

Chance Service Bulletins for Inverter Overview

9/23/02

B414CRM105-0

Inspection of Secondary Restraint Bar (T-Bar) Locking Mechanism

Supersedes B414R1211-0

- Inspect hydraulic lock cylinder for primary restraint bar for each (24) seat.
- Identify if cylinder is the correct type, red plunger or black plunger with E on cylinder
- Check manual release on passenger restraints
- Visual Inspect Monthly
 - o Every lock cylinder for oil leakage
 - o For signs of external damage, including the spherical bearings in the rod end
 - o Activate the rod and check for smooth extension and compression
 - o Piston rod for damage
 - o Accumulator hose and fittings for leaks
 - o Solenoid valve for damage
 - o Accumulator clamp nuts are tight
- storage in off-season
 - o cover breather holes, against water
 - o close lap bars
 - o extend cylinder if not on ride

9/23/02

B414CRM103-0

Mandatory Tower Hinge Bracket and Leveling Strut Rework

Portable Models

Serial # Prior to No. 414-03201

Supersedes B414R1224-0, B414R1223-0, P414R1253-0 and P414R1254-0

- Replace old tower hinge with Reworked tower hinge kit# K414R1253-0
- Replace old Leveling strut with kit# K414R1254-0

9/23/02

B414CRM102-0

Inspection, Replacement and Operation of Hydraulic Lock Cylinders

Portable Models

Park Models

Double Inverter

- Secondary Restraint Bar locking mechanism inspection
 - o Visually – Immediately / Annually
 - Ratchet bar teeth for chips, wear and damage
 - Locking pawl for chips, wear or damage and alignment with bar
 - Springs for damage, alignment and operation
 - o Visually – Weekly
 - Locking bars and pawls teeth and alignment
 - Springs; broken, loose and alignment
 - Pins and fasteners; condition and installation
 - Mounting lugs and clevises for damage and installation
 - Air pressure setting for ratchet locks
 - o Visually – Daily
 - Secondary restraint bars for loose, damaged or missing parts
 - Test secondary restraint bars
 - Reference B414R1225-0 10/25/99

- Install kit# K414R1225-0
- Passenger Restraint Bar Interlock System Check

2/12/02

B414R1269-0

Vehicle Frame Inspection and Rework

Portable Models Only

Serial #s 414-00199 to 414-03401

- Cut sections of the seats and Aluminum under seats for a clear view of areas
- Inspect the vehicle frame monthly until the kit# K414R1266-1 is installed. Install the kit before the ride becomes 4yrs old, but only if inspection finds no indications of cracks.
- Monthly inspection
 - o Welded joints in the center section
 - o Cutouts in the channels of all six seats
 - o Welds between channel and the horizontal frame

9/17/01

B414R1263-0

DC Motor Inspection and Maintenance

Portable Models

Park Models

Double

- Weekly check filters for damage and dirt accumulation
- Twice a season check Brush Holders and Carbon Brushes
 - o Replace if worn or damaged
- Annually clean and check the commutator for damage or wear.

8/20/01

B414R1262-0

Counterweight Arm Fastener Inspection

Portable Model

- Possible replacement parts listed for that counterweight arm fasteners.
 - o These replacement fasteners would alleviate the need to use a torque wrench every morning during inspection.

6/15/01

B414R1252-0

Slewing Ring and Drive Gear Lubrication and Inspection

Portable Model

- Instructions on how to modify the gear guard

6/15/01

P414R1258-0

Slewing Ring and Drive Gear Drip Tray

Portable Model

- Drip Tray Installation Instructions, OPTIONAL INSTALLATION

6/15/01

P414R1254-0

Leveling Strut Kit

Portable Model

Superseded by B414CRM103-0 9/23/02

6/15/01 P414R1248-0

Main Drive Gearbox Kit

Portable Model

- OPTIONAL kit, No. K414R1248-0, for reworking gearbox to eliminate pinion gear misalignment.

6/15/01 P414R1223-0

Tower hinge Bracket Kit

Portable Models

Serial #s Prior to 414-03201

Superseded by B414CRM103-0 9/23/02

11/15/00 P414R1247-0

Vehicle Step Lift Arm

Portable Model

Park Model

Double

- OPTIONAL replacement of step arm

9/19/00 B414R1246-0

Main Arm Inspection

Portable Model

- Visually inspect all four corners of the main arm

9/6/00 B414R1244-0

Hair Guard Rework

Portable Model

Park Model

Double

- Order and install kit No. K414R1244-0

8/31/02 B414R1245-A

Main Drive Inspection – Daily Weekly Inspection Points

Portable Model

- Daily Inspection
 - o Check backlash on main drive shaft and main drive pinion, 30deg Max
 - o Observe movement by drive pinions in relation to main drive gear. No lateral movement should be observed during rotation.
 - o Check gearboxes for oil leaks or excessive noise.
- Weekly Inspection
 - o Teeth on main drive shaft, look for broked, chipped or cracked gear teeth

8/29/00 A414R1245-0

Main Drive Inspection

Portable Model

Superseded by B414R1245-A 8/31/00

8/1/00

B414R1236-0

Vehicle Casters

Portable Model

- Replace caster assembly with Chance parts numbered (quantity); 414-0914A-002 (4), 414-0926-003 (4), CSN10A03-09 (4) and 65190000 (4).

8/1/00

B414R1237-0

Vehicle Tie Down Rods

Portable Models

414-00198 to 414-00399 and 414-00599 to 414-01899

- Replace Tie down rods by 9/1/00, the part numbers are 414-0955-001, 414-0955-002 and 414-0955005

6/16/00

B414R1242-0

Main Arm Drive Shaft inspection (inside tower)

Park Model

Double

Serial #s 414-005S99, 414-008S00, 414 011S00, DBLINV-414-00999 and DBLINV-414-01000

- Monthly Inspection of gearbox to drive shaft connection
 - o If misaligned, remove drive shaft and yoke, inspect all components, replace bolt, apply Loctite to shaft and threads, and reinstall components

4/12/00

B414R1239-0

Slewing Ring and Drive Gear Lubrication

Portable Model

Park Model

Double

- Lube the parts mentioned in the maintenance manual and the main slewing ring and vehicle slewing ring DAILY.

3/3/00

P414R1235-0

Drive Motor Covers

Portable Model

- OPTIONAL, drive motor cover to reduce moisture, part numbers 414-0728-002 and 66429900

10/25/99

B414R1225-0

Vehicle Air System Rework

Portable Model

Park Model

Double

Serial #s Prior to 414-02399 (portable), prior to 414-008P99 (park) or prior to 414-008P99(double)

- Kit #ed K414R1225-0 must be ordered and installed
- Daily Passenger Restraint Bar Interlock System Check

9/25/99

B414R1221-0

Counterweight Sign Frame Inspection and Rework

Portable Model

Park Model

Serial #s 414-00399 to 414-01499 and 414-005P99

- inspect and replace sign frame with appropriate kit
- Inspection must be performed before rework

8/18/99

B414R1211-0

Inspection, Replacement and Operation of Hydraulic Lock Cylinders

Inverter

Superseded by B414CRM105-0 on 9/23/02

8/6/99

B414R1224-0

Set-up and Tear-Down procedure

Portable Model

Superseded by P414R1254-0 on 6/15/01

7/30/99

B414R1215-0

Inspection and Replacement of Secondary Restraint Bar (T-Bar) Closeout Panels

Portable Model

Park Model

Double

- Inspection and replacement of all secondary restraint bar closeout panels (16 per ride) with panel with raised area over release button/plunger

7/30/99

B414R1220-0

Vehicle Software Changes

Portable Model

Park Model

Double

- Installation of new software PLC

7/9/99

B414R1223-0

Tower Hinge Bracket Inspection and Rework

Portable model

Superseded by P414R1253-0 on 6/15/01

7/7/99

B414R1213-0

Inspection of Primary Restraint Bars

Inverter All

- Visually inspect yearly
 - o Ears on back of secondary restraint bars for cracks

6/30/99

B414R1218-0

Step Valve Cover

Portable Model

Park Model

Double

Install Step Valve Cover Kit No. K414R1218-0

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1218-0

Release Date: June 30, 1999

Effective Date: August 30, 1999

Supersedes: N/A

Completion Date: August 30, 1999

Page: 1 of 3

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:
Step Valve Cover

Reason For Release:

Chance Rides, Inc. has become aware that the step valve on the INVERTER amusement ride can be accidentally actuated by the operator or passengers as they are loaded and unloaded, causing the step to raise. Unexpected movement of the step can cause injury to persons in its path.

Action to be Taken:

Chance Rides, Inc. has developed a cover which requires deliberate action by the operator to actuate the step valve. All owner/operators of the above noted INVERTER amusement rides are required to install the Step Valve Cover Kit, part number K414R1218-0, using the instructions on the following page of this bulletin. The kit includes all parts necessary to rework one vehicle. For DOUBLE INVERTER rides, order two kits.

The parts will be provided at no charge if ordered within 30 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.

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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Wichita, KS 67277-2328

U.S.A.

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Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

INVERTER (Park Model)

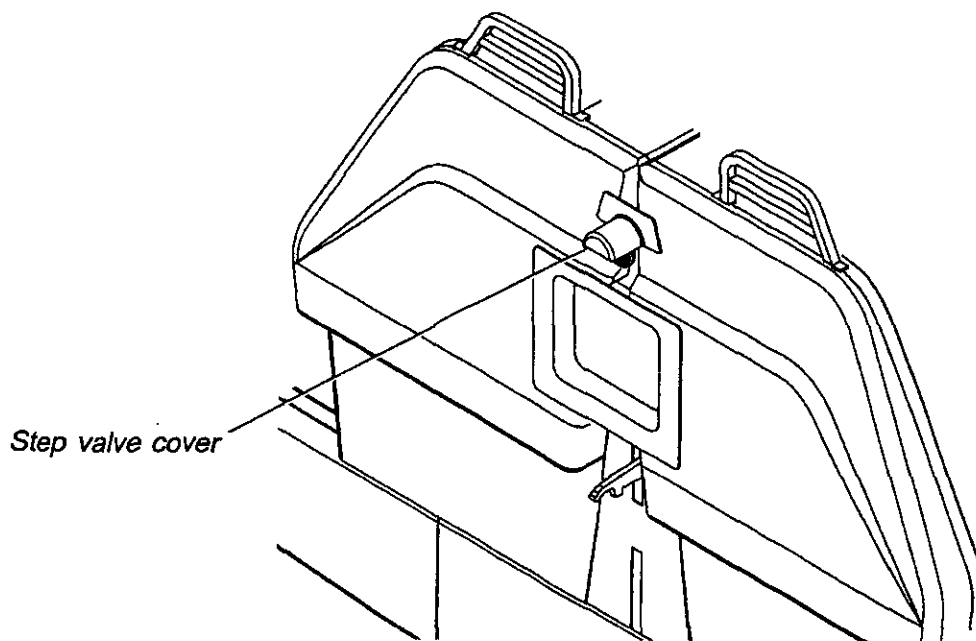
DOUBLE INVERTER

Model No.: 414

Detail of Issue (continued):

Kit number K414R1218-0 contains the following:

| <u>Part Number</u> | <u>Component</u> | <u>Quantity</u> |
|--------------------|-------------------------|-----------------|
| 414-0118-030 | COVER - STEP VALVE | 1 |
| 66149000 | RIVET - AD612BS (3/16") | 4 |

**Installation Instructions - Step Valve Cover**

1. Locate the cover so that it is centered over the step valve knob.
2. Drill through the cover and the fiberglass panels using a 3/16" drill. Maintain 3/8" margin on all edges.
3. Secure the cover to the vehicle using the four pop rivets provided.

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Wichita, KS 67277-2328

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Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

INVERTER (Park Model)

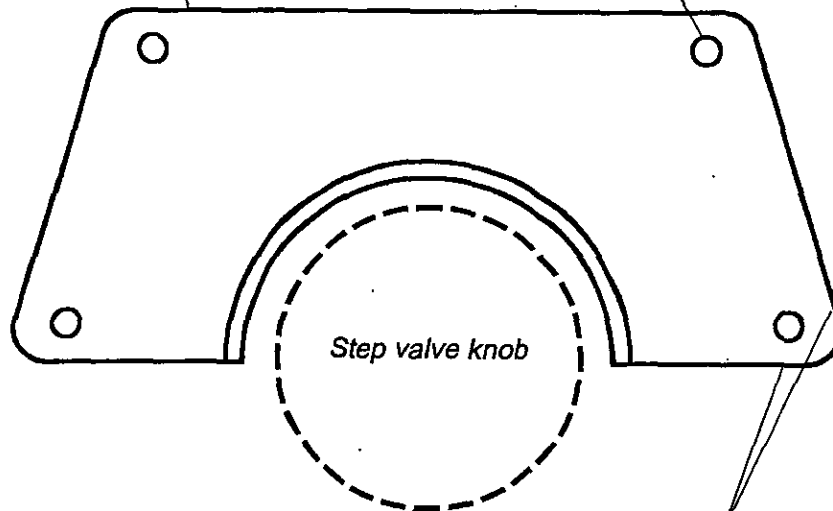
DOUBLE INVERTER

Model No.: 414

Detail of Issue (continued):

Center cover over
step valve knob

Drill 3/16" diameter
holes and install pop
rivets provided
(4 places)



Step valve knob

Locate holes centers to
maintain 3/8" margin on
all edges

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U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Page: 1 of 2

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All

Model No.: 414

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 INVERTER 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.

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Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All

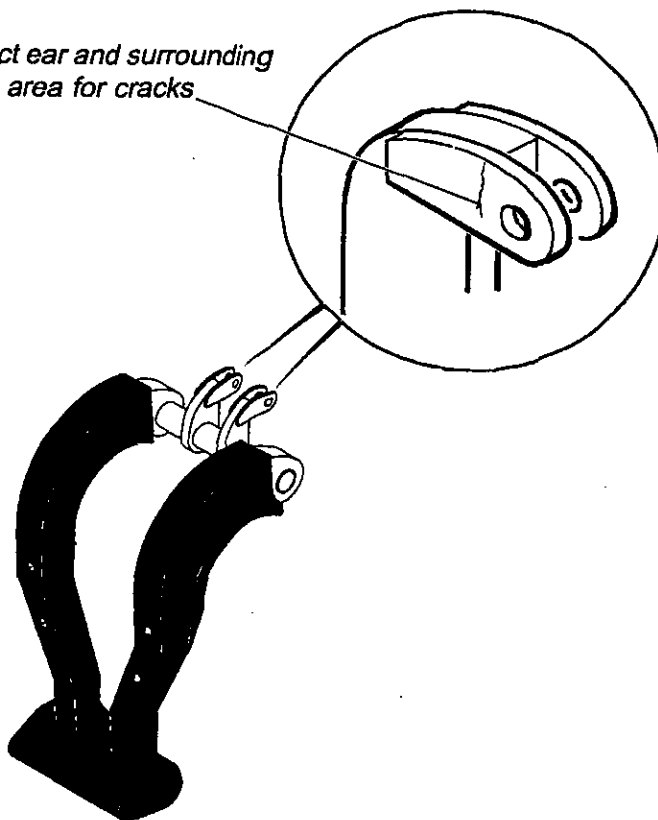
Model No.: 414

Detail of Issue (continued):

Annual Inspection Procedure

Visually inspect all primary restraint bars (24 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*



Superseded by P414R1253-0 6/15/01

then superseded by B414 CRM103-0 9/23/02



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U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

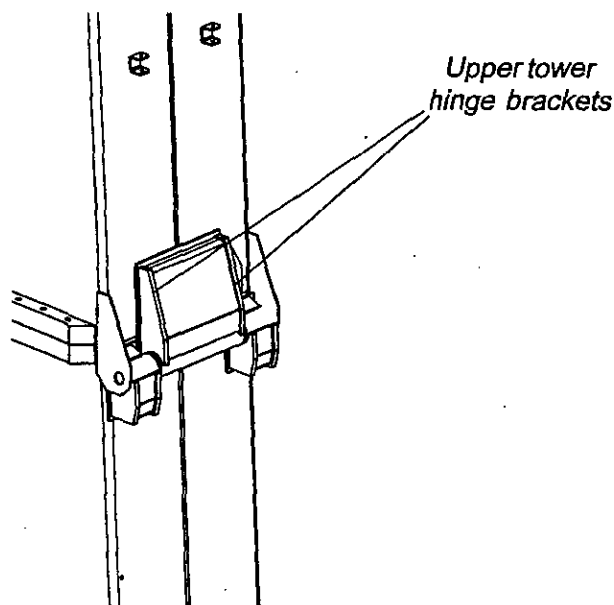
Model No.: 414

Abstract of Issue:

Tower Hinge Bracket Inspection and Rework

Reason For Release:

Chance Rides, Inc. has become aware that cracks can develop in the tower hinge area of the above noted INVERTER amusement rides. The areas where the cracks can occur are the welded joints for the upper tower hinge bracket. If these welds break, the tower can fall during the set-up or tear-down procedure, when the tower is being raised or lowered. This can possibly result in personal injury to set-up personnel and/or bystanders. A kit has been developed to reinforce the tower hinge brackets.



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U.S.A.

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Page: 2 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

Action to be taken (continued):

Chance Rides, Inc. requires all owner/operators to visually inspect and rework the upper tower hinge brackets as outlined in this bulletin.

If indications are found in the hinge brackets or surrounding area, contact the Chance Customer Service Department for specific repair instructions. **DO NOT ATTEMPT TO SET-UP OR TEAR-DOWN THE RIDE IF CRACKS ARE FOUND IN THE HINGE AREA.**

If no indications are found, order and install the Tower Hinge Bracket Rework Kit, number K414R1223-0. This kit includes all necessary parts to rework one complete ride, with complete instructions for installation. **DO NOT INSTALL THIS KIT IF THERE ARE CRACKS IN THE TOWER HINGE AREA UNTIL REPAIRS SPECIFIED BY THE MANUFACTURER ARE MADE.**

The kit will be offered at no charge if ordered within 30 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.

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U.S.A.

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E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

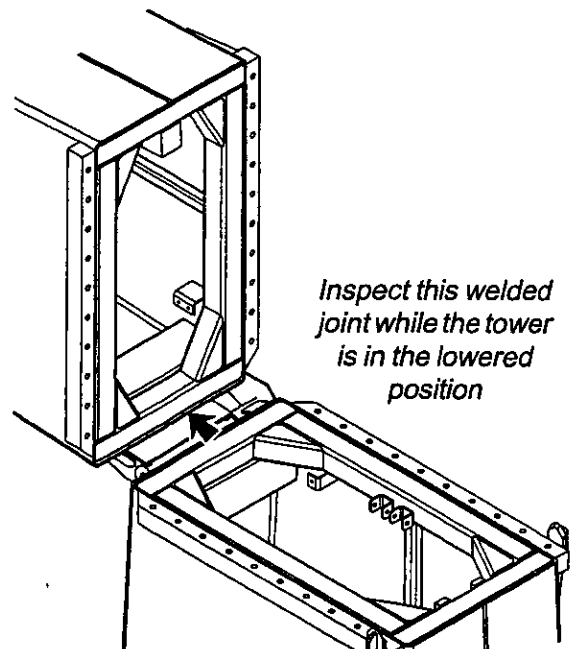
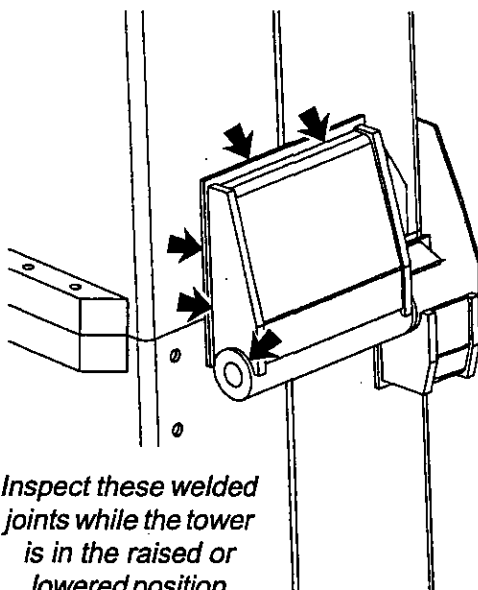
Model No.: 414

Action to be taken (continued):

Inspection Procedure - Tower Hinge Brackets Without Rework Kit K414R1223-0

Perform the following inspection before every set-up and tear-down until the rework kit has been installed.

1. Visually inspect the welds in the area where the tower hinge brackets attach to the tower as shown.
2. If cracks are found, contact the Chance Customer Service Department for specific repair instructions prior to installation of the rework kit. **DO NOT ATTEMPT TO SET-UP OR TEAR-DOWN THE RIDE IF CRACKS ARE FOUND IN THE HINGE AREA.**
3. If no cracks are found, order and install the Upper Tower Hinge Bracket Rework Kit (K414R1223-0) using the instructions provided with the kit.



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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

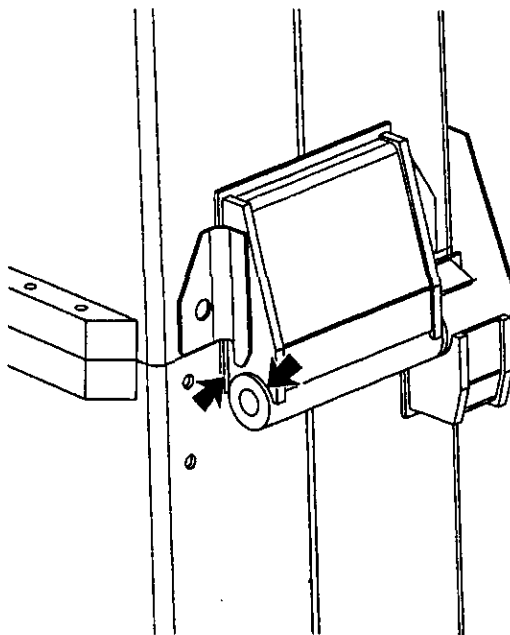
Model No.: 414

Action to be taken (continued):

Inspection Procedure - Tower Hinge Brackets With Rework Kit K414R1223-0 Installed

Perform the following inspection at every set-up

1. Visually inspect the welds in the tower hinge areas shown.
2. If cracks are found, contact the Chance Customer Service Department immediately. **DO NOT ATTEMPT TO SET-UP OR TEAR-DOWN THE RIDE IF CRACKS ARE FOUND IN THE HINGE AREA.**



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Website: www.rides.comE-mail: rides@rides.com

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

INVERTER (Park Model)

DOUBLE INVERTER

Model No.: 414

Abstract of Issue:

Inspection and Replacement of Secondary Restraint Bar (T-Bar) Closeout Panels

Reason For Release:

Chance Rides, Inc. has become aware that the manual release for the primary restraint bars (Shoulder-bars) can be actuated by another passengers's feet. A new T-bar closeout panel has been designed to prevent accidental actuation of the manual release.

Action to be Taken:

Chance Rides, Inc. requires all owner/operators of the above noted INVERTER amusement rides to inspect all T-bar closeout panels and, if required, replace with the new design panels. Refer to the illustration on the following page of this bulletin.

The parts will be provided at no charge if ordered within 30 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.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

INVERTER (Park Model)

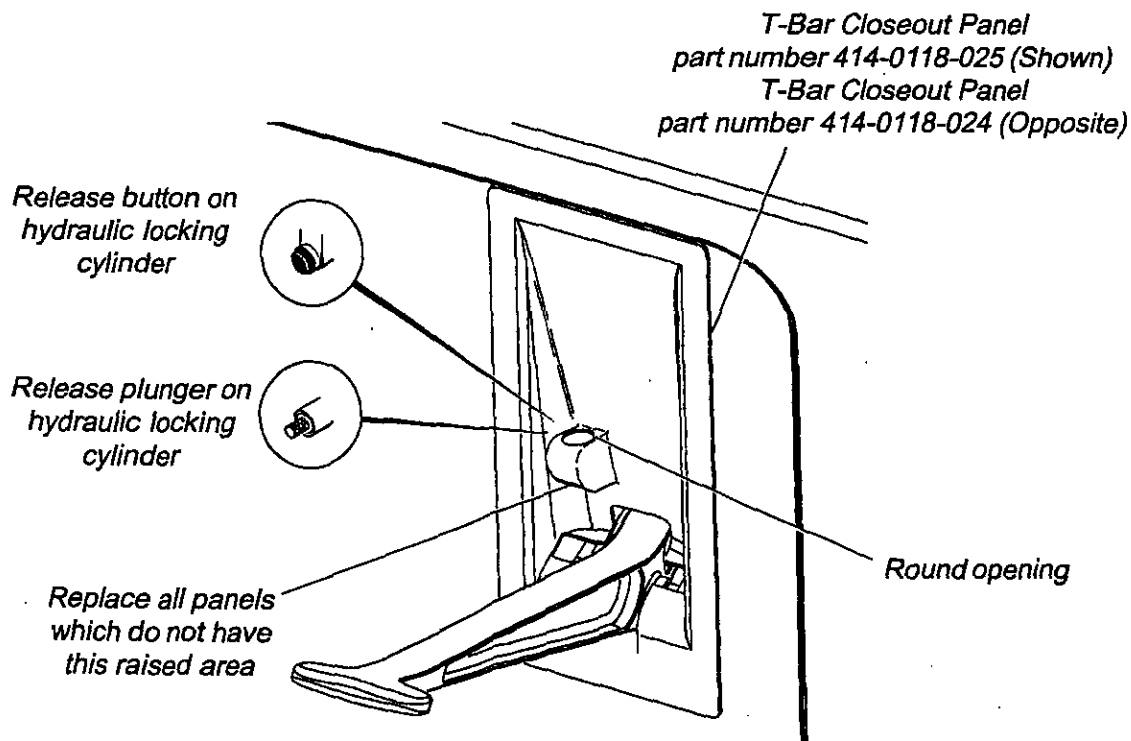
DOUBLE INVERTER

Model No.: 414

Detail of Issue (continued):

Inspect all T-bar closeout panels (8 right hand panels and 8 left hand panels) for raised area over manual release on hydraulic locking cylinder. Replace all panels which do not have this raised area.

NOTE: For hydraulic locking cylinders with release plunger, the closeout panel must have openings in both the top and bottom of the raised area. Replace the panels with the parts shown below as required, or rework by cutting a 1-1/8" diameter hole in the bottom of the raised area.



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U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1220-0

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Completion Date: August 30, 1999

Page: 1 of 4

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

INVERTER (Park Model)

DOUBLE INVERTER

Model No.: 414

Abstract of Issue:

Vehicle Software Changes

Reason For Release:

Chance Rides, Inc. has become aware of necessary changes to the INVERTER vehicle software. The software has been amended. The new software, version 4, features these changes from the previous version:

- If a power failure occurs during a ride cycle, the jog feature can be used to move the vehicle to the loading/unloading station after power is restored. This eliminates the need to fully open all passenger restraints before allowing the READY LIGHT to turn on after turning the power back on.
- If the RESTRAINT ENABLE signal is lost while the vehicle is in the loading/unloading station, the T-bars will no longer lower automatically unless the shoulder bars are closed. If the shoulder bars are open, they will no longer lower automatically. (NOTE: The loss of the RESTRAINT ENABLE SIGNAL is often the result of a failed or out-of-adjustment arm home proximity switch, located at the top of the tower.)
- If a restraint failure occurs just prior to raising the step, the restraint bar indicator display will indicate which restraint bar is not down and locked, identifying it by row number and seat number, and allowing the fault to be acknowledged as described in the INVERTER Operation Manual.
- If a step fault occurs during the ride cycle, the ride cycle will be interrupted and the ride will come to a normal programmed stop, even if the cause of the fault clears itself during the ride cycle. The CAR READY signal is disabled until it is cleared by opening the step and moving the T-bar switch to "Open". (NOTE: The step fault is often the result of an out-of-adjustment step proximity switch, or a loose or damaged step.)

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

INVERTER (Park Model)

DOUBLE INVERTER

Model No.: 414

Action to be taken

Chance Rides, Inc. has developed an EEPROM programmed with the new software. All owner/operators of the above noted INVERTER amusement rides are required to replace any previous version (labeled INVCAR3) with the new EEPROM (labeled INVCAR4). Order the new EEPROM (part number 32516314) and install it using the instructions in this bulletin. For DOUBLE INVERTER rides, order two EEPROM's.

The cost of the new EEPROM will be credited to your account if the old EEPROM is returned within 30 days of the release date of this bulletin.

New operating procedures affected by the software change are also included 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.

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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1220-0

Release Date: July 30, 1999

Effective Date: July 30, 1999

Supersedes: N/A

Completion Date: August 30, 1999

Page: 3 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

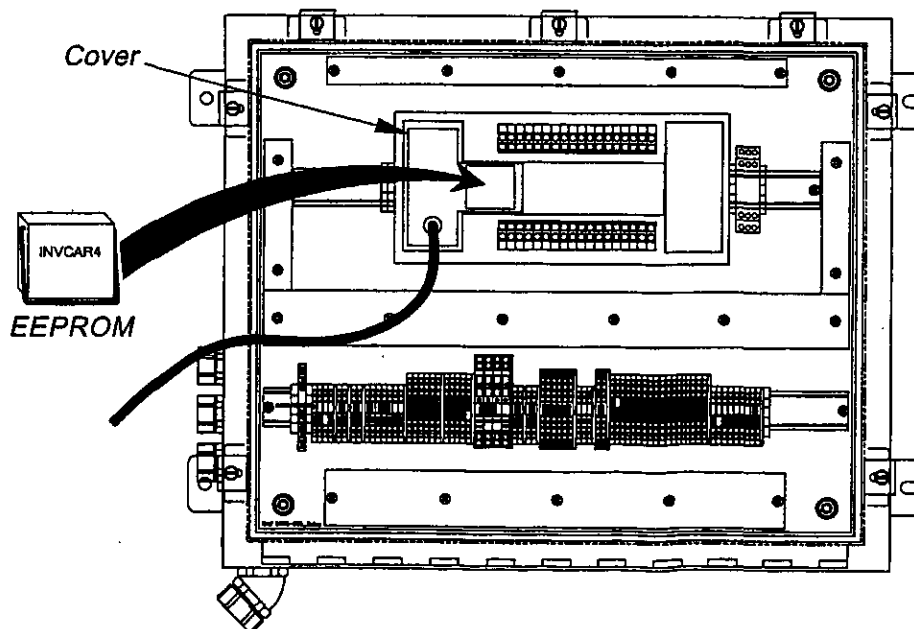
Affected Serial Nos.: All Units

Model No.: 414

Action to be taken (continued):

Installation Instructions - Vehicle Software

1. Turn off the power to the ride.
2. Open the control enclosure on the rear of the vehicle and locate the PLC. Remove the EEPROM cover from the PLC and remove the EEPROM by pulling up on the metal bail wire under the EEPROM.
3. Install the new EEPROM in reverse order of the above steps.



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Page: 4 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

INVERTER (Park Model)

DOUBLE INVERTER

Model No.: 414

Action to be taken (continued):**Operating instructions - Recovering from a power failure**

Use this procedure if a power failure has occurred during a ride cycle and the vehicle is stopped at any position other than the loading/unloading station. After power is restored, the vehicle can be driven to the loading/unloading station using the jog feature.

1. Turn the PANEL SWITCH to "Manual".
2. Push the DRIVES ON MANUAL push-button. The DRIVES ON light will illuminate.
3. Use the MANUAL RUN (JOG) SWITCH to immediately drive the vehicle down and past the loading/unloading station.

IMPORTANT: The vehicle must be driven past the "home" position (at the loading/unloading station) where a photo-eye senses the vehicle and resets the encoder count. If the MANUAL RUN (JOG) SWITCH is released before the vehicle reaches the home position, the drive program will try to drive the vehicle back up to the same position as when power was restored.

If the MANUAL RUN (JOG) SWITCH is not used within a few seconds of pushing the DRIVES ON MANUAL push-button, the drives will turn off. If this happens, push DRIVES ON MANUAL again.


4. Continue to use the MANUAL RUN (JOG) SWITCH to precisely position the vehicle at the unloading station.

If the jog feature is unavailable or otherwise cannot be used, a similar procedure can be performed using the START SWITCH in the automatic ("Auto") mode. Once the vehicle has passed the home position, press the STOP SWITCH or release the OPERATOR PRESENCE SWITCH to bring the vehicle to a normal, programmed stop at the loading/unloading station.

NOTE: In the "Auto" mode, the vehicle will swing back and forth several times before it goes past the "home" position.

Superseded by P414 R12545-0 6/15/01

then superseded by B414 CRM103-0 9/23/02

| | | |
|---|--|--------------------------|
|  | CHANCE RIDES, INC. 4219 Irving Wichita, KS 67277-2328 U.S.A. Phone: 1-800-242-6231 • FAX: 1-316-942-7416 Website: www.rides.com E-mail: rides@rides.com | Bulletin No: B414R1224-0 |
| | Release Date: August 6, 1999 | |
| | Effective Date: August 6, 1999 | |
| | Supersedes: N/A | |
| | Completion Date: September 6, 1999 | |
| | Page: 1 of 4 | |

SERVICE BULLETIN

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

Ride Name: INVERTER (Portable Model) Affected Serial Numbers: All units

Model No.: 414

Abstract of Issue:

Set-Up and Tear-Down Procedure

Reason For Release:

Chance Rides, Inc. specifies in the INVERTER Set-Up Manual the correct way in which the ride is erected for operation and dismantled for transport. The manual provides instruction on the correct sequence of major steps of the set-up/tear-down procedures which must be followed to avoid serious personal injury and/or equipment damage. It is the owner's responsibility to ensure that set-up/tear-down personnel are familiar with the procedures specified and that these procedures are followed.

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 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.

All owners/operators of the INVERTER ride must read the Set-Up Manual and be familiar with all warnings and cautions printed in the manual prior to erecting or dismantling the ride.

Detail of Issue:

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. All owner/operators of the above noted INVERTER rides are required to order and install the decals as instructed in this bulletin. The decals will be offered at no charge if ordered within 30 days of the release date of this bulletin.

| <u>Part Number</u> | <u>Description</u> | <u>Qty. Req'd Per Ride</u> |
|--------------------|--------------------|----------------------------|
| 414-0010-0044 | DECAL - SET-UP | 4 |
| 414-0010-0045 | DECAL - TEAR-DOWN | 4 |

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Completion Date: September 6, 1999

Page: 2 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

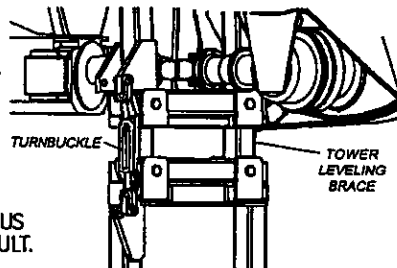
Action to be taken (continued):

**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 TURNBUCKLE MUST BE SECURE. 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



414-0010-044

DECAL - SET-UP (part number 414-0010-0044)

4 required per ride

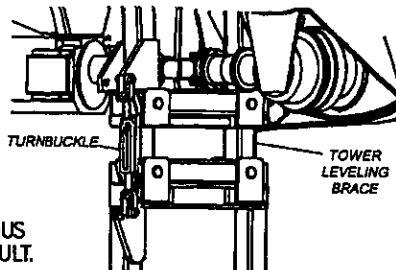
**WARNING****DURING TEAR-DOWN -**

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. THE TURNBUCKLE MUST BE SNUG.

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



414-0010-045

DECAL - TEAR-DOWN (part number 414-0010-0045)

4 required per ride

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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

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E-mail: rides@rides.com

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Completion Date: September 6, 1999

Page: 3 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

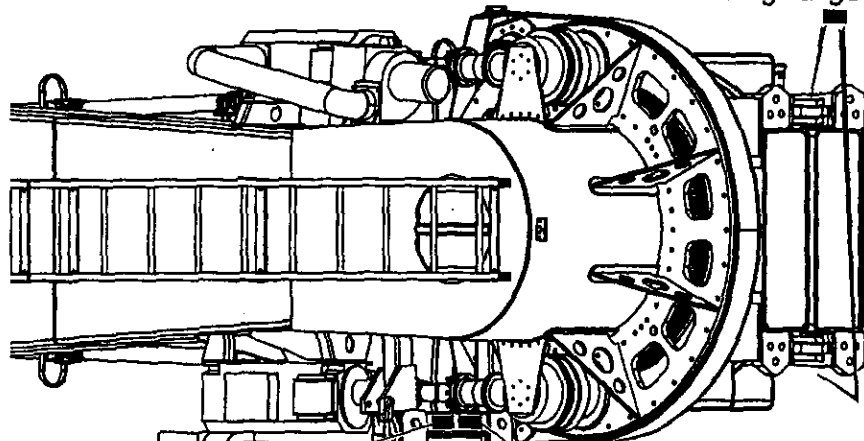
Affected Serial Nos.: All units

Model No.: 414

Action to be taken (continued):

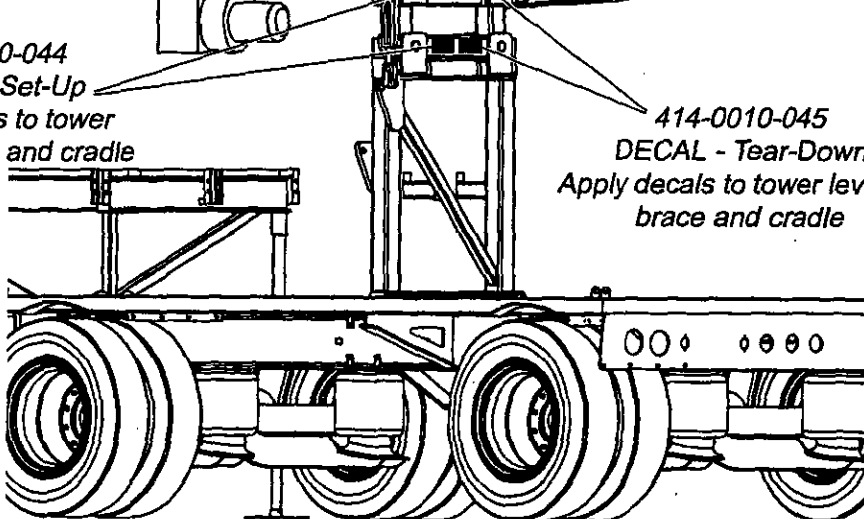
Install the decals in the locations shown in the following illustrations. Clean all decal mounting surfaces with a suitable cleaner such as rubbing alcohol. Do not use cleaners which contain ammonia.

414-0010-045 DECAL - Tear-Down
Apply decal to both sides of counterweight
arm near bolting flanges



**414-0010-044
DECAL - Set-Up**
Apply decals to tower
leveling brace and cradle

**414-0010-045
DECAL - Tear-Down**
Apply decals to tower leveling
brace and cradle





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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

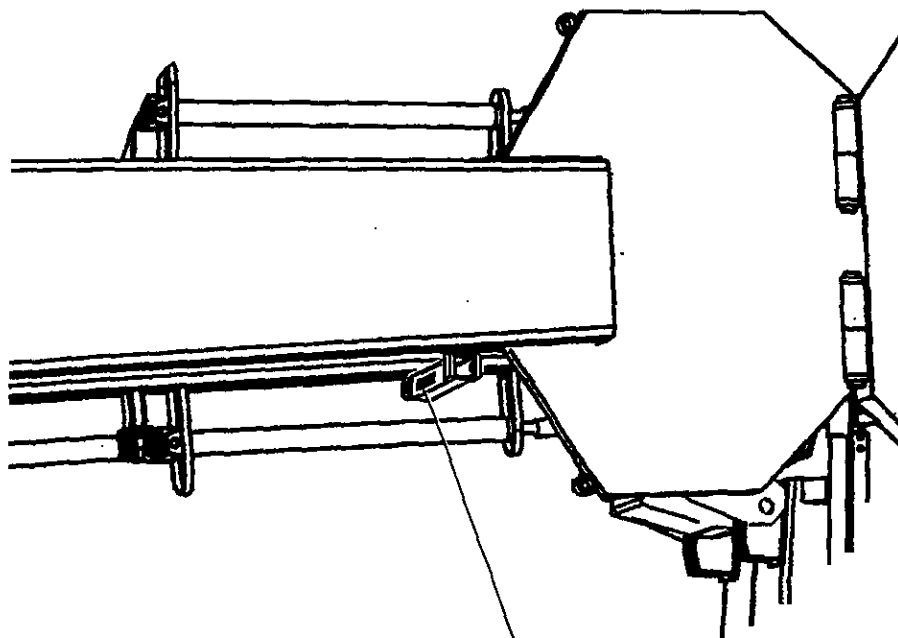
Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

Action to be taken (continued):



414-0010-044 DECAL - Set-Up
Apply decals to both sides of arm-to-arm brace

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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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

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Bulletin No: B414R1211-0

Release Date: August 18, 1999

Effective Date: August 18, 1999

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Completion Date: September 18, 1999

Page: 1 of 4

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All

Model No.: 414

Abstract of Issue:

Inspection, Replacement and Operation of Hydraulic Lock Cylinders

Reason For Release:

The passenger restraint system on the INVERTER amusement ride incorporates a hydraulic lock cylinder for the primary restraint bar (lap bar) for each seat. In the event a hydraulic lock cylinder fails, the secondary restraint bar (T-bar) prevents the lap 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

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

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| Supersedes: | N/A |
| Completion Date: | September 18, 1999 |
| Page: | 2 of 4 |

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

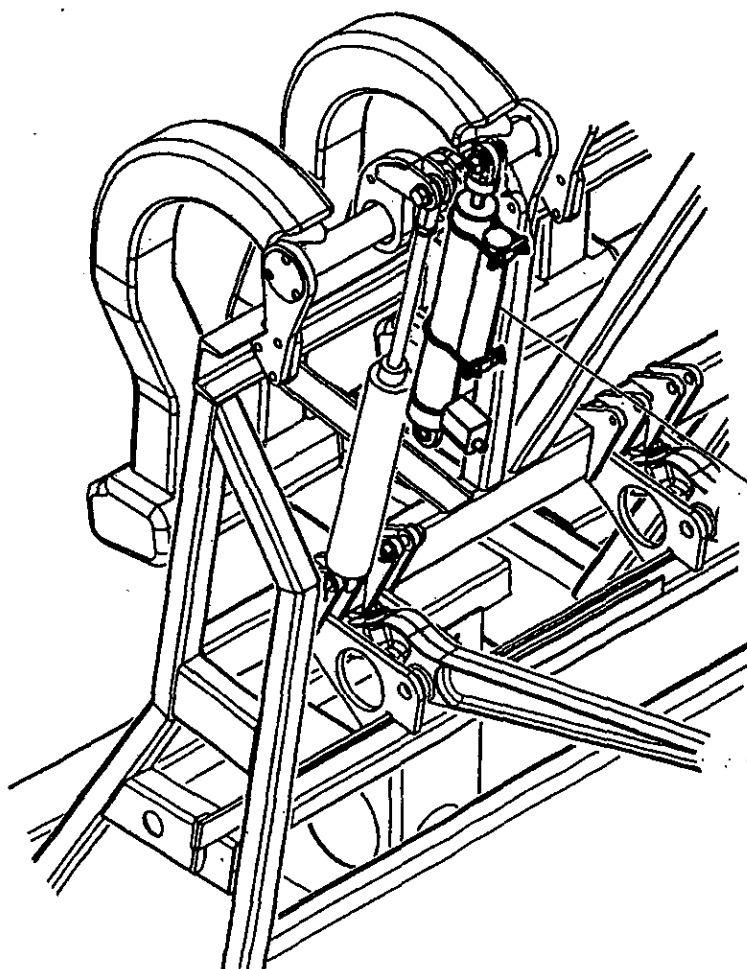
Affected Serial Nos.: All

Model No.: 414

Detail of Issue (continued):

Inspection Procedure

Inspect the hydraulic lock cylinders for all seats (24 total). Identify the cylinders based on the distinguishing characteristics detailed on the next page.



Hydraulic lock cylinder
for primary restraint bar
(lap bar)



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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

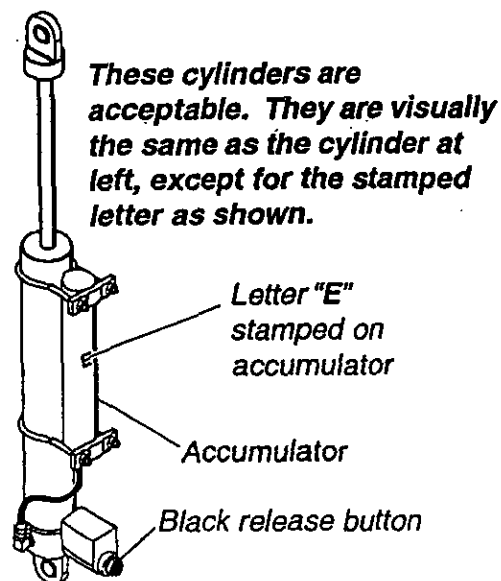
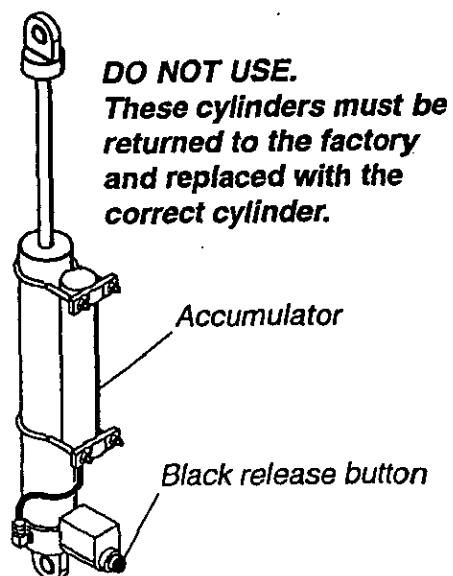
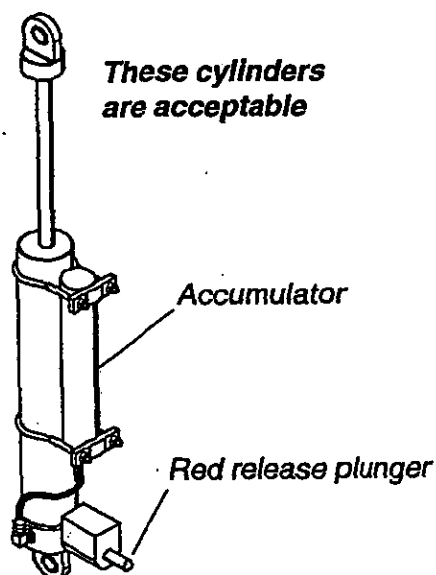
Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All

Model No.: 414

Detail of Issue (continued):





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Wichita, KS 67277-2328

U.S.A.

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E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All

Model No.: 414

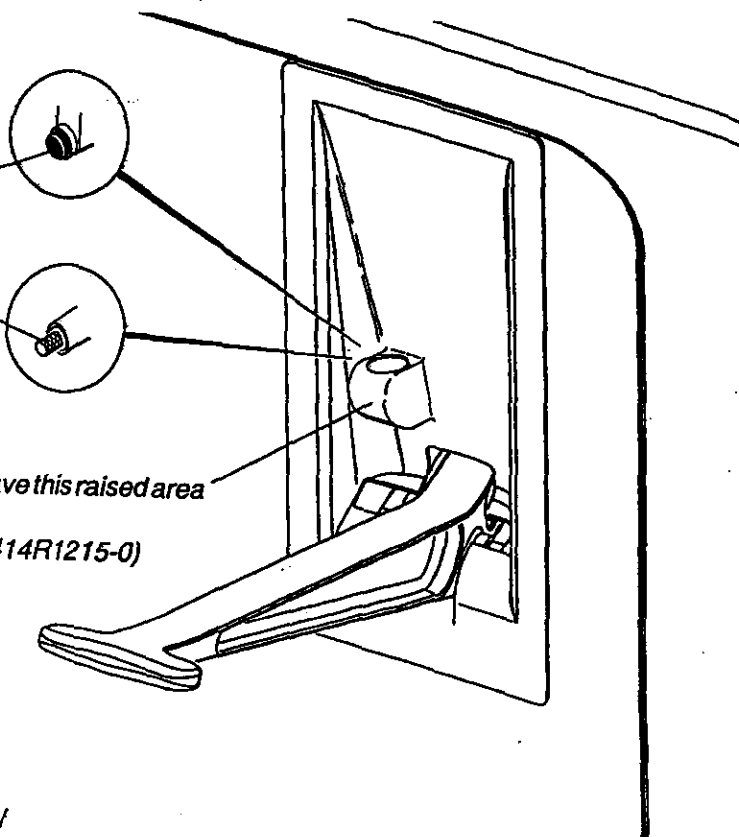
Detail of Issue (continued):

Operation - Manually releasing passenger restraints

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

To manually release the
PRIMARY RESTRAINT BAR
(shoulder bar)

- push the black release button
- or -
- pull the red release plunger



NOTE: All closeout panels must have this raised area
over the manual release.
(refer to Service Bulletin B414R1215-0)

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Bulletin No: B414R1221-0

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Page: 1 of 4

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/1/99 through 7/1/99

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)

Affected Serial Nos.: 414-00399 through 414-01499
414-005P99 only

Model No.: 414

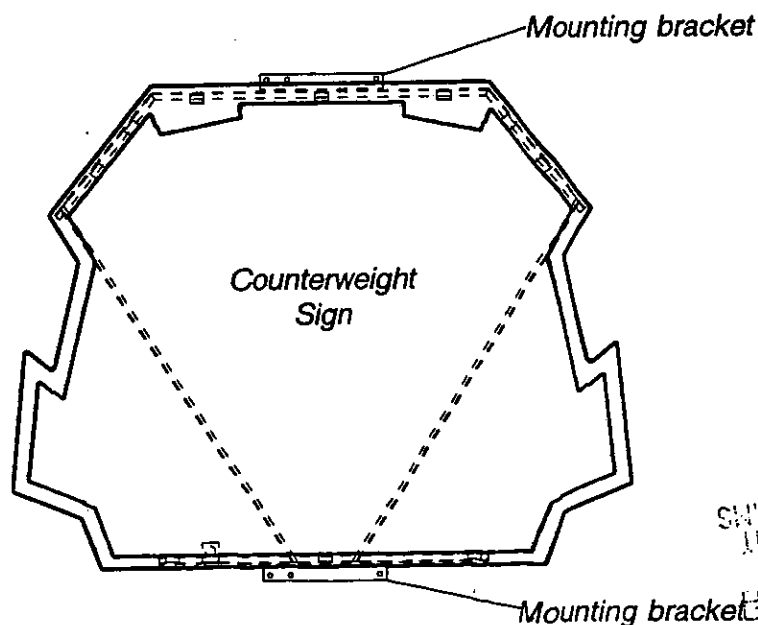
Abstract of Issue:

Counterweight Sign Frame Inspection and Rework

Reason For Release:

Chance Rides, Inc. has become aware that cracks can develop in the counterweight sign frame on the above noted INVERTER amusement rides. The area where the cracks can occur is the welded joints for the mounting brackets. If these weld break, the sign can fall, possibly resulting in personal injury to the operator, passengers and/or bystanders.

Two rework kits have been designed:



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E-mail: rides@rides.com

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Page: 2 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/1/99 through 7/1/99

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)

Affected Serial Nos.: 414-00399 through 414-01499
414-005P99 only

Model No.: 414

Action to be taken (continued):

- For ride serial numbers 414-00699 through 414-01499 and 414-005P99, a kit has been developed to reinforce the aluminum sign frame. The kit, part number K414R1221-1 includes steel doubler plates which attach to the existing frame.
- For ride serial numbers 414-00399 through 414-00599, a kit has been developed to replace the aluminum sign frame with a steel frame. The kit, part number K414R1221-2 includes a complete steel sign frame.

Chance Rides, Inc. requires all owner/operators to visually inspect the counterweight sign frame as described on the following pages of this bulletin and rework the sign as instructed.

Order and install the appropriate kit for that specific ride. Each kit includes all necessary parts to rework one counterweight sign, along with complete instructions for installation.

Each kit will be offered at no charge if ordered within 30 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.

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 4219 Irving
 Wichita, KS 67277-2328
 U.S.A.
 Phone: 1-800-242-6231 • FAX: 1-316-942-7416
 Website: www.rides.com
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 Completion Date: October 25, 1999
 Page: 3 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/1/99 through 7/1/99

Ride Name: INVERTER (Portable Model)
 INVERTER (Park Model)

Affected Serial Nos.: 414-00399 through 414-01499
 414-005P99 only

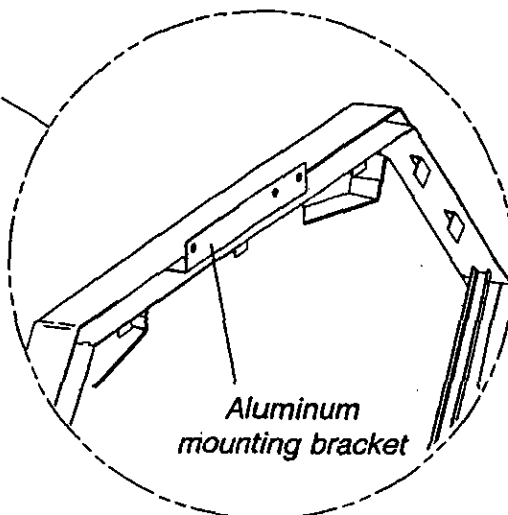
Model No.: 414

Action to be taken (continued):

Inspection Procedure (Ride serial numbers 414-00699 through 414-01499 and 414-005P99)



1. Visually inspect the aluminum mounting brackets and welds in the area where the mounting brackets attach to the frame. Use an inspection mirror or similar tool to view the area under the fiberglass sign.
2. If cracks are found or if the mounting holes in the bracket are excessively worn, contact the Chance Customer Service Department for specific repair instructions prior to installation of the rework kit.
3. If no cracks are found, order and install the Counterweight Sign Rework Kit (K414R1221-1) using the instructions provided with the kit.



Aluminum
 mounting bracket

Side view of counterweight sign
 (Ride serial numbers 414-00699 through
 414-01499 and 414-005P99)

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Website: www.rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/1/99 through 7/1/99

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)

Affected Serial Nos.: 414-00399 through 414-01499
414-005P99 only

Model No.: 414

Action to be taken (continued):

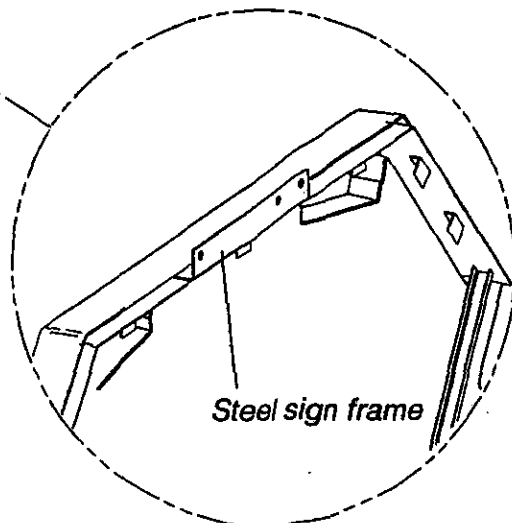
Inspection Procedure (Ride serial numbers 414-00399 through 414-00599)

1. Visually inspect the counterweight frame. It must be made of steel.

If the frame is made of aluminum, contact the Chance Customer Service Department and order the Counterweight Sign Frame Rework Kit (part number K414R1221-2).

2. Drill out the rivets which secure the sign to the aluminum frame. Remove and discard the old frame.

3. Install the steel frame and secure with the rivets provided with the kit.



*Side view of counterweight sign
(Ride serial numbers 414-00399
through 414-00599)*

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.:

Prior to 414-02399

INVERTER (Park Model)

Prior to 414-008P99

DOUBLE INVERTER

Prior to 414-008P99

Model No.: 414

Abstract of Issue:

Vehicle Air System Rework

Reason For Release:

The passenger restraint bar interlock system on the INVERTER has many components which must be adjusted properly and kept in good operating condition for reliability and safety of the ride. Among these components are the primary restraint bar limit switches, secondary restraint bar limit switches and the step interlock valve.

Chance Rides, Inc. has developed a new feature which allows the operator to check the step interlock valve and the adjustment of all primary and secondary restraint bar limit switches with a single procedure.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to install the Air System Rework Kit, part number K414R1225-0, using the instructions on the following pages of this bulletin. The kit includes all parts necessary to rework one vehicle. For DOUBLE INVERTER rides, order two kits.

The parts will be provided at no charge if ordered within 30 days of the release date of this bulletin.

The daily "Passenger Restraint Bar Interlock System Check" procedure affected by this change is also included in this bulletin.

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

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4219 Irving

Wichita, KS 67277-2328

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Page: 2 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.:

Prior to 414-02399

INVERTER (Park Model)

Prior to 414-008P99

DOUBLE INVERTER

Prior to 414-008P99

Model No.: 414

Action to be Taken (continued):

Kit number K414R1225-0 contains the following:

| <u>Part Number</u> | <u>Component</u> | <u>Quantity</u> |
|--------------------|-------------------------------------|-----------------|
| 28445200 | MANUAL OVERRIDE VALVE | 1 |
| 60249200 | BUSHING - 1/4MP x 1/8FP | 1 |
| 60261800 | TEE - 1/8FP x 1/8FP x 1/8MP | 1 |
| 22711400 | TEE - 1/8MP x 1/4T x 1/4T | 1 |
| 60165801 | ELBOW (90°) - 1/4MP x 1/4T | 1 |
| 48015000 | AIR LINE 1/4" diameter x 12" Long | 1 |
| 414-0155-007 | ACTUATOR BLOCK | 1 |
| 60700200 | ADJUSTING BOLT (1/4-20 x 3/4" long) | 1 |
| 64759600 | JAM NUT (1/4-20) | 4 |
| 60252400 | NIPPLE - 1/8MP Close | 1 |
| 60145401 | ADAPTER - 1/8MP x 1/4T | 1 |

NOTICE

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SH2000-10-25-0000
10-25-99
01-03-82-010
10-25-99

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1225-0

Release Date: October 25, 1999

Effective Date: October 25, 1999

Supersedes: N/A

Completion Date: November 25, 1999

Page: 3 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: Prior to 414-02399
Prior to 414-008P99
Prior to 414-008P99

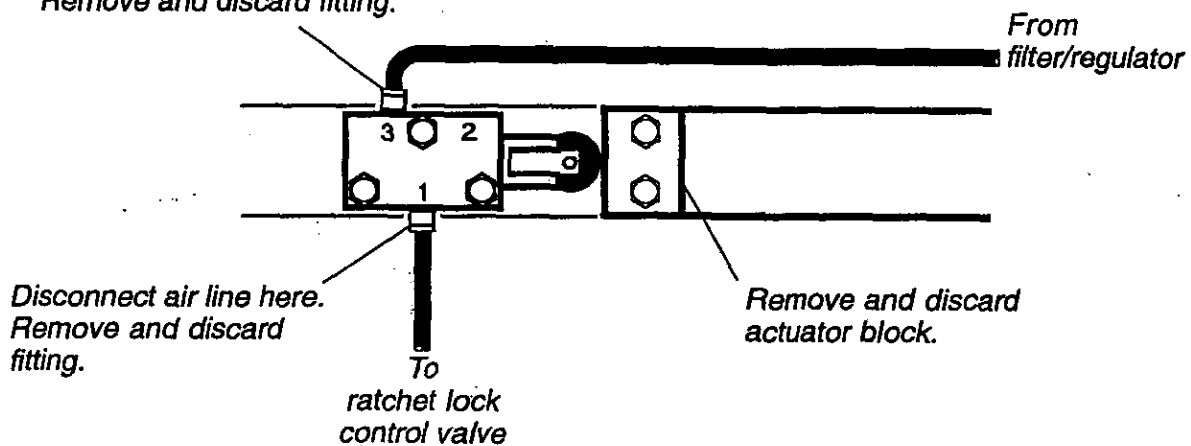
Model No.: 414

Detail of Issue:

Installation Instructions - Vehicle Air System Rework

1. Turn off the power to the vehicle and drain the air system of all pressure.
2. Locate the step interlock valve, visible on the tower side of the vehicle through an access opening.
3. Disconnect the two air lines coming from the step interlock valve. To remove the air line, push the locking collar in toward the fitting, and pull straight out on the line.

*Disconnect air line here.
Remove and discard fitting.*



IMPORTANT: Do not disconnect both ends of these two lines; only disconnect them at the step interlock valve. Pay attention to where the lines are connected and how they are routed before disconnecting.

4. Remove the two fittings from the valve and discard them.
5. Remove the actuator block from the step lock slide bar. Set the fasteners aside for later use. Discard the old actuator block.



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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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E-mail: rides@rides.com

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Completion Date: November 25, 1999

Page: 4 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.:

Prior to 414-02399

INVERTER (Park Model)

Prior to 414-008P99

DOUBLE INVERTER

Prior to 414-008P99

Model No.: 414

Detail of Issue (continued):

6. Assemble the jam nut and adjusting bolt in to the new actuator block. Install the actuator block using the existing fasteners. Check that all components are properly aligned. Tighten the fasteners in the valve and the actuator block.

Adjusting bolt - 1/4-20 x 3/4"
(60700200)

Jam nut - 1/4-20 (64759600)



Actuator block (414-0155-007)

7. Check the operation of the step interlock valve when the step is raised and lowered.

- If the valve is not closing fully when the step is raised, loosen the jam nut on the adjusting bolt. Turn the bolt counter-clockwise to push the plunger in further. Do not adjust the bolt so far that the plunger "bottoms out" in the valve body.
- When the step is lowered, make sure the plunger extends fully, opening the valve.

RECEIVED
 019729 FEB-78
 RIDES SAFETY PROGRAMS

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Wichita, KS 67277-2328
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Phone: 1-800-242-6231 • FAX: 1-316-942-7416

Website: www.rides.com

E-mail: rides@rides.com

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Completion Date: November 25, 1999

Page: 5 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

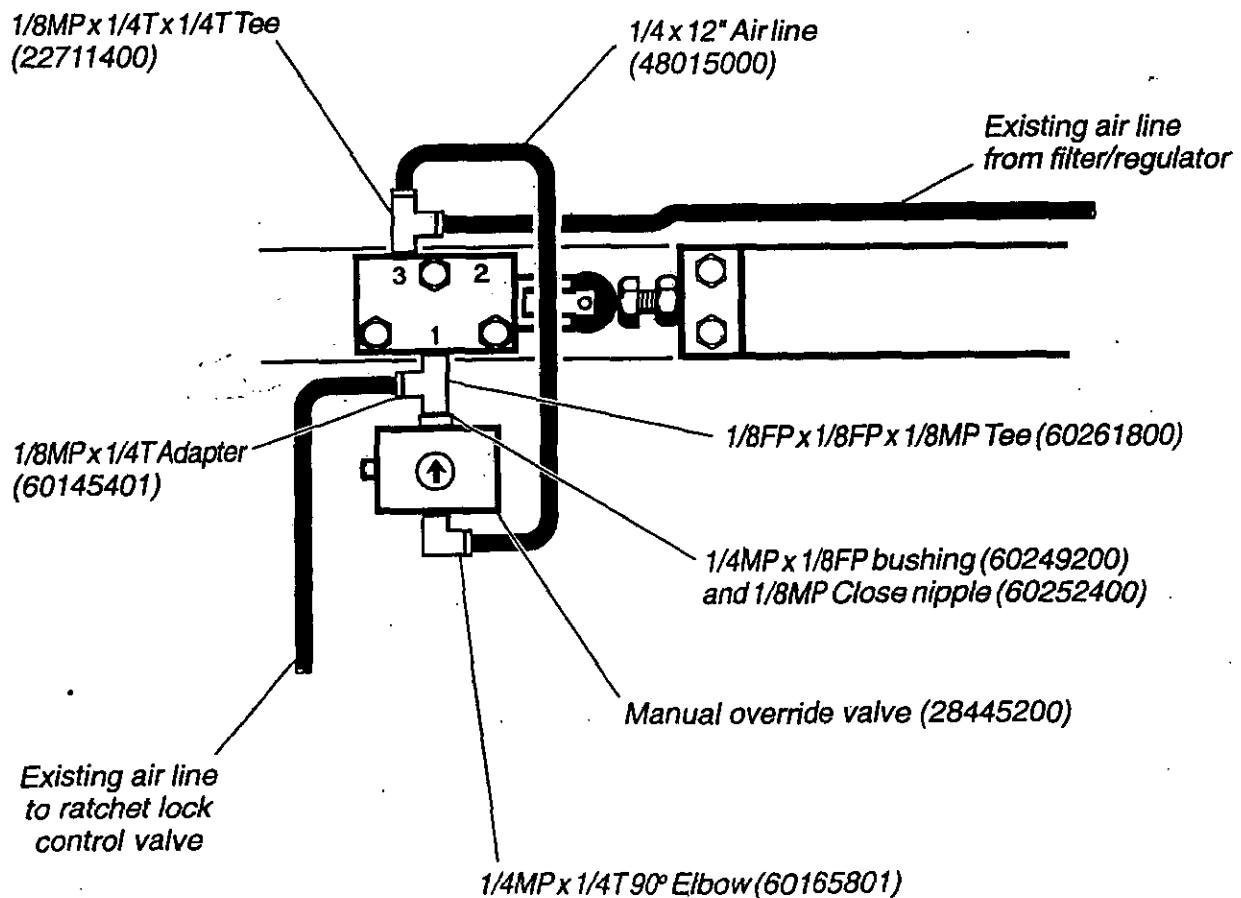
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: Prior to 414-02399
Prior to 414-008P99
Prior to 414-008P99

Model No.: 414

Detail of issue (continued):

8. Install the air lines and fittings as shown below.



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U.S.A.

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Website: www.rides.comE-mail: rides@rides.com

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Completion Date: November 25, 1999

Page: 6 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.:

Prior to 414-02399

INVERTER (Park Model)

Prior to 414-008P99

DOUBLE INVERTER

Prior to 414-008P99

Model No.: 414

Detail of Issue (continued):

Daily Passenger Restraint Bar Interlock System Check

Use the following procedure to check the adjustment of the step interlock valve and the primary and secondary restraint bar limit switches. This is a daily check.

1. Close primary restraint bars (shoulder bars) and secondary restraint bars (T-bars).
2. Raise the step and engage the manual step latch.
3. Turn off electrical power to the vehicle.
4. On the vehicle control panel, turn the SECONDARY RESTRAINT BAR (T-BAR) SWITCH to "Open."
5. On the vehicle control panel, turn the PRIMARY RESTRAINT BAR (SHOULDER BAR) SWITCH to "Open."
6. Turn on electrical power to the vehicle. The secondary restraint bars (T-bars) **MUST NOT RELEASE**. If they do, it indicates the step interlock valve requires adjustment as described previously.
7. Push the button on the manual override valve for the step interlock.

NOTE: At this point the secondary restraint bars (T-bars) should raise until they stop against the step interlock (also referred to as the "Tertiary lock" position). The primary restraint bars should raise until they stop against the T-bars.

8. Check the restraint bar indicator display. It must read:

| ROW SEAT | | R. S. | |
|----------|-----|-------|-----|
| TBR | 0 0 | SBR | 0 0 |

Any other reading indicates that one or more T-bar or shoulder bar limit switch requires adjustment.

9. Adjust the limit switches as required using the procedures described in the INVERTER Service Manual.

DO NOT OPERATE THE RIDE UNTIL THE STEP INTERLOCK VALVE AND ALL T-BAR AND SHOULDER BAR LIMIT SWITCHES ARE ADJUSTED CORRECTLY.

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1235-0

Release Date: March 3, 2000

Effective Date: March 3, 2000

Supersedes: N/A

Completion Date: April 3, 2000

Page: 1 of 2

NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:

Drive Motor Covers

Reason For Release:

Chance Rides, Inc. has become aware that moisture can enter the drive motors through the air intake plenum under certain circumstances. A cover has been developed to shield drive motors.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides can, at their option, order and install the drive motor cover as described in this bulletin. Order the following parts:

| <u>Part Number</u> | <u>Description</u> | <u>Quantity</u> |
|--------------------|------------------------------------|-----------------|
| 414-0728-002 | COVER - DRIVE MOTOR | 2 |
| 66429900 | SCREW - SELF TAPPING (10-24 x 1/2) | 12 |

The parts will be provided at a reduced price if ordered within 30 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.

NOTICE

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Supersedes: N/A

Completion Date: April 3, 2000

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

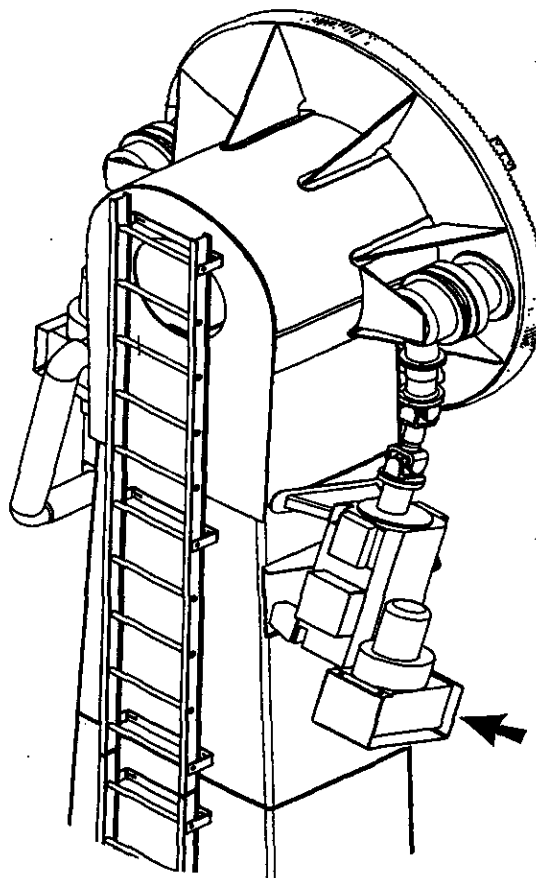
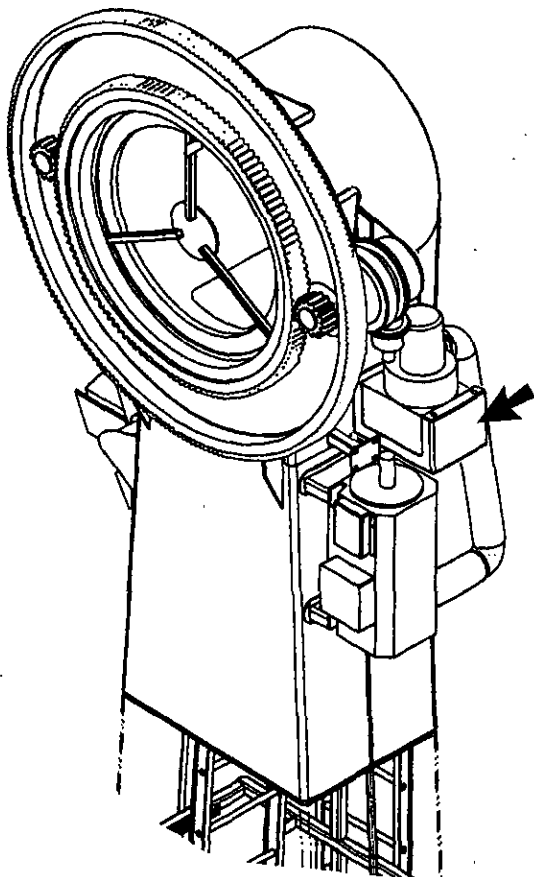
Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue:

1. Locate the drive motor covers on the air intake boxes as shown in the following illustrations.
2. Use a #25 drill bit (0.1495" diameter) to drill through the flange on the cover into the air intake box, six places per cover.
3. Secure with the self tapping screws provided.





CHANCE RIDES, INC.

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

Bulletin No: B414R1239-0

Release Date: April 12, 2000

Effective Date: April 12, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 1 of 1

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER - Portable Model
INVERTER - Park Model Single
DOUBLE INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:

Slewing Ring and Drive Gear Lubrication

Reason For Release:

Chance Rides, Inc. has become aware of rides being operated without adequate lubrication of the drive gears. Daily lubrication with the correct lubricant is necessary to obtain satisfactory service life of these components, as specified in the INVERTER Service Manual.

Operation of the ride without adequate lubrication will result in early failure of these components, as well as the pinion gears which contact them.

Action to be Taken:

All owner/operators of INVERTER amusement rides are required to comply with the lubrication instructions in the INVERTER Service Manual, including the main slewing ring and vehicle slewing ring lubrication described in this bulletin.

Use only NLGI No. 2 or No. 3 EP open gear lube (Pennzoil Pennztac® Blue Streak or equivalent). Do not substitute an inferior lubricant. This product is available through most lubricant suppliers, or from Chance Rides. Order part number 24219701 for one cartridge.

Apply lubricant to the inner and outer teeth of the main slewing ring and the vehicle slewing ring. Distribute the lubricant evenly to keep all teeth well coated. **THIS MUST BE PERFORMED DAILY.**

Failure to maintain the ride in accordance with the manufacturer's specifications will void the product warranty. Complete maintenance instructions are in the INVERTER Service Manual.



The World's Ride Company

CHANCE RIDES, INC.

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

Bulletin No: B414R1242-0

Release Date: June 16, 2000

Effective Date: June 16, 2000

Supersedes: N/A

Completion Date: July 16, 2000

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: April, 1999 through May, 2000

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-005599, 414-008500 and 414-011500
DBLINV-414-00999 and DVLINV-414-01000

Model No.: 414

Abstract of Issue:**Main Arm Drive Shaft Inspection (inside tower)****Reason For Release:**

Chance Rides, Inc. has become aware that the main arm drive shaft can become loose at its connection to the gearbox on the above noted INVERTER amusement rides. If this occurs, serious and expensive damage to the drive shaft, gearbox and electric drive motor can occur.

An inspection procedure has been developed to identify the potential problem before damage occurs.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to perform the inspection detailed on the following pages of this bulletin. If indicated, take the corrective action described in the procedure.

The inspection of the main arm drive shafts must be performed monthly.

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.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1242-0

Release Date: June 16, 2000

Effective Date: June 16, 2000

Supersedes: N/A

Completion Date: July 16, 2000

Page: 2 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: April, 1999 (through May, 2000)

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-005S99, 414-008S00 and 414-011S00
DBLINV-414-00999 and DVLINV-414-01000

Model No.: 414

Action to be taken (continued):

Inspection Procedure - Main Arm Drive Shaft (inside tower)

Inspect the main arm drive shafts in the area indicated in the following illustrations.

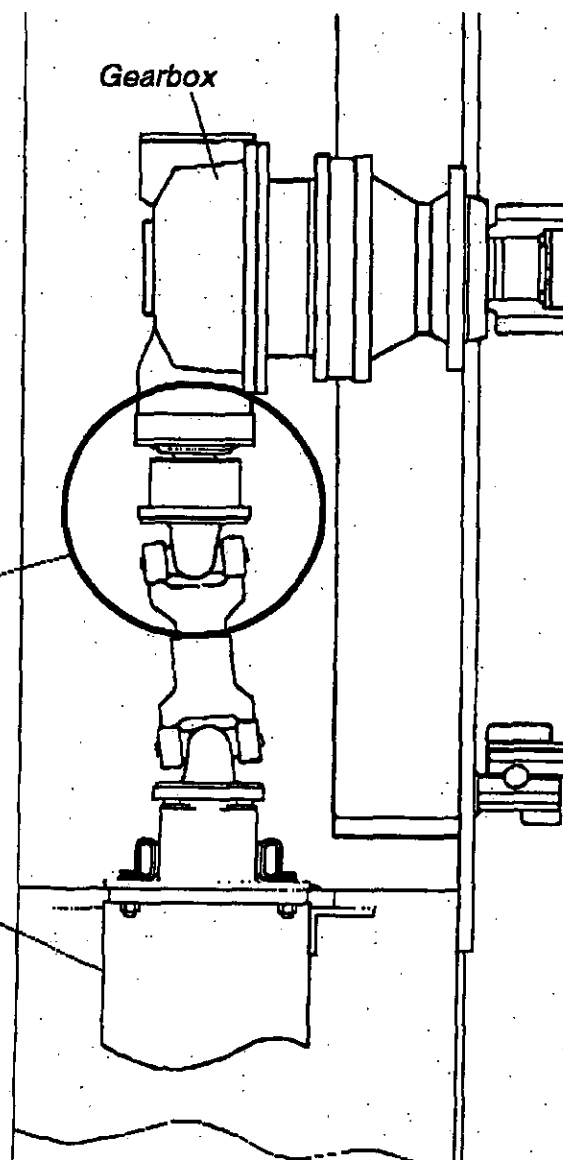
Inspect this area
as shown in detail
on next page

Drive Motor

Gearbox

NOTE: Single PARK MODEL INVERTER
has two main arm drive shafts.

DOUBLE INVERTER has four main
arm drive shafts.



**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Release Date: June 16, 2000

Effective Date: June 16, 2000

Supersedes: N/A

Completion Date: July 16, 2000

Page: 3 of 4

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: April, 1999 through May, 2000

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-005S99, 414-008S00 and 414-011S00
DBLINV-414-00999 and DVLINV-414-01000

Model No.: 414

Action to be taken (continued):

Incorrect

Shoulder on gearbox shaft is visible
between yoke adapter and gearbox
housing.

Yoke adapter

Washer

Shaft bolt

Gearbox

Drive shaft

This condition indicates the shaft bolt is loose.
The following corrective action must be taken:

1. Remove the drive shaft and yoke adapter from the gearbox shaft.
2. Clean and inspect all components, including the gearbox shaft and keyway, the key, and the yoke adapter.
3. Discard the bolt and replace with a new part (M12 x 30, 8.8).
4. Apply Loctite® 620 (green) to the gearbox shaft and Loctite® 262 (red) to the bolt threads.
5. Install the yoke adapter and tighten the bolt to 55 ft-lbs (77.5 N•m).
6. Install the drive shaft.

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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Completion Date: July 16, 2000

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: April, 1999 through May, 2000

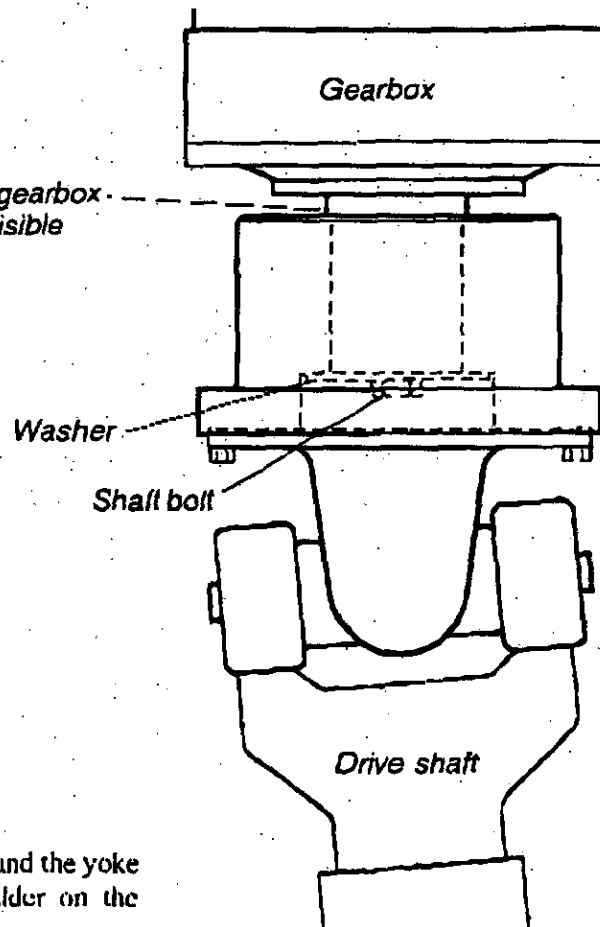
Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: 414-005S99, 414-008S00 and 414-011S00
DBLINV 414-00999 and DVLINV-414-01000

Model No.: 414

Action to be taken (continued):

Correct
Shoulder on gearbox
shaft is not visible



This condition indicates the shaft bolt is tight and the yoke adapter is properly seated against the shoulder on the gearbox shaft.

Repeat this inspection at monthly intervals.



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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

Bulletin No: B414R1236-0

Release Date: August 1, 2000

Effective Date: August 1, 2000

Supersedes: N/A

Completion Date: September 1, 2000

Page: 1 of 3

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Models Only) Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:
Vehicle Casters

Reason For Release:

Chance Rides, Inc. has become aware of difficulties in moving the vehicle during set-up and tear-down of the above noted INVERTER amusement rides. These difficulties result from a combination two factors:

- Binding in the casters after extended use
- Caster movement during transport of the ride

A new caster assembly has been developed which will provide better operation and longer service life. Additionally, a caster stop has been developed to lock the casters and adjusting screw during transport.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to replace the existing casters with the new design and install the caster locks as described on the following pages of this bulletin.

Order the following parts to rework one complete ride:

| <u>Part</u> <u>Number</u> | <u>Description</u> | <u>Qty. Req'd</u> <u>Per Ride</u> |
|------------------------------|---------------------------------|--------------------------------------|
| 414-0914A-002 | VEHICLE CASTER ASSEMBLY | 4 |
| 414-0926-003 | STOP - VEHICLE CASTER | 4 |
| CSN10A03-09 | PIN - TAPER (1/2 X 3-5/16" G/L) | 4 |
| 65190000 | HAIRPIN (1/8) | 4 |

The parts will be provided at no charge for the above noted units if ordered within 30 days of the release date of this bulletin.

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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

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Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Models Only) Affected Serial Nos.: All Units

Model No.: 414

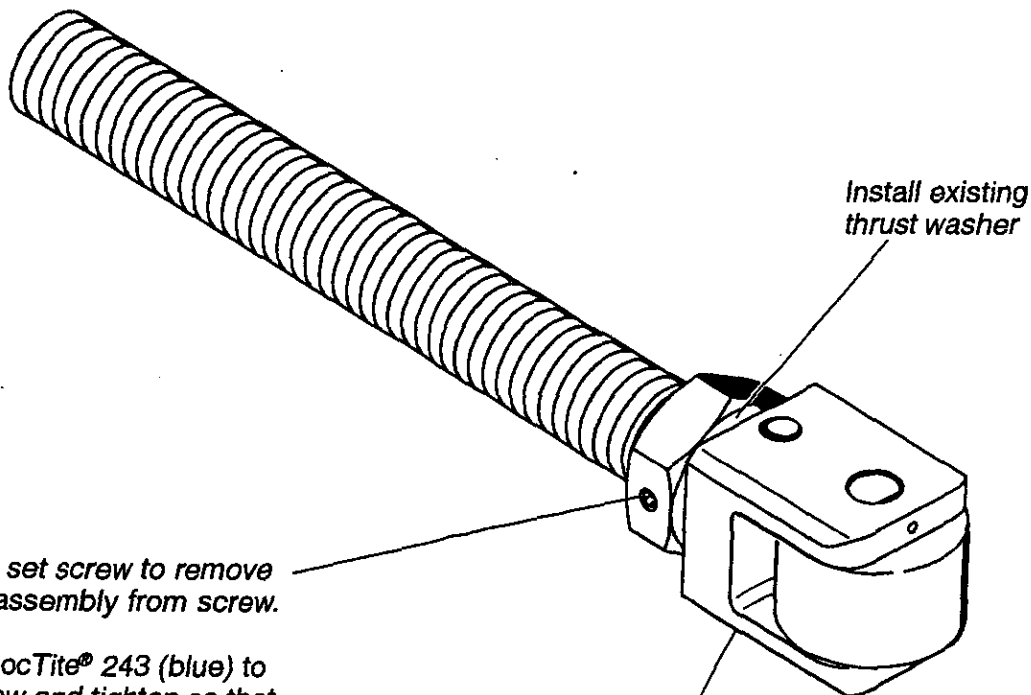
Detail of Issue

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

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Loosen set screw to remove
caster assembly from screw.

Apply Loctite® 243 (blue) to
set screw and tighten so that
caster assembly can turn.

414-0914A-002
Caster Assembly

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

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Completion Date: September 1, 2000

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Models Only) Affected Serial Nos.: All Units

Model No.: 414

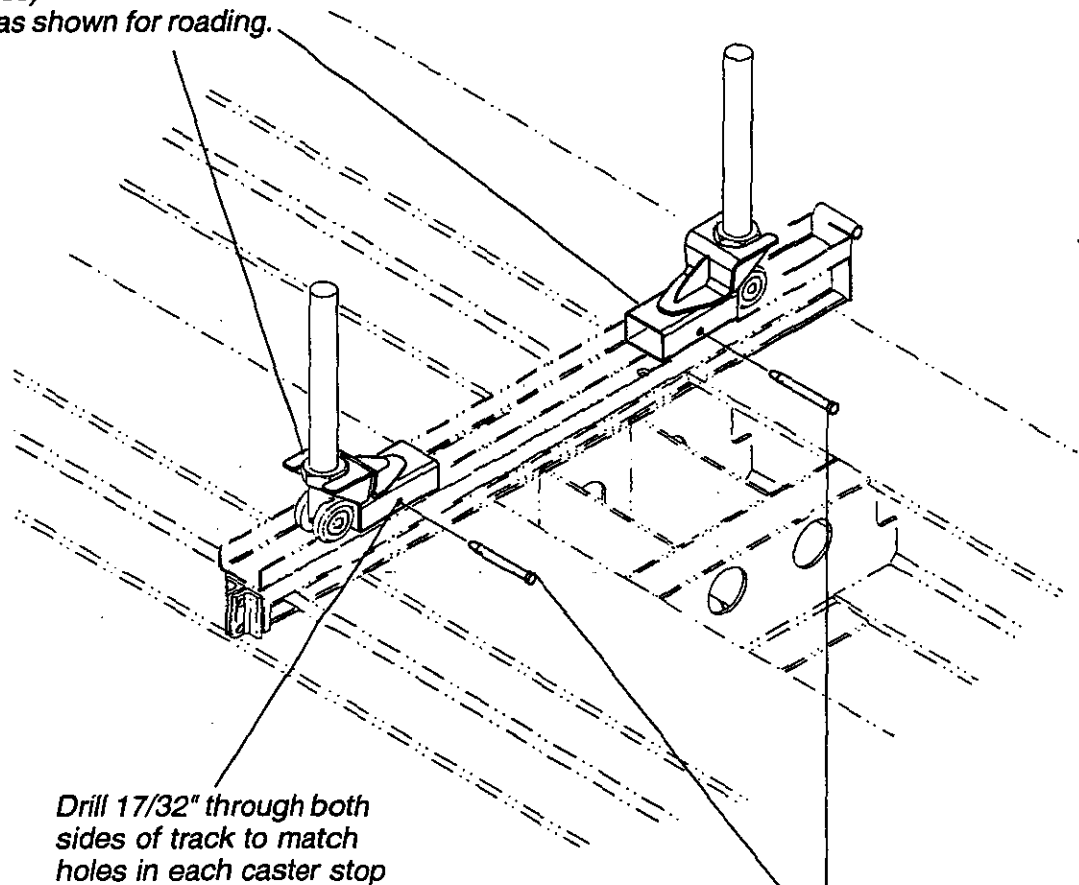
Detail of Issue (continued):

414-0926-003

Caster Stops

(4 places)

Install as shown for roading.

Drill 17/32" through both
sides of track to match
holes in each caster stopSecure with pin and
hairpin provided



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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

Bulletin No: B414R1237-0

Release Date: August 1, 2000

Effective Date: August 1, 2000

Supersedes: N/A

Completion Date: September 1, 2000

Page: 1 of 2

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 4/98 through 9/99

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00198 through 414-00399 and
414-00599 through 414-01899

Model No.: 414

Abstract of Issue:

Vehicle Tie Down Rods

Reason For Release:

Chance Rides, Inc. has become aware that the tie-down rods, which secure the vehicle in the racked position, can fail under certain circumstances on the above noted INVERTER amusement rides. If a tie-down rod fails, the vehicle can become unstable, causing possible personal injury to the driver and/or bystanders, as well as damage to the vehicle and other racking components.

The tie-down rods have been re-designed for additional strength and longer service life. The new design can be visually identified by the clevis ends welded to a solid rod. The original design incorporated clevis ends inserted into a hollow rod.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to replace the three tie-down rods with the new design parts as shown on the following page. The three original tie-down rods must be discarded when their replacements are received. Order the following parts to rework one complete ride.

| <u>Part Number</u> | <u>Description</u> | <u>Quantity</u> |
|--------------------|-------------------------|-----------------|
| 414-0955-002 | TIE-ROD - FRONT (Long) | 1 |
| 414-0955-001 | TIE-ROD - FRONT (Short) | 1 |
| 414-0955-005 | TIE-ROD - REAR | 1 |

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

The parts will be provided at no charge if ordered within 30 days of the release date of this bulletin.

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

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Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 4/98 through 9/99

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos. 414-00198 through 414-00399

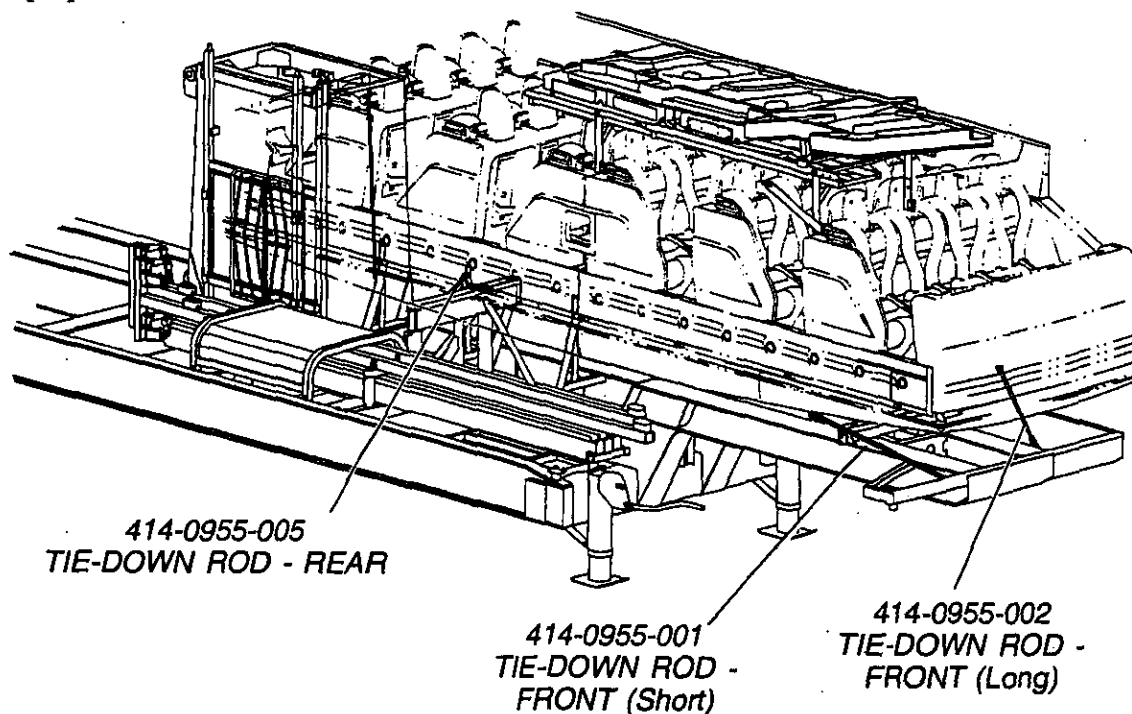
414-00599 through 414-01899

Model No.: 414

Detail of Issue

Install tie-down rods as shown in the following illustration

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

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Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Effective Date: August 29, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 1 of 3

SAFETY ALERT

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Main Drive Inspection

Reason For Release:

WARNING: Failure of a component in the main drives can result in serious personal injury to passengers. Do not operate the above noted INVERTER amusement rides until the main drive inspection described in this safety alert bulletin has been completed. Thereafter, repeat this inspection DAILY.

Chance Rides, Inc. has become aware that the failure of one component in the main drive of the INVERTER can result in broken teeth on the main drive gear and/or pinions. If a broken tooth or other debris becomes lodged in the vehicle drive gears, changes to the vehicle position ("timing") can result. This can cause the vehicle to contact the trailer frame, which can result in serious injury to passengers.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to cease operation until the inspection described in this safety alert bulletin is completed.

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.

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: A414R1245-0

Release Date: August 29, 2000

Effective Date: August 29, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue:

Inspection Instructions

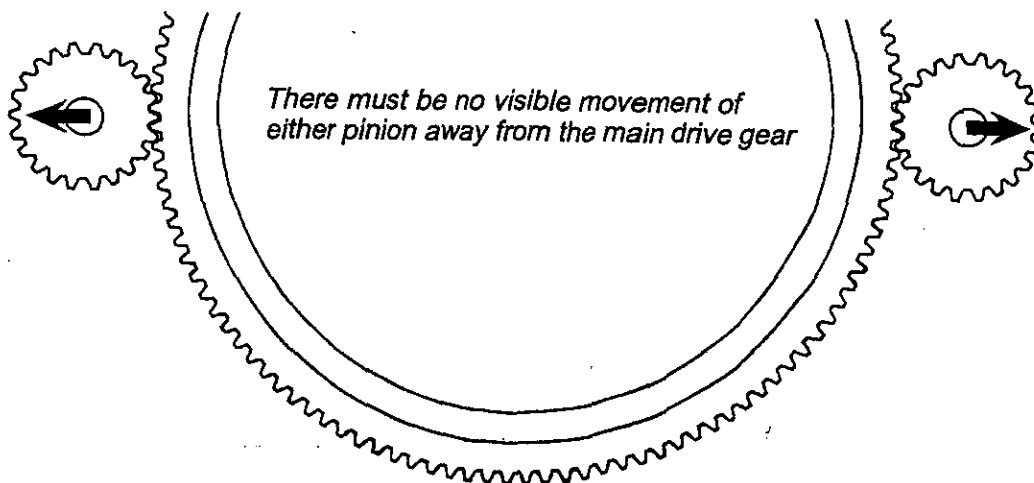
Inspect the main drive gear and pinion EXACTLY as described in the following procedure. This inspection must be performed DAILY.



WARNING: Moving parts can cut or crush. Do not run the ride while performing the main drive gear inspection. Unless specifically instructed, do not manually move the main arm. Serious injury can result.

1. Carefully inspect the teeth on the main drive gear. Look for broken, chipped or cracked gear teeth. If necessary, wipe away the grease to see the teeth clearly. The gear is accessible for inspection through holes in the structure and in the gear guard. If necessary, remove the gear guard.
2. Keeping hands and fingers clear of all moving parts, observe the pinions and main drive gear while an assistant manually moves the main arm back and forth slightly. This can be done by standing on one end of the vehicle and "bouncing" it, then doing the same thing at the other end of the vehicle.

Observe the movement of the pinions in relation to the main drive gear. The pinions must only rotate. Any movement away from the main gear indicates a problem in the gearbox.



**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

BulletinNo: A414R1245-0

ReleaseDate: August 29, 2000

EffectiveDate: August 29, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 3 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

3. Carefully inspect the teeth on the vehicle drive gear. Look for broken, chipped or cracked gear teeth, or debris in the teeth. If necessary, wipe away the grease to see the teeth clearly.
4. Inspect both main drive gearboxes and all four vehicle drive gearboxes. If any gearbox exhibits oil leakage or excessively noisy operation, it is likely that failure of that gearbox has occurred
5. If any of the preceding abnormal conditions are found contact the Chance Customer Service Department immediately for further information. DO NOT OPERATE THE RIDE UNTIL CORRECTIVE MEASURES ARE TAKEN.



CHANCE RIDES, INC.

4219 Irving
Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1245-A

Release Date: August 31, 2000

Effective Date: August 31, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 1 of 5

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Main Drive Inspection - Daily and Weekly Inspection Points

Reason For Release:

IMPORTANT:

This service bulletin is issued to provide additional information to Safety Alert Bulletin A414R1245-0.

After performing the initial inspection described in that bulletin, the inspection procedures and intervals specified in this bulletin supersede the daily inspection required by Safety Alert Bulletin A414R1245-0.

Failure of *one* component in the main drive of the INVERTER can result in broken teeth on the main drive gear and/or pinions. If a broken tooth or other debris becomes lodged in the vehicle drive gears, changes to the vehicle position ("timing") can result. This can cause the vehicle to contact the trailer frame, which can result in serious injury to passengers.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to perform the daily and weekly inspections described in this service 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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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1245-A

Release Date: August 31, 2000

Effective Date: August 31, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 2 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

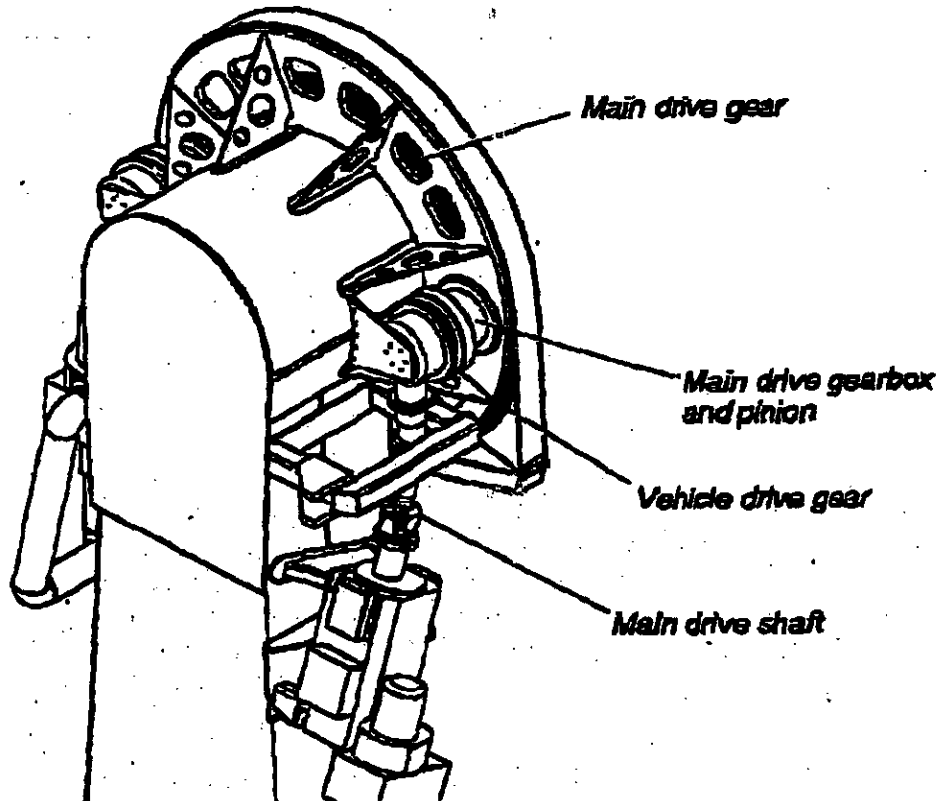
Model No.: 414

Details of Issue:

Inspection Instructions

Inspect the main drive gear and pinion as described in the following procedures. These inspection procedures must be performed **DAILY** or **WEEKLY**, as specified.

If any abnormal conditions are found contact the Chance Customer Service Department immediately. **DO NOT OPERATE THE RIDE UNTIL CORRECTIVE MEASURES ARE TAKEN.**



WARNING: Moving parts can cut or crush. Do not run the ride while performing the main drive gear inspection. Unless specifically instructed, do not manually move the main arm. Serious injury can result.



CHANCE RIDES, INC.

4219 Irving
Wichita, KS 67277-2328
U.S.A.

Phone: 1-800-242-6281 - FAX: 1-316-942-7418

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: **B414R1245-A**

Release Date: **August 31, 2000**

Effective Date: **August 31, 2000**

Supersedes: **N/A**

Completion Date: **Immediately**

Page: **3 of 5**

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

Affected Production Dates: **All**

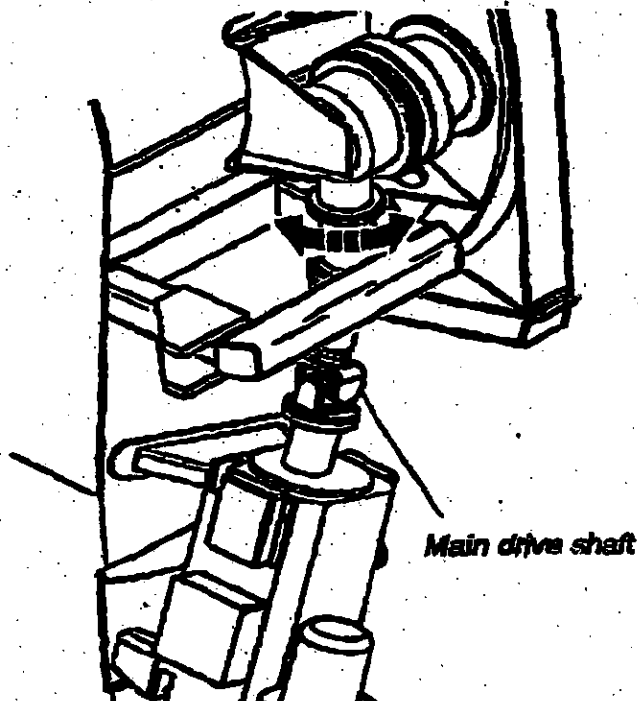
Ride Name: **INVERTER (Portable Model)**

Affected Serial Nos.: **All units**

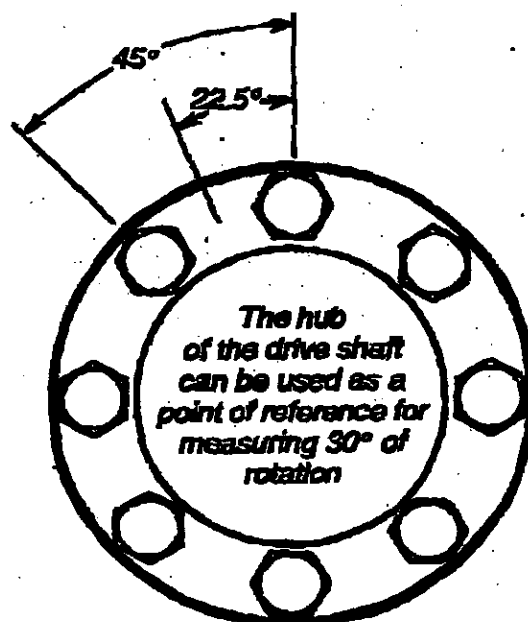
Model No.: **414**

Detail of Issue (continued):

1. **DAILY** - Check the backlash between the main drive pinion and main drive gear as follows:
 - With the parking brake disengaged, turn one of the main drive shafts by hand until it stops.
 - Turn the drive shaft the other direction by hand, noting how far the drive shaft rotates before it stops. The drive shaft must not rotate more than 30° (one-twelfth turn).
 - Repeat the process on the other side to check the backlash at the other drive pinion.



**30° maximum rotation
of main drive shafts**





CHANCE RIDES, INC.

4219 Irving
Wichita, KS 67277-2328
U.S.A.

Phone: 1-800-242-8231 • FAX: 1-316-942-7416

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: **B414R1245-A**

Release Date: **August 31, 2000**

Effective Date: **August 31, 2000**

Supersedes: **N/A**

Completion Date: **Immediately**

Page: **4 of 5**

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

Affected Production Dates: **All**

Ride Name: **INVERTER (Portable Model)**

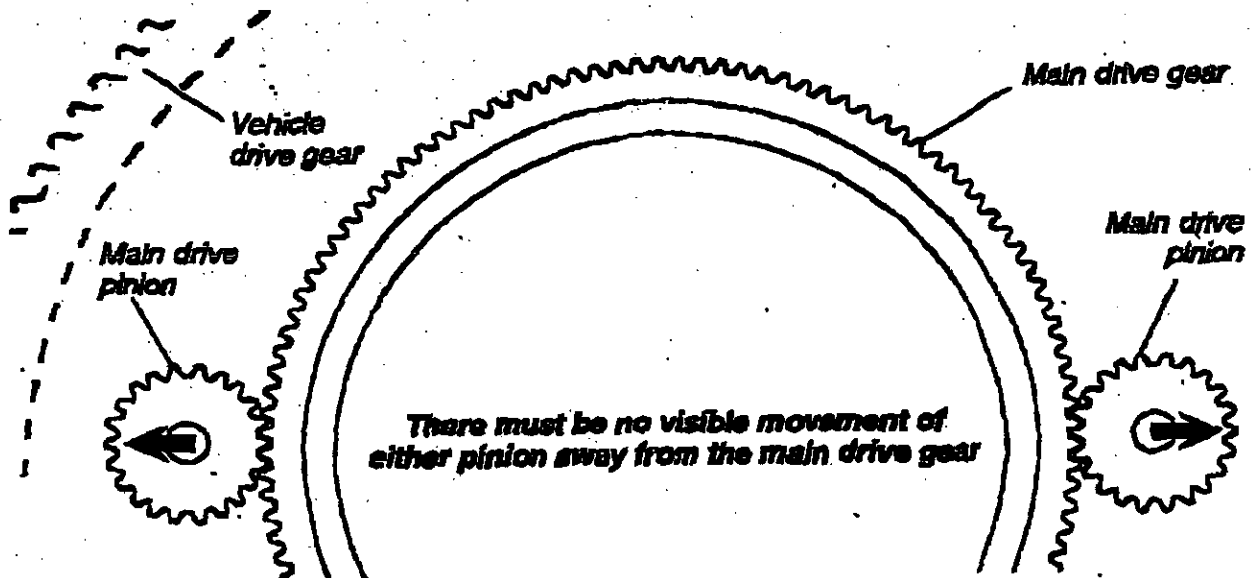
Affected Serial Nos.: **All units**

Model No.: **414**

Detail of Issue (continued):

- DAILY** - Keeping hands and fingers clear of all moving parts, observe the pinions and main drive gear while an assistant manually moves the main arm back and forth slightly. This can be done by standing on one end of the vehicle and "bouncing" it, then doing the same thing at the other end of the vehicle.

Observe the movement of the main drive pinions in relation to the main drive gear. The pinions must only rotate. Any movement away from the main gear indicates a problem in the gearbox.



- DAILY** - Inspect both main drive gearboxes and all four vehicle drive gearboxes. If any gearbox exhibits oil leakage or excessively noisy operation, it is likely that failure of that gearbox has occurred.



CHANCE RIDES, INC.

4219 Irving
Wichita, KS 67277-2328
U.S.A.

Phone: 1-800-242-6231 • FAX: 1-316-942-7415

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: **B414R1245-A**

Release Date: **August 31, 2000**

Effective Date: **August 31, 2000**

Supersedes: **N/A**

Completion Date: **Immediately**

Page: **5 of 5**

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

Affected Production Dates: **All**

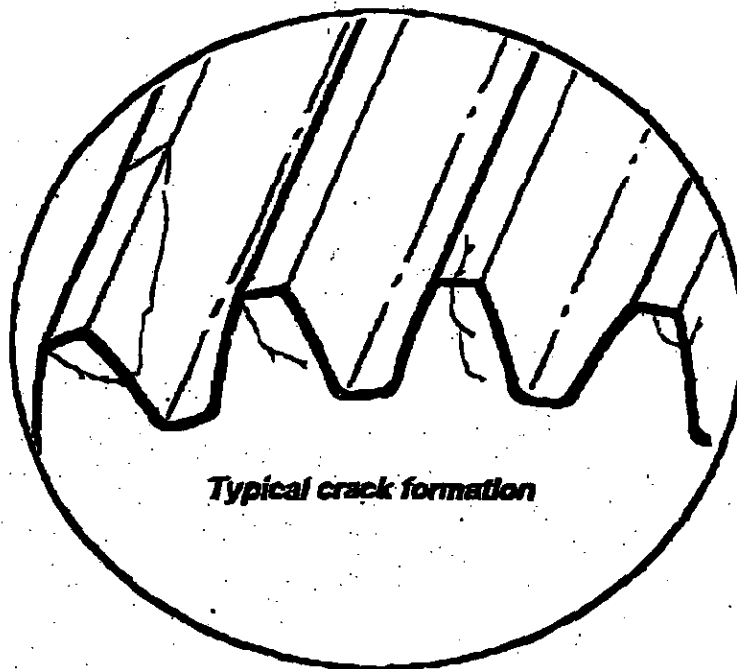
Ride Name: **INVERTER (Portable Model)**

Affected Serial Nos.: **All units**

Model No.: **414**

Detail of Issue (continued):

4. **WEEKLY** - Carefully inspect the teeth on the main drive gear. Look for broken, chipped or cracked gear teeth. If necessary, wipe away the grease to see the teeth clearly. The gear is accessible for inspection through holes in the structure and in the gear guard. If necessary, remove the gear guard.



Typical crack formation



The World's Ride Company

CHANCE RIDES, INC.
 4219 Irving
 Wichita, KS 67277-2328
 U.S.A.

Phone: 1-800-242-5231 • FAX: 1-316-942-7416

Website: www.rides.com

Bulletin No: B414R1244-0

Release Date: September 6, 2000

Effective Date: September 6, 2000

Supersedes: N/A

Completion Date: October 6, 2000

Page: 1 of 3

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
 INVERTER (Park Model)
 DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Hair Guard Rework

Reason For Release:

Chance Rides, Inc. has become aware that the hair guard on the back of the INVERTER vehicle can become deformed during extreme temperature fluctuations. If the deformation becomes severe, breakage of the Lexan® material can occur.

Chance Rides, Inc. has developed a kit which reinforces the panel between each mounting point.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to install the Hair Guard Rework Kit, part number K414R1244-0, using the instructions on the following pages of this bulletin. The kit includes all parts necessary to rework one vehicle. For DOUBLE INVERTER, order two kits.

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

Kit K414R1244-0 contains the following parts

| <u>Part Number</u> | <u>Description</u> | <u>Quantity</u> |
|--------------------|--------------------|-----------------|
| 414-0106-013 | STIFFENER | 6 |
| 66149000 | RIVET (3/16 x 3/8) | 30 |

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

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1244-0

Release Date: September 6, 2000

Effective Date: September 6, 2000

Supersedes: N/A

Completion Date: October 6, 2000

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All units

INVERTER (Park Model)

DOUBLE INVERTER

Model No.: 414

Detail of Issue:**Installation Instructions**

IMPORTANT: This kit must be installed during moderate temperatures. This will prevent excessive stress on the components during hot or cold temperature extremes.

1. Locate the stiffener on the back side of the hair guard panel as shown. The bottom of the stiffener should rest on top of the steel tube of the vehicle frame. Center the stiffener on the panel, with equal spaces at each end.
2. Using one of the holes in the stiffener as a guide, drill a 7/32" diameter hole through the Lexan panel. Do not drill the steel frame.
3. Install one of the rivets provided with the kit to attach the stiffener to the panel. This will hold the stiffener in place while the remaining holes are drilled.
4. Drill the remaining four holes in the panel to match the holes in the stiffener. Install four more rivets to attach the panel to the stiffener.
6. Repeat the process for the five remaining hair guard panels.

NOTICE

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

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1244-0

Release Date: September 6, 2000

Effective Date: September 6, 2000

Supersedes: N/A

Completion Date: October 6, 2000

Page: 3 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

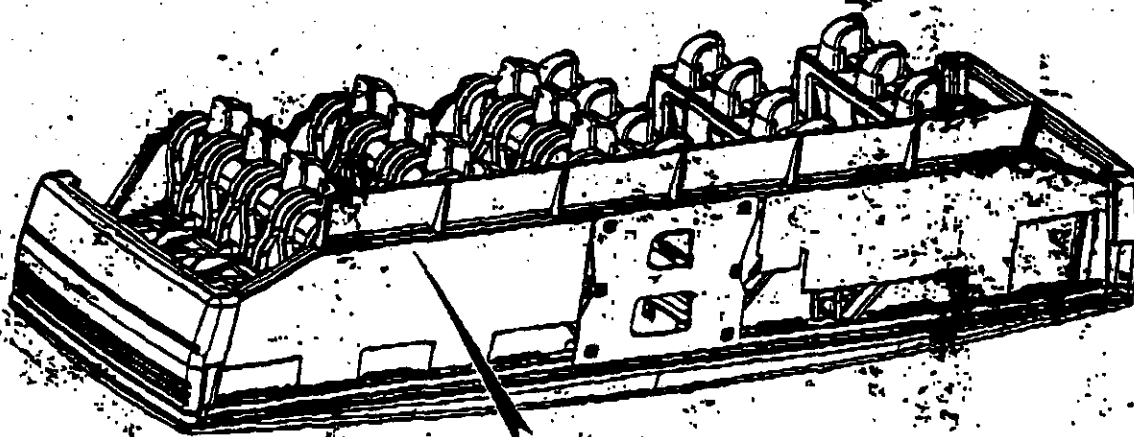
Affected Serial Nos.: All units

INVERTER (Park Model)

DOUBLE INVERTER

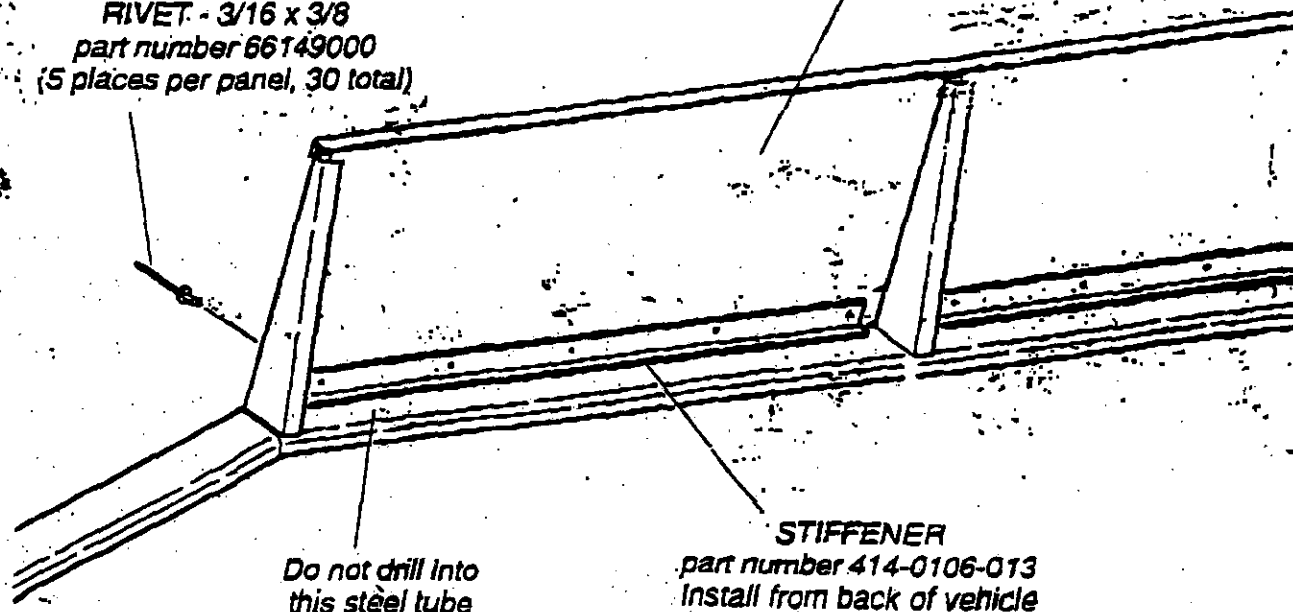
Model No.: 414

Detail of Issue (continued):



Hair guard panel

RIVET - 3/16 x 3/8
part number 66149000
(5 places per panel, 30 total)



Do not drill into
this steel tube

STIFFENER
part number 414-0106-013
Install from back of vehicle
(6 places)

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1246-0

Release Date: September 19, 2000

Effective Date: September 19, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 1 of 3

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:**Main Arm Inspection****Reason For Release:**

Chance Rides, Inc. has become aware that cracks can form near the hub of the main arm on the above noted INVERTER amusement rides.

Action to be Taken:

Chance Rides, Inc. requires all owner/operators of these rides to inspect the main arm in the area near the hub. This is a weekly inspection.

Detail of Issue:

Perform the inspection described on the next page of this bulletin. If any indications are found, DO NOT CONTINUE TO OPERATE 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 MAIN ARM, 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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**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1246-0

Release Date: September 19, 2000

Effective Date: September 19, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: All Units

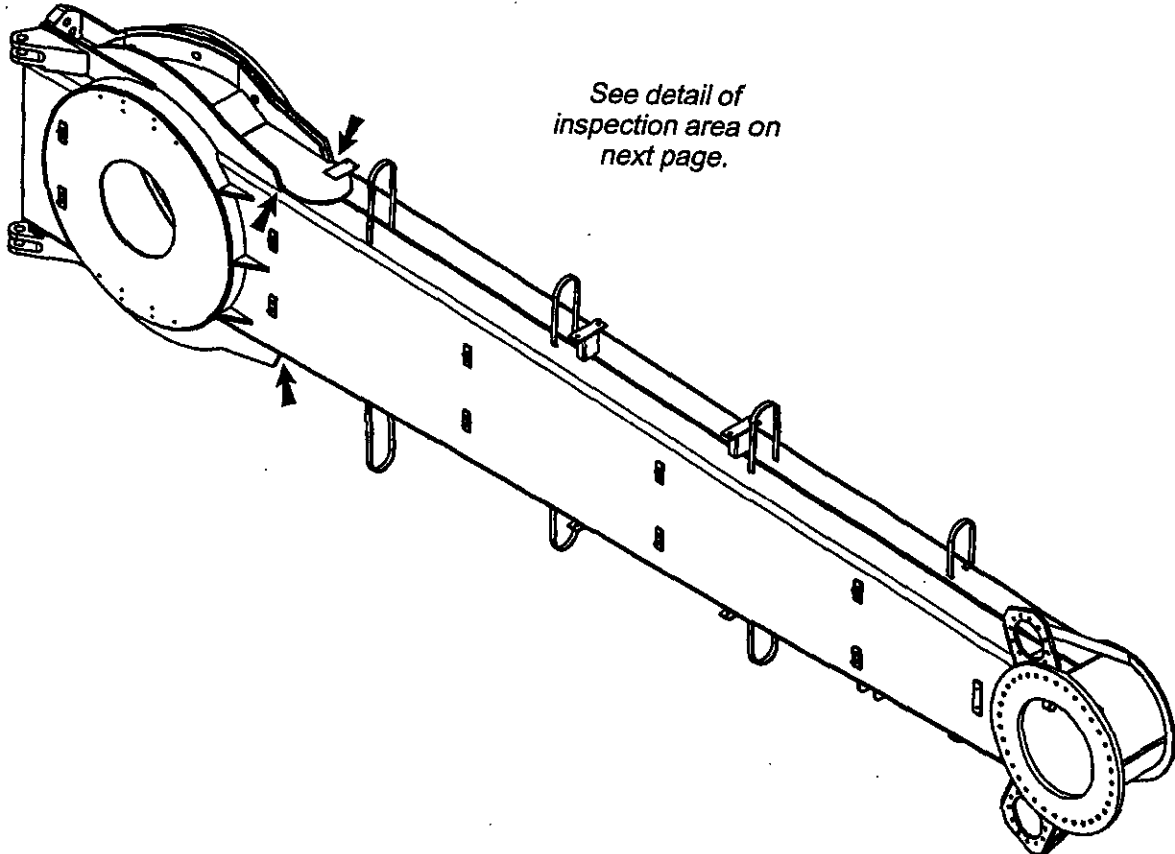
Model No.: 414

Detail of Issue (continued):

WEEKLY INSPECTION PROCEDURE

Visually all four corners of the main arm in the areas indicated by arrows in the following illustration. To inspect the areas closest to the tower, it will be necessary to use a mirror.

If any cracks are found, do not continue to operate the ride. Contact the CHANCE Customer Service Department for instructions on further action to be taken.



**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1246-0

Release Date: September 19, 2000

Effective Date: September 19, 2000

Supersedes: N/A

Completion Date: Immediately

Page: 3 of 3

Ride Manufacturer: CHANCE RIDES, INC.

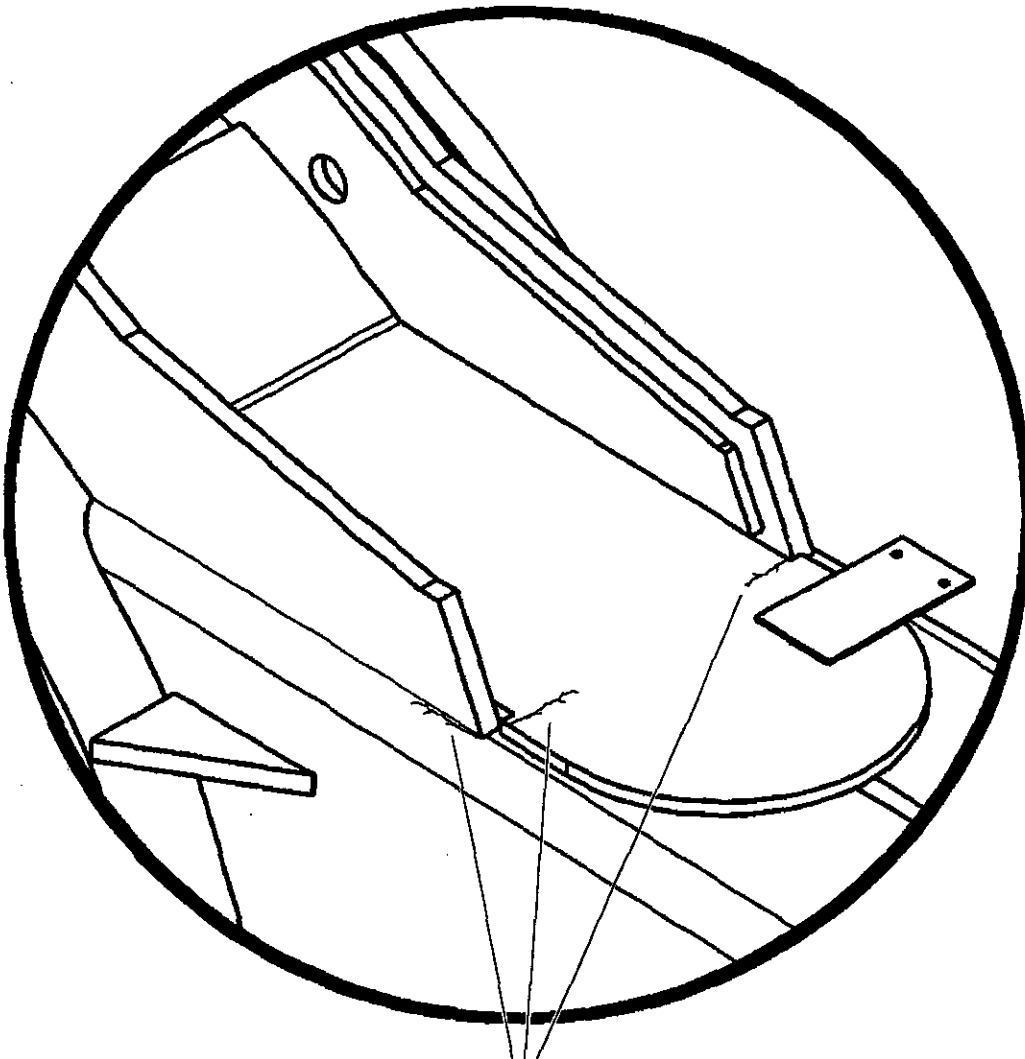
Affected Production Dates: All

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):



Inspect all four corners for cracks in these areas

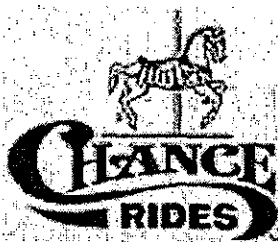
Mike Triplett

From: Richard Osworth <rosworth@dca.state.nj.us>
 To: Michael Triplett <mtriplett@dca.state.nj.us>
 Sent: Friday, October 27, 2000 10:02 AM
 Subject: Fw: Inverter Problems Continue

----- Original Message -----

From: Michael W Rinehart <rineham@doacs.state.fl.us>
 To: Ron Brooks <brooksr@doacs.state.fl.us>; Randy Fleck
 <flecker@doacs.state.fl.us>; Jerry Callahan <callahj@doacs.state.fl.us>;
 Cliff Groscurth <groscuc@doacs.state.fl.us>; Brad Mosher
 <mosherb@doacs.state.fl.us>; Allan Harrison <harrisa@doacs.state.fl.us>;
 Timothy Simpson <simpsot@doacs.state.fl.us>; Carlos Corvo
 <corvoc@doacs.state.fl.us>; Gary Fisher <fisherg@doacs.state.fl.us>; Hunter
 Lyles <lylesh@doacs.state.fl.us>; Jerry Winters <winterj@doacs.state.fl.us>;
 Charlie Stegall <stegalc@doacs.state.fl.us>; Larry Cook
 <cookl@doacs.state.fl.us>; Keith Garner <garnerk@doacs.state.fl.us>; Roland
 Guay <guayr@doacs.state.fl.us>; Isadore Rommes <rommesi@doacs.state.fl.us>;
 Carl Dills <carl.dills@kyagr.com>
 Sent: Friday, October 27, 2000 11:06 AM
 Subject: Inverter Problems Continue

- > According to Dan Dudley the Inverter at the Texas State Fair had its
- > share of problems the last three weeks. Bud Reynolds (Falling Star
- > Amusements) had to have the main drive gearboxes replaced three times
- > over a period of 24 days at the TX state fair.
- >
- > Dan advises the daily, or more frequent, inspections of the gear box is
- > absolutely essential if the ride is to operate safely. First sign of a
- > problem is the seals start leaking and then the shaft starts to get some
- > slop and and then wobble. Catastrophic failure, with the gondola
- > augering in to the ground and/or platform, is the result of not
- > catching the problem.
- >
- > These checks/inspections must be conducted by the owner/operator
- > pursuant with the following Chance Bulletins:
- > B414R1242-0, dated June 16, 2000 (BFI 00-24)
- > B414R1245-A, dated August 31, 2000. (BFI 00-21)
- >
- > Mike Rinehart
- > Fla BFI
- >
- >

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1247-0

Release Date: November 15, 2000

Effective Date: November 15, 2000

Supersedes: N/A

Completion Date: N/A

Page: 1 of 3

NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Vehicle Step Lift Arm

Reason For Release:

Chance Rides, Inc. has developed a new lift arm for the vehicle step on the above noted INVERTER amusement rides. The new lift arm is made of steel, not aluminum, to provide longer service life.

Action to be Taken:

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

Detail of Issue:

Order and install the new LIFT ARM ASSEMBLY (part number 414-0134-001) and one 3/8-16 LOCKNUT (part number 64781600). These parts will be offered at a reduced price if ordered within 30 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.

NOTICE

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

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1247-0

Release Date: November 15, 2000

Effective Date: November 15, 2000

Supersedes: N/A

Completion Date: N/A

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

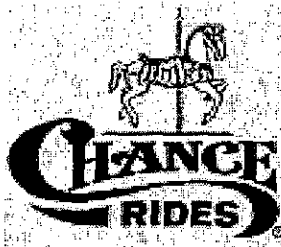
Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

INSTALLATION INSTRUCTIONS

1. The step must be in the down position
2. Remove the fasteners which secure the lift arm assembly to the air cylinder. These are accessible from under the vehicle. Save the fasteners for installation of the new lifting arm.
3. Remove the nut which secures the roller through the slot in the lifting arm. Pay attention to how these parts are installed so that they can be re-assembled in the exact same way. Discard the nut, but save the roller.
4. Remove the two small sections of flooring from the step. Remove and save the fasteners which secure the lifting arm to the step.
5. Install the new lifting arm using the existing fasteners at both ends.
6. Install the roller using the new locknut provided.

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

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Bulletin No: P414R1247-0

Release Date: November 15, 2000

Effective Date: November 15, 2000

Supersedes: N/A

Completion Date: N/A

Page: 3 of 3

Ride Manufacturer: CHANCE RIDES, INC.

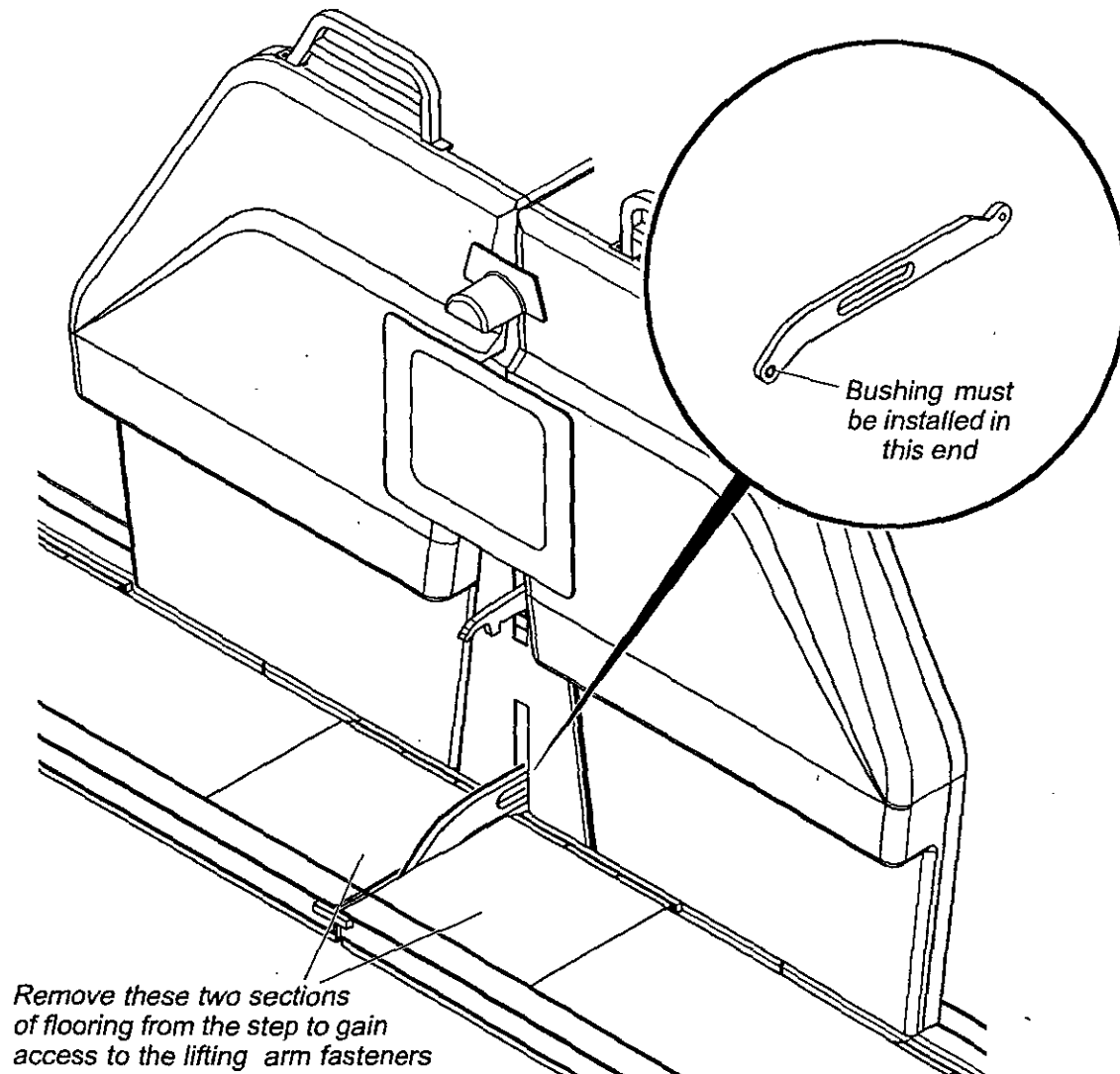
Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):



**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1252-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: July 15, 2001

Page: 1 of 2

SERVICE BULLETIN

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:

Slewing Ring and Drive Gear Lubrication and Inspection

Reason For Release:

Chance Rides, Inc. has become aware of the difficult access to the main drive gear and pinions for lubrication and inspection of these components (refer to the *INVERTER Service Manual* and Chance Rides Service Bulletin B414R1245-A). Proper lubrication and inspection at the specified intervals are necessary to obtain satisfactory service life and safe operation of these components.

Modification of the existing gear guard will improve access to this area and reduce the possibility of objects becoming lodged in the gear teeth.

Action to be Taken:

All owner/operator's of the above noted INVERTER amusement rides are required to modify the gear guard as described in this bulletin.

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

NOTICE

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

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**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1252-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: July 15, 2001

Page: 2 of 2

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: Prior to May, 2001

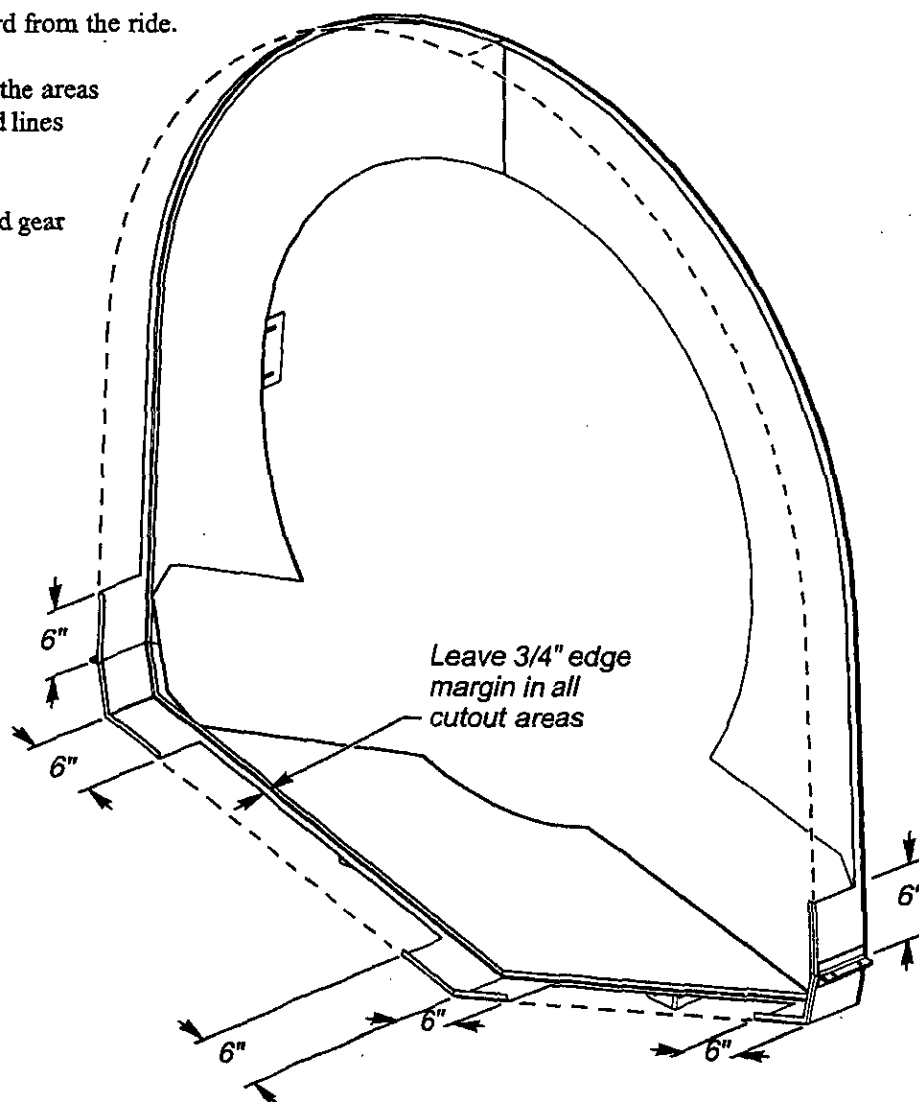
Ride Name: INVERTER - Portable Model

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Detail of Issue**Modification Instructions**

1. Remove gear guard from the ride.
2. Mark and cut out the areas indicated by dotted lines in the illustration.
3. Install the modified gear guard on the ride.



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4219 Irving
Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: P414R1248-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: N/A

Page: 1 of 3

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:

Main Drive Gearbox Kit

Reason For Release:

Frequent inspection is necessary to minimize problems with the main drive gearboxes and main drive gears on the above noted INVERTER amusement rides. The inspections required are outlined in detail in the *INVERTER Service Manual* and Chance Rides Service Bulletin B414R1245-A (Main Drive Inspection - Daily and Weekly Inspection Points, August 31, 2000).

This notification describes an improved main drive gearbox kit which provides longer service life for the main drive components. This kit can be ordered and installed at the owner/operator's option.

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 to replace both main drive gearboxes and related mounting components. The new gearboxes features larger output shaft bearings, and the mounting configuration eliminates pinion gear misalignment which can cause ring gear failure on the main bearing.

Order and install the Main Drive Gearbox Kit, number K414R1248-0. This 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 issue date of this notification.

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.

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: P414R1248-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: N/A

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

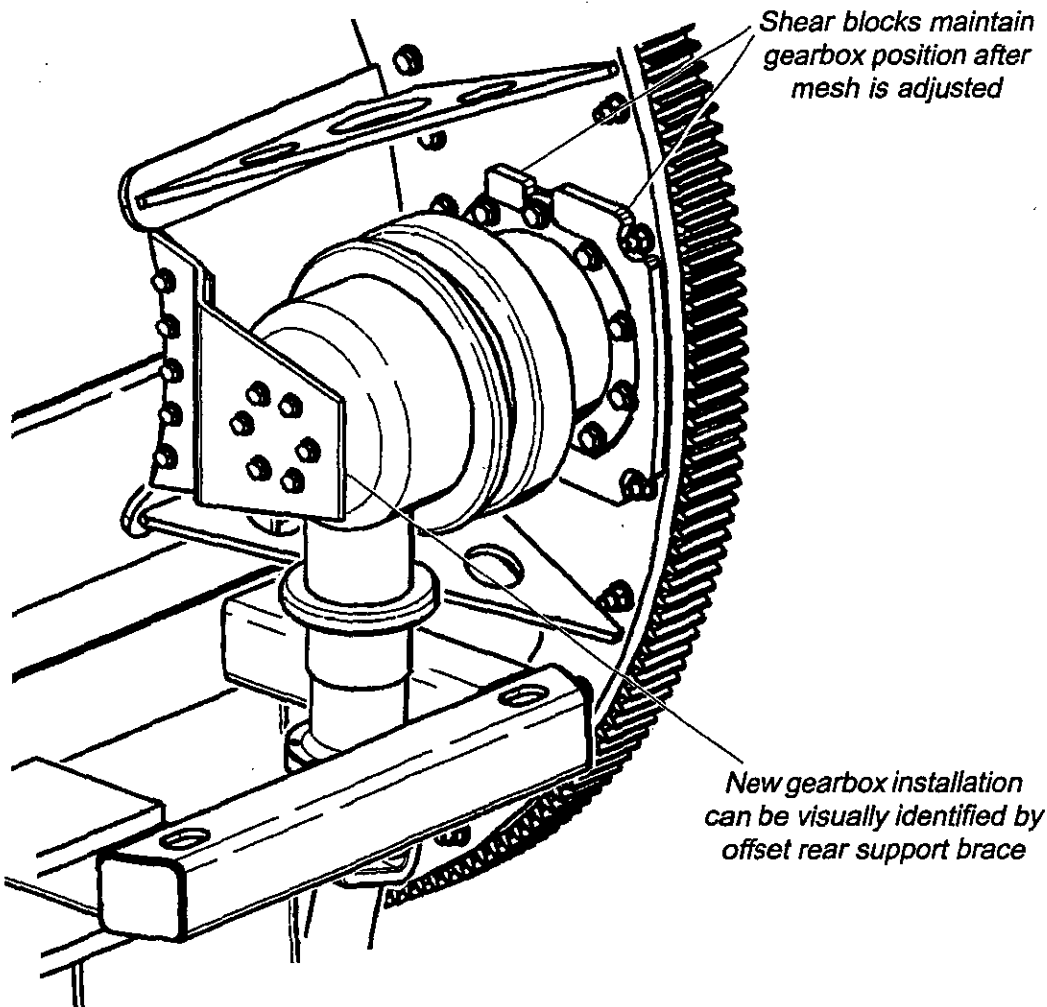
Affected Production Dates: Prior to May, 2001

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Action to be taken



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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1248-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: N/A

Page: 3 of 3

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

Action to be taken (continued):

The Main Drive Gearbox Kit, part number K414R1248-0, contains the following:

| <u>Part Number</u> | <u>Component</u> | <u>Quantity</u> |
|--------------------|--|-----------------|
| K414R1248-0 | Drawing - Installation Instructions | 1 |
| 414-0730-060 | Gearbox | 2 |
| 414-0730-059 | Shear block | 2 |
| 414-0730-061 | Shear block | 4 |
| 414-0730-062 | Brace - Rear Support | 2 |
| 414-00361-002 | Cap - Pinion | 2 |
| 61075801 | Socket Head Capscrew (M10-1.5 x 25 mm) | 6 |
| 60687100 | Hex Head Capscrew (M16-2 x 55 mm 10.9) | 20 |
| 68552900 | Flat Washer - Hardened (5/8) | 20 |

NOTICE

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

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Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

Bulletin No: P414R1253-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: B414R1223-0

Completion Date: N/A

Page: 1 of 3

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:**Tower Hinge Bracket Kit****Reason For Release:**

Chance Rides, Inc. has become aware that cracks can develop in the tower hinge on the above noted INVERTER amusement rides, due to improper set-up and tear-down procedures. The correct set-up and tear-down procedures 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 tower hinge kit which strengthens the hinge area. It can be ordered and installed at the owner/operator's option. If the owner/operator chooses to make this improvement, this notification supersedes Chance Rides service bulletin B414R1223-0 (Tower Hinge Bracket Inspection and Rework, August 9, 1999). If this option is not chosen, service bulletin B414R1223-0 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 to replace the upper tower hinge brackets and the hinge pin. The benefit of the kit is additional strength in the tower hinge area. This improvement is not to be considered an alternative to the correct set-up and tear-down procedures.

Order and install the Tower Hinge Rework Kit, number K414R1253-0. This 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 180 days of the issue date of this notification.

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1253-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: B414R1223-0

Completion Date: N/A

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: Prior to May, 2001

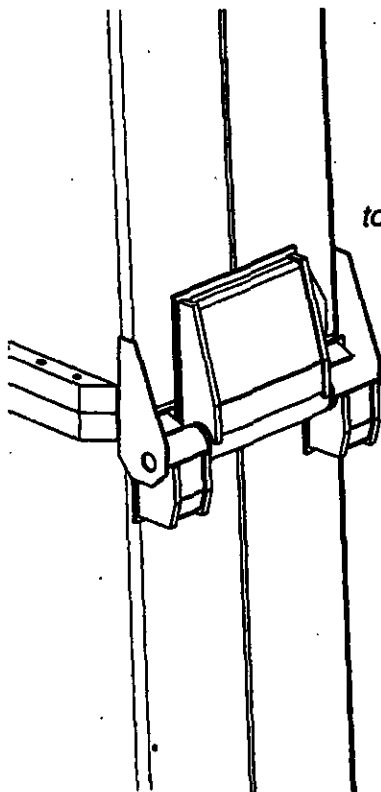
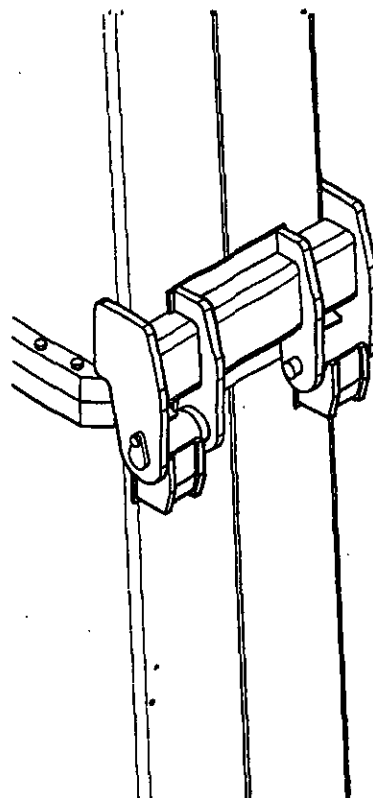
Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Action to be taken

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.

*Existing
tower hinge**Reworked
tower hinge*

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: P414R1253-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: B414R1223-0

Completion Date: N/A

Page: 3 of 3

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

Action to be taken (continued):

The Tower Hinge Bracket Kit, part number K414R1253-0, contains the following:

| <u>Part Number</u> | <u>Component</u> | <u>Quantity</u> |
|--------------------|--|-----------------|
| K414R1253-0 | Drawing - Installation Instructions | 1 |
| 414-0780-002 | Center Ear Weldment | 1 |
| 414-0780-005 | Center Ear Weldment | 1 |
| 414-0780-011 | Plate - Formed Channel | 1 |
| 414-0780-013 | Plate - Side Hinge Ear | 2 |
| 414-0780-015 | Bar - Spacer | 2 |
| 414-0780-005 | Hinge Pin Weldment | 2 |
| 60842800 | Hex Head Capscrew (1/2-13 x 2-1/2 Grade 5) | 2 |
| 64782400 | Lock Nut (1/2-13 Nylon Insert) | 2 |
| 68531800 | Flat Washer (1/2) | 4 |

NOTICE

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

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1254-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: B414R1224-0

Completion Date: N/A

Page: 1 of 7

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.

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1254-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: B414R1224-0

Completion Date: N/A

Page: 2 of 7

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

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.

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: P414R1254-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: B414R1224-0

Completion Date: N/A

Page: 3 of 7

Ride Manufacturer: CHANCE RIDES, INC.

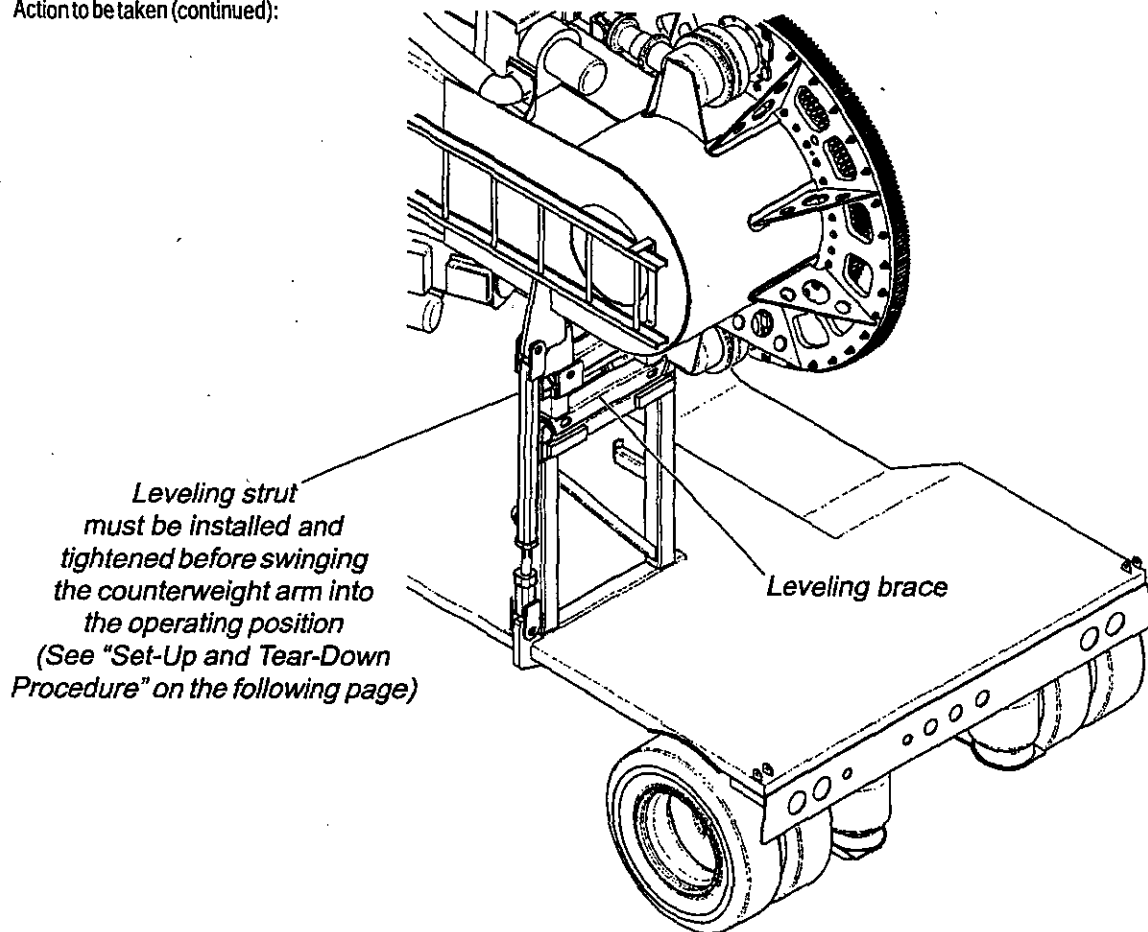
Affected Production Dates: Prior to May, 2001

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Action to be taken (continued):

**NOTICE**

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Release Date: June 15, 2001

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Supersedes: B414R1224-0

Completion Date: N/A

Page: 4 of 7

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

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.



CHANCE RIDES, INC.

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Completion Date: N/A

Page: 5 of 7

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

Action to be taken (continued):

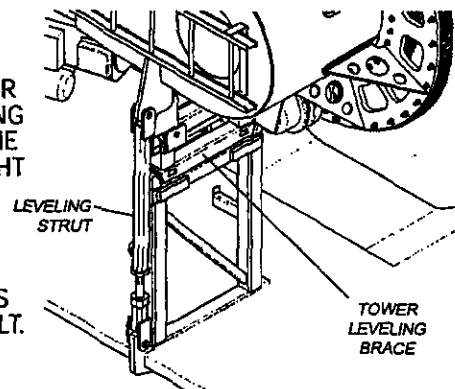
! WARNING

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



414-0010-047

! WARNING

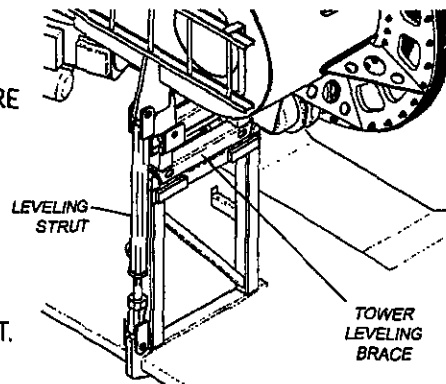
DURING TEAR-DOWN -

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



414-0010-048

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1254-0

Release Date: June 15, 2001

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Supersedes: B414R1224-0

Completion Date: N/A

Page: 6 of 7

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

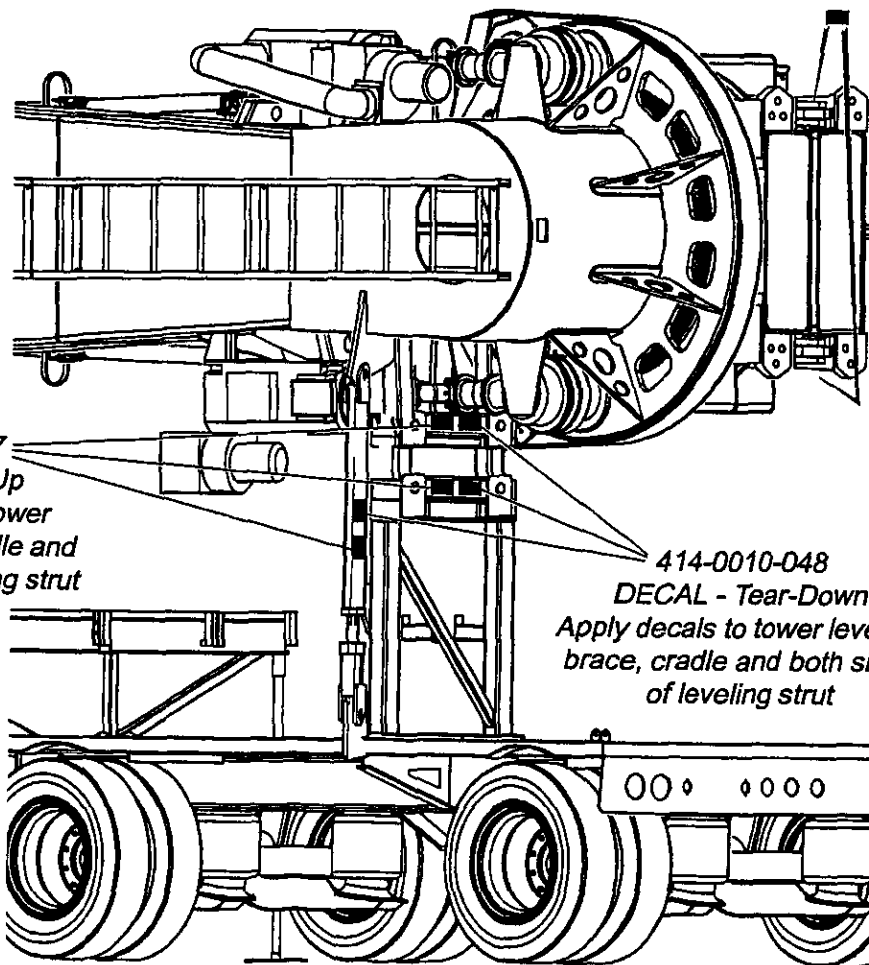
Model No.: 414

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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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

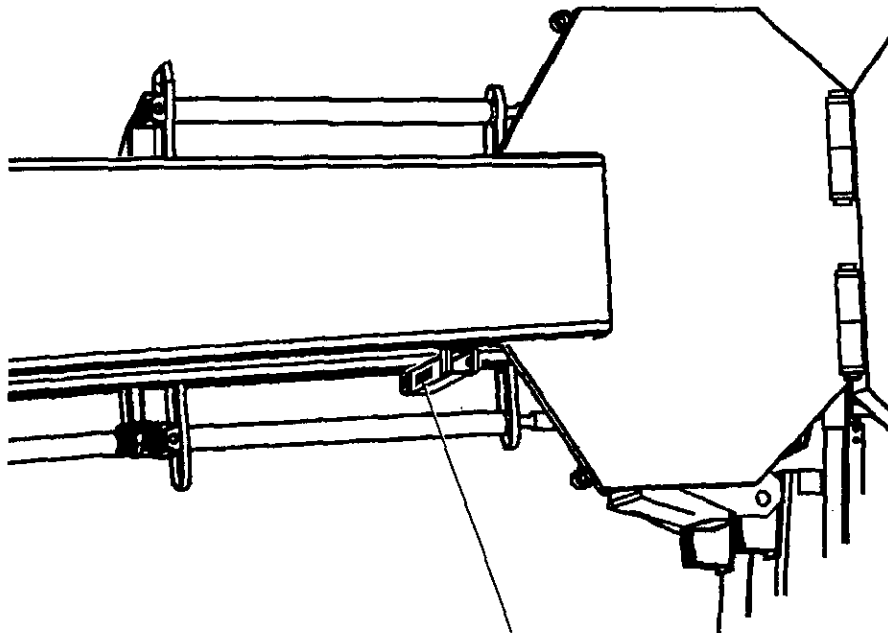
Affected Production Dates: Prior to May, 2001

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Action to be taken (continued):



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

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Wichita, KS 67277-2328

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1258-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: N/A

Page: 1 of 2

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:

Slewing Ring and Drive Gear Drip Tray

Reason For Release:

Chance Rides Service Bulletin B414R1253-0 (June 15, 2001) requires modification of the gear guard to improve access for inspection and lubrication of the slewing ring and drive gears. A drip tray has been developed to minimize grease dropping from the gears if excessive lubricant is allowed to accumulate.

Action to be Taken:

All owner/operator's of the above noted INVERTER amusement rides can, at their option, install the drip tray using the instructions on the following page of this notification. Order the Drip Tray Kit, part number K414R1258-0, 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 notification.

Kit number K414R1258-0 contains the following:

| <u>Part Number</u> | <u>Component</u> | <u>Quantity</u> |
|--------------------|----------------------------------|-----------------|
| 414-0236-001 | Drip Tray | 1 |
| 60766600 | - Hex Head Capscrew (3/8-16 x 1) | 4 |
| 68531000 | Flat Washer (3/8) | 4 |
| 68537400 | Lock Washer (3/8) | 4 |

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

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: P414R1258-0

Release Date: June 15, 2001

Effective Date: June 15, 2001

Supersedes: N/A

Completion Date: N/A

Page: 2 of 2

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

Detail of Issue (continued):

Drip Tray Installation Instructions**NOTE:** Modified gear guard not shown in this illustration

1. Locate drip tray as shown.
2. Drill 5/16" diameter holes through tower gussets to match holes in drip tray.
3. Use a 3/8-16 tap to thread the holes in the tower gussets.
4. Secure the drip tray to the tower gussets with 3/8-16 x 1" hex head capscrews, flat washers and lock washers.

Drip Tray
(part number 414-0236-001)

Secure drip tray to tower gussets with:

3/8-16 x 1" Hex Head Capscrews

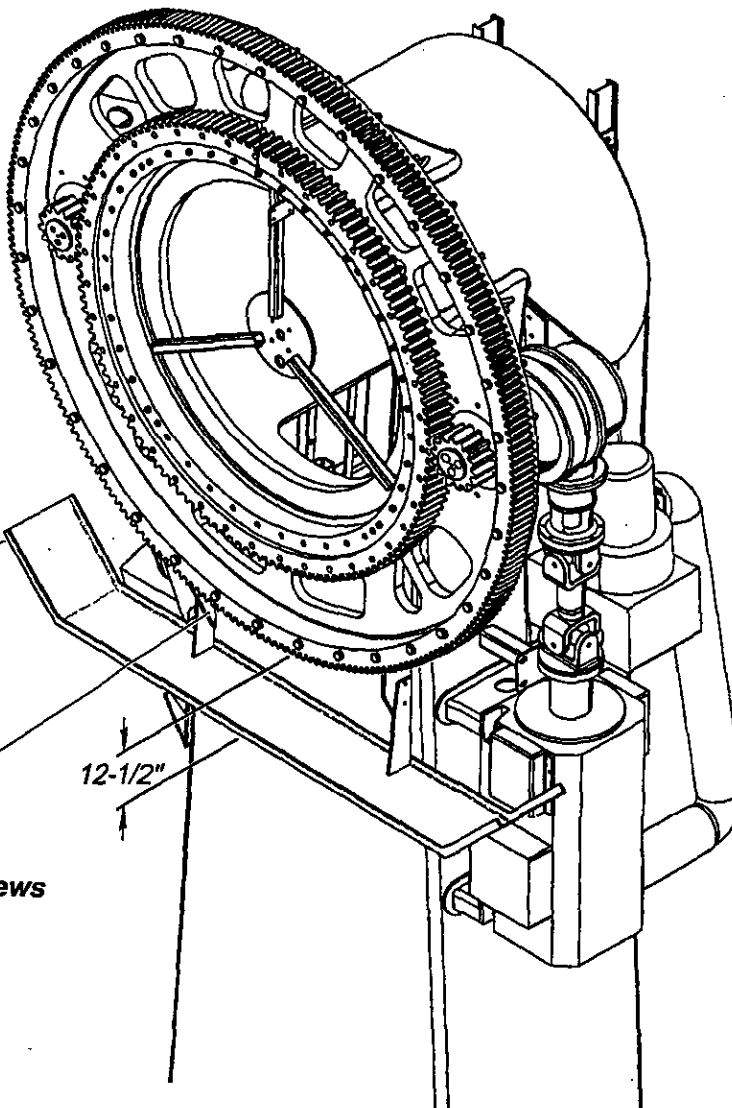
(part number 60766000)

3-8" Flat Washers

(part number 68531000)

3/8" Lock washers

(part number 68537400)



**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1262-0

Release Date: August 20, 2001

Effective Date: August 20, 2001

Supersedes: N/A

Completion Date: N/A

Page: I of 3

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:

Counterweight Arm Fastener Inspection

Reason For Release:

The counterweight arm on the above noted INVERTER amusement rides is secured to the hub with six 1-1/4-7 x 7 ASTM A325 hex head capscrews, with hardened flat washers and ASTM A325 nuts. These fasteners must be checked daily with an accurate torque wrench to ensure they are properly tightened, as outlined in the *INVERTER Service Manual*.

An alternative fastener has been approved by Chance Rides, Inc., which permits the daily check to be performed without the use of a torque wrench.

Detail of Issue:

At the owner operator's option, a special fastener can be used in this location, along with the original hardened flat washer and ASTM A325 nut. The fastener is manufactured under the brand name of RotaBolt®. It is specially calibrated for this specific application, and features a control cap which rotates by hand if the fastener is not tightened to the correct specification. Once the correct tightness is obtained, the control cap cannot be rotated by hand.

If desired, order six RotaBolts (part number 20744100) and install as described in this bulletin. These specially calibrated fasteners can only be obtained from Chance Rides, Inc. RotaBolts are the only approved alternative to the 1-1/4-7 x 7 A325 capscrews shown in the service manual. **DO NOT SUBSTITUTE ANY OTHER FASTENERS FROM ANY OTHER SUPPLIER IN THIS LOCATION.**

Daily inspection of RotaBolts is required, the same as the standard ASTM A325 capscrews. The daily inspection procedure is provided in this bulletin. Annual replacement of RotaBolts is required, the same as all other frequently removed fasteners, per the *INVERTER Service Manual*.

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

Model No.: 414

Action to be taken (

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.

RotaBolt® Installation Instructions

1. Inspect the condition of the lock plate. If damaged, replace it with a new part. Grind the welds to remove the old lock plate. To ensure correct alignment do not weld the replacement lock plate in place until the capscrews are installed.

NOTE: The lock plate on some rides was made of 10 gauge steel. The material on the replacement lock plate is 1/4" steel.

2. Install RotaBolts in the six holes of the counterweight arm flange. The RotaBolts must be installed as shown, with the heads engaged in the hexagonal holes of the lock plate. Install the hardened flat washers and nuts.

NOTE: Either RotaBolts or the specified ASTM A325 capscrews are acceptable. However, all six fasteners must be the same. Do not mix different fasteners.

3. Using an appropriate wrench, tighten the three nuts on one flange evenly until the control caps on the three RotaBolts cannot be turned by hand. DO NOT OVER-TIGHTEN. Repeat the process on the other flange. Do not use a torque wrench - damage to the torque wrench can result.

RotaBolt® Inspection

Inspect the RotaBolt daily by turning the control cap on each RotaBolt. If it turns by hand, tighten the nut until the control cap cannot be turned by hand. DO NOT OVER-TIGHTEN.

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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All Units

Model No.: 414

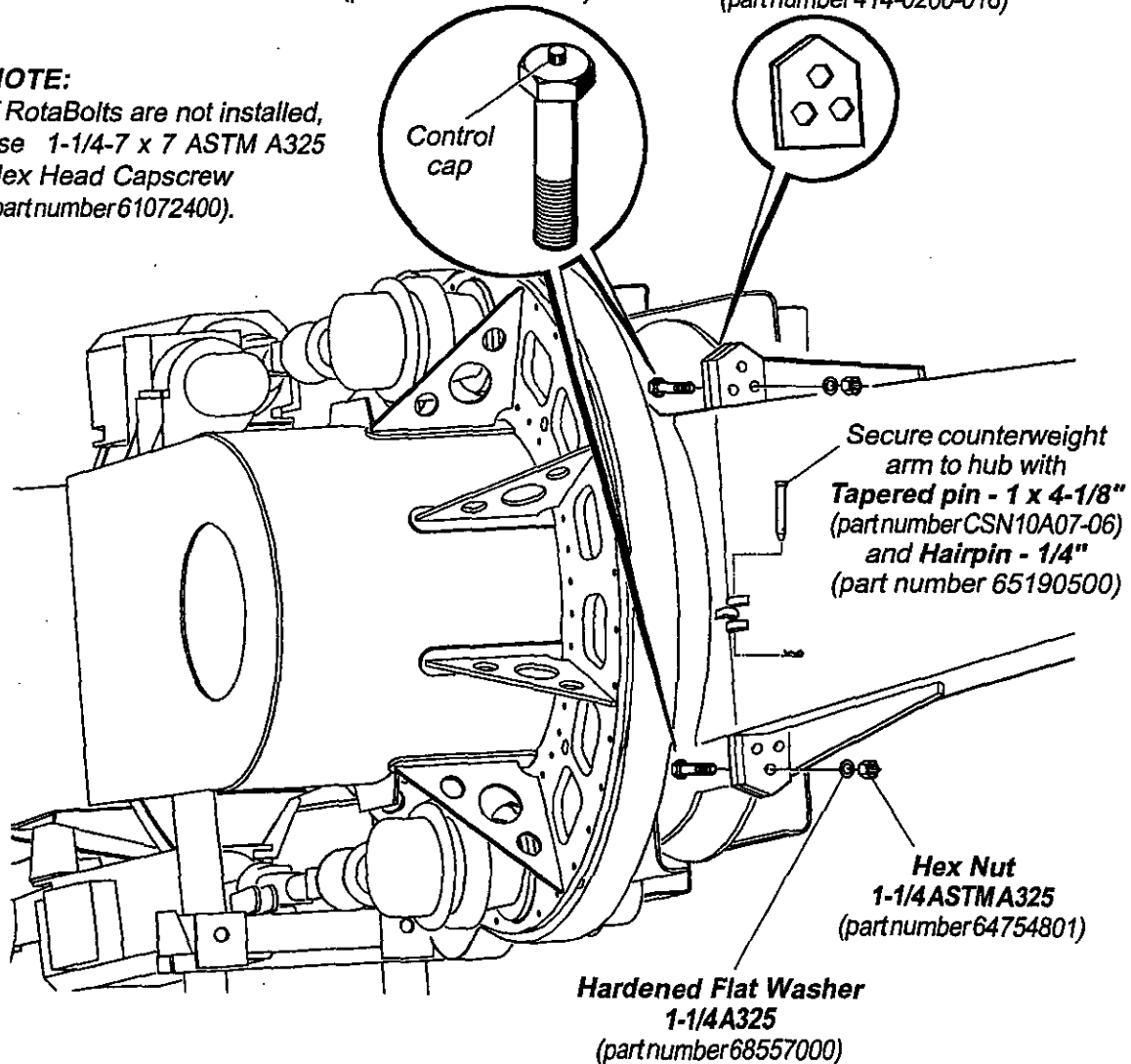
Action to be taken (continued):

NOTE:

If RotaBolts are not installed,
use 1-1/4-7 x 7 ASTM A325
Hex Head Capscrew
(part number 61072400).

RotaBolt®
(part number 20744100)

Lock Plate
(part number 414-0200-016)





The World's Ride Company

CHANCE RIDES, INC.

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

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Release Date: September 17, 2001

Effective Date: September 17, 2001

Supersedes: N/A

Completion Date: N/A

Page: 1 of 5

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:

DC Motor Inspection and Maintenance

Reason For Release:

The INVERTER amusement ride is driven by two DC motors (four motors on the DOUBLE INVERTER). As with any machinery, proper maintenance is essential to minimize downtime and provide satisfactory service life. This bulletin describes the normal inspection and maintenance procedures required by the original manufacturer of these motors (Bautronic Corporation, a subsidiary of Baumuller Nurnberg).

Detail of Issue:

Chance Rides, Inc. requires all owner/operators of the above noted INVERTER amusement rides to perform the procedures described in this bulletin in addition to all other scheduled inspection and maintenance. Failure to perform proper maintenance could void the warranty on the motor.

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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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Completion Date: N/A

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All Units

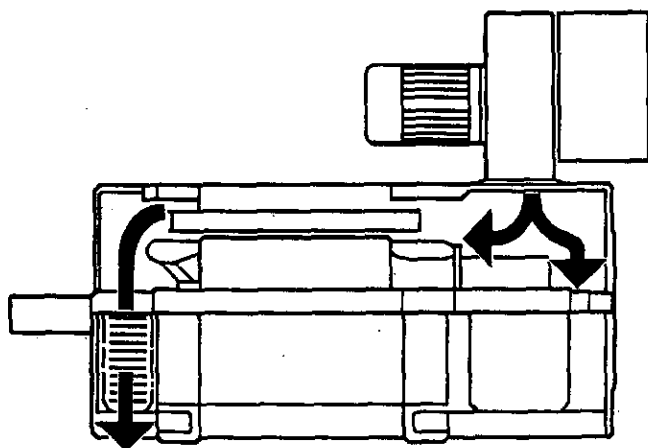
Model No.: 414

Action to be taken:

Intake Filter Inspection and Maintenance

Each motor is cooled by a fan, mounted either on the back of the motor, or remotely mounted and connected to the motor by a metal duct.

The cooling air is drawn through a dust filter at the fan's intake. It is forced through the motor, then exits through openings at the shaft end. The intake filters must be kept clean to allow an adequate flow of air through the motors.



Air Intake Filter

Chance part number 22671801

or Baumuller part number 1801-0527

Clean the filters and inspect for signs of damage at least once a week. Also check the exit openings at the shaft end of the motor. When operating in dusty or damp conditions, it may be necessary to service the filters more frequently. If a filter is damaged, replace it with a new part.

Dry dirt can usually be cleaned by blowing it out. If necessary, remove the filters and wash in a mild solution of lukewarm water and detergent. Rinse and dry filters before installing them.

SWANSON AMUSEMENT
SALES
08/15/01
08/15/01
08/15/01

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Wichita, KS 67277-2328

U.S.A.

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

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Completion Date: N/A

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Action to be taken (continued):

Brush Holders, Carbon Brushes and Commutator Inspection and Maintenance**DANGER:** High voltage. Contact can result in electrocution. Make sure the main circuit breakers are off before performing any work on electrical components.**When maintenance is complete, replace all covers and guards before turning the power back on.****Brush Holders and Carbon Brushes**

Check the condition of the brush holders and carbon brushes every 1000 hours of operation or twice each operating season, whichever occurs first. Check the following:

- Brush wear - Replace the carbon brushes before the brush shunt damages the commutator. The remaining length of the carbon that cannot be used is about 15 mm (0.59 inch). If the carbon brush has a wear indicator, replace it before it wears down to that mark.
- Brush pressure - Brushes must make firm, even contact with the commutator.
- Movement of the brush in the holder - Brushes must move freely, without binding in the holders.
- Firm contact between the carbon brush and the brush shunt.

If necessary, replace ALL the brushes on that motor with new parts. Do not just replace visibly worn or damaged brushes. Each motor has 4 brushes on portable model rides, 8 brushes on park model rides.

To change the carbon brushes, release the locking screws from the operator opening on the side of the terminal box. Loosen and twist the brush rocker.

After changing the brushes, turn the brush rocker back to its original position with the marks on the end shield and the brush rockers lined up exactly with one another.

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Action to be taken (continued):

Commutator

Check the commutator and clean all dust and oil from its surface every 2000 hours of operation or once each operating season, whichever occurs first. Using a clean rag, wipe off any oil and blow away any loose dust with compressed air.

Inspect the commutator for damage, such as burn stains, beads of molten metal, rough areas and small grooves. If necessary, remove minor damage using progressively finer grades of emery cloth. Be careful not to remove too much material. The commutator must remain concentric within 0.02 mm (0.0008 inch).

NOTE: A discoloration ranging from light to dark brown in the brush paths is normal and indicates the equipment is operating properly. Do not try to remove this discoloration.

If necessary, remove minor damage using progressively finer grades of emery cloth. Be careful not to remove too much material. The commutator must remain concentric within 0.02 mm (0.0008 inch).

NOTE: Out of round running surfaces, protruding segments, pitting and severe grooves must be corrected by specialized machining operations. If the commutator has been machined, adjust the brush holder to a distance of 1.5 mm (0.060 inch) to the commutator surface.

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08/15/01
CALIFORNIA AMUSEMENT
RIDES SAFETY PROGRAMS

**CHANCE RIDES, INC.**

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U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Action to be taken (continued):

Carbon Brushes

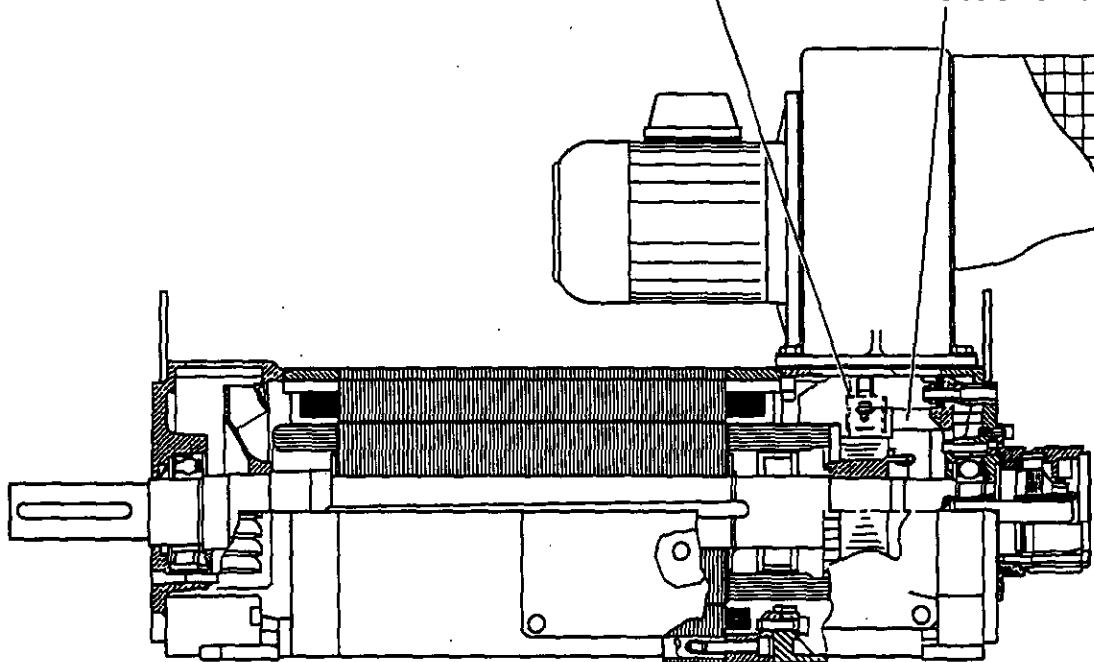
Chance part number 20975101

or Baumuller part number 1801-6903

(4 brushes required for each motor on portable model rides

8 brushes required for each motor on park model rides)

Brush Rocker



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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1266-0

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Completion Date: See Text

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

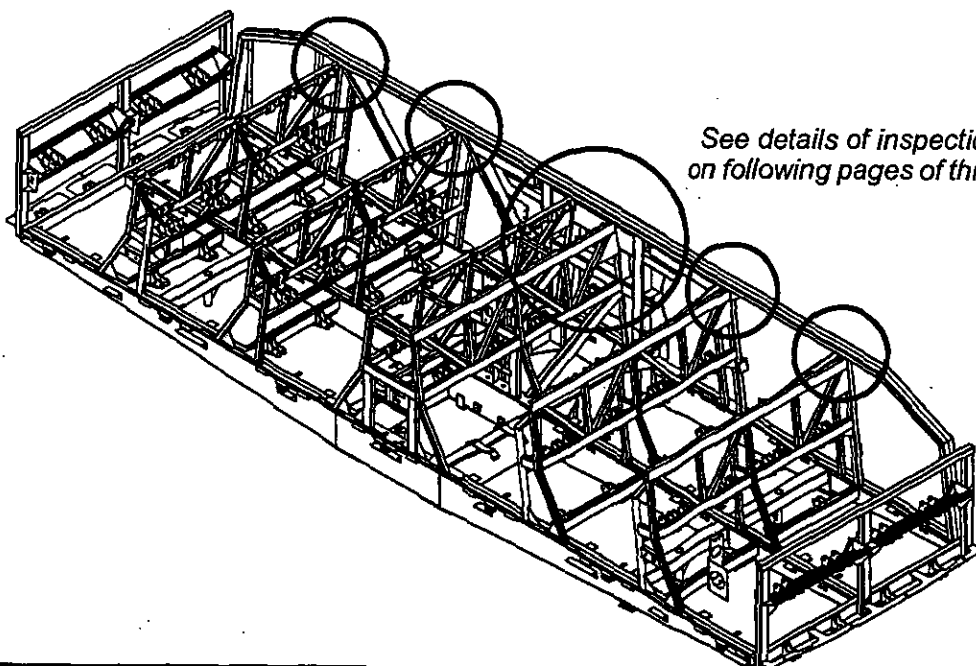
Model No.: 414

Abstract of Issue:**Vehicle Frame Inspection and Rework****Reason For Release:**

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

Action to be Taken:

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



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

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

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Completion Date: See Text

Page: 2 of 13

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue

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

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

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

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

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

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

NOTICE

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

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

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Wichita, KS 67277-2328
U.S.A.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

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

Model No.: 414

Detail of Issue (continued):

PREPARATION OF VEHICLE FOR INSPECTION

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

Removal of Two Center Seats

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

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

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

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Wichita, KS 67277-2328

U.S.A.

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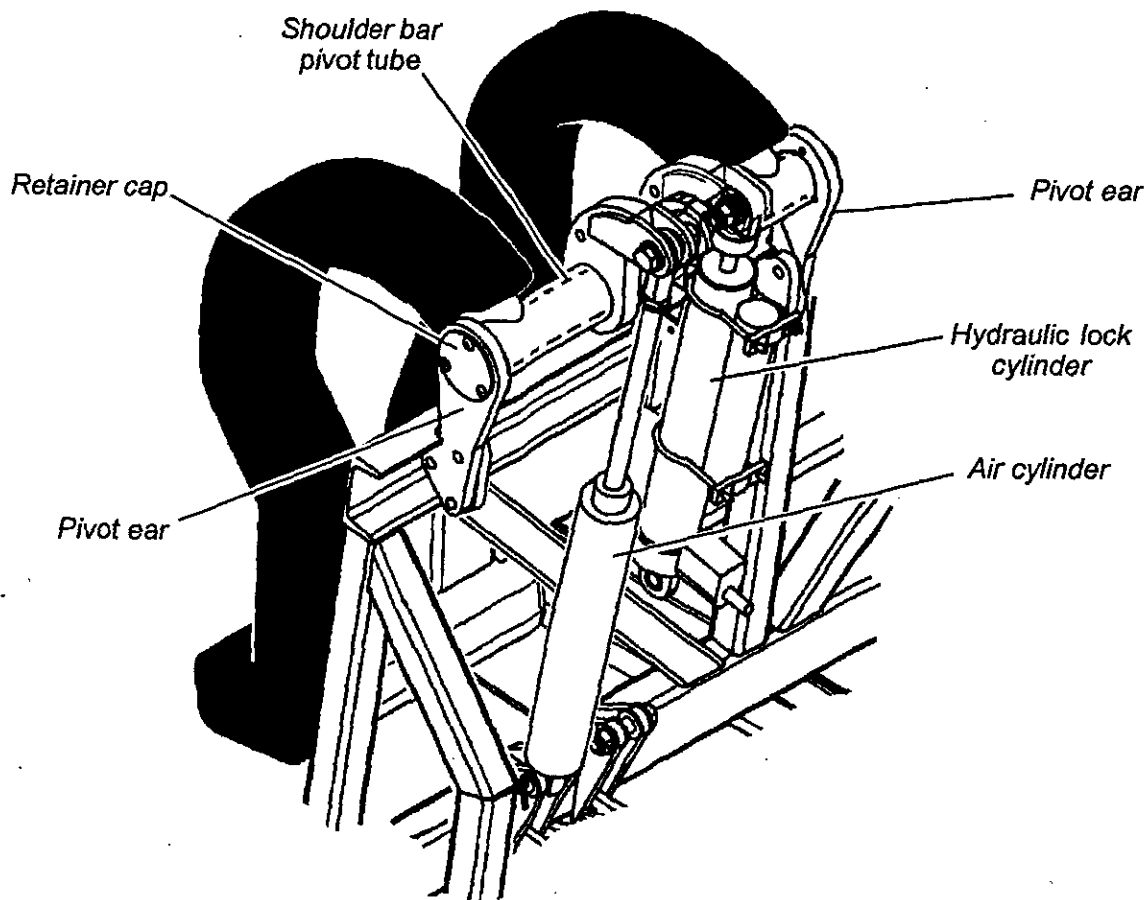
Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of issue (continued):



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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

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

Model No.: 414

Detail of Issue (continued):

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

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

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

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

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

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

Removal of Back Cover Panels

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

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Wichita, KS 67277-2328

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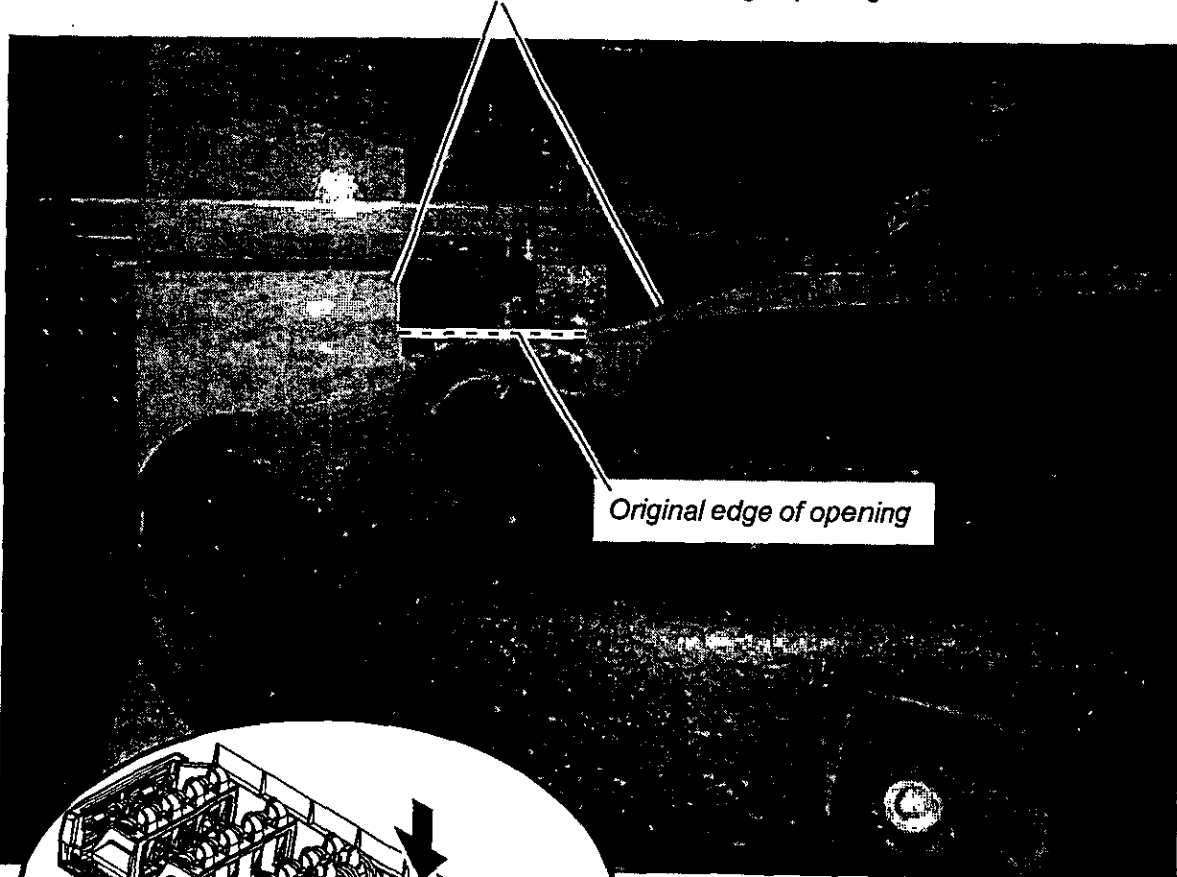
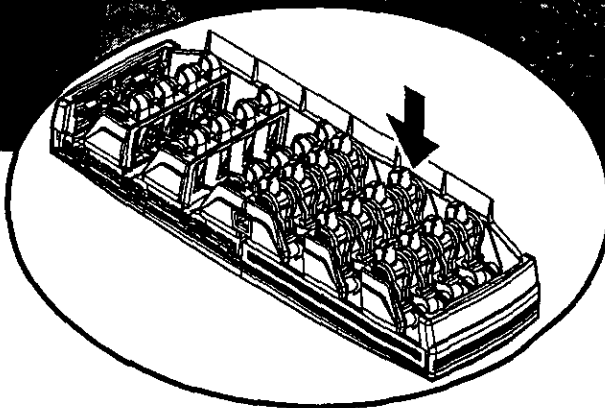
Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue (continued):

Cut fiberglass to enlarge opening*Original edge of opening***TOP VIEW OF SEAT AT BACK WALL**

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

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

Model No.: 414

Detail of Issue (continued):



SAME AREA AFTER FIBERGLASS SEAT HAS BEEN TRIMMED

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue (continued):

INSPECTION PROCEDURE

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

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

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

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

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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Ride Manufacturer: CHANCE RIDES, INC.

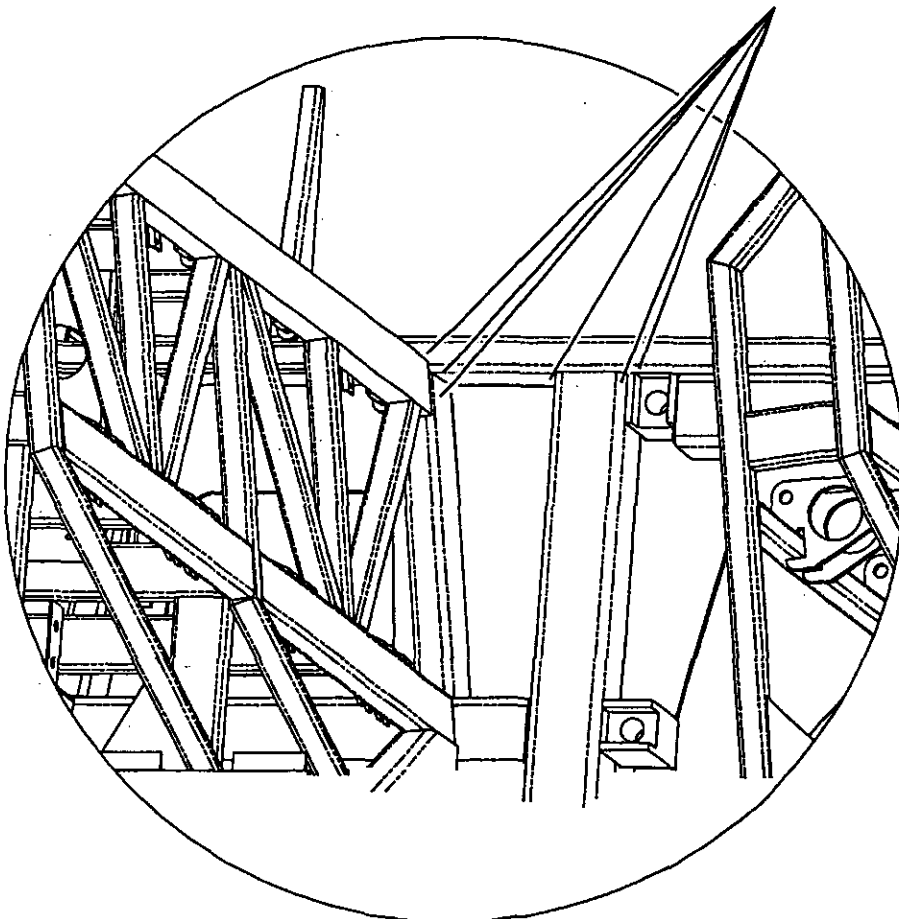
Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue (continued):

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



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

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1266-0

Release Date: February 12, 2002

Effective Date: February 12, 2002

Supersedes: N/A

Completion Date: See Text

Page: 10 of 13

Ride Manufacturer: CHANCE RIDES, INC.

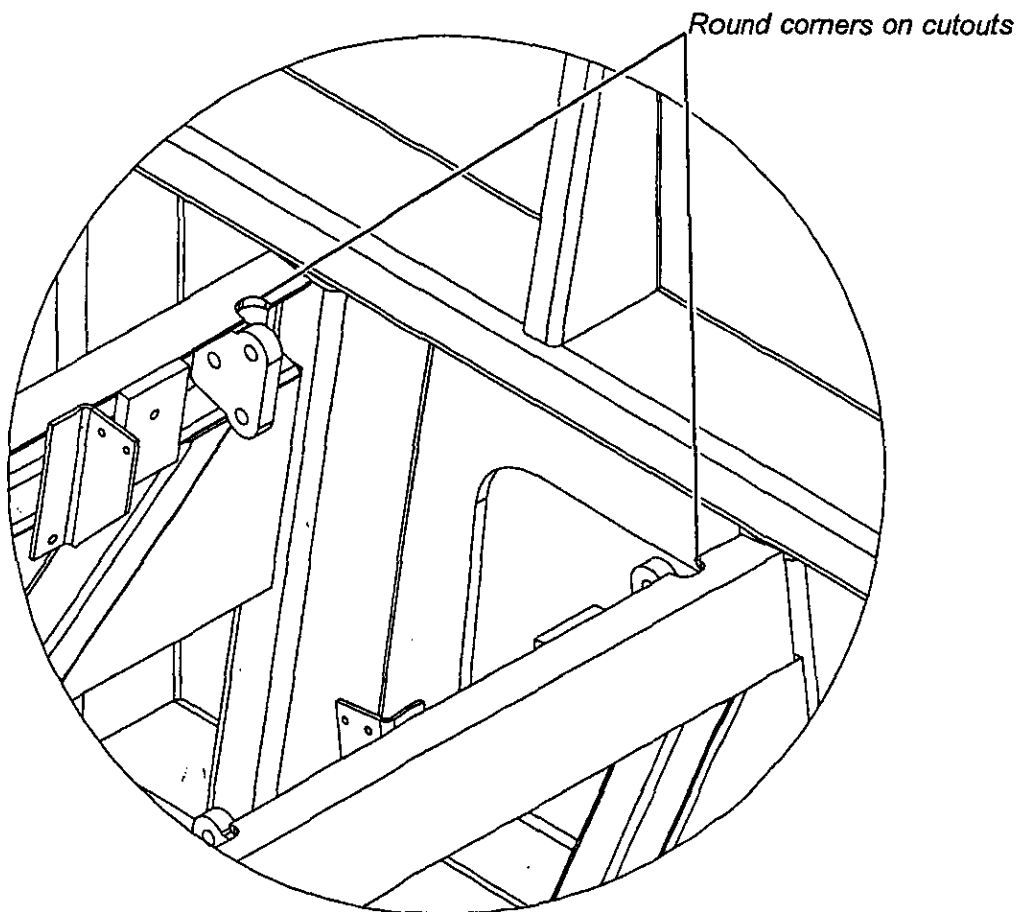
Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Park Model)
DOUBLE INVERTER

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

Model No.: 414

Detail of Issue (continued):



**CHANCE RIDES, INC.**

4219 Irving

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U.S.A.

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Supersedes: N/A

Completion Date: See Text

Page: 11 of 13

Ride Manufacturer: CHANCE RIDES, INC.

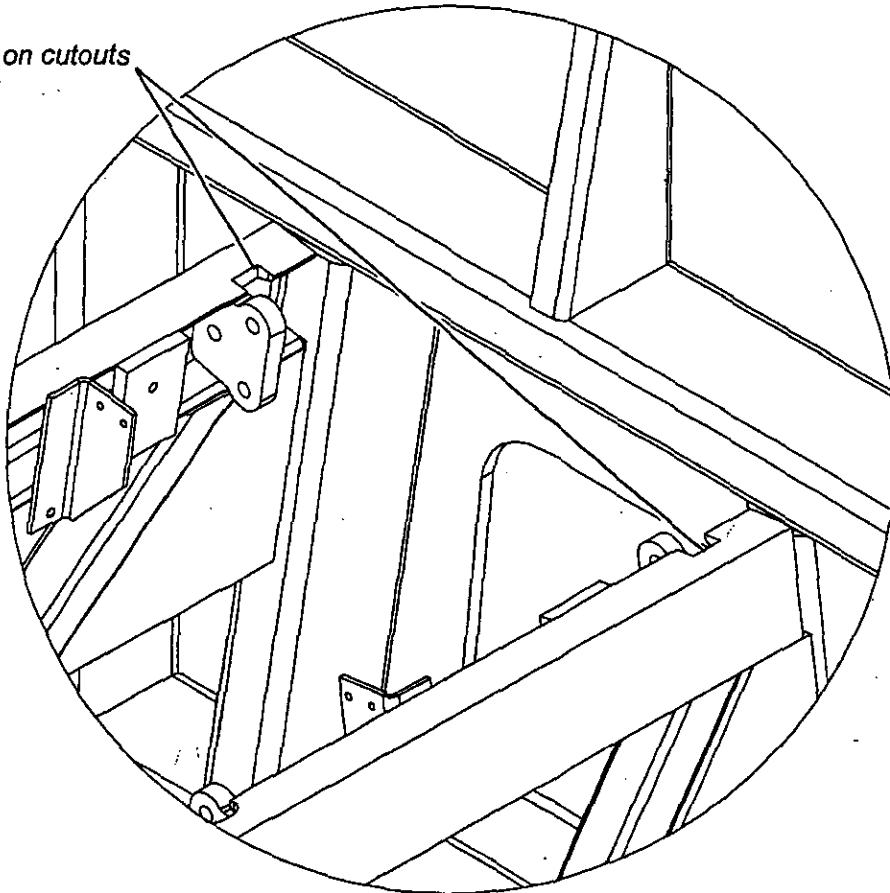
Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue (continued):

Square corners on cutouts



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Supersedes: N/A

Completion Date: See Text

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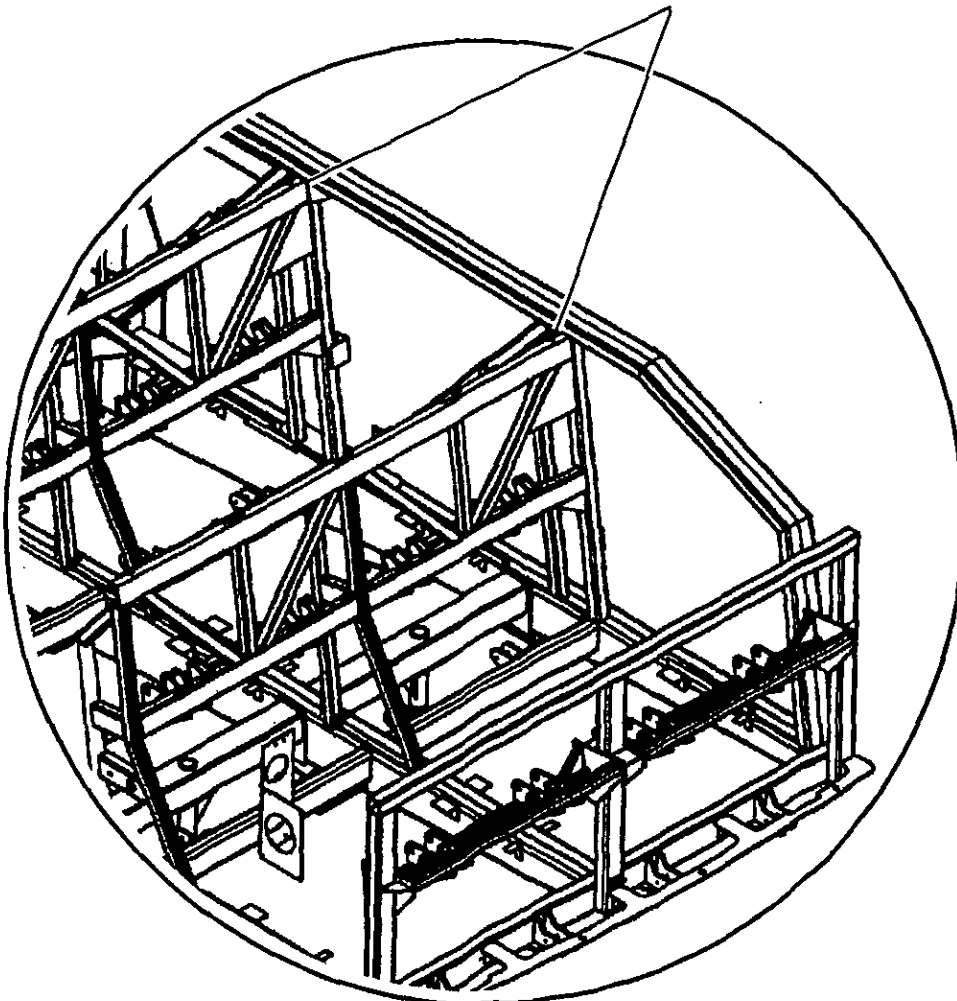
Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue (continued):

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

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

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Supersedes: N/A

Completion Date: See Text

Page: 13 of 13

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

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

Model No.: 414

Detail of Issue (continued):

VEHICLE FRAME REWORK

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

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

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

ANNUAL INSPECTION

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

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1269-0

Release Date: February 12, 2002

Effective Date: February 12, 2002

Supersedes: N/A

Completion Date: See Text

Page: 1 of 11

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Abstract of Issue:

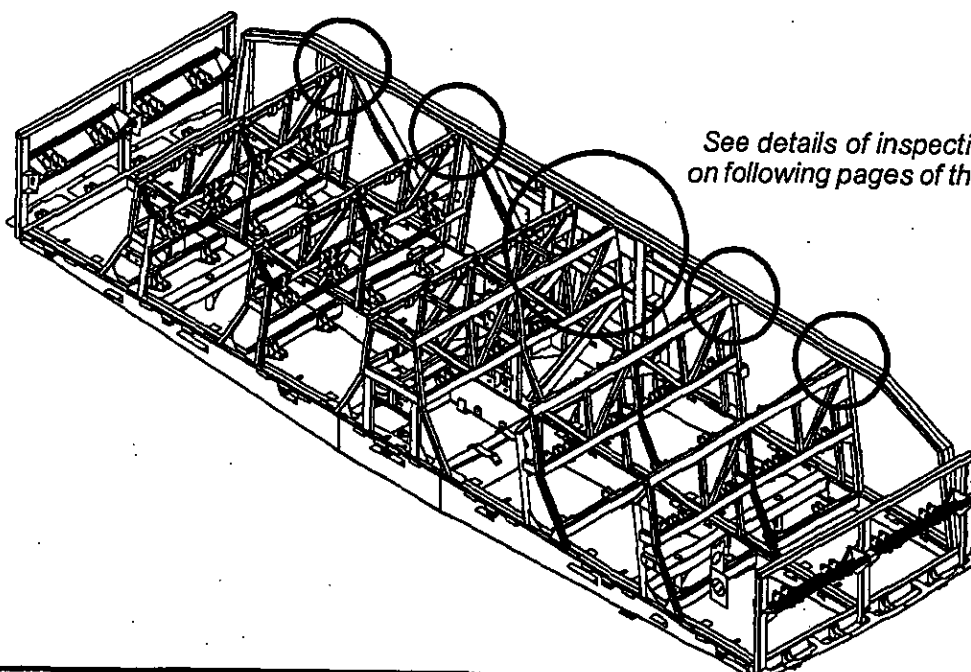
Vehicle Frame Inspection and Rework

Reason For Release:

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

Action to be Taken:

Chance Rides, Inc. requires all owner/operators of these rides to immediately inspect the vehicle frame as described in this bulletin. Thereafter, perform the inspection monthly or at every set-up, whichever occurs first. The rework kit must be installed before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque.



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

COPY

**CHANCE RIDES, INC.**

4219 Irving

Wichita, KS 67277-2328

U.S.A.

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

Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1269-0

Release Date: February 12, 2002

Effective Date: February 12, 2002

Supersedes: N/A

Completion Date: See Text

Page: 2 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue

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

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

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

- If no indications are found, perform the inspection monthly or at every set-up, whichever occurs first, as described under "Monthly Inspection" in this bulletin. Order and install the Vehicle Frame Rework Kit, part number K414R1266-1 before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque. Detailed installation instructions are provided with the kit.

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

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

NOTICE

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

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

**CHANCE RIDES, INC.**

4219 Irving

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Website: www.rides.comE-mail: rides@rides.com

Bulletin No: B414R1269-0

Release Date: February 12, 2002

Effective Date: February 12, 2002

Supersedes: N/A

Completion Date: See Text

Page: 3 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only) Affected Serial Nos.: 414-00199 through 414-03401

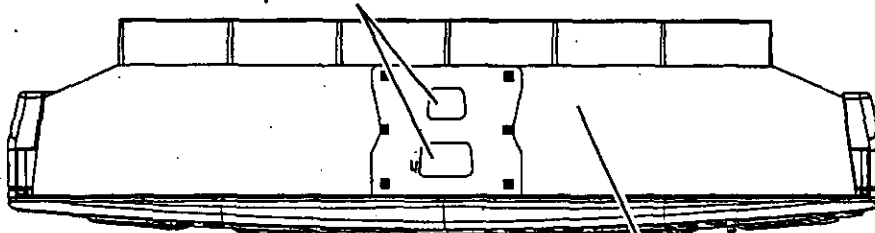
Model No.: 414

Detail of Issue (continued):

PREPARATION OF VEHICLE FOR INSPECTION

Inspection is performed with the vehicle in its rack on the trailer. Remove the center access panel at the back of the vehicle, and the two panels from the outside of the back wall of the vehicle.

These openings in the mounting plate provide access for inspection



Remove center access panel

Remove both back panels

It is also necessary to enlarge the existing openings in the seats and aluminum panels along the inside of the back wall, as shown in the photos on the following pages. Use a die grinder or rotary trimming tool for this procedure.

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

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

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

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



CHANCE RIDES, INC.

4219 Irving

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U.S.A.

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Website: www.rides.com

E-mail: rides@rides.com

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Supersedes: N/A

Completion Date: See Text

Page: 4 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

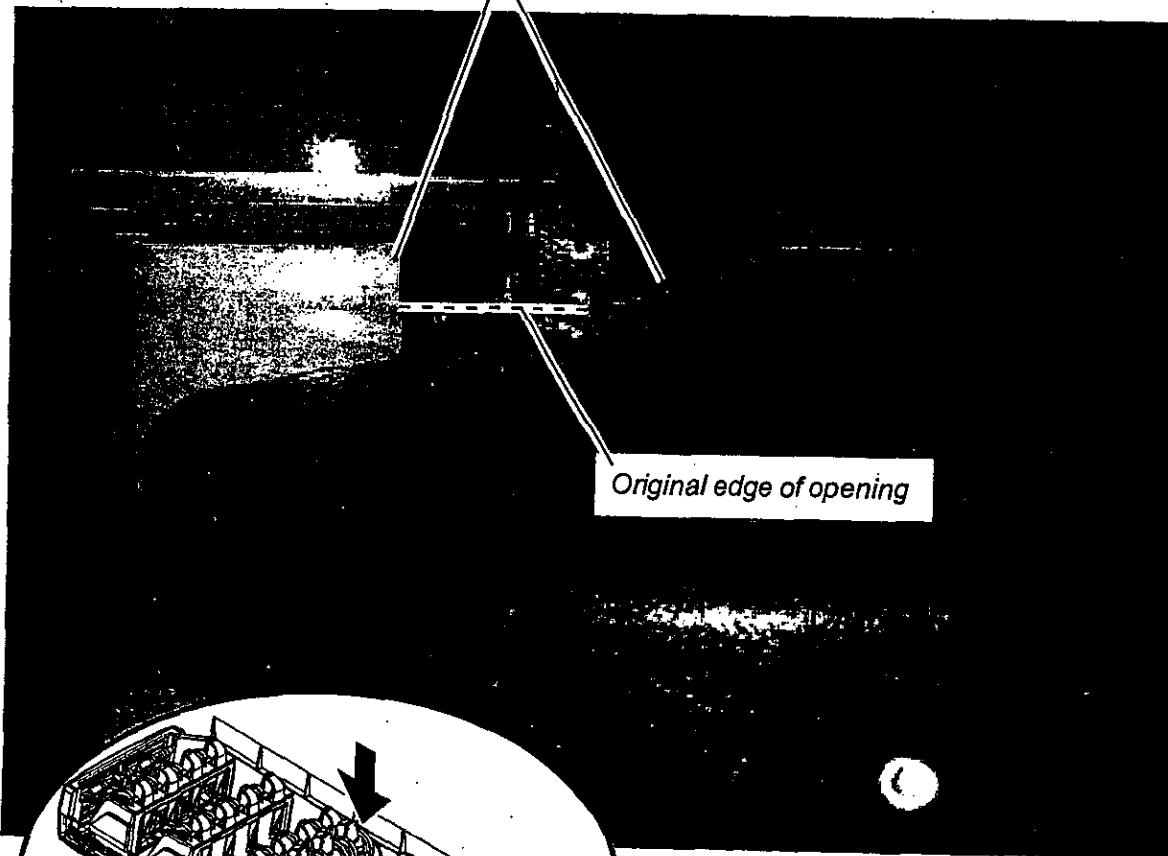
Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

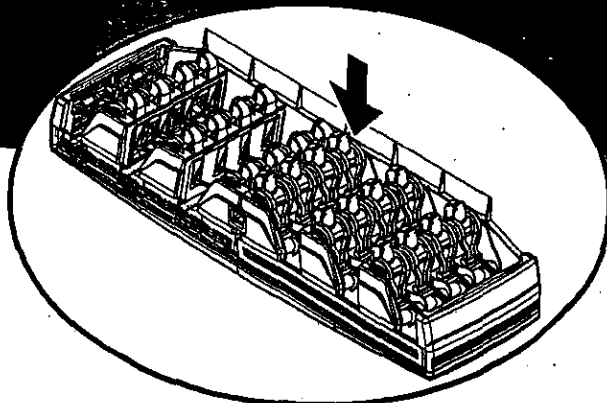
Model No.: 414

Detail of Issue (continued):

Cut fiberglass to enlarge opening



Original edge of opening



TOP VIEW OF SEAT AT BACK WALL

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4219 Irving
Wichita, KS 67277-2328
U.S.A.

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Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

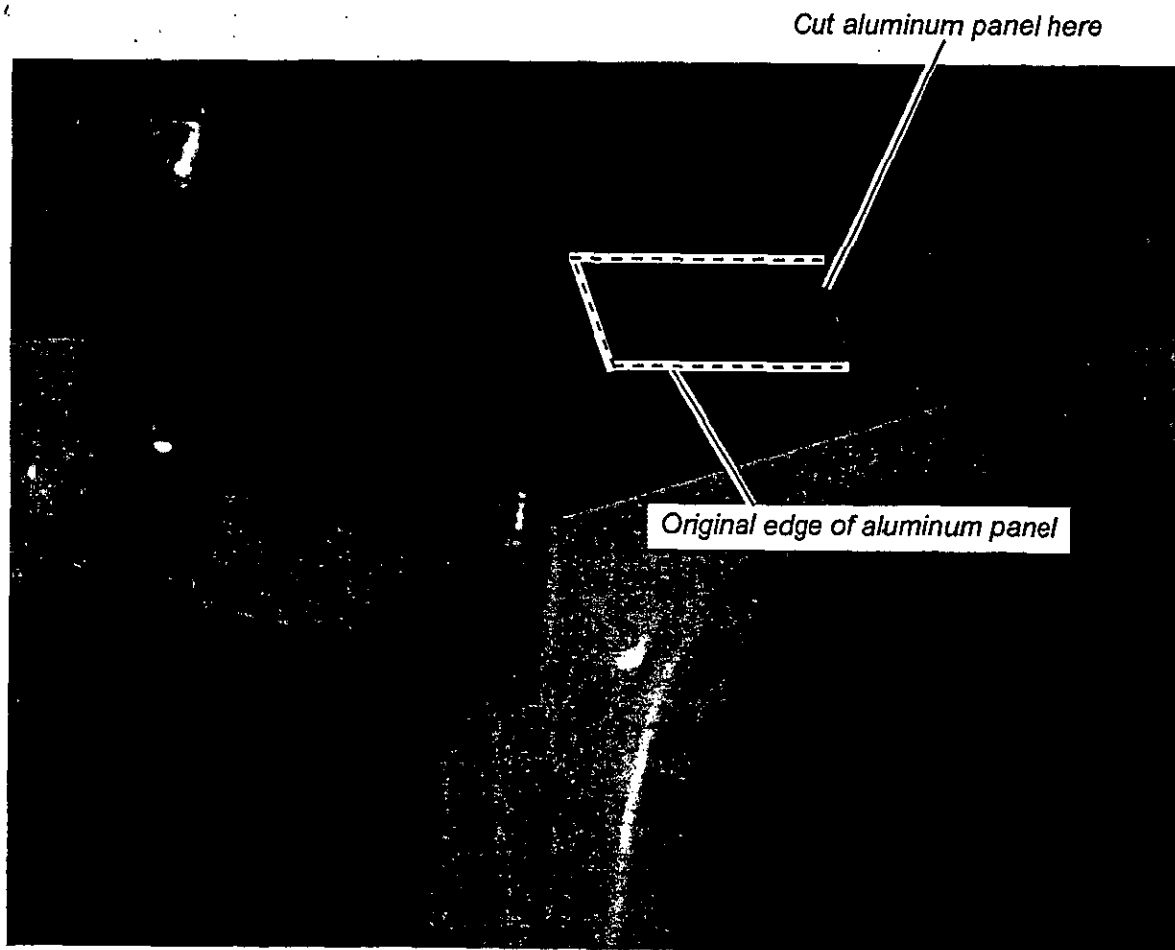
Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):



SAME AREA AFTER FIBERGLASS SEAT HAS BEEN TRIMMED

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4219 Irving

Wichita, KS 67277-2328

U.S.A.

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Website: www.rides.comE-mail: rides@rides.com

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Completion Date: See Text

Page: 6 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only) ... Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):

INSPECTION PROCEDURE

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

1. In the center section of the vehicle frame, inspect the welded joints in the areas shown. Using an inspection mirror and light, thoroughly inspect all sides of each joint, looking for indications in the welds or the parent metal.
2. Inspect the cutouts in the channels in all six seats. Note whether the cutouts have round or square corners.

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

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

MONTHLY INSPECTION (or at every set-up, whichever occurs first)

Inspect the vehicle frame monthly, or at every set-up, whichever occurs first, until the Vehicle Frame Rework Kit is installed (see "Vehicle Frame Rework" in this bulletin). Use the same procedure as outlined in this bulletin. If any indications are found, contact the Chance Customer Service Department immediately.

DO NOT CONTINUE OPERATION OF THE RIDE.

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

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

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E-mail: rides@rides.com

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Effective Date: February 12, 2002

Supersedes: N/A

Completion Date: See Text

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Ride Manufacturer: CHANCE RIDES, INC.

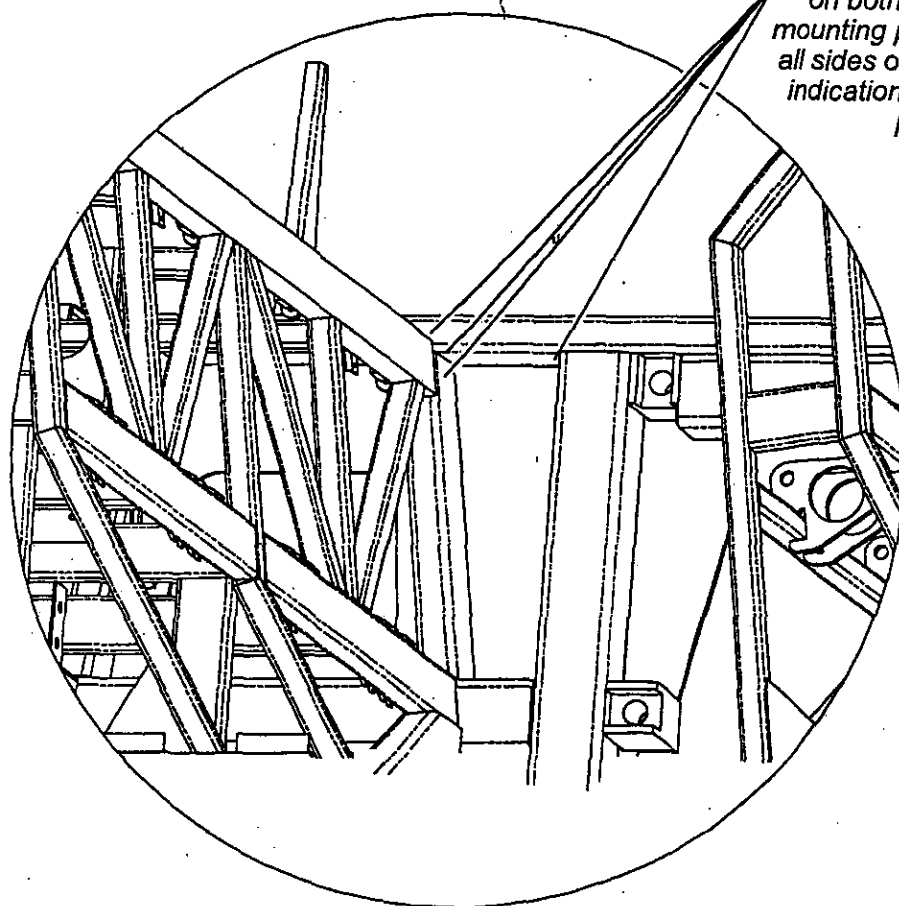
Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):



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

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

**CHANCE RIDES, INC.**

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Supersedes: N/A

Completion Date: See Text

Page: 8 of 11

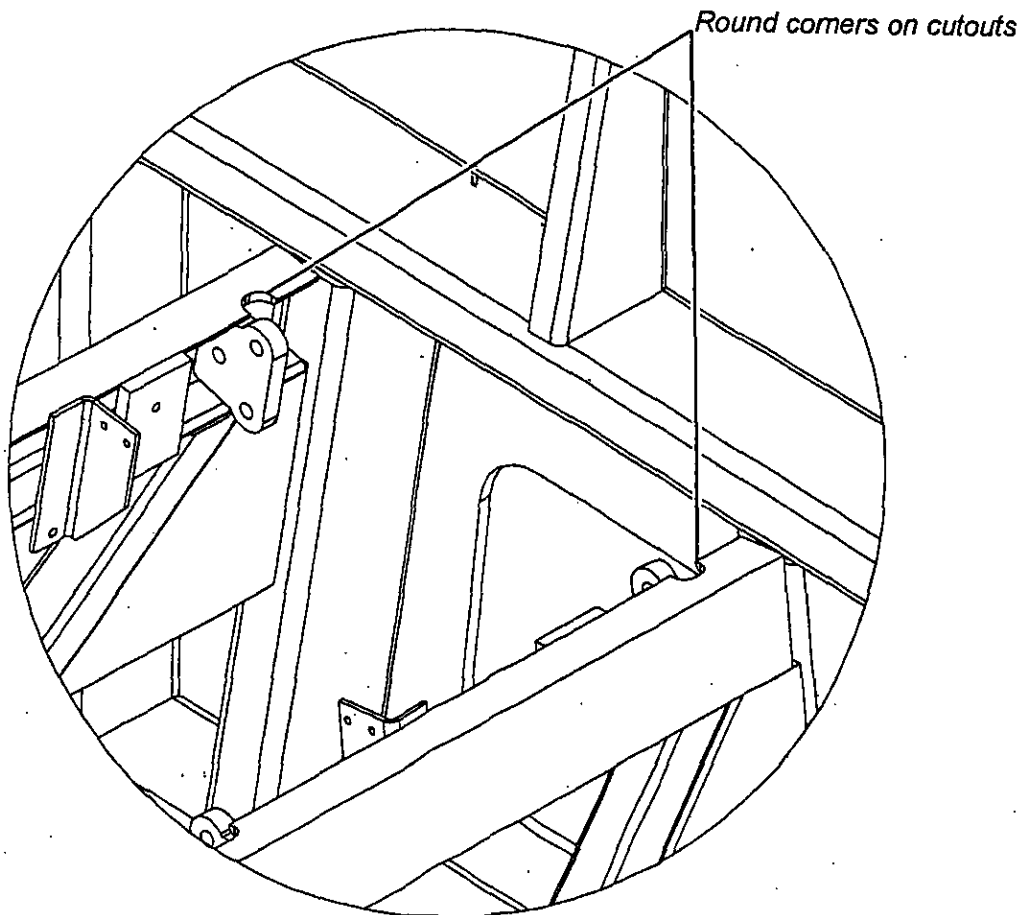
Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only) . Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):



**CHANCE RIDES, INC.**

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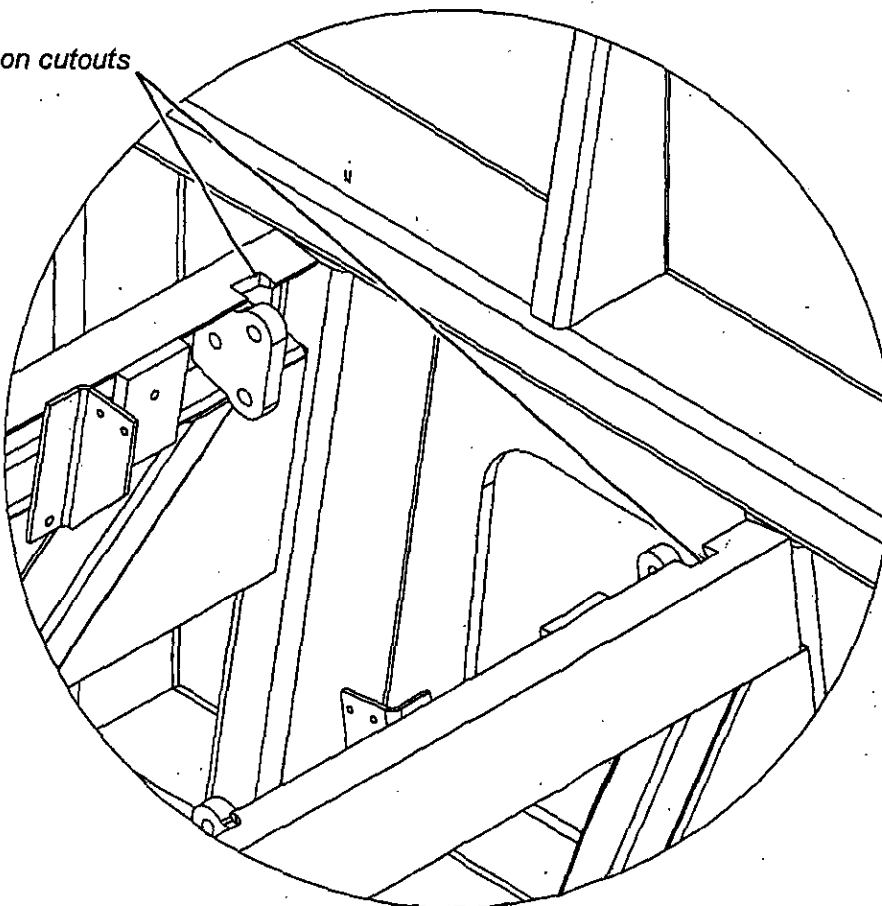
Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only) Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):

Square corners on cutouts

**CHANCE RIDES, INC.**

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U.S.A.

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Supersedes: N/A

Completion Date: See Text

Page: 10 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

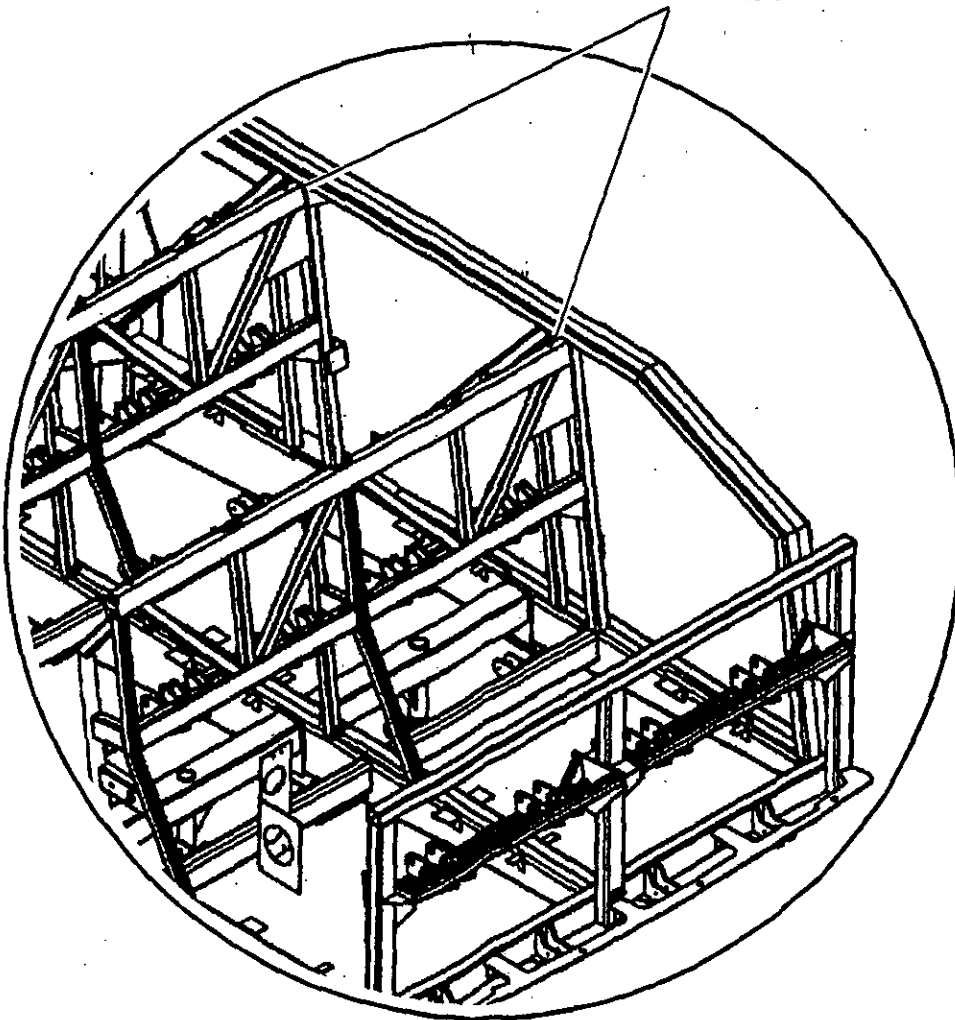
Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):

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



**CHANCE RIDES, INC.**

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Completion Date: See Text

Page: 11 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Detail of Issue (continued):

VEHICLE FRAME REWORK

IMPORTANT: The Vehicle Frame Rework Kit must be installed before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque. After the kit is installed, the ride must be inspected annually as described in "Annual Inspection".

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


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

ANNUAL INSPECTION

On rides with the Vehicle Frame Rework Kit is installed, inspect the vehicle annually, using the same procedure as outlined in this bulletin. If any indications are found, contact the Chance Customer Service Department immediately. **DO NOT CONTINUE OPERATION OF THE RIDE.**

Memorandum

To: Harry Crane

From: M. Moneró 

Date: March 6, 2002

Re: Inverter NDT Requirements

Please be advised that NDT's are required for the Chance Inverter. Attached is the schedule for the portable and park model with the picture as to where the parts are located. The first time an NDT has to be performed is after 4 years of operation. I believe that none of NJ's Inverters will need to have NDT performed on it until next year since most of them started operation in 2000.

CC: Michael Triplett
All Inspectors (14)
Correspondence File

Chance Rides, Inc.**PARK MODEL INVERTER AMUSEMENT RIDE**

| NDT Inspection Schedule | | | |
|--------------------------------|--|---------------------------------|-------------|
| Component | Inspection Point (Location) | Initial NDT Interval | Area |
| Vehicle arm | Gussets adjacent to gear box | 4 years | A |
| | Counterweight arm attaching flange | 4 years | A |
| Counterweight arm | Outboard root of gusset | 8 years | A |
| | Vehicle arm attaching flange | 4 years | A |
| | Vehicle arm to arm hub at corners of arm | 4 years | A |
| Vehicle | 4" x 12" lateral tube (Weld to back wall) | 4 years | C |
| | 4" x 12" tube (Fillet welds and gusset welds) | 4 years | C |
| | Upper back wall 2" x 4" tube at mounting plate | 4 years | C |
| Vehicle arm adapter box | Upper and lower edge facing curbside | 8 years | B |
| | Stiffeners welded to circular barrel | 8 years | B |

NOTE: *Inspect regions in accordance with the above schedule using magnetic particle (MP) inspection per AWS. D1.1:1998, or latest revision, paragraph 6.14.4.*

If MP is not practical, contact Chance Rides, Inc.

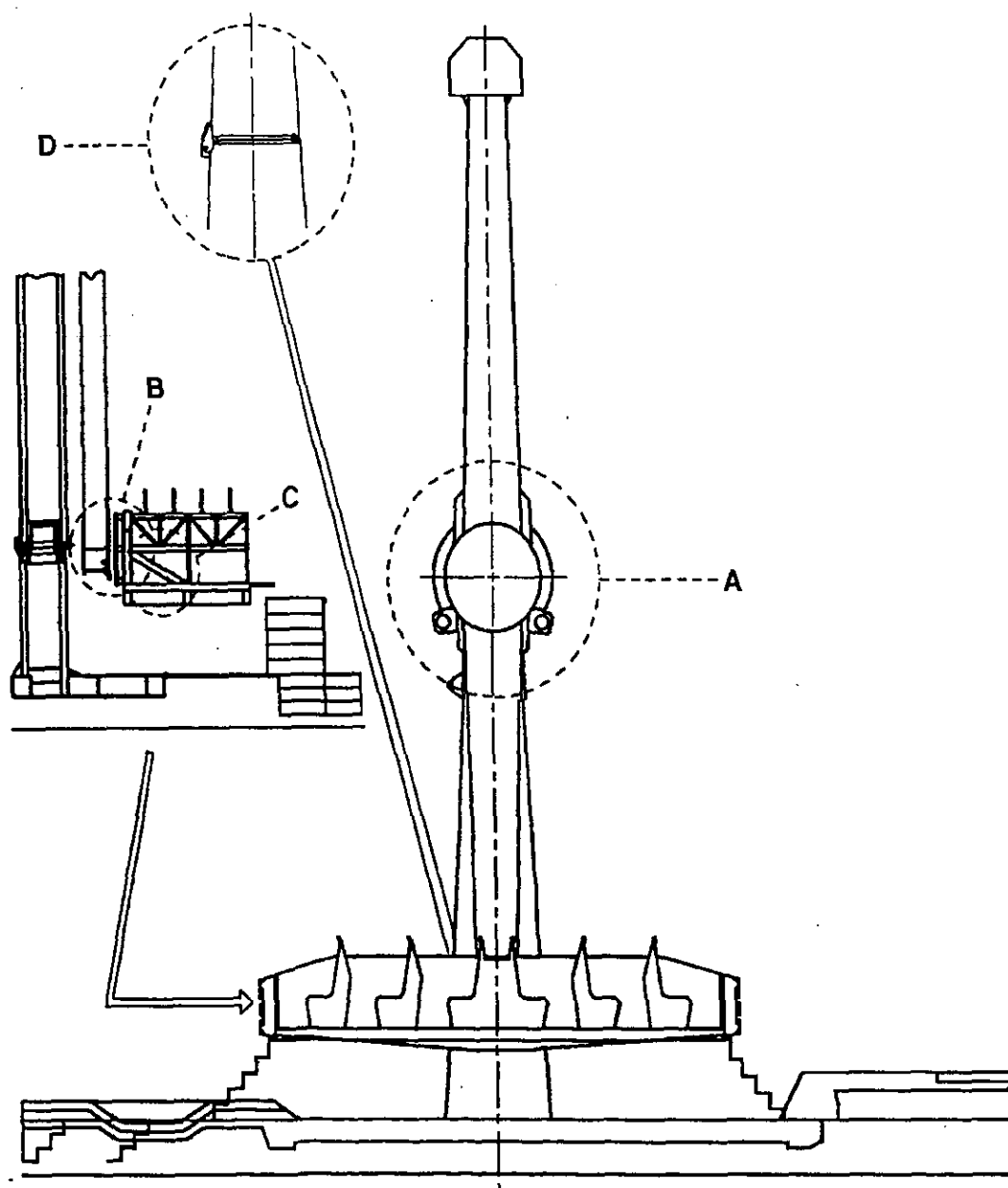
Chance Rides, Inc.

PORTABLE MODEL INVERTER AMUSEMENT RIDES

| NDT Inspection Schedule | | | |
|-------------------------|--|----------------------|------|
| Component | Inspection Point (Location) | Initial NDT Interval | Area |
| Vehicle arm | Gussets adjacent to gear box | 4 years | A |
| | Counterweight arm attaching flange | 4 years | A |
| Counterweight arm | Outboard root of gusset | 8 years | A |
| | Vehicle arm attaching flange | 4 years | A |
| | Vehicle arm to arm hub at corners of arm | 4 years | A |
| Tower hinge (lower) | Weld around doubler to tower wall | 4 years | D |
| Vehicle | 4" x 12" lateral tube (Weld to back wall) | 4 years | C |
| | 4" x 12" tube (Fillet welds and gusset welds) | 4 years | C |
| | Upper back wall 2" x 4" tube at mounting plate | 4 years | C |
| Vehicle arm adapter box | Upper and lower edge facing curbside | 8 years | B |
| | Stiffeners welded to circular barrel | 8 years | B |

NOTE: *Inspect regions in accordance with the above schedule using magnetic particle (MP) inspection per AWS D1.1:1998, or latest revision, paragraph 6.14.4.*

If MP is not practical, contact Chance Rides, Inc.





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-7416
Website: www.rides.com
E-mail: rides@rides.com

| | |
|------------------|---------------|
| Bulletin No: | A414CRM107-0 |
| Release Date: | July 19, 2002 |
| Effective Date: | Immediately |
| Supersedes: | N/A |
| Completion Date: | N/A |
| Page: | 1 of 5 |

SAFETY ALERT

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

Ride Name: **INVERTER (Portable Model Only. Park Model Rides are not affected)** Affected Serial Nos.: **All Units**

Model No.: **414**

Abstract of Issue:

Main Drive Gearbox Recall

Reason For Release:

Chance Rides Manufacturing, Inc. has been contacted by Comer Industries, Inc., the U.S. distributor of the main drive gearboxes incorporated in the INVERTER amusement rides built by Chance Rides, Inc. in 1999 and 2000 (refer to the Comer correspondence on page 4 of this bulletin). There is a concern that a manufacturing defect has occurred in some of the supplied gearboxes creating the potential for gearbox output shaft failure and possible damage or personal injury.

Chance Rides Manufacturing, Inc., having acquired INVERTER owner information from Chance Rides, Inc. (through the bankruptcy of Chance Rides, Inc.), is assisting Comer in notifying Inverter owners by this bulletin and developing a corrective action plan. The plan includes a test procedure to identify the affected gearboxes and a repair program to be administered by Chance Rides Manufacturing, Inc. for Comer Industries, Inc.

NOTE: Park model rides which have the main drive gearboxes located inside the tower are not affected by this bulletin.

Action to be Taken:

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted INVERTER amusement rides to **CEASE OPERATION IMMEDIATELY**. Failure to do so can result in personal injury.

All owner/operators must complete the gearbox identification procedure, then fill out and return the Certificate of Compliance form on page 5 to Chance Rides Manufacturing.

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.



CHANCE RIDES MANUFACTURING, INC.

4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-7416

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: A414CRM107-0

Release Date: July 19, 2002

Effective Date: Immediately

Supersedes: N/A

Completion Date: N/A

Page: 2 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model Only.
Park Model Rides are not affected)

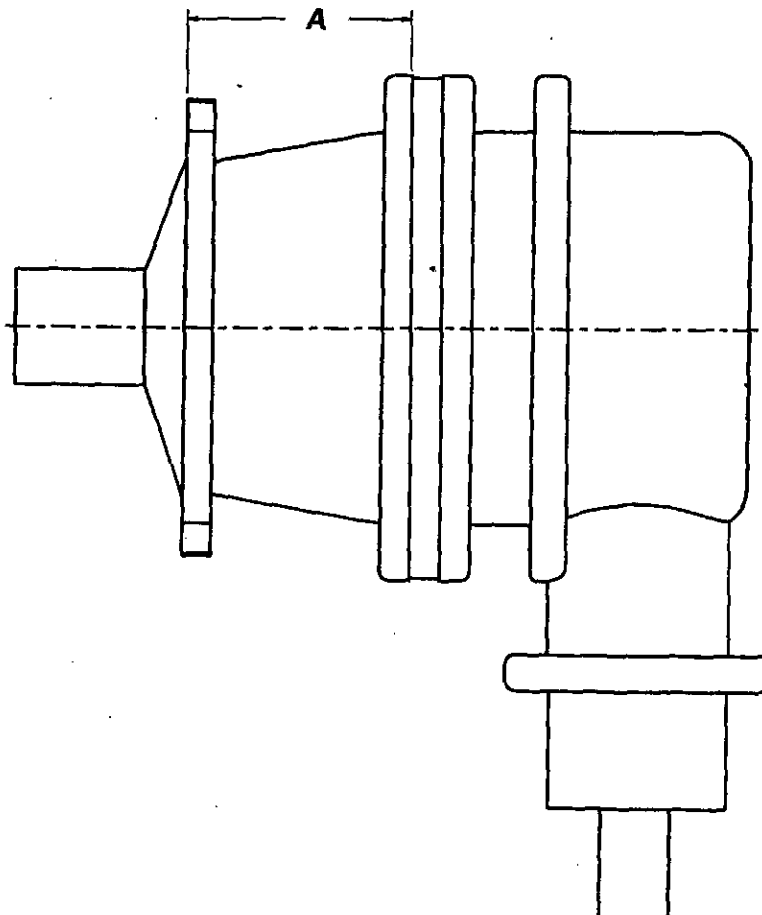
Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):

Gearbox Identification

Identify BOTH main drive gearboxes to determine how this bulletin affects your specific ride. The gearboxes can be identified by measuring the distance between the flanges (Dimension "A") on the output section as shown in the following illustration.





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
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| Bulletin No: | A414CRM107-0 |
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| Supersedes: | N/A |
| Completion Date: | N/A |
| Page: | 3 of 5 |

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

Ride Name: INVERTER (Portable Model Only. Park Model Rides are not affected) Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):

- If dimension "A" on BOTH GEARBOXES is **5-5/8" (143 mm)** :
The ride can continue to operate. Fill out and return the Certificate of Compliance on page 5 of this bulletin. Fax the form to Chance Rides Manufacturing, Inc. at (316) 942-2012.
- If dimension "A" on EITHER OR BOTH GEARBOXES is **7-1/2" (190 mm)** :
DO NOT OPERATE THE RIDE UNTIL ADVISED BY CHANCE RIDES MANUFACTURING, INC. Fill out and return the Certificate of Compliance on page 5 of this bulletin. Fax the form to Chance Rides Manufacturing, Inc. at (316) 942-2012. Information on inspection and repair of the gearboxes by Comer Industries, Inc. will be provided. **DO NOT SHIP GEARBOXES** until specific instructions are provided 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.

4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-7416

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: A414CRM107-0

Release Date: July 19, 2002

Effective Date: Immediately

Supersedes: N/A

Completion Date: N/A

Page: 4 of 5

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

**Ride Name: INVERTER (Portable Model Only.
Park Model Rides are not affected)**

Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):

COMER
Group

Chance Rides Manufacturing, Inc

18 July 2002

Gentlemen:

Per our telephone conversation this morning you are aware that the analysis of the output shafts from the first two failed PGA1002PFS drives you recently returned to us indicates that we have a problem with the metallurgy. Our manufacturing facility in Italy is in the process of determining how many of these drives are affected.

In order to avoid any further shaft failures resulting in incidents with the rides and possible injury, we require that you cease operation of all of the PGA1002 planetary drives including units built as new and drives that have received the modification to the PFS bearing support. Use of these drives may resume once the defective shafts have been identified and replaced.

Best regards:

**Mike Bolling PE
Engineering Manager
Comer Industries, Inc.**



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-7416
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: A414CRM107-0
Release Date: July 19, 2002
Effective Date: Immediately
Supersedes: N/A
Completion Date: N/A
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Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: INVERTER (Portable Model Only. Affected Serial Nos.: All Units
Park Model Rides are not affected)

Model No.: 414

Detail of Issue (continued):

Certificate of Compliance

After both gearboxes have been identified, fill out the following and fax to Chance Rides Manufacturing, Inc. at (316) 942-2012.

- Ride serial number _____
- Name of ride owner's company _____
- Name of company contact person _____
- Telephone number _____
(cell phone or other which is answered at all times)
- Fax number _____
- E-mail address _____

*Travelling carnivals, also please provide your route for the next 4 weeks

- Dimension "A" measurement on both gearboxes _____

- Serial numbers of both gearboxes _____

Signature of person performing the inspection

Date



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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|------------------|--------------------|
| Bulletin No: | B414CRM102-0 |
| Release Date: | September 23, 2002 |
| Effective Date: | September 23, 2002 |
| Supersedes: | N/A |
| Completion Date: | Immediately |
| Page: | 1 of 9 |

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Inspection of Secondary Restraint Bar (T-Bar) Locking Mechanisms

Reason For Release:

Chance Rides Manufacturing, Inc. has become aware that wear, damage or improper alignment of parts can result in the secondary restraint bar (T-bar) locking mechanism not locking securely. The *INVERTER Service Manual* requires weekly inspection of all secondary restraint bar locking mechanisms in addition to daily operational checks. This bulletin is being released to provide additional inspection information to ensure the proper operation of the locking mechanisms.

It is essential for the safety of the passengers that all passenger restraint system components are inspected and maintained according to the manufacturer's specifications.

Action to be Taken:

Chance Rides Manufacturing, 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 all components of the secondary restraint bar locking mechanism. This inspection must be performed annually thereafter. Daily and weekly inspection requirements are also provided 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.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B414CRM102-0

Release Date: September 23, 2002

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Completion Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

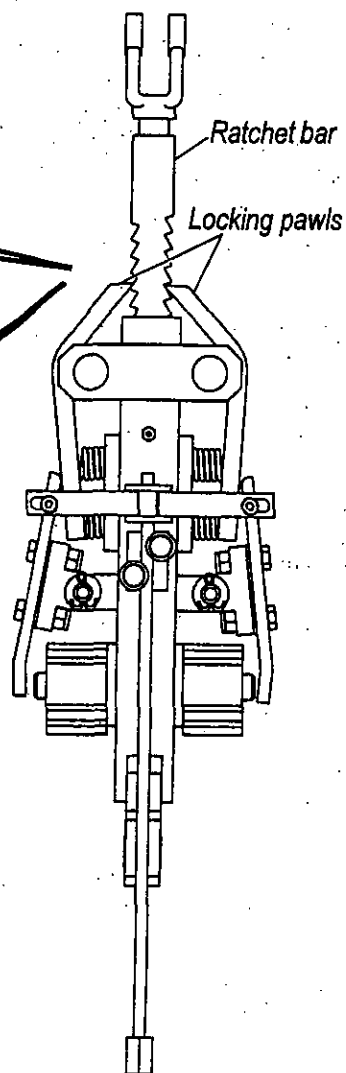
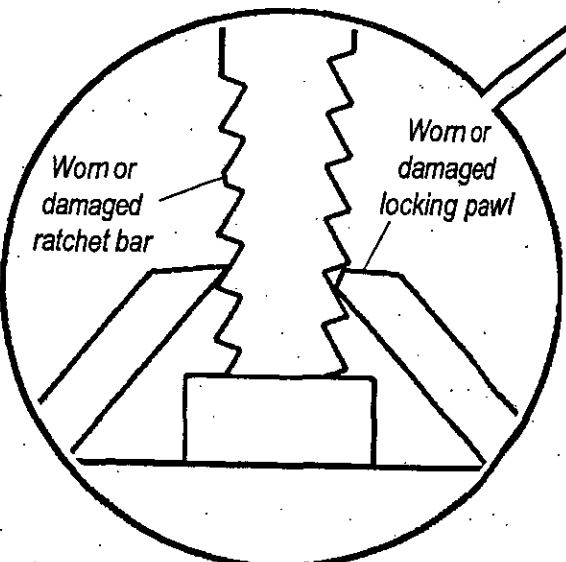
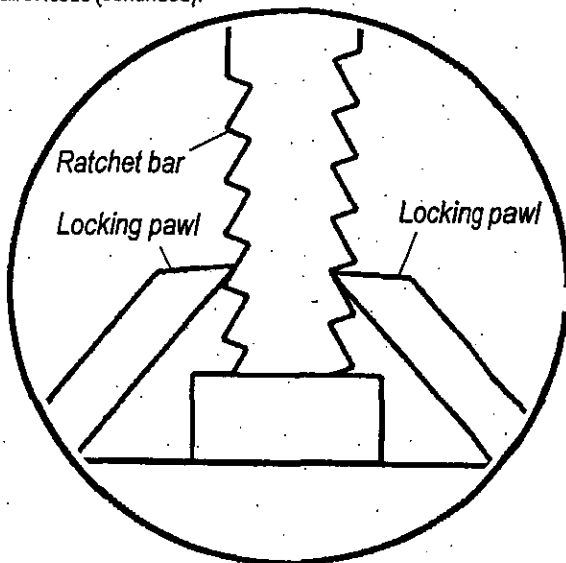
Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected SerialNos.: All units

Model No.: 414

Detail of Issue (continued):



**CHANCE RIDES MANUFACTURING, INC.**

4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.comE-mail: rides@rides.com

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Release Date: September 23, 2002

Effective Date: September 23, 2002

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Completion Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Inspection of Secondary Restraint Bar (T-Bar) Locking Mechanisms

The locking mechanisms for the secondary restraint bars (T-bars) must be kept in good working condition at all times. In addition to daily and weekly checks, perform the following inspection immediately. Perform the same inspection annually thereafter.

Replace any part which is worn, damaged or not working properly. An illustrated parts breakdown is provided on the following pages of this bulletin.

1. Push the secondary restraint bar (T-bar) completely down. This will fully extend the ratchet bar for inspection of all teeth.
2. Visually inspect the teeth on the ratchet bar for wear or damage. Look for the following:
 - Wear or damage on the points of the teeth.
 - Chipped corners on the teeth.
 - The profile of all teeth must be consistent. Note that the teeth on the ratchet bar are offset from one side to another, allowing the locking pawls to engage on one side at a time.
3. Visually inspect the locking pawls for the following:
 - Wear or damage on the chamfered end of the locking pawls.
 - Blunt, uneven or chipped edges on the chamfered end.
 - The locking pawl must engage the ratchet bar as shown, making contact across the full width of the teeth.



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U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

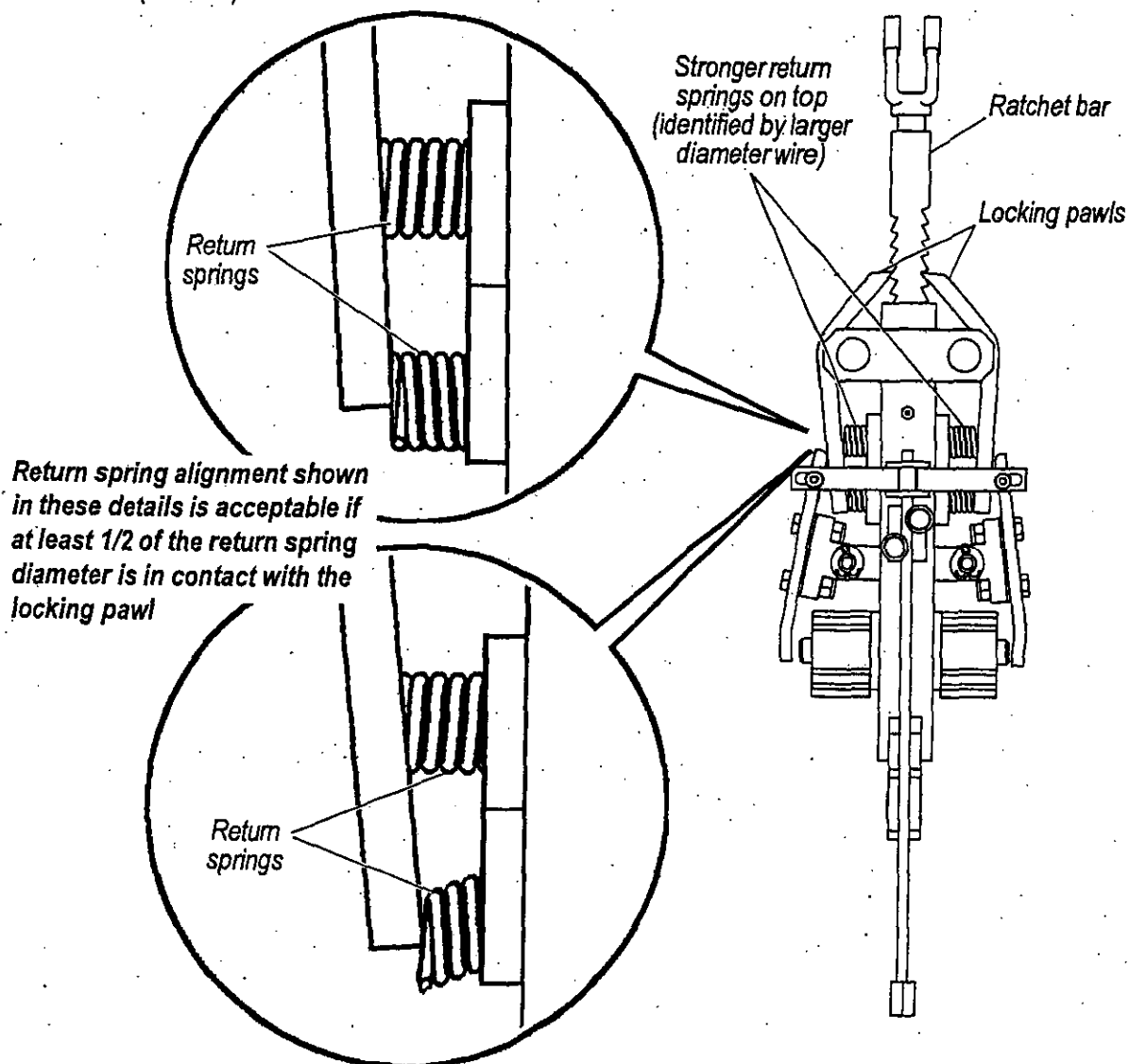
Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):



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4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.comE-mail: rides@rides.com

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Completion Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

4. Check for broken or loose return springs. Note that there are two different springs installed on each side. The stronger springs, identified by larger wire diameter, must be installed at the top of the assembly, as shown in the illustration on page 4 of this bulletin.
5. Check the return springs for proper alignment between the locking pawl and the spring pocket as shown. Alignment is acceptable only if at least 1/2 of the diameter of the bottom return spring is in contact with the locking pawl.
6. Check the operation of each secondary restraint bar latch using the following procedure:
 - With air pressure removed from the ratchet release cylinders, have an assistant push the secondary restraint bar down slowly. **KEEP FINGERS AND HANDS AWAY FROM ALL MOVING PARTS AS THE BAR IS LOWERED.**
 - As the ratchet bar extends, observe the locking pawls as they alternately engage the ratchet bar teeth on one side, then the other. The locking pawls must engage completely with the teeth in the ratchet bar.
 - With air pressure applied, the pawls must retract fully and clear the teeth on the ratchet bar.



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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| Completion Date: | Immediately |
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Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

WEEKLY INSPECTION of Secondary Restraint Bar (T-Bar) Locking Mechanisms

Perform the following inspection weekly.

Replace any part which is worn, damaged or not working properly. An illustrated parts breakdown is provided on the following pages of this bulletin.

1. Visually inspect the locking pawls and the teeth on the ratchet bar for wear or damage. The chamfered end on each locking pawl must engage completely with the teeth in the ratchet bar.
2. Check the return springs for condition and correct operation.
 - Look for broken or loose return springs.
 - Make sure each return spring is properly aligned and seated securely between the locking pawl and the spring pocket.
3. All pins and fasteners must be in good condition and properly installed.
4. Inspect the mounting lugs and clevises for damage. All fasteners must be correctly installed.
5. Check the air pressure settings for the ratchet locks as described in the INVERTER Service Manual.



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

DAILY INSPECTION of Secondary Restraint Bar (T-Bar) Locking Mechanisms

The following points must be included as part of the daily pre-operational inspection.

Replace any part which is worn, damaged or not working properly. An illustrated parts breakdown is provided on the following pages of this bulletin.

1. Visually inspect the secondary restraint bars (T-bars) for loose, damaged or missing parts.
2. Test the operation of each secondary restraint bar (T-bar). Pull up on each bar to check that the locking mechanisms are engaged.
3. Check the operation of the passenger restraint interlock system using the procedure described in the *INVERTER Service Manual* ("Passenger Restraint System Operational Check") and in Chance Rides, Inc. Service Bulletin B414R1225-0.
4. Check the operation of the secondary restraint bar (T-bar) interlock with the step. Make sure that all six slide bars work smoothly both directions and the springs return them completely to the out position.

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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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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| Supersedes: | N/A |
| Completion Date: | Immediately |
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Ride Manufacturer: CHANCE RIDES, INC.

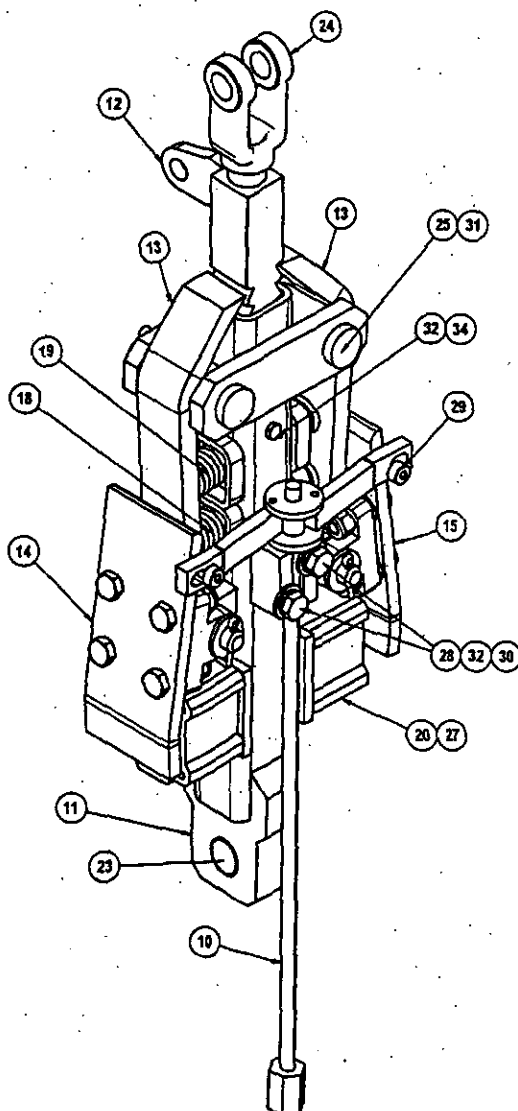
Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):



**CHANCE RIDES MANUFACTURING, INC.**

4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.comE-mail: rides@rides.com

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Completion Date: Immediately

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Replacement Part List - Secondary Restraint Bar (T-Bar) Locking Mechanisms

| Index No. | Part No. | Description | Qty. per Assembly |
|-----------|--------------|--|-------------------|
| 10 | 414-0171-005 | MANUAL RELEASE ASSEMBLY | 1 |
| 11 | 414-0171-007 | RATCHET LOCK WELDMENT | 1 |
| 12 | 414-0171-008 | RATCHET BAR WELDMENT | 1 |
| 13 | 414-0171-028 | LOCKING PAWL WELDMENT (for use with 1/2" pin, item #25) | 2 |
| 13 | 414-0171-033 | LOCKING PAWL WELDMENT (for use with 14mm pin, item #25) | 2 |
| 14 | 414-0171-030 | SIDE PLATE ASSEMBLY - Left Hand (includes the items indented below) | 1 |
| | 414-0171-023 | ...BAR - SIDE PLATE | 1 |
| | 24161802 | ...CLEVIS WITH PIN, SMC D5032 | 1 |
| | 60700400 | ...HHCS 1/4-20 x 1 | 4 |
| | 68530200 | ...WASHER, SAE 1/4 | 4 |
| | 64780800 | ...LOCKNUT, N/I | 4 |
| 15 | 414-0171-032 | SIDE PLATE ASSEMBLY - Right Hand (includes the items indented below) | 1 |
| | 414-0171-031 | ...BAR - SIDE PLATE | 1 |
| | 24161802 | ...CLEVIS WITH PIN, SMC D5032 | 1 |
| | 60700400 | ...HHCS 1/4-20 x 1 | 4 |
| | 68530200 | ...WASHER, SAE | 4 |
| | 64780800 | ...LOCKNUT, N/I | 4 |
| 18 | 27220605 | SPRING - RETURN (22 lb/in) | 2 |
| 19 | 27220606 | SPRING - RETURN (38 lb/in) | 2 |
| 20 | 22171600 | CYLINDER - RATCHET NCQ2B32-10S | 2 |
| 23 | 20460804 | BEARING JOURNAL 16mm ID x 18mm OD x 20mm | 1 |
| 24 | 21663900 | CLEVIS 5/8-18 (B/W) | 1 |
| 25 | 25235900 | PIN - CLEVIS 1/2 x 2-1/4 | 2 |
| 25 | Call Factory | PIN - CLEVIS 14mm x x-x/xmm | 2 |
| 27 | 61079101 | SHCS #10-24 x 1-1/2 | 8 |
| 28 | 60700000 | HHCS 1/4-20 x 1/2 GR5 | 2 |
| 29 | 61222601 | BOLT - SHOULDER 1/4 x 1 | 2 |
| 30 | 68537000 | LOCKWASHER, 1/4" SPLIT | 2 |
| 32 | 68530200 | WASHER - SAE 1/4" | 4 |
| 34 | 68981000 | ZERK GREASE 1/4-28 STRAIGHT | 2 |



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B414CRM103-0
Release Date: September 23, 2002
Effective Date: September 23, 2002
Supersedes: B414R1224-0,
P414R1253-0 and P414R1254-0
Completion Date: December 23, 2002
Page: 1 of 9

SERVICE BULLETIN

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:

Mandatory Tower Hinge Bracket and Leveling Strut Rework

Reason For Release:

Chance Rides, Inc. service bulletin B414R1224-0, and notifications P414R1253-0 and P414R1254-0 are superseded by this bulletin and are no longer in effect.

Chance Rides Manufacturing, Inc. has determined that cracks can develop in the tower hinge on the above noted INVERTER amusement rides. An improved tower hinge design has been developed to strengthen the components in the hinge area.

Also, an improved leveling strut has been developed to replace the existing turnbuckle used during the set-up and tear-down of the ride. The new design provides additional strength in the leveling strut and its attaching lugs, and is easier to install and use correctly at every set-up and tear-down.

These improvements are not to be considered an alternative to the correct set-up and tear-down procedures. 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.

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

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to order and install the tower hinge rework kit (part number K414R1253-0) and the Leveling Strut Kit (part number K414R1254-0) within 90 days of the issue date of this bulletin.

These kits include all necessary parts to rework one complete ride, with complete instructions for installation.

Supersedes

B414R1224-0 6/15/01

B414R1223-0 7/19/99

B414R1224-0 8/6/99

B414R1223-0 7/19/99



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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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

Detail of Issue

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.

The Tower Hinge Bracket Kit, part number K414R1253-0, contains the following:

| <u>Part Number</u> | <u>Component</u> | <u>Quantity</u> |
|--------------------|--|-----------------|
| K414R1253-0 | Drawing - Installation Instructions | 1 |
| 414-0780-002 | Center Ear Weldment | 1 |
| 414-0780-003 | Center Ear Weldment | 1 |
| 414-0780-011 | Plate - Formed Channel | 1 |
| 414-0780-013 | Plate - Side Hinge Ear | 2 |
| 414-0780-015 | Bar - Spacer | 2 |
| 414-0780-005 | Hinge Pin Weldment | 2 |
| 60843000 | Hex Head Capscrew (1/2-13 x 2-3/4 Grade 5) | 2 |
| 64782400 | Lock Nut (1/2-13 Nylon Insert) | 2 |
| 68531800 | Flat Washer (1/2) | 4 |
| 68980600 | Grease Zerk (1/8 PT x 90 Deg) | 2 |



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4200 Walker

Wichita, KS 67277-2328

U.S.A.

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Website: www.rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

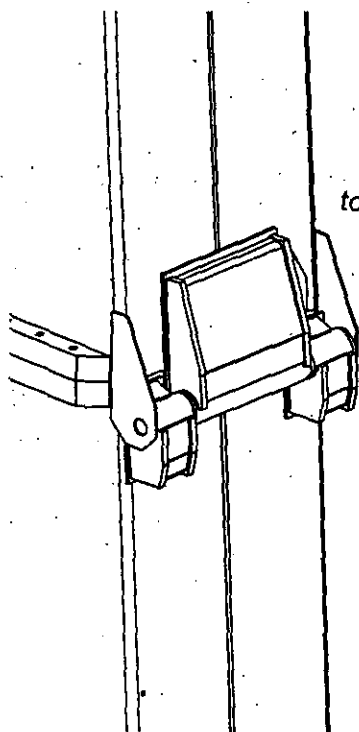
Affected Production Dates: Prior to May, 2001

Ride Name: INVERTER (Portable Model)

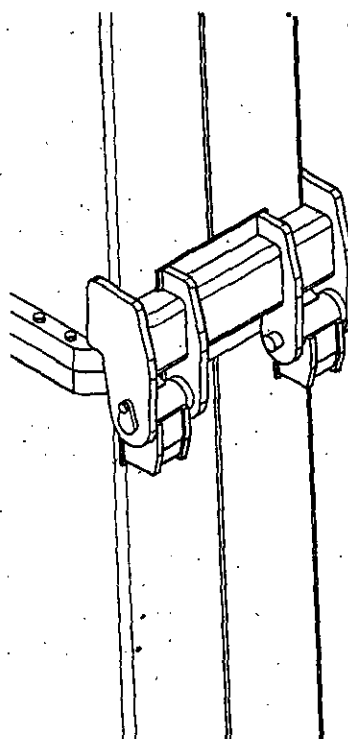
Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Detail of Issue (continued):



Existing
tower hinge



Reworked
tower hinge



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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Completion Date: December 23, 2002
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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

Detail of Issue (continued):

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 |



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4200 Walker
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U.S.A.
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: Prior to May, 2001

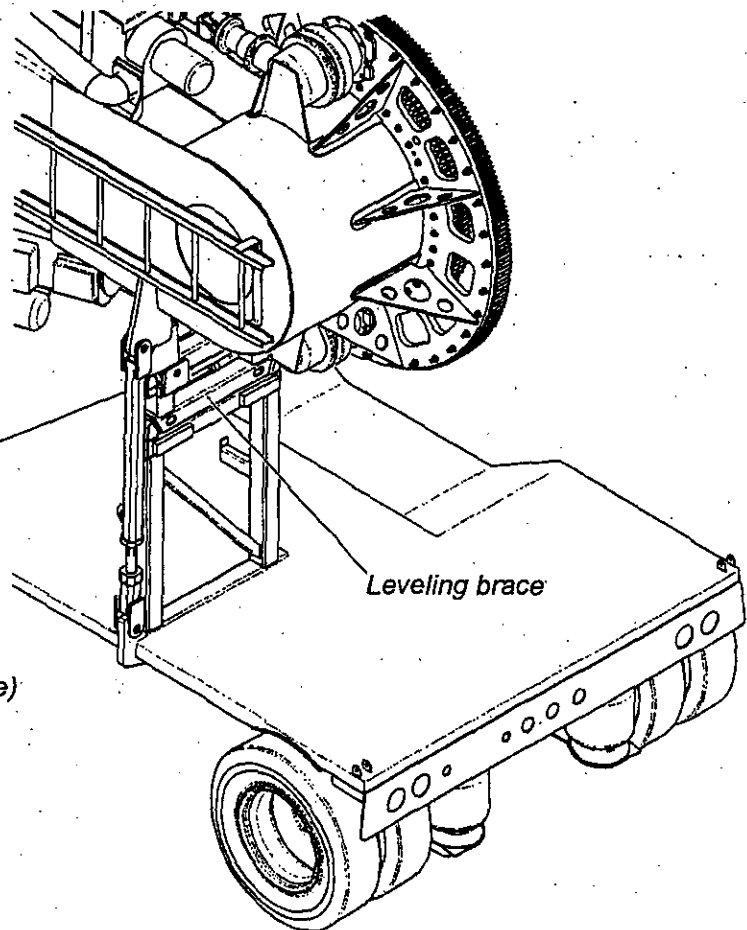
Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No: 414-03201

Model No.: 414

Detail of Issue (continued):

*The leveling strut
must be installed and
tightened before swinging
the counterweight arm into
the operating position
(See "Set-Up and Tear-Down
Procedure" on the following page)*





CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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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

Detail of Issue (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 Customer Service Department at Chance Rides Manufacturing, Inc.

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 Manufacturing, Inc. supplies two decals which must be properly located on the ride. These decals, along with the instructions in the Set-Up Manual, will alert personnel to specific steps in the procedure.

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



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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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

Detail of Issue (continued):



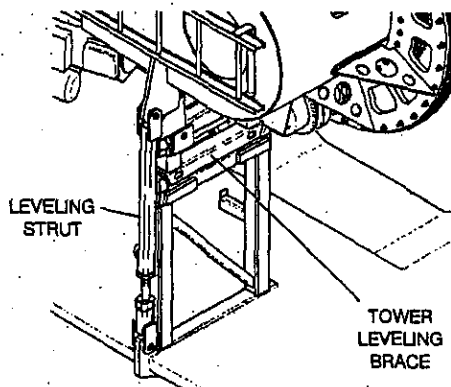
WARNING

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.



414-0010-047



WARNING

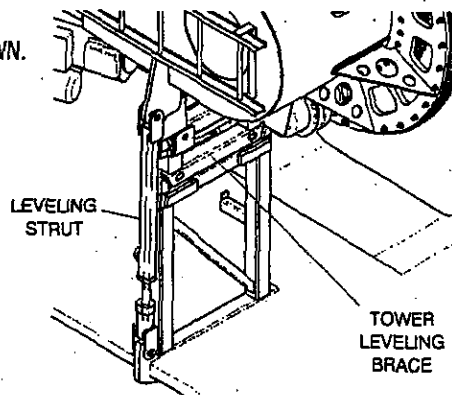
DURING TEAR-DOWN

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.



414-0010-048



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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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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

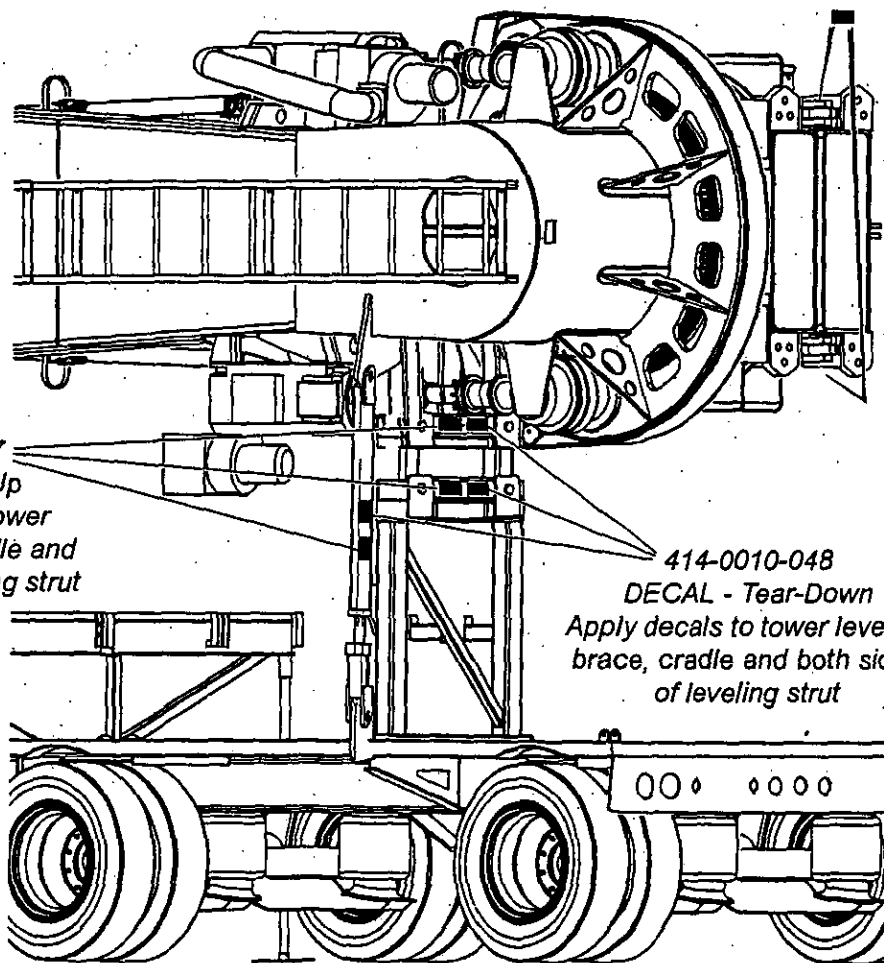
Model No.: 414

Detail of Issue (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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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

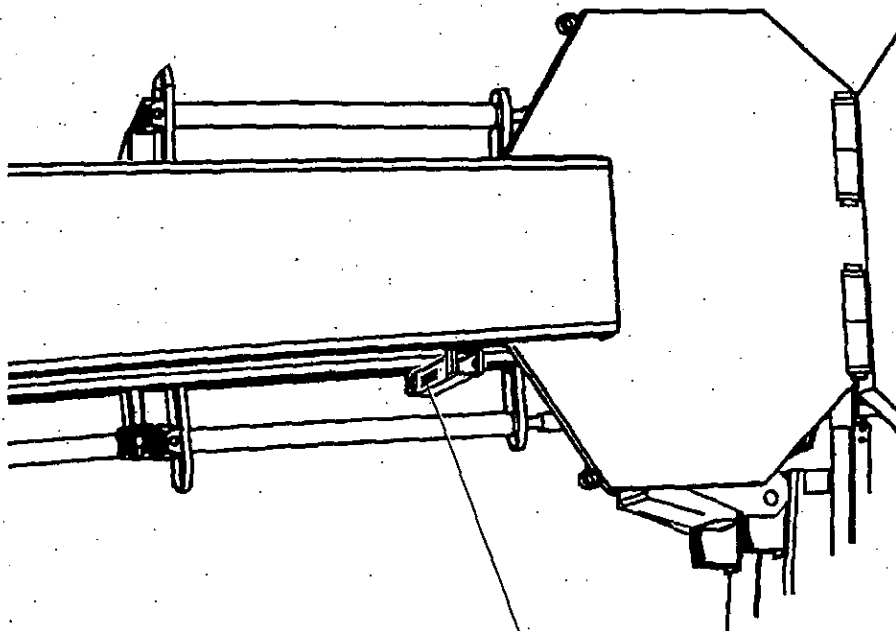
Affected Production Dates: Prior to May, 2001

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Detail of Issue (continued):



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

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CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:

Inspection, Replacement and Operation of Hydraulic Lock Cylinders

Reason For Release:

Chance Rides, Inc. service bulletin B414R1211-0 is superseded by this bulletin and is no longer in effect.

The passenger restraint system on the INVERTER amusement ride incorporates a hydraulic lock cylinder for the primary restraint bar (lap bar) at each seat. In the event a hydraulic lock cylinder fails, the secondary restraint bar (T-bar) prevents the lap 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 as described on the following pages of this bulletin. A manufacturing defect was discovered in one version. Chance Rides, Inc. service bulletin B414R1211-0 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.

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 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.



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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Page: 2 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

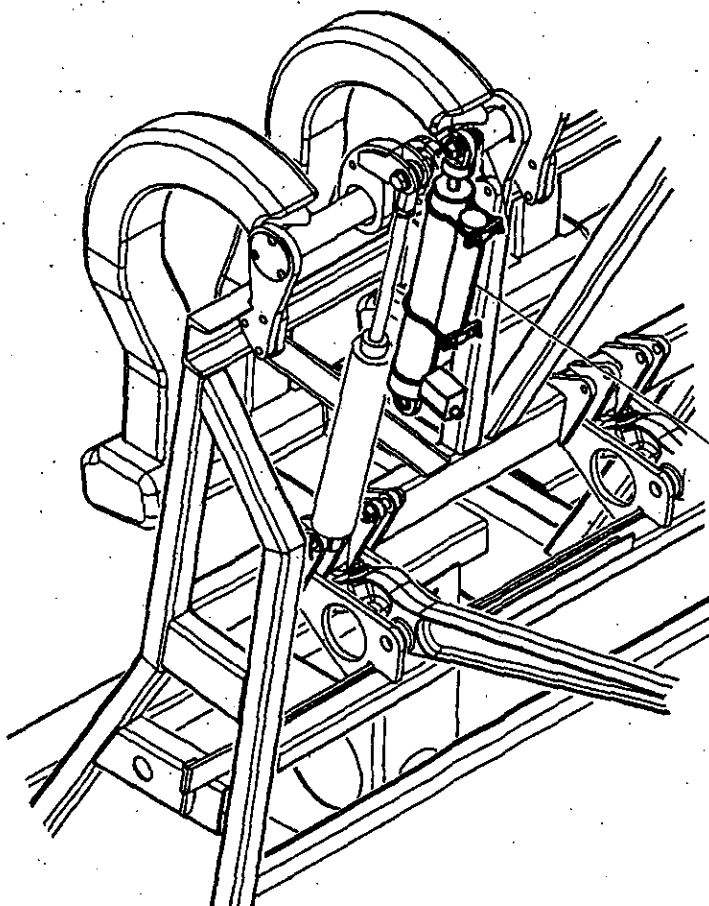
Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):

Inspection Procedure

Inspect the hydraulic lock cylinders for all seats (24 total). Identify the cylinders based on the distinguishing characteristics detailed on the next page.



Hydraulic lock cylinder
for primary restraint bar
(lap bar)



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 4200 Walker
 Wichita, KS 67277-2328
 U.S.A.
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 Website: www.rides.com
 E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

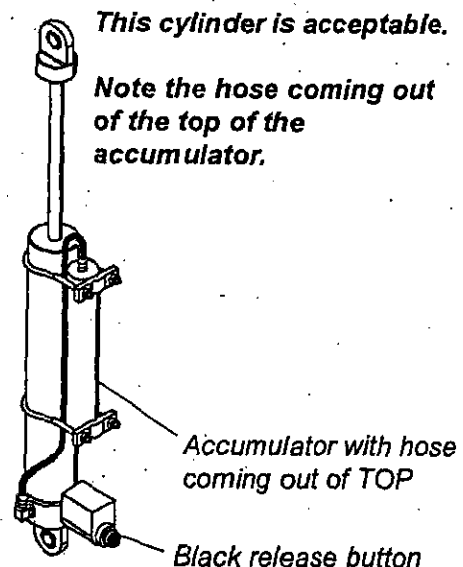
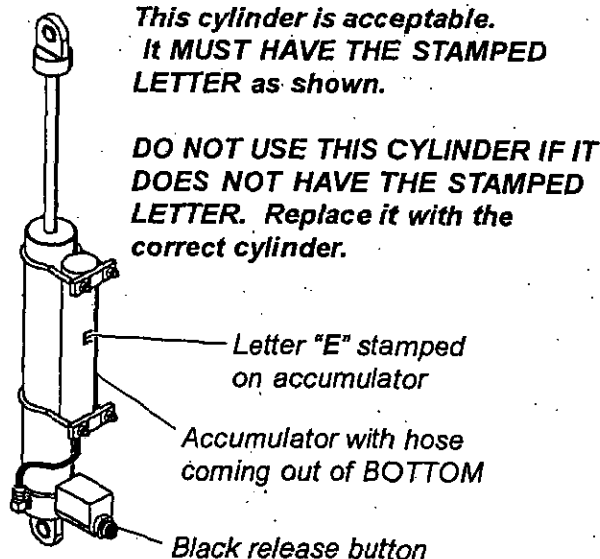
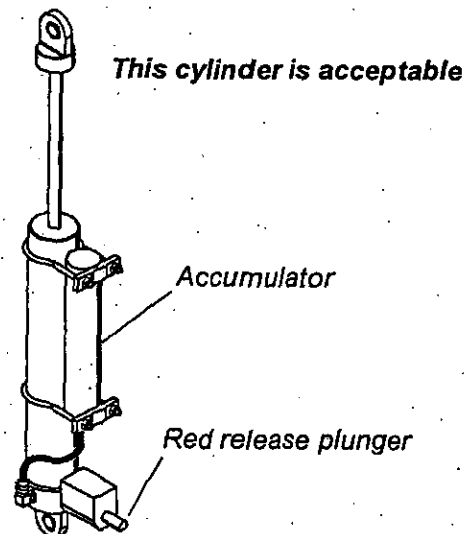
Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):





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4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.com

E-mail: rides@rides.com

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Page: 4 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):

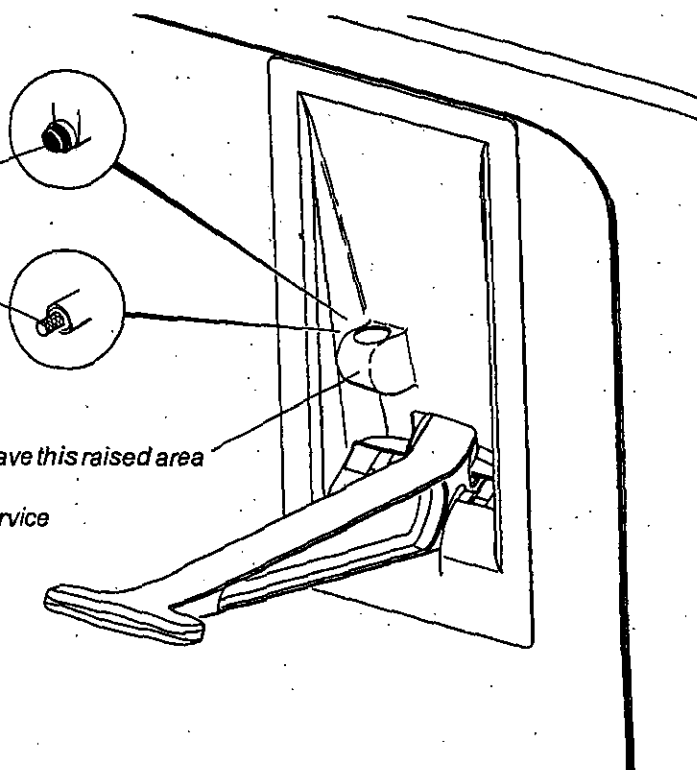
Operation - Manually releasing passenger restraints

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

To manually release the
PRIMARY RESTRAINT BAR
(shoulder bar)

- push the black release button
- or -
- pull the red release plunger

NOTE: All closeout panels must have this raised area
over the manual release.
(refer to Chance Rides Service
Bulletin B414R1215-0)



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4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.comE-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All Units

Model No.: 414

Detail of Issue (continued):

Monthly Inspection of Hydraulic Lock Cylinders

The primary restraint bar on each seat incorporates a hydraulic lock cylinder. Remove the back cover from the seat to gain access to the lock cylinders on that row of seats.

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

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.



CHANCE RIDES MANUFACTURING, INC.

4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER

Affected Serial Nos.: All Units

Model No.: 414

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 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 passenger restraint 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 to prevent moisture from entering.

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CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model Rides Only)

Affected Serial Nos.: All Units

Model No.: 414

Abstract of Issue:

Main Drive Software Changes

Reason For Release:

Chance Rides Manufacturing, Inc. has become aware of a problem with the software for the main drive system on the above noted INVERTER amusement rides. A condition can occur which causes the ride not to respond when the "Start Cycle" push-button is pressed.

An EEPROM programmed with improved software has been developed to eliminate this condition.

Action to be Taken:

The new software is not mandatory, and can be installed at the owner/operator's option. Ride operating procedures are not affected by this change.

Order the new software (part number 32516315). The EEPROM, labeled version 3.0.2, replaces the existing EEPROM in the PLC inside the main control cabinet. Make sure all power to the ride is off before changing the EEPROM.

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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CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

NDT Inspection Schedule

Reason For Release:

Specific areas of the above noted INVERTER amusement rides must be inspected by qualified NDT inspection personnel at scheduled intervals. This bulletin is being released to clarify and revise the information provided in the "Maintenance Manual" for these rides.

Action to be Taken:

All owner/operators of the above noted amusement rides are required to inspect the ride as specified in the following pages of this bulletin after the first four years of operation, then annually thereafter. The inspection must be performed by qualified NDT inspection personnel as specified.

IMPORTANT: The inspection areas defined in this bulletin must be performed in addition to all other required daily, weekly, monthly, and annual inspections.

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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 4200 Walker
 Wichita, KS 67277-2328
 U.S.A.
 Phone: 1-316-942-7411 • FAX: 1-316-942-2012
 Website: www.rides.com
 E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
 INVERTER (Park Model)
 DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

NDT Inspection Schedule

IMPORTANT: Chance Rides Manufacturing, Inc. typically specifies "visual inspection" on areas where a competent owner/operator can perform the inspection. THE FOLLOWING AREAS MUST BE INSPECTED BY QUALIFIED NDT PERSONNEL, REGARDLESS OF THE INSPECTION METHOD SPECIFIED.

Inspect the ride in the following areas using the inspection method specified. Inspection must be performed after the first FOUR YEARS of operation, then ANNUALLY thereafter.

Magnetic Particle Testing (MT) is done in accordance with ASTM E709 using the enclosed procedure. All other inspections are done by Visual Inspection (VT).

| COMPONENT | AREA (Refer to detail views on the following pages) | INSPECTION POINT (Location) | INSPECTION METHOD |
|--|---|---|----------------------|
| Main Arm | 1 | Gusset ends adjacent to gear box | MT |
| | 2 | Vehicle arm to arm hub at corners of arm | VT |
| | 3 | Counterweight arm attaching flange | VT |
| | 4 | Vehicle arm gusset extension ends (applies only to portable model rides with gusset extensions installed) | MT |
| Counterweight Arm | 5 | Outboard root of gusset | MT |
| | 6 | Weld at outboard end of doubler plates (portable model rides only) | VT |
| | 7 | Vehicle arm attaching flange | VT |
| Tower Hinge (portable model rides only) | 8 | Hinge blocks, brackets, pivot ears and doubler plates | VT |
| Vehicle | 9 | 4" x 12" lateral tube (Weld to back wall) | VT |
| | 10 | 4" x 12" tube (Fillet welds and gusset welds) | VT |
| Vehicle Arm Adapter Box | 11 | Welds around vehicle mounting blocks (vehicle must be removed from main arm) | MT |
| | 12 | Outboard root of stiffeners welded to circular barrel | MT |



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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Magnetic Particle Inspection (MT) Procedure

Use the following procedure where Magnetic Particle Inspection (MT) is specified.

1. Remove paint and contaminants from the area to be inspected.
2. Use dry powder and a magnetic yoke.
3. Position the yoke so that the longitudinal magnetic field cuts across the weld at a perpendicular angle.
4. After positioning the yoke, use the continuous method.
5. Inspect for discontinuities.
6. If any discontinuity is found, contact Chance Rides Manufacturing, Inc.



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

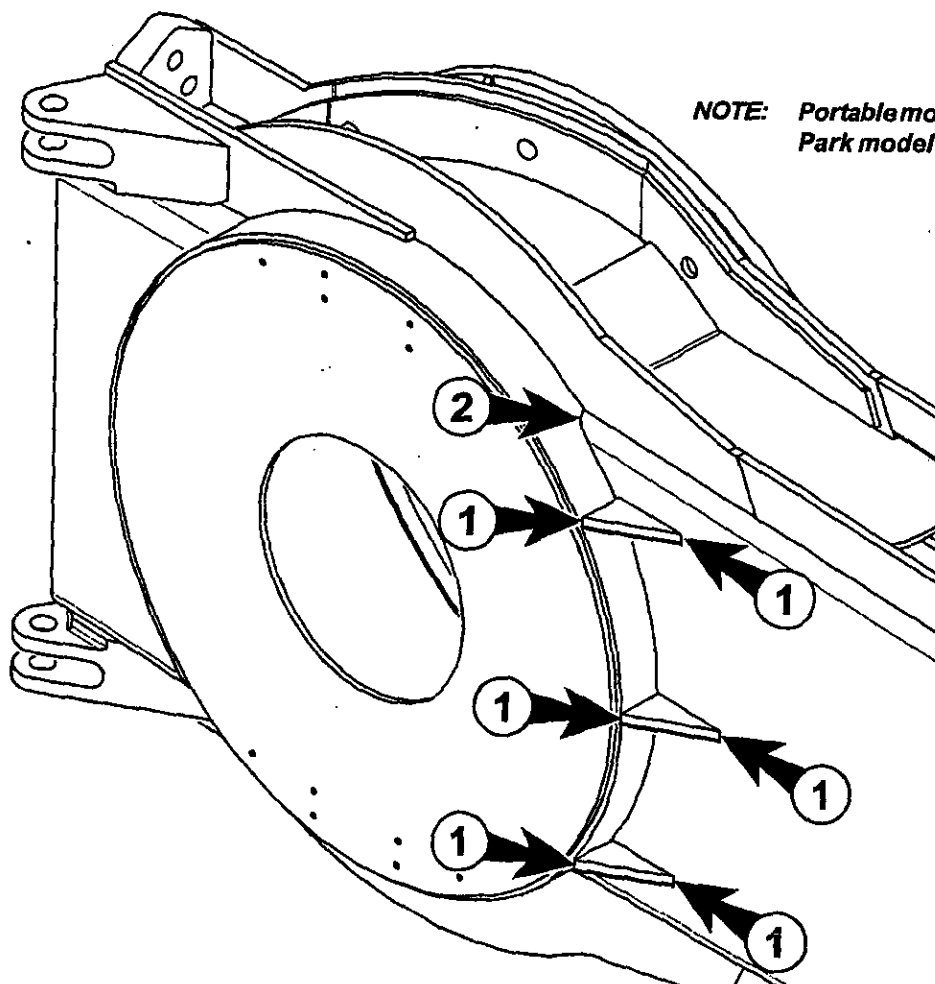
Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Area 1 (Main Arm) - Gusset ends adjacent to gearbox

Area 2 (Main Arm) - Vehicle arm to arm hub at corners of arm



NOTE: Portable model shown.
Park model is similar.



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B414CRM117-0

Release Date: December 1, 2003

Effective Date: See Text

Supersedes: N / A

Completion Date: See Text

Page: 5 of 11

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

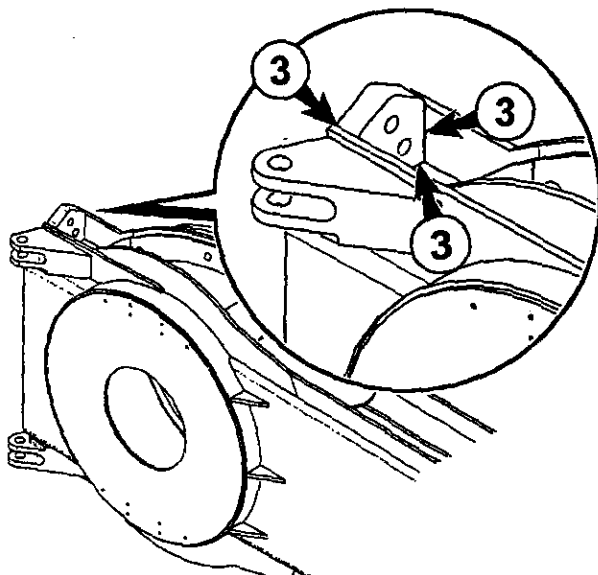
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

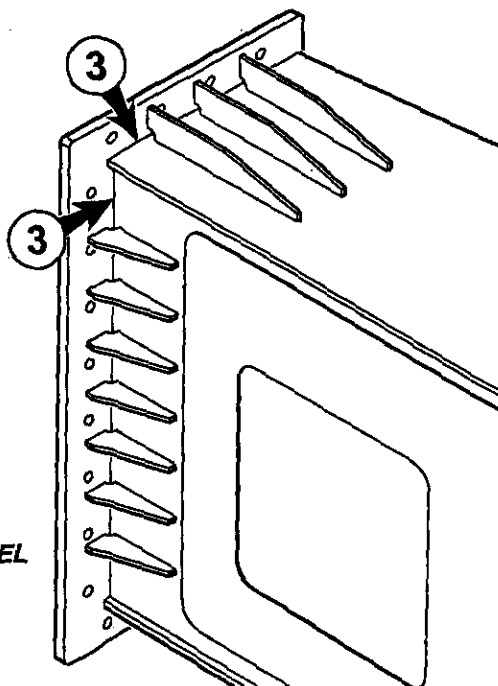
Model No.: 414

Detail of Issue (continued):

Area 3 (Main Arm) - Counterweight arm attaching flange



PORTABLE MODEL



PARK MODEL



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Wichita, KS 67277-2328
U.S.A.
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Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

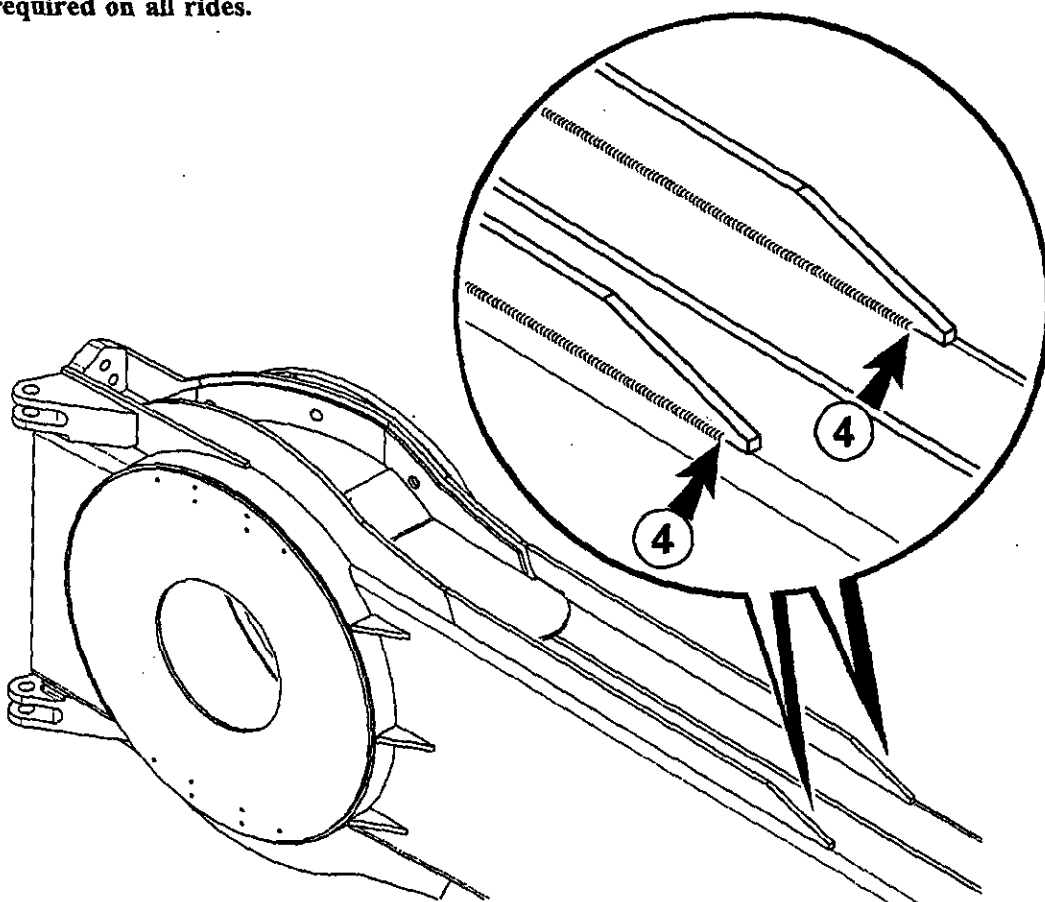
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Area 4 (Main Arm) - Vehicle arm gussets extension ends. This inspection point applies only to portable model rides equipped with the gusset extensions shown. These gusset extensions are not required on all rides.





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

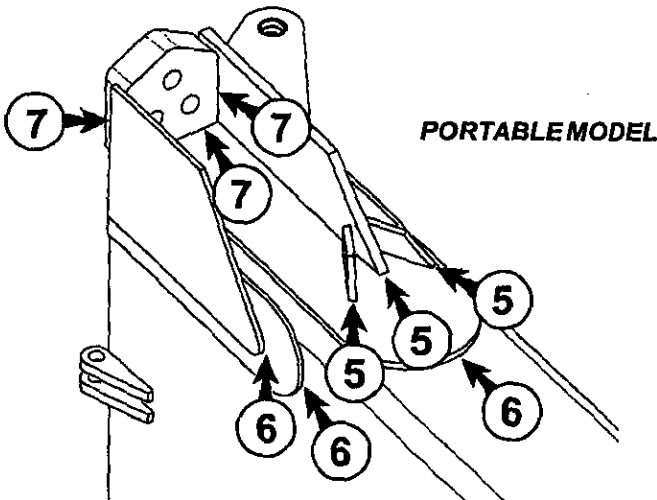
Model No.: 414

Detail of Issue (continued):

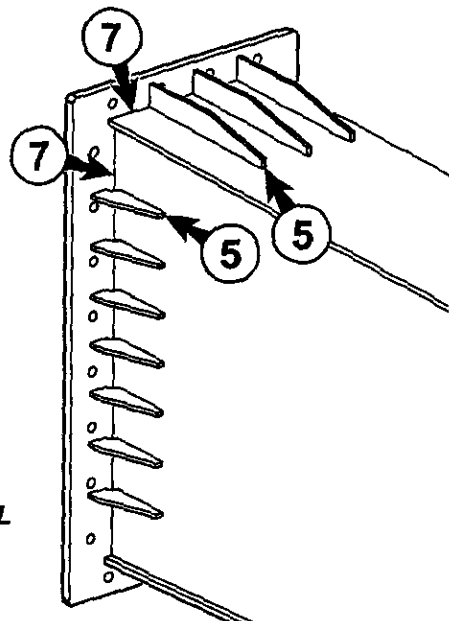
Area 5 (Counterweight Arm) - Outboard root of gussets

Area 6 (Counterweight Arm) - Weld at outboard end of doubler plates (portable model rides only)

Area 7 (Counterweight Arm) - Vehicle arm attaching flange



PARK MODEL





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

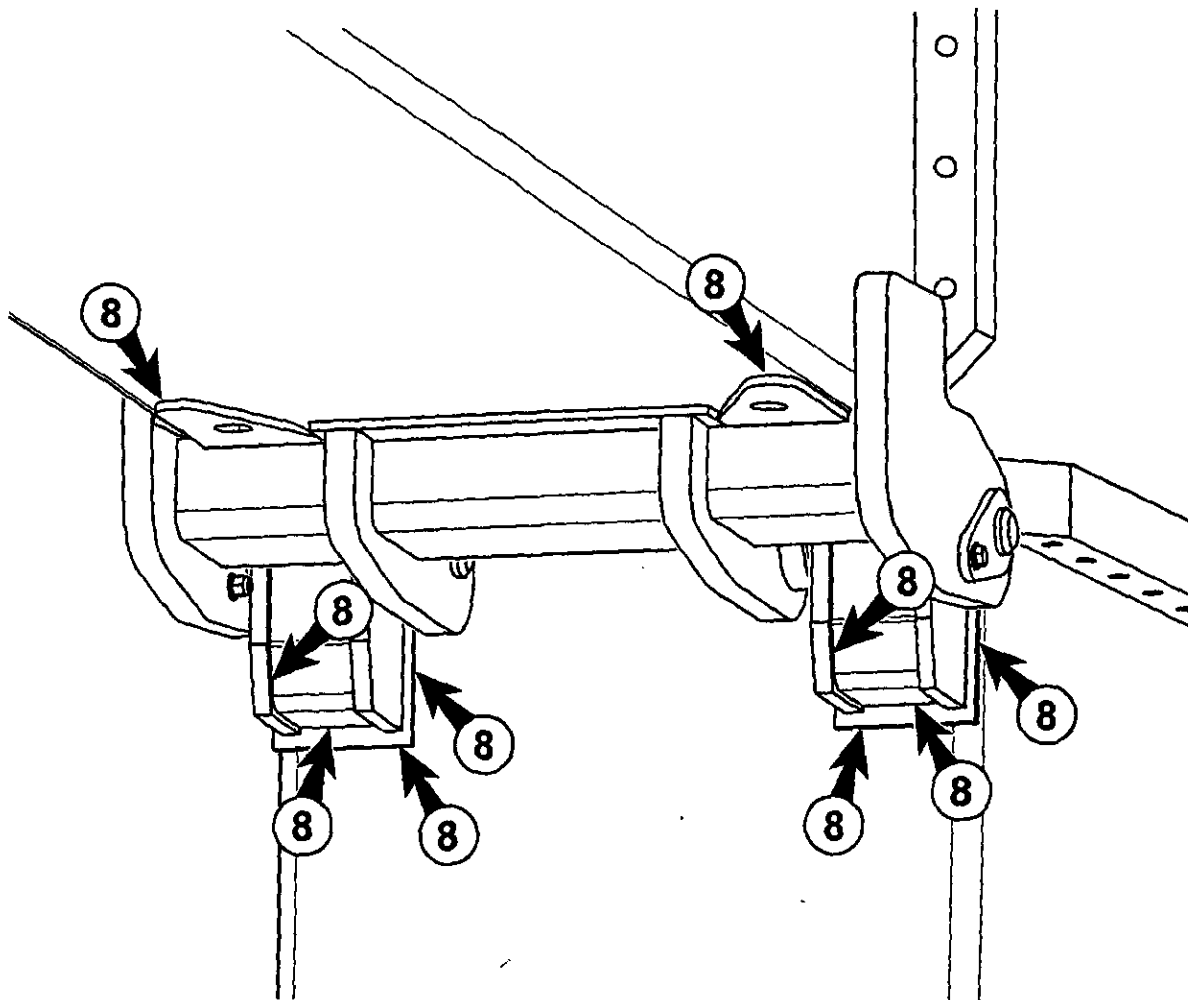
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Area 8 (Tower Hinge) - Welds and parent metal around hinge blocks, brackets, pivot ears and doubler plates. This inspection point applies only to portable model rides.





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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| Supersedes: | N / A |
| Completion Date: | See Text |
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

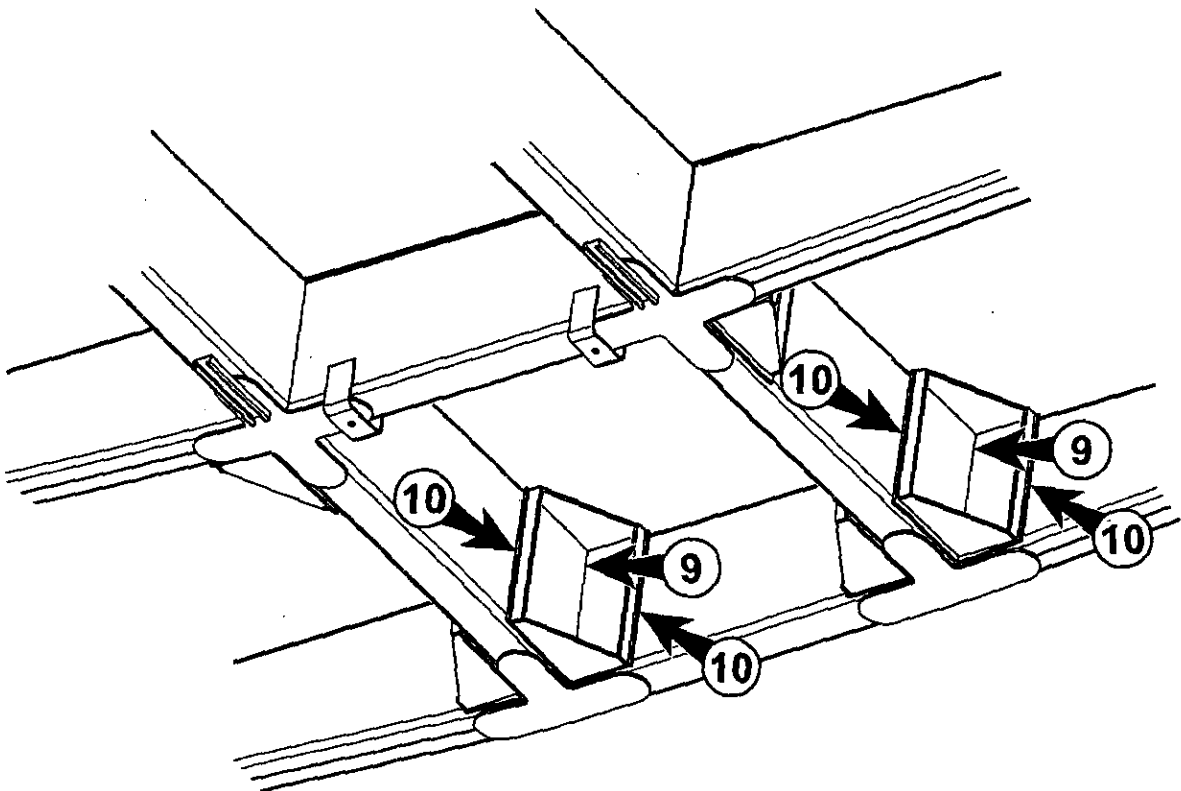
Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Area 9 (Vehicle Frame) - 4" x 12" lateral tube (weld to back wall)

Area 10 (Vehicle Frame) - 4" x 12" lateral tube (fillet welds and gusset welds)





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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| Completion Date: | See Text |
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

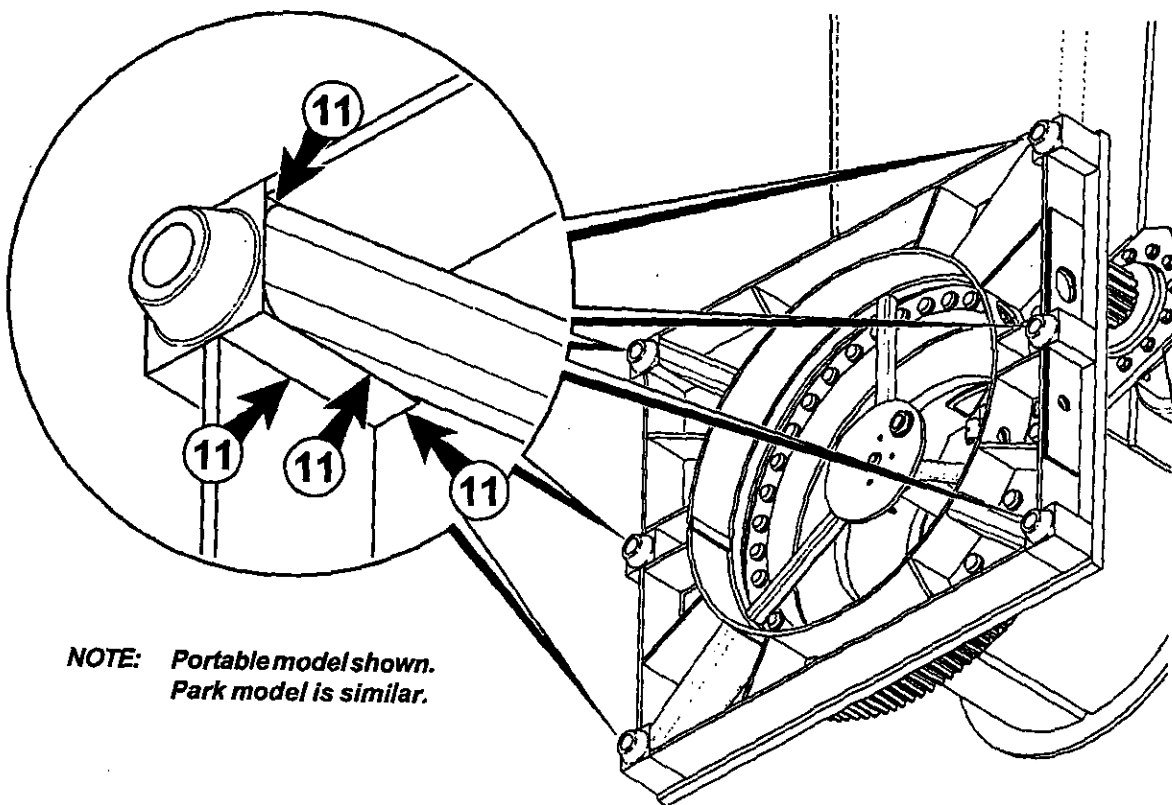
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Area 11 (Vehicle Arm Adapter Box) - Welds around vehicle mounting blocks



NOTE: Portable model shown.
Park model is similar.



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4200 Walker
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U.S.A.
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Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

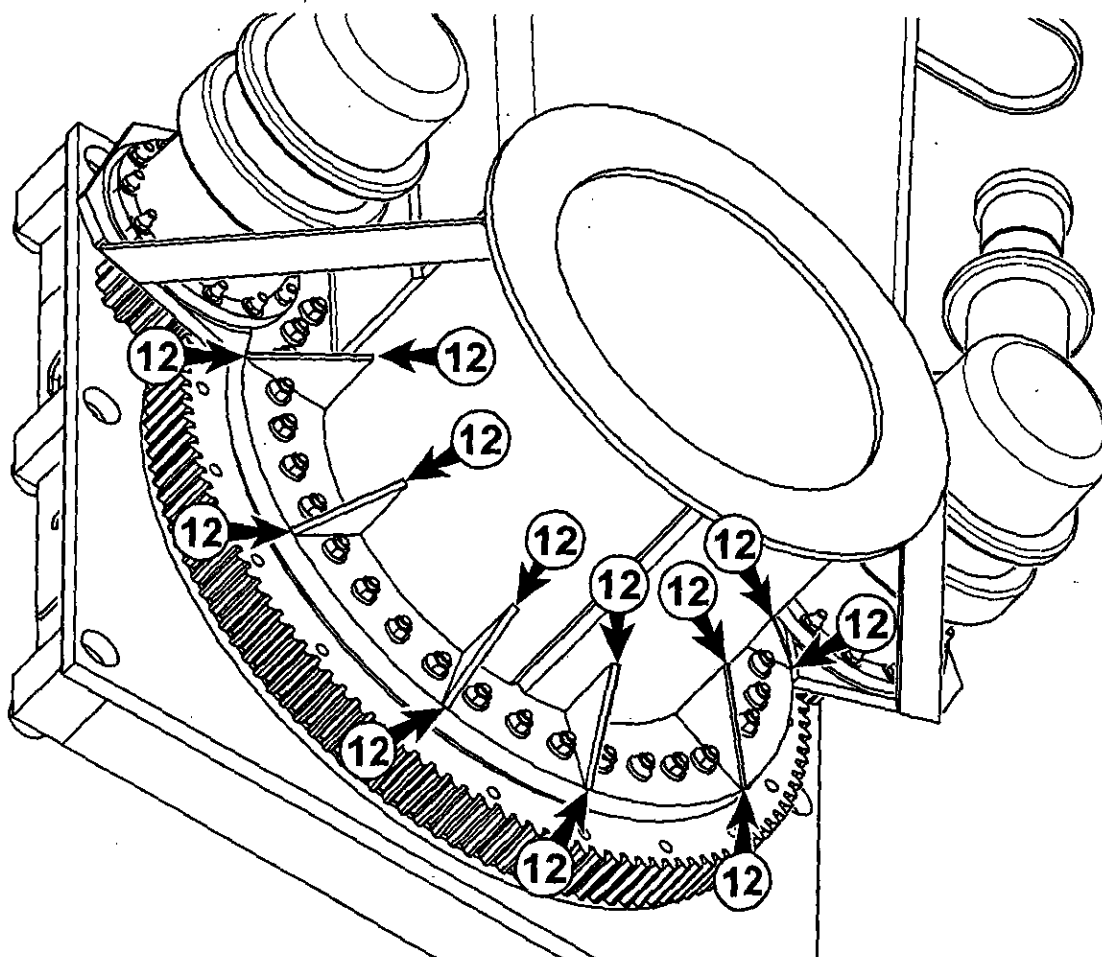
Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Area 12 (Vehicle Arm Adapter Box) - Outboard root of stiffeners welded to circular barrel

**NOTE: Portable model shown.
Park model is similar.**





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B414CRM131-0
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SERVICE BULLETIN

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

Ride Name: INVERTER (Portable Model) Affected Serial Nos.: All

Model No.: 414

Abstract of Issue:

Inspection of Main Bearing Capscrews

Reason For Release:

Chance Rides Manufacturing, Inc. has become aware of broken and/or loose capscrews which attach the main bearing on at least one portable model INVERTER ride. These capscrews secure the bearing to both the tower structure and the main arm, and must be kept properly tightened and in good condition. The capscrews are tightened to a torque of 160 ft.-lbs. at the factory, using LocTite® 271 (red) applied to the threads.

Action to be Taken:

All owner/operators of the above noted INVERTER amusement rides are required to inspect the capscrews for the main bearing using the procedure described on the following pages of this service bulletin. The inspection must be done immediately upon receipt of this bulletin, then annually thereafter.

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.

**CHANCE RIDES MANUFACTURING, INC.**

4200 Walker
Wichita, KS 67277-2328
U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.com

E-mail: rides@rides.com

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Release Date: July 30, 2004

Effective Date: July 30, 2004

Supersedes: N/A

Completion Date: N/A

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All

Model No.: 414

Detail of Issue

Main Bearing Capscrew Inspection Procedure

1. Locate the 40 capscrews which secure the main bearing to the arm. These capscrews are installed in through-holes in the outer bearing race and are secured by nuts on the outside of the flange as shown in the illustration.

NOTE: The heads of these capscrews are not accessible when the ride is assembled. Check the capscrews at the nuts, which are accessible from the back side of the flange.

2. Locate the 38 capscrews which secure the main bearing to the tower structure. These capscrews are installed into tapped holes in the inner bearing race.
3. Use a torque wrench to check all capscrews and nuts. SET THE TORQUE WRENCH TO ONLY 140 FT-LBS TO CHECK THE FASTENERS. This permits the fastener to be checked, but prevents damage to the LocTite.

NOTE: The space available to check some fasteners is limited. If necessary, use an extension, "crow's foot," or other adapter on the torque wrench to accurately check the tightness of the fastener.

When using adapters or extensions, the torque wrench reading must be corrected as specified by the tool manufacturer.

4. The fasteners must not turn when checked as instructed. If any fastener turns, it indicates a damaged or loose fastener. The fastener must be removed and replaced with a new part. Apply LocTite 271 (red) to the threads using the manufacturer's instructions. Tighten to the correct assembly torque of 160 ft-lbs.



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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

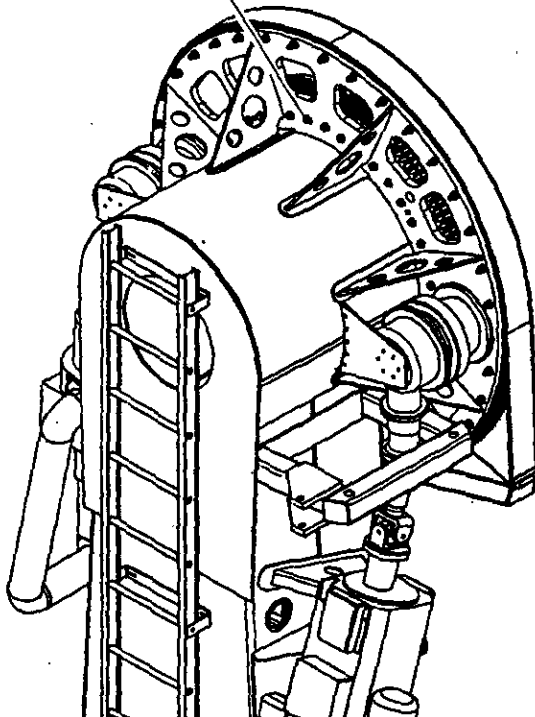
Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: All

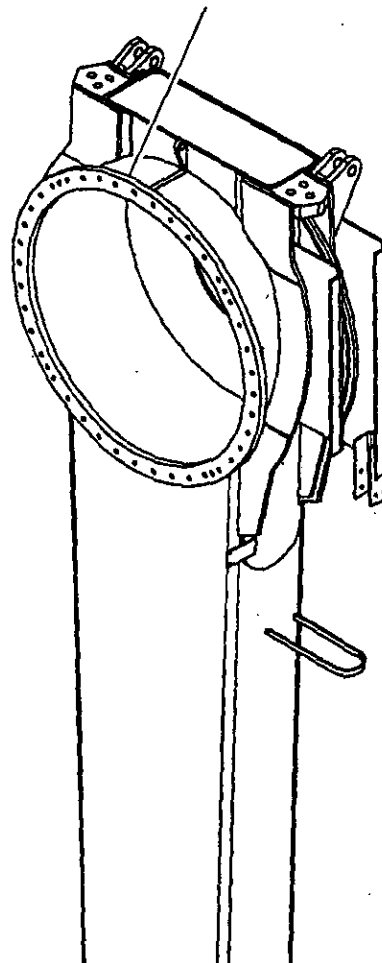
Model No.: 414

Detail of Issue (continued):

Bearing inner race is attached to the tower structure by these capscrews (38 places)



Bearing outer race is attached to the main arm structure on this flange. Nuts are accessible from back side of the flange (40 places)





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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: P414CRM127-0
Release Date: November 10, 2004
Effective Date: November 10, 2004
Supersedes: N / A
Completion Date: N / A
Page: 1 of 3

NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Vehicle Control Panel Replacement

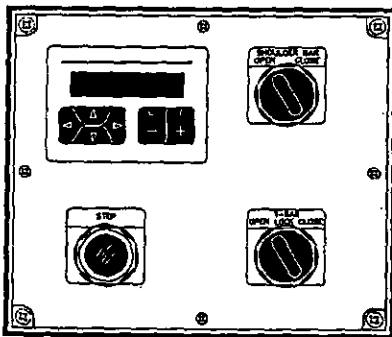
Reason For Release:

The display screen for the vehicle control panel on the INVERTER amusement ride has been discontinued by its manufacturer. This screen displays important information and is necessary for ride operation.

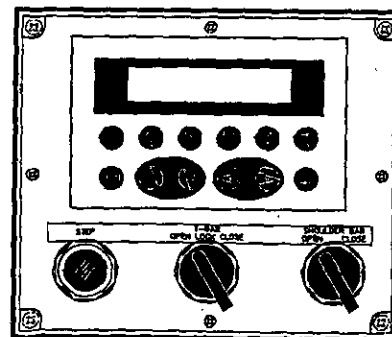
Chance Rides Manufacturing, Inc. has developed a retrofit kit which will permit replacement of the original control panel if the display screen becomes inoperative. The kit consists of a complete new control panel, including the restraint bar switches and indicator lights.

Action to be Taken:

In the event that the display screen on the vehicle control panel becomes inoperative, order the Vehicle Control Panel Retrofit Kit, part number 414-0441-001. Install the kit using the instructions on the following page of this bulletin. (NOTE: INSTALLATION OF THIS KIT IS NOT MANDATORY IF THE ORIGINAL CONTROL PANEL IS OPERATING PROPERLY)



Original Vehicle Control Panel



Retrofit Vehicle Control Panel

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4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.comE-mail: rides@rides.com

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Completion Date: N / A

Page: 2 of 3

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

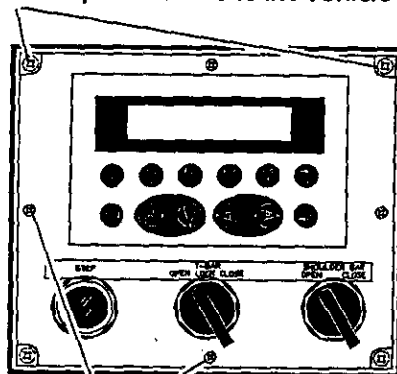
Model No.: *

Detail of Issue (continued):

Installation Instructions

1. Remove the four screws which secure the control panel frame in the vehicle.
2. Disconnect the wires from the control panel at the terminal block.
3. Remove the four screws which secure the control panel in the panel frame and install the new panel into the panel frame.
4. The new control panel is sub-assembled at the factory to simplify its installation. Connect the wiring from the new control panel to the terminal block. The wires are all numbered, and correspond with numbered terminals on the terminal block. Install the frame into the vehicle.
5. Check the operation of the controls and perform the "Passenger Restraint System Operational Check" as described in the *INVERTER Service Manual* before putting the ride into service.

The corner screws secure the control panel frame to the vehicle



These screws secure the panel to the frame

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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 4200 Walker
 Wichita, KS 67277-2328
 U.S.A.
 Phone: 1-316-942-7411 • FAX: 1-316-942-2012
 Website: www.rides.com
 E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

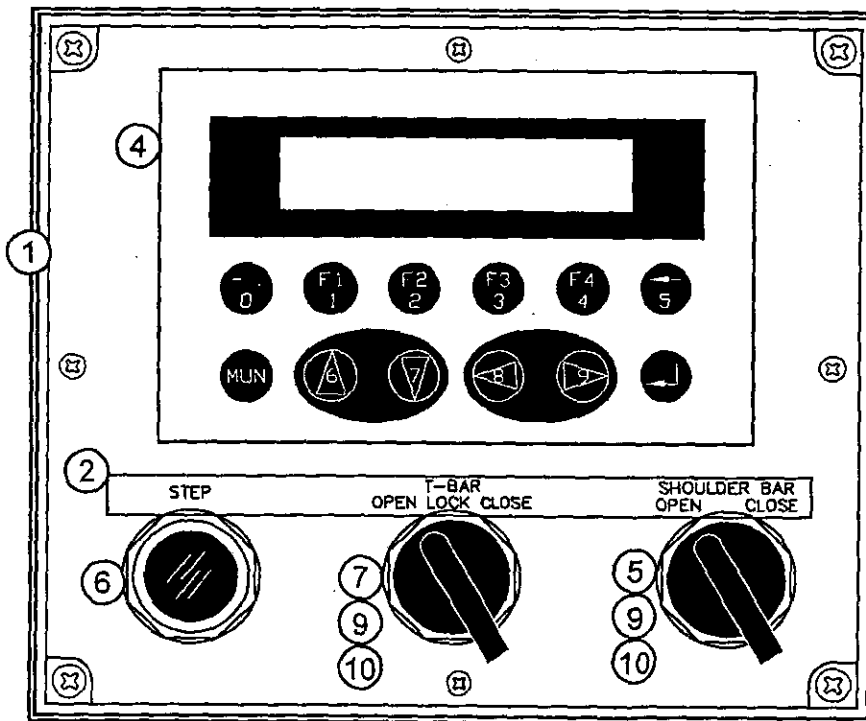
Ride Name: INVERTER (Portable Model)
 INVERTER (Park Model)
 DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Parts List for New Vehicle Control Panel



| Ref. No. | Part Number | Component | Qty. |
|----------|--------------|---------------------------------------|------|
| 1 | 414-0441-011 | FRONT PLATE | 1 |
| 2 | 414-0441-012 | LEGEND PLATE | 1 |
| 3 | 22275202 | COMMUNICATION CABLE (not shown) | 1 |
| 4 | 24841210 | SCREEN | 1 |
| 5 | 24842921 | OPERATOR - 2 POSITION GREEN | 1 |
| 6 | 24842927 | OPERATOR - PILOT LIGHT GREEN | 1 |
| 7 | 24842932 | OPERATOR - 3 POSITION GREEN | 1 |
| 8 | 24842900 | POWER MODULE (not shown) | 1 |
| 9 | 24842902 | CONTACT BLOCK N/O | 3 |
| 10 | 24842903 | CONTACT BLOCK N/C | 3 |



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U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Abstract of Issue:

Inspection and Maintenance of Vehicle Drive Shafts

Reason For Release:

The position of the vehicle is controlled by two drive shaft assemblies. Gearboxes at both ends of each drive shaft engage the static ring on the tower and the bearing on the vehicle. The drive shafts and all related components must be installed correctly and maintained properly to ensure the proper position of the vehicle throughout the ride cycle.

This bulletin outlines the specific areas of these components which must be maintained in accordance with good mechanical practice and the manufacturer's specifications. This bulletin is being released to supplement the information provided in the *INVERTER Service Manual*.

Action to be Taken:

All owner/operators of the above noted amusement rides are required to inspect the drive shafts monthly or at every set-up, whichever occurs first. The inspection procedure is described on the following pages of this bulletin. In addition to this inspection, the four pillow block bearings must be replaced annually to ensure that they are in good operating condition. Important drive shaft servicing information is also included in this bulletin.

It is highly recommended that detailed records be maintained regarding the maintenance of these components to verify that the required work has been performed in accordance with the specifications 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.

4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.com

E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

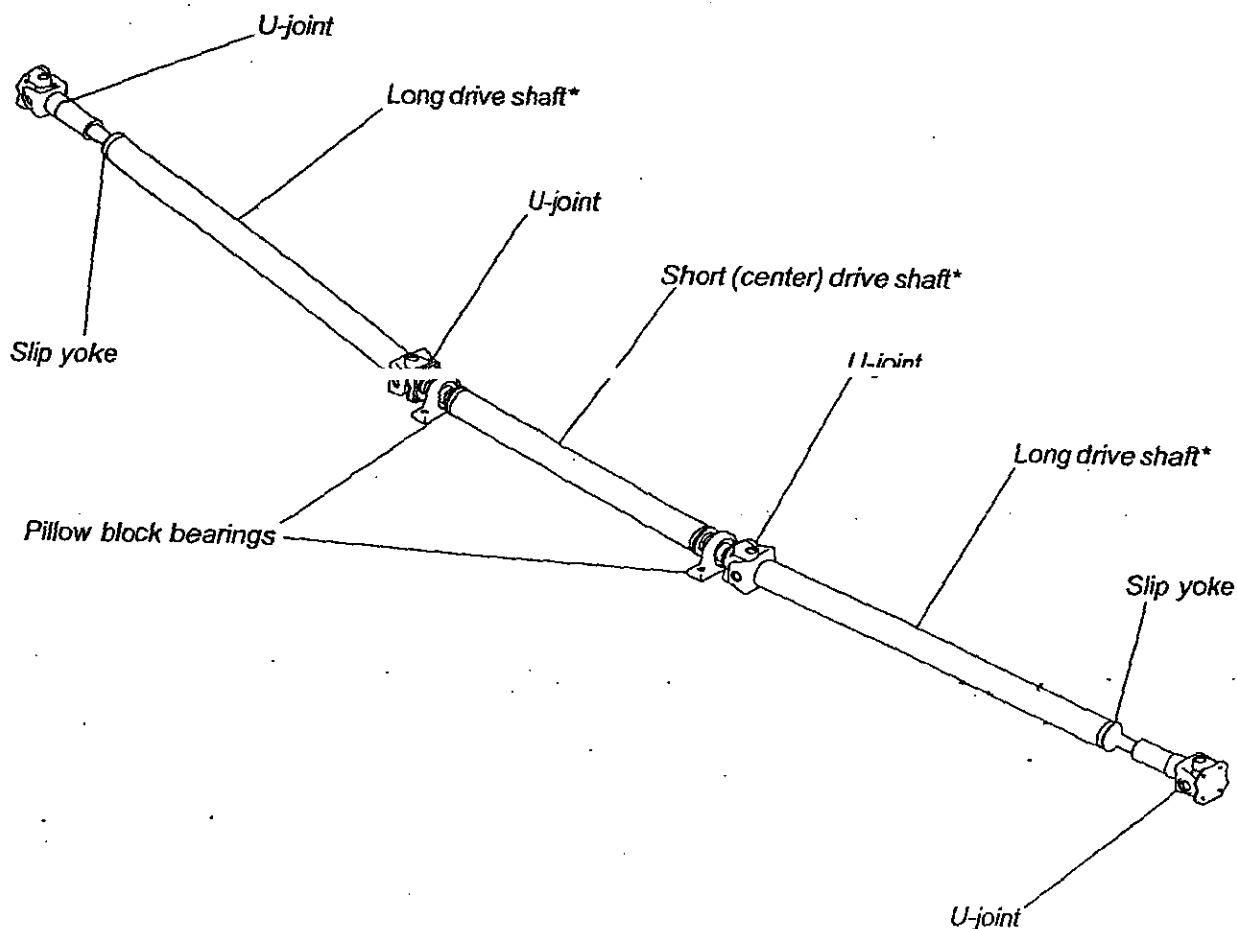
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Drive Shaft Component Identification



* These components are not serviced separately



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Drive Shaft Inspection

The following items must be inspected monthly or at every set-up, whichever occurs first. These items can be inspected with the drive shafts installed on the ride.

1. Check for loose fasteners at the flanges at both ends of the drive shaft assemblies. Refer to the *INVERTER Maintenance Manual* for fastener size and torque specifications.
2. Check the drive shaft assemblies for loose or missing balance weights, bent tubing, cracks, or any other signs of damage.
3. Check the pillow block bearings for loose fasteners, damaged seals, leaking lubricant or signs of looseness or wear in the bearing.
4. Check the slip yoke splines for excessive movement.
5. Check the u-joints for cracks, pitting, signs of damage, surface fatigue and looseness.

NOTE: Check u-joint for looseness by grasping one side of the drive shaft behind the u-joint and placing your other hand on the opposite side of the u-joint while rotating the drive shaft back and forth in opposite directions. If any looseness is found, replace the u-joint before putting the ride back into service.

6. Check the two long drive shafts and the short (center) drive shaft for proper phasing (refer to illustrations on following pages). If a drive shaft is found to be improperly phased, it must be removed from the ride to correct the problem.

NOTE: To check the phasing of the two long drive shafts, pay attention to the position of the yokes at each end. The yokes must be exactly aligned with each other. To check the phasing of the short (center) drive shaft, look at the flanges at each end. The flanges must be exactly aligned with each other.

An improperly phased drive shaft usually occurs when the drive shaft is assembled, and the splined connection at the slip yoke or flange is not rotated to the proper position. To avoid this, make a reference mark on both parts of the drive shaft before disassembling the slip yoke or flange.



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4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

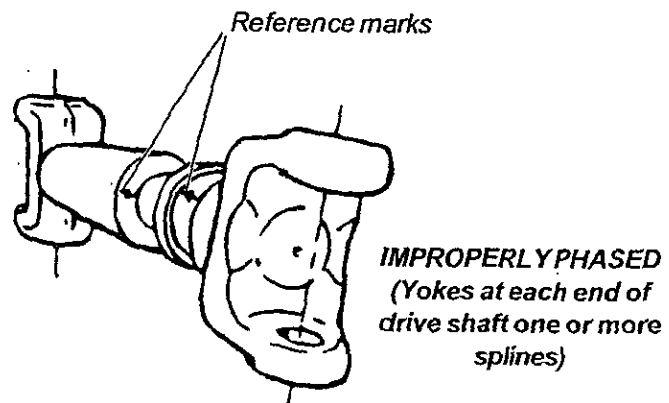
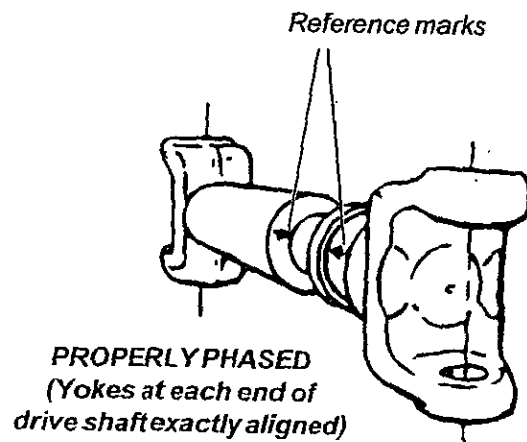
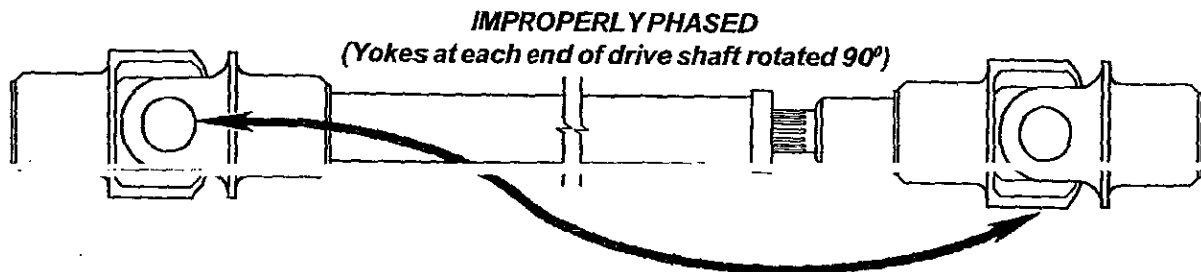
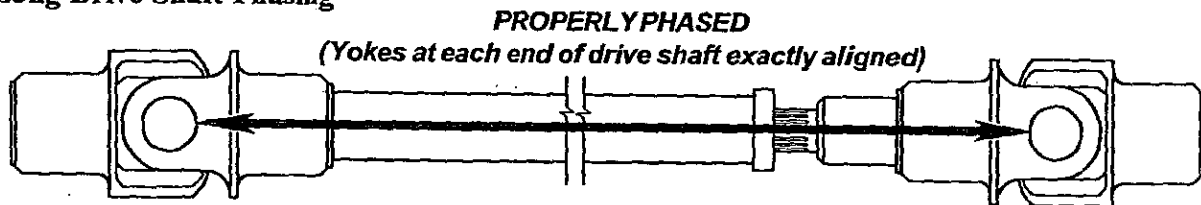
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Long Drive Shaft Phasing





CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

| | |
|------------------|-----------------|
| Bulletin No: | B414CRM147-0 |
| Release Date: | August 18, 2006 |
| Effective Date: | August 18, 2006 |
| Supersedes: | N / A |
| Completion Date: | See Text |
| Page: | 5 of 6 |

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

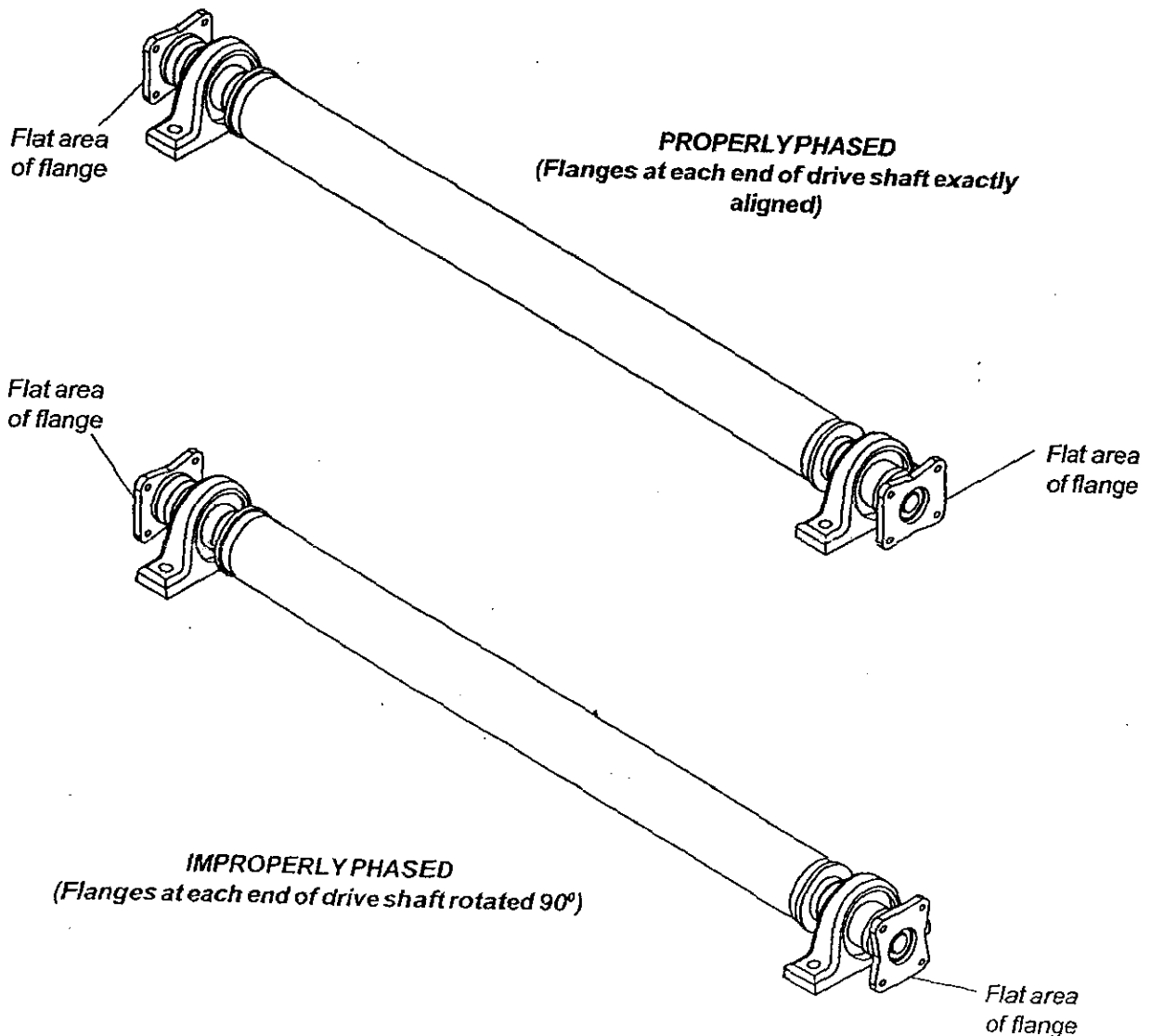
Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Short (Center) Drive Shaft Phasing



**CHANCE RIDES MANUFACTURING, INC.**

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Completion Date: See Text

Page: 6 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: INVERTER (Portable Model)
INVERTER (Park Model)
DOUBLE INVERTER

Affected Serial Nos.: All units

Model No.: 414

Detail of Issue (continued):

Drive Shaft Service

The following items must be considered when servicing and/or repairing the vehicle drive shafts:

1. Drive Shaft Balance - Each vehicle drive shaft assembly is made up of three individual drive shafts. The drive shaft assembly is balanced as an assembly.

IMPORTANT: *Never replace individual drive shaft(s) within the drive shaft assembly - the correct balance cannot be maintained. If an individual drive shaft is damaged, or requires replacement for any reason, ORDER A COMPLETE NEW DRIVE SHAFT ASSEMBLY.*

2. Pillow Block Bearings - The pillow block bearings must be lubricated per the *INVERTER Maintenance Manual*. The pillow block bearings must be replaced with new parts annually, regardless of their condition, or any time that the bearings exhibit signs of wear, damage, excessive noise, looseness, etc.
3. U-Joints - The u-joints must be lubricated per the *INVERTER Maintenance Manual*. The u-joints must be replaced at the first sign of wear, looseness, noise, etc.
4. Slip Yokes - The slip yokes must be lubricated per the *INVERTER Maintenance Manual*. The slip yokes must be replaced at the first sign of wear, looseness in the splines, noise, etc. If a slip yoke is disassembled for service, it must be re-assembled correctly to obtain the proper phasing of the drive shaft as described in this bulletin.

IMPORTANT: *Before disassembling the slip yoke, make reference marks on both sides of the splined connection to ensure that the parts are properly re-assembled.*

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.