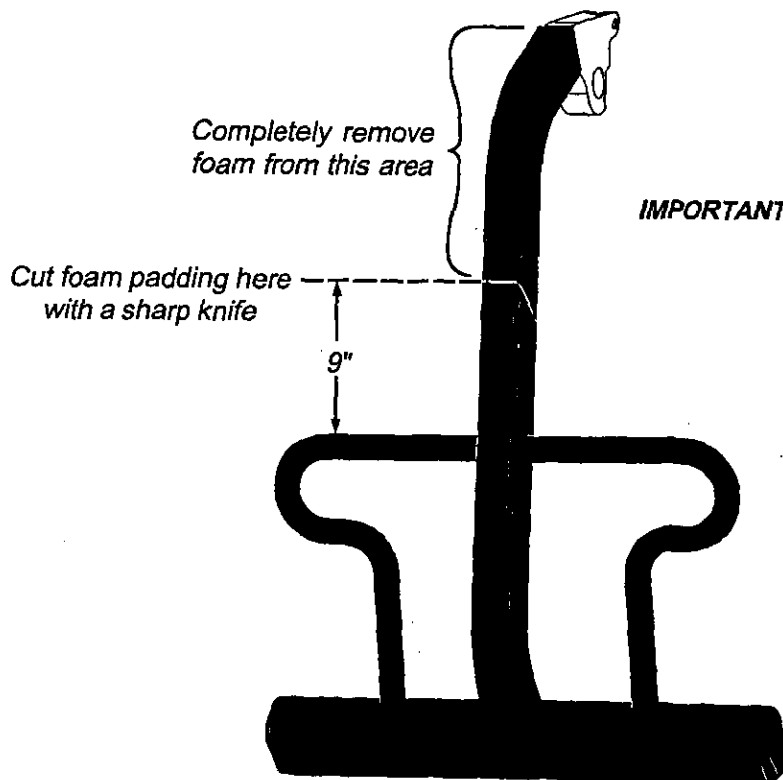
Model No.: 408

Detail of Issue (continued):

## **Annual Inspection Procedure**

**NOTE:** Steps 1 and 2 are only necessary prior to the first inspection. An optional removable boot is available for subsequent annual inspections.

1. Use a sharp knife to carefully cut the foam padding as shown on all 18 secondary restraint bars.



**IMPORTANT:** When cutting the foam, be careful not to score the aluminum tube inside the foam. This will severely weaken the tube.

2. Remove the foam above the cut as shown. This will expose the entire curved area of the frame and the full length of the welds on the doubler plate.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 and on

Ride Name: CHAOS

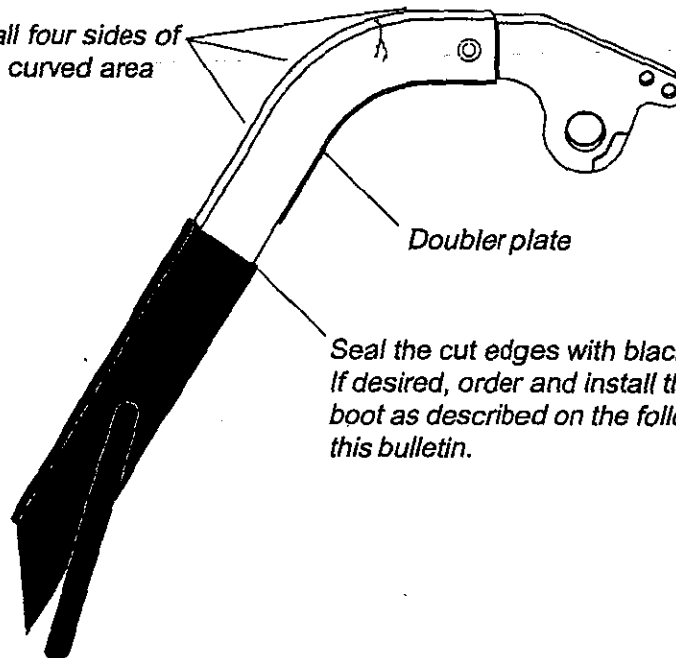
Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

## Detail of Issue (continued):

3. Visually inspect all four sides of the aluminum tube in the curved area. Also, inspect the welds on the doubler plate and the metal surrounding the welds.

*Inspect all four sides of  
tube in curved area*



*Seal the cut edges with black RTV sealant.  
If desired, order and install the inspection  
boot as described on the following page of  
this bulletin.*

4. If any indications are noted, contact the Chance Rides Customer Service Department immediately. DO NOT LOAD PASSENGERS IN THAT VEHICLE UNTIL REPAIR OR REPLACEMENT IS MADE.
5. If no indications are found, seal the cut edges of the foam with a generous fillet of black RTV sealant.



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Bulletin No: B408R1222-A

Release Date: August 1, 2000

Effective Date: August 1, 2000

Supersedes: B408R1222-0

Completion Date: September 1, 2000

Page: 4 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 and on

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

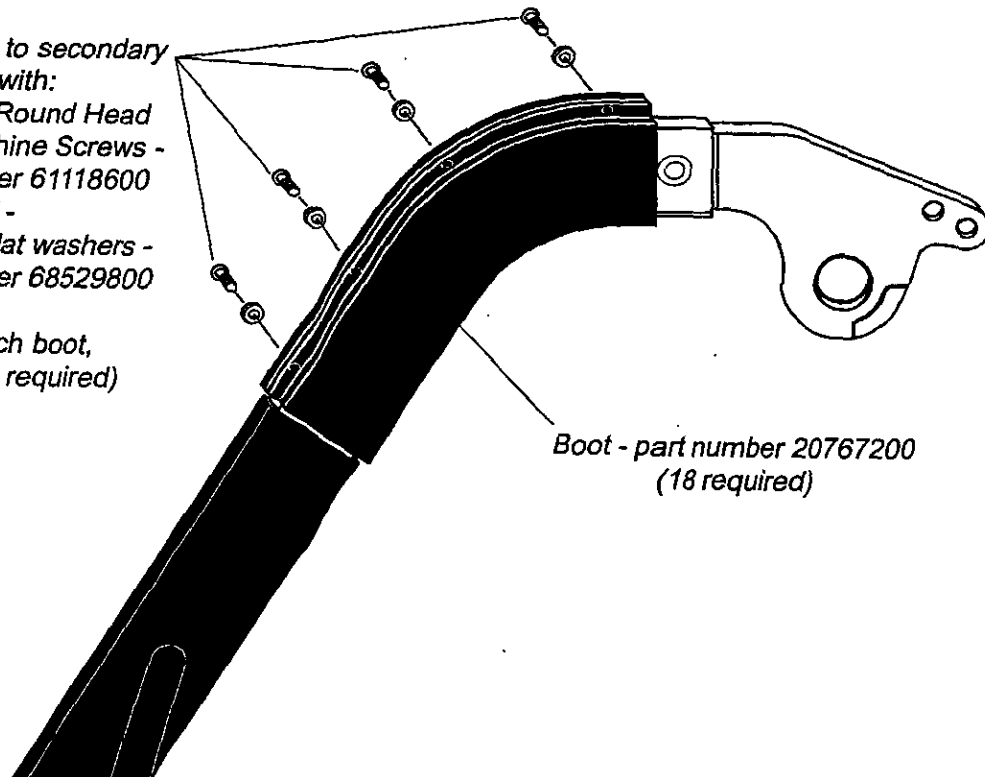
## Detail of Issue (continued):

6. If desired, order and install the boots as shown. The following parts will be provided at no charge if or ordered within 30 days of the release of this bulletin.

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
20767200	BOOT - Inspection	18
61118600	SCREW - Phillips Head Machine (#10-32 x 1")	72
68529800	WASHER - SAE Flat (3/16)	72

Secure boot to secondary  
restraint bar with:  
#10-32 x 1" Round Head  
Phillips Machine Screws -  
part number 61118600  
- and -  
3/16" SAE Flat washers -  
part number 68529800

(4 places each boot,  
total 72 each required)



**CHANCE RIDES, INC.**

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Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 1 of 7

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

Abstract of Issue:

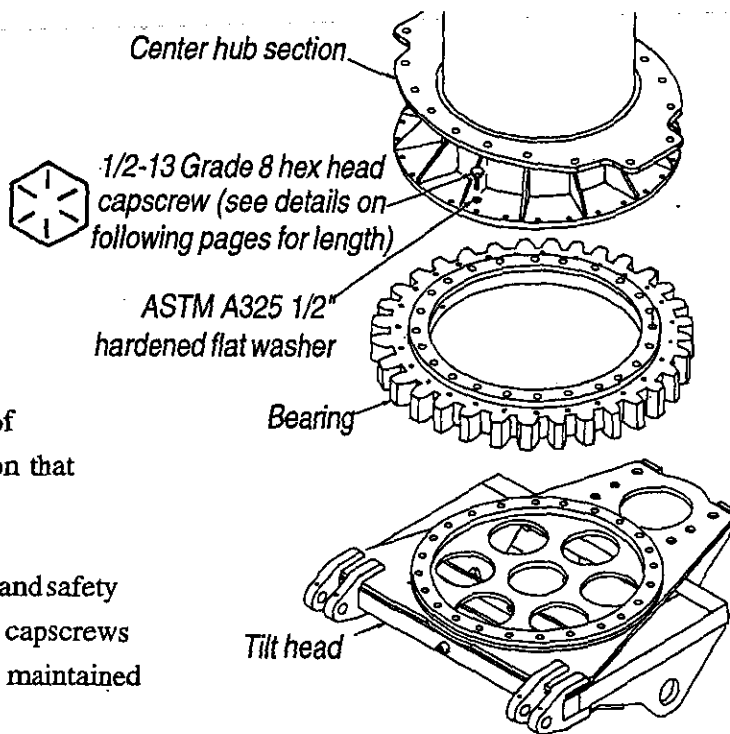
Hub Capscrew Torque Check

Reason For Release:

This bulletin supersedes Service Bulletin B408R1181-A. It is being released to emphasize and supplement the information contained in B408R1181-A.

The center hub section on the CHAOS amusement ride is secured to the bearing with 28 Grade 8 hex head capscrews. The correct length of the capscrews varies with the serial number of the ride and with the bearing installed on that specific ride.

It is essential for the care of the equipment and safety of the passengers that the correct length capscrews are installed and that the correct torque is maintained on these capscrews.



Action to be Taken:

Chance Rides, Inc. requires all owner/operators of the above noted amusement rides to immediately perform the inspection described in the bulletin to verify the condition of the tapped holes in the bearing, and to install the correct length of capscrews for that specific ride. Thereafter, the capscrews must be checked for correct torque at least once per month during the operating season.

As with any ride, perform a daily visual check for signs of loose, broken or missing parts.

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Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 2 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. All applicable OSHA safety standards and safe industry practices must be observed.

**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.

**Detail of Issue:****Capscrew Length**

Two factors determine the correct length of capscrews securing the center hub section to the bearing:

1. The ride serial number - ride serial numbers 408-00196 through 408-02097 and 408-02297 through 408-03998 were retrofitted with the Hub Gusset Kit (refer to Chance Rides Service Bulletin B408R1203-A). In the locations of the hub gussets on these rides, a different length capscrew is required.
2. The tapped holes in the bearing - the bearing manufacturer has changed the tapped holes from a "blind hole" to a "through hole". Different length capscrews are required for each type of tapped hole.

Using the illustrations on the following pages of this bulletin, inspect the hub and bearing to determine the correct fasteners for that specific ride.

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Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 3 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

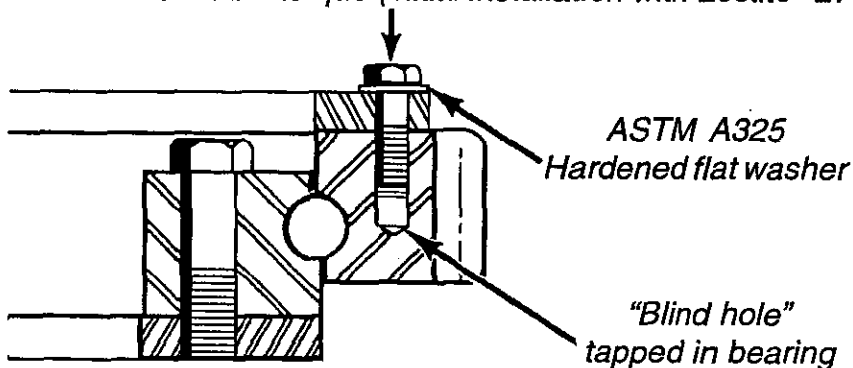
Detail of Issue (continued):

**IMPORTANT:** These details illustrate the correct length capscrews for all rides. Inspect the tapped holes in the bearing as shown to determine the correct length of capscrew. On rides with the **Hub Gusset Kit** installed (Service Bulletin B408R1203-A), refer also to the following page for capscrew lengths in the hub gusset locations.

**1/2-13 x 1-3/4" long Grade 8 Hex Head Capscrew**

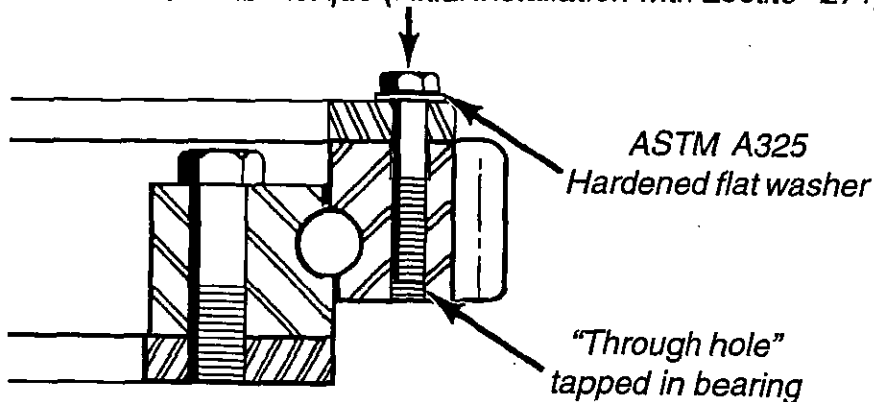
80 ft-lbs torque (monthly check).

90 ft-lbs torque (initial installation with Loctite® 271)

**1/2-13 x 2-3/4" long Grade 8 Hex Head Capscrew**

80 ft-lbs torque (monthly check).

90 ft-lbs torque (initial installation with Loctite® 271)



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Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 4 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

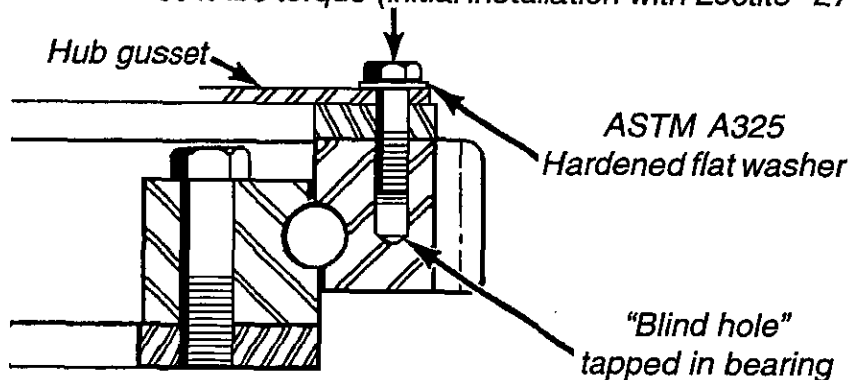
Detail of Issue (continued):

**IMPORTANT:** These details illustrate the correct length capscrews at the gusset locations on rides with the **Hub Gusset Kit** installed (Service Bulletin B408R1203-A). Inspect the tapped holes in the bearing as shown to determine the correct length of capscrew.

**1/2-13 x 2-1/4" long Grade 8 Hex Head Capscrew**

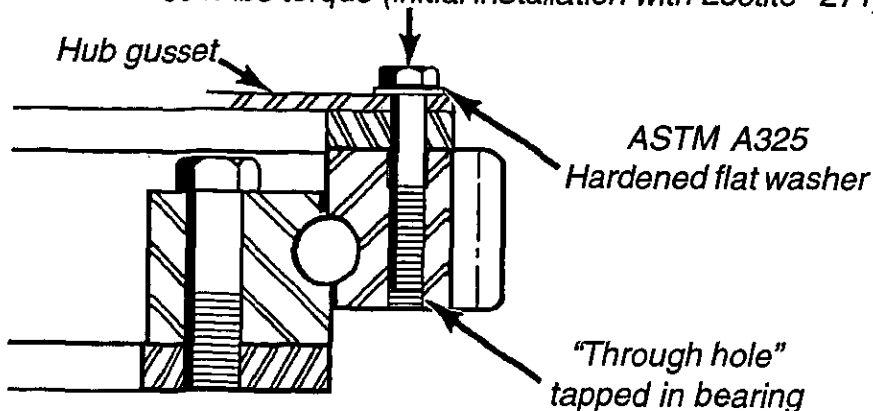
80 ft-lbs torque (monthly check).

90 ft-lbs torque (initial installation with Loctite® 271)

**1/2-13 x 3-1/4" long Grade 8 Hex Head Capscrew**

80 ft-lbs torque (monthly check).

90 ft-lbs torque (initial installation with Loctite® 271)



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Bulletin No: B408R1181-B

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Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 5 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

Detail of Issue (continued):

**Preparation of Tapped Holes in Bearing**

Once the correct capscrew length for each location is determined, clean and prepare the tapped holes in the bearing as follows:

**IMPORTANT:** *This procedure requires that all capscrews be removed, one at a time. The existing capscrews and hardened flat washers must all be discarded and replaced with new parts of the correct size.*

1. Remove the existing capscrew and hardened flat washer and discard.
2. Using a 1/2-13 UNC bottoming tap, chase the entire length of the threads in the bearing to restore and clean the threads.
3. Using appropriate eye protection, clear chips and other debris from the tapped hole with compressed air.
4. Install the new capscrew with new hardened flat washer under the head, using Loctite® 271 (red).
5. Tighten the capscrew to 90 ft-lbs.
6. Continue the process until all 28 capscrews have been replaced.

**Monthly Check of Capscrew Torque**

Using a torque wrench, check for proper torque of all 28 capscrews. Torque value for checking these capscrews must be 80 ft-lbs.

**IMPORTANT:** *ALL 28 CAPSCREWS MUST BE TIGHTENED AND MAINTAINED AS DESCRIBED TO OPERATE THE RIDE. If damage in the tapped holes prevents one or more capscrews from meeting these specifications, the bearing must be replaced. Contact the Chance Rides Customer Service Department for all necessary parts and instructions on this procedure.*

If any capscrew is found to be loose, remove it and replace it with a new capscrew. Clean the threads on the new capscrew and in the bearing, then apply Loctite® 271 (red). Tighten the new capscrew to 90 ft-lbs. If a broken capscrew is found, contact Chance Rides, Inc. immediately for further instructions.



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Completion Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

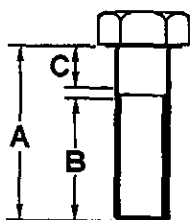
Detail of Issue (continued):

## **Hex Head Capscrew Specifications**

**NOTE:** Capscrews and hardened flat washers can be procured from sources other than Chance Rides, provided they meet these specifications.

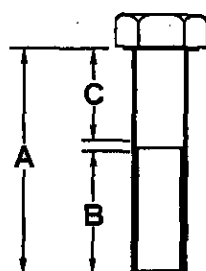
1/2-13 UNC x 1-3/4

Grade 8



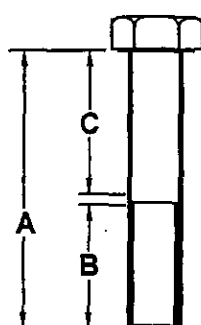
1/2-13 UNC x 2-1/4

Grade 8



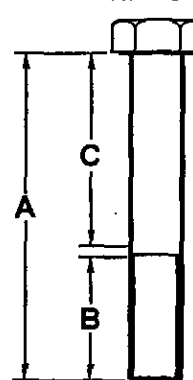
1/2-13 UNC x 2-3/4

Grade 8



1/2-13 UNC x 3-1/4

Grade 8



**Coating - Yellow chromate zinc electroplating**

	"A" Nominal Length	"B" Thread Length	"C" Shank Length (minimum)
1/2-13 UNC x 1-3/4 Grade 8	1.75	1.25	0.115
1/2-13 UNC x 2-1/4 Grade 8	2.25	1.25	0.615
1/2-13 UNC x 2-3/4 Grade 8	2.75	1.25	1.115
1/2-13 UNC x 3-1/4 Grade 8	3.25	1.25	1.615

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Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 7 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

Detail of Issue (continued):

For ride serial numbers 408-00196 through 408-02097 and 408-02297 through 408-03998 (with Hub Gusset Kit) with "blind holes" in bearing, order Kit number K408R1181-1, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60849400	HEX HEAD CAPSCREW (1/2-13 x 1-3/4 Grade 8)	14
60849700	HEX HEAD CAPSCREW (1/2-13 x 2-1/4 Grade 8)	14
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28

For ride serial numbers 408-00196 through 408-02097 and 408-02297 through 408-03998 (with Hub Gusset Kit) with "through holes" in bearing, order Kit number K408R1181-2, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60850200	HEX HEAD CAPSCREW (1/2-13 x 2-3/4 Grade 8)	14
60850600	HEX HEAD CAPSCREW (1/2-13 x 3-1/4 Grade 8)	14
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28

For ride serial numbers 408-02197 and 408-04098 and on with "blind holes" in bearing, order Kit number K408R1181-3, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60849400	HEX HEAD CAPSCREW (1/2-13 x 1-3/4 Grade 8)	28
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28

For ride serial numbers 408-02197 and 408-04098 and on with "through holes" in bearing, order Kit number K408R1181-4, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60850200	HEX HEAD CAPSCREW (1/2-13 x 2-3/4 Grade 8)	28
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28





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Bulletin No:	B408CRM101-0
Release Date:	July 30, 2002
Effective Date:	July 30, 2002
Supersedes:	N/A
Completion Date:	August 30, 2002
Page:	1 of 2

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

## Abstract of Issue:

### Drive Pinion Bearing Housing Lubrication

#### Reason For Release:

Chance Rides Manufacturing, Inc. has become aware of failure of certain drive components on the CHAOS amusement ride due to two factors:

- Operation of the ride without adequate lubrication of the drive pinion bearing housing. Weekly lubrication with the correct lubricant is required, as specified in the *CHAOS Service Manual*.
- Operation of the ride with the drive pinion cover missing or improperly installed. This can allow water to enter the pinion bearing housing, main drive gearbox and motor.

If either of these conditions exist, failure of expensive drive components can result.

#### Action to be Taken:

To ensure satisfactory service life of the drive components, all owner/operators of CHAOS amusement rides are required to do the following (refer to the illustration on page 2 of this bulletin):

- Comply with the lubrication instructions in the *CHAOS Service Manual*, including the drive pinion bearing housing lubrication. Apply NLGI No. 2 lithium based grease weekly at the zerk shown.
- Check to make sure the pinion gear cover is installed and sealed with silicone sealant. If the cover is missing, order a new part and install it as shown.
- Make sure the drain holes in both sides of the mounting plate are not plugged.

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Bulletin No: B408CRM101-0

Release Date: July 30, 2002

Effective Date: July 30, 2002

Supersedes: N/A

Completion Date: August 30, 2002

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

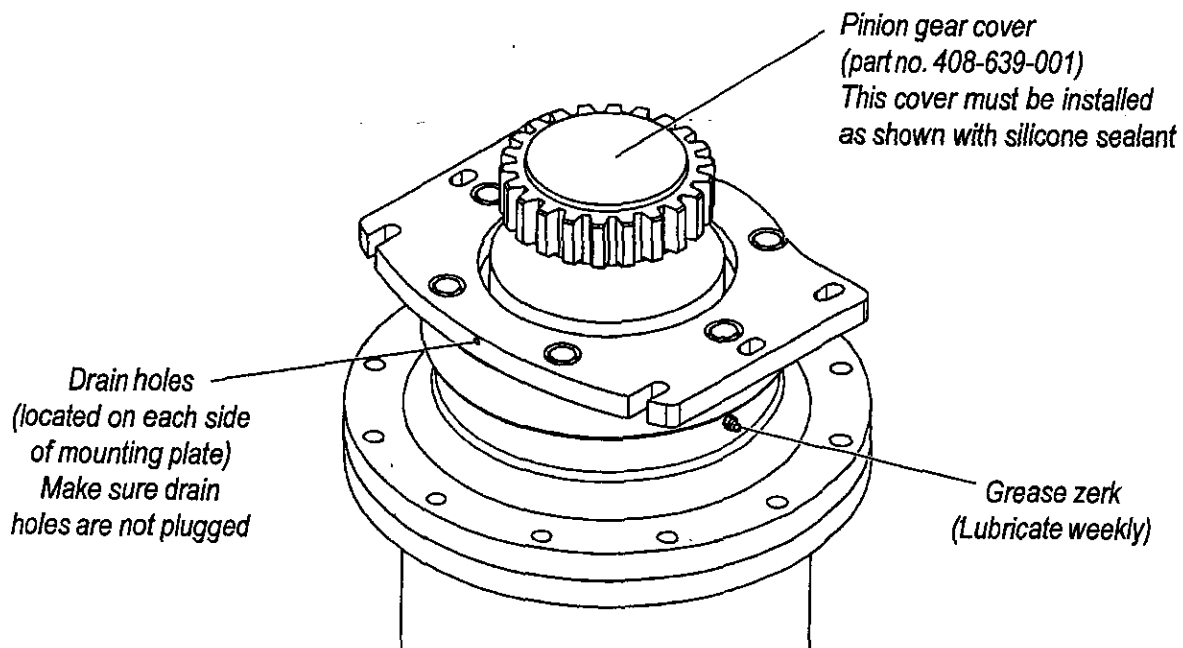
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):



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.

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.



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**Bulletin No: B408CRM106-0**

**Release Date: July 30, 2002**

**Effective Date: Immediately**

**Supersedes: N/A**

**Completion Date: October 30, 2002**

**Page: 1 of 2**

# SERVICE BULLETIN

**Ride Manufacturer: CHANCE RIDES, INC.**

**Affected Production Dates: All**

**Ride Name: CHAOS**

**Affected Serial Nos.: All Units**

**Model No.: 408**

**Abstract of Issue:**

**Sweep Inspection**

**Reason For Release:**

Chance Rides Manufacturing, Inc. has become aware of cracks in the sweeps of at least one CHAOS amusement ride. Failure of a sweep could result in serious injury to passengers and/or bystanders.

**Action to be Taken:**

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS rides to cease operation of the ride until the inspection described in this bulletin is performed. If any indications are found, contact the Customer Service Department at Chance Rides Manufacturing, Inc. immediately for instructions on further action to be taken.

**DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE SWEEPS EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.**

If no indications are found, operation of the ride can resume. However, all sweeps must be inspected as described MONTHLY.

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.

*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.*



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Bulletin No: B408CRM106-0

Release Date: July 30, 2002

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

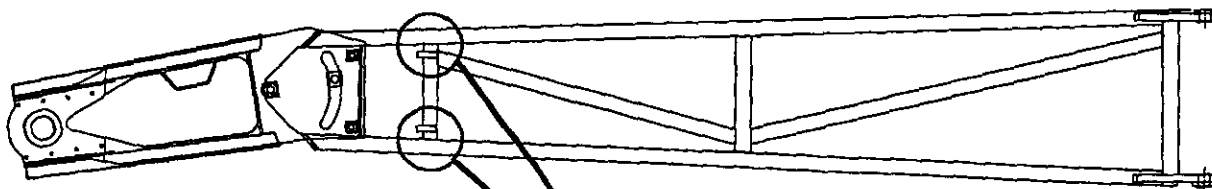
Affected Serial Nos.: All Units

Model No.: 408

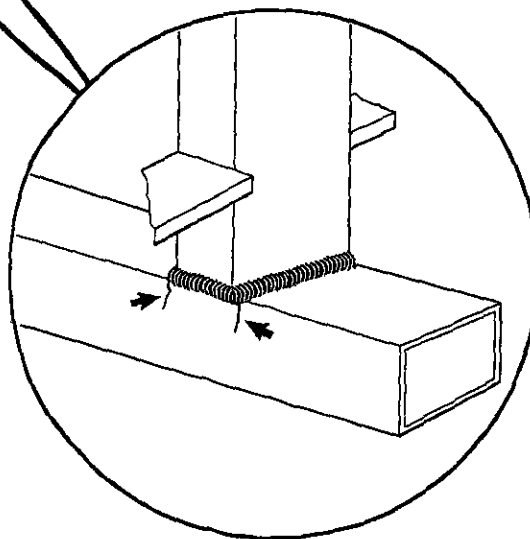
Detail of Issue (continued):

### **Sweep Inspection Procedure**

Visually inspect every sweep, paying particular attention to the areas indicated in the following illustration. Look for indications in the steel tubes, and check the welded joints for indications in the welds and the parent metal. If any indication is found, **DO NOT OPERATE THE RIDE**. Contact the Customer Service Department at Chance Rides Manufacturing, Inc. for specific instructions on further action to be taken.



*Pay particular attention to this area on both the top and bottom tubes of each sweep.*





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Bulletin No:	B408CRM104-0
Release Date:	November 6, 2002
Effective Date:	November 6, 2002
Supersedes:	B408R1210-0
Completion Date:	N/A
Page:	1 of 6

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

**Abstract of Issue:**

**Inspection, Replacement and Operation of Hydraulic Lock Cylinders**

**Reason For Release:**

Chance Rides, Inc. service bulletin B408R1210-0 is superseded by this bulletin and is no longer in effect.

The passenger restraint system on the above noted CHAOS amusement rides incorporates three hydraulic lock cylinders on each vehicle - one for each lap bar and one for the secondary restraint bar. In the event a hydraulic lock cylinder fails, a redundant mechanical lock prevents the restraint bar from opening.

The manufacturer of the hydraulic lock cylinder has made design changes over the years to provide better performance and longer service life. With one exception, all versions of this component are acceptable for use on the ride in the locations described on the following pages of this bulletin. A manufacturing defect was discovered in one version. Chance Rides, Inc. service bulletin B408R1210-0 required these cylinders to be removed from service no later than September 18, 1999.

This bulletin provides detailed identification of all versions of the hydraulic locking cylinder and the location where each version can be used.

**Action to be Taken:**

All owners of the above noted amusement rides are required to inspect all hydraulic lock cylinders and the locations where they are installed per the instructions on the following pages of this bulletin. Order and install part number 22162104 in the appropriate quantity to replace any cylinder which does not meet the specifications provided.

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.



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Bulletin No: B408CRM104-0

Release Date: November 6, 2002

Effective Date: November 6, 2002

Supersedes: B408R1210-0

Completion Date: N/A

Page: 2 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

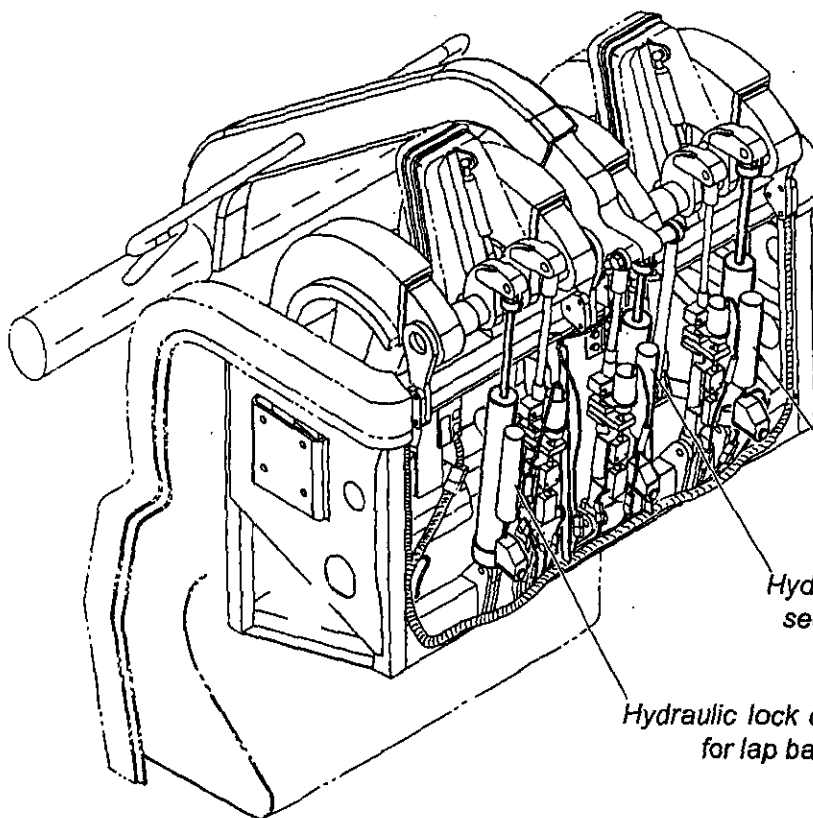
Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### Inspection Procedure

Inspect the three hydraulic lock cylinders on all vehicles (54 total). Identify the cylinders based on the distinguishing characteristics detailed on the next page.



### IMPORTANT:

Note the location at which each cylinder is installed. Pay particular attention to the cylinder for the secondary restraint bar (center position).



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Bulletin No: B408CRM104-0  
 Release Date: November 6, 2002  
 Effective Date: November 6, 2002  
 Supersedes: B408R1210-0  
 Completion Date: N/A  
 Page: 3 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):



**This cylinder can be used on the lap bars, but NOT THE SECONDARY RESTRAINT BARS (center position)**

Red release plunger



**This cylinder can be used on the lap bars and the secondary restraint bars**

Accumulator

Red release plunger



**This cylinder can be used on the lap bars and the secondary restraint bars. It MUST HAVE THE STAMPED LETTER as shown.**

**DO NOT USE THIS CYLINDER IF IT DOES NOT HAVE THE STAMPED LETTER. Replace it with the correct cylinder.**

Letter "E" stamped on accumulator

Accumulator with hose coming out of BOTTOM

Black release button



**This cylinder can be used on the lap bars and the secondary restraint bars.**

**Note the hose coming out of the top of the accumulator.**

Accumulator with hose coming out of TOP

Black release button



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Effective Date: November 6, 2002

Supersedes: B408R1210-0

Completion Date: N/A

Page: 4 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### Operation - Manually Releasing Passenger Restraints

Use the following information in conjunction with the procedure in the *CHAOS Operation Manual*.

To manually release the LAP BAR on this side of the vehicle:

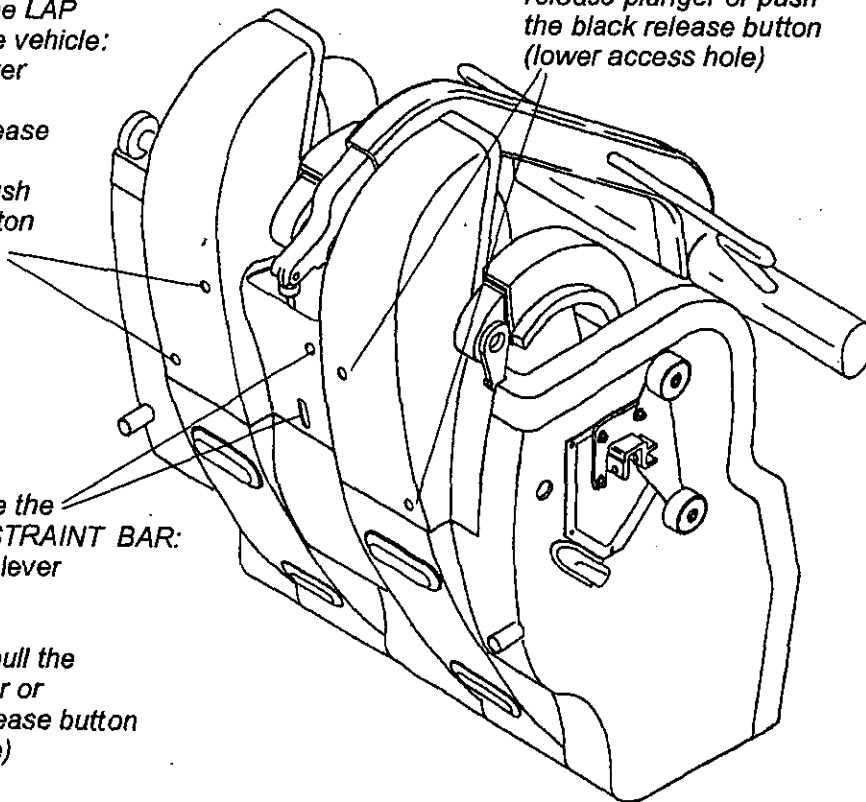
- Raise the release lever (top access hole).
- While holding the release lever up, pull the red release plunger or push the black release button (lower access hole)

To manually release the LAP BAR on this side of the vehicle:

- Raise the release lever (top access hole).
- While holding the release lever up, pull the red release plunger or push the black release button (lower access hole)

To manually release the SECONDARY RESTRAINT BAR:

- Raise the release lever (top access hole).
- While holding the release lever up, pull the red release plunger or push the black release button (lower access hole)







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Bulletin No:	B408CRM104-0
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Effective Date:	November 6, 2002
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### Monthly Inspection of Hydraulic Lock Cylinders

The passenger restraint system on each vehicle incorporates three hydraulic lock cylinders - one for each lap bar and one for the secondary restraint bar. Remove the back cover from the vehicle to gain access to the lock cylinders.

Perform the following inspection on the lock cylinders monthly or at every set-up, whichever occurs first. Check all three lock cylinders on EVERY VEHICLE.

1. Visually inspect each lock cylinder for oil leakage around the seals.
2. Inspect for any signs of external damage, including the spherical bearings in the rod end.
3. Activate the solenoid and check for smooth movement of the piston rod in extension and compression.
4. Inspect the piston rod for any evidence of damage. **DO NOT PUT CLAMP PRESSURE ON THE PISTON ROD.**
5. Inspect the accumulator hose and hose fittings for leakage.
6. Inspect the solenoid valve for damage.
7. Inspect the accumulator clamp nuts to ensure the nuts are tight and have not loosened.

If any sign of damage, leakage or other malfunction is noted, **REPLACE THE LOCK CYLINDER.**

**IMPORTANT:** *Passenger restraint lock cylinders are not repairable in the field. If a damaged or malfunctioning lock cylinder is found, replace it with a new or re-manufactured part, available from CHANCE RIDES MANUFACTURING, INC. DO NOT ATTEMPT TO REPAIR THE CYLINDER.*



**WARNING:** The passenger restraint lock cylinder is under high pressure. **DO NOT ATTEMPT TO DISASSEMBLE** the cylinder or serious personal injury can result. Replace the cylinder with a new or re-manufactured part.

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Bulletin No: B408CRM104-0

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Completion Date: N/A

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

**Storage of Hydraulic Lock Cylinders**

To obtain maximum service life from the hydraulic lock cylinders, always close the lap bars and secondary restraint bars during long periods of inactivity, such as during off-season storage of the ride.

The accumulator (if equipped) has a breather at the end opposite the hose. Do not allow precipitation to enter the breather. This will cause the unit to malfunction or become damaged. The breather should be covered during long periods of inactivity, such as during winter storage. If precipitation should enter into the breather, turn the lock cylinder over and allow the moisture to drain out. **DO NOT ALLOW MOISTURE TO FREEZE INSIDE THE ACCUMULATOR**, or permanent damage to the lock cylinder can result.

Similarly, if hydraulic lock cylinders are stored separate from the ride (e.g., as spare parts), always fully extend the cylinder before storing. Cover the breather on the accumulator (if equipped) to prevent moisture from entering.

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.



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Bulletin No:	B408CRM110-0
Release Date:	November 6, 2002
Effective Date:	Immediately
Supersedes:	B408CRM106-0
Completion Date:	February 6, 2003
Page:	1 of 8

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Abstract of Issue:

Sweep Rework Kit

Reason For Release:

Service bulletin B408CRM106-0 is superseded by this bulletin and is no longer in effect.

Chance Rides Manufacturing, Inc. has become aware of cracks in the sweeps of at least one CHAOS amusement ride. Failure of a sweep could result in serious injury to passengers and/or bystanders. A kit has been developed to reinforce the sweeps.

Action to be Taken:

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS rides to order and install the Sweep Rework Kit, part number K408CRM110-0, within 90 days of the release date of this bulletin. The kit includes all necessary parts to rework one complete ride. Rework instructions are provided in this bulletin. The kit will be offered at a reduced price if ordered within this 90 day period.

After the Sweep Rework Kit is installed, the sweeps must be inspected annually 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. 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.

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.



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Bulletin No: B408CRM110-0

Release Date: November 6, 2002

Effective Date: Immediately

Supersedes: B408CRM106-0

Completion Date: February 6, 2003

Page: 2 of 8

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### **SWEEP INSPECTION PRIOR TO REWORK**

Carefully inspect all sweeps for cracks or other indications. Look at the welds and parent metal at all joints, paying particular attention to the areas where the gussets will be installed.

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

- 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 SWEEPS, EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.**

- If no indications are found, order and install the Sweep Rework Kit, part number K408CRM110-0 using the instructions on the following pages of this bulletin.

### **ANNUAL INSPECTION OF SWEEPS**

After Sweep Rework Kit is installed, visually inspect the sweeps **annually** for damage, cracks, or other indications. Look at the welds and parent metal at all joints. If any indications are found, contact the Chance Customer Service Department immediately. **DO NOT CONTINUE OPERATION OF THE RIDE.**



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

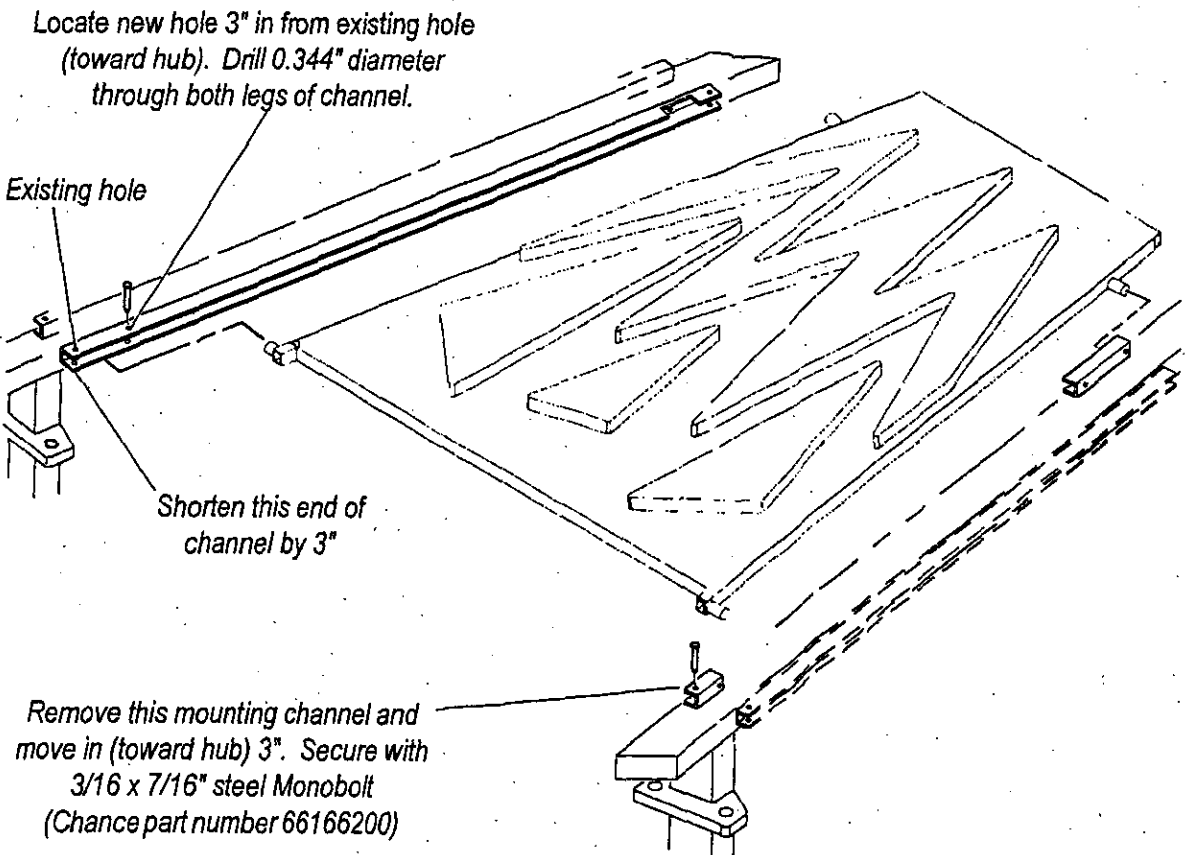
Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### PREPARATION OF SWEEPS FOR REWORK

Modify all mounting channels for the sweep insert panels as shown. This is necessary to provide clearance for the upper doubler plates. Also, modify all sweep insert panels as shown on the next page.





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Release Date: November 6, 2002

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Completion Date: February 6, 2003

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

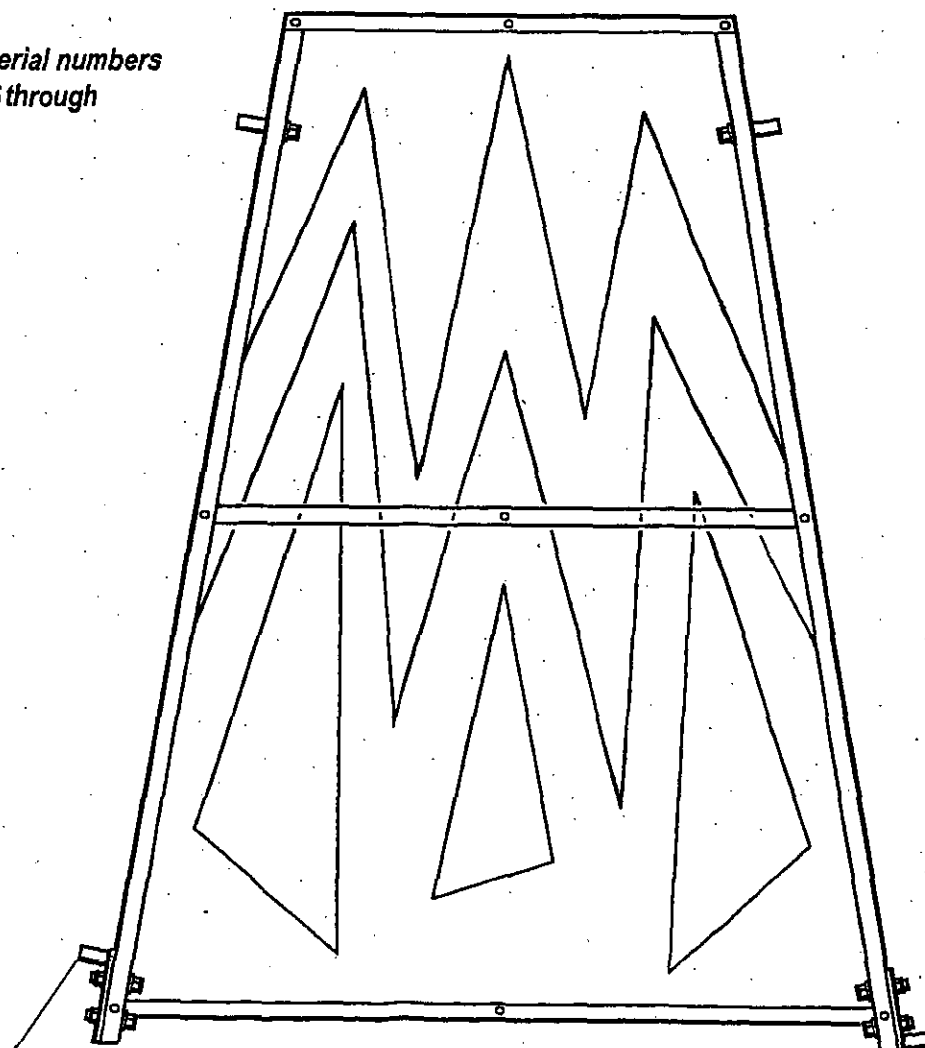
Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

*For ride serial numbers  
408-00196 through  
408-04399*



*Remove guide pin weldments from both  
sides of sweep insert panel. Turn 180° as  
shown and mount with existing fasteners.*

*Original position of  
guide pin weldments*



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Bulletin No: B408CRM110-0

Release Date: November 6, 2002

Effective Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

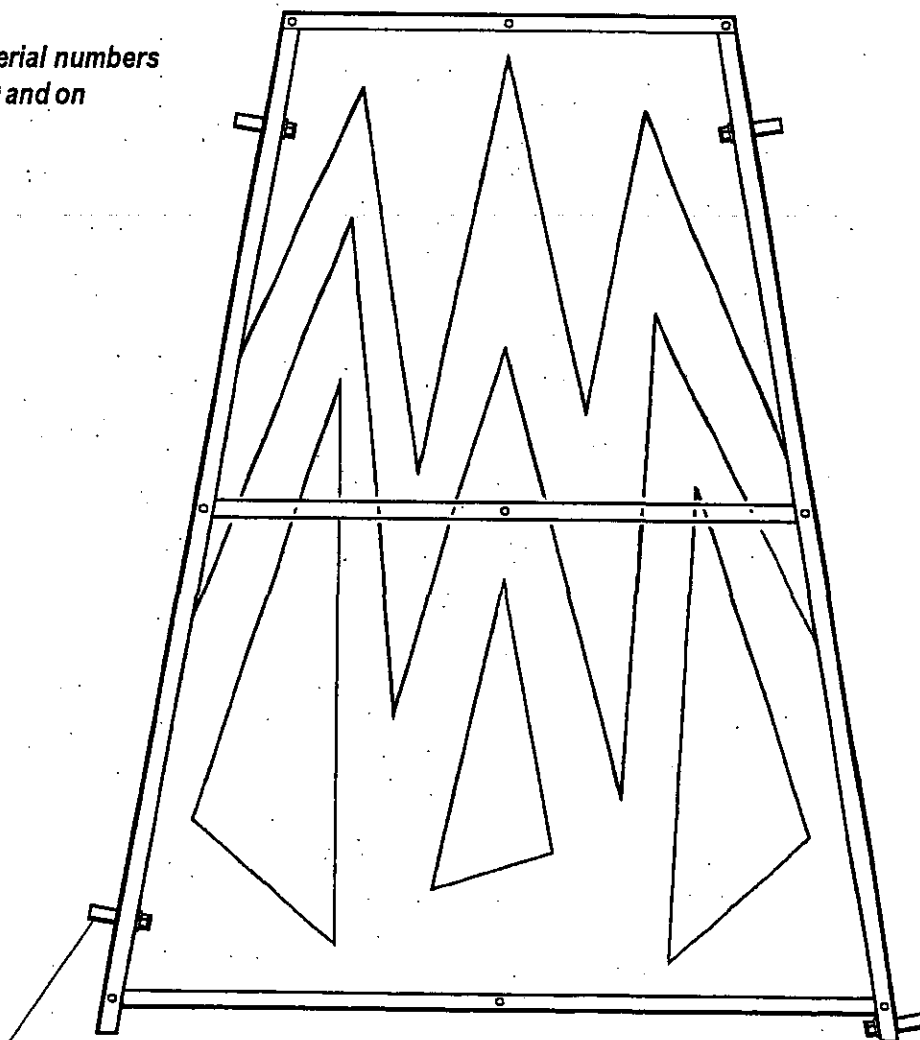
Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

**For ride serial numbers  
408-04499 and on**



Remove guide pins from both sides of sweep insert panel. Locate new holes 3" in from existing holes (toward hub). Drill 0.28" diameter holes through both sides of tube and install guide pins with existing fasteners.

Original position  
of guide pins



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

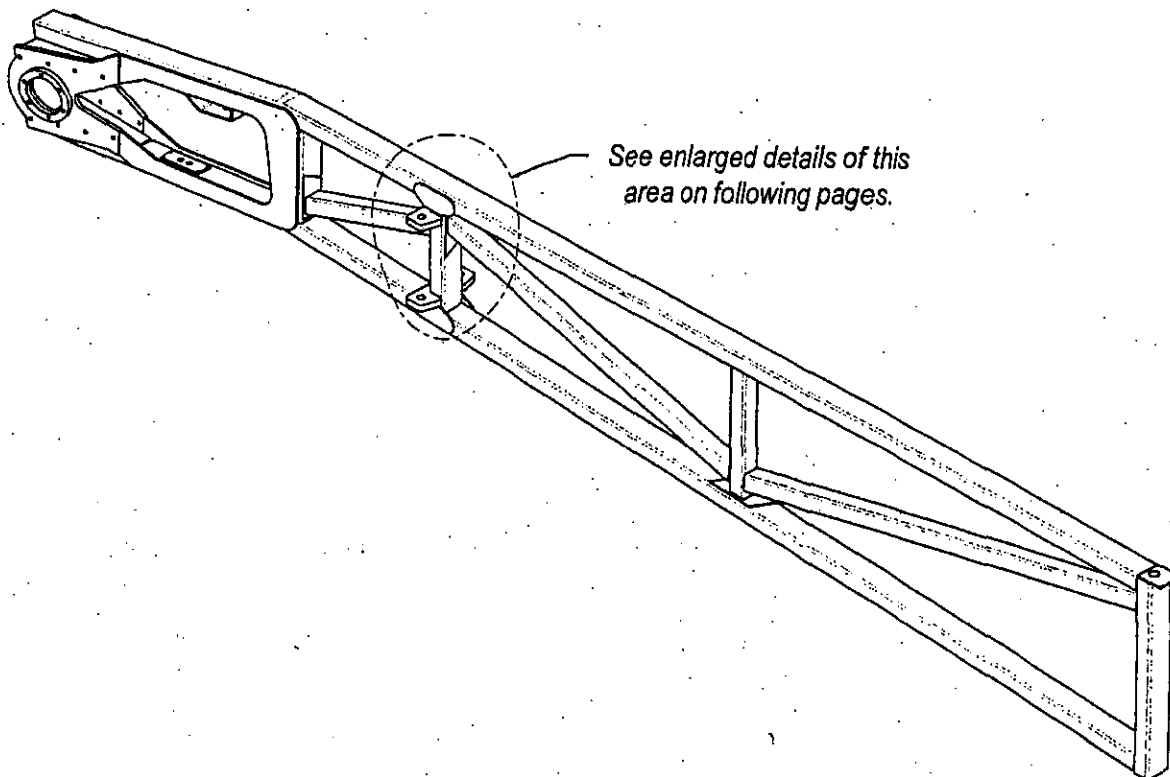
Model No.: 408

Detail of Issue (continued):

### SWEEP REWORK PROCEDURE

After inspecting all sweeps to verify that no indications exist, locate and weld the doubler plates on all sweeps as shown in the following illustrations (four places on each sweep). Note the position of the "notched" area of each doubler plate, which is located toward the center hub of the ride. If necessary, grind the existing welds to allow the doubler plates to lay flat against the sweeps.

**IMPORTANT:** All welding must be performed in accordance with American Welding Society (AWS) D1.1.







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Completion Date: February 6, 2003

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

Doubler Plates  
part number 408-225-026  
(4 places per sweep, 72 total)

Center hub of ride →

1/8" TYP. E7018

3/4"

Note the position of this "notched" area of each doubler plate. It must be toward the center hub of the ride.

1/2"



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Supersedes: B408CRM106-0

Completion Date: February 6, 2003

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Ride Manufacturer: CHANCE RIDES, INC.

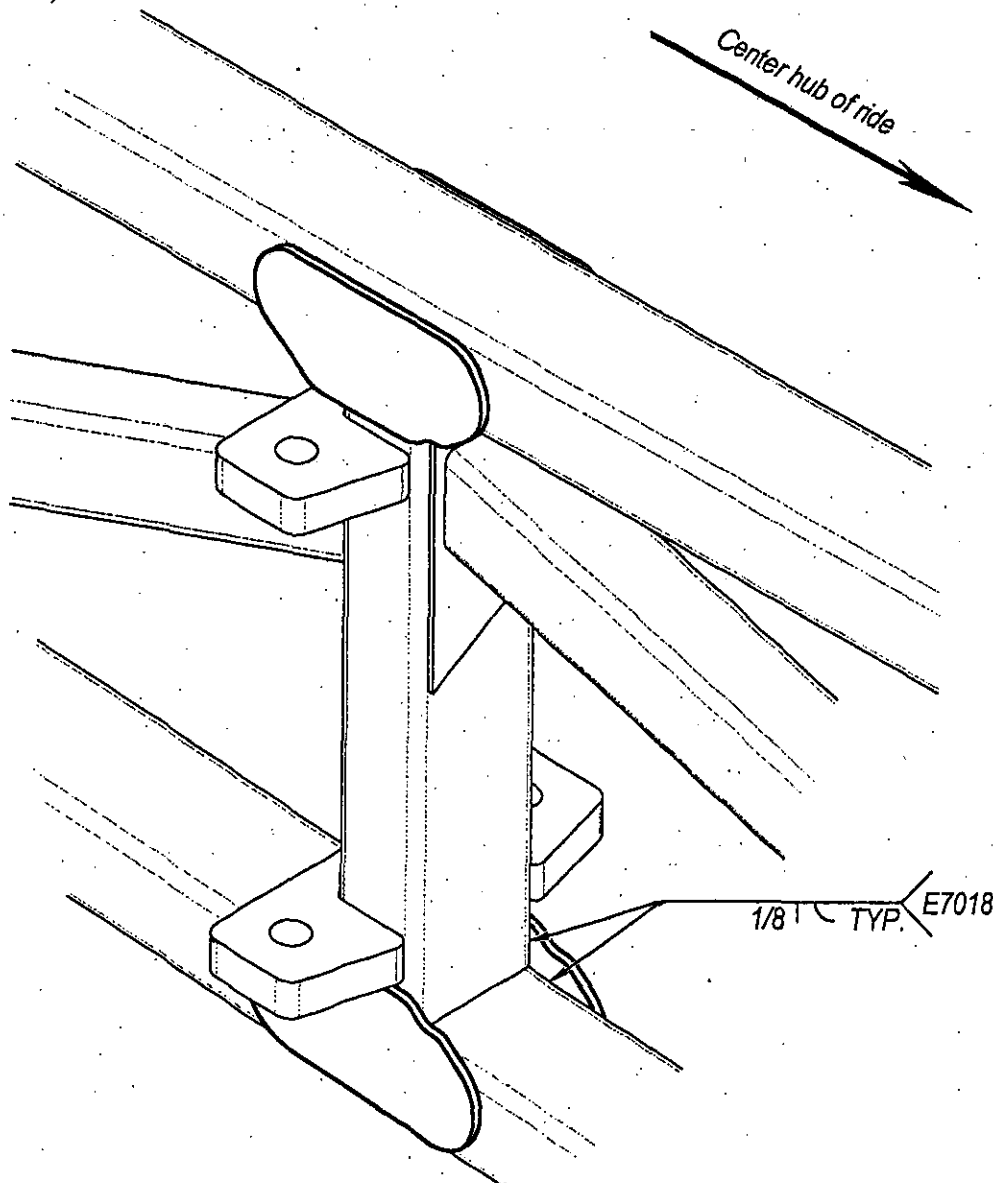
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):





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Bulletin No:	B408CRM111-0
Release Date:	November 6, 2002
Effective Date:	Immediately
Supersedes:	N/A
Completion Date:	N/A
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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

**Abstract of Issue:**

**Cross Rod Inspection**

**Reason For Release:**

Chance Rides Manufacturing, Inc. has become aware of a cross rod failure on at least one CHAOS amusement ride. Failure of one or more cross rods can result in serious injury to passengers and damage to sweeps and other ride components. This bulletin provides specific inspection information for the cross rods to ensure that they are in good operating condition.

**Action to be Taken:**

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS rides to inspect all four cross rods at every set-up or monthly, whichever occurs first. The inspection procedure is provided on the following pages of this bulletin.

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.

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.



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Bulletin No: B408CRM111-0

Release Date: November 6, 2002

Effective Date: Immediately

Supersedes: N/A

Completion Date: N/A

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

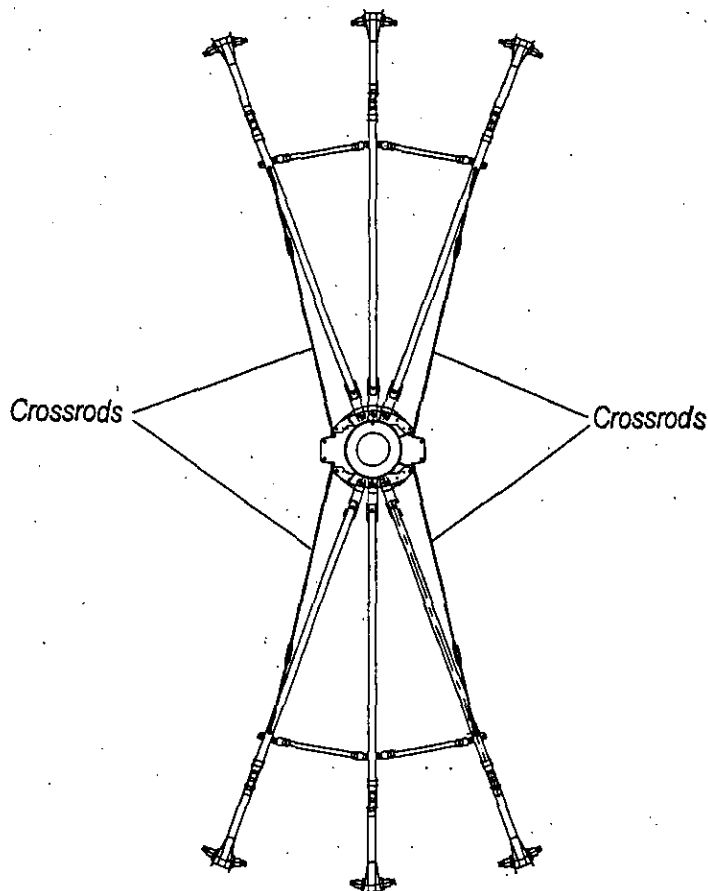
Model No.: 408

Detail of Issue (continued):

### CROSS ROD INSPECTION

Carefully inspect the overall condition of all four cross rods. Look for cracks, bends, wear or other damage. Pay particular attention to the welded joints detailed on the next page. If any damage or indications are found, do not operate the ride until repairs have been made.

Also, check the adjustment of the cross rods. Loosen the jam nuts on each turnbuckle and tighten it until snug. Turnbuckles must be tightened so the cross rod is in TENSION, NOT COMPRESSION.





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Bulletin No:	B408CRM111-0
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Ride Manufacturer: CHANCE RIDES, INC.

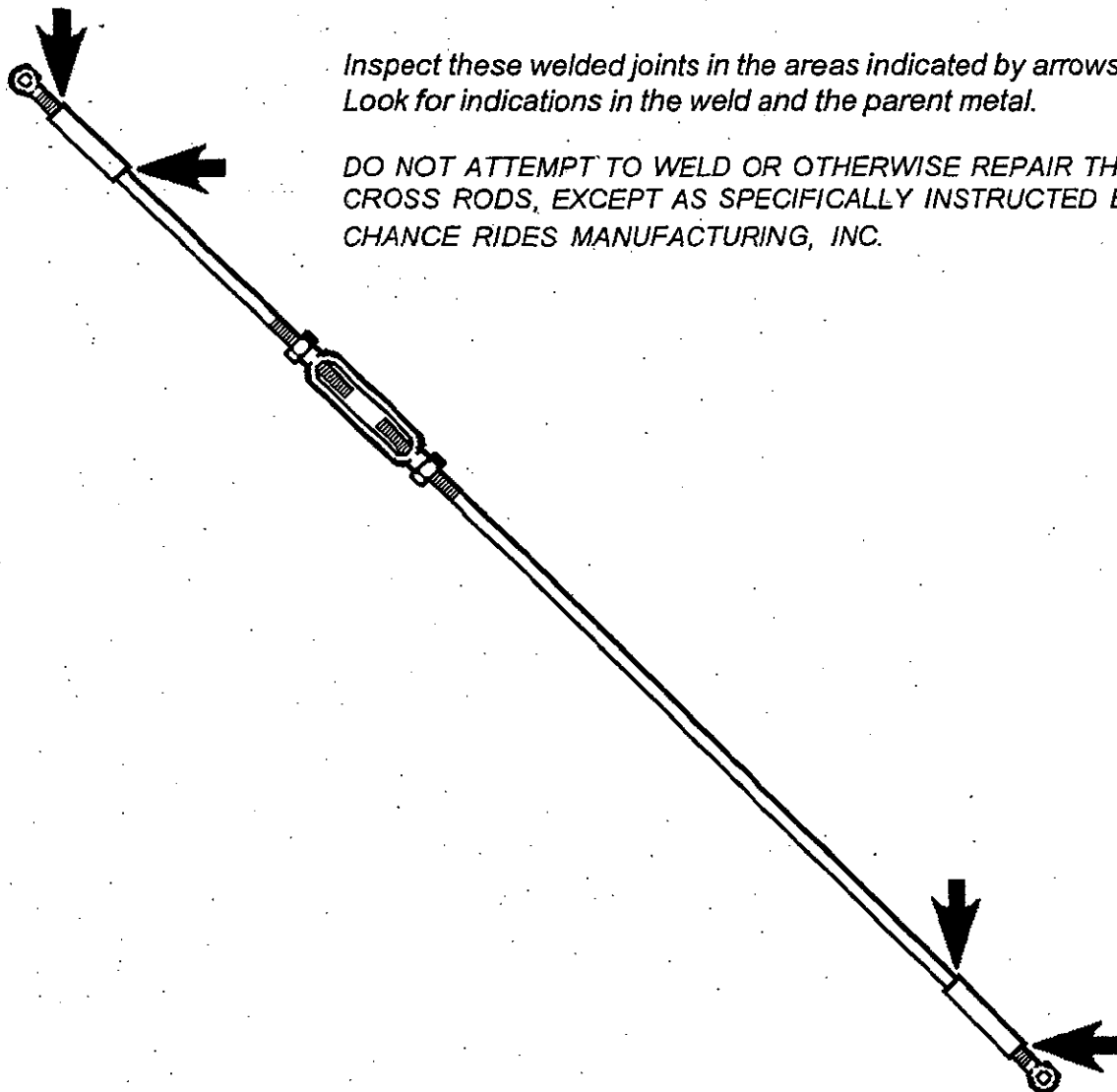
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):



*Inspect these welded joints in the areas indicated by arrows.  
Look for indications in the weld and the parent metal.*

**DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE  
CROSS RODS, EXCEPT AS SPECIFICALLY INSTRUCTED BY  
CHANCE RIDES MANUFACTURING, INC.**

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# Fax

**To:**

**From:** Steven Laycock QA/Product Safety Mang.

**Fax:**

**Pages:** 1

**Phone:**

**Date:** April 8, 2003

**Re:** CHAOS

**CC:**

Chance Rides Manufacturing, Inc. is in the process of reviewing the sweep gusset kit, number K408CRM110-0, for the above noted amusement ride. Until final evaluation of this kit can be completed, CRM is granting an extension for the completion date as was originally stated in CRM Service Bulletin number B408CRM110-0. We hope to have the evaluation completed in the near future and will keep you informed as to our progress.

Operation of the above noted amusement ride can continue without the installation of the above noted kit as long as inspection of the sweeps per CRM Service Bulletin number B408CRM106-0 is continued and no indications are found.

If you have any questions regarding this matter, please feel free to contact me.



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Bulletin No:	B408CRM115-0
Release Date:	May 9, 2003
Effective Date:	Immediately
Supersedes:	B408CRM110-0
Completion Date:	N/A
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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Abstract of Issue:

Sweep Inspection

Reason For Release:

**Service bulletin B408CRM110-0 is superseded by this bulletin and is no longer in effect.**

Chance Rides Manufacturing, Inc. has become aware of cracks in the sweeps of at least one CHAOS amusement ride. A kit has been developed to repair and reinforce the sweeps in the event that cracks develop. The kit is not required unless indications are found on one or more sweeps.

Action to be Taken:

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS amusement rides to immediately inspect all sweeps as described in this bulletin. The inspection must be performed weekly.

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.

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Bulletin No:	B408CRM115-0
Release Date:	May 9, 2003
Effective Date:	Immediately
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### Sweep Inspection Procedure

Visually inspect every sweep for cracks as shown in the illustration on the next page; paying particular attention to the areas indicated by arrows. Look for indications in the steel tubes, and check the welded joints for indications in the welds and the parent metal.

**NOTE:** Some rides have been reworked per Service Bulletin B408CRM110-0. The inspection described in this bulletin applies to ALL RIDES, whether they have been reworked or not.

**IF NO INDICATIONS ARE FOUND**, the ride can be operated normally. The sweeps must be inspected weekly as described in this bulletin.

**IF ANY INDICATIONS ARE FOUND**, do not operate the ride. Contact the Customer Service Department at Chance Rides Manufacturing, Inc. immediately for instructions on the necessary repair procedure. The repair will include the installation of the Sweep Reinforcement Kit (number K408CRM115-0), as well as specific instructions for repairing cracks.

**DONOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE SWEEPS EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.**

After the Sweep Reinforcement Kit is installed, the sweeps must be inspected annually as described in this bulletin.

**NOTE:** The installation of the Sweep Reinforcement Kit can be visually identified as shown in the illustration on page 4 of this bulletin.





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Bulletin No: B408CRM115-0

Release Date: May 9, 2003

Effective Date: Immediately

Supersedes: B408CRM110-0

Completion Date: N/A

Page: 3 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

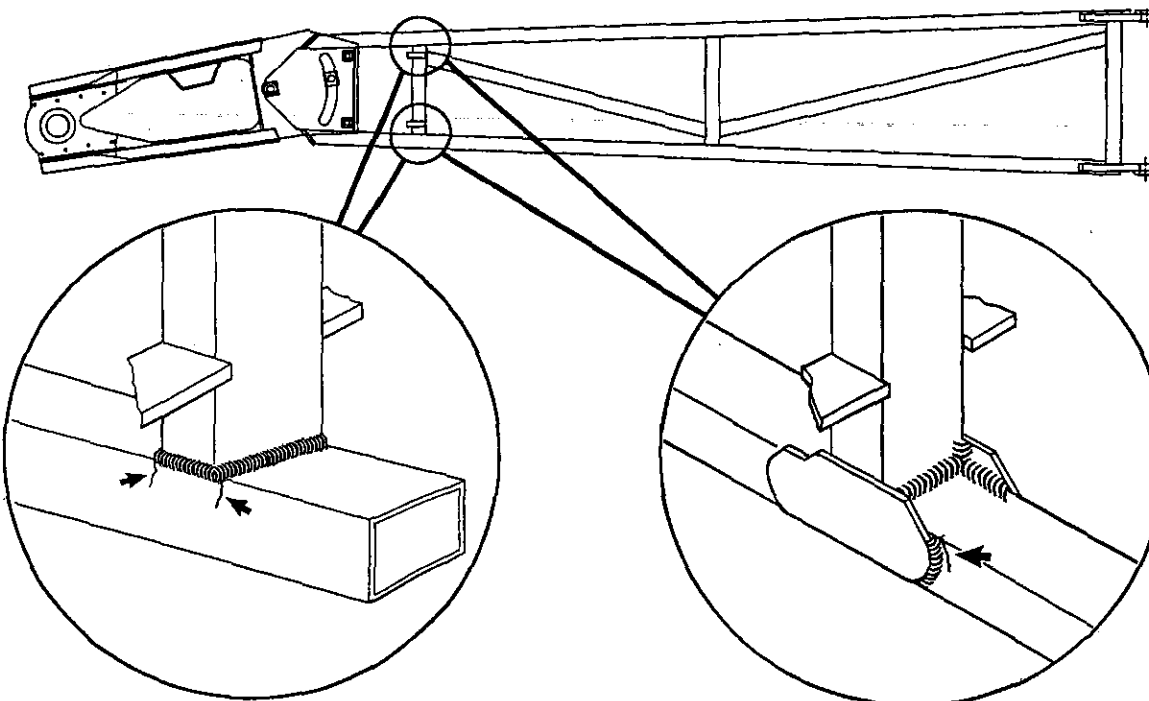
Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

**NOTE:** Sweep configuration may vary slightly from that shown.



**Rides that have NOT been  
reworked per Service Bulletin  
B408CRM110-0**

**Rides that HAVE been  
reworked per Service Bulletin  
B408CRM110-0**

*Pay particular attention to this area on both the top and bottom tubes of each sweep.*

*Perform this inspection WEEKLY.*



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Bulletin No: B408CRM115-0

Release Date: May 9, 2003

Effective Date: Immediately

Supersedes: B408CRM110-0

Completion Date: N/A

Page: 4 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

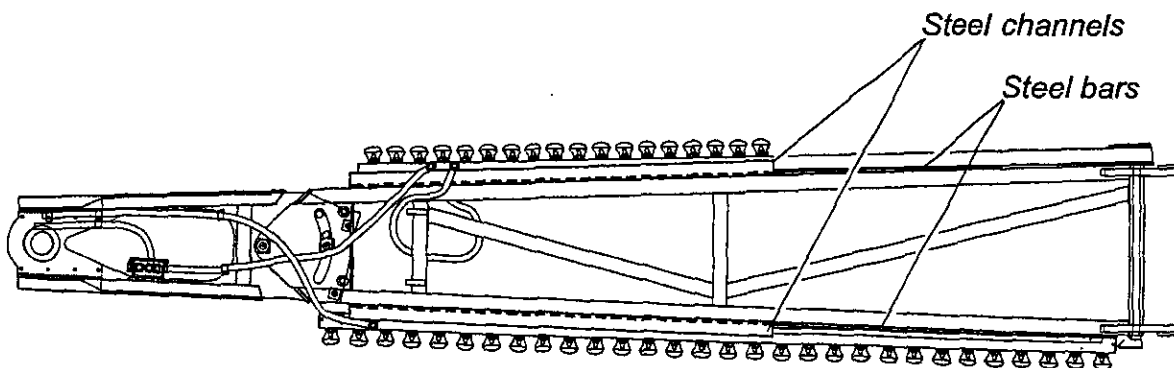
Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

*Installation of the Sweep Reinforcement Kit (K408CRM115-0) can be visually verified by the channels and bars welded to the upper and lower tubes of every sweep as shown.*



*On rides with the Sweep Reinforcement Kit installed, perform the inspection described in this bulletin ANNUALLY.*



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Bulletin No:	B408CRM125-0
Release Date:	December 1, 2003
Effective Date:	Immediately
Supersedes:	N / A
Completion Date:	N / A
Page:	1 of 1

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 408

Abstract of Issue:

Floor Replacement

Reason For Release:

Due to cost and availability, Chance Rides Manufacturing, Inc. is no longer able to supply replacement floor sections for the above noted CHAOS amusement rides. Replacement floors can be fabricated from locally procured materials, using the specifications provided in this bulletin.

Action to be Taken:

In the event that one or more floor sections require replacement, use materials meeting these specifications:

- Flooring - 1" thick plywood, smooth on one side for the top surface. Marine grade plywood is preferred for durability, but not required. DO NOT USE 3/4" THICK PLYWOOD. To ensure a proper fit, use the floor section being replaced as a template.
- Coating - Duraback™ Non-Slip Coating (manufactured by The Durabak Company, Aurora, CO.), applied per the manufacturer's instructions. A minimum of two coats is required on all sides to seal the plywood against moisture.

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.

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.



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Bulletin No: B408CRM124-0  
Release Date: December 1, 2003  
Effective Date: Immediately  
Supersedes: B408CRM115-0  
Completion Date: March 1, 2004  
Page: 1 of 4

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Abstract of Issue:  
Sweep Rework

Reason For Release:

**Service bulletin B408CRM115-0 is superseded by this bulletin and is no longer in effect.**

Chance Rides Manufacturing, Inc. has become aware that cracks can develop in the sweeps of the CHAOS amusement ride. A kit has been developed to reinforce the sweeps.

**Action to be Taken:**

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS amusement rides to inspect and rework all sweeps as described in this bulletin. The rework must be completed within 90 days of the release date of this bulletin.

Order and install the Sweep Reinforcement Kit (number K408CRM115-0). The kit includes all necessary parts to rework one complete ride. Complete installation instructions are provided with the kit. The ride can be operated until the Sweep Reinforcement Kit is installed. During this time, the sweeps must be inspected weekly 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. 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.

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.



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Bulletin No:	B408CRM124-0
Release Date:	December 1, 2003
Effective Date:	Immediately
Supersedes:	B408CRM115-0
Completion Date:	March 1, 2004
Page:	2 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### Sweep Inspection Procedure

Visually inspect every sweep for cracks as shown in the illustration on the next page, paying particular attention to the areas indicated by arrows. Look for indications in the steel tubes, and check the welded joints for indications in the welds and the parent metal.

**NOTE:** Some rides have been reworked per Service Bulletin B408CRM110-0. The inspection described in this bulletin applies to ALL RIDES, whether they have been reworked or not.

**IF NO INDICATIONS ARE FOUND,** order and install the Sweep Reinforcement Kit (number K408CRM115-0). The ride can be operated until the Sweep Reinforcement Kit is installed. During this time, the sweeps must be inspected weekly as described in this bulletin.

**IF ANY INDICATIONS ARE FOUND,** do not operate the ride. Contact the Customer Service Department at Chance Rides Manufacturing, Inc. immediately for instructions on the necessary repair procedure. The repair will require specific instructions for repairing cracks prior to installation of the Sweep Reinforcement Kit (number K408CRM115-0).

**DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE SWEEPS EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.**

After the Sweep Reinforcement Kit is installed, the sweeps must be inspected annually as described in this bulletin.

**NOTE:** The installation of the Sweep Reinforcement Kit can be visually verified as shown in the illustration on page 4 of this bulletin.



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Bulletin No:	B408CRM124-0
Release Date:	December 1, 2003
Effective Date:	Immediately
Supersedes:	B408CRM115-0
Completion Date:	March 1, 2004
Page:	3 of 4

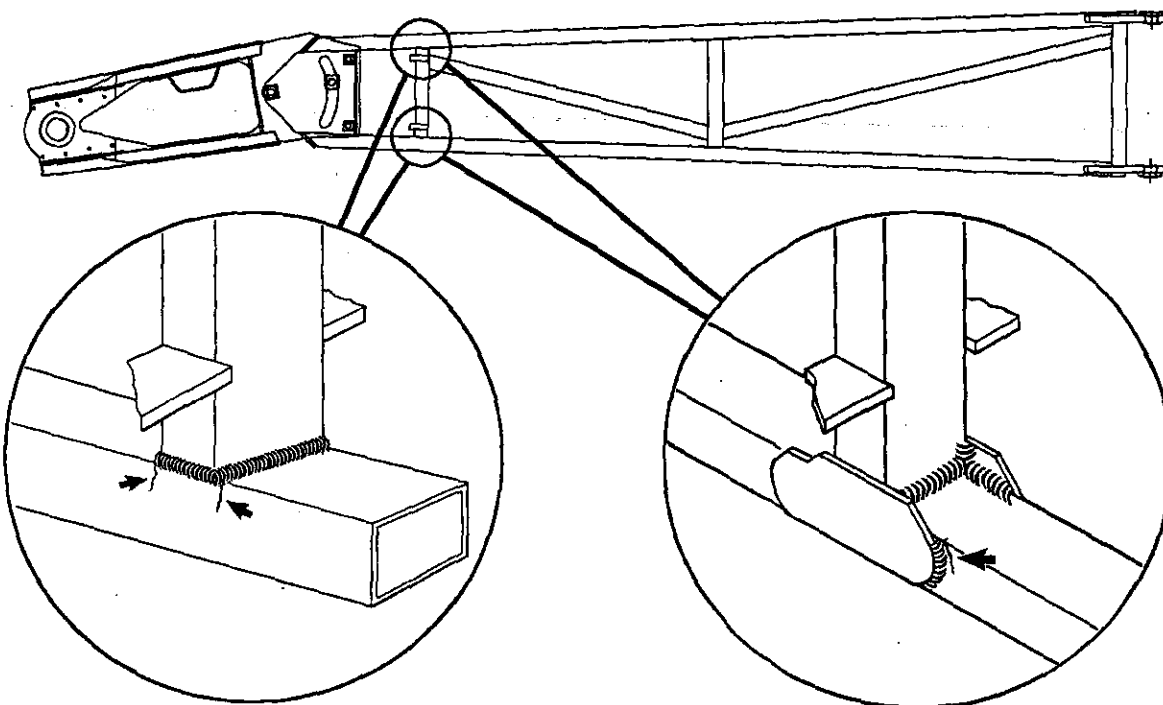
Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: CHAOS Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

**NOTE:** Sweep configuration may vary slightly from that shown.



**Rides that have NOT been  
reworked per Service Bulletin  
B408CRM110-0**

**Rides that HAVE been  
reworked per Service Bulletin  
B408CRM110-0**

*Pay particular attention to this area on both the top and bottom tubes of each sweep.*

*Perform this inspection WEEKLY until the Sweep Reinforcement Kit is installed, then ANNUALLY thereafter.*



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Bulletin No: B408CRM124-0

Release Date: December 1, 2003

Effective Date: Immediately

Supersedes: B408CRM115-0

Completion Date: March 1, 2004

Page: 4 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

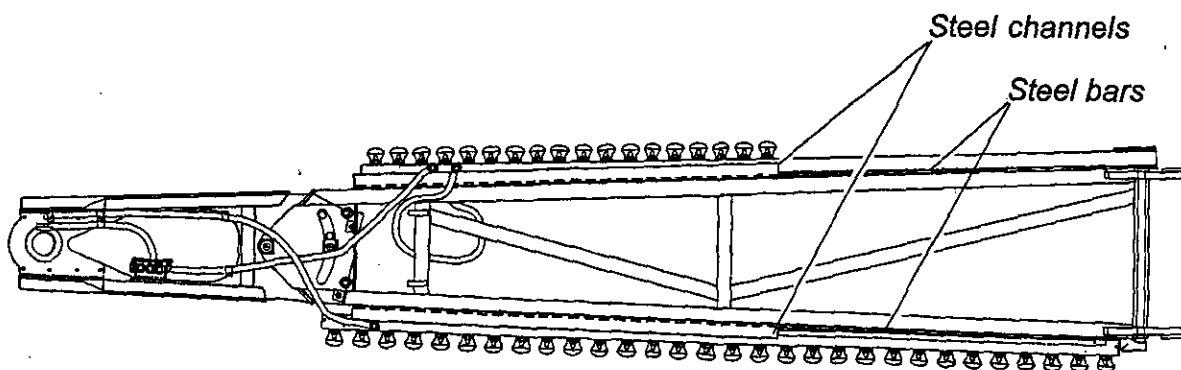
Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

*Installation of the Sweep Reinforcement Kit (number K408CRM115-0) can be visually verified by the channels and bars welded to the upper and lower tubes of every sweep as shown.*



*On rides with the Sweep Reinforcement Kit installed, perform the inspection described in this bulletin ANNUALLY.*



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**Bulletin No: B408CRM125-A**

**Release Date: March 4, 2004**

**Effective Date: Immediately**

**Supersedes: B408CRM125-0**

**Completion Date: N / A**

**Page: 1 of 5**

# SERVICE BULLETIN

**Ride Manufacturer: CHANCE RIDES, INC.**

**Affected Production Dates: All**

**Ride Name: CHAOS (Portable Model Only)**

**Affected Serial Nos.: All Units**

**Model No.: 408**

**Abstract of Issue:**

**Floor Replacement**

**Reason For Release:**

**Service bulletin B408CRM125-0 is superseded by this bulletin and is no longer in effect.**

Due to cost and availability, Chance Rides Manufacturing, Inc. is no longer able to supply replacement composite floor sections for the above noted CHAOS amusement rides. Replacement floors can be fabricated from locally procured materials, using the specifications provided in this bulletin. These floors require additional supports to be installed, as specified in this bulletin.

**Action to be Taken:**

**In the event that one or more floor sections require replacement, use materials meeting these specifications:**

- **Flooring** - 1" thick plywood, smooth on one side for the top surface. Marine grade plywood is preferred for durability, but not required. **DO NOT USE 3/4" THICK PLYWOOD.** To ensure a proper fit, use the floor section being replaced as a template.
- **Coating** - Durabak™ Non-Slip Coating (manufactured by The Durabak Company, Aurora, CO.), applied per the manufacturer's instructions. A minimum of two coats is required on all sides to seal the plywood against moisture.
- **Supports** - Additional floor support components are specified on the following pages of this bulletin. The supports are required under any plywood floor section. They can also be used under the original composite floor sections to provide extended life, at the owner's option.

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.





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Bulletin No:	B408CRM125-A
Release Date:	March 4, 2004
Effective Date:	Immediately
Supersedes:	B408CRM125-0
Completion Date:	N / A
Page:	2 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 408

#### Detail of Issue

#### Installation Instructions

1. Refer to the illustration on the following page to determine the specific location for each floor section being replaced.
2. Using the chart on page 4 of this bulletin, order the proper quantities for those specific floor sections. Pay attention to the following:
  - The T-supports are different lengths for each floor section. Be sure to order the correct length.
  - The support brackets must be located 1/4" below the surface on which the floors will rest, with the bottom flush with the bottom of the spreader bar or existing floor frame rail. To facilitate installation in this position, there are two different support brackets. Be sure to order the correct part.
3. Locate the support brackets as shown in the detail on page 5. Observe the distance from the support bracket to the end of the spreader bar or existing floor frame rail, as specified in the chart. Clamp the support brackets in place.
4. Using a 7/32" diameter bit, drill the spreader bar or floor frame rail to match the four holes in the support brackets. Secure the brackets with four 3/16" x 7/16" Monobolts.

**NOTE:** The support brackets can be welded in place if desired. All welding must be performed by a certified welder. Clean areas to be welded with a clean stainless steel brush. Use ER5356 welding electrode and weld along both sides of each bracket.

5. Install the T-supports in the slot of the support bracket slot and install the floors sections.

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.



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Bulletin No:	B408CRM125-A
Release Date:	March 4, 2004
Effective Date:	Immediately
Supersedes:	B408CRM125-0
Completion Date:	N / A
Page:	3 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS (Portable Model Only)

Affected Serial Nos.: All Units

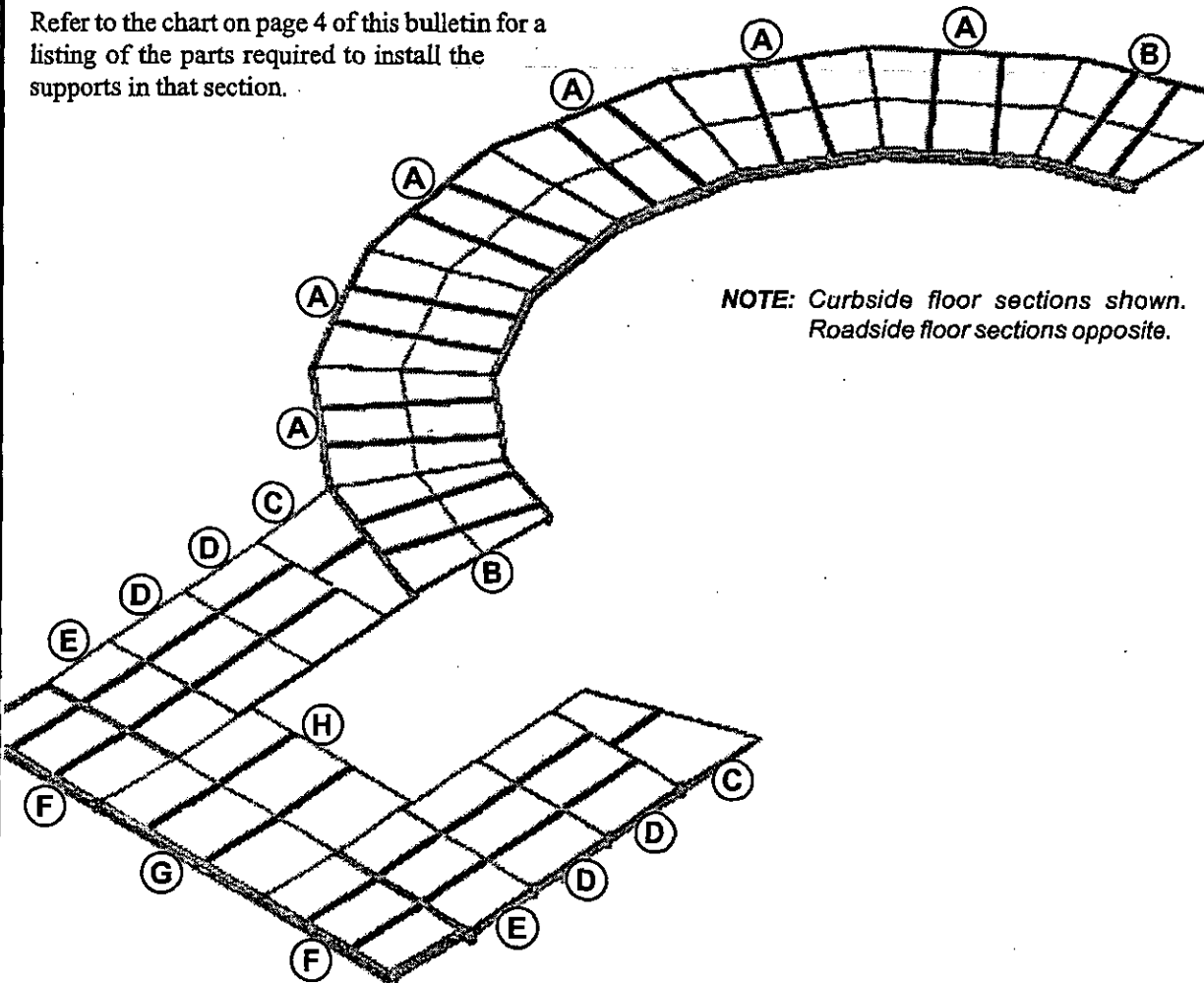
Model No.: 408

Detail of Issue (continued):

#### Floor Section Identification

Determine the location of each floor section being replaced using the illustration below. Additional floor supports are indicated by heavy lines.

Refer to the chart on page 4 of this bulletin for a listing of the parts required to install the supports in that section.





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Bulletin No: B408CRM125-A  
 Release Date: March 4, 2004  
 Effective Date: Immediately  
 Supersedes: B408CRM125-0  
 Completion Date: N / A  
 Page: 4 of 5

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

Ride Name: CHAOS (Portable Model Only) Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### CHAOS Floor Support Installation (for use with plywood replacement floors)

Floor Location (refer to drawing)	Support Components Required For Each Section	Location of Floor Support Brackets (Distance from each end of spreader bar or existing floor frame rail. Measurements are plus/minus 1/4")
A (12 places)	408-829-013 T-Support - 70-1/4" long (2 required) 408-829-011 Floor Support Bracket (4 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	26-3/8" from each end of long spreader bar 13-3/8" from each end of short spreader bar
B (4 places)	408-829-013 T-Support - 70-1/4" long (2 required) 408-829-011 Floor Support Bracket (4 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	23-7/8" from each end of long spreader bar 2-1/4" from the trailer end of short spreader bar 11" from the outer end of short spreader bar
C (2 places)	408-829-014 Support - 27-1/4" long (1 required) 408-829-011 Floor Support Bracket (1 required) 408-829-012 Floor Support Bracket (1 required) 66166200 Monobolt - 3/16" x 7/16" (8 required)	41-3/8" from the outer end of the long spreader bar Centered on the floor frame rail
D (4 places)	408-829-015 T-Support - 39-3/4" long (2 required) 408-829-012 Floor Support Bracket (4 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	21-7/8" from each end of floor frame rail (centered)
E (2 places)	408-829-016 T-Support - 34-1/4" long (2 required) 408-829-012 Floor Support Bracket (4 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	21-7/8" from each end of floor frame rail
F (2 places)	408-829-017 Support - 40" long (2 required) 408-829-011 Floor Support Bracket (2 required) 408-829-012 Floor Support Bracket (2 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	21-3/4" from each end of floor frame rail
G (1 place)	408-829-017 Support - 40-5/16" long (2 required) 408-829-011 Floor Support Bracket (2 required) 408-829-012 Floor Support Bracket (2 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	28" from each end of floor frame rail
H (1 place)	408-829-016 T-Support - 34-1/4" long (2 required) 408-829-012 Floor Support Bracket (4 required) 66166200 Monobolt - 3/16" x 7/16" (16 required)	28" from each end of floor frame rail



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Bulletin No:	B408CRM125-A
Release Date:	March 4, 2004
Effective Date:	Immediately
Supersedes:	B408CRM125-0
Completion Date:	N / A
Page:	5 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

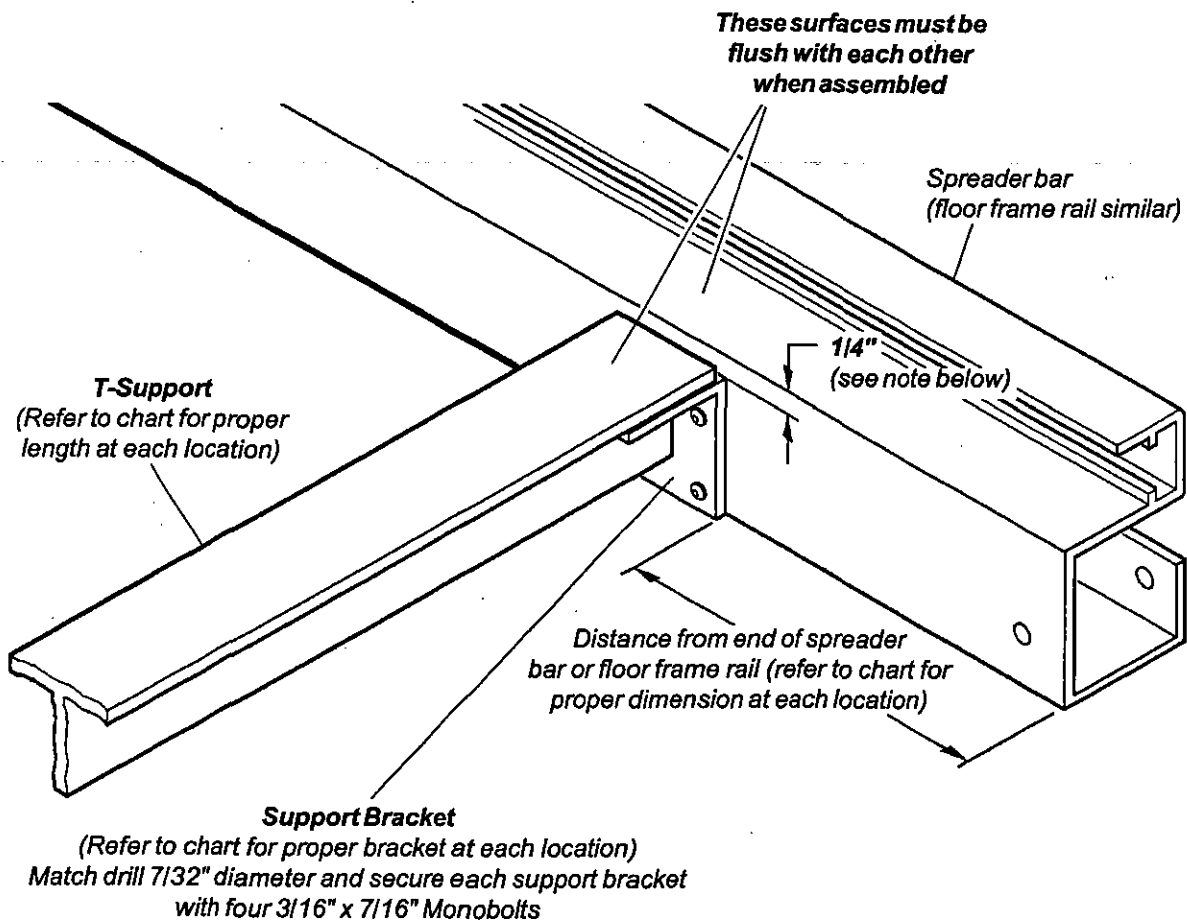
Ride Name: CHAOS (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

### Detail of Floor Support Installation



**NOTE:** Locate support brackets 1/4" below the surface on which the floor will rest. The bottom of the support bracket will be flush with the bottom of the spreader bar or floor frame rail



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Bulletin No:	B408CRM129-0
Release Date:	July 30, 2004
Effective Date:	July 30, 2004
Supersedes:	N / A
Completion Date:	See Text
Page:	1 of 3

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: November, 1997 and on

Ride Name: CHAOS  
(Park Model Rides  
with one-piece sweeps only)

Affected Serial Nos.: 408-03398 and on

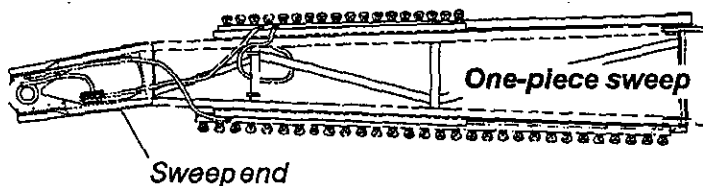
Model No.: 408

Abstract of Issue:  
Sweep Inspection

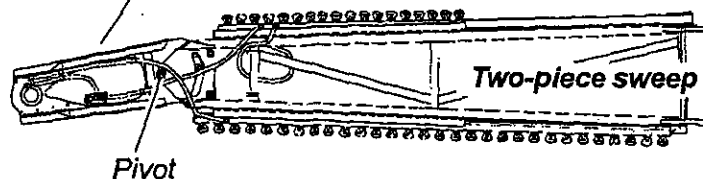
Reason For Release:

This service bulletin applies only to park model rides with one-piece sweeps (ride serial number 408-03398 and on). PORTABLE MODEL RIDES AND PARK MODEL RIDES WITH EARLIER SERIAL NUMBERS ARE NOT AFFECTED.

*One-piece sweep has sweep end integrated into sweep weldment. This bulletin applies to these sweeps.*



*Two-piece sweep has separate sweep end which can be pivoted up or down. These sweeps are not affected by this bulletin.*



Chance Rides Manufacturing, Inc. has become aware that cracks can develop in the sweeps of the above noted CHAOS amusement rides, even after installation of the Sweep Reinforcement Kit K408CRM115-0 (Refer to Chance Rides Manufacturing, Inc. service bulletin B408CRM124-0).



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Bulletin No:	B408CRM129-0
Release Date:	July 30, 2004
Effective Date:	July 30, 2004
Supersedes:	N / A
Completion Date:	See Text
Page:	2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: November, 1997 and on

Ride Name: CHAOS  
(Park Model Rides  
with one-piece sweeps only)

Affected Serial Nos.: 408-03398 and on

Model No.: 408

**Action to be Taken:**

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS amusement rides to inspect all sweeps as described in this bulletin. The inspection must be completed immediately upon receipt of this bulletin and weekly thereafter.

**Sweep Inspection Procedure**

Visually inspect every sweep for cracks as shown in the illustration on the next page, paying particular attention to the areas indicated by arrows. Look for indications in the steel tubes, and check the welded joints for indications in the welds and the parent metal.

**IF NO INDICATIONS ARE FOUND**, operation of the ride can continue. The sweeps must be inspected weekly as described in this bulletin.

**IF ANY INDICATIONS ARE FOUND**, do not operate the ride. Contact the Customer Service Department at Chance Rides Manufacturing, Inc. immediately for instructions on the necessary repair procedure. **DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE SWEEPS EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.**

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.

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.



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Bulletin No:	B408CRM129-0
Release Date:	July 30, 2004
Effective Date:	July 30, 2004
Supersedes:	N / A
Completion Date:	See Text
Page:	3 of 3

Ride Manufacturer: CHANCE RIDES, INC.

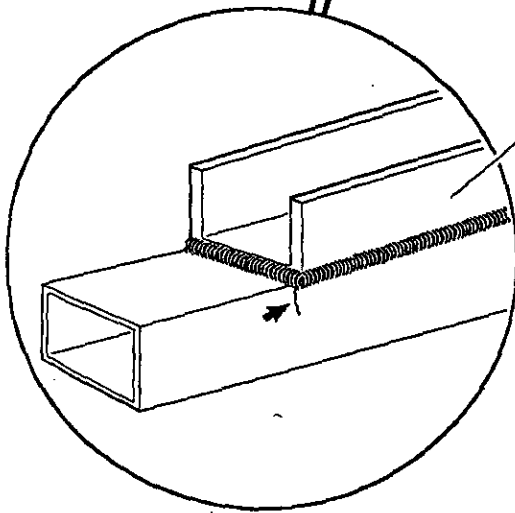
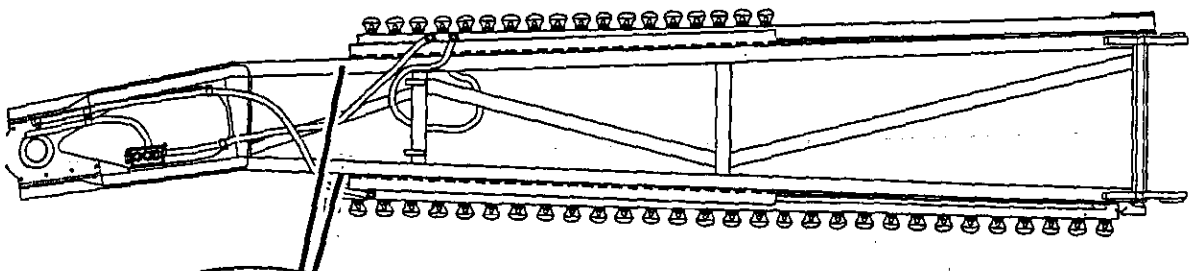
Affected Production Dates: November, 1997 and on

Ride Name: CHAOS  
(Park Model Rides  
with one-piece sweeps only)

Affected Serial Nos.: 408-03398 and on

Model No.: 408

Detail of Issue (continued):



This steel channel was added as part of the Sweep Reinforcement Kit required by service bulletin B408CRM124-0

**NOTE:** Sweep configuration may vary slightly from that shown.

*Pay particular attention to this area on both the top and bottom tubes of each sweep.*

*Perform this inspection IMMEDIATELY upon receipt of this bulletin and WEEKLY thereafter.*



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Bulletin No:	P408CRM133-0
Release Date:	October 15, 2004
Effective Date:	October 15, 2004
Supersedes:	N / A
Completion Date:	N/A
Page:	1 of 3

# NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

Model No.: 408

Abstract of Issue:

New Lap Bar and T-Bar Ratchet Lock System

Reason For Release:

The original passenger restraint system on the above noted CHAOS amusement rides incorporates three hydraulic lock cylinders on each vehicle - one for each lap bar and one for the secondary restraint bar (T-bar). In the even a hydraulic lock cylinder fails, a redundant mechanical lock prevents the restraint bar from opening.

The hydraulic lock cylinders have performed satisfactorily and provided acceptable service life when properly maintained. The cylinders have, however, been subject to damage from weather, improper storage and physical damage. When a hydraulic lock cylinder fails, the only option has been to replace it with a new or re-manufactured part, since they are not serviceable in the field.

Chance Rides Manufacturing, Inc. has developed a mechanical ratchet lock system to replace the hydraulic lock cylinders. The new ratchet locks are manually operated and will require less maintenance. The new ratchet locks completely replace the hydraulic lock cylinders and eliminate electric operation of the solenoids.

The new ratchet lock design functions similarly to the original, except that manual release of the restraint bars is required. This is accomplished with a single lever on each vehicle, which releases both lap bars and the T-bar with one motion.

Action to be Taken:

All owners of the above noted amusement rides can, at their option, replace the hydraulic lock cylinders with the new ratchet lock system. Either design is acceptable and safe to operate if properly maintained, but all vehicles on a specific ride must be equipped with the same restraint bar locking system. **INSTALLATION OF THIS KIT IS NOT MANDATORY AND IS INTENDED ONLY TO REDUCE MAINTENANCE COSTS.** Replacement parts for the original system will continue to be available.

Order the Ratchet Lock Kit, part number K408CRM133-1, which includes all parts necessary to convert one ride to the new design. Detailed installation instructions are included with the kit.

A credit for the return of rebuildable hydraulic locking cylinders will be applied to the purchase price of the ratchet lock kit.





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Page:	2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

Model No.: 408

**Detail of Issue (continued):**

**Overview of new ratchet lock system features:**  
(Refer to the photo on the following page)

1. Ratchet locks replace existing hydraulic lock cylinders (3 places on each vehicle). These units are all stainless steel construction for longer service life.
2. The new components mount to the vehicle with capscrews - no welding is required.
3. Manual lever releases both lap bars and T-bar simultaneously with one motion to eliminate electrical operation of the solenoids.
4. Lower pivot shaft releases all three ratchet locks.
5. Upper pivot shaft releases all three existing mechanical secondary locks. The solenoids are disabled.

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.

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Ride Manufacturer: CHANCE RIDES, INC.

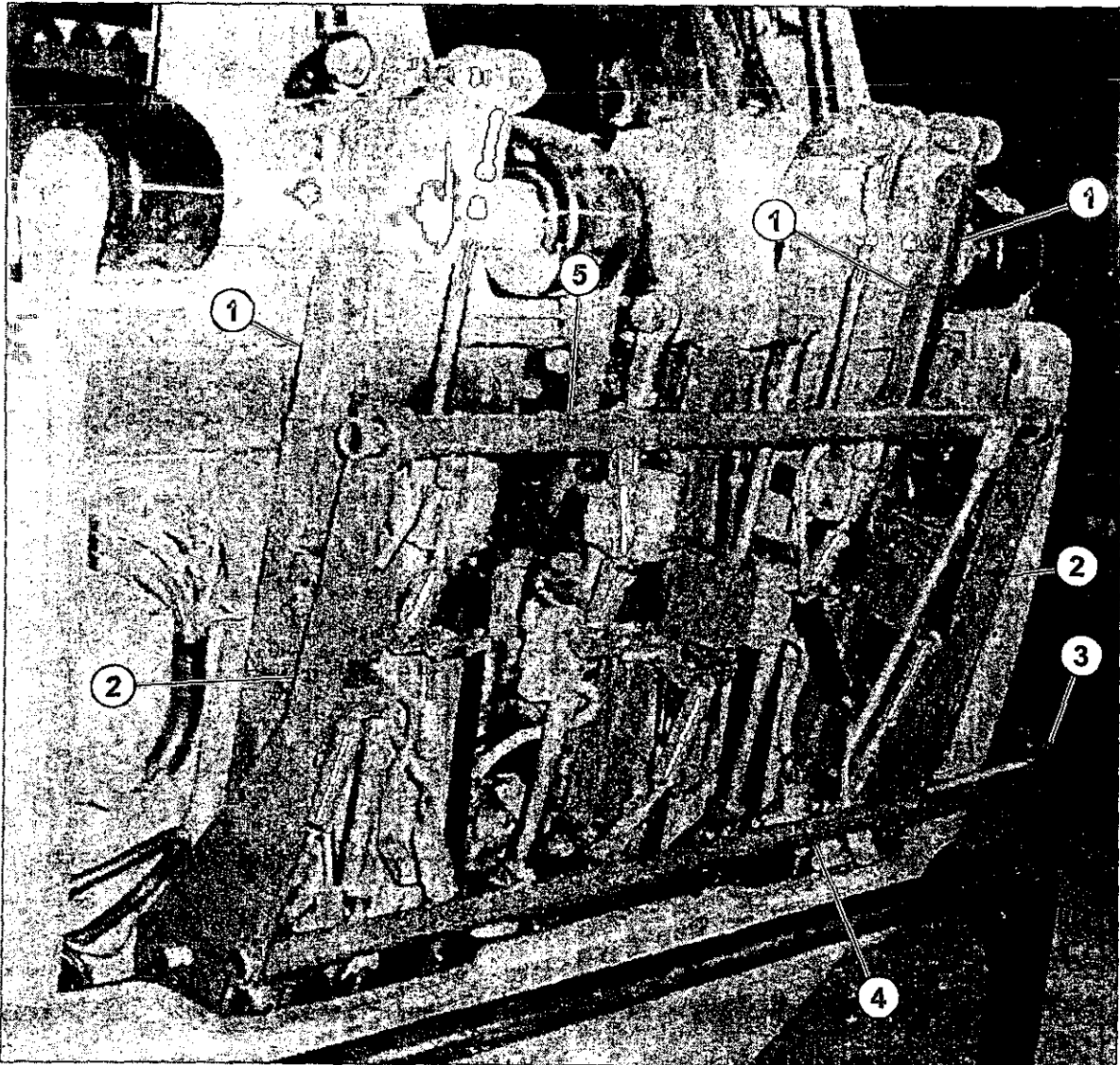
Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 through 408-03998

Model No.: 408

Detail of Issue (continued):





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Bulletin No: B408CRM139-0  
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(issued 8/1/00 by Chance Rides, Inc.)  
Completion Date: N/A  
Page: 1 of 5

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Abstract of Issue:

NDT Inspection of Secondary Restraint Bars

Reason For Release:

Chance Rides, Inc. has become aware of an occurrence where a crack developed in the curved area of the secondary restraint bars of the CHAOS amusement ride. A break in the secondary restraint bar can possibly result in personal injury to the operator, passengers, and/or bystanders.

This bulletin is being issued to change the required annual visual inspection of these parts to an NDT inspection.

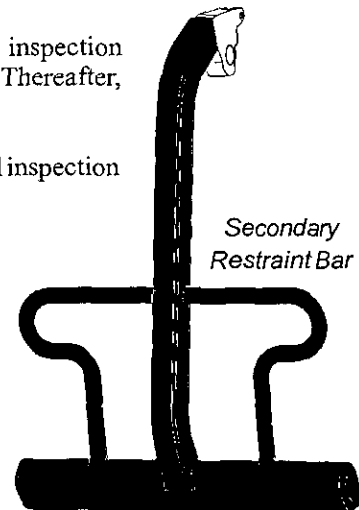
Action to be Taken:

All owners of the above noted amusement rides are required to perform the inspection described in this bulletin within 30 days of the release date on this bulletin. Thereafter, perform the inspection annually.

If desired, a boot is available to cover the inspection area. Subsequent annual inspection requires the removal of the boot.

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.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

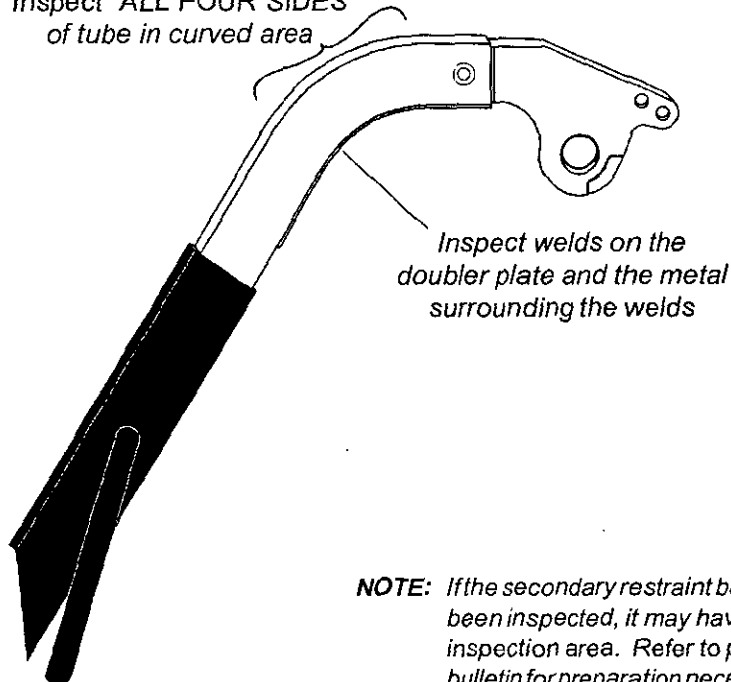
#### Annual NDT Inspection Procedure for Secondary Restraint Bars

Using the liquid penetrant inspection procedure on the next page of this bulletin, inspect the following areas of all secondary restraint bars:

- All four sides of the aluminum tube in the curved area.
- The welds on the doubler plate and the metal surrounding the welds.

If any indications are found, contact the Chance Rides Customer Service Department immediately. **DO NOT LOAD PASSENGERS IN THAT VEHICLE UNTIL REPAIR OR REPLACEMENT IS MADE.**

*Inspect ALL FOUR SIDES  
of tube in curved area*



**NOTE:** If the secondary restraint bar has not previously been inspected, it may have foam covering the inspection area. Refer to pages 4 and 5 of this bulletin for preparation necessary to gain access to the inspection area.

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Completion Date: N/A

Page: 3 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

**IMPORTANT:** The following liquid penetrant inspection technique meets the requirements of ASTM E1220 and must be performed by a certified Level II or Level III inspector.

1. Pre-Clean:  
Use a solvent to clean contaminants from the area to be inspected.
2. Apply Penetrant:  
The visible dye, color contrast, solvent-removable penetrant must thoroughly cover the inspection areas.
3. Dwell Time:  
The penetrant shall remain on the areas of interest for a minimum of 10 minutes.
4. Excess Penetrant Removal:
  - a. Wipe as much of the penetrant from the inspection areas as possible by using a clean, dry, lint-free cloth rag.
  - b. Removal of penetrant residue is done by wiping the inspection area with a clean, lint-free cloth rag that has been moistened with the cleaner remover
5. Developer Application:  
Apply a thin, even coating of a non-aqueous developer to the inspection area and allow it to develop for a minimum of seven minutes.
6. Inspection:  
Thoroughly inspect the areas for indications within 30 minutes after developer is applied..

**IF NO INDICATIONS ARE FOUND**, the ride can be put back into service.

**IF ANY INDICATIONS ARE FOUND**, do not operate the ride with passengers in that vehicle. Contact the Customer Service Department at Chance Rides Manufacturing, Inc. immediately for instructions on the necessary repair procedure.

**DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE SECONDARY RESTRAINT BAR, EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.**

7. Post-Clean:  
Clean all inspection areas with penetrant cleaner remover and wipe off residues with a cloth rag.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue(continued):

### Preparation of Secondary Restraint Bars for Inspection

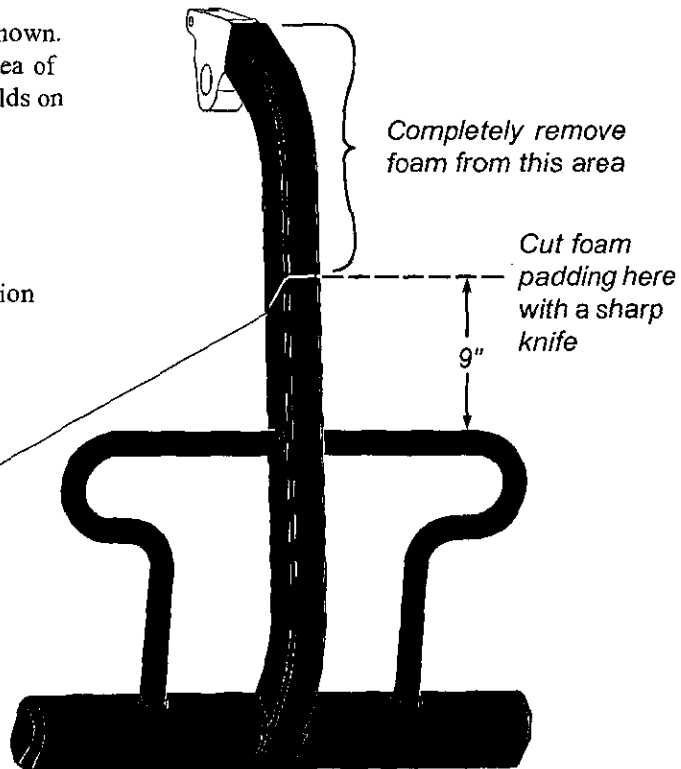
If the secondary restraint bar has not previously been inspected, it may have foam covering the inspection area. The following preparation is necessary to gain access to the inspection area.

- Use a sharp knife to carefully cut the foam padding as shown on all 18 secondary restraint bars.

**IMPORTANT:** When cutting the foam, be careful not to score the aluminum tube inside the foam. This will severely weaken the tube.

- Remove the foam above the cut as shown. This will expose the entire curved area of the frame and the full length of the welds on the doubler plate.
- Seal the cut edges of the foam with a generous fillet of black RTV sealant.
- A boot is available to cover the inspection area if desired, but it is not mandatory. Refer to the last page of this bulletin for information on the boot.

Seal the cut edges with black RTV sealant. If desired, order and install the inspection boot as described on the following page of this bulletin.



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Page: 5 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

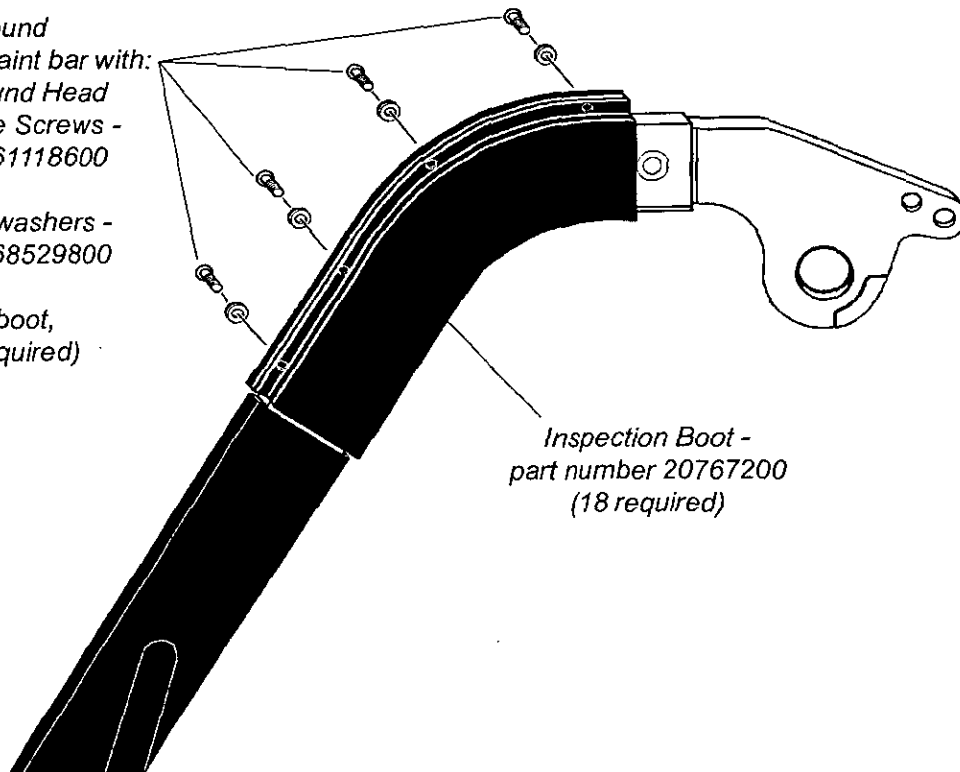
Detail of Issue (continued):

If desired, order and install the inspection boots as shown.

Part Number	Component	Quantity
20767200	INSPECTION BOOT	18
61118600	SCREW - Phillips Head Machine (#10-32 x 1")	72
68529800	WASHER - SAE Flat (3/16)	72

Secure boot around  
secondary restraint bar with:  
#10-32 x 1" Round Head  
Phillips Machine Screws -  
part number 61118600  
- and -  
3/16" SAE Flat washers -  
part number 68529800

(4 places each boot,  
total 72 each required)





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Bulletin No: P408CRM140-0

Release Date: June 25, 2005

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Page: 1 of 3

# NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

Model No.: 408

Abstract of Issue:

Inspection of Passenger Restraint Interlock System

Reason For Release:

Chance Rides Manufacturing, Inc. has become aware, through field observation, that some operators of the CHAOS amusement ride are not performing the daily check of the passenger restraint interlock system as described in the *CHAOS Service Manual*.

The passenger restraint system must be maintained per the manufacturer's specifications without modifications or alterations, and inspected to verify the operation of the interlock system and ensure safe operation of the ride.

This notification is being released to emphasize the importance of the information in the *CHAOS Service Manual* and to remind owners that **MODIFYING, TAMPERING WITH OR CHANGING THE INTERLOCK SYSTEM, INCLUDING BUT NOT LIMITED TO, LIMIT SWITCHES AND CONTROL LOGIC, MAY RESULT IN INJURY TO PASSENGERS.**

The passenger restraint interlock system check procedure is reprinted on the following pages of this notification. Note that two different procedures are provided, depending upon the ride serial number.

Action to be Taken:

All owners/operators of the above noted amusement rides must establish an inspection program which emphasizes the manufacturer's requirements for all scheduled inspections including, but not limited to the items described in this notification. All owners/operators must read the *CHAOS Service Manual* and be familiar with all information, warnings and cautions printed in the manual and service bulletins prior to operating the ride.

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 notification and all related technical information to personnel using or inspecting the equipment.





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

Ride Name: CHAOS Affected Serial Nos.: All

Model No.: 408

**Detail of Issue**

**Passenger Restraint Interlock System Operational Check  
(Ride Serial Numbers 408-00296 through 408-01997)**

An interlock system prevents the ride from being started if any of the secondary restraint bars are not down and locked. The following check must be made DAILY to ensure the proper operation of the passenger restraint bar interlock system.



**WARNING: Never load passengers into a vehicle unless ALL passenger restraint bars on that vehicle are in good working condition, and the passenger restraint bar interlock system is operating correctly.**

**Do not tamper with or attempt to defeat the purpose of the passenger restraint bars or the passenger restraint bar interlock system. Serious injury to passengers can result.**

1. Lower and lock all lap bars and secondary restraint bars. All white lap bar indicator lights must be on.
2. Start the ride. It should start and run normally. Stop the ride.
3. With the ride stopped, manually release the secondary restraint bar on only one vehicle.
4. Carefully close the secondary restraint bar, engaging the right hand latch first, then the left hand latch. Listen for two audible "clicks" as the left hand latch engages in two positions. The white lap bar indicator light must not come on until the left hand latch reaches the second, fully engaged position.
5. Repeat Step 3 and 4, but close the left hand latch first, then observe the indicator light as the right hand latch is engaged.
6. If the indicator light comes on before EITHER secondary restraint bar latch is completely engaged, adjustment or repair of the passenger restraint bar interlock system is necessary.
7. Proceed to the next vehicle and repeat Steps 3, 4, 5, and 6 until all vehicles have been tested, ONE AT A TIME.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All

Model No.: 408

Detail of Issue (continued):

**Passenger Restraint Interlock System Operational Check**

(Ride Serial Numbers 408-00196, 408-02097 and on)

An interlock system prevents the ride from being started if any of the secondary restraint bars are not down and locked. The following check must be made DAILY to ensure the proper operation of the passenger restraint bar interlock system.



**WARNING: Never load passengers into a vehicle unless ALL passenger restraint bars on that vehicle are in good working condition, and the passenger restraint bar interlock system is operating correctly.**

**Do not tamper with or attempt to defeat the purpose of the passenger restraint bars or the passenger restraint bar interlock system. Serious injury to passengers can result.**

1. Lower and lock all lap bars and secondary restraint bars. All white lap bar indicator lights must be on.
2. Start the ride. It should start and run normally. Stop the ride.
3. With the ride stopped, manually release the secondary restraint bar on only one vehicle.
4. Carefully close the secondary restraint bar. The white lap bar indicator light must not come on until the bar is completely down and locked.
5. If the indicator light comes on before the secondary restraint bar is fully down, adjustment or repair of the passenger restraint bar interlock system is necessary.
6. Proceed to the next vehicle and repeat Steps 3, 4, and 5 until all vehicles have been tested, ONE AT A TIME.

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Page:	1 of 4

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

## Abstract of Issue:

### Inspection of Main Bearing

#### Reason For Release:

Over time, normal wear to the main bearing on the CHAOS amusement ride can cause reduced clearance between the boom and the vehicles. If wear becomes severe, the vehicles can contact the boom during operation. This condition can cause personal injury.

Periodic inspection of the main bearing is necessary to ensure that wear is detected before it becomes severe. Early detection of wear also increases the possibility of repairing/remanufacturing the bearing, as opposed to more expensive replacement of a severely worn bearing.

This service bulletin establishes the proper interval and procedure for inspection of the main bearing.

#### Action to be Taken:

All owner/operators of CHAOS amusement rides are required to inspect the main bearing as described in this service bulletin. This inspection must be performed and recorded ANNUALLY until significant bearing wear is noted. As wear increases, the time interval between measurements must be shortened.

The main bearing inspection procedure on the following pages provides an accurate measurement of the tilting clearance of the bearing. The change in this clearance over time indicates the wear in the bearing raceway.

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.

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.

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Bulletin No: B408CRM143-0

Release Date: September 7, 2005

Effective Date: September 7, 2005

Supersedes: N/A

Completion Date: N/A

Page: 2 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

## Detail of Issue

**Main Bearing Inspection Procedure**

Tilting clearance in the main bearing can be measured by applying both a positive and a negative load on opposite sides of the bearing. Because of normal variation in clearances between the inner and outer races of the bearing, the following conditions must be met every time bearing clearance is measured.

- **The sweeps must be in the same position relative to the boom**

This locates the inner and outer bearing races in the same position relative to each other. This can be accomplished by always positioning vehicle #1 in the center of the boom as shown in the illustration on the next page. Do not rotate the ride until bearing inspection is completed.

- **The bearing must be measured in at least three places, equally spaced around the bearing**

The bearing must be measured in the same three places every time it is measured. This ensures that the same clearances are being measured every time for comparison with previous measurements. It is recommended that the exact points on the bearing are marked in some manner so that they can be identified for measurement in the future. Refer to points marked "A," "B" and "C" in the illustration on the following page.

**NOTE:** This procedure requires at least two people. The ride must be set up with the sweeps spread out and the spreader bars installed.

1. Set up a dial indicator as shown on page 4 of this bulletin. The magnetic base is on the tilt head structure and the dial indicator follower is on the flat area on one of the gear teeth. Mark both locations for future measurements.
2. Load one side of the ride opposite the dial indicator (for location "A," load vehicles #18, #1 and #2). As load is increased, clearance will be recognized by movement of the dial indicator. When the dial indicator stops moving, set the dial to zero.
3. Now, unload the ride and start loading the ride on the opposite side (for location "A," load vehicles #9, #10 and #11). When the dial indicator stops moving, read and record the total movement. This is the tilting clearance at location "A."
4. Repeat process at locations "B" and "C" and record the tilting clearance at those locations.



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Ride Manufacturer: CHANCE RIDES, INC.

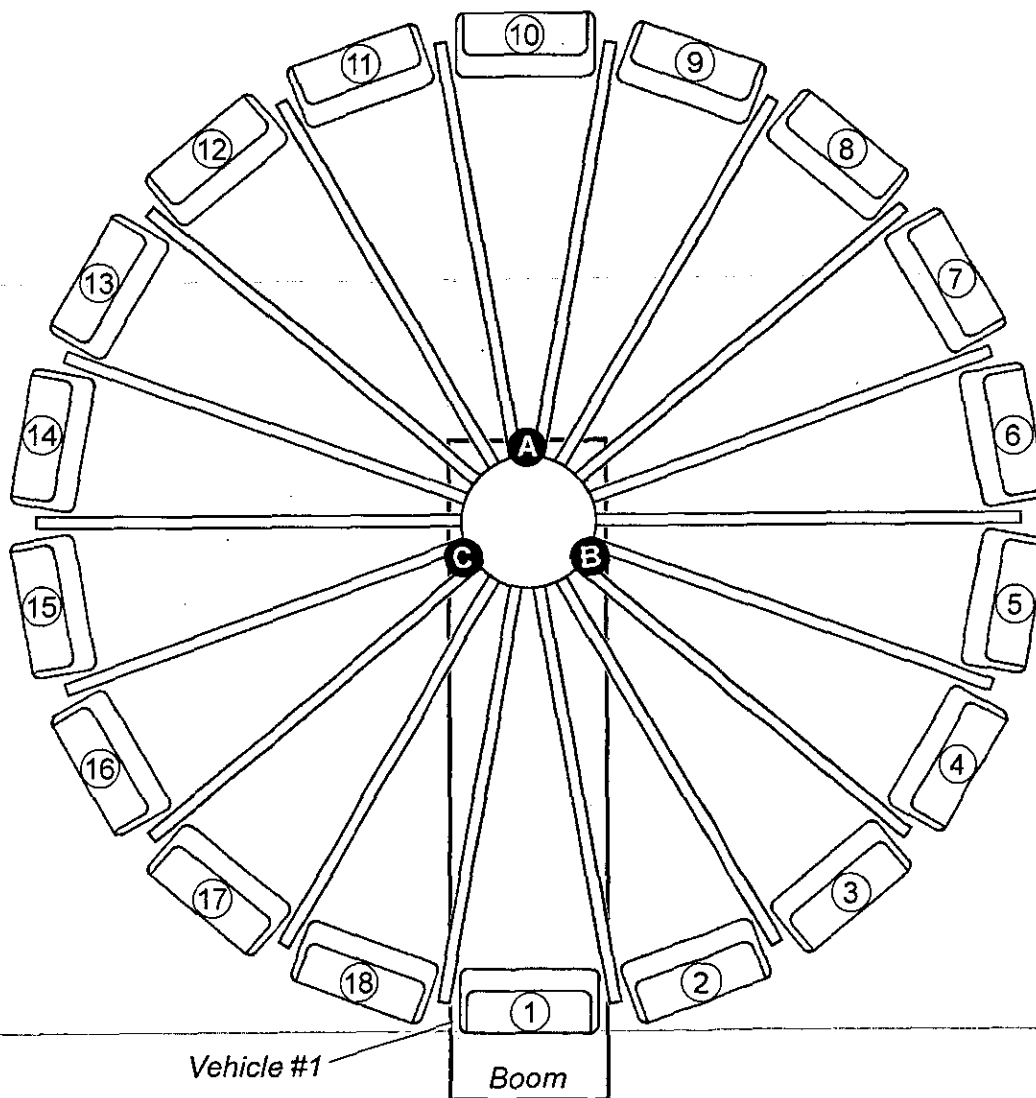
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):



**Locations to Measure Main Bearing Clearance**



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Ride Manufacturer: CHANCE RIDES, INC.

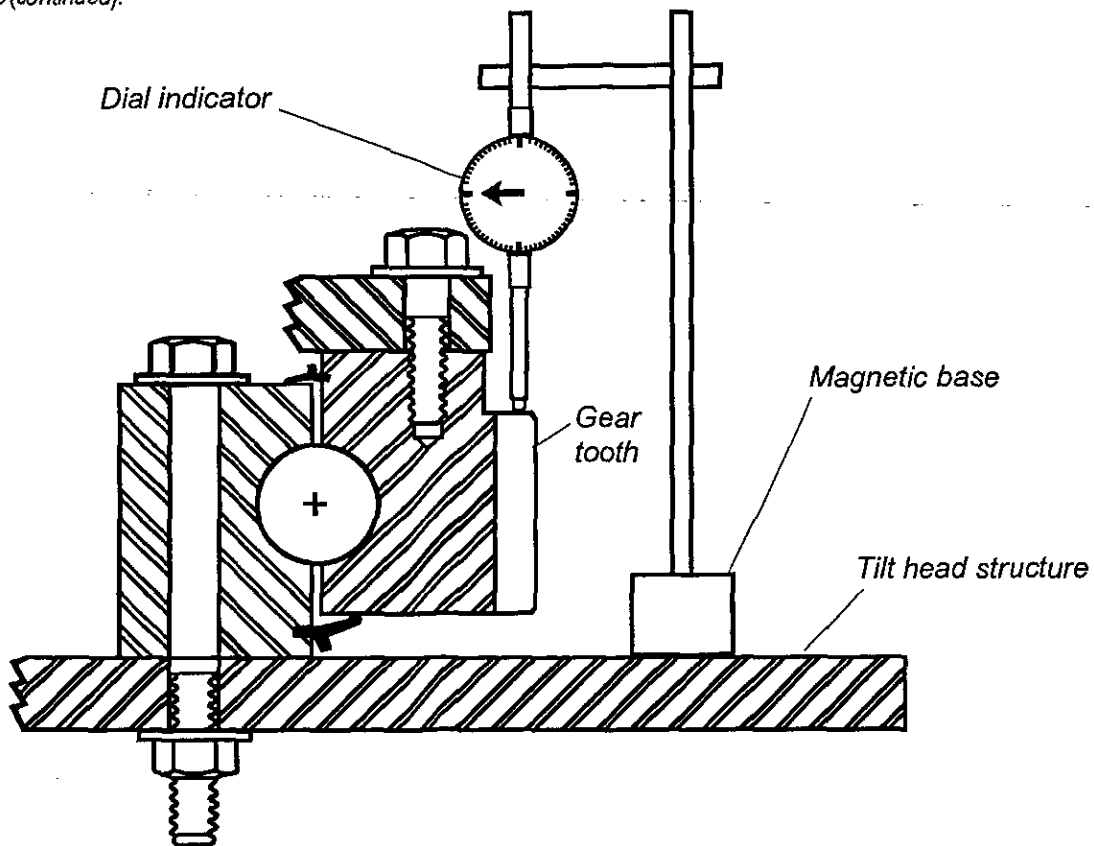
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):



**Detail of Dial Indicator Set-Up to Measure Main Bearing Clearance**  
(Typical three locations equally spaced around the bearing)

Maximum allowable tilting clearance in the main bearing at any point is 0.047 inches.

If tilting clearance exceeds this amount, the bearing must be repaired/remanufactured (if possible); or replaced with a new bearing. Contact Chance Rides Manufacturing, Inc. for more information on repair and/or replacement.

This inspection must be performed and recorded ANNUALLY until significant bearing wear is noted. As wear increases, the time interval between measurements must be shortened.



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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

## Abstract of Issue:

Passenger Restraint Bar Locking System Inspection and Operational Check  
(Rides Equipped With Hydraulic Lock Cylinders)

## Reason For Release:

The passenger restraint system on the above noted CHAOS amusement rides incorporates one of the following restraint bar locking systems

- Three hydraulic lock cylinders on each vehicle - one for each primary restraint bar (shoulder bar) and one for the secondary restraint bar (T-bar)
- or --
- Three ratchet locks on each vehicle - one for each shoulder bar and one for the T-bar (ratchet locks can be retrofitted to replace the hydraulic lock cylinders at the owner's option). **For the "Inspection and Operational Check Procedure" on rides which have been retrofitted with this system, refer to Service Bulletin B408CRM148-0.**

With either system, a redundant mechanical lock is provided for each restraint bar. In the event that the hydraulic lock cylinder or ratchet lock fails, the mechanical lock will prevent the restraint bar from opening.

Chance Rides Manufacturing, Inc. has become aware that some owner/operators are not maintaining and inspecting the restraint bar locking system as specified in the *CHAOS Service Manual*. If the locking mechanisms on any restraint bar do not operate correctly, multiple component failures on a seat can result in injury to passengers.

This bulletin is being released to provide additional information on the correct procedures to check the operation of the restraint bar locking system.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

**Action to be Taken:**

All owners of the above noted CHAOS amusement rides are required to inspect the condition of the restraint bar locking system and check its operation as described in the *CHAOS Service Manual* and this service bulletin.

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.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

#### Detail of Issue

#### Inspection and Testing of Restraint Bar Locking System

The passenger restraint system on each vehicle incorporates a locking system for each shoulder bar and T-bar. All components must be in good working condition to ensure the safety of the passengers.

The following pages provide instructions for weekly testing of the restraint bar locking system.

This procedure requires two people. The vehicle back panel need not be removed. Access holes are provided for manual release of the restraint bar locking system components (See page 5 of this bulletin).

**IMPORTANT:** *This procedure does not replace any inspections described in the CHAOS Service Manual. It is to be used in addition to all previously published inspections.*

*Always check both shoulder bars and the T-bar on every vehicle using the procedures provided in this bulletin and in the CHAOS Service Manual.*

**NOTE:** *The procedure described in this bulletin applies to rides equipped with hydraulic lock cylinders. If the ride has been retrofitted with ratchet locks, refer to Service Bulletin B408CRM148-0.*



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

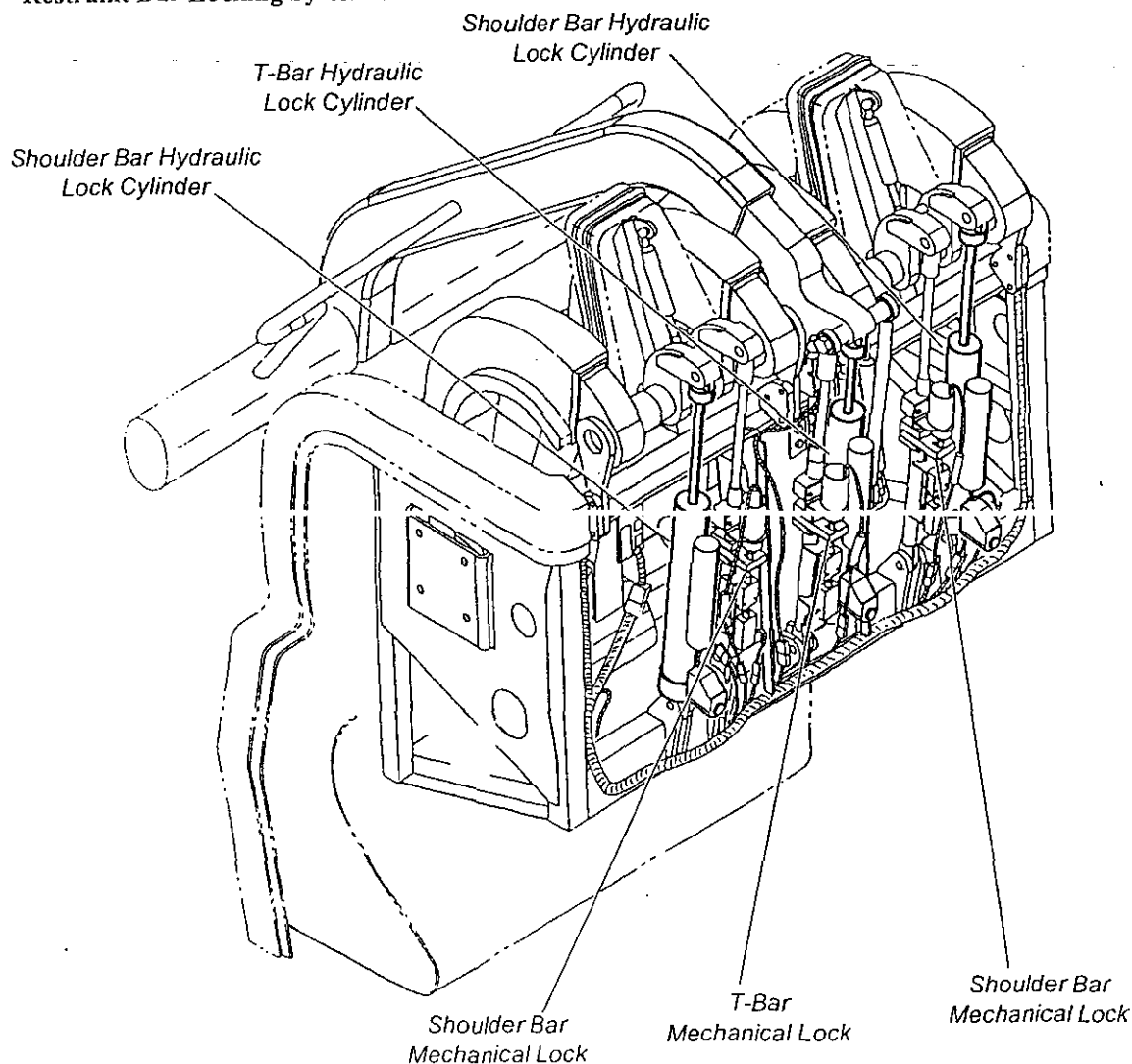
Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

### Restraint Bar Locking System on Rides With HYDRAULIC LOCK CYLINDERS





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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

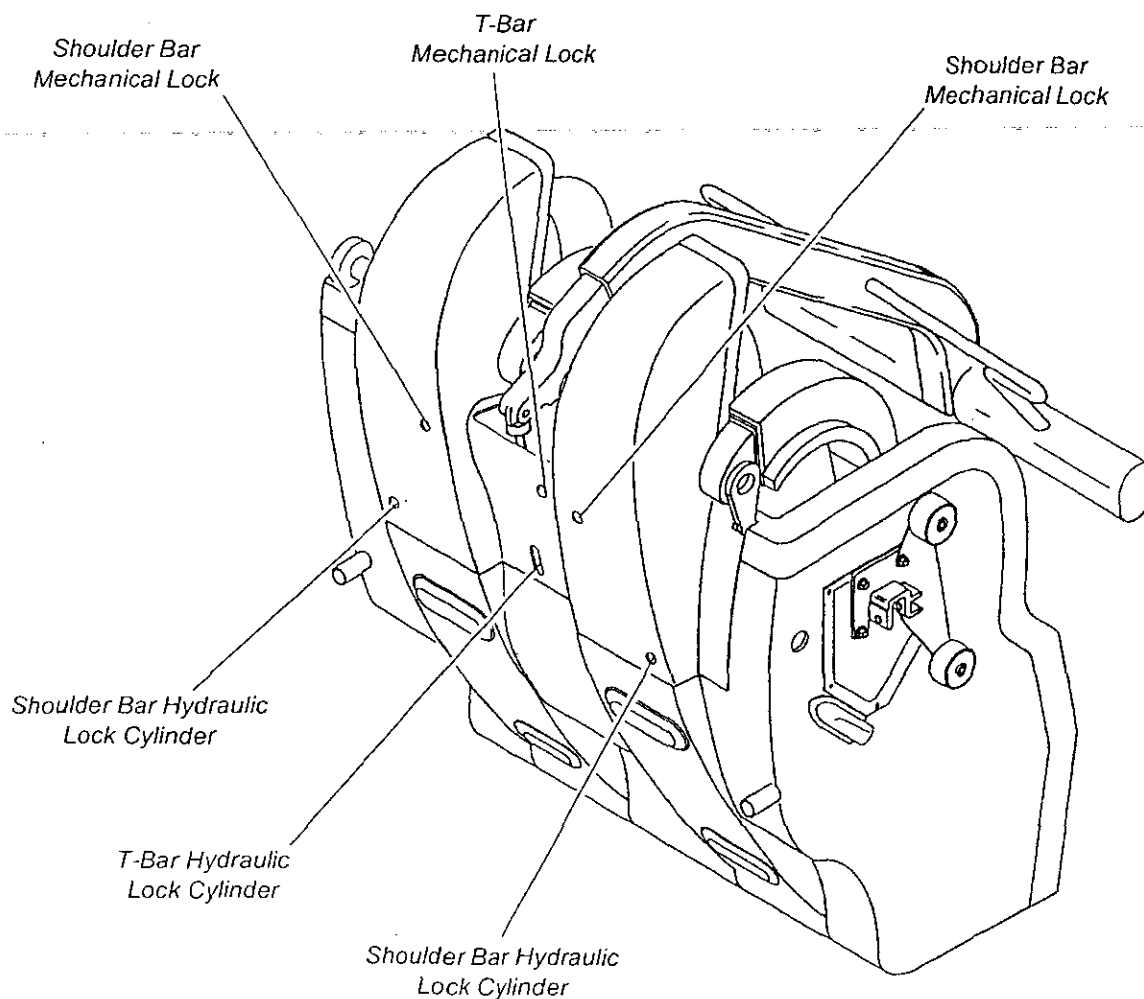
Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

### Access Holes for Manual Release of Restraint Bar Locking System





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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

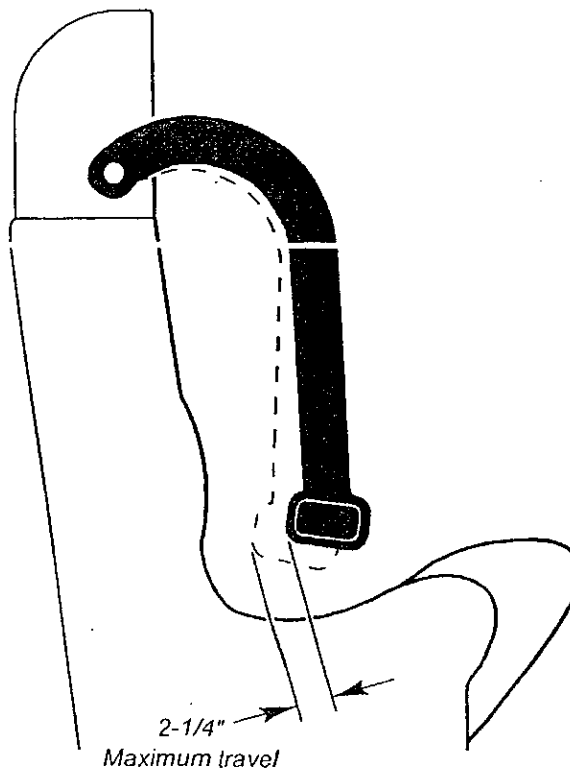
Model No.: 408

Detail of Issue (continued):

1. With the LAP BAR SWITCH on the operator's control console in the "Close" position, close both of the shoulder bars on one vehicle.
2. From the back of the vehicle, have the helper manually release the hydraulic lock cylinder for one shoulder bar (pull out the release plunger, or push the release button, depending upon which style release is on the hydraulic lock cylinder).
3. Try to open the shoulder bar. It must not open, because of the mechanical lock holding it.

- Check the distance the shoulder bar travels before the mechanical lock stops it. Travel must not exceed 2-1/4".
- If travel exceeds 2-1/4", repairs must be made before allowing passengers to ride in that vehicle.

**NOTE:** Excessive travel before the mechanical lock engages is usually the result of one or more of these conditions: wear or damage to the mechanical lock components, worn rod end bearings, worn restraint bar pivot bushings, or loose fasteners.





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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

4. Close the shoulder bar completely and have the helper manually release the mechanical lock for the same shoulder bar.
5. Try to open the shoulder bar again. It must not open, because of the hydraulic lock cylinder holding it.

- Check the distance the shoulder bar travels before the hydraulic lock cylinder stops it. TRAVEL MUST BE LESS THAN THE TRAVEL ALLOWED BY THE MECHANICAL LOCK IN THE PREVIOUS STEP. (EXAMPLE: If the mechanical lock allows the shoulder bar to travel 1-3/4", the hydraulic lock cylinder for that same shoulder bar must limit its travel to less than 1-3/4". This ensures that the shoulder bar is locked by the hydraulic lock cylinder first.
- If travel exceeds this amount, replacement of the hydraulic lock cylinder is required before allowing passengers to ride in that vehicle.

**IMPORTANT:** Record all measurements on the form provided the first time this inspection is performed. Keep this data for comparison to subsequent inspections. **The measurements must be recorded again at annual intervals.**

6. Repeat steps 2 through 5 for the other shoulder bar on that vehicle.
7. Close the T-bar on the same vehicle.

**IMPORTANT:** The T-bar has gas springs to assist in opening it. Be prepared for the T-bar to raise without assistance when the locking system is manually released in the following steps.

8. Have the helper manually release the hydraulic lock cylinder for the T-bar.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

*Detail of Issue (continued):*

9. Try to open the T-bar. It must not open, because of the mechanical lock holding it.

- Check the distance the T-bar travels before the mechanical lock stops it. Travel must not exceed 2-1/4".
- If travel exceeds 2-1/4", repairs must be made before allowing passengers to ride in that vehicle.

10. Close the T-bar and have the helper manually release the center mechanical lock by pulling up on the release lever.

11. Try to open the T-bar again. It must not open, because of the hydraulic lock cylinder holding it.

- Check the distance the T-bar travels before the hydraulic lock cylinder stops it. THERE MUST BE ALMOST ZERO TRAVEL.
- If the travel exceeds this amount, replacement of the hydraulic lock cylinder is required before allowing passengers to ride in that vehicle.

**IMPORTANT:** Excessive travel of the T-bar must prevent the ride from operating. If the ride will start and run when the T-bar is not completely down, adjustment of the T-bar limit switch is required. When performing the "Passenger Restraint and Interlock System Operation Check" (described in detail in the CHAOS Service Manual), raise the T-bars only slightly from the full-down position to test the interlock system.

12. Repeat the entire process on all vehicles so that every shoulder bar and T-bar has been checked.

#### **ANNUAL Inspection of Restraint Bar Locking System**

Perform the "WEEKLY Operational Check of Restraint Bar Locking System" procedure described in this bulletin. Record the measurements and compare to previous measurements. Increasing travel distances are an advance sign of component wear. Replace components as required, or have them on hand to minimize potential downtime during the busiest times of the operating season.

# CHAOS Restraint Bar Lock Inspection

(Rides Equipped with Hydraulic Lock Cylinders)

Ride Serial Number	Person Performing Inspection	Date
--------------------	------------------------------	------

Vehicle Number	Travel Before Lock Engages					
	<i>IMPORTANT: "B" Dimension must be less than "A" for any specific shoulder bar</i>				T-Bar (Center)	
	Shoulder Bar (Left Hand)		Shoulder Bar (Right Hand)			
	"A" Mechanical Lock (Maximum 2-1/4")	"B" Hydraulic Lock	"A" Mechanical Lock (Maximum 2-1/4")	"B" Hydraulic Lock	Mechanical Lock (Maximum 2-1/4")	Hydraulic Lock (No travel allowed)
1						
2						
3						
4						
5						
6						
7						
8						
9						
10						
11						
12						
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14						
15						
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17						
18						



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# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Abstract of Issue:

*Passenger Restraint Bar Locking System Inspection and Operational Check*  
(Rides Retrofitted With Ratchet Lock Kit Only)

Reason For Release:

The passenger restraint system on the above noted CHAOS amusement rides incorporates one of the following restraint bar locking systems

- Three hydraulic lock cylinders on each vehicle - one for each primary restraint bar (shoulder bar) and one for the secondary restraint bar (T-bar). For the "Inspection and Operational Check Procedure" on these rides, refer to Service Bulletin B408CRM138-0.

-- or --

- Three ratchet locks on each vehicle - one for each shoulder bar and one for the T-bar (ratchet locks can be retrofitted to replace the hydraulic lock cylinders at the owner's option). This bulletin applies to only these rides.

With either system, a redundant mechanical lock is provided for each restraint bar. In the event that the hydraulic lock cylinder or ratchet lock fails, the mechanical lock will prevent the restraint bar from opening.

Chance Rides Manufacturing, Inc. has become aware that some owner/operators are not maintaining and inspecting the restraint bar locking system as specified in the *CHAOS Service Manual*. If the locking mechanisms on any restraint bar do not operate correctly, multiple component failures on a seat can result in injury to passengers.

This bulletin is being released to provide additional information on the correct procedures to check the operation of the restraint bar locking system.



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Page: 2 of 8

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

**Action to be Taken:**

All owners of the above noted CHAOS amusement rides are required to inspect the condition of the restraint bar locking system and check its operation as described in the *CHAOS Service Manual* and this service bulletin.

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.

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Page: 3 of 8

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue

### Inspection and Testing of Restraint Bar Locking System

The passenger restraint system on each vehicle incorporates a locking system for each shoulder bar and T-bar. All components must be in good working condition to ensure the safety of the passengers.

The following pages provide instructions for weekly testing of the restraint bar locking system.

This procedure requires two people. The vehicle back panel must be removed to gain access to the locking system components.

**IMPORTANT:** This procedure does not replace any inspections described in the CHAOS Service Manual. It is to be used in addition to all previously published inspections.

Always check both shoulder bars and the T-bar on every vehicle using the procedures provided in this bulletin and in the CHAOS Service Manual.

**NOTE:** The procedure described in this bulletin applies only to rides retrofitted with the ratchet lock kit. If the ride still has hydraulic lock cylinders, refer to Service Bulletin B408CRM138-0.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

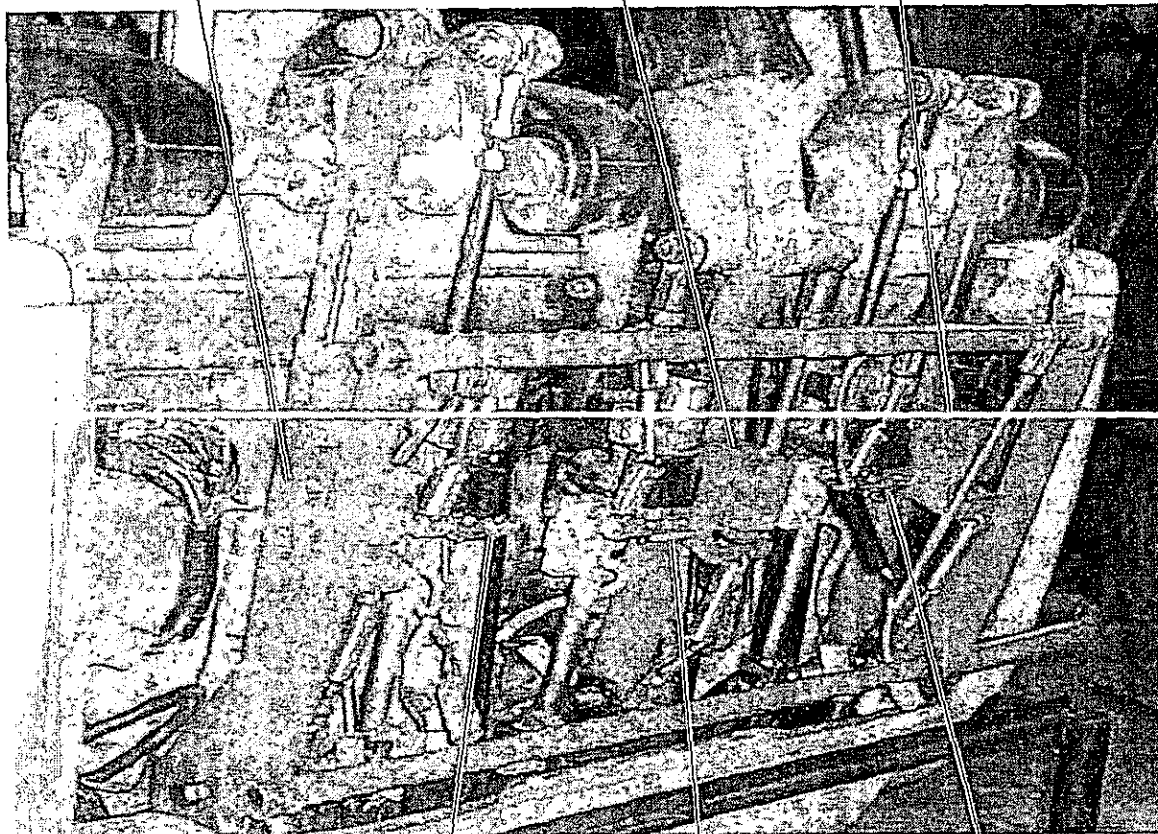
Detail of Issue (continued):

### Restraint Bar Locking System on Rides With RATCHET LOCKS

Lap Bar Ratchet Lock

T-Bar Ratchet Lock

Lap Bar Ratchet Lock



Lap Bar  
Mechanical Lock

T-Bar  
Mechanical Lock

Lap Bar  
Mechanical Lock



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Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

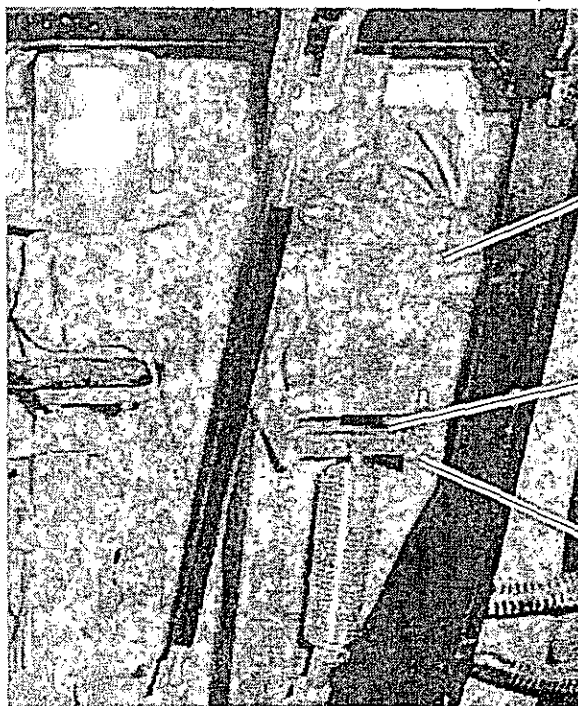
Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

1. With the LAP BAR SWITCH on the operator's control console in the "Close" position, close both of the shoulder bars on one vehicle.
2. From the back of the vehicle, have the helper manually release the ratchet lock for one shoulder bar, using a screwdriver as shown.

**Manually Releasing the Ratchet Locks**  
(Typical for Lap Bar or T-Bar Ratchet Lock)



Ratchet lock housing

Insert screwdriver here,  
between ratchet lock housing  
and release arm. Pry down-  
ward to release the ratchet lock

Release arm



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Bulletin No: B408CRM148-0

Release Date: October 12, 2006

Effective Date: October 12, 2006

Supersedes: N/A

Completion Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

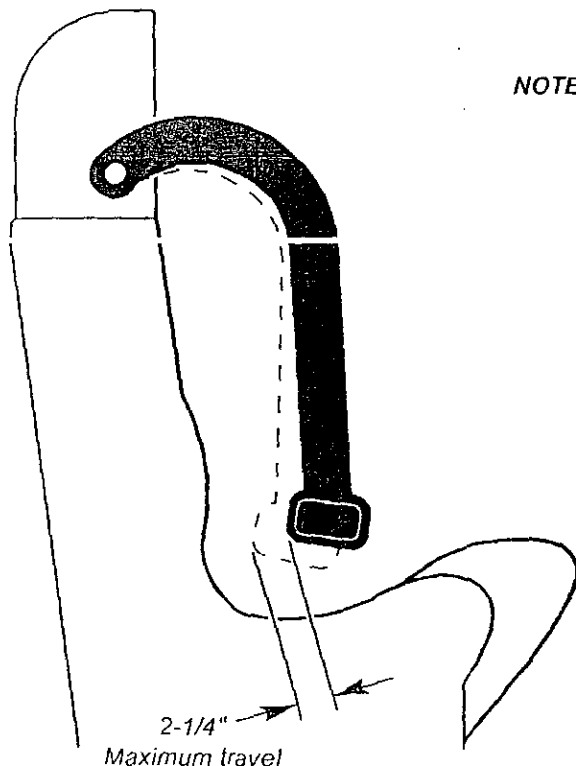
Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

3. Try to open the shoulder bar. It must not open, because of the mechanical lock holding it.

- Check the distance the shoulder bar travels before the mechanical lock stops it. Travel must not exceed 2-1/4".
- If travel exceeds 2-1/4", repairs must be made before allowing passengers to ride in that vehicle.



**NOTE:** Excessive travel before the mechanical lock engages is usually the result of one or more of these conditions: wear or damage to the mechanical lock components, worn rod end bearings, worn restraint bar pivot bushings, or loose fasteners.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

4. Close the shoulder bar completely and have the helper manually release the mechanical lock for the same shoulder bar.

5. Try to open the shoulder bar again. It must not open, because of the ratchet lock holding it.

- Check the distance the shoulder bar travels before the ratchet lock stops it. TRAVEL MUST BE LESS THAN THE TRAVEL ALLOWED BY THE MECHANICAL LOCK IN THE PREVIOUS STEP. (EXAMPLE: If the mechanical lock allows the shoulder bar to travel 1-3/4", the ratchet lock for that same shoulder bar must limit its travel to less than 1-3/4". This ensures that the shoulder bar is locked by the ratchet lock first.

- If travel exceeds this amount, repair or replacement of the ratchet lock is required before allowing passengers to ride in that vehicle.

**IMPORTANT:** Record all measurements on the form provided the first time this inspection is performed. Keep this data for comparison to subsequent inspections. The measurements must be recorded again at annual intervals.

6. Repeat steps 2 through 5 for the other shoulder bar on that vehicle.

7. Close the T-bar on the same vehicle.

**IMPORTANT:** The T-bar has gas springs to assist in opening it. Be prepared for the T-bar to raise without assistance when the locking system is manually released in the following steps.

8. Have the helper manually release the ratchet lock for the T-bar.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 and  
408-02097 and on

Model No.: 408

Detail of Issue (continued):

9. Try to open the T-bar. It must not open, because of the mechanical lock holding it.

- Check the distance the T-bar travels before the mechanical lock stops it. Travel must not exceed 2-1/4".
- If travel exceeds 2-1/4", repairs must be made before allowing passengers to ride in that vehicle.

10. Close the T-bar and have the helper manually release the center mechanical lock by pulling up on the release lever.

11. Try to open the T-bar again. It must not open, because of the ratchet lock holding it.

- Check the distance the T-bar travels before the ratchet lock stops it. TRAVEL MUST BE LESS THAN THE TRAVEL ALLOWED BY THE MECHANICAL LOCK IN THE PREVIOUS STEP. (EXAMPLE: If the mechanical lock allows the shoulder bar to travel 1-3/4", the ratchet lock for that same T-bar must limit its travel to less than 1-3/4". This ensures that the T-bar is locked by the ratchet lock first.
- If the travel exceeds this amount, repair or replacement of the ratchet lock is required before allowing passengers to ride in that vehicle.

**IMPORTANT:** Excessive travel of the T-bar must prevent the ride from operating. If the ride will start and run when the T-bar is not completely down, adjustment of the T-bar limit switch is required. When performing the "Passenger Restraint and Interlock System Operation Check" (described in detail in the CHAOS Service Manual), raise the T-bars only slightly from the full-down position to test the interlock system.

12. Repeat the entire process on all vehicles so that every shoulder bar and T-bar has been checked.

### ANNUAL Inspection of Restraint Bar Locking System

Perform the "WEEKLY Operational Check of Restraint Bar Locking System" procedure described in this bulletin. Record the measurements and compare to previous measurements. Increasing travel distances are an advance sign of component wear. Replace components as required, or have them on hand to minimize potential downtime during the busiest times of the operating season.

## CHAOS Restraint Bar Lock Inspection (Rides Retrofitted with Ratchet Locks)

Ride Serial Number	Person Performing Inspection	Date
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Vehicle Number	Travel Before Lock Engages					
	<i>IMPORTANT: "B" Dimension must be less than "A" for any specific shoulder bar or T-bar</i>					
	Shoulder Bar (Left Hand)		Shoulder Bar (Right Hand)		T-Bar (Center)	
	"A" Mechanical Lock (Maximum 2-1/4")	"B" Ratchet Lock	"A" Mechanical Lock (Maximum 2-1/4")	"B" Ratchet Lock	"A" Mechanical Lock (Maximum 2-1/4")	"B" Ratchet Lock
1						
2						
3						
4						
5						
6						
7						
8						
9						
10						
11						
12						
13						
14						
15						
16						
17						
18						