

# Tivoli Mfg. Ltd.

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## Safety Bulletin

**Bulletin No:** SOSA013

**Ride Type:** Spin Out

(aka. The Claw, The Maelstrom, El Nino)

**Date:** March 22, 2004

**Page:** 1 of 2

**Rides Included:** All Rides

**Pages:** 2

**Parts supplied:** N/A

**Purpose:** Structural Inspection of sweep arms

**In cooperation with the Consumer Products Safety commission (CPSC), Tivoli Mfg. Ltd is issuing this bulletin. This supercedes all previous bulletins issued by Tivoli concerning sweep arm inspection procedures.**

Tivoli requires that all rides must have installed the reinforcement gusset kits as described in safety bulletin SOSA010. If this kit has not been added on your ride sweep arms, the ride must not be operated until the gusset plate kit is installed.

After the kit has been installed it is necessary to follow the inspection procedures indicated below. These inspection procedures supercede all previous bulletins concerning inspection of the sweep arms.

**Annual inspection:** Every 400 hours or one (1) year, which ever comes first.

Inspect all sweep arm welds in addition to the welds installing the gusset kit using nondestructive (NDT) inspection techniques. The 400-hour NDT test requirements can include ultrasonic, magnetic particle, or dye penetrant inspection by a professional inspector.

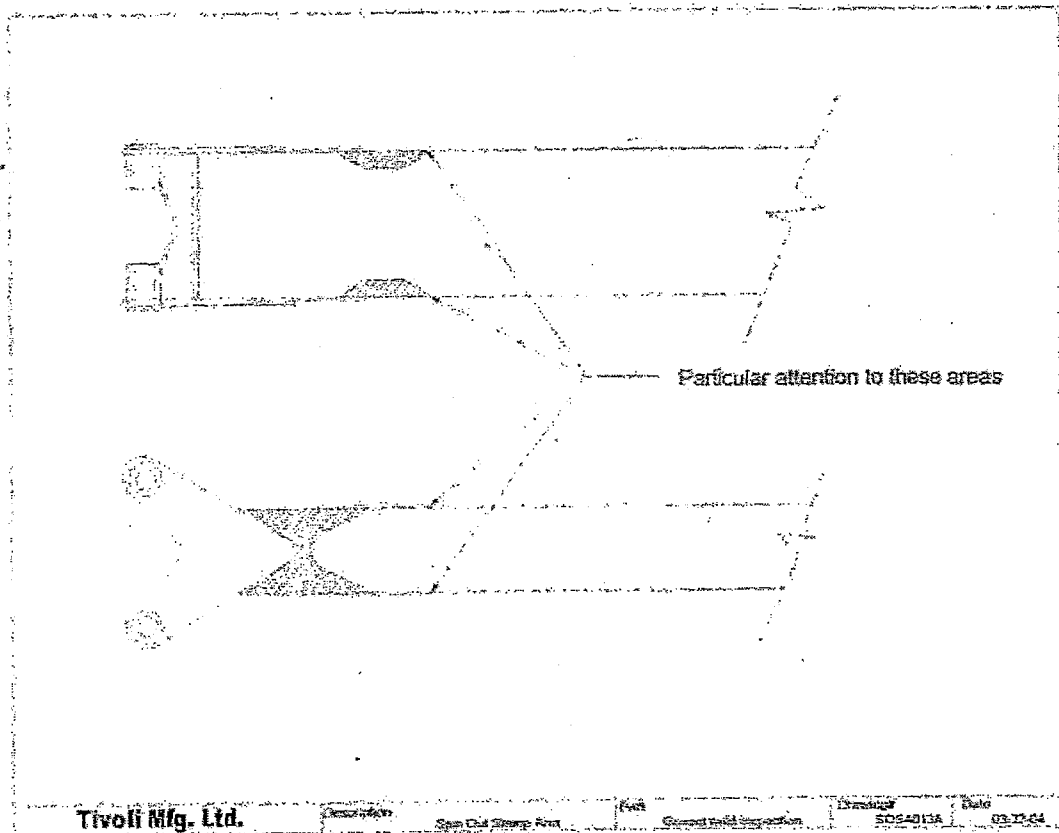
This inspection must be documented and retained in the ride's logbook.

**Bi-annual inspection:** Every 200 hours or six (6) months, which ever comes first.

This inspection is required to be made midway between the annual inspection.

Visually inspect all welds on the entire sweep length of each sweep arm. Pay particular attention to the tips of the side gussets as indicated in the attached drawing SOSA013A.

A trained inspector must carry out all visual sweep inspections. This inspection must be documented and retained in the ride's logbook.



If any cracks are detected, the ride must remain closed and Tivoli Mfg. Ltd. or AmTech / Amusement Technologies Intl. Inc (817-641-5045) should be contacted for repair instructions and procedures.

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