

**CHANCE RIDES, INC.**

4219 Irving
Wichita, KS 67277-2328
U.S.A.

Phone: 1-800-242-6231 • FAX: 1-316-942-7416

Website: www.rides.com

E-mail: rides@rides.com

Bulletin No: B414R1269-0

Release Date: February 12, 2002

Effective Date: February 12, 2002

Supersedes: N/A

Completion Date: See Text

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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.

Affected Production Dates: All Prior to 2002

Ride Name: INVERTER (Portable Model Only)

Affected Serial Nos.: 414-00199 through 414-03401

Model No.: 414

Abstract of Issue:

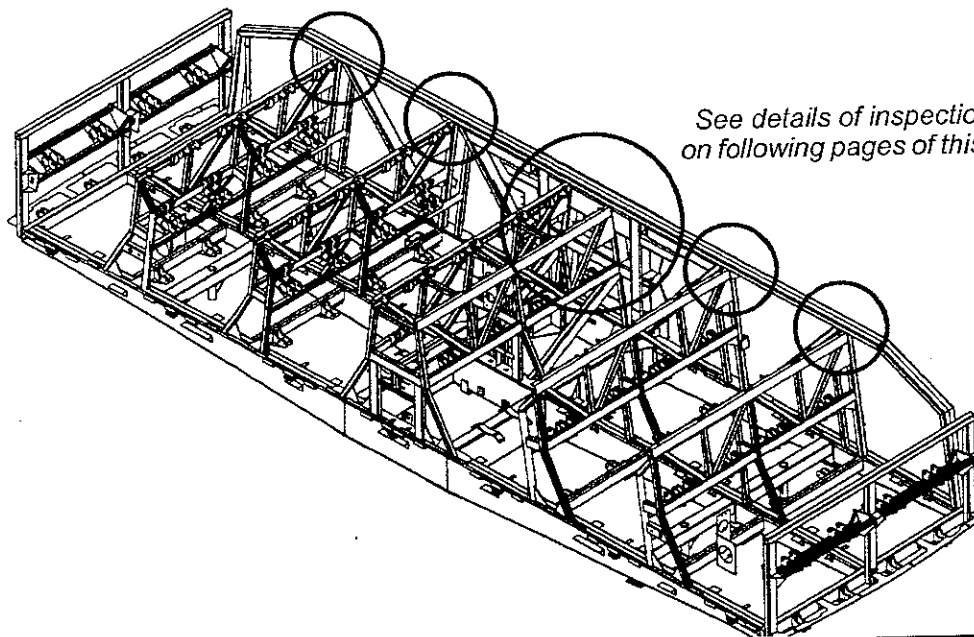
Vehicle Frame Inspection and Rework

Reason For Release:

Chance Rides, Inc. has become aware that cracks can form in certain areas of the vehicle frame on the above noted INVERTER amusement rides. A rework kit has been developed to reinforce these areas.

Action to be Taken:

Chance Rides, Inc. requires all owner/operators of these rides to immediately inspect the vehicle frame as described in this bulletin. Thereafter, perform the inspection monthly or at every set-up, whichever occurs first. The rework kit must be installed before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque.



*See details of inspection areas
on following pages of this bulletin.*

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Model No.: 414

Detail of Issue

Perform the inspection described on the following pages of this bulletin.

- **If any indications are found, DO NOT CONTINUE OPERATION OF THE RIDE.** Contact the Chance Customer Service Department immediately for instructions on further action to be taken.

DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE VEHICLE FRAME, EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES INC.

- **If no indications are found,** perform the inspection monthly or at every set-up, whichever occurs first, as described under "Monthly Inspection" in this bulletin. Order and install the Vehicle Frame Rework Kit, part number K414R1266-1 before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque. Detailed installation instructions are provided with the kit.

DO NOT INSTALL THE REWORK KIT IF THERE ARE CRACKS IN THE VEHICLE FRAME UNTIL REPAIRS SPECIFIED BY CHANCE RIDES, INC. ARE MADE.

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.

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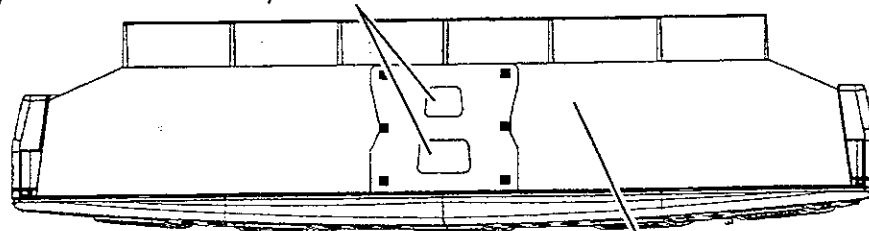
Model No.: 414

Detail of Issue (continued):

PREPARATION OF VEHICLE FOR INSPECTION

Inspection is performed with the vehicle in its rack on the trailer. Remove the center access panel at the back of the vehicle, and the two panels from the outside of the back wall of the vehicle.

These openings in the mounting plate provide access for inspection.



Remove center access panel

Remove both back panels

It is also necessary to enlarge the existing openings in the seats and aluminum panels along the inside of the back wall, as shown in the photos on the following pages. Use a die grinder or rotary trimming tool for this procedure.

IMPORTANT: When cutting the fiberglass seats and aluminum back wall panel, **BE EXTREMELY CAREFUL NOT TO CUT INTO THE STEEL VEHICLE FRAME MEMBERS.** This will severely weaken the frame and require extensive repair before the ride can be operated.

After trimming, remove all burrs or sharp edges from the cutout areas to prevent injury.

1. Raise the shoulder bar fully to gain access to the area to be trimmed.
2. Using a suitable cutting bit, enlarge the opening for the shoulder bar support nearest the back wall as shown in the first photo.
3. After the fiberglass has been trimmed, the aluminum panel will be visible. Trim the aluminum panel as shown in the second photo.

NOTE: Before trimming the aluminum panel, grind off the rivet head securing the end of the panel and pry the panel slightly away from the frame. This allows trimming without damaging the steel frame underneath.

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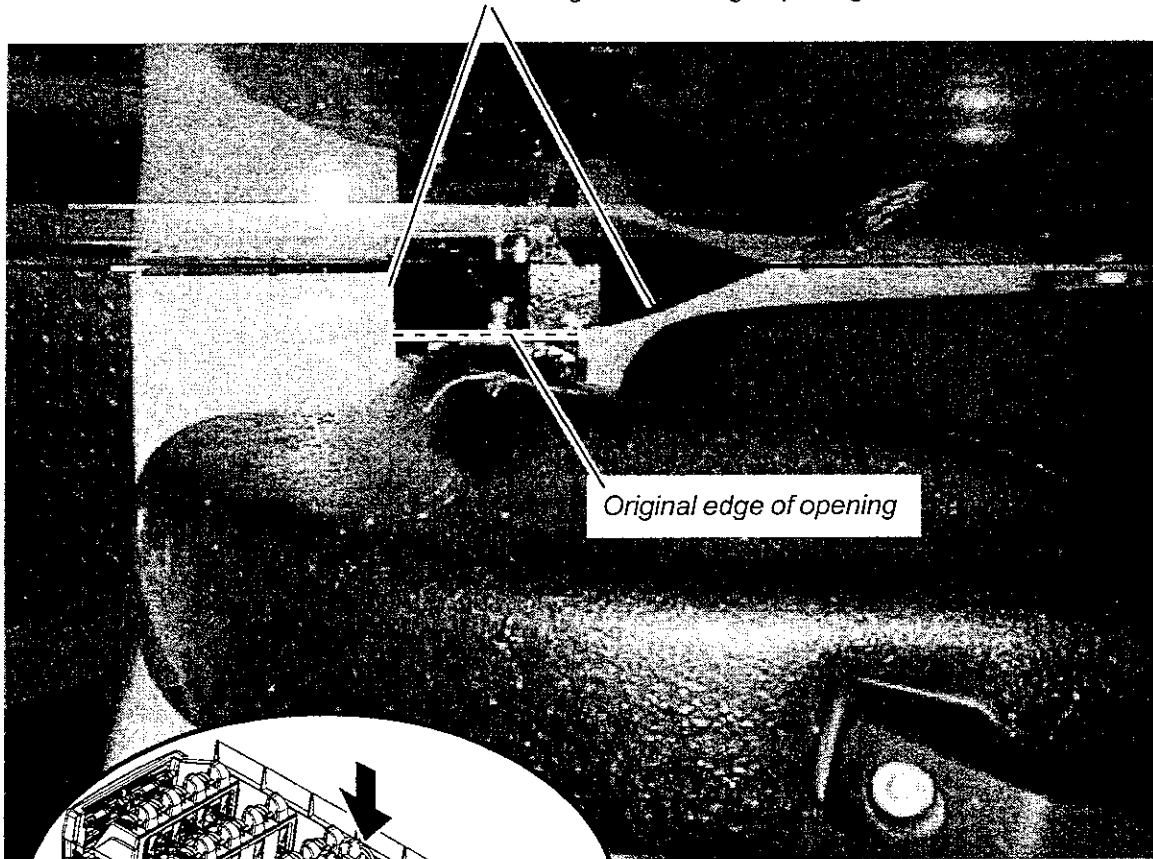
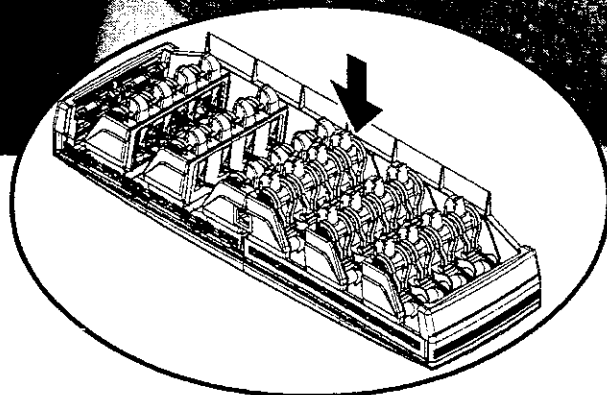
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Ride Name: INVERTER (Portable Model Only)

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Detail of issue (continued):

Cut fiberglass to enlarge opening*Original edge of opening***TOP VIEW OF SEAT AT BACK WALL**

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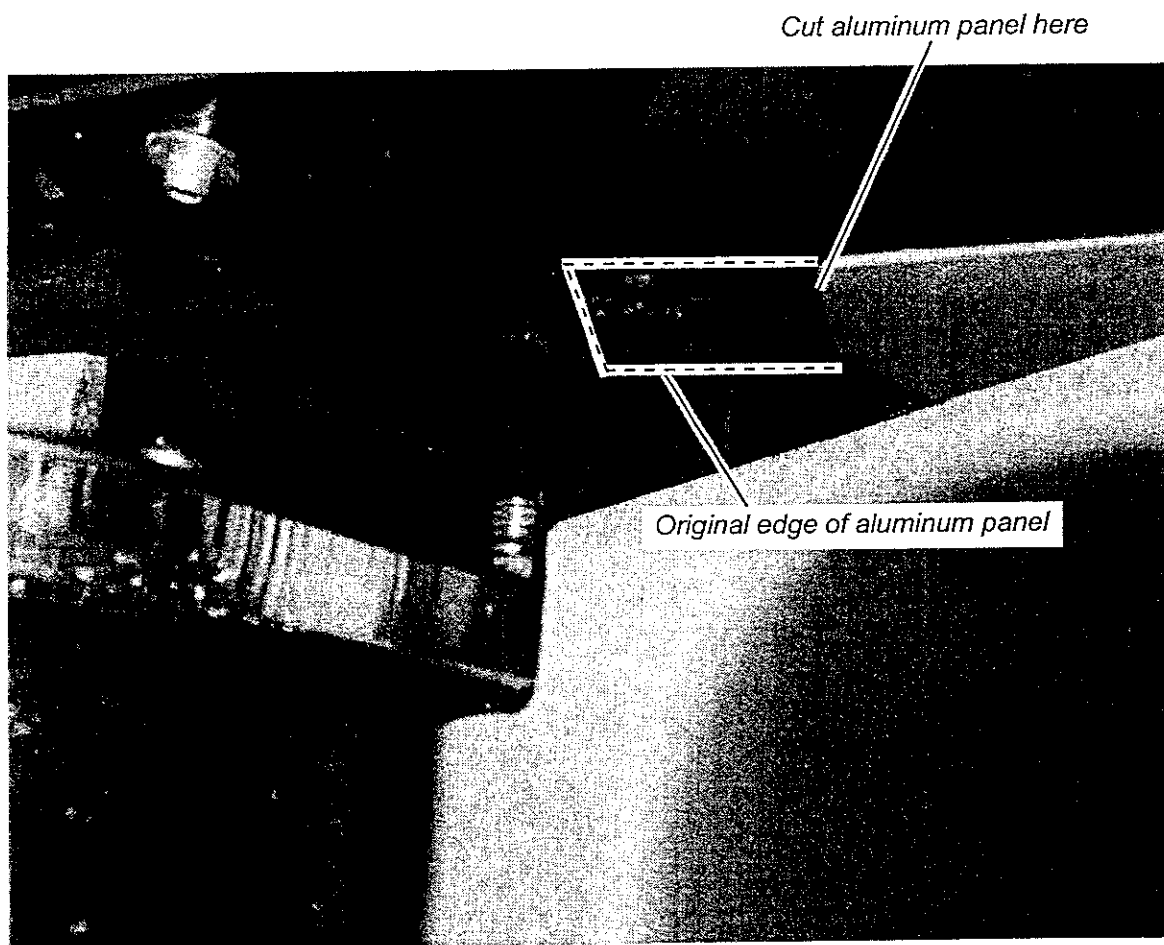
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Detail of Issue (continued):

**SAME AREA AFTER FIBERGLASS SEAT HAS BEEN TRIMMED**



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Model No.: 414

Detail of Issue (continued):

INSPECTION PROCEDURE

Visually inspect the vehicle frame structure in the areas indicated in the illustrations on the following pages.

1. In the center section of the vehicle frame, inspect the welded joints in the areas shown. Using an inspection mirror and light, thoroughly inspect all sides of each joint, looking for indications in the welds or the parent metal.
2. Inspect the cutouts in the channels in all six seats. Note whether the cutouts have round or square corners.

NOTE: The cutouts are visible through the existing openings in the fiberglass, so disassembly of the seats is not required. If necessary, enlarge the openings slightly to permit inspection of these areas. Be careful not to cut into the vehicle frame structure. Look for indications around the cutouts.

3. With the aid of an inspection mirror and light, thoroughly inspect the welded joints between the channel and the horizontal frame member at the four outer seats. Inspect all sides of each joint, looking for indications in the welds or the parent metal. Repeat the inspection on all four seats.

MONTHLY INSPECTION (or at every set-up, whichever occurs first)

Inspect the vehicle frame monthly, or at every set-up, whichever occurs first, until the Vehicle Frame Rework Kit is installed (see "Vehicle Frame Rework" in this bulletin). Use the same procedure as outlined in this bulletin. If any indications are found, contact the Chance Customer Service Department immediately.

DO NOT CONTINUE OPERATION OF THE RIDE.



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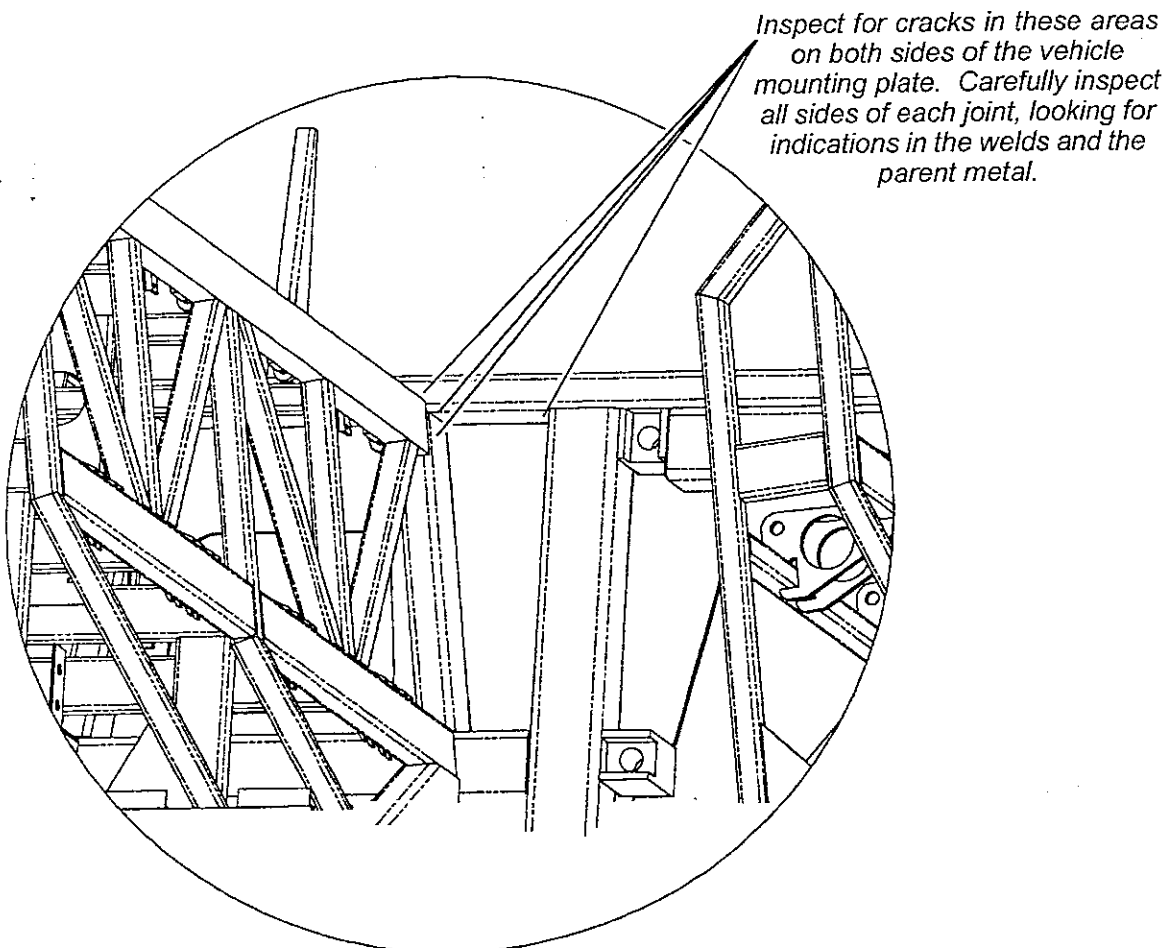
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Detail of Issue (continued):



NOTE: For clarity, fiberglass seats and back panel are not shown in some views.

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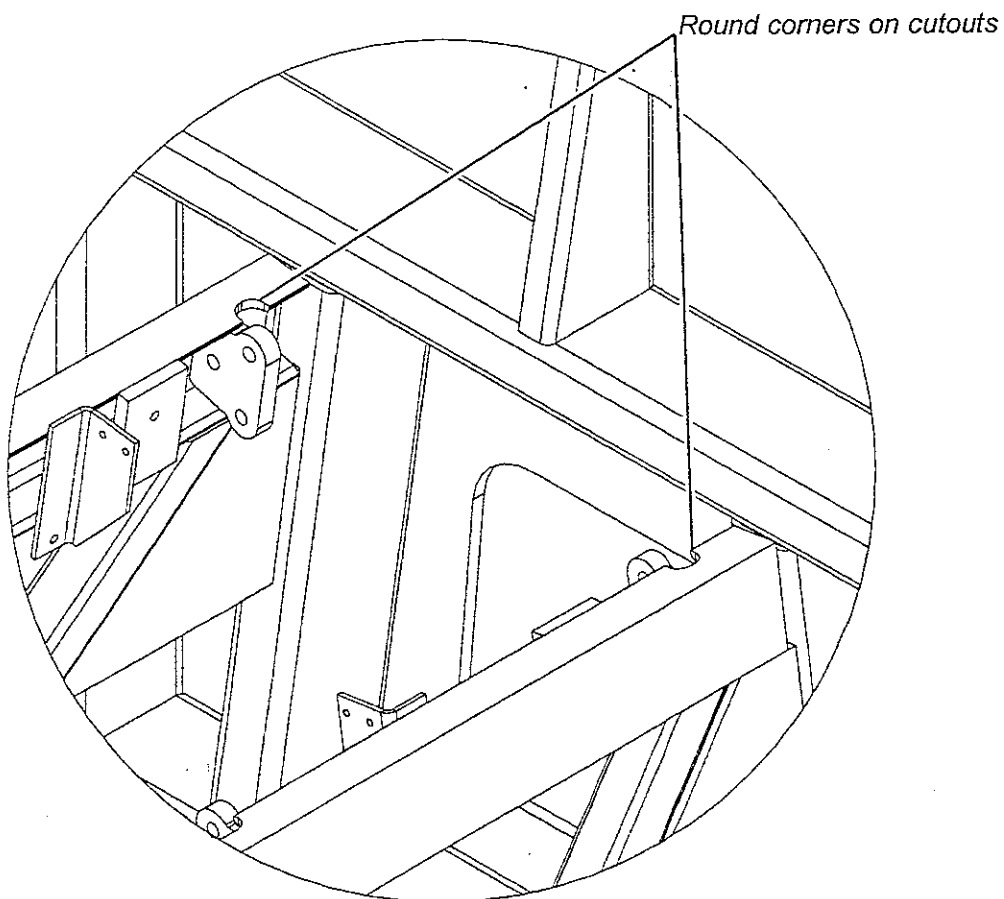
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Detail of Issue (continued):



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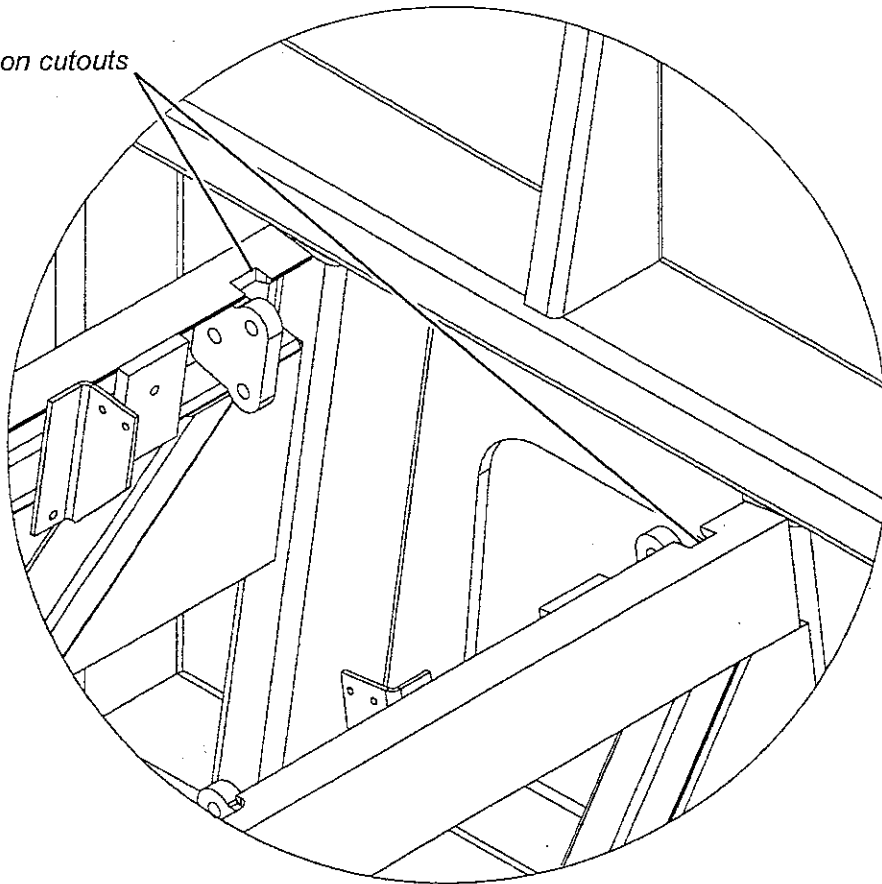
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Detail of Issue (continued):

Square corners on cutouts

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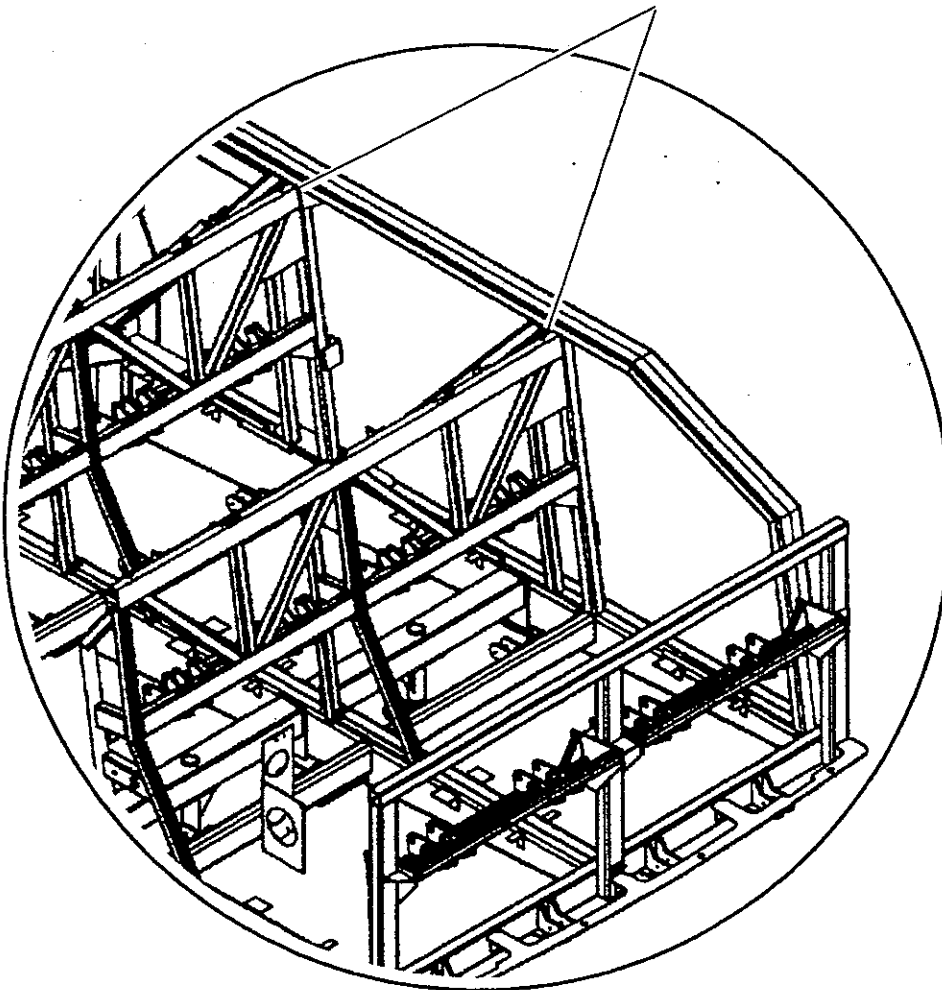
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Detail of Issue (continued):

*Inspect the welded joints on
these channels at both ends
of vehicle*



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Model No.: 414

Detail of Issue (continued):

VEHICLE FRAME REWORK

IMPORTANT: *The Vehicle Frame Rework Kit must be installed before the ride is four (4) years old, as determined by the "DATE OF MFG." on the ride information plaque. After the kit is installed, the ride must be inspected annually as described in "Annual Inspection".*

After inspection is complete, order and install the Vehicle Frame Rework Kit, part number K414R1266-1. The kit includes all necessary parts to rework one complete vehicle, and includes detailed installation instructions.

DO NOT INSTALL THE REWORK KIT IF THERE ARE CRACKS IN THE VEHICLE FRAME UNTIL REPAIRS SPECIFIED BY CHANCE RIDES, INC. ARE MADE.

ANNUAL INSPECTION

On rides with the Vehicle Frame Rework Kit is installed, inspect the vehicle annually, using the same procedure as outlined in this bulletin. If any indications are found, contact the Chance Customer Service Department immediately. **DO NOT CONTINUE OPERATION OF THE RIDE.**