



CHANCE
MANUFACTURING CO., INC.

Number: B61-0226-00

Date: 8-4-81

Supersedes:

America's Largest Manufacturer of Amusement Rides

Service Bulletin

Effective Serial Numbers: ALL RIDES

Ride: YO YO Subject: TILT CYLINDER EARS & STOPS

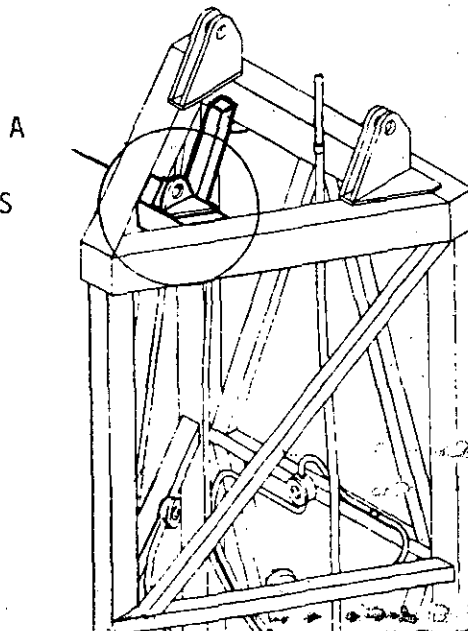
A condition has occurred on one ride in which the bottom ear fastening the tilt cylinder to the top of the tower, tore loose. We are requesting that all owners of Yo Yo's immediately inspect the weld and metal adjacent to the weld on the ear attached to the tower, (FIGURE A). The ear at the top of the cylinder attached to the tilt head, (FIGURE B). and the leveling stop tube where it attaches to the tower (FIGURE C), should also be checked.

These areas should be established as "Special Care Areas" and given regular weekly visual inspections by qualified individuals.

Please report the presence of cracks at areas "A", "B", or "C" immediately to Chance Manufacturing Co., Inc.

The attached Certification of Compliance must be completed and returned to Chance Mfg. within seven days of receipt of the bulletin.

INSPECT ALL WELDS
IN THIS AREA



Factory and General Office, 4219 Irving, P.O. Box 12328 Wichita, Ks

Sales Office:

1103 Ross Ave., Dallas, Texas 75202

Area Code (316) 942-7411

Area Code (214) 742-3802

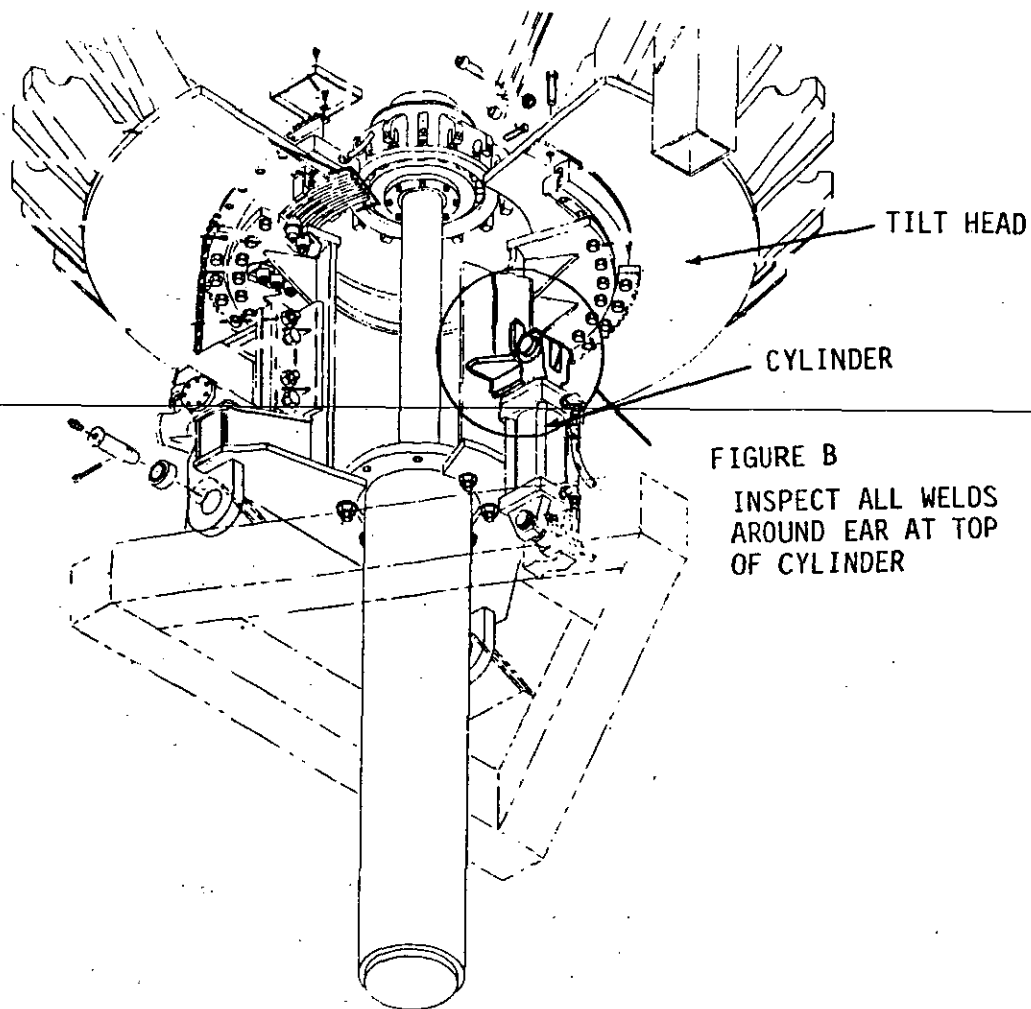


FIGURE B
INSPECT ALL WELDS
AROUND EAR AT TOP
OF CYLINDER

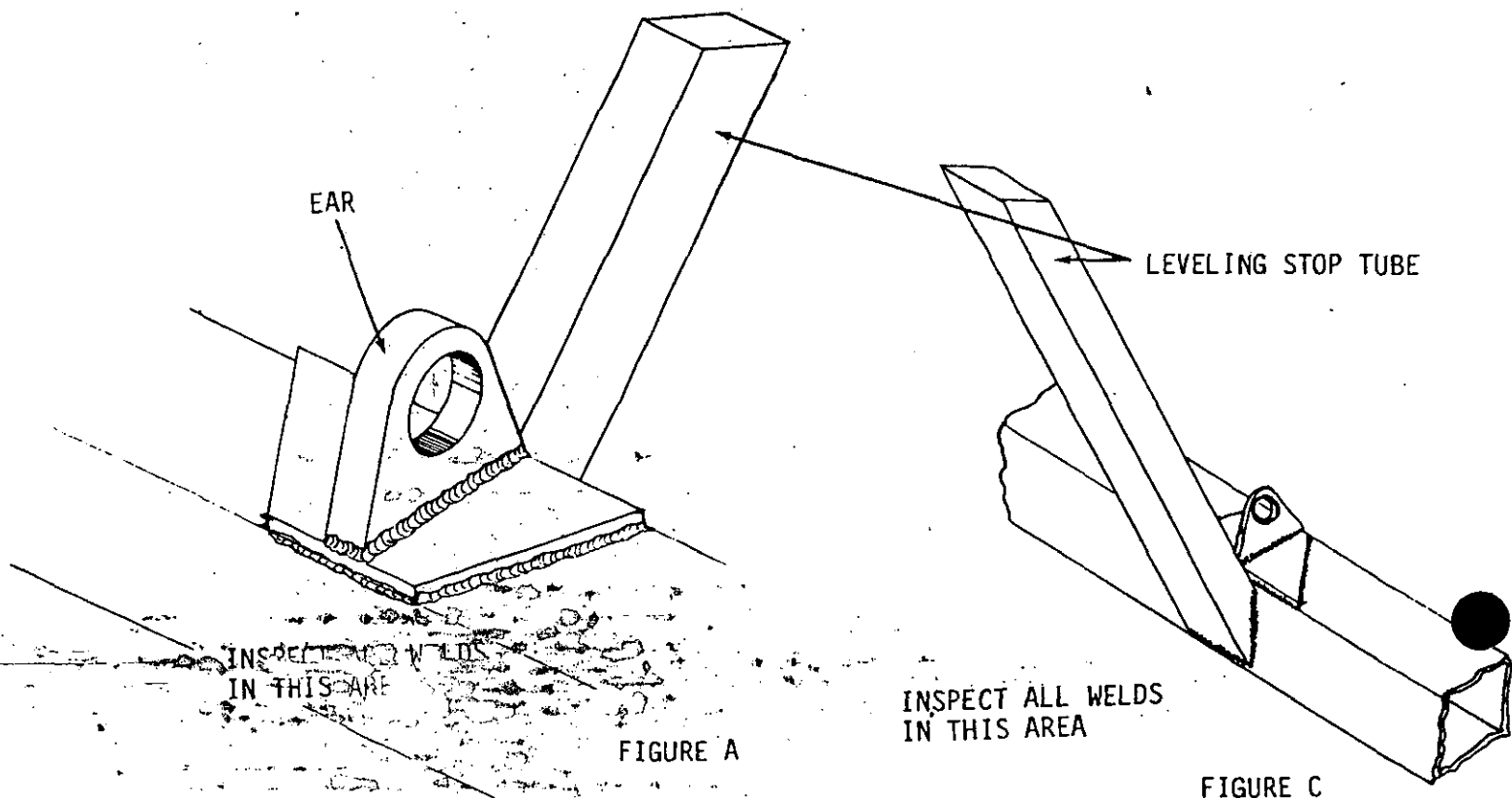


FIGURE A

FIGURE C

MAGNETIC PARTICLE INSPECTION OF ROD - Use longitudinal magnetization to detect circumferential cracking along full length of rod.

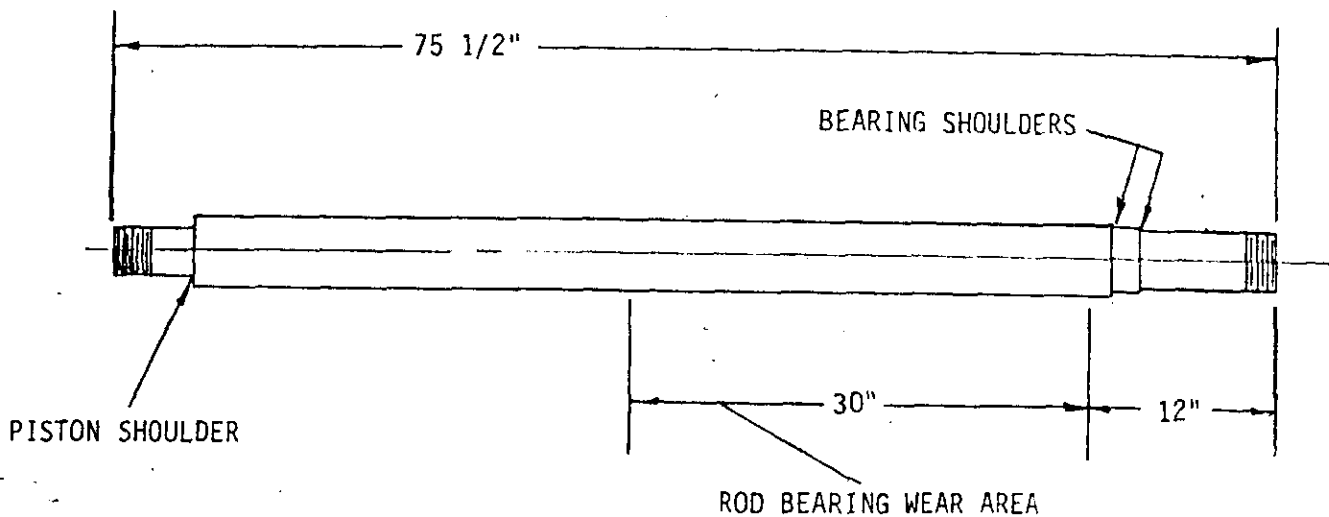
AREA	ACCEPT	REJECT
PISTON SHOULDER		
ROD BEARING WEAR AREA		
BEARING SHOULDERS		
OTHER AREAS		

CERTIFIED INSPECTION ORGANIZATION _____ DATE _____

SIGNATURE _____

ADDRESS _____ PHONE _____

NON-DESTRUCTIVE TEST OF ROD



ACCEPT

REJECT

SPIDER BEARINGS		
SPIDER BEARING SEALS		
PISTON		
PISTON WEAR RING		
PISTON CAST IRON RING		
ROD BEARING AS		
PISTON NUT		
SPIDER BEARING NUTS		
SPIDER BEARING TANG WASHER		
ROD EXTERNAL CONDITION		
TESTING AFTER RE-ASSEMBLY		
25-1/4 IN. MID STROKE		
52-3/8 IN. FULL STROKE		
RETRACTED - 3000 PSI ROD END PRESSURE		
MID POINT 3000 PSI PISTON END PRESSURE		
EXTENDED 3000 PSI PISTON END PRESSURE		

QUALIFIED INSPECTION ORGANIZATION _____ DATE _____

SIGNATURE _____

ADDRESS _____ PHONE _____