



Florida Department of Agriculture & Consumer Services  
**BOB CRAWFORD**, Commissioner  
The Capitol • Tallahassee, FL 32399-0800

Please Respond To:  
Division of Standards  
Bureau of Fair Ride Inspection  
131 Administration Building  
3125 Conner Boulevard  
Tallahassee, FL 32399-1650  
1-800-HELP FLA  
Ph. (850) 488-9790, Fax (850) 488-9023

March 25, 1998

To all Himalaya Owners permitted during the last year.  
Addressed to each individually.

RE: Austin, TX, Himalaya Death of 3/19/98;

Preliminary reports on the above accident (copy attached) indicate, among other things, the passengers were "thrown out" and the lap bar on the car had broken away. The investigation into this tragedy is continuing. However, indications are that officials are focusing on broken and/or too small cotter keys, operating the ride after being told the lap bar was detached, and/or the possibility that the ride was operating too fast.

Because of this we want to reemphasize the manufacturer's position and requirements as it relates to Himalaya type rides operated in Florida (copy of 3/7/97 Reverchon memo attached).

1. Cotter keys, or diaper pins, of any type are unacceptable and shall not be used to secure the bottom of the lap bar.
2. "R" keys are required to secure the lap bar in place on both the right and left sides and the "R" keys must be of a sufficient size so that no movement or play occurs after they are inserted.
3. A block of wood shall be placed, and nailed down, near each "R" key to avoid patrons placing their feet on or near the keys and eliminate the possibility of the keys being removed.
4. "R" keys shall be tied off to eliminate them being inadvertently, or intentionally, pulled out.
5. Operator's should be instructed and cautioned; any car's lap bar that is found to not lock properly shall immediately cease being used until proper repairs can be made.
6. Rides shall not be operated in excess of the manufacturer's authorized or recommended speed under any circumstances.

If you have any questions in regard to this matter please do not hesitate to write or call.

Sincerely,

**BOB CRAWFORD**  
COMMISSIONER OF AGRICULTURE

Michael W. Rinehart  
Operations & Management Consultant  
(850) 413-7756

*98-12 Reverchon Himalaya*



**WISDOM  
INDUSTRIES, Ltd.**

# **SERVICE BULLETIN**

**DATE: NOVEMBER 12, 2000,**

**RIDE: HIMALAYA**

**SUBJECT: HIMALAYA SECONDARY SWEEP REINFORCEMENT**

**COMPLIANCE DATE: IMMEDIATE**

**COMPLETION DATE: INSPECTION IMMEDIATE**

**CRACK REPAIR IMMEDIATE**

**REINFORCEMENT- DEC. 1, 2000**

**INSTALLATION OF THIS BULLETIN PERTAINS TO THE 18  
SECONDARY SWEEPS ON THE ONE TRUCK HIMALAYA.**

## **INSPECT FOR CRACKS**

1. Inspect sweeps in the area of the airline hole next to the car.
2. Clean area on each secondary sweep where the airline exits the pipe (see drawing).
3. Visually inspect around the circumference of the pipe at the airline hole for cracks.
4. Follow the visual inspection with magnaflex or dye penetrant.
5. Repeat for the other 17 secondary sweeps.
6. Sweeps must be inspected daily until installation of reinforcement.

## **REINFORCEMENT**

1. Remove plastic airline from the pipe.

- ♦ NOTE: Attach a wire to the hose to pull it back into the hole. When finished with the reinforcement.

2. If a crack is found, "V" the cracked area of the pipe and weld back with 7018 rod.
3. Grind crack smooth or flush with top surface of pipe.

- ♦ NOTE: Do not gouge into the weld or tube when grinding weld.

4. Review the attached drawing and install 2 split halves onto each secondary sweep in the area of the airline hole.
5. Clean the area to be welded of paint and grease.
6. Use 7018 rod to weld the pipe halves to the sweep. Make a 3/16" fillet weld to each horizontal edge of the reinforcement pieces, 4 places each sweep. (See Drawing)

- ♦ **WARNING: WELD ONLY TO THE 2 HORIZONTAL EDGES OF THE HALVES. SEE DRAWING. DO NOT WELD PAST THE RADIUS OF EACH HALF. DO NOT WELD AROUND THE CIRCUMFERENCE OF THE TUBE.**

7. Inspect the welds for cracks, undercuts or cratering. If any exist "V" out the weld and reweld.
8. Repeat for the other 17 sweeps.
9. Paint the area welded.
10. Pull airline back through hole and reattach airline quick connect.

- ♦ NOTE: An alternative is to remove the airline and run it through the light bar. The upper split reinforcement half would not need to have the hole in it.

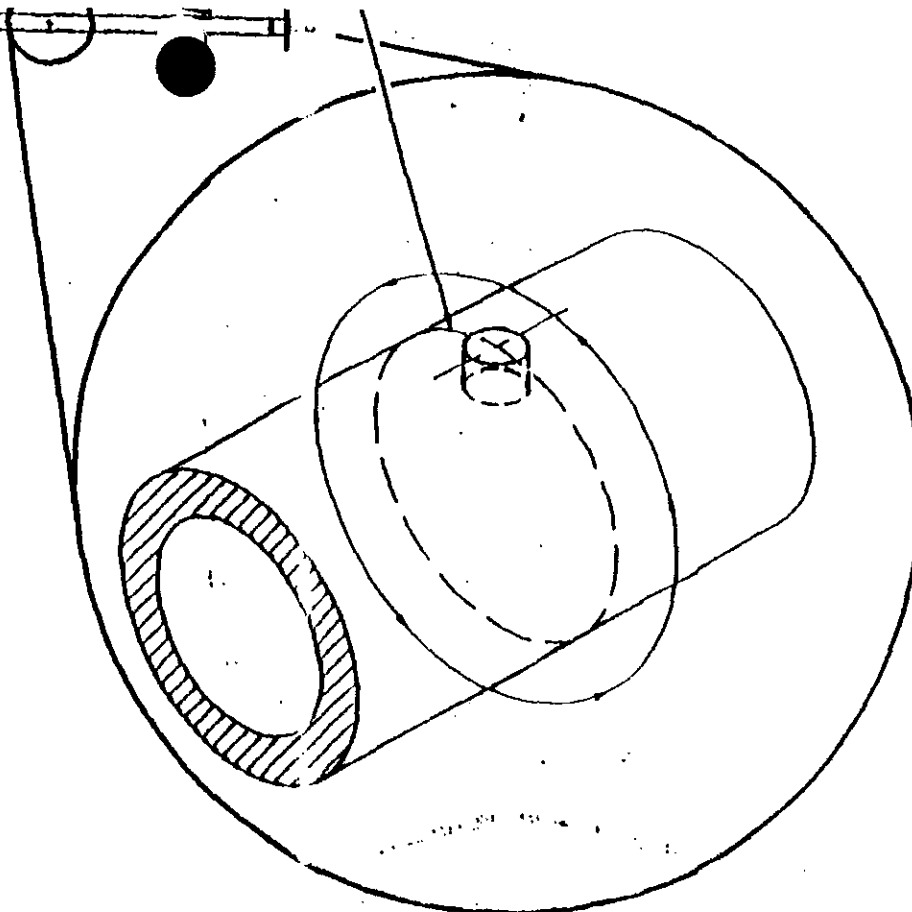
**CONTACT WISDOM INDUSTRIES FOR THE SPLIT HALVES FOR YOUR RIDE. THE HALVES WILL BE SENT OUT AT NO CHARGE.**


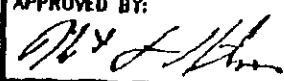
INSPECT AROUND PIPE NEAR THE AIR LINE HOLE  
ON SECONDARY SWEEP TUBE FOR CRACKS.

CLEAN OFF GREASE & DIRT BEFORE INSPECTING.

USE VISUAL INSPECTION FOLLOWED BY MAGNA  
FLUX OR DYE PENETRANT.

IF CRACKS ARE FOUND, DO NOT OPERATE THE  
RIDE UNTIL CONTACTING WISDOM INDUSTRIES AT  
(800) 634-6097 FOR REPAIR OR REPLACEMENT  
INSTRUCTIONS.

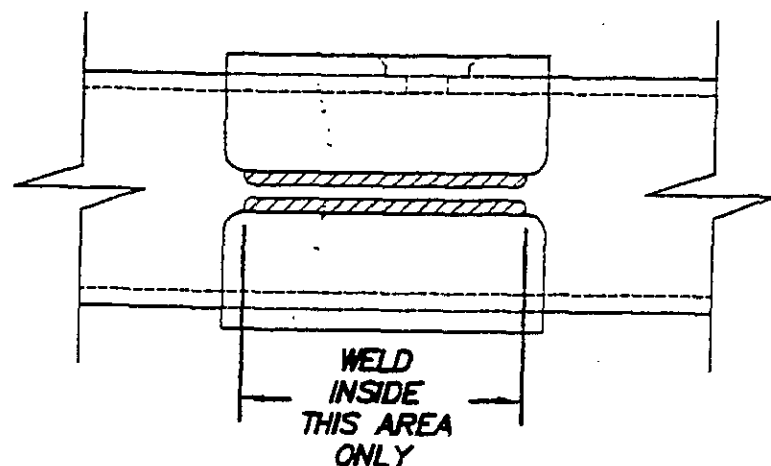
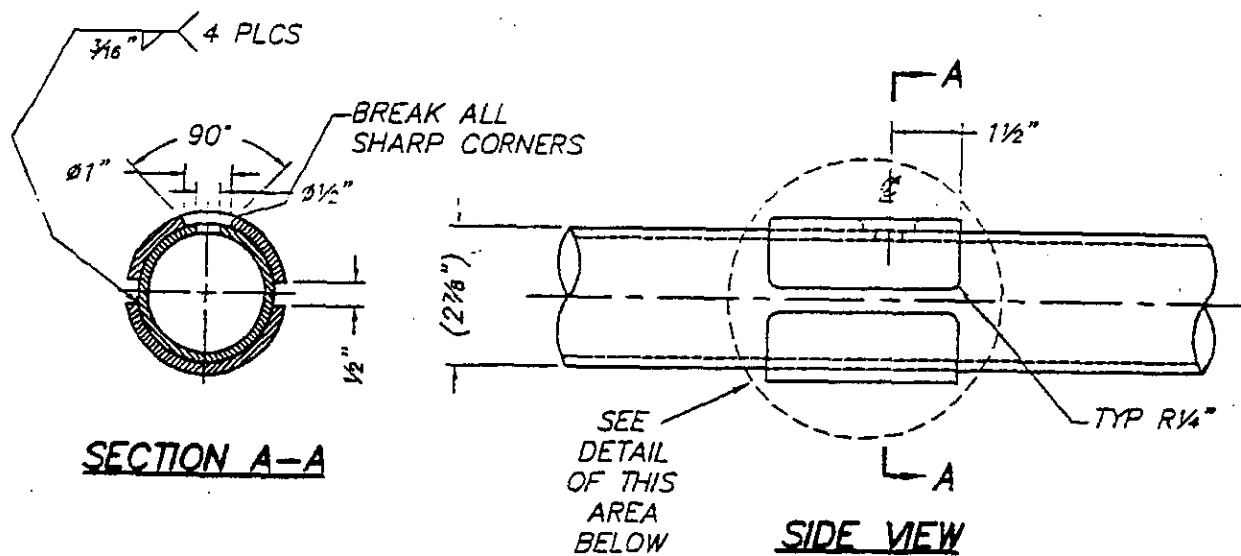
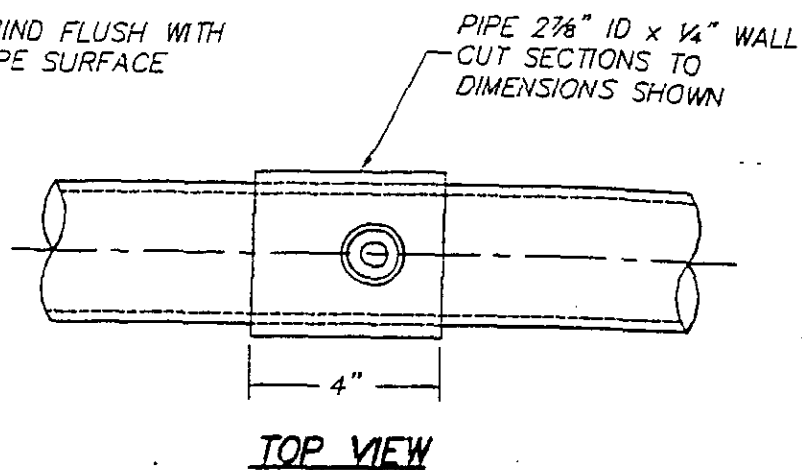
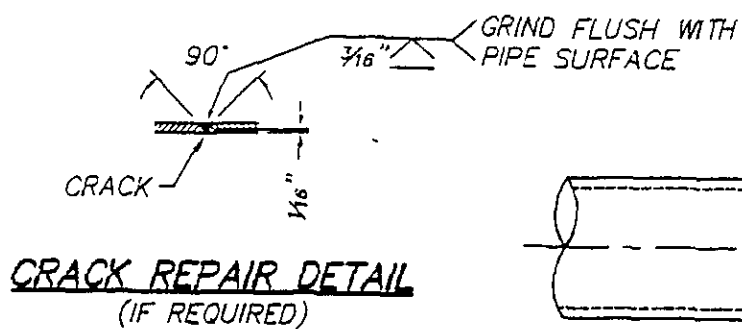


 <b>WISDOM INDUSTRIES</b>		Merino, CO 80741	
SCALE: 3/8" = 1' - 0"	APPROVED BY: 		DRAWN BY: SAS
DATE:			REVISED
DESCRIPTION <b>CAR SWEEP</b>			
EQUIPMENT: <b>MID-SIZE HIMALAYA</b>		DRAWING NUMBER <b>CAR_SWEEP</b>	

19 Apr 00 REVISED MAHI CAR SWEEP TO CAR SWEEP

J.R

APR 19, 2000 - 13:13 44 < L: \MID-HIM\CAR\_SWEEP.DWG >



**WARNING!**  
WELD HORIZONTALLY ONLY.  
DO NOT WELD BEYOND  
RADIUS ON CORNER OF EACH  
HALF AS SHOWN.



**WISDOM INDUSTRIES** Merino, CO 80741

APPROVED BY:

DESCRIPTION

CAR SWEEP REPAIR

SCALE: QUARTER

DATE: 11/07/00

EQUIPMENT:

MID-SIZE HIMALAYA

DRAWN BY:

SMY

DRAWING NUMBER:

SWEEP REPAIR