



Issuing Entity:	Bulletin No.: SA-003-040412_Rev. 00
Vekoma Rides Parts & Services B.V.	Release Date: 04-04-2012
Schaapweg 18	Effective Date: Immediately
6063 BA VLODROP	Supersedes: -
The Netherlands	Completion Date: 04-04-2012
CoC Number: 12049585	

# Safety Alert

Original Ride Manufacturer: Table 1	Affected Production Dates: All rides as mentioned in table 1
Ride Name: GIB, HS SLC, TILT, BA	Affected Serial Nos: Table 1
Model No: N.A.	

<p><b>Abstract of issue:</b></p> <p>This safety alert instructs owners to examine the bearing blocks of the seat restraint for cracks before continuing operation.</p>
<p><b>Reason for release:</b></p> <p>The bearing blocks of the seat restraints are subject to fatigue stress. Undetected cracks can lead to total failure, which can result in the restraint being opened during operation, leaving the patron unrestrained.</p>
<p><b>Action to be taken:</b></p> <p>Stop operation with patrons of the mentioned ride systems and check all bearing blocks for cracks or other anomalies.</p>

## Revision summary:

Revision	Date	Comment

\* In the interests of safety and as a service to the industry, Vekoma Rides Parts & Services B.V. issues technical information bulletins for the benefit of owners of amusement rides that are manufactured by Vekoma Rides Manufacturing B.V. (both companies are members of Vekoma Rides B.V.). These bulletins may also contain technical information, on parts or modifications relating to amusement rides, manufactured by *Vekoma International B.V.* and / or *Vekoma Manufacturing B.V.* These are dissolved companies which have no legal relationship whatsoever with Vekoma Rides B.V.

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Details of issue continued:

**Table 1: Affected serial Nos.**

IB-nr.	Original Ride Manufacturer	Project number
30501	Vekoma International BV / Vekoma Manufacturing BV*	20142
30502	Vekoma International BV / Vekoma Manufacturing BV*	20144
30503	Vekoma International BV / Vekoma Manufacturing BV*	20143
30504	Vekoma Rides Manufacturing BV	91011
30505	Vekoma Rides Manufacturing BV	60329
32034	Vekoma Rides Manufacturing BV	91015/91016
34001	Vekoma Rides Manufacturing BV	60189/60066/91026
32501	Vekoma Rides Manufacturing BV	91050

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## 1.1 Why this information bulletin

The bearing blocks of the seat restraint (see figure 1) are subject to fatigue stress/loading. At an existing ride a bearing block had a complete fracture. In some cases also crack initiations were found (see figure 2). These cracks compromise the containment of patrons during the ride sequence.

## 1.2 Required actions

Stop operation with patrons of the mentioned ride systems.

The bearing blocks for all systems mentioned in table 1 (see figure 1) shall be inspected by means of NDT (Non Destructive Testing) examination. The NDT examination should be in compliance with the standard as mentioned in table 2 for penetrant testing (PT). Information on how to perform and assess the NDT examination can be found in this standard as well. For more information or in case of any uncertainties Vekoma Rides Parts & Services BV (VRP&S) shall be contacted.

All aluminum bearing blocks need to be replaced by an upgraded design in case the ride is more than 7 years in operation (drawing 01206-57-2013; article number 3012648). The upgraded design is expected to be a material change.

In case the ride is in operation less than 7 years updated manual NDT inspection intervals will be provided. Daily visual inspections per table 2 (VT) shall be carried out on the bearing blocks until these updated NDT inspection intervals are available.

### Course of action after NDT (PT) is carried out;

In case no indications are found the ride can be taken in operation again. Daily visual inspections per table 2 (VT) need to be carried out until replacement parts of the upgraded design are carried out.

In case indications are identified, then details of the indications (including pictures) shall be reported to VRP&S immediately. Seats in which bearing blocks have indications are not allowed to continue operation with passengers. For other seats without indications the previous section applies; Daily visual inspections until replacement of the upgraded design parts are carried out.

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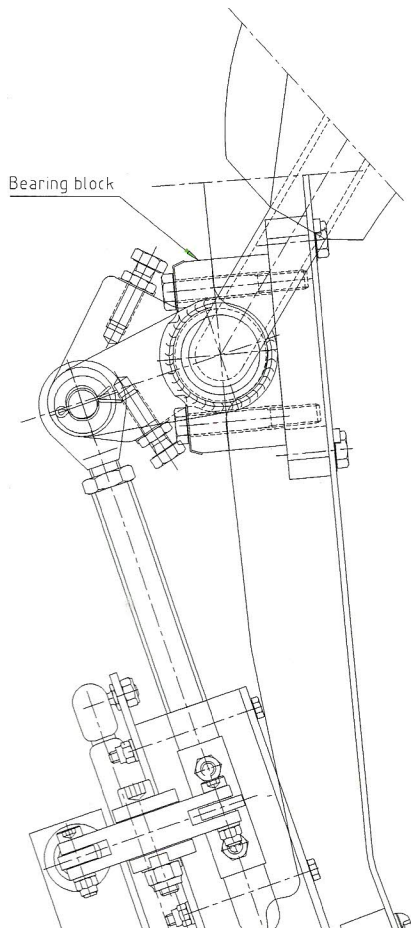
**Table 2 Inspection standard**

Code	Section / Article	Acceptance level
EN 10228-2	Penetrant testing (PT)	Class 4
EN 13814:2004 (7.7.1.3)	Visual testing (VT)	No indications allowed

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**Figure 1 Location of bearing blocks**

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**Figure 2 Cracks of bearing blocks**

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### According to the ASTM F853-04 standard:

Supplemental bulletins delivered by the manufacturer to the owner / operator that were not provided at the time of hand over of the attraction and contain new information or newly recommended inspections or testing, or both, will be released as a Safety Alert, Service Bulletin or an Notification, with the following criteria in order to carry the force and effect of this practice:

- "Safety Alert" For notifications that recommend immediate action.
- "Service Bulletin" For notifications that do not recommend immediate action but do recommend future action.
- "Notification" For notifications that do not necessarily recommend future action but are promulgation of information.

For additional information contact the Vekoma Rides Parts & Services B.V.:

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