



Issuing Entity:
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Bulletin No.: L16-002A
Release Date: 12/13/16
Effective Date: Immediately
Supercedes: L16-002
Completion Date: 3/1/17
Page: 1 of 2

SERVICE BULLETIN

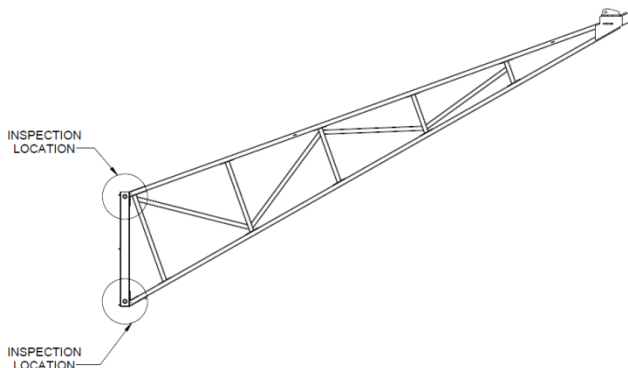
Ride Manufacturer: Larson International Inc. **Affected Production Dates:** All
Ride Name: FLYING SCOOTERS **Affected Serial Nos.:** 7-30

Abstract Of Issue: Reinforcement of the sweep assembly vertical tubes (L340000 item 1).

Reason for Release: Product improvement. Installation of the doubler plates described in the attached procedure eliminates the recurring annual NDT MT requirement in bulletin L16-002. The daily visual inspection still applies. If indications are found, contact Larson International to determine if sweep can be repaired.

Action To Be Taken: Remove each sweep from the ride and perform NDT MT per bulletin L16-002. If no indications are found, install the doubler plates according to X169107-00 [parts available at Larson International]. If indications are found, contact Larson International to determine if sweep can be repaired.

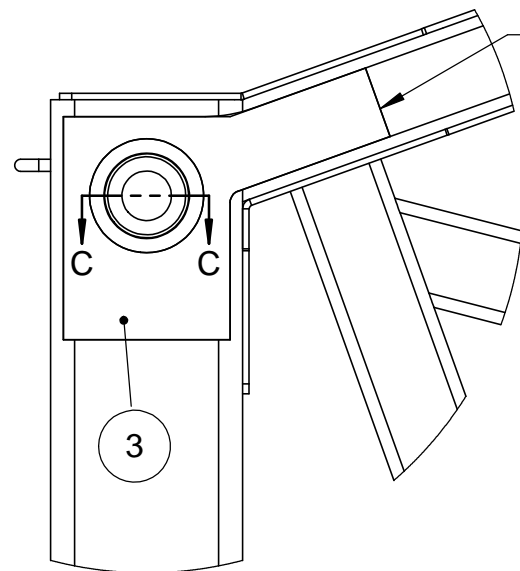
Detail Of Issue:



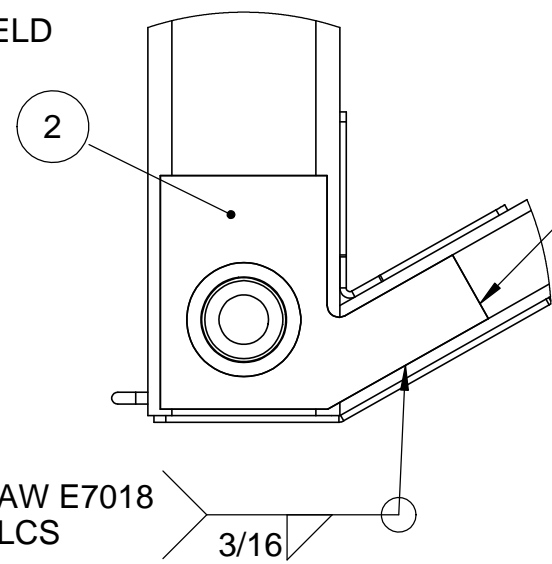
Larson International Inc. issues notifications for the benefit of owners of amusement rides manufactured by Larson International, Inc. As a service to the industry, and in the interest of employee and public safety, Larson International, Inc. also issues notifications for the benefit of owners of amusement ride equipment for which the manufacturer no longer exists such as LMC, Inc. and Hi-Roller Company. In doing so, Larson International, Inc. does not assume liability for losses associated with amusement ride equipment built by manufacturers other than Larson International, Inc.

REV	E.C.O.	REVISION DESCRIPTION	DATE	BY
A		REVISED PROCEDURE	12/13/16	KW

DETAIL A
SCALE 1 : 4

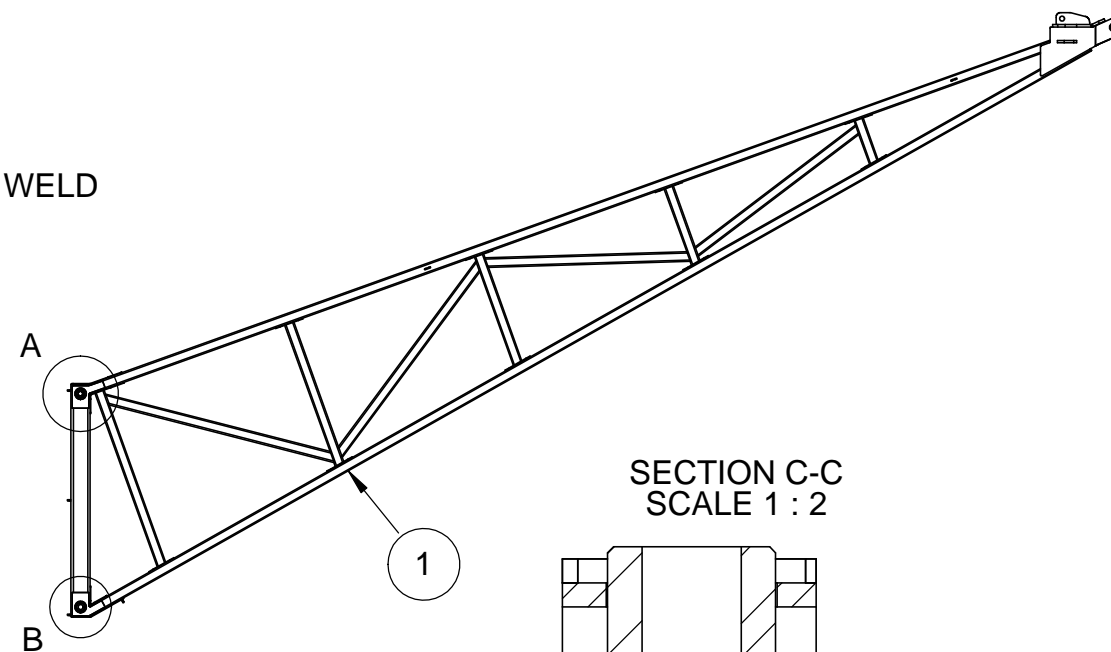


DETAIL B
SCALE 1 : 4



SMAW E7018
4 PLCS

CONTINUOUS WELD
WRAP ENDS



SECTION C-C
SCALE 1 : 2

SMAW E7018
4 PLCS

Repair Cracks - If indications are found, contact Larson International to determine if sweep can be repaired

1. NDT MT all cracks to identify ends
2. Grind past ends of cracks and create a joint detail with 0-1/8 inch root opening with a 60 degree bevel
3. Remove paint in the area to be repaired
4. Weld repair all cracks – SMAW E7018 per WPS [Flying Scooters – Sweep Repair/Doubler]
5. Grind welds flush with surface of tube
6. NDT MT all areas to verify repair

Add Doubler Plates - Parts available at Larson International

1. Grind tube to tube welds flush in area of doubler plate
2. Remove paint in the area to be covered by doubler plate and all areas to be welded
3. Center doubler plate over lower mounting sleeve – may need to profile the existing fillet weld to allow the plate to sit flush on the tube
4. Fillet weld all around doubler plate (no stops/starts on ends)
5. Groove weld all around mounting sleeves
6. Grind all starts and stops
7. Profile fillet welds with Polifan Flap Disc to blend toe of weld
8. Prime and paint all bare metal

3	X169107-02	PL: 1/4" X 5 21/32" X 6 13/16"	ASTM A36	2
2	X169107-01	PL: 1/4" X 4 7/8" X 6 27/32"	ASTM A36	2
1	L340007	SWEEP WELDMENT		1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY

UNLESS SPECIFIED OTHERWISE:
DIMENSIONS ARE IN INCHES
DIM & TOL PER ASME Y14.5M
TOLERANCE UNLESS SPECIFIED
BREAK AND DEBURR ALL SHARP EDGES
DO NOT SCALE DRAWING

FRACTIONS: ±1/16"
DECIMALS: .X = ±0.03
.XX = ±0.01
.XXX = ±0.005
.XXXX = ±0.0005
ANGLES: ±0.5°

GENERAL SURFACE FINISH = 125/



PLAINVIEW, TEXAS 79072
WWW.LARSONINTL.COM
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PROJECT/RIDE:
FLYING SCOOTERS
TITLE:
**SWEEP DOUBLER
WELDMENT**

SCALE: 1:40
FILE NAME: X169107-00
SHEET: 1 OF 1

NEXT ASSEMBLY:
QUANTITY:

DRWN:	DATE:	CHK:	DATE:	APPD:	DATE:	SIZE:	WEIGHT:	DRAWING NUMBER:	REV
KW	2/22/2016					B	lb	X169107-00	