

CHANCE RIDES, INC.
 4219 Irving
 Wichita, KS 67277-2328
 U.S.A.
 Phone: 1-800-242-6231 • FAX: 1-316-942-7416
 Website: www.rides.com

Bulletin No:	B408R1181-B
Release Date:	August 3, 2001
Effective Date:	August 3, 2001
Supersedes:	B408R1181-A
Completion Date:	Immediately
Page:	1 of 7

SERVICE BULLETIN

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

Ride Name: CHAOS Affected Serial Nos.: All units

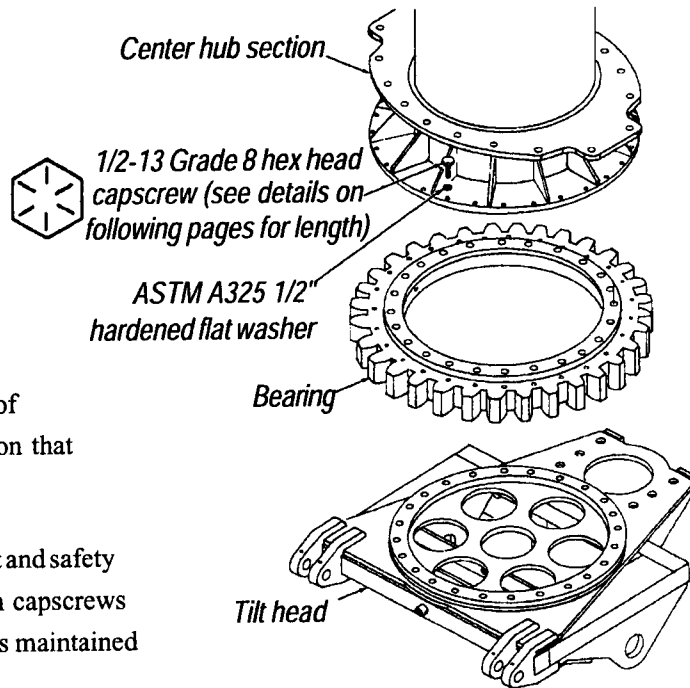
Model No.: 408

Abstract of Issue:
 Hub Capscrew Torque Check

Reason For Release:
 This bulletin supersedes Service Bulletin B408R1181-A. It is being released to emphasize and supplement the information contained in B408R1181-A.

The center hub section on the CHAOS amusement ride is secured to the bearing with 28 Grade 8 hex head capscrews. The correct length of the capscrews varies with the serial number of the ride and with the bearing installed on that specific ride.

It is essential for the care of the equipment and safety of the passengers that the correct length capscrews are installed and that the correct torque is maintained on these capscrews.



Action to be Taken:
 Chance Rides, Inc. requires all owner/operators of the above noted amusement rides to immediately perform the inspection described in the bulletin to verify the condition of the tapped holes in the bearing, and to install the correct length of capscrews for that specific ride. Thereafter, the capscrews must be checked for correct torque at least once per month during the operating season.

As with any ride, perform a daily visual check for signs of loose, broken or missing parts.



CHANCE RIDES, INC.
 4219 Irving
 Wichita, KS 67277-2328
 U.S.A.
 Phone: 1-800-242-6231 • FAX: 1-316-942-7416
 Website: www.rides.com

Bulletin No: B408R1181-B
 Release Date: August 3, 2001
 Effective Date: August 3, 2001
 Supersedes: B408R1181-A
 Completion Date: Immediately
 Page: 6 of 7

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

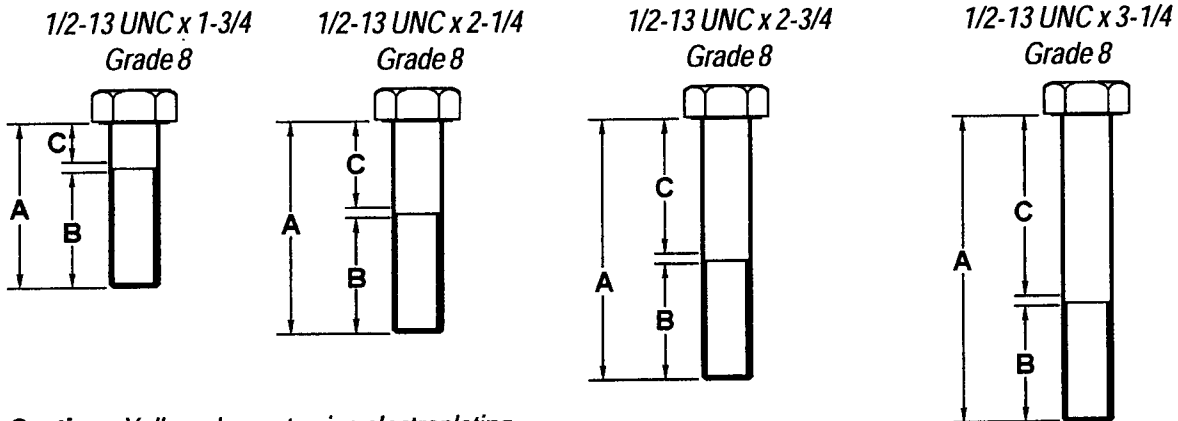
Ride Name: CHAOS Affected Serial Nos.: All units

Model No.: 408

Detail of Issue (continued):

Hex Head Capscrew Specifications

NOTE: Capscrews and hardened flat washers can be procured from sources other than Chance Rides, provided they meet these specifications.



Coating - Yellow chromate zinc electroplating

	"A" Nominal Length	"B" Thread Length	"C" Shank Length (minimum)
1/2-13 UNC x 1-3/4 Grade 8	1.75	1.25	0.115
1/2-13 UNC x 2-1/4 Grade 8	2.25	1.25	0.615
1/2-13 UNC x 2-3/4 Grade 8	2.75	1.25	1.115
1/2-13 UNC x 3-1/4 Grade 8	3.25	1.25	1.615



CHANCE RIDES, INC.
4219 Irving
Wichita, KS 67277-2328
U.S.A.
Phone: 1-800-242-6231 • FAX: 1-316-942-7416
Website: www.rides.com

Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 5 of 7

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

Ride Name: CHAOS Affected Serial Nos.: All units

Model No.: 408

Detail of Issue (continued):

Preparation of Tapped Holes in Bearing

Once the correct capscrew length for each location is determined, clean and prepare the tapped holes in the bearing as follows:

IMPORTANT: *This procedure requires that all capscrews be removed, one at a time. The existing capscrews and hardened flat washers must all be discarded and replaced with new parts of the correct size.*

1. Remove the existing capscrew and hardened flat washer and discard.
2. Using a 1/2-13 UNC bottoming tap, chase the entire length of the threads in the bearing to restore and clean the threads.
3. Using appropriate eye protection, clear chips and other debris from the tapped hole with compressed air.
4. Install the new capscrew with new hardened flat washer under the head, using Loctite® 271 (red).
5. Tighten the capscrew to 90 ft-lbs.
6. Continue the process until all 28 capscrews have been replaced.

Monthly Check of Capscrew Torque

Using a torque wrench, check for proper torque of all 28 capscrews. Torque value for checking these capscrews must be 80 ft-lbs.

IMPORTANT: *ALL 28 CAPSCREWS MUST BE TIGHTENED AND MAINTAINED AS DESCRIBED TO OPERATE THE RIDE. If damage in the tapped holes prevents one or more capscrews from meeting these specifications, the bearing must be replaced. Contact the Chance Rides Customer Service Department for all necessary parts and instructions on this procedure.*

If any capscrew is found to be loose, remove it and replace it with a new capscrew. Clean the threads on the new capscrew and in the bearing, then apply Loctite® 271 (red). Tighten the new capscrew to 90 ft-lbs. If a broken capscrew is found, contact Chance Rides, Inc. immediately for further instructions.



CHANCE RIDES, INC.
4219 Irving
Wichita, KS 67277-2328
U.S.A.
Phone: 1-800-242-6231 • FAX: 1-316-942-7416
Website: www.rides.com

BulletinNo: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 4 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

ModelNo.: 408

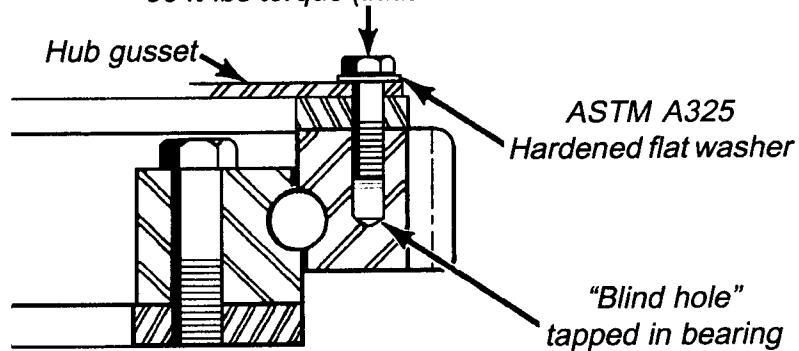
Detail of Issue (continued):

IMPORTANT: These details illustrate the correct length capscrews at the gusset locations on rides with the **Hub Gusset Kit** installed (Service Bulletin B408R1203-A). Inspect the tapped holes in the bearing as shown to determine the correct length of capscrew.

1/2-13 x 2-1/4" long Grade 8 Hex Head Capscrew

80 ft-lbs torque (monthly check).

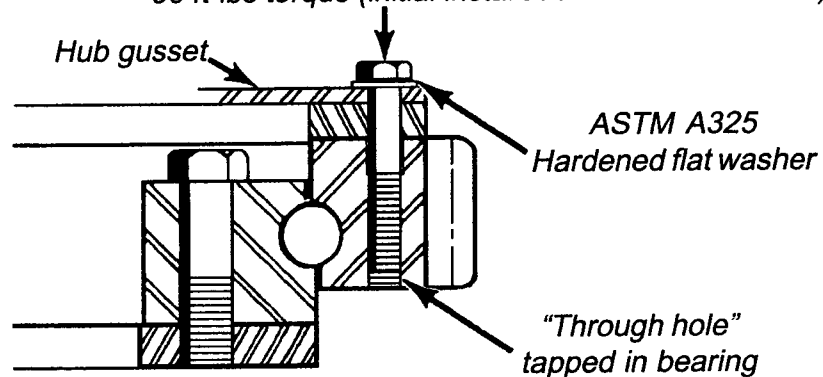
90 ft-lbs torque (initial installation with Loctite® 271)



1/2-13 x 3-1/4" long Grade 8 Hex Head Capscrew

80 ft-lbs torque (monthly check).

90 ft-lbs torque (initial installation with Loctite® 271)





CHANCE RIDES, INC.

4219 Irving

Wichita, KS 67277-2328

U.S.A.

Phone: 1-800-242-6231 • FAX: 1-316-942-7416

Website: www.rides.com

Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 3 of 7

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: CHAOS

Affected Serial Nos.: All units

Model No.: 408

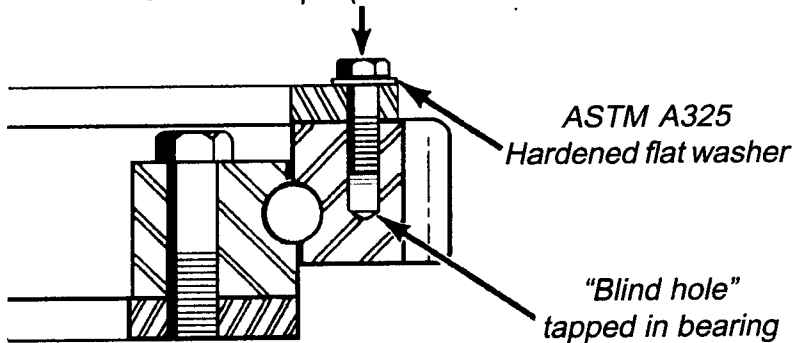
Detail of Issue (continued):

IMPORTANT: These details illustrate the correct length capscrews for all rides. Inspect the tapped holes in the bearing as shown to determine the correct length of capscrew. On rides with the **Hub Gusset Kit** installed (Service Bulletin B408R1203-A), refer also to the following page for capscrew lengths in the hub gusset locations.

1/2-13 x 1-3/4" long Grade 8 Hex Head Capscrew

80 ft-lbs torque (monthly check).

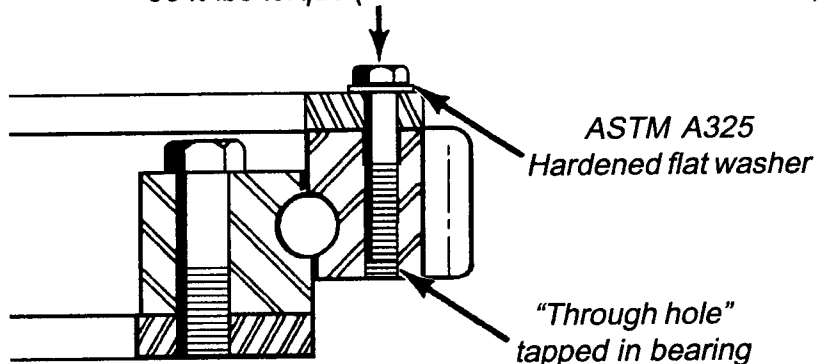
90 ft-lbs torque (initial installation with Loctite® 271)



1/2-13 x 2-3/4" long Grade 8 Hex Head Capscrew

80 ft-lbs torque (monthly check).

90 ft-lbs torque (initial installation with Loctite® 271)





CHANCE RIDES, INC.
4219 Irving
Wichita, KS 67277-2328
U.S.A.
Phone: 1-800-242-6231 • FAX: 1-316-942-7416
Website: www.rides.com

Bulletin No: B408R1181-B

Release Date: August 3, 2001

Effective Date: August 3, 2001

Supersedes: B408R1181-A

Completion Date: Immediately

Page: 2 of 7

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

Ride Name: CHAOS Affected Serial Nos.: All units

Model No.: 408

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. All applicable OSHA safety standards and safe industry practices must be observed.

NOTICE

Use only those components authorized, specified or provided by Chance Rides, Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with any unauthorized alterations and/or modifications or additions and installations of unauthorized components.

Detail of Issue:

Capscrew Length

Two factors determine the correct length of capscrews securing the center hub section to the bearing:

1. The ride serial number - ride serial numbers 408-00196 through 408-02097 and 408-02297 through 408-03998 were retrofitted with the Hub Gusset Kit (refer to Chance Rides Service Bulletin B408R1203-A). In the locations of the hub gussets on these rides, a different length capscrew is required.
2. The tapped holes in the bearing - the bearing manufacturer has changed the tapped holes from a "blind hole" to a "through hole". Different length capscrews are required for each type of tapped hole.

Using the illustrations on the following pages of this bulletin, inspect the hub and bearing to determine the correct fasteners for that specific ride.



CHANCE RIDES, INC.
4219 Irving
Wichita, KS 67277-2328
U.S.A.
Phone: 1-800-242-6231 • FAX: 1-316-942-7416
Website: www.rides.com

Bulletin No:	B408R1181-B
Release Date:	August 3, 2001
Effective Date:	August 3, 2001
Supersedes:	B408R1181-A
Completion Date:	Immediately
Page:	7 of 7

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 408-02097 and 408-02297 through 408-03998 (with Hub Gusset Kit) with "blind holes" in bearing, order Kit number K408R1181-1, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60849400	HEX HEAD CAPSCREW (1/2-13 x 1-3/4 Grade 8)	14
60849700	HEX HEAD CAPSCREW (1/2-13 x 2-1/4 Grade 8)	14
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28

For ride serial numbers 408-00196 through 408-02097 and 408-02297 through 408-03998 (with Hub Gusset Kit) with "through holes" in bearing, order Kit number K408R1181-2, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60850200	HEX HEAD CAPSCREW (1/2-13 x 2-3/4 Grade 8)	14
60850600	HEX HEAD CAPSCREW (1/2-13 x 3-1/4 Grade 8)	14
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28

For ride serial numbers 408-02197 and 408-04098 and on with "blind holes" in bearing, order Kit number K408R1181-3, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60849400	HEX HEAD CAPSCREW (1/2-13 x 1-3/4 Grade 8)	28
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28

For ride serial numbers 408-02197 and 408-04098 and on with "through holes" in bearing, order Kit number K408R1181-4, which contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
60850200	HEX HEAD CAPSCREW (1/2-13 x 2-3/4 Grade 8)	28
68553000	HARDENED FLAT WASHER (1/2" ASTM A325)	28