



U.S. CONSUMER PRODUCT SAFETY COMMISSION  
WASHINGTON, D.C. 20207-0001

**TO: ALL AMUSEMENT RIDE SAFETY OFFICIALS**  
**IMPORTANT**  
**AMUSEMENT RIDE SAFETY BULLETIN!**  
**RE: Amtech/Tivoli “Spin Out” Amusement Rides**  
**Issued March 30, 2004**

The U.S. Consumer Product Safety Commission (CPSC), in cooperation with AmTech/Amusement Technologies International, Inc. of Cleburne, TX and Tivoli Mfg., Inc. of Canterbury, England is issuing the following safety bulletin and inspection guidelines to prevent serious injury or death due to failures of the sweep arms on “Spin Out” aka “The Claw, The Maelstrom, El Nino” amusement rides resulting from an incident in San Juan, Puerto Rico operated by Amusements of America, Monroe Township, NJ. The Commission and AmTech/Tivoli are aware of four (4) injuries involving a “Spin Out”; resulting from sweep arm failure. In addition, AmTech reported two (2) other “Spin Out” rides reporting cracks on sweep arms in critical areas. Currently, twenty-one (21) “Spin Out” rides operate in the United States.

*The following are Amtech/Tivoli required inspection procedures for the sweep arms and sweep gusset kits:*

1. Follow all Amtech/Tivoli Safety Bulletins SOSA0001 to SOSA012B. All inspections concerning the Spin Out sweep arms are as specified on Tivoli Mfg. Ltd. Safety Bulletin SOSA13. Safety Bulletin SOSA13 supercedes all previous bulletins issued by Tivoli concerning sweep arm inspection procedures.
2. Immediately inspect all welds on the “Spin Out” sweep arms as indicated on the attached drawings. Be sure to visually inspect the full sweep length, and make appropriate repairs if necessary. Pay particular attention to the hinge plate gussets and the gussets and the tips of the gusset kits (Drawing A).
3. If cracking is detected by the hinge plate gussets, or any weld along the sweep arm immediately discontinue operation of the ride and report this to AmTech or CPSC.
4. If the gusset kits have not been installed, they are required. All rides MUST have the gusset kits installed according to the procedures described in Safety Bulletin SOSA010.
5. Inspect the gusset welds every 200 hours of operation or 6 months, whichever comes first with particular attention to the tips of the gusset kit as indicated in the attached drawing. (Drawing B). These inspections shall be performed by a certified inspector, with written documentation of that inspection maintained by the ride owner/operator.
6. Every 400 hours or 12 months, whichever comes first, inspect all sweep welds in addition to the gusset kit welds with nondestructive (NDT) inspection techniques. The 400 hour NDT test requirements can include ultrasonic, magnetic particle, or dye

penetrant inspection by a certified inspector. Ride owners/operators shall maintain written records of all inspections performed.

7. If cracks are detected, the ride must remain closed and AmTech/Tivoli must be contacted for repair instructions and procedures.

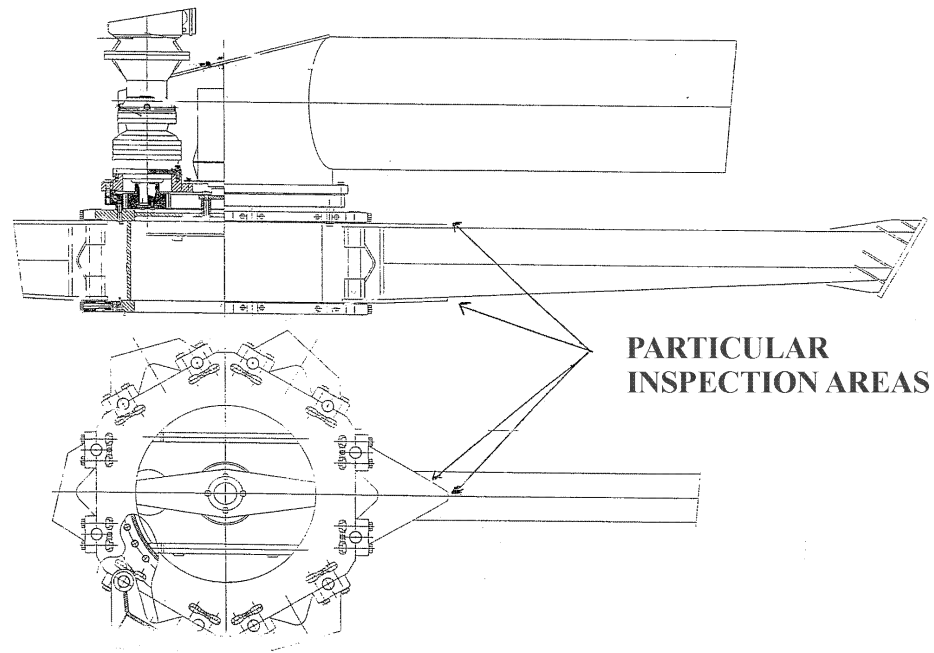
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or

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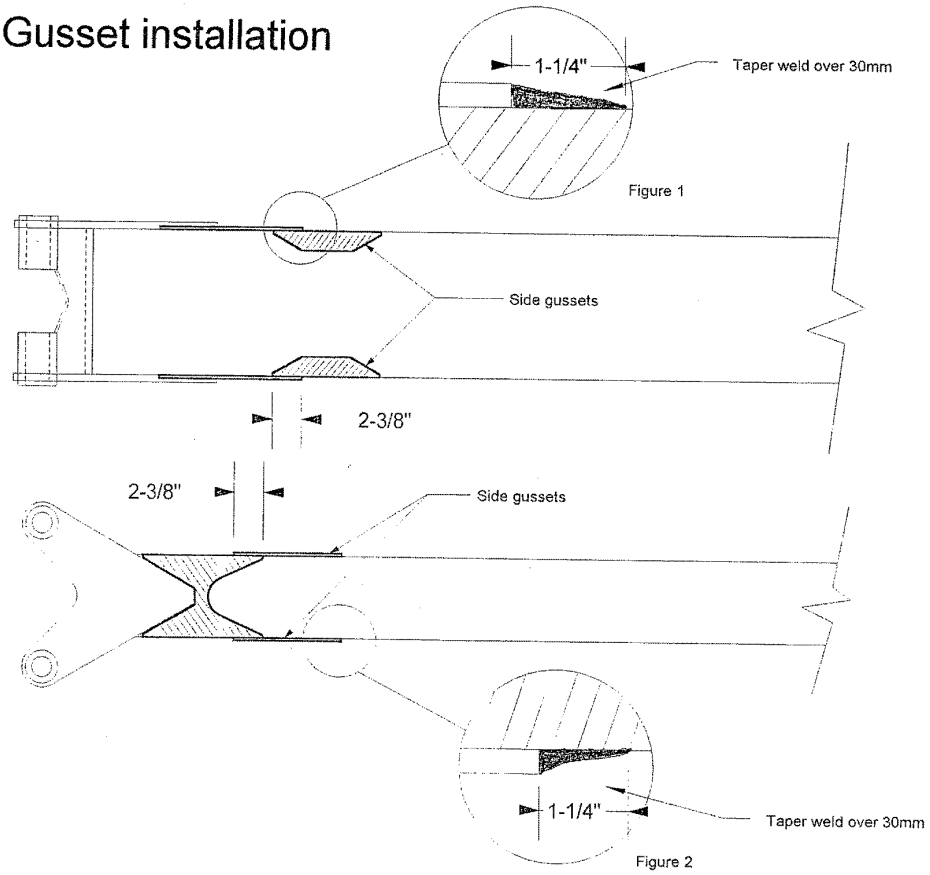
or

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**Figure A**

# Side Gusset installation



**Figure B**