



**CHANCE RIDES MANUFACTURING, INC.**  
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Bulletin No: B414CRM131-0  
Release Date: July 30, 2004  
Effective Date: July 30, 2004  
Supersedes: N/A  
Completion Date: N/A  
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# SERVICE BULLETIN

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

Ride Name: INVERTER (Portable Model) Affected Serial Nos.: All

Model No.: 414

Abstract of Issue:  
Inspection of Main Bearing Capscrews

**Reason For Release:**

Chance Rides Manufacturing, Inc. has become aware of broken and/or loose capscrews which attach the main bearing on at least one portable model INVERTER ride. These capscrews secure the bearing to both the tower structure and the main arm, and must be kept properly tightened and in good condition. The capscrews are tightened to a torque of 160 ft.-lbs. at the factory, using LocTite® 271 (red) applied to the threads.

**Action to be Taken:**

All owner/operators of the above noted INVERTER amusement rides are required to inspect the capscrews for the main bearing using the procedure described on the following pages of this service bulletin. The inspection must be done immediately upon receipt of this bulletin, then annually thereafter.

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.

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Detail of Issue

### Main Bearing Capscrew Inspection Procedure

1. Locate the 40 capscrews which secure the main bearing to the arm. These capscrews are installed in through-holes in the outer bearing race and are secured by nuts on the outside of the flange as shown in the illustration.

**NOTE:** The heads of these capscrews are not accessible when the ride is assembled. Check the capscrews at the nuts, which are accessible from the back side of the flange.

2. Locate the 38 capscrews which secure the main bearing to the tower structure. These capscrews are installed into tapped holes in the inner bearing race.
3. Use a torque wrench to check all capscrews and nuts. SET THE TORQUE WRENCH TO ONLY 140 FT-LBS TO CHECK THE FASTENERS. This permits the fastener to be checked, but prevents damage to the LocTite.

**NOTE:** The space available to check some fasteners is limited. If necessary, use an extension, "crow's foot," or other adapter on the torque wrench to accurately check the tightness of the fastener.

*When using adapters or extensions, the torque wrench reading must be corrected as specified by the tool manufacturer.*

4. The fasteners must not turn when checked as instructed. If any fastener turns, it indicates a damaged or loose fastener. The fastener must be removed and replaced with a new part. Apply LocTite 271 (red) to the threads using the manufacturer's instructions. Tighten to the correct assembly torque of 160 ft-lbs.



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Detail of Issue (continued):

*Bearing inner race is attached to the tower structure by these capscrews (38 places)*

*Bearing outer race is attached to the main arm structure on this flange. Nuts are accessible from back side of the flange (40 places)*

