

Dartron

Issuing Entity:  
Dartron Industries, Inc

P. O. Box 13114  
Salem, Oregon 97309  
Phone: 503-362-2341  
Fax: 503-362-2536

www.dartronrides.com

Bulletin # SR-5R-0001

Release Date: 5/15/06

Effective Date: 5/15/06

Supercedes: N/A

Completion Date: 5/15/06

Page 1 of 2

## PRODUCT IMPROVEMENT

Ride Manufacturer: Dartron Industries, Inc.

Affected Production Dates: 04/03 thru 08/03

Ride Name: Zero Gravity

Affected Serial #'s 0301201-5R, 0302102-5R

Model # Portable

0303103-5R, 0303244-5R

**Abstract of Issue:** Dartron Industries, Inc. became aware that the Parking Brake Mount Assembly cracked on at least one Zero Gravity. As soon as Dartron gained this knowledge a more robust Parking Brake Mount Assembly was designed and cut into production.

**Reason for release:** A cracked Parking Brake Mount Assembly could fail and cause injury. The more robust Parking Brake Mount Assembly should be added to the first four Zero Gravity rides.

**Action to be taken:** The four Zero Gravity rides listed above as Affected Serial #'s must replace the Parking Brake Mount Assembly with the more robust Parking Brake Mount Assembly.

**Detail of issue:**

1. Ask the Dartron Parts And Service Department to send the robust Parking Brake Mount Assembly.
2. Remove power from the ride.
3. Plug and cap the hydraulic line connected to the parking brake caliper located on the boom close to the hub. The fittings are JIC-4.
4. Remove the four ½-inch fasteners from the corners of the brake base plate, and remove the plate from the hub.
5. Remove the brake calipers from the original parking brake assembly.
6. Verify serviceability of the pads on the brake calipers. If new pads are required, please contact Dartron Parts and Service Department at (503) 362-2341.

7. Install the original brake caliper onto the robust Parking Brake Mount Assembly.
8. Use the provided spacers and/or 1/2" washers to adjust the calipers to the approximate centerline of the brake rotor.
9. Remove the plug and cap from the brake line.
10. Install the hydraulic line.
11. Apply power to the ride at this time.
12. Verify proper operation of the brake caliper by pressing and releasing the jog button.
13. Use the adjusting washers to insure that the center of the brake calipers is aligned with the centerline of the rotor.

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Bulletin # SB-5R-0906-01

Release Date: 9/20/06

Effective Date: 9/20/06

Supersedes: N/A

Completion Date: 10/20/06

Page 1 of 2

## SAFETY BULLETIN

Ride Manufacturer: Dartron Industries, Inc.      Affected Production Dates: 1/03-8/05  
Ride Name: ZERO GRAVITY      Affected Serial #'s 0301201-5R, 0302102-5R, 0303103-5R,  
0303244-5R, 0310092-5R, 0312233-5R, 0403034-5R,  
0404125-5R, 0510053-5R, 0511081-5R, 0502145-5R

Model # PORTABLE

**Abstract of Issue:** Dartron is aware that the center column ornament light assembly can be torn loose from the center column with a strong head wind during transport.

**Reason for release:** Failure to update the existing mounting hardware for the center column ornament to the Dartron supplied hardware could result in it being torn loose from the ride during transport.

**Action to be taken:** Replace existing center column ornament light mounting hardware with the Dartron Industries provided hardware.

**Detail of issue:**

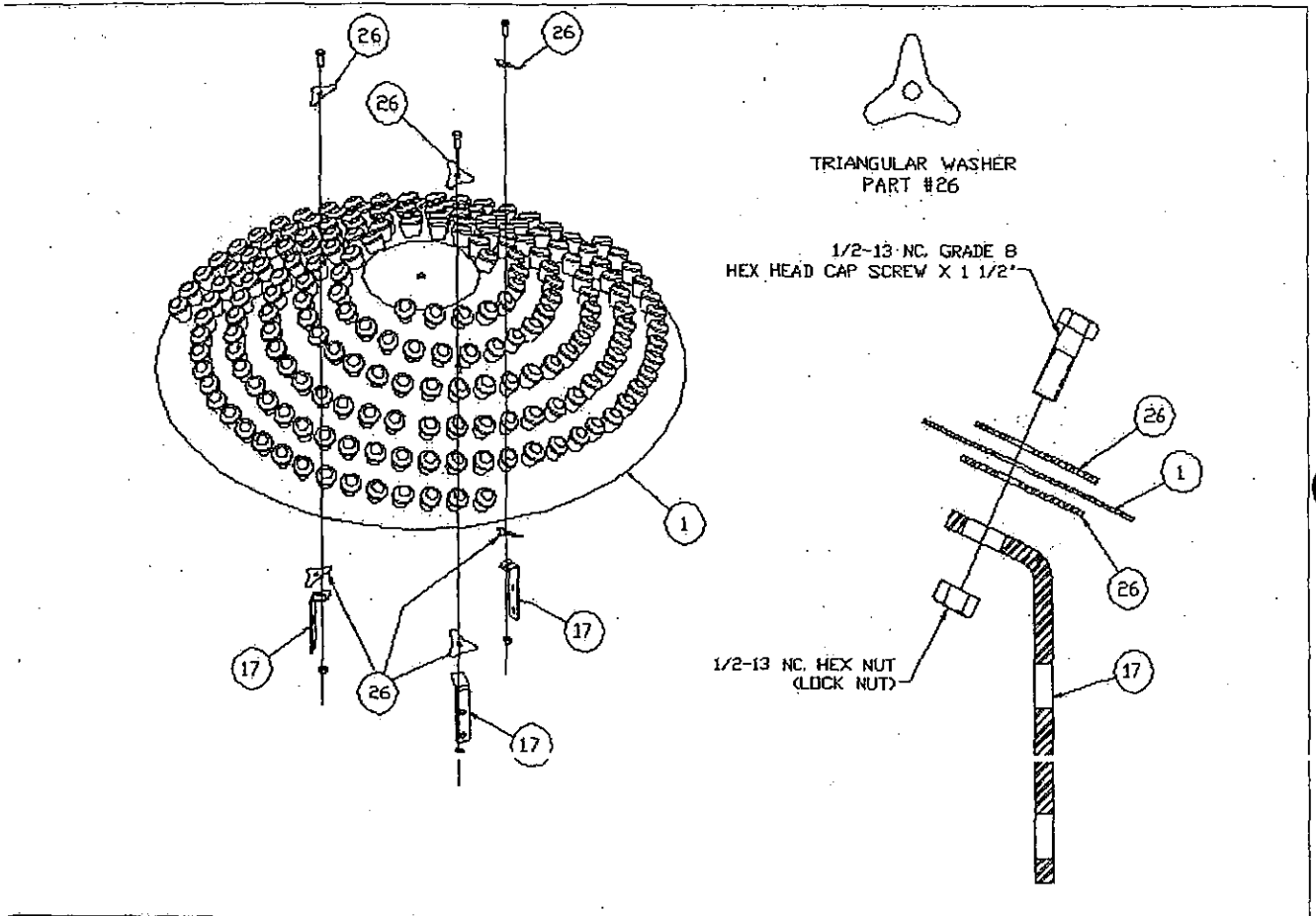
Tools required: Two ¾" wrenches.

NOTE: Care should be taken not to drop anything down the column tower while changing hardware.

During removal and replacement, check the bolt location for any deformation of the material around the holes. If any abnormalities are noted please call Dartron Industries at (503) 362-2341 before continuing.

1. Remove and replace each set of mounting hardware individually.
2. Remove the current mount bolt, washer and nut at a single location on the center column ornament light assembly.

3. Re-install the mount bolt assembly using the Dartron provided hardware as shown below.
  - a. Replace the standard 1/2" washers with the Dartron provided triangular washer (#26) at the bolt head on the topside as shown below.
  - b. Place the second provided triangular washer (#26) on the bottom side between the mount bracket (#17) and the sheet metal of the ornament (#1) as shown on the following illustration.
  - c. Place the bolt through the hole on the mount bracket (#17) and install the provided Nyloc-type self-locking nut. See the following diagram.
4. Repeat these steps on the other two mount locations.



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Bulletin # SB-5R-0107-01  
Release Date: 1/09/2007  
Effective Date: 1/09/2007  
Supercedes: N/A  
Completion Date: 3/31/2007  
Page 1 of 2

## SAFETY BULLETIN

<u>Ride Manufacturer:</u> Dartron Industries, Inc.	<u>Affected Production Dates:</u> 2006
<u>Ride Name:</u> Zero Gravity	<u>Affected Serial #'s:</u> 0510031-5R, 0510312-5R,
<u>Model #</u> Portable	0511213-5R, 0601094-5R & 0602065-5R

**Abstract of Issue:** Dartron has discovered that it is possible to over-tighten the strobe lights attaching bolts and strip their threads. If the threads are stripped the possibility exists that the strobe light cover or the light could fall off during operation.

**Reason for release:** To avoid the possibility of injury from the strobe light cover Dartron is requiring that the existing bolts be removed and replaced with longer bolts secured with Nyloc jamming nuts.

**Action to be taken:** Install longer bolts with Nyloc jamming nuts. Nuts are located inside the strobe light.

### Detail of issue:

**Tools Required:** Phillips head screw driver and two 1/2" wrenches.

**People Required:** Two ride maintenance personnel are needed to perform the bolt replacement operation.

1. Remove power from the ride.
2. Locate the input and output connectors on the individual Strobe lights and label the mono-jack plugs as input or output. Disconnect these plugs from the light.
3. Unplug the strobe light 120VAC power supply from the center column.
4. Two bolts hold the strobe to its mounting brackets on the center column. One bolt is on top and one on the bottom of the strobe. Loosen the two bolts but do not remove them at this time.
5. Turn the light around exposing the 6 Phillips head screws that hold the control part of the strobe light to the remainder of the assembly. There are three of these screws on the top and three on the bottom.

6. While one person holds the control panel the second person removes the 6 screws.
7. After removing the control panel, remove the top mounting bracket bolt and replace it with a 2-1/4" long Grade 5, or better, bolt. Insure that the spacer is re-installed between the mounting bracket and the light. Remove the bottom mounting bracket bolt and replace it with a 2-1/4" long Grade 5, or better, bolt. Insure that the spacer is re-installed between the mounting bracket and the light.
8. Install and tighten until snug the provided Nyloc nut on the inside of the housing where the bolt threads through.
9. Install the control panel to the assembly by replacing the 6 screws that were removed in Step 7.
10. Repeat Steps 4 thru 9 for the remaining two strobe lights.
11. Insert the input and output cables back into their respective jacks.
12. Plug the power cord for the strobe lights back into their corresponding receptacles.
13. Apply power to the ride.
14. Verify proper operation of the strobes.

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Bulletin # 7039

Release Date: 9-12-1995

Effective Date: 9-12-1995

Supersedes: None

Completion Date: March 1, 1996

Page 1 of 2

## MANDAROTY CHANGE BULLETIN

Ride Manufacturer: Dartron Industries, Inc.

Ride Name: Zendar

Model #

Affected Production Dates: Prior to 8-13-1995

Affected Serial #'s 405121-5Z, 410181-5Z,  
410011-5Z, 412021-5Z, 501231-5Z

**Abstract of Issue:** Zendar Front Rack Storage

**Reason for release:** As a result of moving the Zendar long distances over rough roads, cracks could develop in certain welded joints in the front storage rack. If the cracks are not addressed, the joint could separate and cause the rack to drop during transit.

**Action to be taken:**

- Immediately inspect area shown on the attached drawings for cracking.
- If cracks are detected, immediately install gussets as shown in attached drawings.
- If cracks are not detected, gusset's still must be added no later than March 1, 1996.

**Parts Required:**

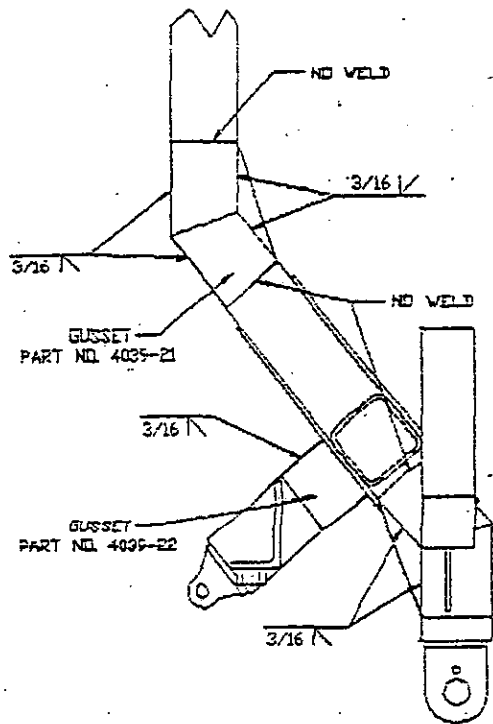
Description	Part #	Quantity
Gusset	4039-21	6
Formed Gusset	4039-22	2

**Detail of issue:**

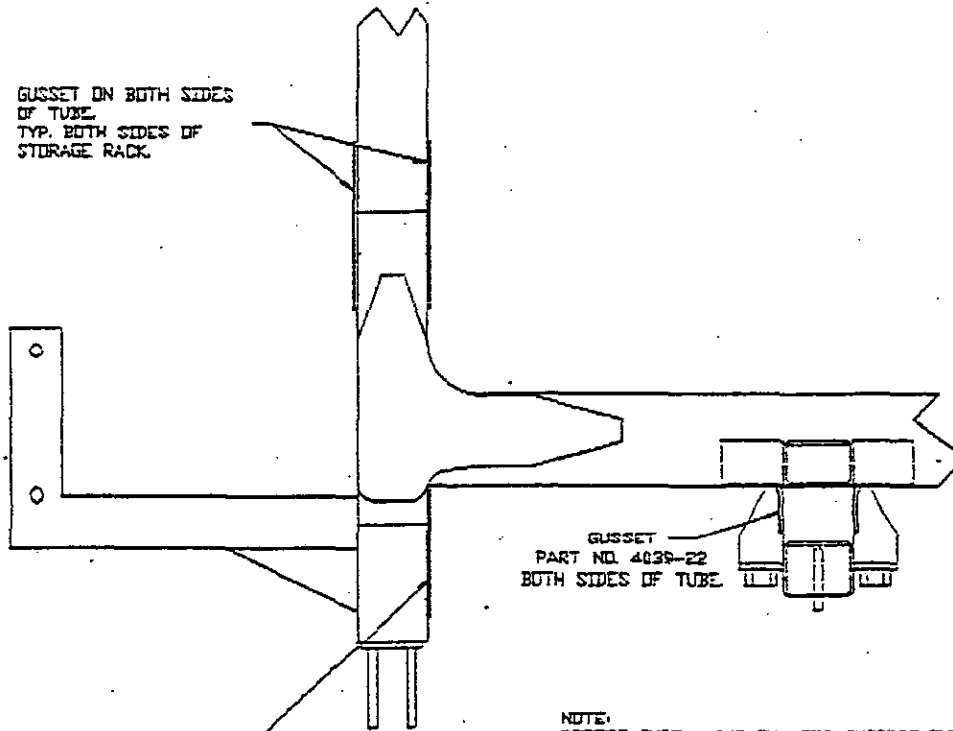
**Welding Specifications:** Weld with 70,000 psi filler.

**Administration:** Gussets will be supplied without charge by Dartron.

If required, copies of this bulletin will be sent to ride inspection organizations.



GUSSET ON BOTH SIDES  
OF TUBE.  
TYP. BOTH SIDES OF  
STORAGE RACK.



GUSSET ON INSIDE WALL  
OF TUBE ONLY.  
TYP. BOTH SIDES OF  
STORAGE RACK.

NOTE:  
BEFORE INSTALLING GUSSETS, INSPECT TUBE  
JOINTS FOR CRACKS. IF A CRACK IN A JOINT  
IS PRESENT GRIND A 3/16" DEEP "V" GROOVE  
AT THE TUBE JOINT AND REWELD WITH A  
3/16" BEVEL WELD. THEN GRIND WELD FLAT  
AND INSTALL GUSSETS.

DARTKON IND., INC. P.O. BOX 13014 SALEM, OR 97309	TELEWOOD UNLESS NOTED	STORAGE RACK REINFORCEMENT	9-13-95	1 - 1	HM	
	REWORKS (FRACTIONS INCHES)					
	A = 1/2 C = 3/8 D = 1/4	AL/16	400	ZENDAR	BU7039	
					1/1	0