



CHANCE RIDES, INC.
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Bulletin No:	P414R1254-0
Release Date:	June 15, 2001
Effective Date:	June 15, 2001
Supersedes:	B414R1224-0
Completion Date:	N/A
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NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: Prior to May, 2001

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

Model No.: 414

Abstract of Issue:
Leveling Strut Kit

Reason For Release:

If the leveling brace and turnbuckle are not installed properly during set-up and tear-down of the INVERTER amusement ride, serious structural damage can occur when the counterweight arm is swung into its operating position. The correct use of the leveling brace and turnbuckle are described in detail in the *INVERTER Service Manual*.

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

This notification describes an improved leveling strut used in the set-up and tear-down of the ride. It can be ordered and installed at the owner/operator's option. If the owner/operator chooses to make this improvement, this notification and the procedures described herein supersede Chance Rides service bulletin B414R1224-0 (Set-Up and Tear-Down Procedure, September 6, 1999). If this option is not chosen, service bulletin B414R1224-0 remains in effect.

Chance Rides, Inc. strongly recommends that this improvement be made to all of the above noted INVERTER amusement rides.

Detail of Issue:

A kit has been developed which includes a leveling strut, to be used instead of the existing turnbuckle during set-up and tear-down. The benefits of the kit are additional strength in leveling strut and its attaching lugs, plus the new leveling strut is easier to install and use correctly at every set-up and tear-down. This improvement is not to be considered an alternative to the correct set-up and tear-down procedures.



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Action to be taken

Order the Leveling Strut Kit, part number K414R1254-0, which includes all necessary parts to rework one complete ride. Installation instructions are included with the kit. The kit will be offered at a reduced price for 60 days after the release date of this notification.

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

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

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

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



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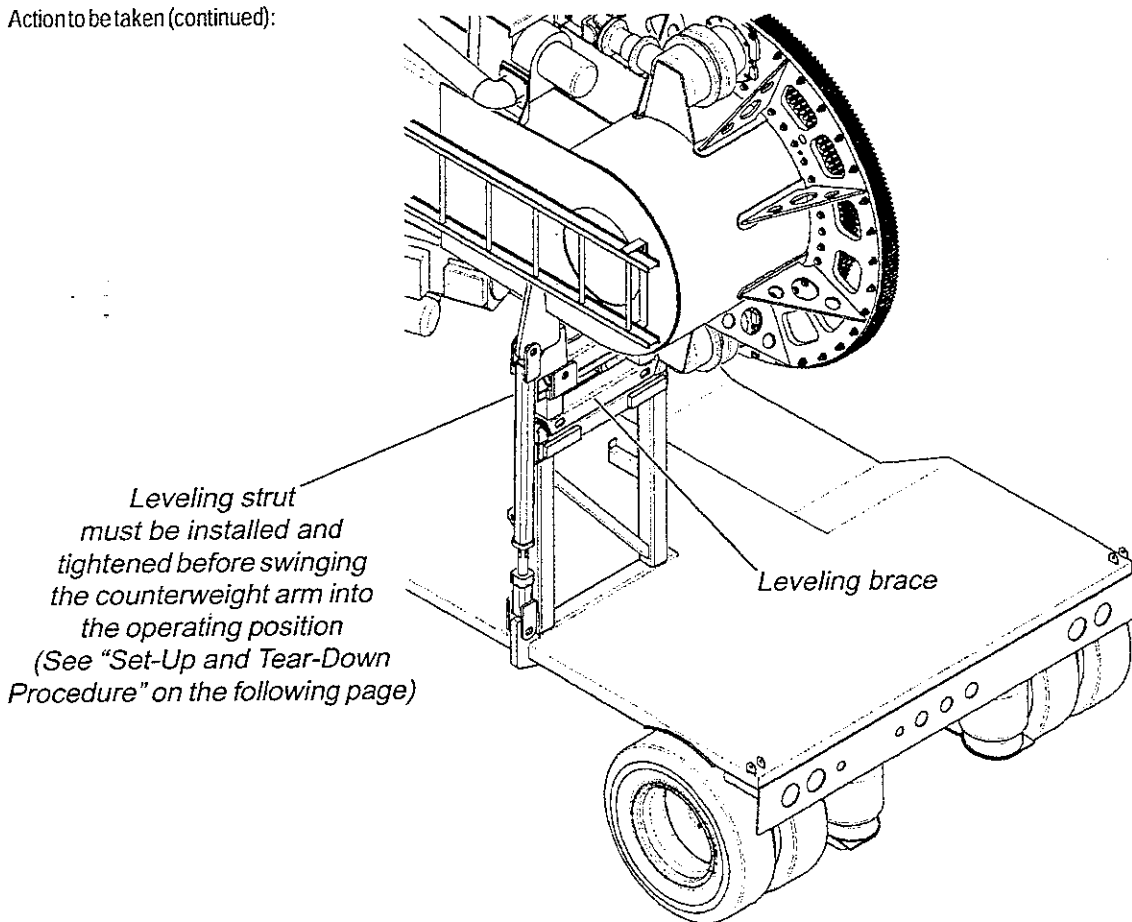
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Action to be taken (continued):



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.



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Action to be taken (continued):

Set-Up and Tear-Down Procedure

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

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

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

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

NOTE: To help insure the safety of the set-up/tear-down personnel, Chance Rides, Inc. has developed two decals which, along with the instructions in the *Set-Up Manual*, will alert personnel to specific steps in the procedure.

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



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Action to be taken (continued):

WARNING

DURING SET-UP –

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

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

FOR COMPLETE INSTRUCTIONS, SEE THE SET-UP MANUAL

LEVELING
STRUT

TOWER
LEVELING
BRACE

414-0010-047

WARNING

DURING TEAR-DOWN –

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

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

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

FOR COMPLETE INSTRUCTIONS, SEE THE SET-UP MANUAL

LEVELING
STRUT

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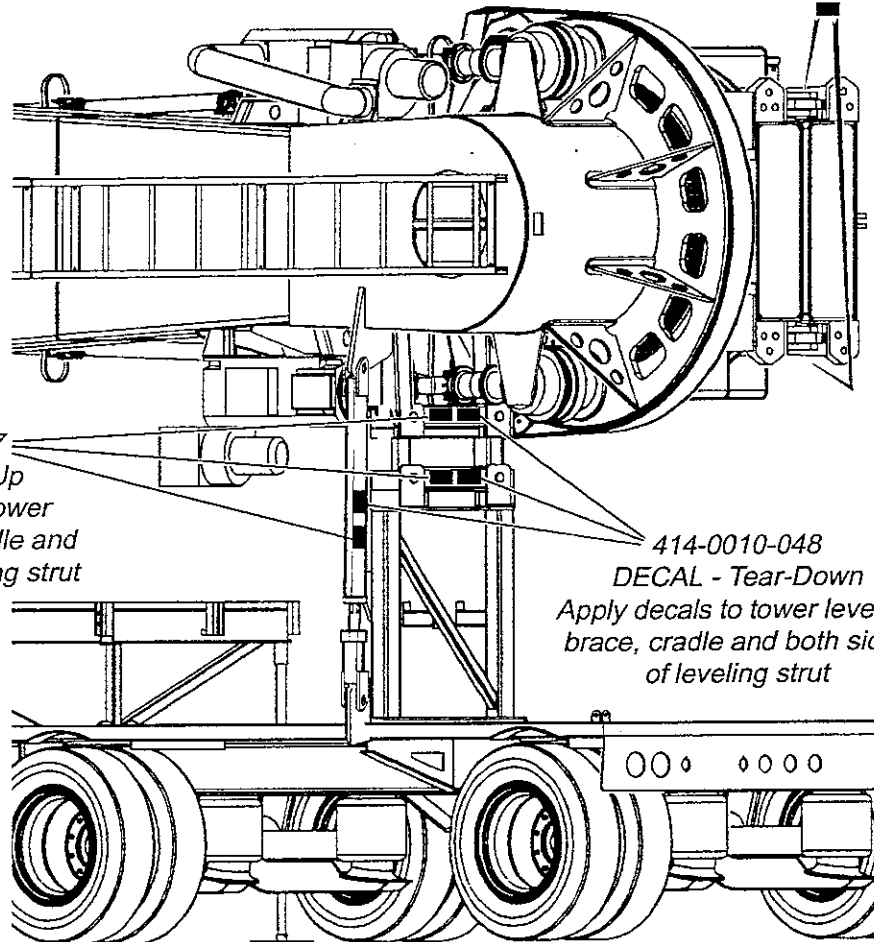
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Action to be taken (continued):

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



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

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



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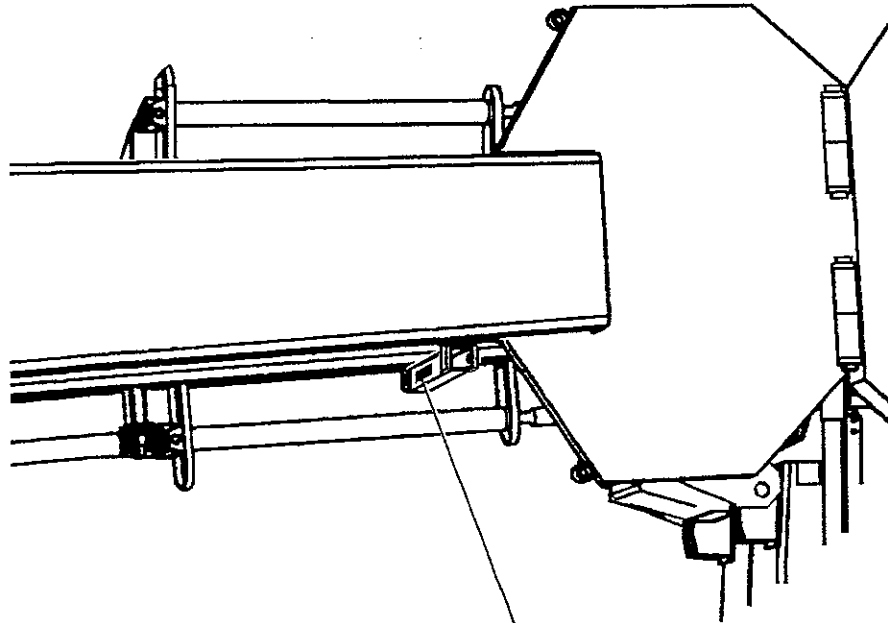
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Action to be taken (continued):



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