CHANCE RIDES MANUFACTURING, INC.
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Bulletin No:	B376CRM146-0
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SERVICE BULLETIN

Ride Manufacturer: CHANCE RIDES, INC.	Affected Production Dates: All
Ride Name: YO YO	Affected Serial Nos.: All Units
Model No.: 376	

Abstract of Issue:

Sweep Lift Cylinder Bearing Inspection

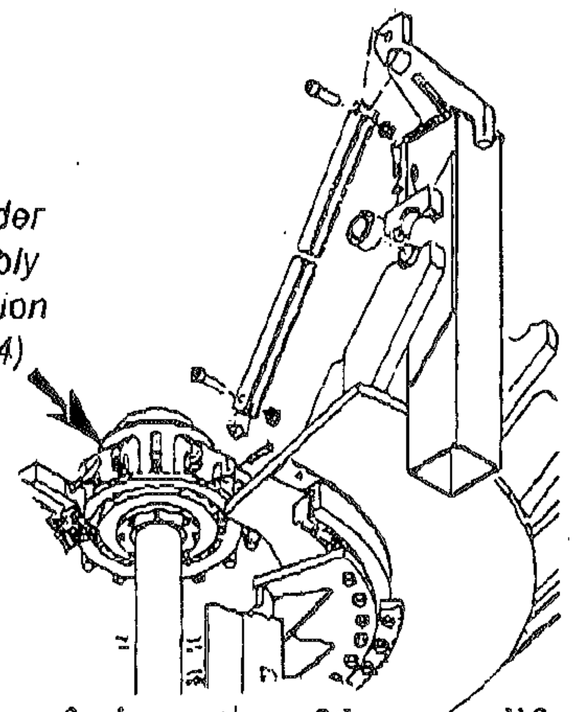
Reason For Release:

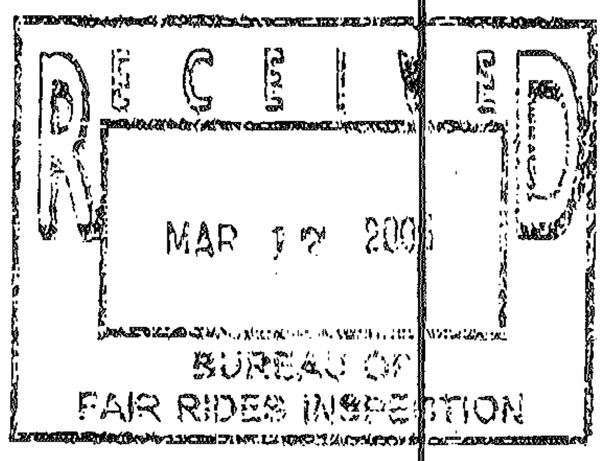
The sweeps on the YO YO connect to the sweep lift cylinder bearing assembly through the sweep links (the sweep lift cylinder bearing assembly is sometimes referred to as the "spider"). The bearing assembly is secured to the sweep lift cylinder rod by two lock nuts, and further secured by LocTite® and a bearing lock washer. If the sweep lift cylinder bearing assembly comes loose from the cylinder rod, the sweeps will lower, which can result in personal injury to the passengers.

The design of this area has not changed in over 35 years of production. To date, 95 YO YO amusement rides have been built using this design. Chance Rides Manufacturing, Inc. believes that this time-proven design is sound and the ride is safe if all aspects of the design are maintained per the manufacturer's specification.

The sweep lift cylinder bearing assembly and its connection to the sweep lift cylinder must be periodically inspected to ensure that the parts are functioning properly and that the connection is secure.

Sweep lift cylinder bearing assembly (See cross-section view on page 4)





This service bulletin defines the procedure for inspection of the sweep lift cylinder bearing assembly and its connection to the sweep lift cylinder.

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Model No.: 376

Action to be Taken:

All owner/operators of YO YO amusement rides are required to inspect the sweep cylinder bearing assembly immediately upon receipt of this bulletin. The inspection procedure is provided on the following pages of this bulletin.

- The initial portion of the inspection must be performed immediately upon receipt of this bulletin, then annually thereafter.
- The remaining portion of the inspection, as defined in the inspection procedure, must be performed within 7 days of the release date of this bulletin.

IF ANY VARIATIONS FROM THE CONDITIONS DESCRIBED IN THIS BULLETIN ARE FOUND, do not operate the ride. Contact the Customer Service Department at Chance Rides Manufacturing, Inc. immediately for instructions on the necessary repair procedure. DO NOT ATTEMPT TO REPAIR THESE COMPONENTS EXCEPT AS SPECIFICALLY INSTRUCTED BY CHANCE RIDES MANUFACTURING, INC.

IF THE CONDITION AND INSTALLATION OF THE SWEEP LIFT CYLINDER BEARING COMPONENTS ARE AS DESCRIBED, the ride can be operated normally.

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.

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Detail of Issue

Inspection Procedure - Sweep Lift Cylinder Bearing Assembly (refer to the illustration on page 4 of this bulletin)

1. Remove the eight (8) capscrews which secure the cover to the bearing housing. Remove the cover.

2. Clean the grease off of the cylinder rod and lock nuts to gain access to these parts for inspection.

3. Measure the cylinder rod protruding past the upper lock nut. There must be 1/8" to 1/4" of the cylinder rod protruding past the upper lock nut (approximately 3 full threads). If this measurement is correct, proceed to the next step.

4. With the assistance of two helpers to MANUALLY rotate the sweeps as instructed in the Operation Manual. Observe the components from above while the ride is turning.

CAUTION: Movement of the ride while inspecting the sweep lift cylinder bearing assembly can cause loss of balance, which can result in personal injury. Use OSHA approved devices to secure the person to the ride structure until the inspection is completed.

DO NOT TURN THE RIDE BY ANY MEANS OTHER THAN MANUAL ROTATION FOR THIS PROCEDURE.

- The inner race of the upper bearing must remain stationary in relation to the cylinder rod.
- The spacer must remain stationary in relation to the cylinder rod
- Listen for any unusual noises from the bearing. Look for any unusual movement of any component.

5. Stop turning the ride. Use a 0.002" feeler gauge to look for clearance between the spacer and the inner race of the upper bearing as shown. Check this around the entire circumference of the spacer. There should be zero clearance at all locations.

Steps 1 through 5 must be performed immediately upon receipt of this bulletin, then annually thereafter.

If all components are functioning as described, proceed to the following steps. Steps 6 through 16 need only be performed one time, within 7 days of the release date on this bulletin. Steps 6 through 16 do not need to be repeated annually.

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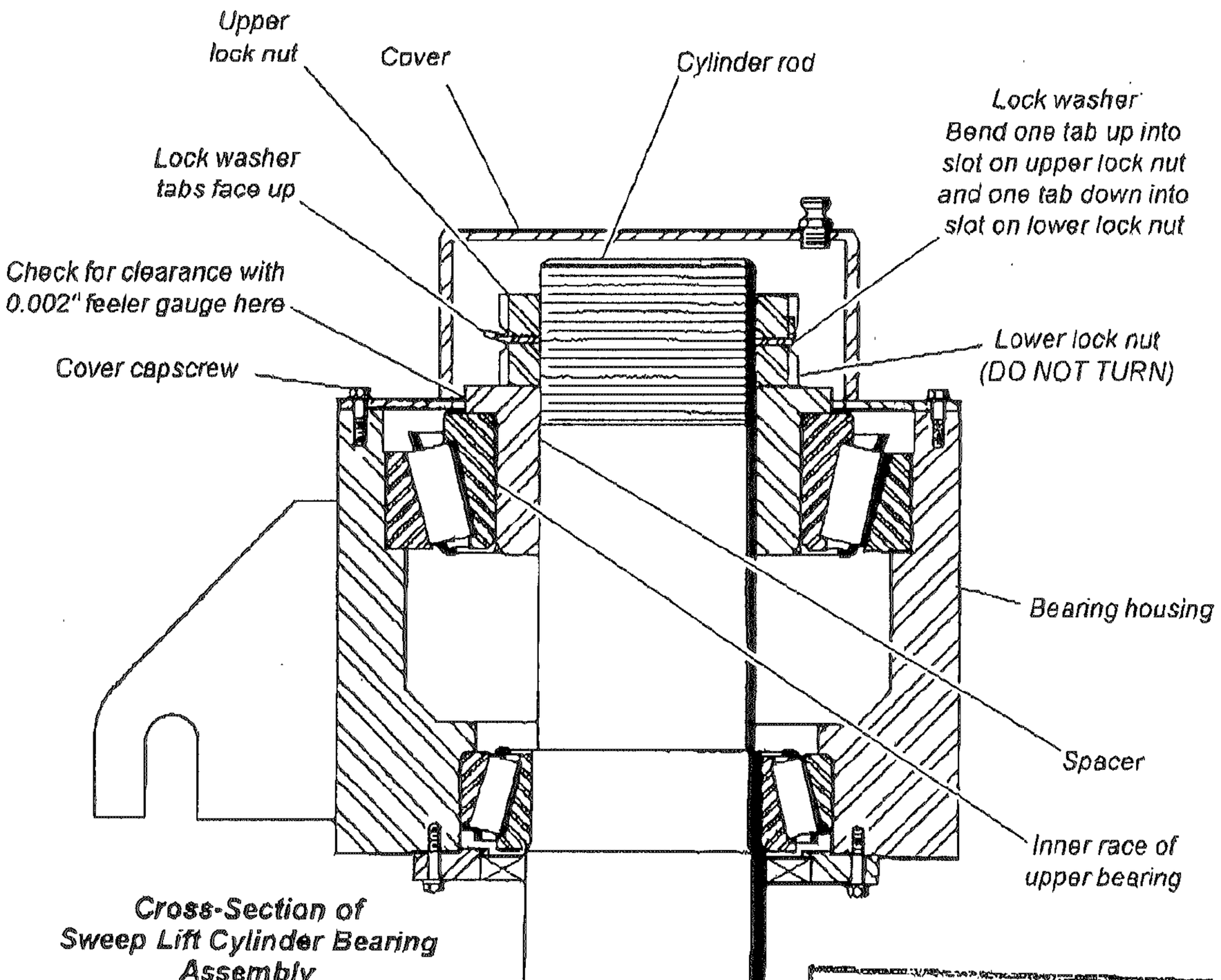
Detail of Issue (continued):



Cross-Section of Sweep Lift Cylinder Bearing Assembly

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Detail of Issue (continued):

6. Bend the locking tab of the lock washer out of the slot on the upper lock nut. Remove the upper lock nut by turning counter-clockwise.

IMPORTANT: Do not turn the lower lock nut or bearing adjustment will be changed.

NOTE: The upper lock nut is secured with LocTite®. It may be necessary to heat the parts to approximately 480°F (250°C) to turn the lock nut. Also, a hammer and brass drift punch can be used to carefully break the lock nut loose.

7. Remove the lock washer and inspect it for broken, cracked or distorted tabs. Pay particular attention to the inner tab which engages the keyway in the cylinder rod. If the lock washer is in good condition, discard it and the upper lock nut, then proceed to the next step.

8. Thoroughly clean the cylinder rod, being careful to keep all dirt, solvent and other foreign material out of the bearings.

IMPORTANT: These parts must be clean to properly inspect them.

9. Check the condition of the threads on the cylinder rod. Look for signs of wear or damage. If the threads are in good condition, proceed to the next step.

10. Install a new lock washer (SKF #W21 / Chance part number 28560000) and new upper lock nut (SKF #AN21 / Chance part number 24760700). The outer tabs on the lock washer must face up (see drawing).

11. Check that one of the outer tabs on the lock washer will engage in one of the slots on the lower lock nut. If necessary, turn the lower lock nut very slightly, just enough to allow the slot to align with the lock washer tab. Do not bend the tab into the slot yet.

NOTE: Only one tab and slot will be aligned. If turning the lower lock nut is necessary, select the tab and slot which will require minimal turning to obtain alignment.

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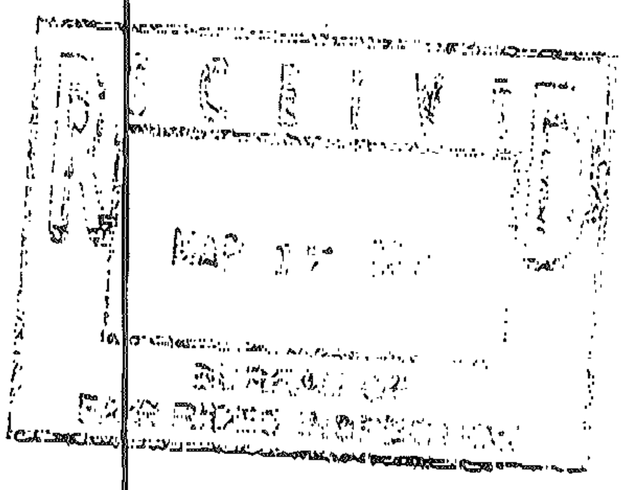
Detail of Issue (continued):

12. Use LocTite® 271 (red) on the threads, following the manufacturer's instructions. Use a special socket or a spanner wrench to tighten the upper lock nut to approximately 500 ft-lbs.

NOTE: If using a spanner wrench, the correct torque can be achieved using the following guidelines:

1. *With the spanner wrench engaged on the lock nut, measure the length of the wrench handle from the centerline of the lock nut.*
2. *Divide 500 by the length of the wrench handle (in feet, not inches). That is the amount of force at the end of the handle required to achieve 500 ft-lbs. at the lock nut. For example:*
   - *If the wrench handle is 24 inches long (2 feet), divide 500 by 2 = 250 pounds of force at the end of the wrench.*
   - *If the wrench handle is 30 inches long (2.5 feet), divide 500 by 2.5 = 200 pounds of force at the end of the wrench.*



13. Re-check the measurement of the cylinder rod protruding past the upper lock nut. There must be 1/8" to 1/4" of the cylinder rod protruding past the upper lock nut (approximately 3 full threads).

14. Bend one tab of the new lock washer down to engage in the slot in the lower lock nut.

15. Bend one tab of the lock washer up to engage the slot in the upper lock nut. If necessary, tighten the upper lock nut further to allow the slot to align with the lock washer tab.

NOTE: Only one tab and slot will be aligned. If further tightening of the upper lock nut is necessary, select the tab and slot which will require minimal tightening to obtain alignment.

16. Apply silicone sealant to the flange on the cover and install it. Tighten the cover capscrews to 5-6 ft-lbs.