



Majestic Manufacturing Inc.
4536 State Route 7
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Bulletin No.: 2013-04

Release Date: 8-27-13

Effective Date: 8-27-13

Supersedes: All

Completion Date:
If cracks are found upon inspection,
repairs must be done before
returning to operation

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SERVICE BULLETIN

Ride Manufacturer: Majestic Manufacturing

Affected Production Dates: All

Ride Name: Musik Express™

Affected Serial Nos.: All

Model Number: All

Abstract of Issue: Welding procedure for repairing cracks found in Musik Express™ amusement ride track.

Reason For Release: Upon inspection of the Musik Express™ amusement ride, cracks have been found in the track.

Action To Be Taken:

Welding procedure for repairing cracks found in Musik Express™ amusement ride track.

1. Remove the damaged piece of track from the Musik Express™ ride.
2. Musik Express™ track welds are to be inspected by a certified level II NDT technician.
(Note: An electronically emailed, faxed or physically sent copy of the inspection report must be sent to Majestic Manufacturing Inc.) The following must be inspected.
 - 100% Visual Testing of all Musik Express™ track welds (VT – Visual Testing).
 - 100% Liquid Dye Penetrate Inspection Testing of all repaired Musik Express™ track welds specified in this procedure.If any defects or deficiencies are found in the Musik Express™ track welds, they must be repaired prior to the ride being allowed to return to operation.
3. Cracked welds must be ground out to a chamfer by using an aluminum grinding wheel that is suitable for grinding.
4. Once the cracked welds are ground out to a chamfer, the aluminum must be pre-heated to allow better penetration for the new weld.
When welding, apply a minimum of a 1/4" continuous fillet weld using a 3/64" aluminum wire (#5356). All welding repairs are to be in accordance with American Welding Society (ANSI/AWS D1.1 Structural Welding Code – Steel & AWS D1.2/D1.2M Structural Welding Code – Aluminum) or American Society of Mechanical Engineers and are to be performed by appropriately certified or qualified welders as required by the standard.
5. Clean welded areas after welding is finished.
6. The welds must be inspected by a certified level II NDT technician.
 - 100% Visual Testing of all Musik Express™ track welds (VT – Visual Testing).
 - 100% Liquid Dye Penetrate Inspection Testing of all repaired Musik Express™ track welds specified in this procedure.



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Ride Manufacturer: Majestic Manufacturing

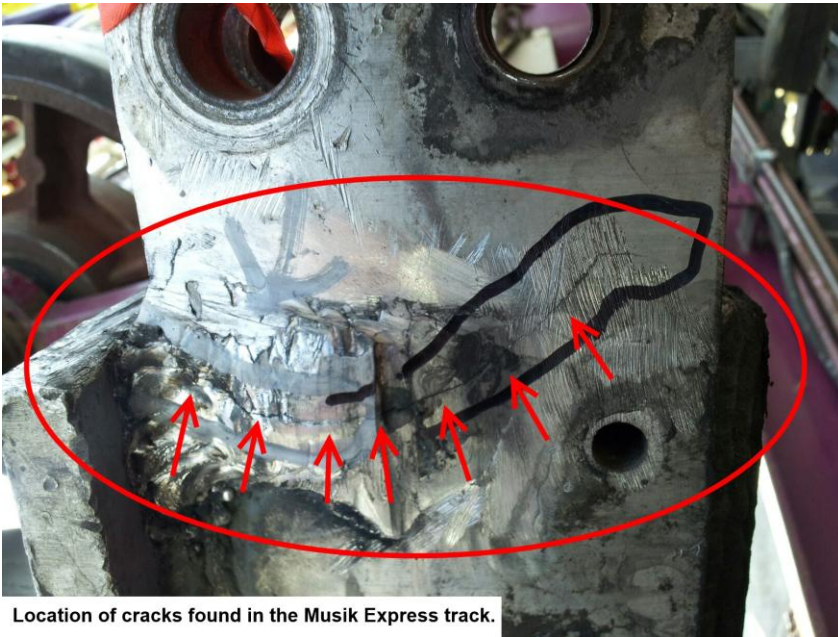
Affected Production Dates: All

Ride Name: Musik Express™

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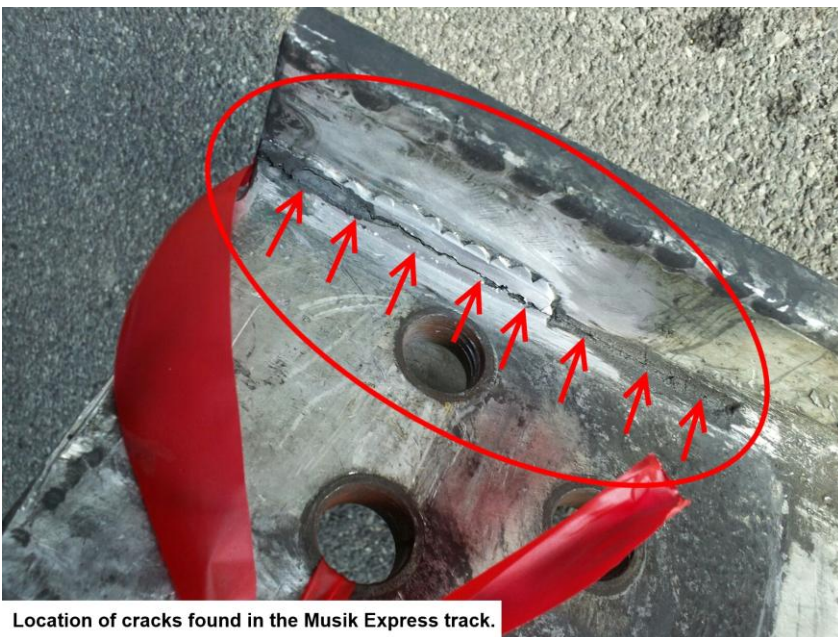
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Detail Of Issue Continued:



Location of cracks found in the Musik Express track.

Figure 1: This is a picture of the location of the cracks found in Musik Express™ amusement ride track.



Location of cracks found in the Musik Express track.

Figure 2: This is a picture of the location of the cracks found in Musik Express™ amusement ride track.

