



NUMBER: A106R1057-A

DATE: MAY 22, 1990

SUPERSEDES:

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## SAFETY ALERT

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Effective Serial Number: All Units - Chance Rides, Inc.  
(Excluding units #145 and on)  
All Units - Chance Manufacturing Co., Inc.  
(Excluding those units which have  
repair kit K106R1057-A added.)

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY  
LIABILITY for losses associated with rides  
produced by Chance Manufacturing Company, Inc.

Ride: ZIPPER

Subject: NDT Inspection of boom weld  
around spindle

**WARNING: FAILURE TO COMPLY WITH THIS SAFETY ALERT BULLETIN  
CAN RESULT IN INJURY TO PASSENGERS**

Cracks on the bottom of the boom around the spindle have been found on some ZIPPER amusement rides. Chance Rides, Inc. requires all owners of ZIPPER rides indicated above regardless of boom type, to have a qualified testing laboratory perform the liquid penetrant inspection technique outlined on the reverse side of this bulletin. This inspection must be completed within 15 days from receipt of this bulletin or by July 1, 1990, whichever occurs first, and on an annual basis, thereafter.

Once this NDT technique has been completed the attached Certificate Of Compliance and a copy of the NDT report must be sent to Chance Rides, Inc.

If the inspection reveals any linear indications, DO NOT OPERATE THE RIDE. DO NOT ATTEMPT TO WELD OR REPAIR THE RIDE. A rework kit has been developed for this repair. CONTACT CHANCE RIDES, INC. CUSTOMER SERVICE DEPARTMENT IMMEDIATELY.

The ZIPPER rides which are exempt from this bulletin, see illustration C, must be inspected as outlined in Service Bulletin B106R1057-0 or B05-0359-00.

The following liquid penetrant inspection technique meets the requirements of ASTM E1220-87 and must be performed by a qualified and certified Level II or Level III inspector.

1. Pre-Clean:  
Lightly dress weld areas as shown in Illustration A and B with grinding pad to remove rust, paint, and other contaminates.
2. Apply Penetrant:  
The visible dye, color contrast, solvent removable penetrant must thoroughly cover the weld areas.
3. Dwell Time:  
The penetrant shall remain on the area of interest for a minimum of 10 minutes.
4. Excess Penetrant Removal:
  - A. Wipe as much of the penetrant from the weld area as possible by using a clean, dry, lint-free cloth rag.
  - B. Removal of penetrant residue is done by wiping the weld area with a clean, lint-free cloth rag that has been moistened with the cleaner remover.
5. Developer Application:  
Apply a thin even coating of a non-aqueous developer to the weld area and allow it to develop for a minimum of seven minutes.
6. Inspection:  
Thoroughly inspect all weld areas for linear indications. IF ANY LINEAR INDICATIONS ARE FOUND, DO NOT OPERATE THE RIDE. CONTACT THE CHANCE RIDES, INC. CUSTOMER SERVICE DEPARTMENT IMMEDIATELY. Fill out test report with results and send a copy to Chance Rides, Inc.
7. Post Clean:  
Clean weld areas with penetrant cleaner remover and wipe off residues with a cloth rag.

ILLUSTRATION A

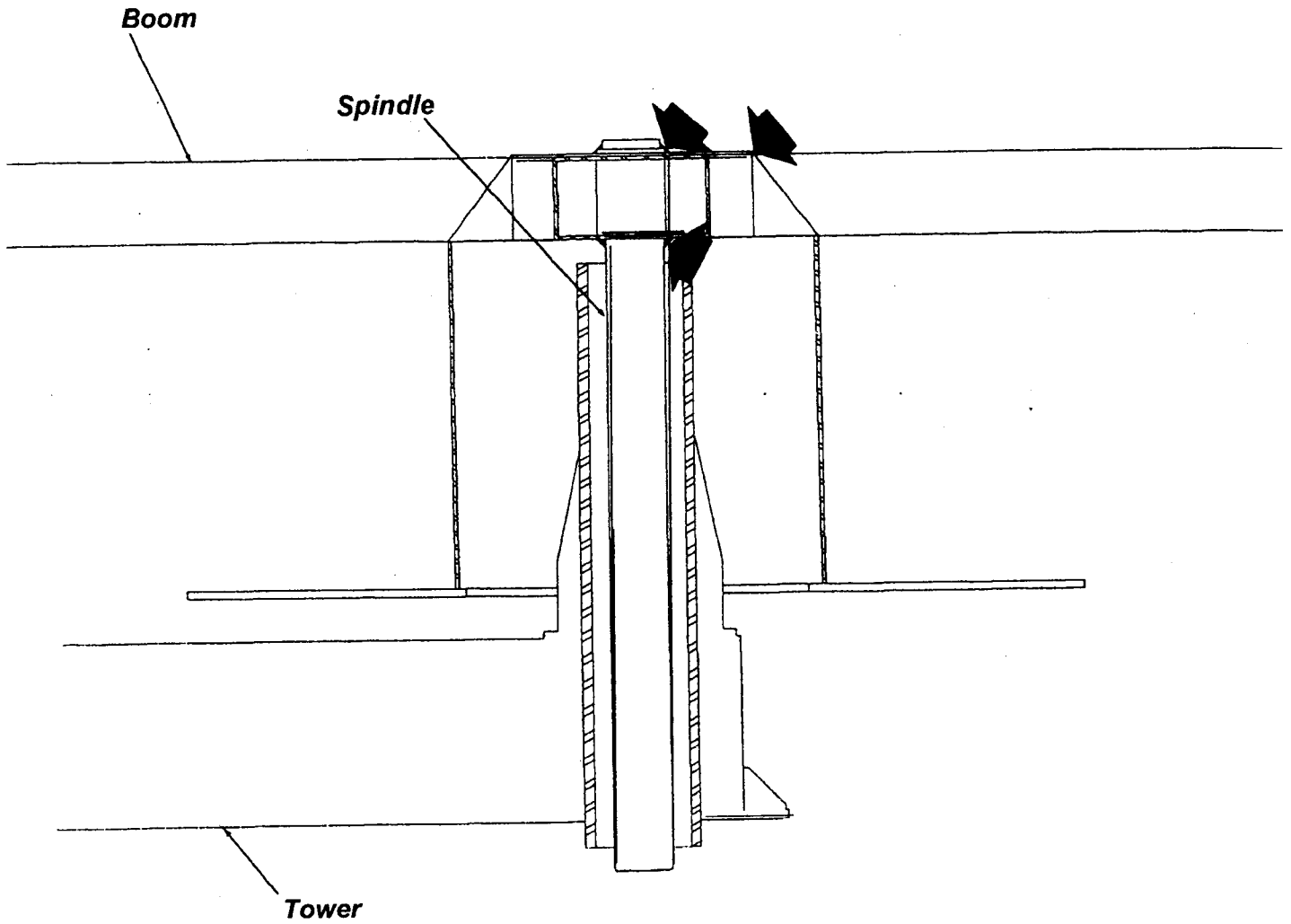


ILLUSTRATION B

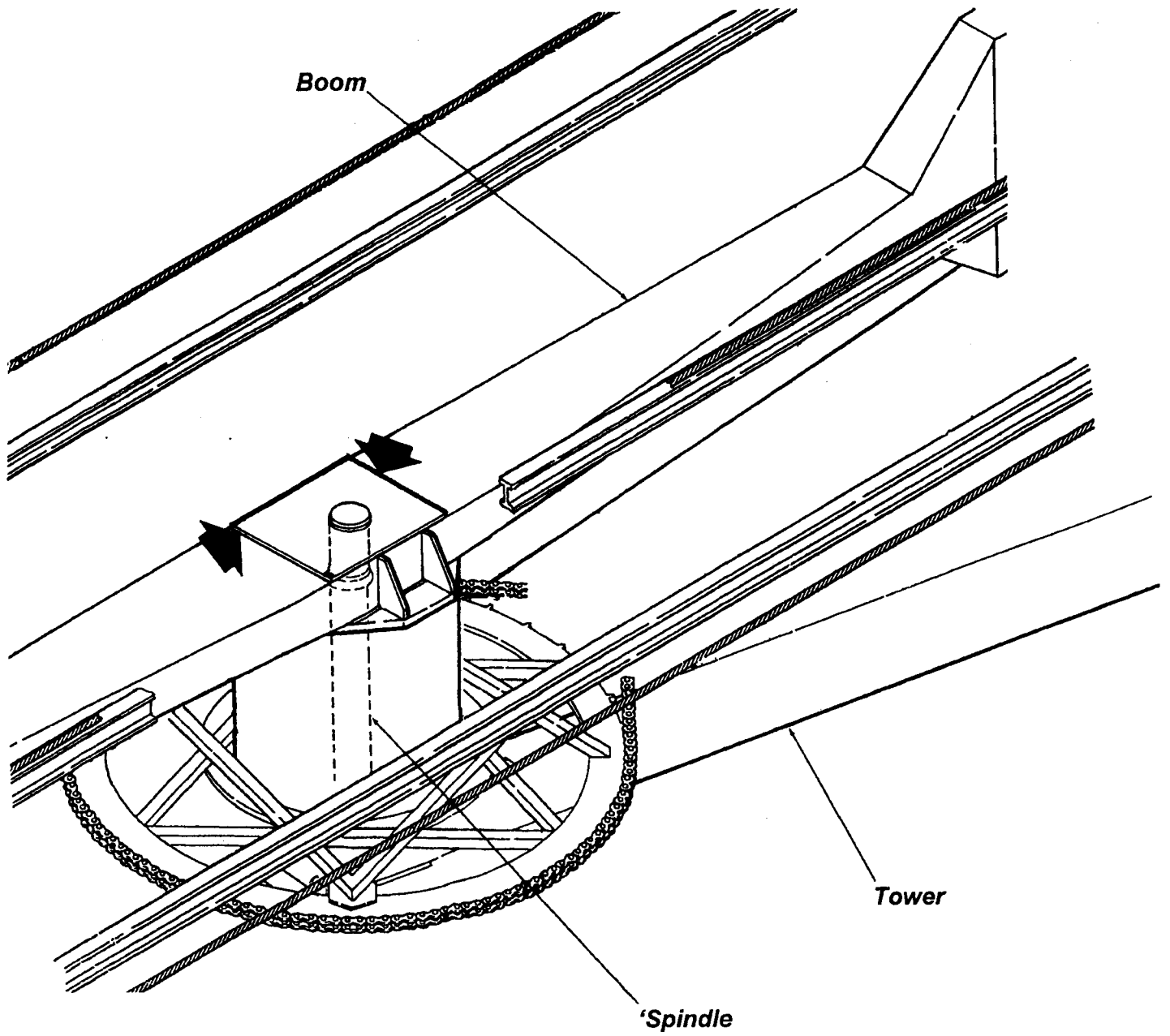


ILLUSTRATION C

