

461.

Vekoma MK12xx train sit down chassis inspection intervals

NAFLIC is in receipt of a service bulletin from Vekoma Rides Parts & Service relating to its MK12xx train sit down chassis. During NDT examination on a MK 12xx sit down chassis a linear indication in a chassis weld seam has been found. In view of this knowledge it is required to change the inspection intervals.

The necessary action to be taken is outlined in the bulletin.

The information contained within is that of the manufacturer and not NAFLIC. When following the advice from the manufacturer, you are reminded of your duties and responsibilities under HSG175 regarding modifications.

Committee Members: Mr. D Dadswell (Chairman), Mr. A Mellor (Secretary), Mr. P Smith, Mr. J Green, Mr. D Cox, Mr. I Davies, Mr. J Shilling, Mr. D Inman & Mr. R Hiscoe

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Vekoma Rides Parts & Services B.V.	Release Date: February 12, 2018
Schaapweg 18	Effective Date: February 12, 2018
6063 BA VLODROP	Supersedes: SB-025_00 and SB-025_01
The Netherlands	Completion Date: March 12, 2018
CoC Number: 12049585	

Service Bulletin

Original Ride Manufacturer: Table 1	Affected Production Dates: All
Ride Name: MK12xx sit down series	Affected Serial Nos: Table 1
Model No: -	

Abstract of issue:

This Service Bulletin requires additional weld inspections for the MK12xx sit down chassis.

Reason for release:

During NDT examination on a MK 1212 sit down chassis a linear indication in a chassis weld seam has been found. Due to this knowledge it is required to change the inspection intervals.

Action to be taken:

Immediate magnetic testing or dye penetrant testing of welded joints of the chassis within the completion date of this document; only required in case this inspection has not been performed within the last year.

Visual inspection of welded joints of the chassis on a weekly basis.

Eddy current testing, magnetic testing or dye penetrant testing of welded joints of the chassis on a monthly basis.

Magnetic testing or dye penetrant testing of welded joints of the chassis on a yearly basis.

Date	Revision	Comment
November 2012	00	Initial version
January 2018	01	Removed lifetime requirement of 10 years Changed ride cycles interval Updated figures
February 2018	02	Changed visual testing to visual inspection Added eddy current testing on a monthly basis Added dye penetrant testing as option for yearly inspection

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Details of issue continued:

IB-nr.	Original Ride Manufacturer	Project number
10505	Vekoma Rides Manufacturing B.V.*	91178
27001	Vekoma International B.V./Vekoma Manufacturing B.V.*	99292
27002	Vekoma International B.V./Vekoma Manufacturing B.V.*	97134
27003	Vekoma International B.V./Vekoma Manufacturing B.V.*	91018
27502	Vekoma International B.V./Vekoma Manufacturing B.V.*	83515
27503	Vekoma International B.V./Vekoma Manufacturing B.V.*	83530
27505	Vekoma International B.V./Vekoma Manufacturing B.V.*	91685
27506	Vekoma International B.V./Vekoma Manufacturing B.V.*	84545
27507	Vekoma International B.V./Vekoma Manufacturing B.V.*	84555
27509	Vekoma International B.V./Vekoma Manufacturing B.V.*	85590
27510	Vekoma International B.V./Vekoma Manufacturing B.V.*	86785
27511	Vekoma International B.V./Vekoma Manufacturing B.V.*	86780
27514	Vekoma International B.V./Vekoma Manufacturing B.V.*	86715
27515	Vekoma International B.V./Vekoma Manufacturing B.V.*	86640
27517	Vekoma International B.V./Vekoma Manufacturing B.V.*	93104
27518	Vekoma International B.V./Vekoma Manufacturing B.V.*	87610
27521	Vekoma International B.V./Vekoma Manufacturing B.V.*	89605
27523	Vekoma International B.V./Vekoma Manufacturing B.V.*	90510
27524	Vekoma International B.V./Vekoma Manufacturing B.V.*	90523
27525	Vekoma International B.V./Vekoma Manufacturing B.V.*	91678
27526	Vekoma International B.V./Vekoma Manufacturing B.V.*	95115
27527	Vekoma International B.V./Vekoma Manufacturing B.V.*	95163

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27528	Vekoma International B.V./Vekoma Manufacturing B.V.*	96378
27529	Vekoma International B.V./Vekoma Manufacturing B.V.*	96372
27530	Vekoma International B.V./Vekoma Manufacturing B.V.*	96340
27531	Vekoma International B.V./Vekoma Manufacturing B.V.*	96293
27532	Vekoma International B.V./Vekoma Manufacturing B.V.*	97105
27533	Vekoma International B.V./Vekoma Manufacturing B.V.*	97117
27534	Vekoma International B.V./Vekoma Manufacturing B.V.*	97153
27535	Vekoma International B.V./Vekoma Manufacturing B.V.*	97128
27536	Vekoma International B.V./Vekoma Manufacturing B.V.*	97196
27537	Vekoma International B.V./Vekoma Manufacturing B.V.*	98113
27538	Vekoma International B.V./Vekoma Manufacturing B.V.*	98111
27539	Vekoma International B.V./Vekoma Manufacturing B.V.*	99306
27540	Vekoma International B.V./Vekoma Manufacturing B.V.*	97333
27541	Vekoma International B.V./Vekoma Manufacturing B.V.*	99269
27542	Vekoma International B.V./Vekoma Manufacturing B.V.*	98112
27543	Vekoma International B.V./Vekoma Manufacturing B.V.*	20151
27544	Vekoma Rides Manufacturing B.V.*	91008
27545	Vekoma Rides Manufacturing B.V.*	91228
27546	Vekoma Rides Manufacturing B.V.*	60022
28001	Vekoma International B.V./Vekoma Manufacturing B.V.*	93102
28503	Vekoma International B.V./Vekoma Manufacturing B.V.*	86770
28504	Vekoma International B.V./Vekoma Manufacturing B.V.*	87580
28505	Vekoma International B.V./Vekoma Manufacturing B.V.*	88692
28506	Vekoma International B.V./Vekoma Manufacturing B.V.*	92511
28507	Vekoma International B.V./Vekoma Manufacturing B.V.*	97121

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29003	Vekoma International B.V./Vekoma Manufacturing B.V.*	78830
29501	Vekoma International B.V./Vekoma Manufacturing B.V.*	80880
29502	Vekoma International B.V./Vekoma Manufacturing B.V.*	82550
29504	Vekoma International B.V./Vekoma Manufacturing B.V.*	84535
31002	Vekoma International B.V./Vekoma Manufacturing B.V.*	95116
32501	Vekoma Rides Manufacturing B.V.*	91050
33002	Vekoma International B.V./Vekoma Manufacturing B.V.*	87640
33501	Vekoma International B.V./Vekoma Manufacturing B.V.*	80710

Table 1: Affected serial Nos.

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Details of issue continued:

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Details of issue continued:

1.1 Why this service bulletin

This service bulletin is a result of a linear indication found in an MK1212 sit down chassis. VRPS therefore recommends increasing the number of NDT inspections as stated in the following paragraphs for all chassis with similar weld details and loading conditions.

1.1.1 Involved weld seams

This service bulletin is applicable to all MK12xx sit down chassis types.

The typical weld details for MK12xx sit down chassis are illustrated in figures 1 and 2.

1.2 Recommended inspection intervals

1.2.1 Immediate inspection

Perform magnetic testing or dye penetrant testing of all welds as specified in figure 1 and 2 on 100% of the vehicle chassis in the ride system; only required in case this inspection has not been performed within the last year. NDT examination has to be executed according to the codes as mentioned in table 2. These NDT examinations must be completed before the completion date of this document. If necessary for NDT accessibility, it is required to disassemble the body to access the weld seams.

1.2.2 Weekly maintenance (corresponds with approximately 700 ride cycles)

Perform visual inspection of all welds as specified in figure 1 and 2 on 100% of the vehicle chassis in the ride system. For visual inspection it is not necessary to disassemble any components, only check the welds which are visible without removing components.

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Details of issue continued:

1.2.3 Monthly maintenance (corresponds with approximately 2500 ride cycles)

Perform Eddy current testing, magnetic testing or dye penetrant testing of all welds as specified in figure 1 and 2 on 100% of the vehicle chassis in the ride system. NDT examinations need to be executed according to the codes as mentioned in table 2. For Eddy current testing, magnetic testing and dye penetrant testing it is not necessary to disassemble any components, only check the welds which are accessible without removing components.

1.2.4 Yearly maintenance (corresponds with approximately 30.000 ride cycles)

Every year the same NDT examinations have to be performed as described in paragraph 1.2.1.

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Details of issue continued:

1.3 Non destructive testing

The NDT examinations as recommended by VRPS have to be performed according to the procedures and standards as mentioned in this paragraph.

1.3.1 Related codes and standards

Parts should be inspected according to the related standards and codes as mentioned in table 2:

NDT Method	Codes (Examination)	Codes (Acceptance level)	Acceptance level
Visual inspection	-	Indications not allowed.	
PT (Penetrant Testing)	ISO 3452-1	ISO 23277	Level 1
MT (Magnetic particle Testing)	ISO 17638 or EN 1290	ISO 23278	Level 1
ET (Eddy current Testing) ¹⁾	ISO 17643	Acceptance level 5 x 1 mm (length x height) Reference EDM NotCh ²⁾	

Table 2: Related standards and codes

- 1) Corrections for coating thicknesses are as per approved procedure by means of shimmers. The reference level shall be checked are recorded on a 4 hourly basis and on the start- and finish of a shift / examination
- 2) All indications observed with ET are subject to confirmation by PT or MT.

1.3.2 NDT personnel

NDT personnel must be:

- Instructed and trained, by an independent and recognized inspection authority
- Qualified and certified to the EN 473 or ISO 9712 or SNTC-TC-1A, level II



1.3.3 Results of NDT

If any indications are found by visual inspection (per section 1.2.2) or eddy current testing (per section 1.2.3), perform magnetic testing or dye penetrant testing on all ride chassis.

If any indications are found by magnetic testing always contact VRPS.

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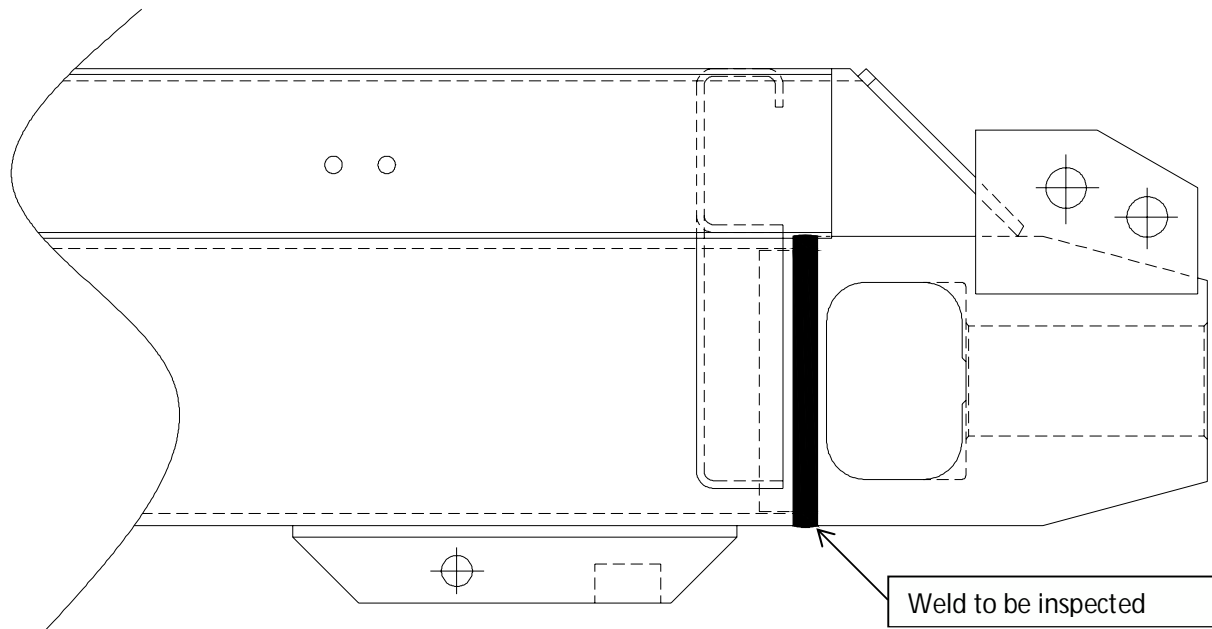


Figure 1 Typical weld location of block connected to chassis with overlapping profile

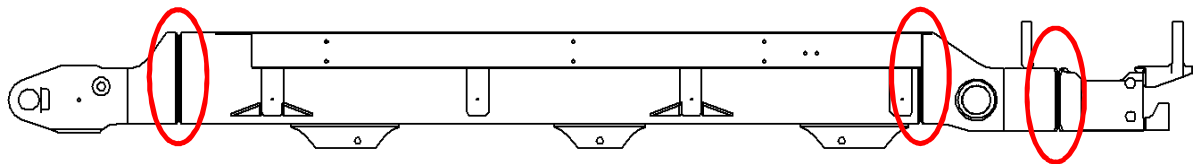


Figure 2 Typical weld locations of block connections to chassis with single weld around

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Details of issue continued:

1.3.4 Inspection procedure



WARNING

Contact VRPS if indications are found.

Prepare

- 1 Disassemble the part (not necessary for visual inspection or ET).
- 2 Remove moisture, oil, grease and dirt.
- 3 Remove the paint (not necessary for visual inspection or ET), e.g. by sand blast or with the help of a liquid paint remover. Do not use steel grit blast. Make sure that the whole surface is free from paint.
- 4 Remove any slag and spatter (if still present) from welded joints.

Inspect

- 1 Inspect the part or weld according to the applicable NDT method.
 - the inspection company shall use their own NDT procedure. The applicable procedure must be referring to the relevant EN- or ISO standards;
 - the used NDT procedure must be approved by an inspector, qualified and certified to EN 473 / ISO 9712 level III or ASNT-TC-1A level III.
- 2 Only for visual inspection on welds:
 - pay special attention to indications or signs of corrosion in the paint;
- 3 Only for visual inspection and ET on parts: If indications are found or if there is any doubt, check all parts with the same function by PT or MT.
- 4 If indications are found, replace the part or repair the weld.
- 5 Fill out all the inspections and repairs performed on parts of the amusement ride.
- 6 Use the inspection and repair list, both added in the logbook.

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Finish

- 1 Paint the part.
- 2 Assemble the part.
- 3 Re-apply the rust preventive coating to all parts.

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According to the ASTM F853/ F1193 latest revision:

Supplemental bulletins delivered by the manufacturer to the owner / operator that were not provided at the time of hand over of the amusement ride and contain new information or newly recommended inspections or testing, or both, will be released as a Safety Alert, Service Bulletin or an Notification, with the following criteria in order to carry the force and effect of this practice:

- "Safety Alert" For notifications that recommend immediate action.
- "Service Bulletin" For notifications that do not recommend immediate action but do recommend future action.
- "Notification" For notifications that do not necessarily recommend future action but are promulgation of information.



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