



**CHANCE RIDES MANUFACTURING, INC.**  
**4200 Walker**  
**Wichita, KS 67277-2328**  
**U.S.A.**  
Phone: 1-316-942-7411 • FAX: 1-316-942-2012  
**Website: www.rides.com**  
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Bulletin No:	B391CRM166-0
Release Date:	October 23, 2009
Effective Date:	Immediately
Supersedes:	N/A
Completion Date:	See Text
Page:	1 of 3

# SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.  
CHANCE MANUFACTURING CO., INC.

Affected Production Dates: All

Ride Name: FALLING STAR (Park and Portable Models)

Affected Serial Nos.: All Units

Model No.: 391

Abstract of Issue:  
Vehicle Axle NDT and Replacement

Reason For Release:

Chance Rides Manufacturing, Inc. has become aware that cracks in the front and rear vehicle axles can occur after many years of operation. Failure of a vehicle axle could result in serious injury to passengers and/or bystanders.

Action to be Taken:

An accurate calculation of the total accumulated number of revolutions that the axles have experienced is necessary to determine what action must be taken.

Chance Rides Manufacturing, Inc. requires all owner/operators of the above noted FALLING STAR amusement rides to calculate the accumulated revolutions on the vehicle axles within 10 days of the issue date of this bulletin.

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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Affected Production Dates: All

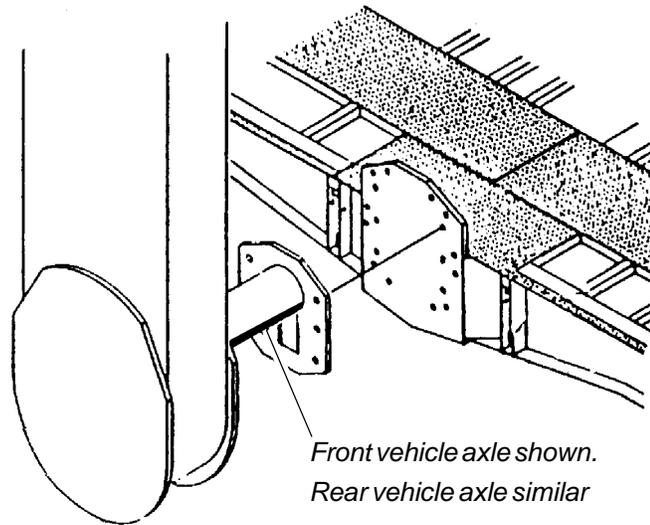
Ride Name: FALLING STAR

Affected Serial Nos.: All Units

Model No.: 391

Detail of Issue

An accurate calculation of the total accumulated axle revolutions is necessary to determine what action must be taken. A sample worksheet is provided on the following page of this bulletin.



**AXLES WITH LESS THAN 3 MILLION REVOLUTIONS MAY CONTINUE OPERATION** until a total of 3 million revolutions is reached. Revolution calculations must be maintained and updated **annually**. It is recommended that these calculations be readily accessible for reference at all times.

**AXLES WITH OVER 3 MILLION REVOLUTIONS MUST BE TAKEN OUT OF SERVICE IMMEDIATELY.** Before the ride can be returned to service, both axles must be removed from the ride for either NDT inspection or replacement with new parts, at the owner's discretion.

- If NDT is performed and no indications are found, the axles can be placed back into service for a period of no more than one year. The NDT inspection of both axles must be performed **annually**.
- If NDT is performed and indications are found, the axles must be replaced with new parts. **DO NOT ATTEMPT TO WELD OR OTHERWISE REPAIR THE VEHICLE AXLES.**
- If, for any reason, the axles are replaced with new parts, the ride can be operated for up to 3 million additional axle revolutions. No annual NDT is required during this period.



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Detail of Issue (continued):

**WORK SHEET EXAMPLE**

To determine the total accumulated revolutions experienced by the vehicle axles, the following factors must be known:

\_\_\_\_\_ YEARS  
 The number of years the ride has been in service

\_\_\_\_\_ DAYS  
 The number of days the ride was in operation each year

\_\_\_\_\_ HOURS  
 The number of hours the ride has been operated per day

\_\_\_\_\_ CYCLES  
 The number of ride cycles per hour

\_\_\_\_\_ REVOLUTIONS  
 The number of axle revolutions per ride cycle. Per factory program, 5 full axle revolutions on the short program, 10 full axle revolutions on the long program)

**IMPORTANT:** If ANY of the above factors is unknown, it should be assumed that the axles have over 3 million revolutions.

To determine total actual axle revolutions, multiply:

$$\frac{\text{YEARS}}{\text{YEARS}} \times \frac{\text{DAYS}}{\text{DAYS}} \times \frac{\text{HOURS}}{\text{HOURS}} \times \frac{\text{CYCLES}}{\text{CYCLES}} \times \frac{\text{REVOLUTIONS}}{\text{REVOLUTIONS}} = \text{TOTAL AXLE REVOLUTIONS}$$