Number: 96

Date: 3-13-75

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers:

Ride: ALL SKY WHEELS BUILT PREVIOUS TO MARCH, 1975

Subject: NEW STYLE SEAT LATCH

The Seat Latch for the SKY WHEEL has been redesigned to allow for the addition of a Hairpin Safety.

The addition of the Hairpin was deemed necessary as a safety precaution.

Cost of the new Seat Latches is $23.00 at present. This represents a small investment for the protection it adds to your operation.

Installation of the latches is simple and can be accomplished in a short time. The only modification necessary is drilling a new hole in the seat.

NEW PARTS

QUANTITY PER SEAT	PART NUMBER	DESCRIPTION
1	347-39632	Latch Assembly
2	5/16-18 x 3/4	Soc. Hd. Button Cap Screw
2	5/16	Lock Washers

INSTALLATION

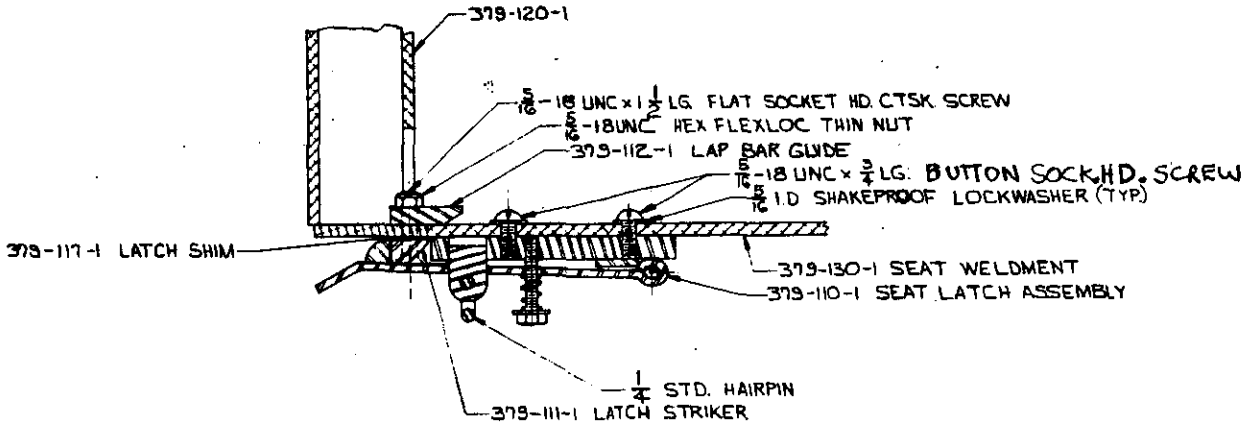
After removing old latches, position new Latch by installing screw (finger tight) in the hinge end of the latch.

Mark location of new hole and drill 5/16" dia. hole through seat.

Install second screw and torque both to 10-12 ft. lbs.

Check alignment and closure of Latch.

Shim the Latch Striker out from the Lap Bar if necessary to insure a good contact.



ALLAN HERSCHELL

CHANCE
MANUFACTURING CO., INC.

Number: 99
Date: 4-7-75

Supercedes:
Number:
Date:

Service Information

Ride: SKY WHEEL ALL UNITS BUILT PREVIOUS TO 4-3-75

Subject: SEAT SUPPORT SHAFT MODIFICATION AND SPOKE CHECK

As an added measure of safety on new SKY WHEELS, a bolt has been added to the end of the Seat Support Shaft.

Addition of the bolt was deemed necessary to insure that a seat would not be dropped because of a Seat Support Shaft coming out of the Spoke.

The previous method of double Snap Rings has proven adequate over the years. However, as the rides age and the spokes are handled more, there is an increasing possibility of the spokes spreading outward at the seat attach area. Should this happen, the Snap Rings will be subject to a shear type load, much greater than designed for.

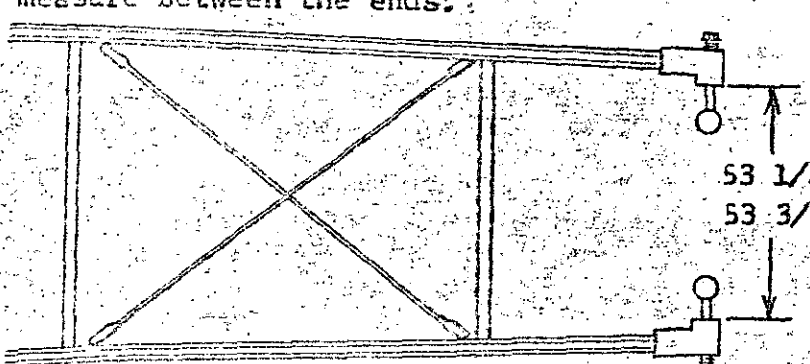
The above condition should never happen, providing the spokes are handled in a reasonable fashion and periodically checked for a spreading condition.

It is recommended that all existing rides be modified and checked per the following instructions.

SPOKE CHECK

Spokes should be visually checked each time the ride is assembled.

Sight along each side of the spoke for signs of bending or twisting and measure between the ends.



SPOKES NOT WITHIN LIMITS

If Spokes are bent and do not meet specified dimensions, consult Chance Manufacturing Company about corrective action.

Factory and General Office, 4219 Irving, Box 2397 Wichita, Kansas 67201 Area Code (316) 942-741

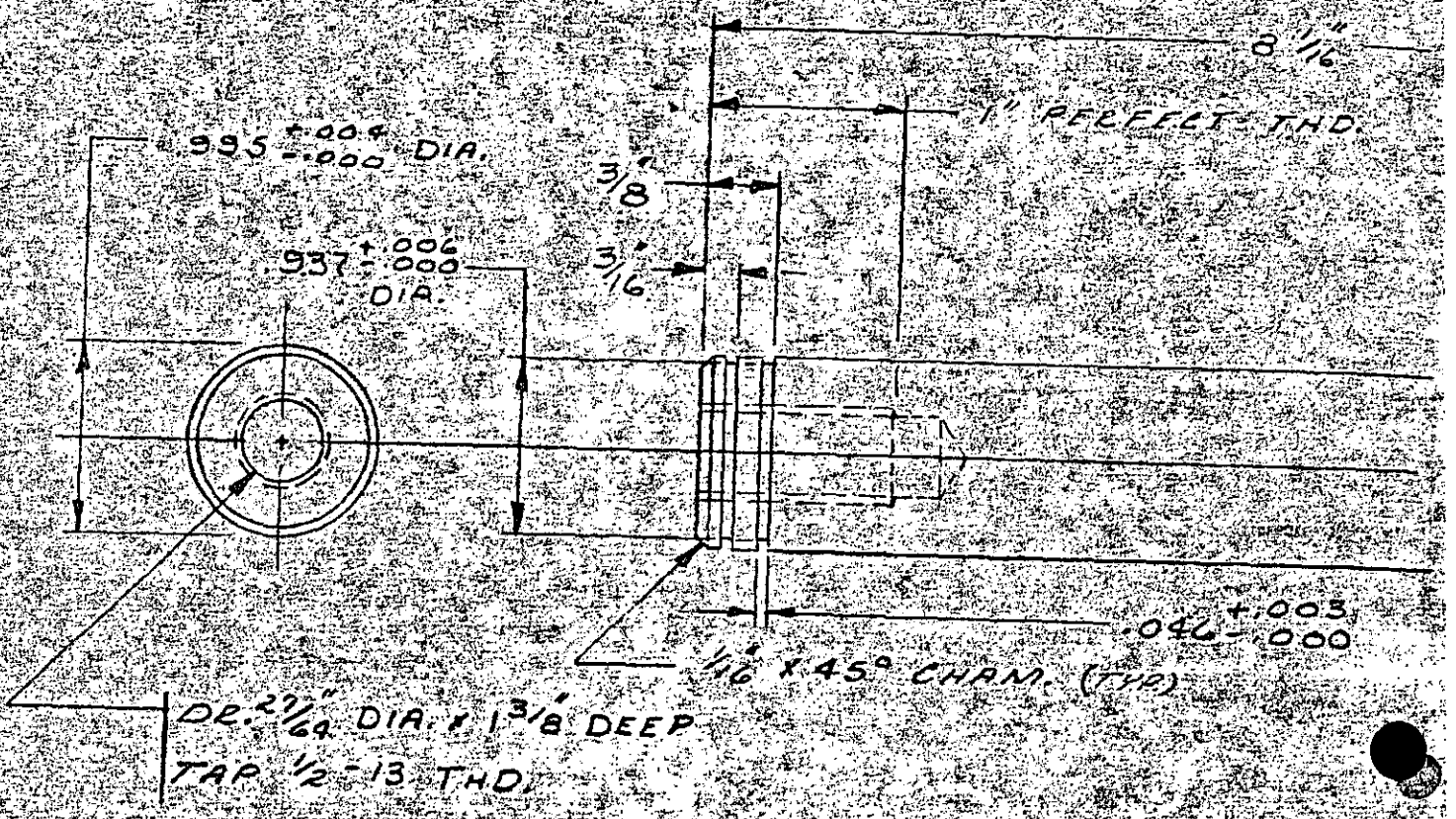
Sales Office: 103 Ross Ave., Dallas, Texas 75202 Area Code (214) 742-380

ADDITION OF BOLT TO SEAT SUPPORT SHAFT

5K9 Wheel

Remove shafts from ride and modify per drawing.

New shafts can be ordered if modification of existing shafts is not practica



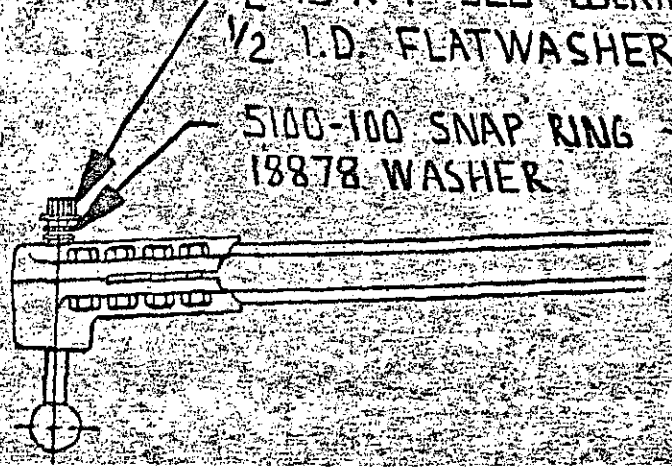
Installation

When installing new or reworked parts, use both of the Snap Rings and the special Self-Locking Bolt.

If old shafts have been reworked, the bolts can be ordered from us, Part Number 247-64329, or from Bowman Products Division, Part Number 41024.

New Shafts, Part Number 247-64881, will be shipped with Lock Bolt, Part Number 247-64329, and Washer.

Present cost of new shafts is $11.40.



Sky Wheel

Number: 111

Date: 1-5-76

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 71-2601 through 74-2609

Ride: SKY WHEELS (CHANCE BUILT) Subject: BULL WHEEL AXLE CHECK

A SKY WHEEL built by the Allan Herschell Company had a Bull Wheel Axle fracture in two. Fortunately the ride did not collapse and no one was injured. However, the results of an accident such as this could be tragic.

The fracture occurred on an eight year old ride, and it is our opinion that the fracture was caused by the welding procedures that were used on the axle.

Newer axles have additional gussets, and strengthening members, but they were welded to Allan Herschell specifications. We feel these specifications are marginal from a safety standpoint.

Boom Axle Inspection

Because of the welding procedures used, it is imperative that all axles be checked by a certified testing firm. The axles can be checked by magna-flux, ultrasonic or other method deemed suitable by the testing firm, along the entire length of the axle, and especially in the welded areas.

All axles should be checked before the next operating season and once a year thereafter.

Visual Inspections

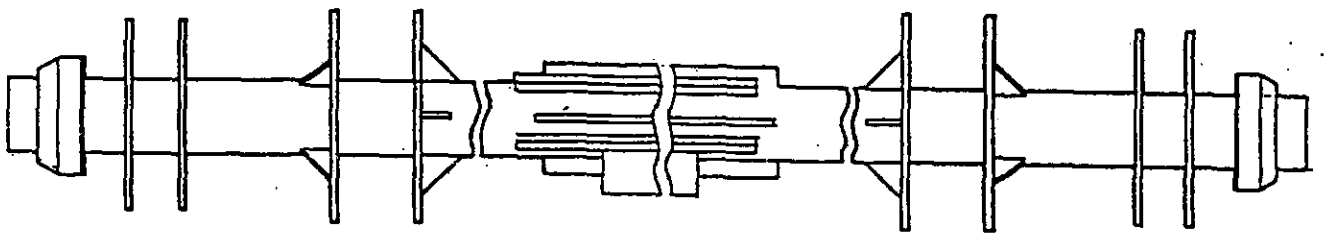
In addition, the ride operator should visually inspect structural members, including axles, daily before operating ride.

Failures of this type do not happen all of a sudden. The first signs of fatigue will be a hairline crack which enlarges until final failure occurs.

If any flaws or cracks are detected, contact the factory at once.

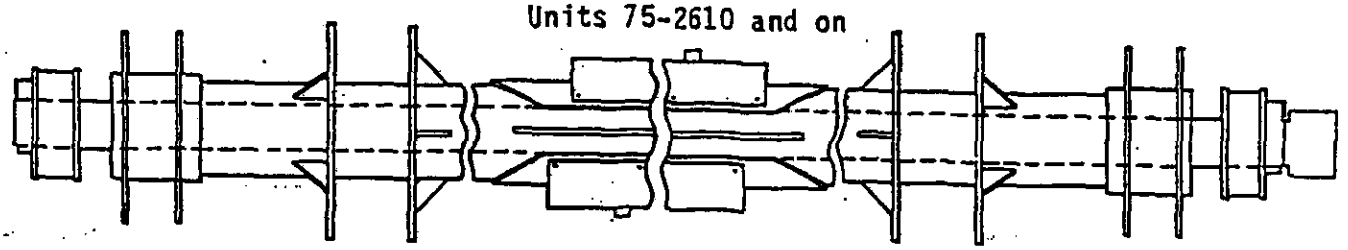
DO NOT ATTEMPT TO REWELD THE SHAFT

OLD STYLE (Solid Axle Shaft)
Units prior to 75-2610



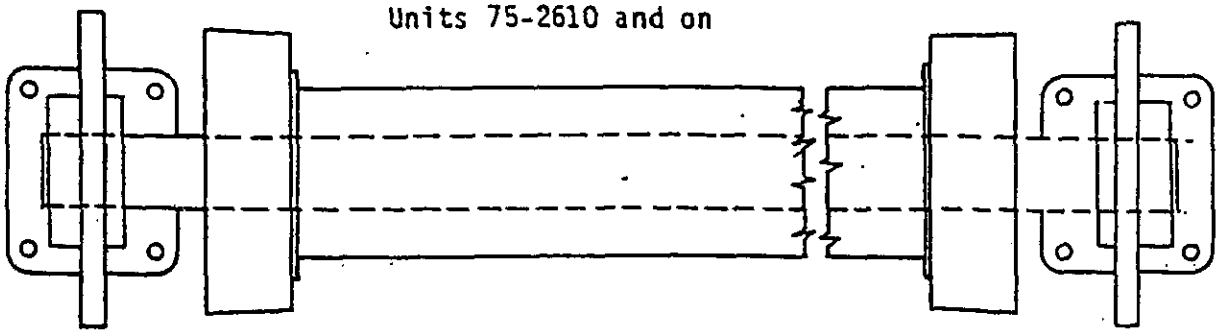
DO NOT ATTEMPT TO WELD ON SHAFT

NEW STYLE (Axle revolves around "dead" axle)
Units 75-2610 and on



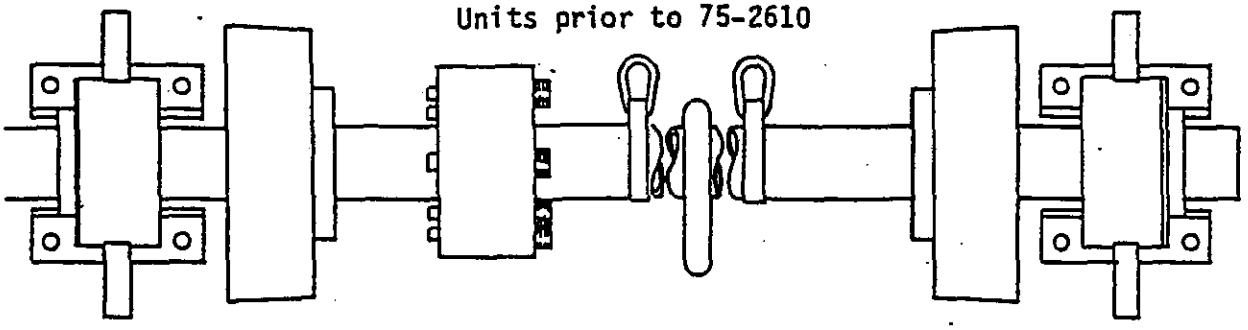
20. Inspect boom axle (Bulletin 111).

NEW STYLE (Axle revolves around "dead" axle)
Units 75-2610 and on



DO NOT ATTEMPT TO WELD ON SHAFT

OLD STYLE (Solid Axle Shaft)
Units prior to 75-2610



29. Inspect wheel axles.

Number: B379R1041-0

Date: July 17, 1989

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

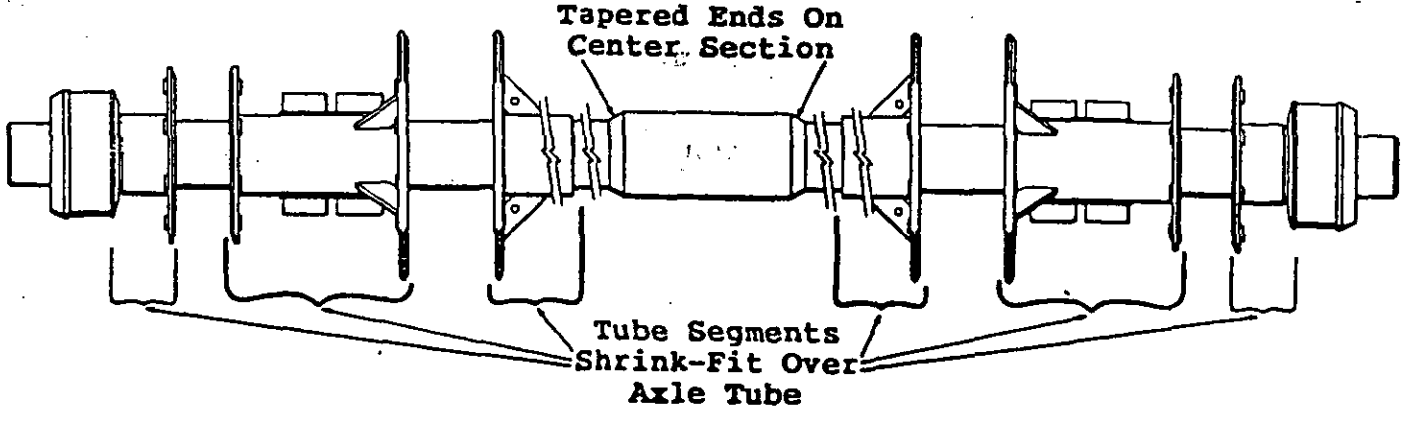
Model: SKY WHEEL

Subject: Boom Axle Inspection

In 1987, CHANCE RIDES, INC. made available a newly designed boom axle for the SKY WHEEL. This new axle has segmented components which are shrink-fit to a single axle tube, thus eliminating welding directly to the tube, and resulting in a more fatigue-resistant axle.

The boom axle is an important structural component of the SKY WHEEL. As a safety precaution, it must be inspected regularly. If the boom axle fails during operation, serious structural damage and possible injury to passengers and/or bystanders can result.

All owners of SKY WHEEL amusement rides which are equipped with the new style boom axle are required to inspect the boom axle as described in this bulletin. These axles can be identified as shown below.



Perform the inspection as described on the reverse side of this bulletin. Fill out and return the attached Certificate Of Compliance for the inspection no later than February 1, 1990.

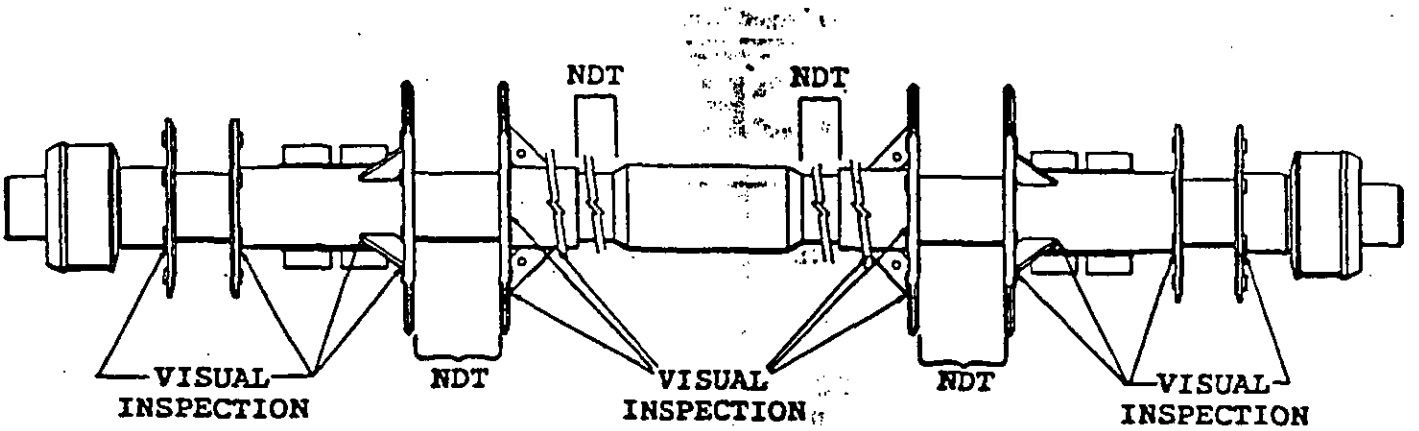
NOTE: Complete the Certificate Of Compliance only for the initial NDT inspection. Visual inspections must commence immediately.

If there are any questions regarding this inspection, contact the CHANCE CUSTOMER SERVICE DEPARTMENT immediately.

Factory and Sales Office: 4219 Irving · P.O. Box 12328 · Wichita, Kansas 67277-2328 · (316) 942-7411 · FAX: (316) 942-7416

INSPECTION PROCEDURE

Visual inspection of the ride's major structural components must be made on a continuing basis. The following inspection of the boom axle must be made in addition to the ongoing inspection of the ride.



- ANNUALLY - At least once each operating season, the axle must be checked by a certified testing firm, using a suitable non-destructive testing (NDT) method in the areas noted.

- MONTHLY - Visually check the axle as noted once a month, or at every set-up, whichever occurs first. Inspect the welds and the parent metal surrounding the welds. This inspection must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation.

If cracks or any unusual condition are detected, contact the CHANCE CUSTOMER SERVICE DEPARTMENT immediately. **DO NOT OPERATE THE RIDE.**

Certification of Compliance

SERVICE BULLETIN B379R1041

We hereby certify the procedure outlined in the above-mentioned service bulletin has been performed on the SKY WHEEL

Serial No(s) _____, in accordance with the instructions and specifications supplied by Chance Rides, Inc.

Date Bulletin Received _____

Date Procedure Performed _____

Name and Address of Person performing Procedure:

_____

_____

Attested:

Owner _____

Address _____

City _____ State _____

By: _____

Date: _____

Maintenance Supervisor _____

Address _____

City _____ State _____

Date: _____

Results: _____

_____

_____

_____

This certification must be completed and returned to Chance Rides, Inc. within fifteen (15) days of receipt of the bulletin.

Number: B47-0355-00

Date: Feb. 1, 1990

Supersedes:

America's Largest Manufacturer of Amusement Rides

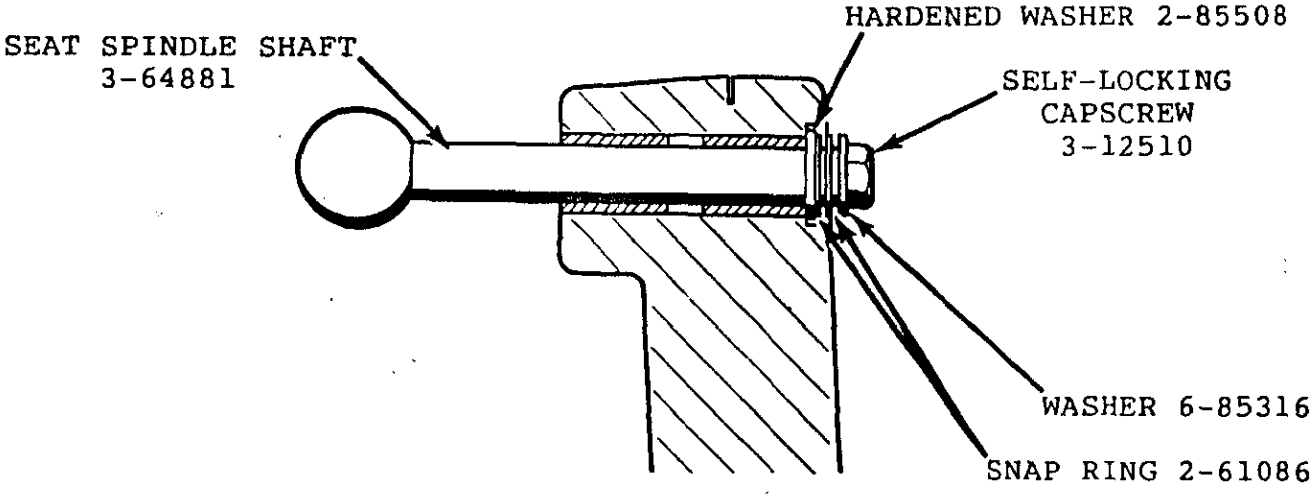
SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: SKY WHEEL

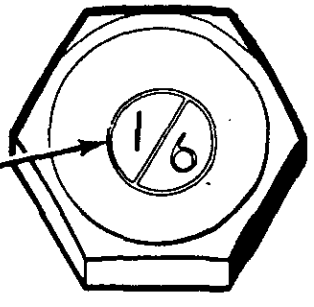
Subject: Seat Spindle Bolt Identification

It has come to Chance Manufacturing's attention that the Bowmalok® self locking capscrew used with the seat spindle shaft for SKY WHEEL amusement ride as illustrated below is no longer available.

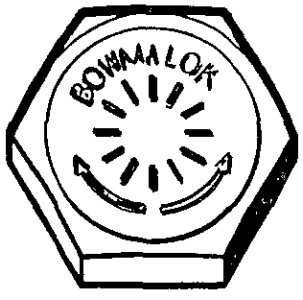


A new self locking capscrew is now available and must be used when replacing the old style self locking capscrew. Only self-locking capscrews as identified below are acceptable for use with the seat shaft spindle.

Numbers may vary due to production date



NEW STYLE
Part No. 3-12510



OLD STYLE

Factory and Sales Office: 4219 Irving • P.O. Box 12328 • Wichita, Kansas 67277 • (316) 942-7411

IMPORTANT

IF EITHER OF THESE SELF LOCKING CAPSCREWS IS REMOVED FROM THE SEAT SHAFT SPINDLE FOR ANY REASON, IT MUST BE DISCARDED AND A NEW SELF LOCKING CAPSCREW USED IN ITS PLACE.

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions of this bulletin, contact the Chance Customer Service Department.

NOTICE

Use only those components authorized, specified or provided by the manufacturer. If any alterations and/or modifications or additions and installations of unauthorized components are made to the original design without the manufacturer's explicit written consent or without direct supervision by a manufacturer's representative, Chance Manufacturing Co., Inc. makes no claims to the integrity of the altered or modified ride.

Number: B160R1060-0

Date: March 16, 1990

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: ALL UNITS - Chance Manufacturing Co. Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing Company, Inc.

Ride: SKYWHEEL Subject: INSPECTION OF SPOKES

Chance Rides, Inc. has become aware of a SKYWHEEL amusement ride in which cracks developed in a spoke. All SKYWHEEL owners are required to perform the inspection on each spoke of their ride as described on the reverse side of this bulletin. The Certification Of Compliance must be filled in and returned to Chance Rides, Inc. within 15 days from receipt of this bulletin.

This inspection must be performed on an annual basis.

This inspection must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this inspection, contact the Chance Customer Service Department.

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.

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INSPECTION PROCEDURES

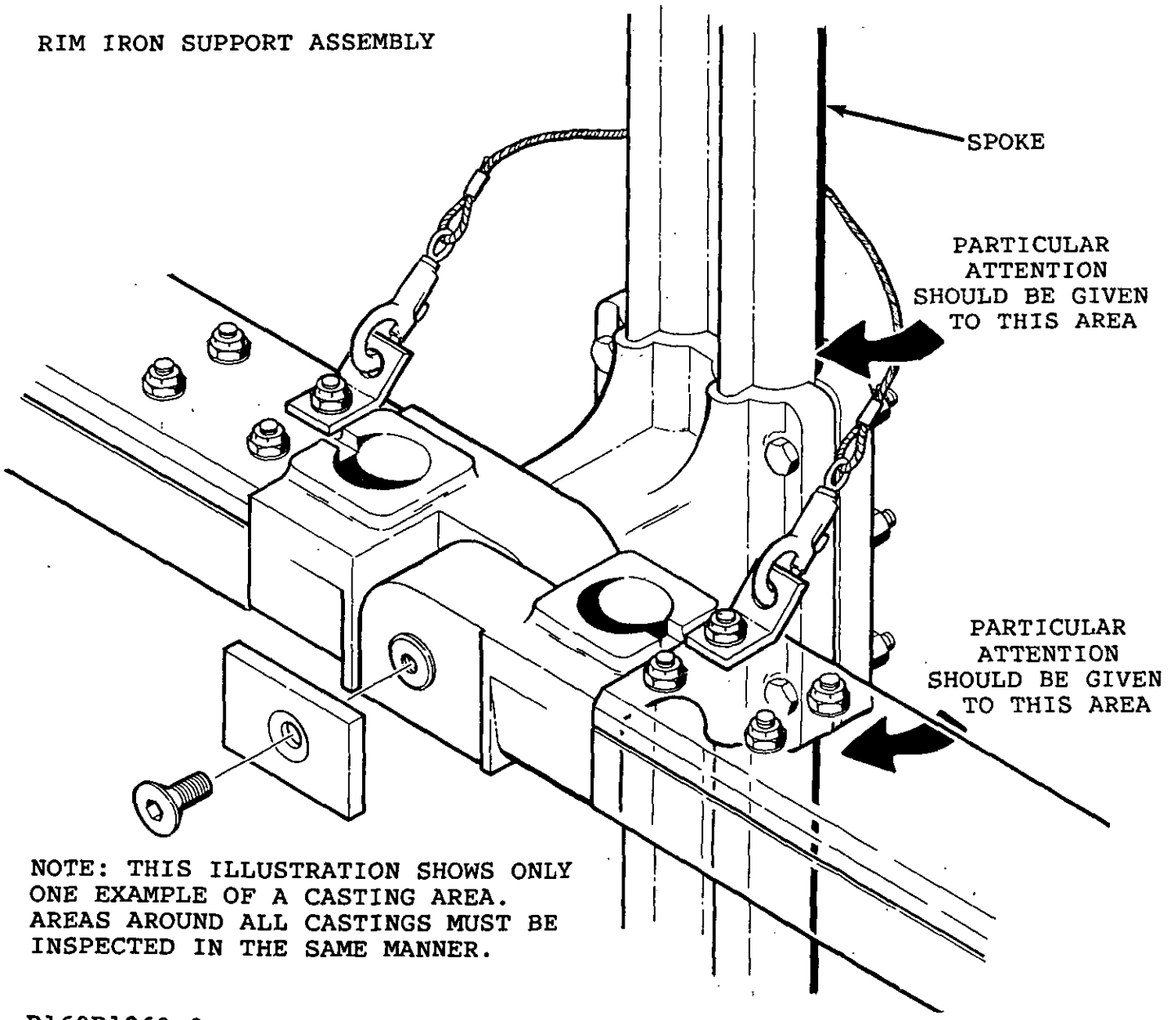
1. Thoroughly clean all surfaces of each spoke. Using a suitable solvent, remove all dirt and grease residues.

2. Visually inspect entire length of spoke. Particular attention must be given to the areas around each casting, see example illustration below.

3. If visual inspection reveals a questionable area, that area must be inspected by a qualified person using liquid penetrant testing.

4. If any cracks are found, DO NOT ATTEMPT TO REPAIR OR WELD THEM, contact Chance Customer Service immediately. DO NOT OPERATE THE RIDE UNTIL CHANCE CUSTOMER SERVICE HAS BEEN NOTIFIED AND THE APPROVED REPAIR PROCEEDURES COMPLETED.

RIM IRON SUPPORT ASSEMBLY



NOTE: THIS ILLUSTRATION SHOWS ONLY ONE EXAMPLE OF A CASTING AREA. AREAS AROUND ALL CASTINGS MUST BE INSPECTED IN THE SAME MANNER.

CERTIFICATION OF COMPLIANCE

FOR

SERVICE BULLETIN

B160R1060-0

We hereby certify the procedure outlined in the above-mentioned service bulletin has been performed on the SKYWHEEL

Serial No(s) _____, in accordance with the instructions and specifications supplied by Chance Rides, Inc.

Date Bulletin Received _____

Date Procedure Performed _____

Name and Address of Person performing Procedure:

_____

_____

Attested:

Owner _____ Maintenance Supervisor _____

Address _____ Address _____

City _____ State _____ City _____ State _____

By: _____

Date: _____ Date: _____

Results: _____

_____

_____

This certification must be completed and returned to **CHANCE Rides, Inc. P.O. Box 12328, WICHITA, KS 67277-2328**, within fifteen (15) days of receipt of this bulletin.

Number: B160R1063-0

Date: April 13, 1990

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Units - Chance Manufacturing Co.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with rides produced by Chance Manufacturing Company, Inc.

Ride: SKYWHEEL

Subject: Casting Installation

It has been found during field inspections by Chance Rides, Inc. personnel that some spoke castings on some SKYWHEEL amusement rides have been improperly installed. These castings were installed without the use of epoxy between the two halves. This results in a space between the two halves when clamped together around the spokes, as shown in illustration A. When the 5/16 inch bolts are brought to the proper torque the stress created on the casting due to this space may cause the casting to crack.

Whenever the castings on the spokes are removed or replaced the following proper installation procedure must be followed.

1. Thoroughly clean the area of the spoke where the casting will be mounted with lacquer thinner or a suitable solvent that removes all contaminates and which will not leave a residue.

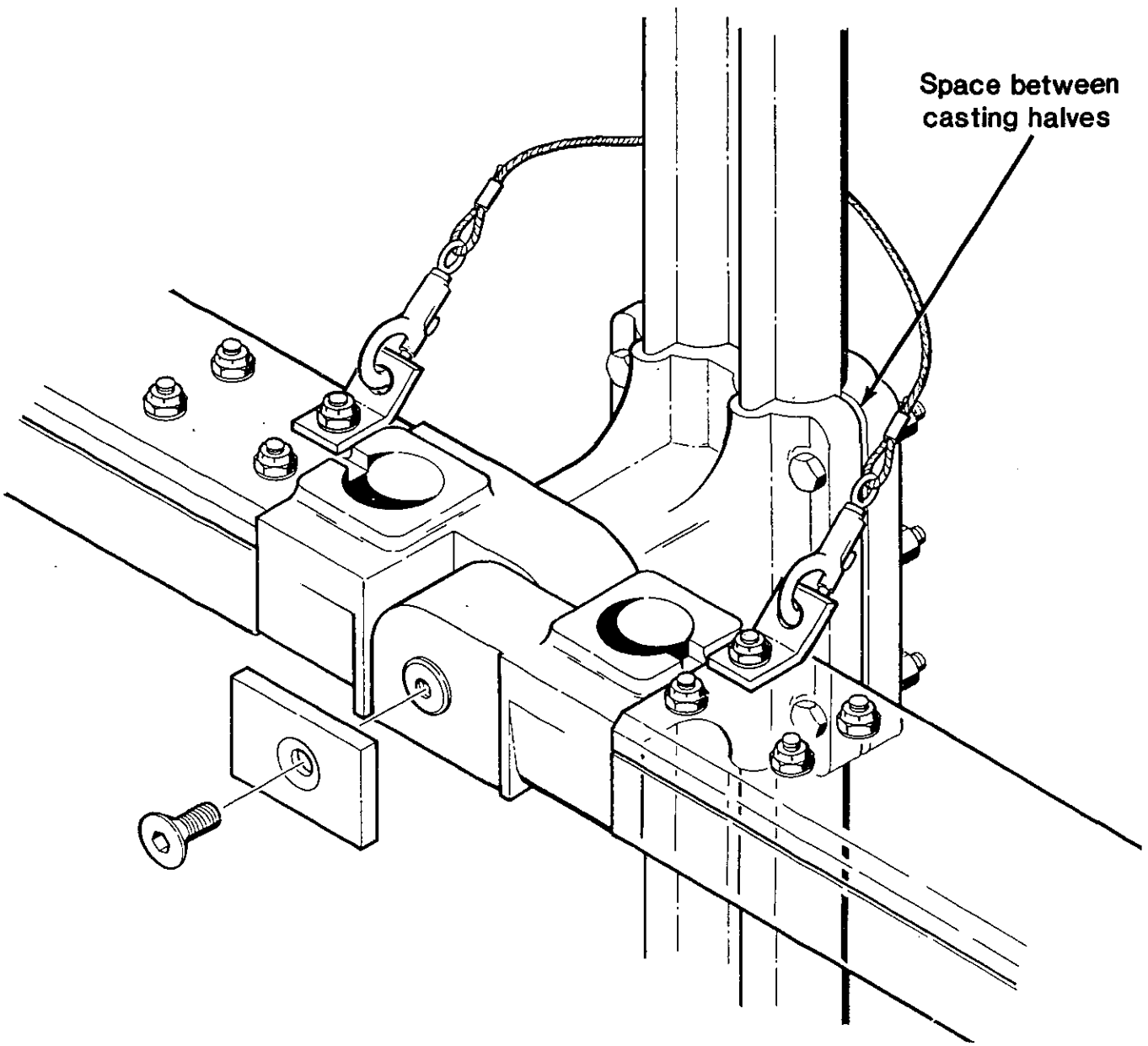
2. Apply a good quality auto paste wax to each location on the spoke where a casting is to be positioned.

3. Mix the special epoxy and hardener per the instructions on the kit. Use kit number S0056100 only.

4. Apply the epoxy to the inside of both halves of the casting, to a uniform layer of approximately 1/4 inch thick.

5. Use a torque wrench to torque the 5/16 inch bolts to 5 to 7 foot pounds. After the epoxy has hardened for at least 3 hours, torque bolts to 10 to 12 foot pounds.

ILLUSTRATION A



This bulletin applies to all spoke castings, including:

1. seat hanger support castings
2. rim iron support castings
3. spoke hub castings