



NUMBER: B400R1175-0

DATE: May 17, 1996

SUPERSEDES:

SERVICE BULLETIN

Effective Serial Number: All Portable Units

Ride: GIANT GONDOLA WHEEL Subject: Bolting Flange
Annual Inspection

Chance Rides, Inc. has become aware of at least one case on a GIANT GONDOLA WHEEL amusement ride in which the weld around the bolting flange to the torque tube or the bearing housing has cracked. In this case, an inspection revealed evidence that the capscrews securing the torque tube to the bearing housing had not been properly tightened. Failure to properly tighten these capscrews could result in serious personal injury to the operators, passengers, and bystanders, as well as structural damage to the ride. At each set-up, the capscrews in these bolting flanges must be torqued to between 700 and 850 foot pounds, using a properly calibrated torque wrench, refer to Chance Service Bulletin numbers B400R1036A and B400R1058-0.

All owner/operators of the above noted amusement rides are required to inspect the bolting flanges annually using magnetic particle inspection as described in this bulletin. All inspections must be performed by a Level II or III person who is certified in magnetic particle inspection.

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.

The following magnetic particle inspection technique meets the requirements of ASTM E709.

1. PRE-CLEAN:
 - * Clean the weld area around the inside and outside of the bolting flanges on the torque tube and the bearing housing (8 places). This cleaning is to remove rust, paint or other contaminants.
2. MAGNETIZATION PROCESS:
 - * Using an A.C. yoke with articulating legs, position yoke over weld so flux field is 90 degrees to the weld,
 - * Use continuous method for applying particles and current.
3. INSPECTION:
 - * Thoroughly inspect all weld areas for linear indications.
 - * If any linear indications are found, do not operate the ride; contact the Chance Rides, Inc. Customer Service Department at 1-800-242-6231.
4. POST-CLEAN:
 - * Remove magnetic particles from weld areas.

