



CHANCE RIDES, INC.
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Bulletin No:	B414R1262-0
Release Date:	August 20, 2001
Effective Date:	August 20, 2001
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 Units

Model No.: 414

Abstract of Issue:
Counterweight Arm Fastener Inspection

Reason For Release:

The counterweight arm on the above noted INVERTER amusement rides is secured to the hub with six 1-1/4-7 x 7 ASTM A325 hex head capscrews, with hardened flat washers and ASTM A325 nuts. These fasteners must be checked daily with an accurate torque wrench to ensure they are properly tightened, as outlined in the *INVERTER Service Manual*.

An alternative fastener has been approved by Chance Rides, Inc., which permits the daily check to be performed without the use of a torque wrench.

Detail of Issue:

At the owner operator's option, a special fastener can be used in this location, along with the original hardened flat washer and ASTM A325 nut. The fastener is manufactured under the brand name of RotaBolt®. It is specially calibrated for this specific application, and features a control cap which rotates by hand if the fastener is not tightened to the correct specification. Once the correct tightness is obtained, the control cap cannot be rotated by hand.

If desired, order six RotaBolts (part number 20744100) and install as described in this bulletin. These specially calibrated fasteners can only be obtained from Chance Rides, Inc. RotaBolts are the only approved alternative to the 1-1/4-7 x 7 A325 capscrews shown in the service manual. **DO NOT SUBSTITUTE ANY OTHER FASTENERS FROM ANY OTHER SUPPLIER IN THIS LOCATION.**

Daily inspection of RotaBolts is required, the same as the standard ASTM A325 capscrews. The daily inspection procedure is provided in this bulletin. Annual replacement of RotaBolts is required, the same as all other frequently removed fasteners, per the *INVERTER Service Manual*.



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Action to be taken:

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.

RotaBolt® Installation Instructions

1. Inspect the condition of the lock plate. If damaged, replace it with a new part. Grind the welds to remove the old lock plate. To ensure correct alignment do not weld the replacement lock plate in place until the capscrews are installed.

***NOTE:** The lock plate on some rides was made of 10 gauge steel. The material on the replacement lock plate is 1/4" steel.*

2. Install RotaBolts in the six holes of the counterweight arm flange. The RotaBolts must be installed as shown, with the heads engaged in the hexagonal holes of the lock plate. Install the hardened flat washers and nuts.

***NOTE:** Either RotaBolts or the specified ASTM A325 capscrews are acceptable. However, all six fasteners must be the same. Do not mix different fasteners.*

3. Using an appropriate wrench, tighten the three nuts on one flange evenly until the control caps on the three RotaBolts cannot be turned by hand. **DO NOT OVER-TIGHTEN.** Repeat the process on the other flange. Do not use a torque wrench - damage to the torque wrench can result.

RotaBolt® Inspection

Inspect the RotaBolt daily by turning the control cap on each RotaBolt. If it turns by hand, tighten the nut until the control cap cannot be turned by hand. **DO NOT OVER-TIGHTEN.**



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Action to be taken (continued):

