



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:	B408R1203-A
Release Date:	December 8, 1999
Effective Date:	December 8, 1999
Supersedes:	B408R1203-0
Completion Date:	January 8, 2000
Page:	1 of 6

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.	Affected Production Dates: 1/31/96 through 8/1/98	
Ride Name: CHAOS	Affected Serial Nos.: 408-00196 through 408-02097 and 408-02297 through 408-03998	
Model No.: 408		
Abstract of Issue: Hub Gusset Kit		
Reason For Release: Chance Rides, Inc. has become aware that cracks can form in and around the gussets on the hub of the above noted CHAOS amusement rides.		
Action to be Taken: Chance Rides, Inc. requires all owner/operators to perform the following inspection and to order and install kit number K408R1203-0. This kit includes all of the parts needed to rework one ride. Kit K408R1203-0. is offered at no charge if ordered within 60 days of the issue date of this bulletin. Kit number K408R1203-0 contains the following:		
<u>Part Number</u>	<u>Component</u>	<u>Quantity</u>
K408R1203-2	GUSSET WELDMENT	7
60849700	HEX HEAD CAPSCREW (1/2-13 x 2-1/4" Grade 8)	14
<i>NOTE: If the main bearing has been replaced, 1/2-13 x 3-1/4" Grade 8 capscrews (part number 60850600) may be required. See details in this bulletin.</i>		

Detail of Issue:
 All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation.

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.



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: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

Page: 5 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

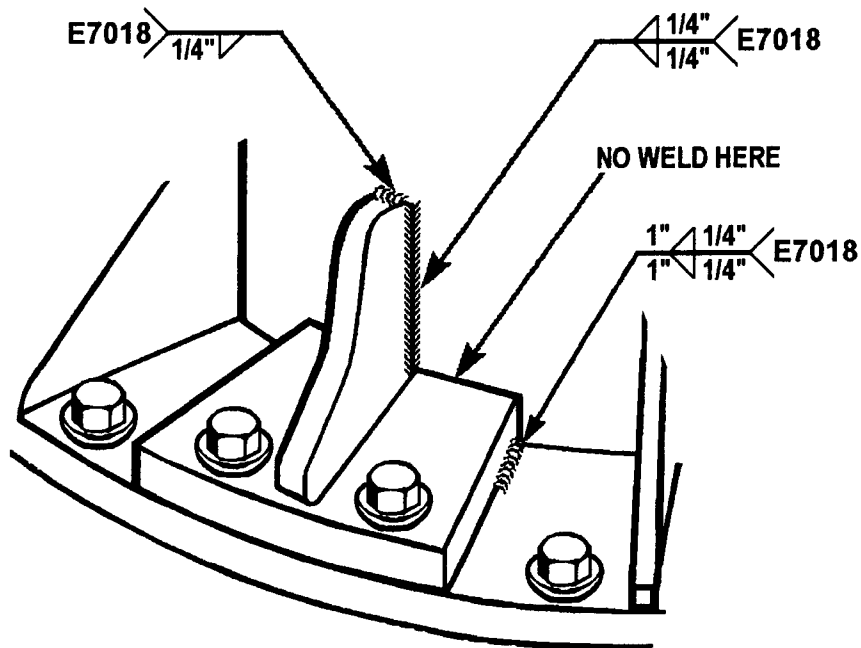
Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-02097 and
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

5. Weld the gussets in place using E-7018 welding rod. Weld only in the areas shown below.



6. Material surface to be welded must be above 70° F before welding. To avoid heat distortion of the hub, welds must be performed in the sequence shown on the following page.

NOTE: All welding must be done by a certified welder, following the sequence and procedure as outlined in this bulletin.



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: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

Page: 4 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

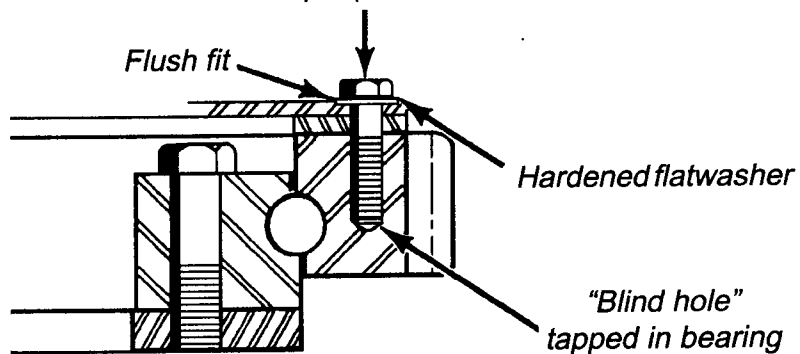
Affected Serial Nos.: 408-00196 through 408-02097 and
408-02297 through 408-03998

Model No.: 408

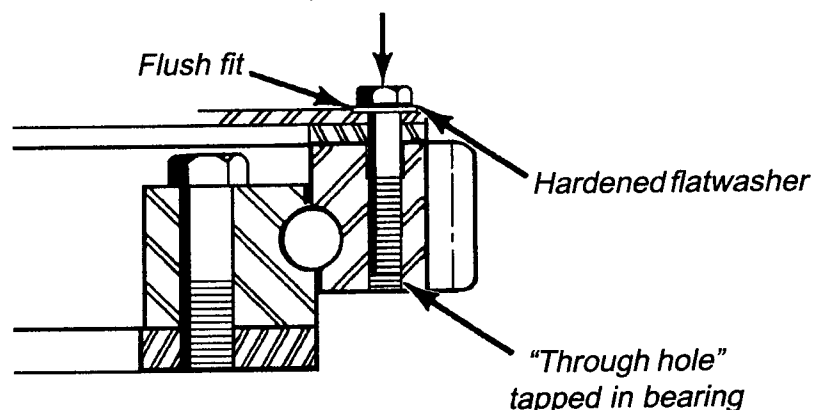
Detail of Issue (continued):

IMPORTANT: *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 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 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: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

Page: 3 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-02097 and
408-02297 through 408-03998

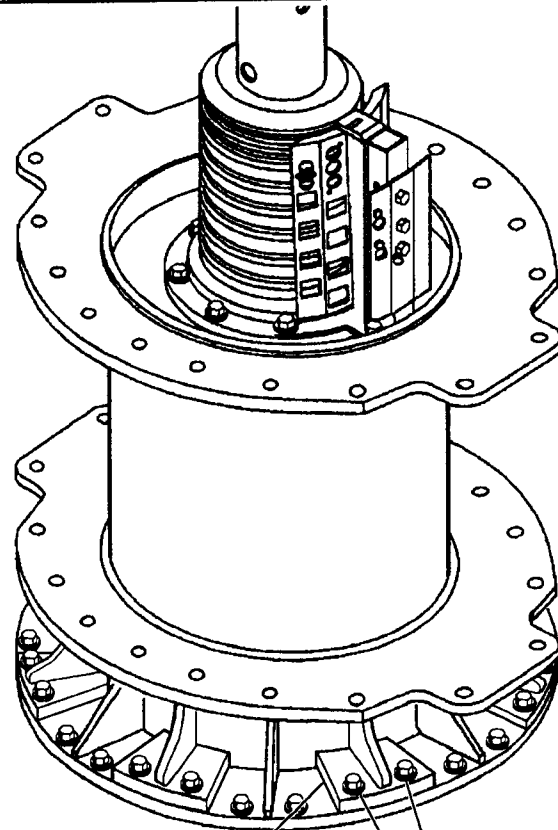
Model No.: 408

Detail of Issue (continued):

INSTALLATION INSTRUCTIONS -

Kit Number K408R1203-1

1. Remove and discard the two center hex head capscrew between two of the existing gussets. Retain the existing hardened washers which will be reused during installation of the new gusset weldments.
2. Clean the threaded holes of the bearing where the capscrews were removed.
3. Position one of the new gusset weldments in place. Using the existing hardened washers and the new 1/2-13 x 2-1/4" hex head capscrews, secure the gusset weldment in place. Apply Loctite® 271 (red) to the capscrew threads before installation. Using a torque wrench, tighten these capscrews to 90 ft-lbs.
4. Repeat Steps 1 and 2 above until all gusset weldments have been installed.



Gusset Weldment

1/2-13 x 2-1/4" hex head capscrews
- or -

1/2-13 x 3-1/4" hex head capscrews
(see detail on following page)

Use existing hardened washers.

Apply Loctite® 271 (red) and tighten to 90 ft-lbs.



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: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

Page: 2 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

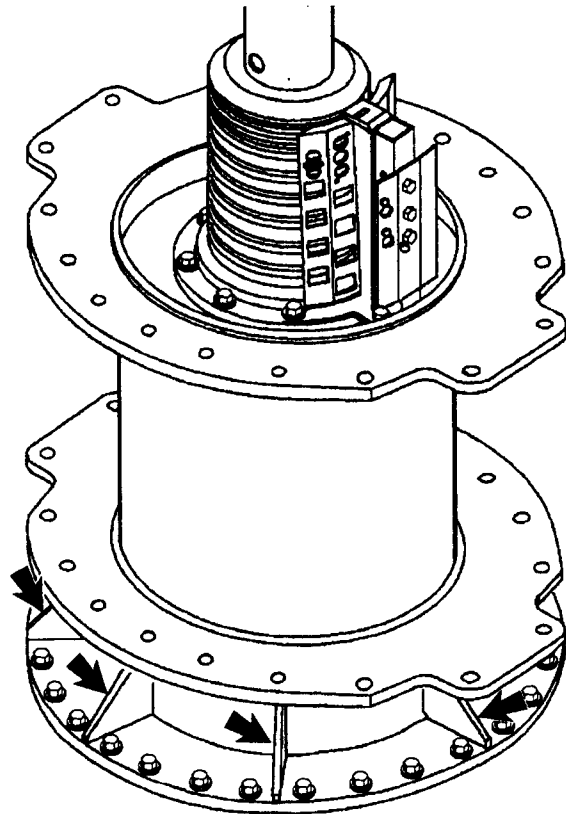
Affected Serial Nos.: 408-00196 through 408-02097 and
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

INSPECTION PROCEDURE

1. Visually inspect the seven existing gussets and the weld area around each gusset as shown.
2. If any cracks are found, contact Chance Rides, Inc. Customer Service Department for a repair procedure. If no cracks are found, install Kit number K408R1203-0.





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: B408R1203-A

Release Date: December 8, 1999

Effective Date: December 8, 1999

Supersedes: B408R1203-0

Completion Date: January 8, 2000

Page: 6 of 6

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: 1/31/96 through 8/1/98

Ride Name: CHAOS

Affected Serial Nos.: 408-00196 through 408-02097 and
408-02297 through 408-03998

Model No.: 408

Detail of Issue (continued):

Weld Sequence

