



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B400CRM136-0
Release Date: May 13, 2005
Effective Date: May 13, 2005
Supersedes: B400R1058-0
(issued 2/16/90 by Chance Rides, Inc.)
Completion Date: See Text
Page: 1 of 4

SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES MANUFACTURING, INC.
CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: GIANT GONDOLA WHEEL Affected Serial Nos.: All

Model No.: 400

Abstract of Issue:
Axle Hub Fastener Inspection

Reason For Release:
The fasteners which secure the axle to the hub on the GIANT GONDOLA WHEEL must be installed and tightened correctly to prevent the capscrews from becoming loose. The specific length of capscrews and other components depends upon several variables, and must be determined for each specific ride. This bulletin summarizes the various configurations and the parts required for each.

Action to be Taken:
Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted GIANT GONDOLA WHEEL amusement rides to inspect the axle hub fasteners and related parts as shown on the following pages of this bulletin.

The inspection must be completed immediately upon receipt of this bulletin. Thereafter, check the axle hub capscrews for proper torque at every set-up or once each operating season, whichever occurs first.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. Use only those components authorized, specified or provided by Chance Rides Manufacturing, Inc. All applicable OSHA safety standards and safe industry practices must be observed.

Observe all safety information contained in the manufacturer's manuals. Make available this bulletin and all related technical information to personnel using the equipment.

Chance Rides Manufacturing, Inc. issues notifications for the benefit of owners of amusement rides manufactured by Chance Rides Manufacturing, Inc. As a service to the industry, and in the interest of employee and public safety, Chance Rides Manufacturing, Inc. also issues notifications for the benefit of owners of amusement ride equipment for which the manufacturer no longer exists, such as the Allan Herschell Company, Chance Manufacturing Co., Inc., Chance Rides, Inc., etc. In doing so, Chance Rides Manufacturing, Inc. does not assume liability for losses associated with amusement ride equipment built by manufacturers other than Chance Rides Manufacturing, Inc.



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B400CRM136-0
Release Date: May 13, 2005
Effective Date: May 13, 2005
Supersedes: B400R1058-0
(issued 2/16/90 by Chance Rides, Inc.)
Completion Date: See Text
Page: 2 of 4

Ride Manufacturer: CHANCE RIDES MANUFACTURING, INC.
CHANCE RIDES, INC.

Affected Production Dates: All

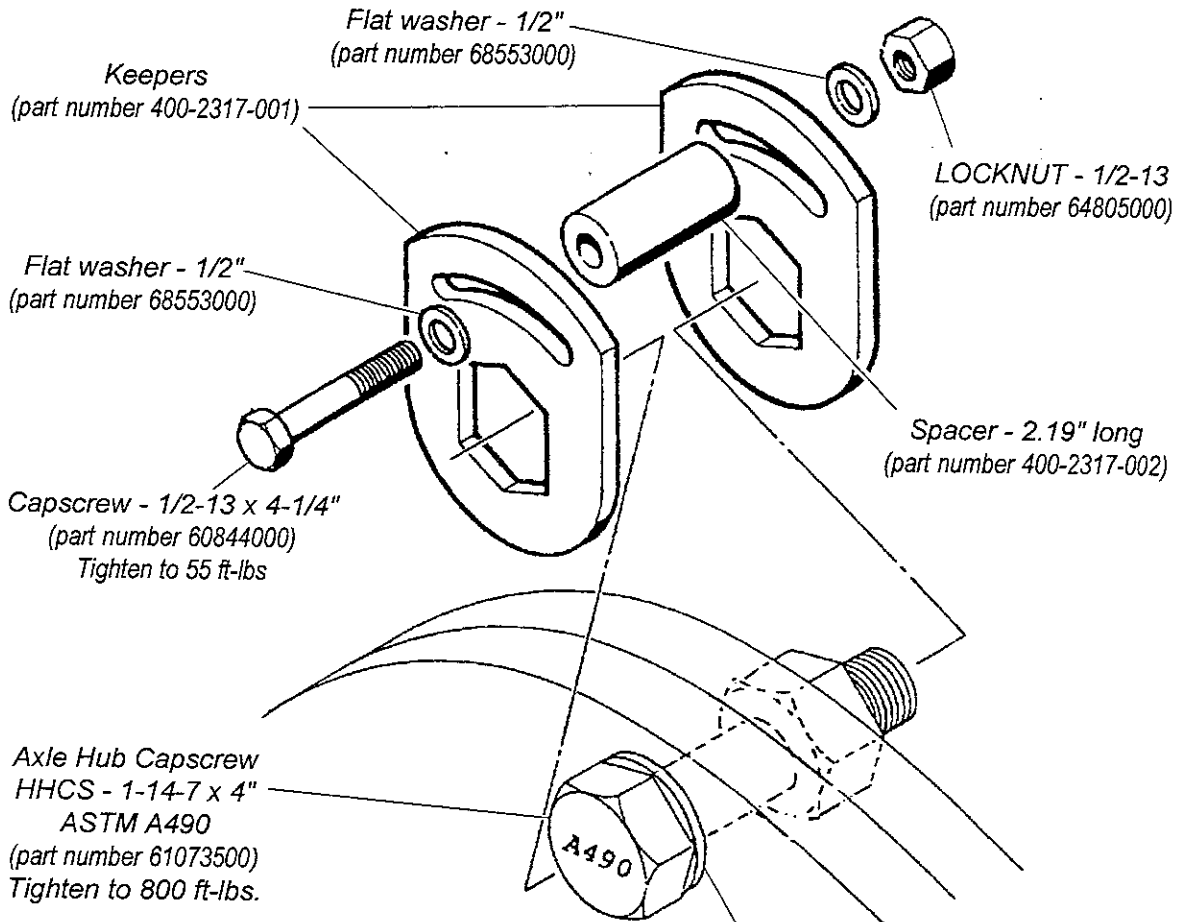
Ride Name: GIANT GONDOLA WHEEL

Affected Serial Nos.: All

Model No.: 400

Detail of Issue (continued):

Axle Hub Fasteners Original Production Configuration up to Ride Serial Number 400-04302



NOTE: Some rides have six (6) capscrews in each flange. All other rides have ten (10) capscrews in each flange.

Hardened Flat washer- 1-1/4 ASTM A325
(part number 6685570)
Install under capscrew head only



CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

Bulletin No: B400CRM136-0
Release Date: May 13, 2005
Effective Date: May 13, 2005
Supersedes: B400R1058-0
(issued 2/16/90 by Chance Rides, Inc.)
Completion Date: See Text
Page: 3 of 4

Ride Manufacturer: CHANCE RIDES MANUFACTURING, INC.
CHANCE RIDES, INC.

Affected Production Dates: All

Ride Name: GIANT GONDOLA WHEEL

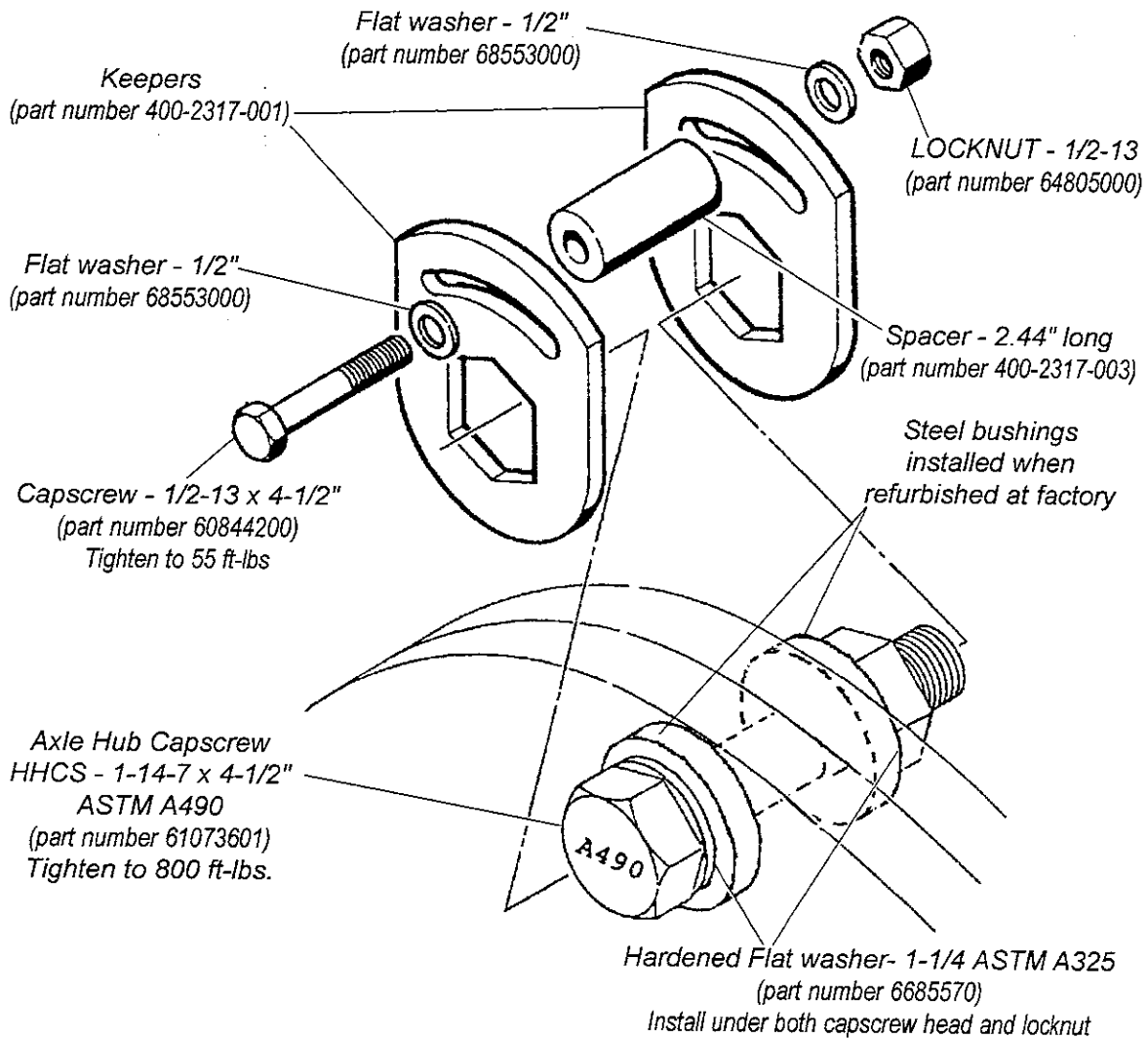
Affected Serial Nos.: All

Model No.: 400

Detail of Issue (continued):

Axle Hub Fasteners

Ride Serial Number 400-04302 and on, and All Rides With Factory Refurbished Hub





CHANCE RIDES MANUFACTURING, INC.
4200 Walker
Wichita, KS 67277-2328
U.S.A.
Phone: 1-316-942-7411 • FAX: 1-316-942-2012
Website: www.rides.com
E-mail: rides@rides.com

| | |
|------------------|---|
| Bulletin No: | B400CRM136-0 |
| Release Date: | May 13, 2005 |
| Effective Date: | May 13, 2005 |
| Supersedes: | B400R1058-0 (issued 2/16/90 by Chance Rides, Inc.) |
| Completion Date: | See Text |
| Page: | 4 of 4 |

Ride Manufacturer: CHANCE RIDES MANUFACTURING, INC.
CHANCE RIDES, INC. Affected Production Dates: All

Ride Name: GIANT GONDOLA WHEEL Affected Serial Nos.: All

Model No.: 400

Detail of Issue (continued):

Axle Hub Capscrew Torque Check Procedure

IMPORTANT: Before proceeding, check ALL COMPONENTS to make sure that the correct parts are installed for the specific ride configuration as shown on the previous pages of this bulletin. This includes, but is not limited to the following:

- Check the length and grade of axle hub capscrews
- Check for hardened flat washers installed in the locations shown for each specific configuration.
- Check the length of the spacers

1. Loosen the capscrews securing the keepers and remove the keepers.
2. Check each axle hub capscrew for 800 ft-lbs, using a torque wrench on the head of the capscrew.

IMPORTANT: Check that there are 2 to 4 capscrew threads showing beyond the locknut. This is a visual indication that the correct length of axle hub capscrew is installed.

3. Place one keeper over the axle hub capscrew head and one keeper over the nut.
4. Insert the 1/2" capscrew through the slot in the keeper, through the spacer and through the other keeper. Make sure flat washers are installed as shown in the illustration.
5. Secure the capscrew with a 1/2" locknut. Use a torque wrench to tighten the nut to 55 ft-lbs.
6. Install the remaining keepers on both sides of the axle in the same manner.

Check the axle hub capscrews for proper torque at every set-up or once each operating season, whichever occurs first.