



**CHANCE RIDES, INC.**  
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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)      Affected Serial Nos.: 414-005S99, 414-008S00 and 414-011S00  
DOUBLE INVERTER      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

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

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



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Action to be taken (continued):

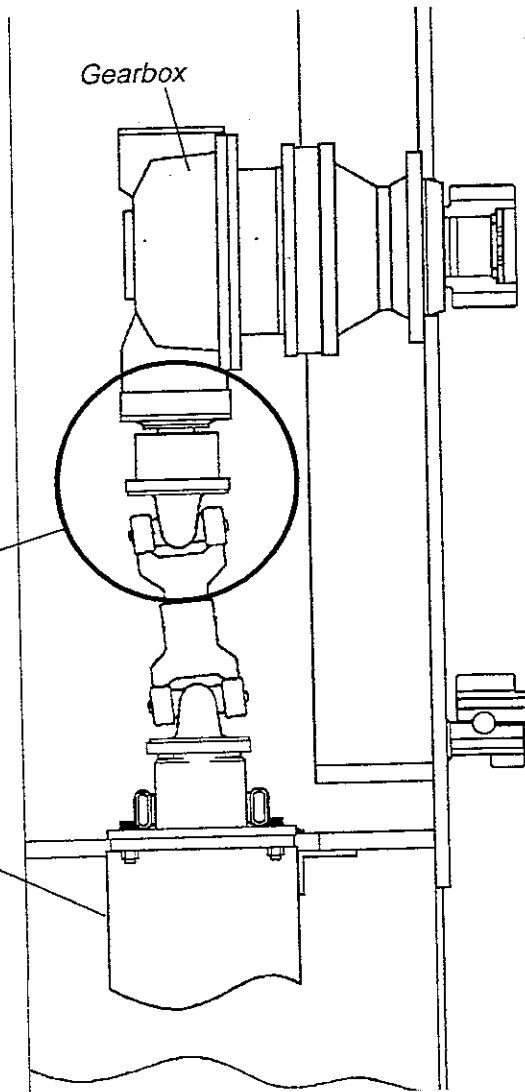
### Inspection Procedure - Main Arm Drive Shaft (inside tower)

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.



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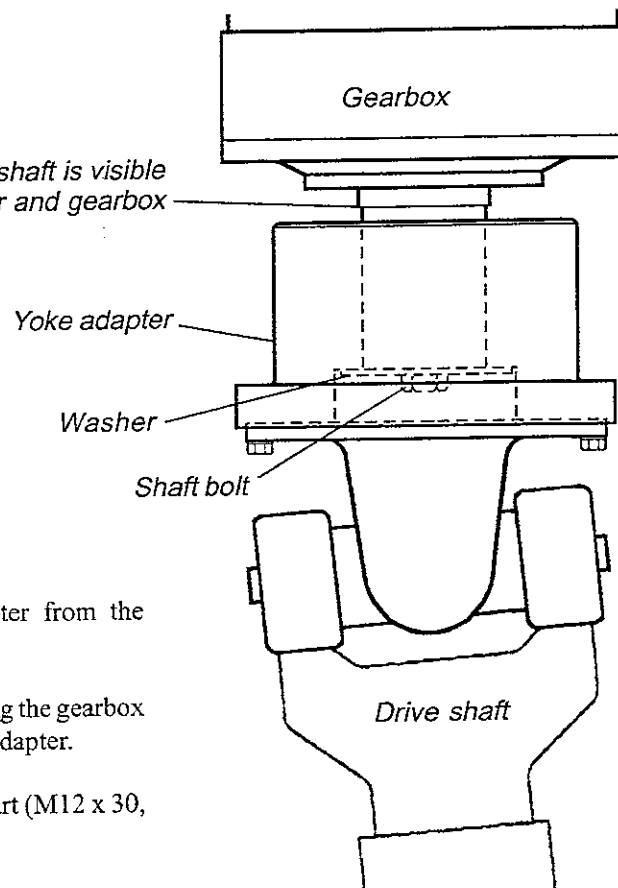
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Action to be taken (continued):

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



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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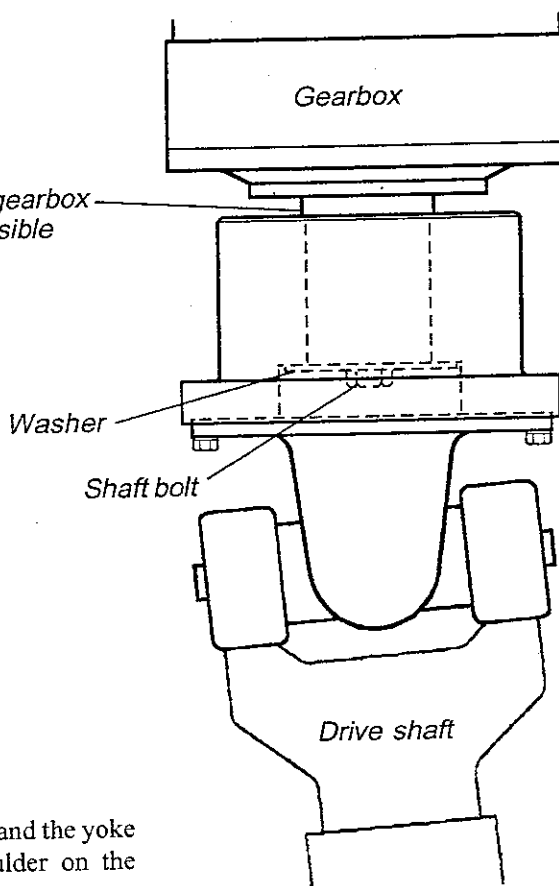
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Action to be taken (continued):

**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.