



Number: B392R1020-0

Date: March 21, 1988

Supersedes:

SERVICE BULLETIN

Effective Serial Numbers: 392-008-86 through 392-014-87

Ride: THUNDERBOLT

Subject: Master Sweep Bearing
Cap Rework (Capscrews)

As a safety precaution, CHANCE RIDES, INC. requires that the owners of THUNDERBOLT amusement rides with the above noted serial numbers perform the modification described in this bulletin. This modification will provide improved retention of the master sweep bearings in the center hub.

Order kit number K76-0317-00, which includes all necessary parts and hardware for one complete ride. Install the kit using the instructions provided on the following pages of this bulletin. Fill out the attached Certification Of Compliance for the installation within 15 days of receipt of the kit.

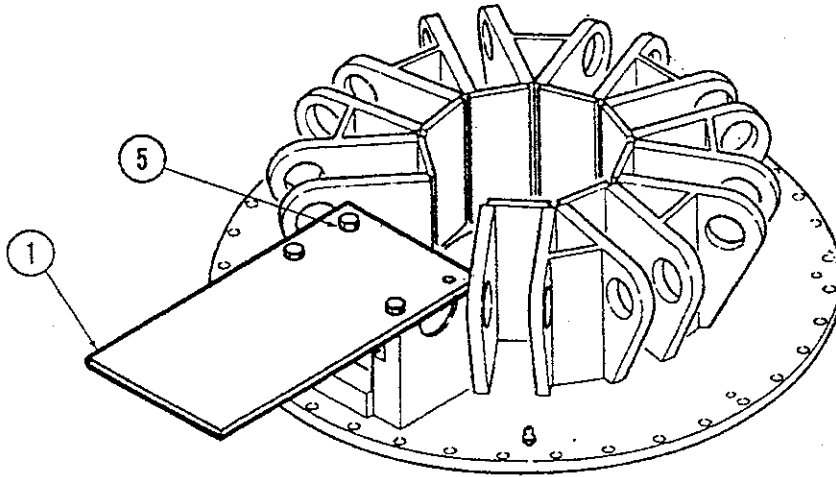
PARTS LIST

Kit Number K76-0317-00 Master Sweep Bearing Cap Rework

<u>Item No.</u>	<u>Quantity</u>	<u>Part Number</u>	<u>Description</u>
1	1	376-31703	Drill Guide (K76-0317-01)
2	4	686-09831	Capscrew - 7/8-9 x 4-1/2" (Grade 8)
3	4	376-85568	Hardened Washer - Special (K76-0317-02)
4	1	---	Tap (7/8-9 Thread)
5	3	686-09512	Bolt - 3/4-10 x 1-1/2"
6	3	686-10226	Bolt - 7/8-9 x 1-1/2"
7	1	---	Drill Bit (49/64" Diameter)
8	1	---	Drill Bit (29/32" Diameter)

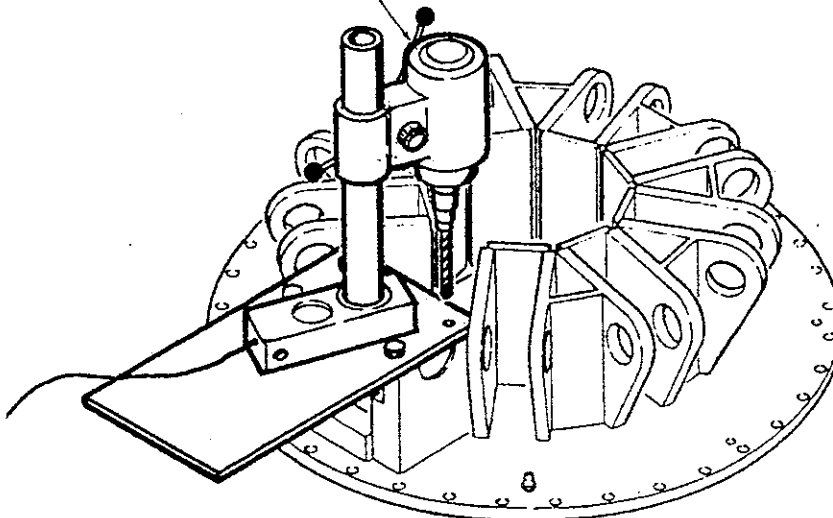
INSTALLATION INSTRUCTIONS

1. Use the chain hoist to remove the two sweeps from the master sweep.
2. Using the hoist to support the weight of the master sweep, remove the four 3/4-10 bolts from the bearing caps. Remove the cap and move the master sweep out of the way.



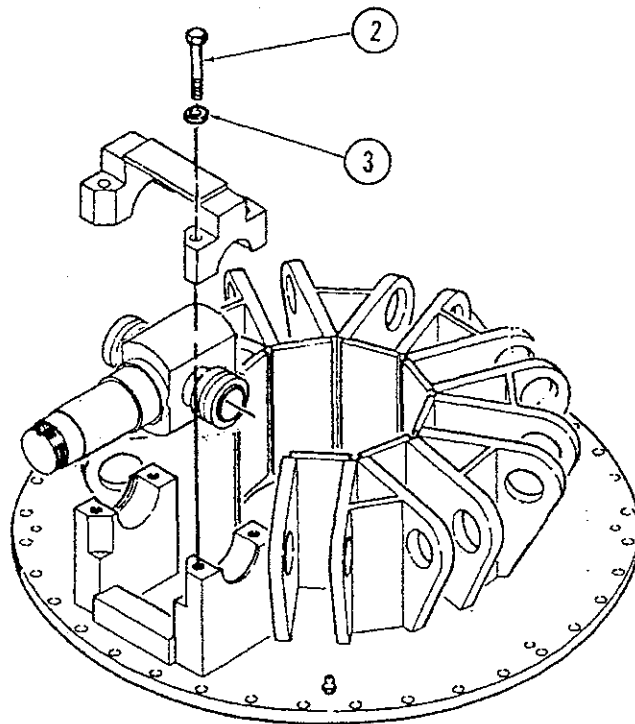
Use three 3/4-10 x 1-1/2" bolts (Item #5) to mount the drill guide (Item #1) to the bearing blocks on the center hub as shown.

PORTABLE
DRILL PRESS,



1. Using a 1-1/4" capacity portable drill press with a magnetic base, locate the drill exactly over the existing threaded hole. Drill the hole to 49/64" diameter, 3" deep, using the bit provided (Item #7). DO NOT USE A HAND-HELD DRILL MOTOR.

5. Tap the hole to 7/8-9, 2-1/2" deep using the tap provided (Item #4). Install a 7/8-9 x 1-1/2" bolt. (Item #6).
6. Remove the next 3/4-10 bolt and repeat Steps 4 and 5 on that hole.
7. Repeat Steps 4, 5 and 6 until all four holes have been drilled and tapped to 7/8-9.
8. Remove the capscrews and the drilling guide.
9. Drill the four holes in the bearing cap to 29/32" diameter, using a drill press and the drill bit provided (Item #8). DO NOT USE A HAND HELD DRILL MOTOR.



10. Install the master sweep and bearing cap using the 7/8-9 capscrews (Item #2) with the special hardened flatwashers (Item #3) under the heads. Tighten the capscrew to 460 ft-lbs. torque.
11. Reassemble the sweeps to the master sweep.
12. Check the torque of the capscrews at weekly intervals or at every set-up, whichever occurs first.