

ZAMPERLA INC.
49 Fanny Road
Parsippany, New Jersey 07054-0598
USA
Phone: 973 334 8133 Fax: 973 334 6880

Bulletin No: 97 SA1
Release Date: 12/8/97
Effective Date: 12/8/97
Supersedes:
Completion Date: Before riding passengers
Page: 1 of 2

SERVICE BULLETIN

Ride Manufacturer: Zamperla Inc.

Affected Production Dates: All

Ride Name: Samba

Affected Serial Nos.: All

Model Number: Samba

Abstract Of Issue:

Cracks have been found in the welds located at the center column base plate junction and in the lower center frame structure. See areas indicated on the accompanying diagram.

Reason For Release:

Same.

Action To Be Taken:

Magnetic particle testing by a certified NDT technician

Detail Of Issue:

If cracks have been detected in the above mentioned welds and confirmed, please contact Zamperla Inc. for Notification of repair procedure.

Future Action To Be Taken:

Magnetic particle testing by a certified NDT technician annually.

ZAMPERLA INC.
49 Fanny Road
Parsippany, New Jersey 07054-0598
USA
Phone: 973 334 8133 Fax: 973 334 6880

Bulletin No: 97 SA2
Release Date: 12/8/97
Effective Date: 12/8/97
Supersedes: 97 SA1
Completion Date: Before riding passengers
Page: 1 of 2

SERVICE BULLETIN

Ride Manufacturer: Zamperla Inc.	Affected Production Dates: All
Ride Name: Samba	Affected Serial Nos.: All
Model Number: Samba	

Abstract Of Issue:

Cracks have been found in the welds located at the center column base plate junction and in the lower center frame structure. See areas indicated on the accompanying diagram.

Reason For Release:

Same.

Action To Be Taken:

Magnetic particle testing by a certified NDT technician

Detail Of Issue:

If cracks have been detected in the above mentioned welds and confirmed, please contact Zamperla Inc. for Notification of repair procedure.

Future Action To Be Taken:

Magnetic particle testing by a certified NDT technician annually.

~~Superseded by 48-561~~

ZAMPERLA INC.
49 Fanny Road
Parsippany, New Jersey 07054-0598
USA
Phone: 973 334 8133 Fax: 973 334 8880

Bulletin No: 97 SB1
Release Date: 12/8/97
Effective Date: 12/8/97
Supersedes:
Completion Date: Before riding passengers
Page: 1 of 2

SERVICE BULLETIN

Ride Manufacturer: Zamperla Inc.

Affected Production Dates: All

Ride Name: Samba Balloon

Affected Serial Nos.: All

Model Number: Samba Balloon

Abstract Of Issue:

Cracks have been found in the welds located at the center column base plate junction and in the lower center frame structure. See areas indicated on the accompanying diagram.

Reason For Release:

Same.

Action To Be Taken:

Magnetic particle testing by a certified NDT technician

Detail Of Issue:

If cracks have been detected in the above mentioned welds and confirmed, please contact Zamperla Inc. for Notification of repair procedure.

Future Action To Be Taken:

Magnetic particle testing by a certified NDT technician annually.

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MAR 30 1998

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CARNIVAL & AMUSEMENT RIDE
INSPECTION DIVISION

TAE.
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ed.

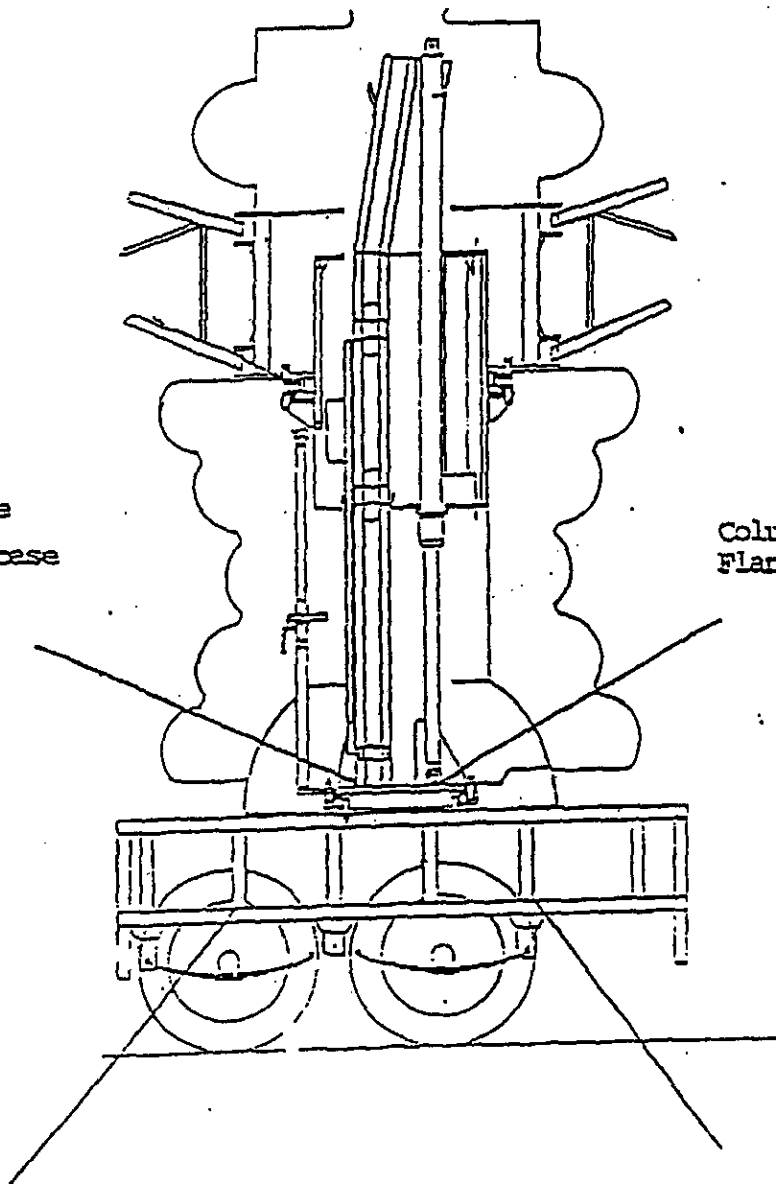
ASSIEME
ASSEMBLY



Page 2 of 2

Inspect the column Flange
joint welds here at the base

Column joint
Flange welds



Inspect the lower frame welds here

LOWER FRAMES WELDS

ZAMPERLA INC.
49 Fanny Road
Parsippany, New Jersey 07054-0598
USA
Phone: 973 334 8133 Fax: 973 334 6880

Bulletin No: 98 SA1
Release Date: 3/20/98
Effective Date: 3/20/98
Supersedes: 97 SA2
Completion Date: As soon as possible
Page: 1 of 3

SERVICE BULLETIN

Ride Manufacturer: Zamperla Inc.	Affected Production Dates: All
Ride Name: Samba	Affected Serial Nos.: All
Model Number: Samba	

Abstract Of Issue:

Cracks have been found in the welds located at the center column base plate junction and in the lower center frame structure.

Reason For Release:

This reinforcement kit when installed properly will strengthen the center column base plate junction and the lower center frame structure.

Action To Be Taken:

Examine the accompanying drawings and have a certified welder install the components of the column and frame reinforcement kit.

Detail Of Issue:

The reinforcement kit contains three drawings, one for the column base plate junction and two for the lower frame structure. The kit also contains the necessary metal components to complete this task.

Future Action To Be Taken:

None

ZAMPERLA INC.
49 Fanny Road
Parsippany, New Jersey 07054-0598
USA
Phone: 973 334 8133 Fax: 973 334 6880

Bulletin No: 98 SB1
Release Date: 3/20/98
Effective Date: 3/20/98
Supersedes: 97 SB2
Completion Date: Before landing passengers
Page: 1 of 3

SERVICE BULLETIN

Ride Manufacturer: Zamperla Inc.	Affected Production Dates: All
Ride Name: Samba Balloon	Affected Serial Nos.: All
Model Number: Samba Balloon	

Abstract Of Issue:

Cracks have been found in the welds located at the center column base plate junction and in the lower center frame structure.

Reason For Release:

This reinforcement kit when installed properly will strengthen the center column base plate junction and the lower center frame structure.

Action To Be Taken:

Examine the accompanying drawings and have a certified welder install the components of the column and frame reinforcement kit.

Detail Of Issue:

The reinforcement kit contains two drawings, one for the column base plate junction and one for the lower frame structure. The kit also contains the necessary metal components to complete this task.

Future Action To Be Taken:

None

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JAN 20 1996

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CARNIVAL & AMUSEMENT RIDE
INSPECTION DIVISION

Samba Balloon Reinforcement Kit

The Samba Balloon Reinforcement Kit was designed to reinforce the Samba Balloon ride frame components. The kit consists of two parts.

Part one:

The first part of the kit provides for reinforcement of the center-rotating column. The column is already supported with gussets. The kit adds thickness to the metal surface by the addition of metal plates. Additional gussets are added to increase the strength of the thicker metal plates.

Part two:

The second part of the kit provides for stabilizing the lower center frame. The kit adds four additional feet to the center frame area. The feet are located in line with main frame members, which stabilize the center frame to the ground. This prevents flexing in the center frame, which will prevent cracks in the lower frame from developing.

After completion of the above modifications by a certified welder, there is no need to NDT the ride on an annual basis. There is always a need to visually examine the ride components following a routine inspection process.

ZAMPERLA INC. 49 Fanny Road Parsippany, New Jersey 07054-6545 USA Phone: 973 334 8133 Fax: 973 334 6880	Bulletin No: 2001 SB1
	Release Date: 05/11/2001
	Effective Date: 05/11/2001
	Supersedes:
	Completion Date: As soon as possible
Page: 1 of 4	

SERVICE BULLETIN

Ride Manufacturer: Zamperla Inc.	Affected Production Dates: N/A
Ride Name: Samba Balloon	Affected Serial Nos.: SB08F302US97, SB08F316US98, SB08F257US95, SB08F121US96, SB08F321US98, SB08F365US98
Model Number: Samba Balloon	
Abstract Of Issue: <p style="text-align: center;">There is a possibility for weld cracks in the upper themeing centerpiece steel structure.</p>	
Reason For Release: <p style="text-align: center;">Cracks have been found on some upper themeing centerpiece steel structures.</p>	
Action To Be Taken: <p style="text-align: center;">Perform a close visual inspection of the steel structure of the upper centerpiece. If cracks are present, weld reinforcements (gussets and/or inserts) in the areas indicated in the following diagram. Use welding procedure AZ-9602 (attached).</p>	
Detail Of Issue: <p style="text-align: center;">Drawing 9CDC001542A (attached).</p>	
Future Action To Be Taken: <p style="text-align: center;">None</p>	

Inspect the column flange
joint welds here at the base

Column joint
flange welds

Inspect the lower frame welds here

LOWER FRAME WELDS

