



CHANCE RIDES MANUFACTURING, INC.

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4200 Walker

Wichita, KS 67277-2328

U.S.A.

Phone: 1-316-942-7411 • FAX: 1-316-942-2012

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B408CRM110-0

Release Date: November 6, 2002

Effective Date: Immediately

Supersedes: B408CRM106-0

Completion Date: February 6, 2003

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Abstract of Issue:

Sweep Rework Kit

Reason For Release:

Service bulletin B408CRM106-0 is superseded by this bulletin and is no longer in effect.

Chance Rides Manufacturing, Inc. has become aware of cracks in the sweeps of at least one CHAOS amusement ride. Failure of a sweep could result in serious injury to passengers and/or bystanders. A kit has been developed to reinforce the sweeps.

Action to be Taken:

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted CHAOS rides to order and install the Sweep Rework Kit, part number K408CRM110-0, within 90 days of the release date of this bulletin. The kit includes all necessary parts to rework one complete ride. Rework instructions are provided in this bulletin. The kit will be offered at a reduced price if ordered within this 90 day period.

After the Sweep Rework Kit is installed, the sweeps must be inspected annually as described in this bulletin.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. Use only those components authorized, specified or provided by Chance Rides Manufacturing, Inc. All applicable OSHA safety standards and safe industry practices must be observed.

Observe all safety information contained in the manufacturer's manuals. Make available this bulletin and all related technical information to personnel using the equipment.

Chance Rides Manufacturing, Inc. issues notifications for the benefit of owners of amusement rides manufactured by Chance Rides Manufacturing, Inc. As a service to the industry, and in the interest of employee and public safety, Chance Rides Manufacturing, Inc. also issues notifications for the benefit of owners of amusement ride equipment for which the manufacturer no longer exists, such as the Allan Herschell Company, Chance Manufacturing Co., Inc., Chance Rides, Inc., etc. In doing so, Chance Rides Manufacturing, Inc. does not assume liability for losses associated with amusement ride equipment built by manufacturers other than Chance Rides Manufacturing, Inc.



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Ride Manufacturer: CHANCE RIDES, INC.

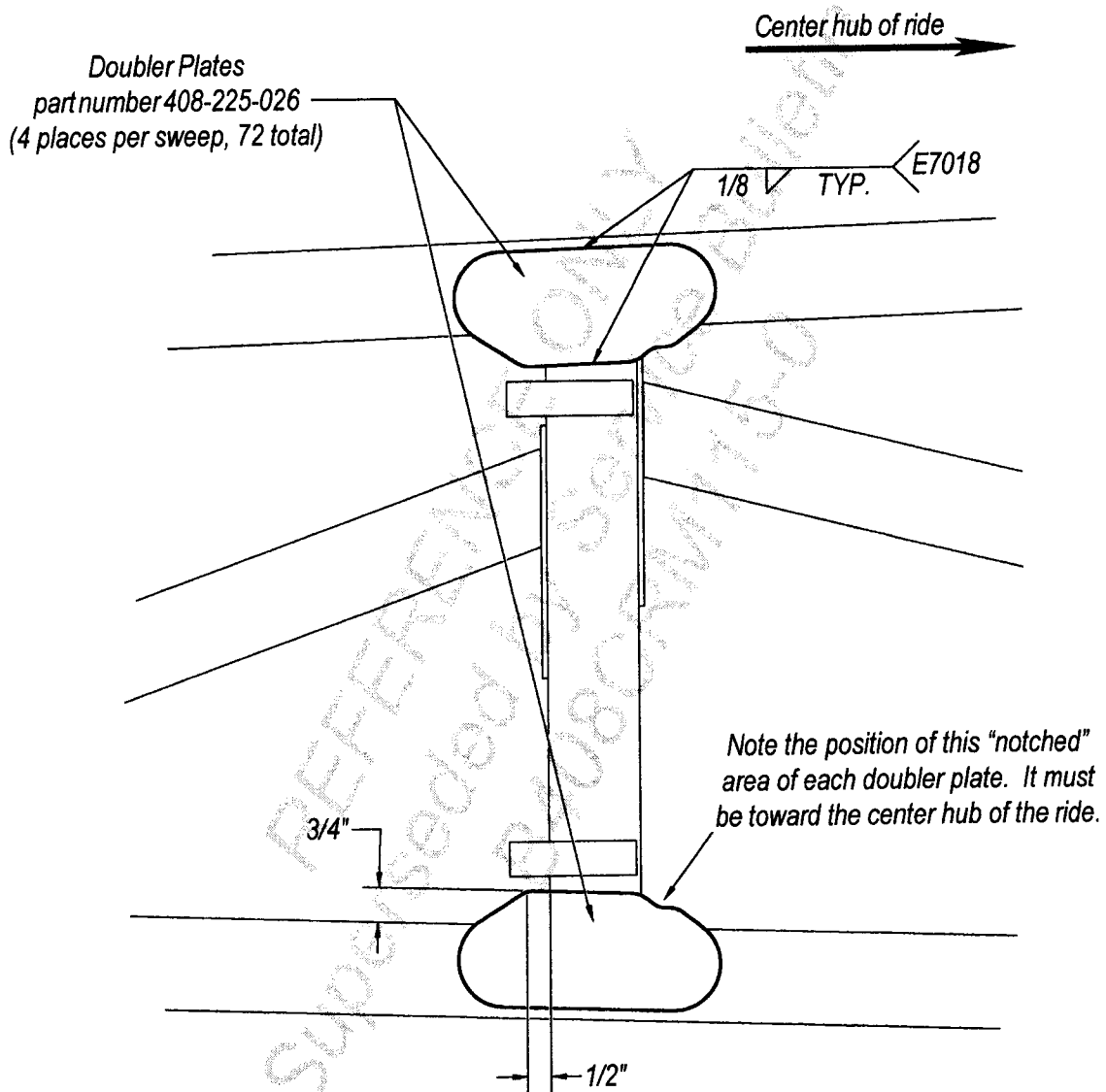
Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):





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Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: CHAOS Affected Serial Nos.: All Units

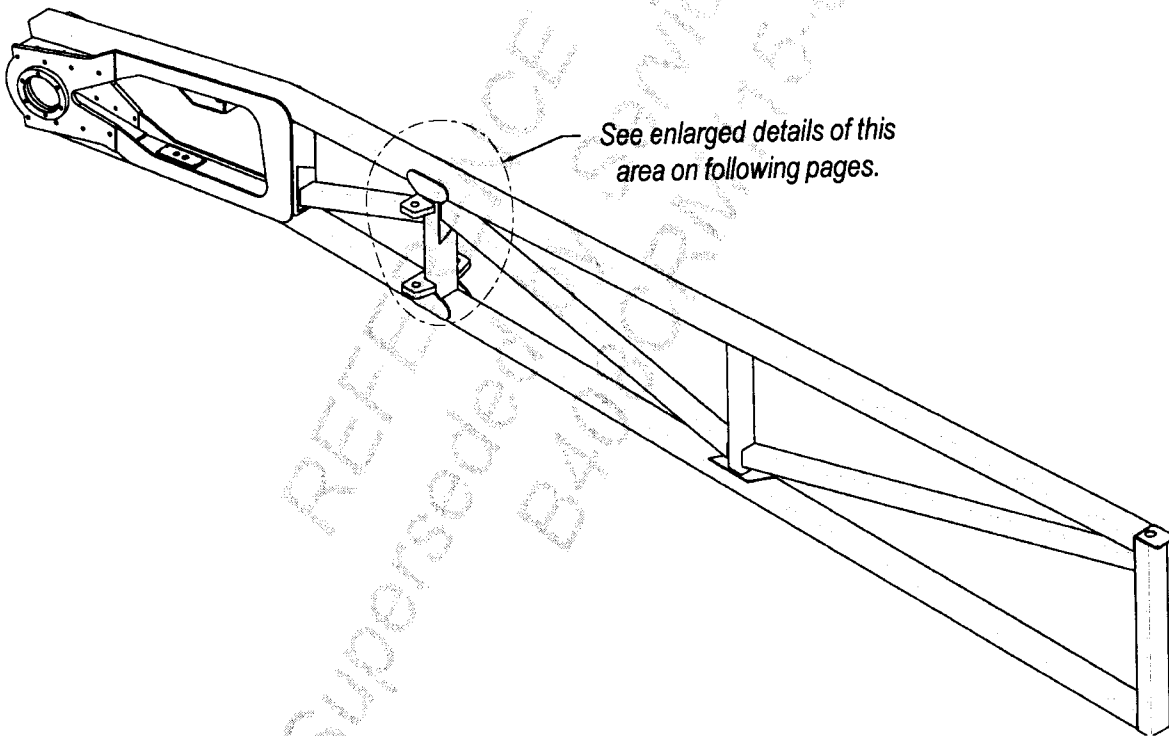
Model No.: 408

Detail of Issue (continued):

SWEEP REWORK PROCEDURE

After inspecting all sweeps to verify that no indications exist, locate and weld the doubler plates on all sweeps as shown in the following illustrations (four places on each sweep). Note the position of the "notched" area of each doubler plate, which is located toward the center hub of the ride. If necessary, grind the existing welds to allow the doubler plates to lay flat against the sweeps.

IMPORTANT: All welding must be performed in accordance with American Welding Society (AWS) D1.1.





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Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

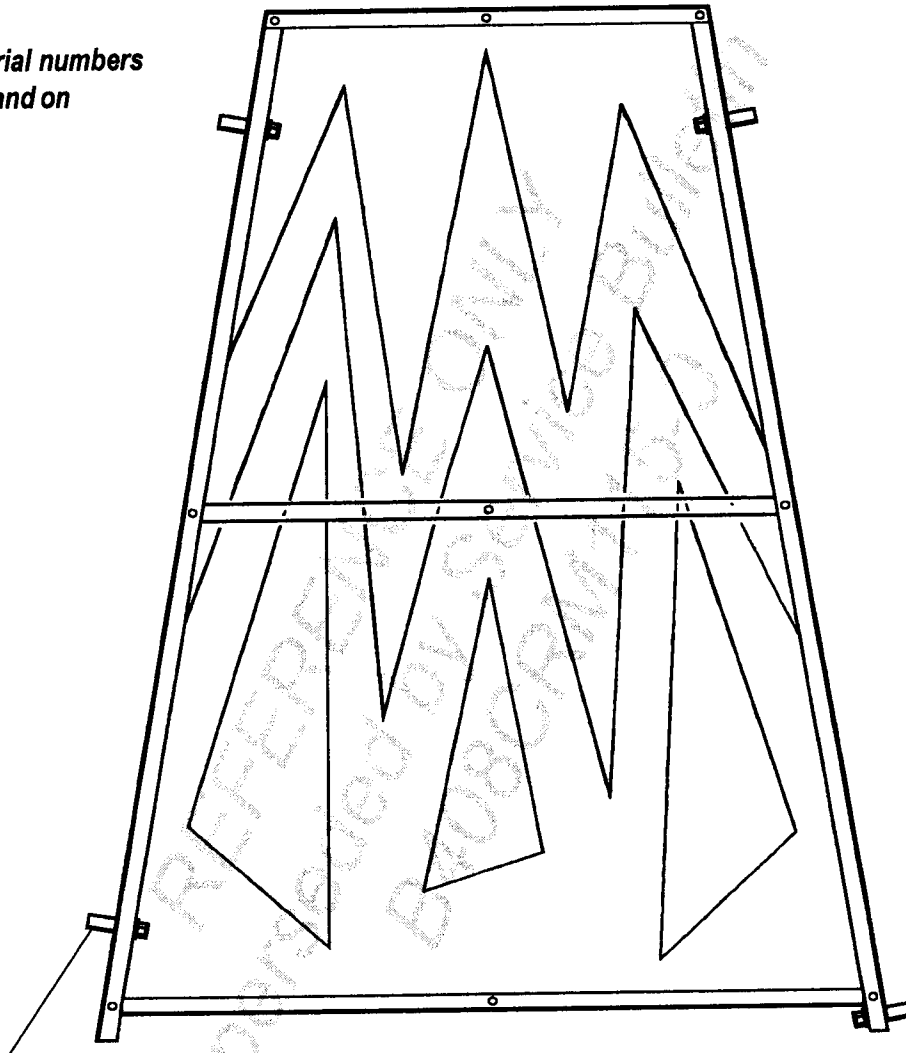
Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

**For ride serial numbers
408-04499 and on**



Remove guide pins from both sides of sweep insert panel. Locate new holes 3" in from existing holes (toward hub). Drill 0.28" diameter holes through both sides of tube and install guide pins with existing fasteners.

Original position
of guide pins



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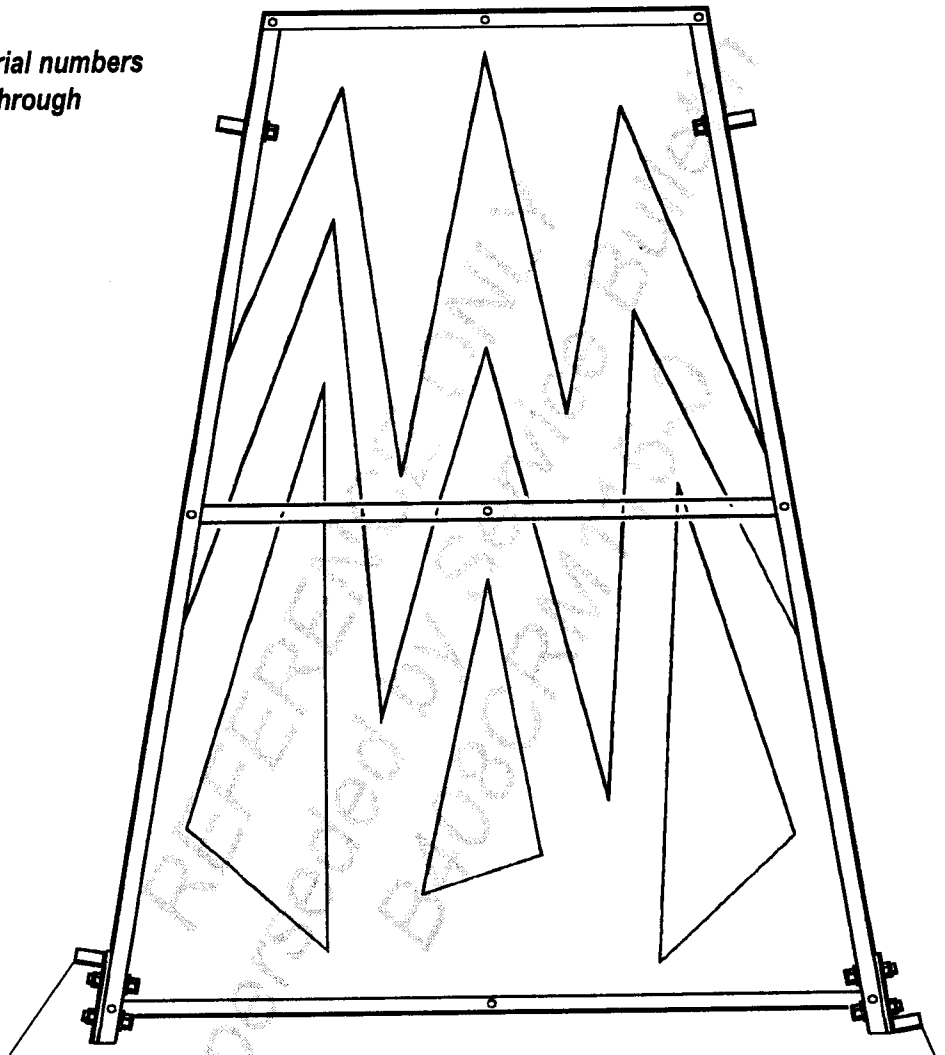
Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: CHAOS Affected Serial Nos.: All Units

Model No.: 408

Detail of issue (continued):

**For ride serial numbers
408-00196 through
408-04399**



Remove guide pin weldments from both sides of sweep insert panel. Turn 180° as shown and mount with existing fasteners.

Original position of guide pin weldments



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Affected Production Dates: All

Ride Name: CHAOS

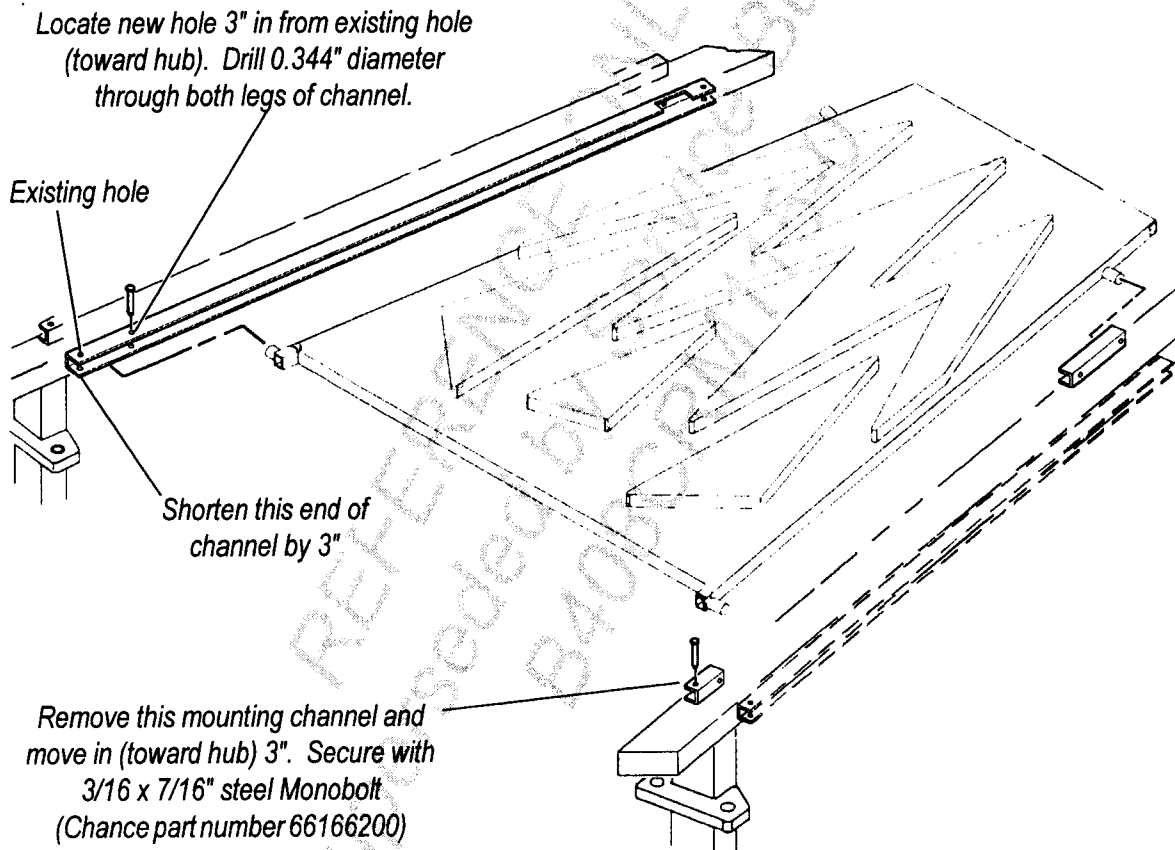
Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

PREPARATION OF SWEEPS FOR REWORK

Modify all mounting channels for the sweep insert panels as shown. This is necessary to provide clearance for the upper doubler plates. Also, modify all sweep insert panels as shown on the next page.





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Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All Units

Model No.: 408

Detail of Issue (continued):

SWEEP INSPECTION PRIOR TO REWORK

Carefully inspect all sweeps for cracks or other indications. Look at the welds and parent metal at all joints, paying particular attention to the areas where the gussets will be installed.

DO NOT INSTALL THE REWORK KIT IF THERE ARE CRACKS IN THE SWEEP UNTIL REPAIRS SPECIFIED BY CHANCE RIDES MANUFACTURING, INC. ARE MADE.

- **If any indications are found, DO NOT CONTINUE OPERATION OF THE RIDE.** Contact the Chance Customer Service Department immediately for instructions on further action to be taken.

DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE SWEEPS, EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.

- **If no indications are found,** order and install the Sweep Rework Kit, part number K408CRM110-0 using the instructions on the following pages of this bulletin.

ANNUAL INSPECTION OF SWEEPS

After Sweep Rework Kit is installed, visually inspect the sweeps **annually** for damage, cracks, or other indications. Look at the welds and parent metal at all joints. If any indications are found, contact the Chance Customer Service Department immediately. **DO NOT CONTINUE OPERATION OF THE RIDE.**



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Model No.: 408

Detail of Issue (continued):

