



CHANCE RIDES, INC.
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Bulletin No:	P414R1253-0
Release Date:	June 15, 2001
Effective Date:	June 15, 2001
Supersedes:	B414R1223-0
Completion Date:	N/A
Page:	1 of 3

NOTIFICATION

Ride Manufacturer: CHANCE RIDES, INC. Affected Production Dates: Prior to May, 2001

Ride Name: INVERTER (Portable Model) Affected Serial Nos.: Prior to Ride Serial No. 414-03201

Model No.: 414

Abstract of Issue:
Tower Hinge Bracket Kit

Reason For Release:

Chance Rides, Inc. has become aware that cracks can develop in the tower hinge on the above noted INVERTER amusement rides, due to improper set-up and tear-down procedures. The correct set-up and tear-down procedures are described in detail in the *INVERTER Service Manual*.

It is the owner/operator's responsibility to ensure that set-up/tear-down personnel are familiar with the procedures specified and that these procedures are followed. If the proper procedures are not followed, serious personal injury to workers and severe structural damage to the ride can occur.

This notification describes an improved tower hinge kit which strengthens the hinge area. It can be ordered and installed at the owner/operator's option. If the owner/operator chooses to make this improvement, this notification supersedes Chance Rides service bulletin B414R1223-0 (Tower Hinge Bracket Inspection and Rework, August 9, 1999). If this option is not chosen, service bulletin B414R1223-0 remains in effect.

Chance Rides, Inc. strongly recommends that this improvement be made to all of the above noted INVERTER amusement rides.

Detail of Issue:

A kit has been developed to replace the upper tower hinge brackets and the hinge pin. The benefit of the kit is additional strength in the tower hinge area. This improvement is not to be considered an alternative to the correct set-up and tear-down procedures.

Order and install the Tower Hinge Rework Kit, number K414R1253-0. This kit includes all necessary parts to rework one complete ride, with complete instructions for installation. The kit will be offered at a reduced price if ordered within 180 days of the issue date of this notification.



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Affected Production Dates: Prior to May, 2001

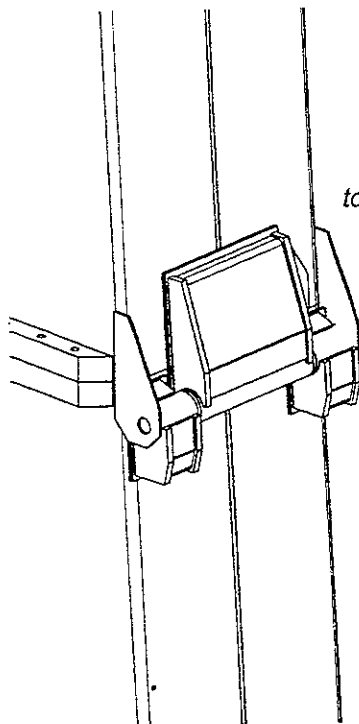
Ride Name: INVERTER (Portable Model)

Affected Serial Nos.: Prior to Ride Serial No. 414-03201

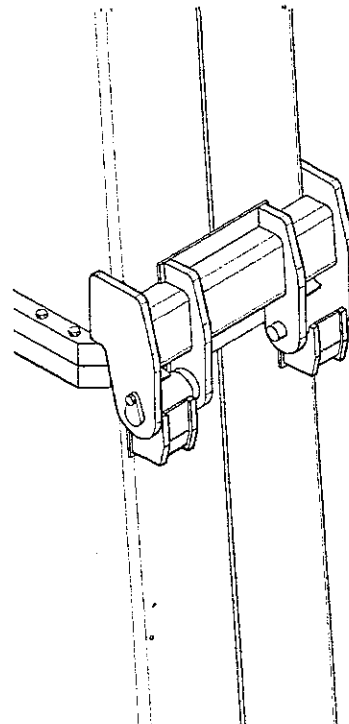
Model No.: 414

Action to be taken

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. All welding must be performed by a certified welder.



*Existing
tower hinge*



*Reworked
tower hinge*



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Action to be taken (continued):

The Tower Hinge Bracket Kit, part number K414R1253-0, contains the following:

<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K414R1253-0	Drawing - Installation Instructions	1
414-0780-002	Center Ear Weldment	1
414-0780-003	Center Ear Weldment	1
414-0780-011	Plate - Formed Channel	1
414-0780-013	Plate - Side Hinge Ear	2
414-0780-015	Bar - Spacer	2
414-0780-005	Hinge Pin Weldment	2
60843000	Hex Head Capscrew (1/2-13 x 2-3/4 Grade 5)	2
64782400	Lock Nut (1/2-13 Nylon Insert)	2
68531800	Flat Washer (1/2)	4
68980600	Grease Zerk (1/8 PT x 90 Deg)	2

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.