



NUMBER: B391R1144-0

DATE: JAN. 7, 1994

SUPERSEDES:

SERVICE BULLETIN

Effective Serial Number: All Units

Ride: FALLING STAR

Subject: Drive Sprocket/NDT

Chance Rides, Inc. has become aware that cracks can develop in the large chain drive sprocket on the FALLING STAR amusement ride. The cracks have appeared on the back side of the sprocket in the radius where the horizontal part of the sprocket is welded to the vertical part of the sprocket.

All owner/operators of the above noted rides are required to test the drive sprocket annually as described in this bulletin. All work must be performed by Level II or III persons who are certified in magnetic particle inspection. Testing can be done through the side inspection port without removing the chain case. Inspect a small portion at a time, rotating the ride after each inspection, until the entire circumference of the sprocket has been inspected.

The following magnetic particle inspection technique meets the requirements of ASTM E709.

1. PRE-CLEAN:
 - * Clean the weld radius area of the drive sprocket as shown in the illustrations in this bulletin to remove oils and other contaminants.
2. MAGNETIZATION PROCESS:
 - * Using an A.C. yoke with articulating legs, position yoke over weld so flux field is 90° to weld as shown in illustration.
 - * Use continuous method for applying particles and current.
3. INSPECTION:
 - * Thoroughly inspect all weld areas for linear indications.
 - * If any linear indications are found, **do not operate the ride**, contact the Chance Rides, Inc. Customer Service Department.
 - * Fill out test report with results and send a copy to Chance Rides, Inc.
4. POST-CLEAN:
 - * Remove magnetic particles from weld area.

REMOVE THIS COVER TO
PERFORM THE INSPECTION
SPECIFIED IN THIS BULLETIN



