



CHANCE RIDES, INC.
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Bulletin No:	B387R1265-0
Release Date:	December 20, 2001
Effective Date:	December 20, 2001
Supersedes:	N/A
Completion Date:	See Text
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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: SEA DRAGON

Affected Serial Nos.: All Units

Model No.: 387

Abstract of Issue:

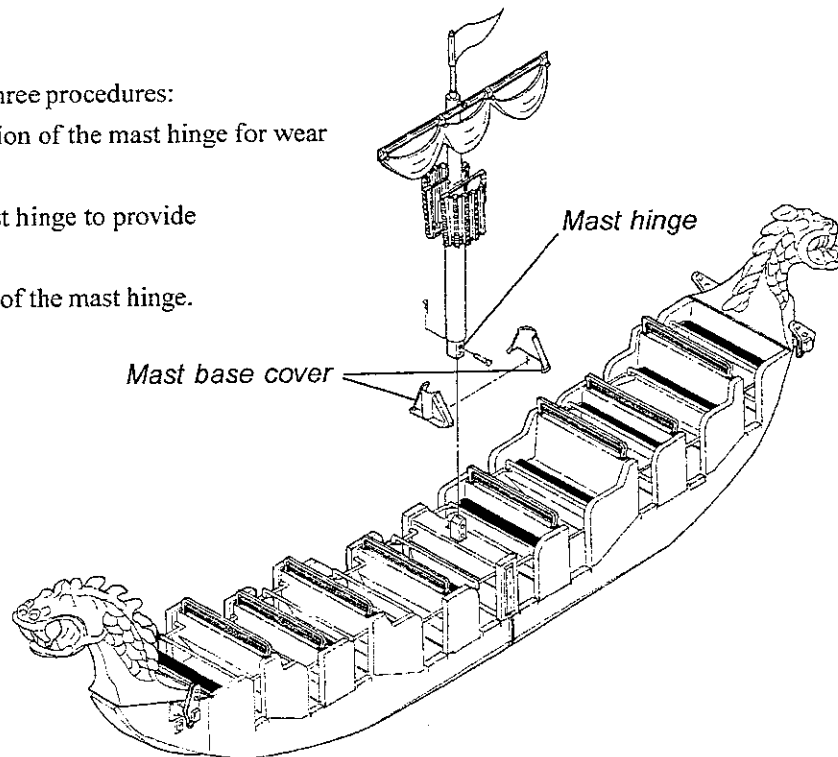
Mast Hinge Inspection and Rework

Reason For Release:

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

This bulletin describes three procedures:

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





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Ride Name: SEA DRAGON Affected Serial Nos.: All Units

Model No.: 387

Detail of Issue:

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

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

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

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

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

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

NOTICE

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

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



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Model No.: 387

Action to be taken

Inspection Procedure

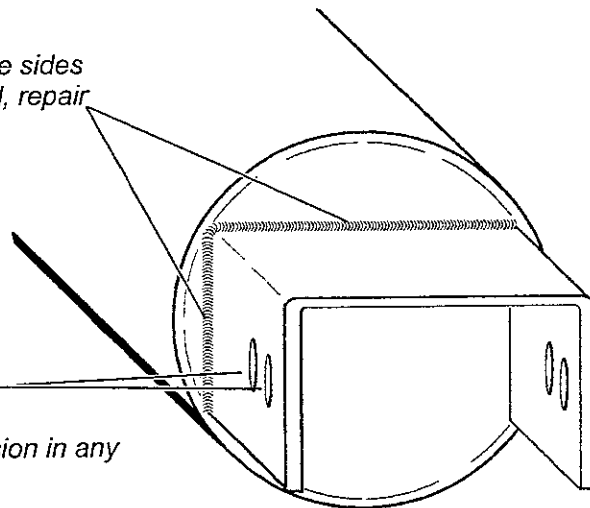
Perform the following inspection procedure immediately upon receipt of this bulletin.

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

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

Inspect all four holes for wear.

The maximum allowable dimension in any direction is 1.150".





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Action to be taken (continued):

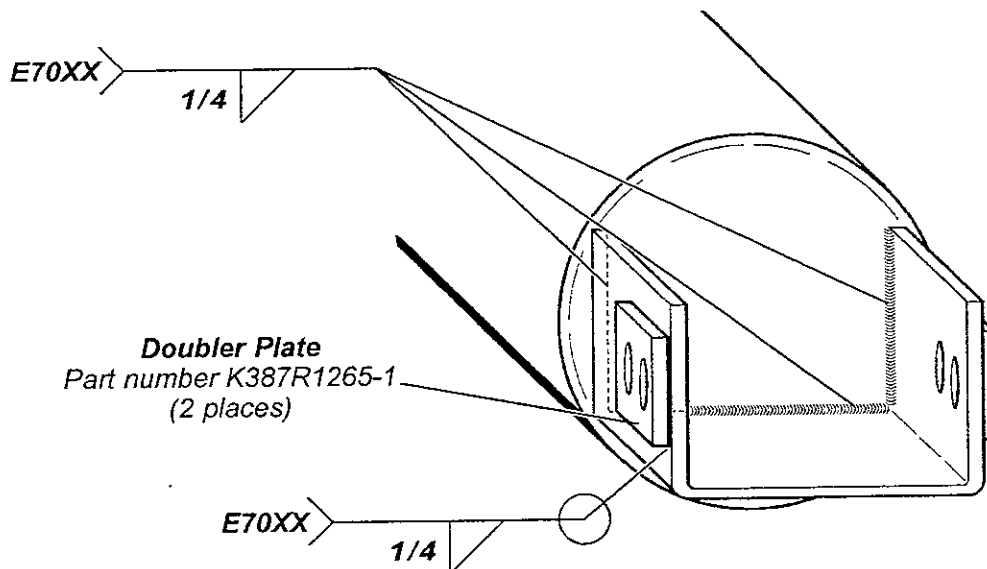
Rework Procedure

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

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

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

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





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Model No.: 387

Action to be taken (continued):

Annual Inspection of Mast Hinge

Perform the following inspection on the mast hinge annually.

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