SPECIFICATI(

MFG: CHANCE RIDES, INC.
NAME: GONDOLA WHEEL
TYPE: NON-KIDDIE

This ride conforms with all applicable ASTM amusement ride standards in effect on the date of manufacture.

SEATING

Number of gondolas 20
Maximum number of passengers per gondola ..... 6 adults* or 8 children
Maximum total weight per gondola ..... 1,296 lbs.
Maximum total number of passengers ..... 120 adults* or 160 children
Maximum total passenger weight ..... 25,920 lbs.
Minimum passenger height ..... 42 inches (unaccompanied by adult)
Loading ..... 4 gondolas simultaneously
Maximum unbalance ..... 12 adults* (2,592 lbs.)

PERFORMANCE

Direction of travel ..... Clockwise and counter-clockwise
Ride speed ..... (maximum) 2.5 rpm
Maximum wind speed (operating) ..... 35 mph
Maximum wind speed (static) ..... 80 mph
(guy wires recommended in high winds)

MAXIMUM RIDE WEIGHT (empty) ..... 120,000 lbs.

DRIVE ..... 60 hp electric

POWER REQUIREMENTS

Total ..... 130 kW
Drive ..... 70 kW
Lights ..... 60 kW
Minimum/Maximum line voltage 208/240

*A maximum load can be derived from random individual passenger weights, but must not exceed the specifications given.

Specifications are effective as of publication date. Because we try to improve every Chance product, these specifications are subject to change without notice.

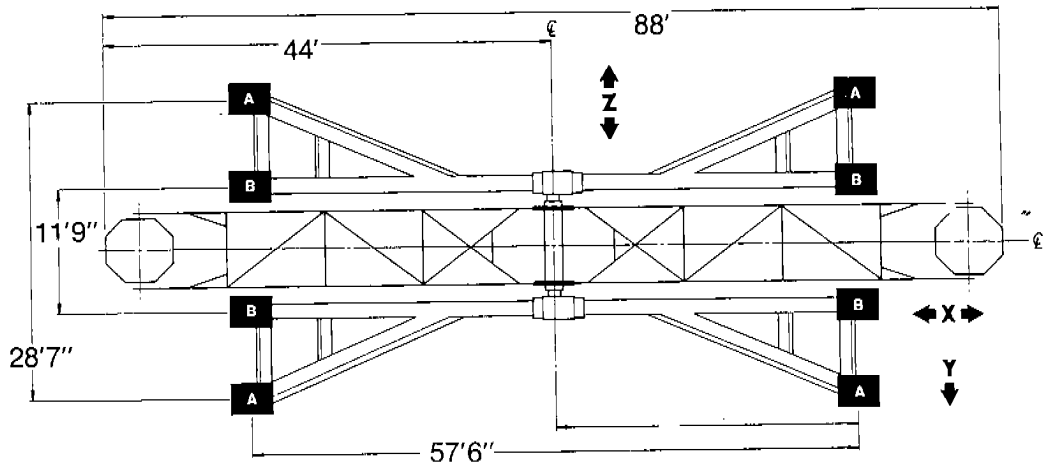
PARK MODEL **GIANT GONDOLA WHEEL**

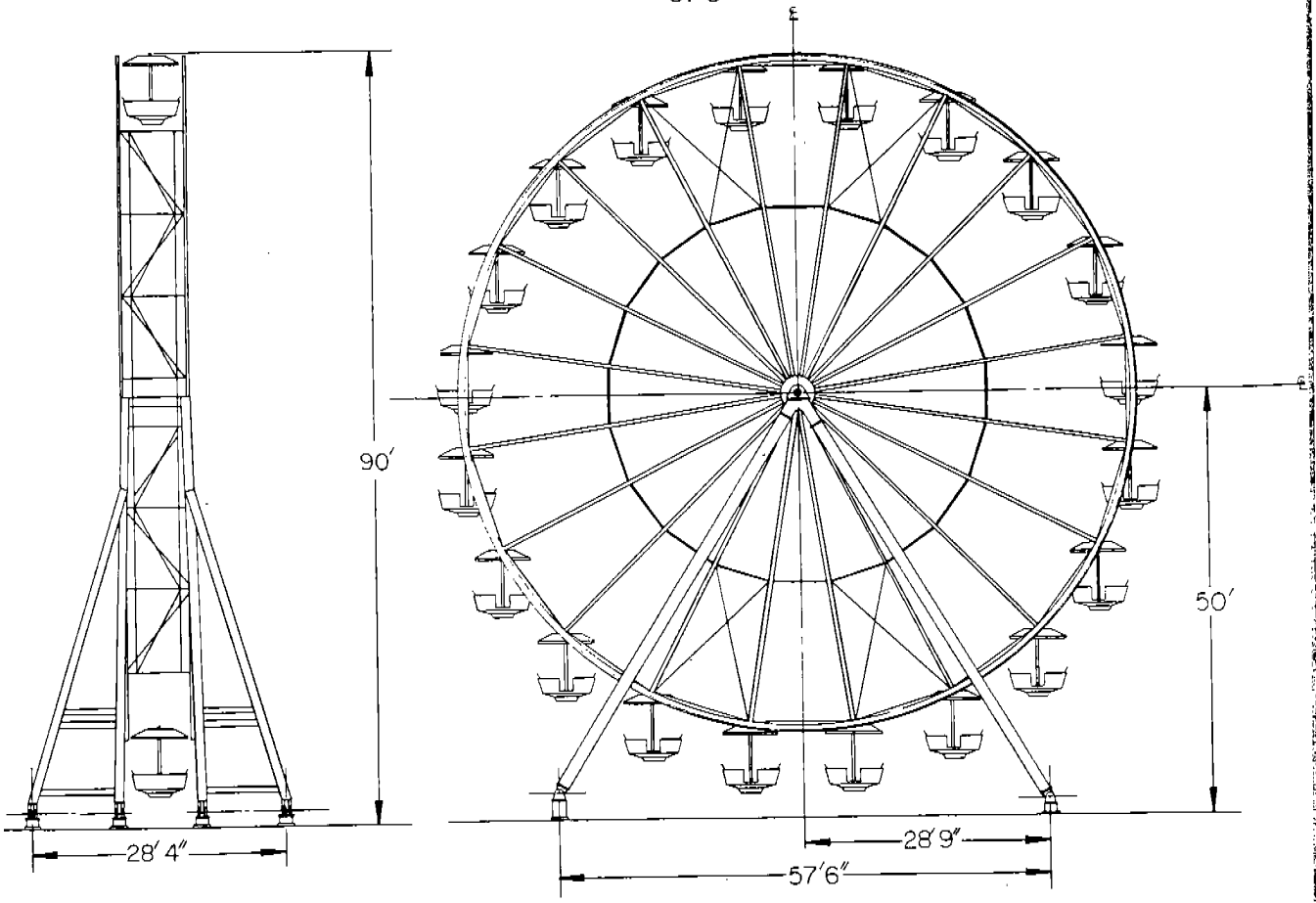
CHANCE RIDES INC.

America's Largest Manufacturer of Amusement Rides

4219 Irving
P.O. Box 12328
Wichita, KS 67277-2328

Telephone (316) 942-7411
Telex: 910 9976518 (CHANCE WIC)
FAX: (316) 942-7416





REACTION AND MOMENTS ON FOOTING—STATIC—NO PASSENGERS						
POSITION	REACTION IN POUNDS			MOMENTS (IN. LBS.)		
	LONGITUDINAL "X"	TRANSVERSE "Z"	VERTICAL "Y"	M_X	M_Z	M_Y
A	±6,000	±3,000	±1,100	± 150,000	±300,000	0
B	±11,000	±2,000	±22,000	±100,000	±550,000	0
REACTION AND MOMENTS ON FOOTING FOR 80 MPH WIND—NO PASSENGERS—						
A	±31,000	±11,000	+58,000 −47,000	±550,000	±1,500,000	0
B	±53,000	±4,000	+99,000 −24,000	±200,000	±2,650,000	0

GIANT GONDOLA WHEEL:

Giant Wheel

Serial Numbers: 400-001-88 and on

The Following Service Bulletins Are Applicable:

B400R1026-0	Rim Iron Pins And Bushings
B400R1030-0	Retainer Clips For Rim Iron Light Bar Jumper Cables
B400R1031-0	Inspection Of Fasteners For T-Bar Bearing Blocks
B400R1035-0	Hydraulic Cylinder Rework For Adjustable Long Spreader Bars
B400R1036-0	Inspection Of Torque Tube Fasteners
B400R1038-0	Hydraulic Leveling Cylinder Plumbing Rework
B400R1043-0	Floor Rework
B400R1045-0	Axle Conduit Coupling Check
B400R1046-A	Gondola Door Adjustment
B400R1047-0	Trailer Leveling Instructions
B400R1054-0	TIE ROD INSTALLATION
B400R1055-0	PLATING ON GONDOLA STEM
B400R1058-0	AXLE HUB REWORK
B400R1062-0	LIGHTING CONTROLLER BOX
B400R1093-0	WARNING TAPE/DECAL
B400R1114-0	CAUTION RAISE FLOOR DECAL

GIANT GONDOLA WHEEL

Ride Serial Number _____ Owner _____ Date _____

FIELD INSPECTION POINTS

1. ( ) Inspect blocking and leveling on portable model (Bulletin B400R1047-0).

2. ( ) Inspect lock rings on screw jacks. Lock rings must be tight against top of jack on portable model.

3. ( ) Inspect hydraulic system for leveling jacks, material handling and ride erection on portable model (Bulletin B400R1038-0).

4. ( ) Inspect all trailer-to-trailer connections (ball and socket joints and pins on portable model).

5. ( ) Inspect cable leads, electrical connections and grounding per local code.

6. ( ) Inspect trailer wind braces. Turnbuckles must be snug on portable model).

7. ( ) Inspect air system for leaks.

8. ( ) Inspect rim iron attaching pins. Pins must be installed from the outside of the wheel and secured with lynch pins.

9. ( ) Inspect all spreader bars (long and short) for correct attachment.

10. ( ) Inspect adjustable spreader bars. Lock rings must be tight (Bulletin B400R1035-0).

11. ( ) Inspect long tie rods (8 pairs). Tie rods must be in tension, with turnbuckles snug.

12. ( ) Inspect torsion rods (4 pairs). Torsion rods must be in tension with turnbuckles snug.

13. ( ) Inspect the mating of right hand tower legs to left hand tower legs. Check connecting capscrews for proper torque.

14. ( ) Check the capscrews which attach the torque tube to the hub bearing housings for proper torque (Bulletin B400R1036-0).

14A. ( ) Inspect the set screws in the electrical conduit couplings in the axle hubs (Bulletin B400R1045-0).

15. ( ) Inspect the four hub wing draw bolts and the four pins. The hub wings must be completely drawn together.

16. ( ) Inspect the drive tires for proper and equal pressure, contact area and tracking. Safety covers must be in place.

17. ( ) Inspect gondola stems for two capscrews at the top.

18. ( ) Inspect gondola stems for two pins at the bottom.

19. ( ) Check gondola doors for proper "self-closing" operation. Check door adjustment (Bulletin B400R1046-A).

20. ( ) Inspect hand rails, floors, ramps and walkways (Bulletin B400R1043-0).

21. ( ) Inspect all gates and safety chains. All "self-closing" gates must operate properly.

22. ( ) Check all entrance and exit signs.

23. ( ) Inspect operator controls, including E-Stop and emergency brake systems.

24. ( ) Check the main power shut-down switch (shunt trip).

25. ( ) Inspect all safety placards and signs.

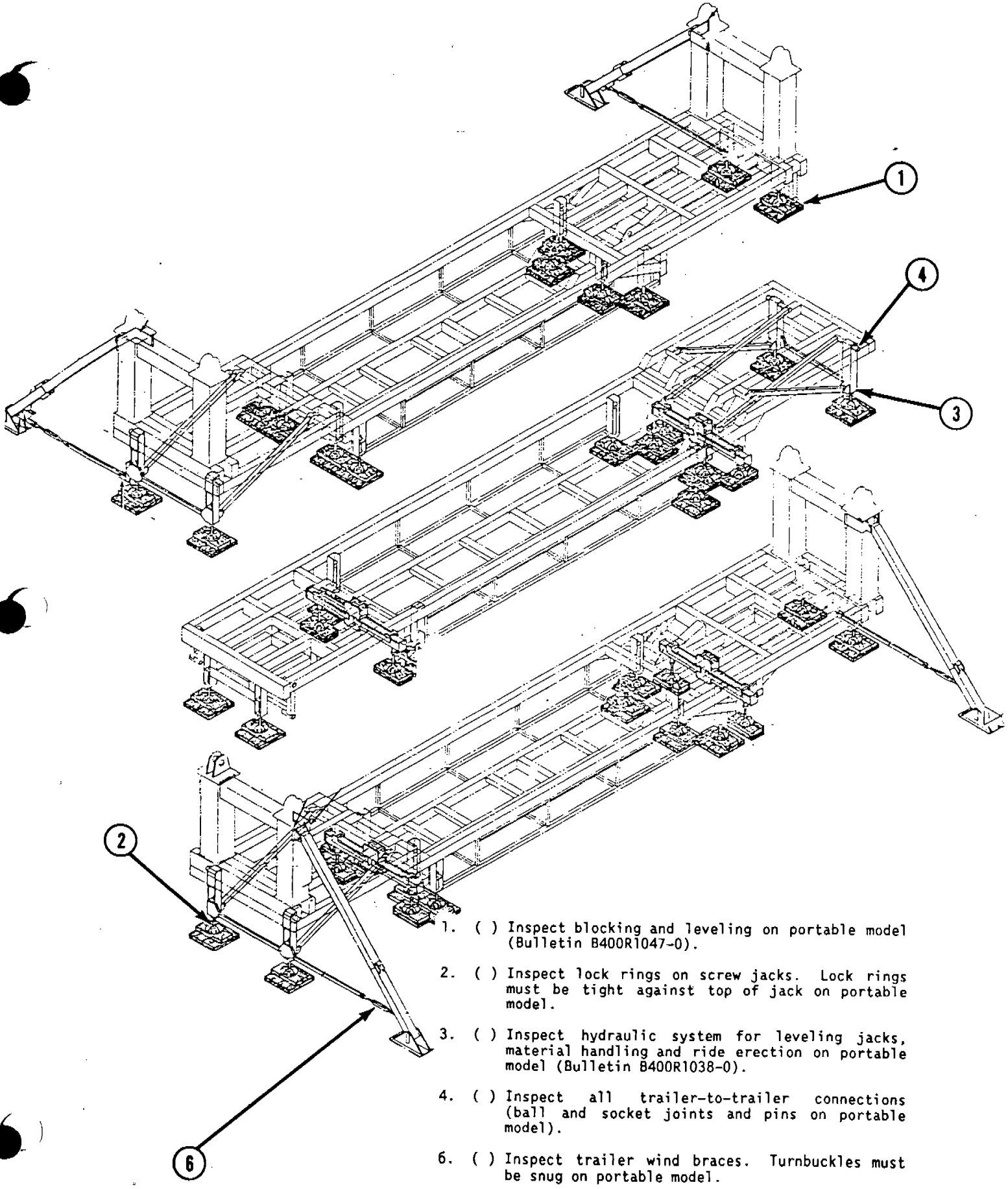
26. ( ) Covers must be in place over decorative lighting on the spreader bars and lower portion of each sweep.

27. ( ) Check ride speed - maximum 3 rpm.

28. ( ) Check for excessive vibration.

29. ( ) Inspect structure for cracks, bad welds, etc.

30. ( ) Inspect overall appearance of ride for cleanliness and general overall upkeep.



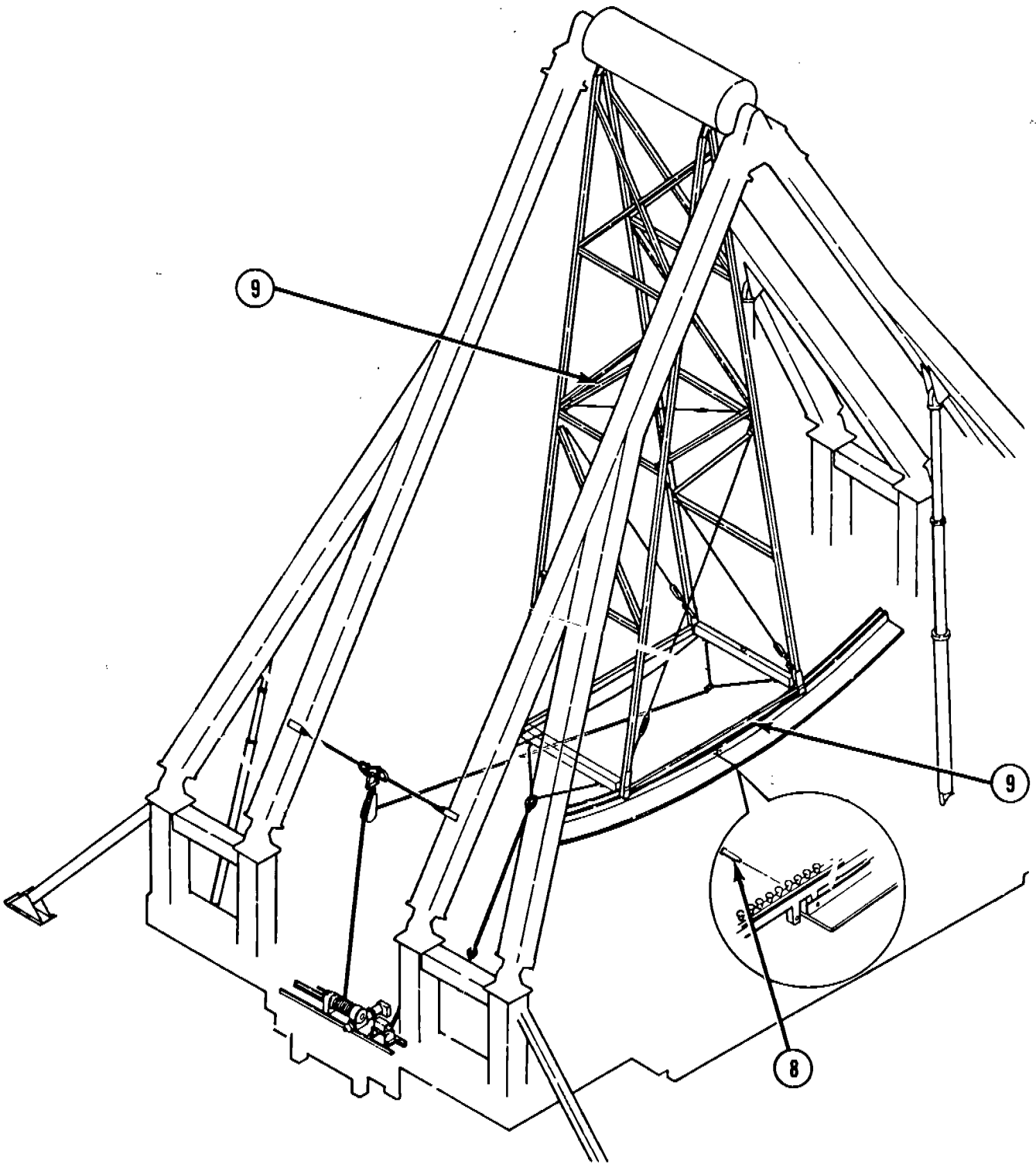
1. ( ) Inspect blocking and leveling on portable model (Bulletin B400R1047-0).

2. ( ) Inspect lock rings on screw jacks. Lock rings must be tight against top of jack on portable model.

3. ( ) Inspect hydraulic system for leveling jacks, material handling and ride erection on portable model (Bulletin B400R1038-0).

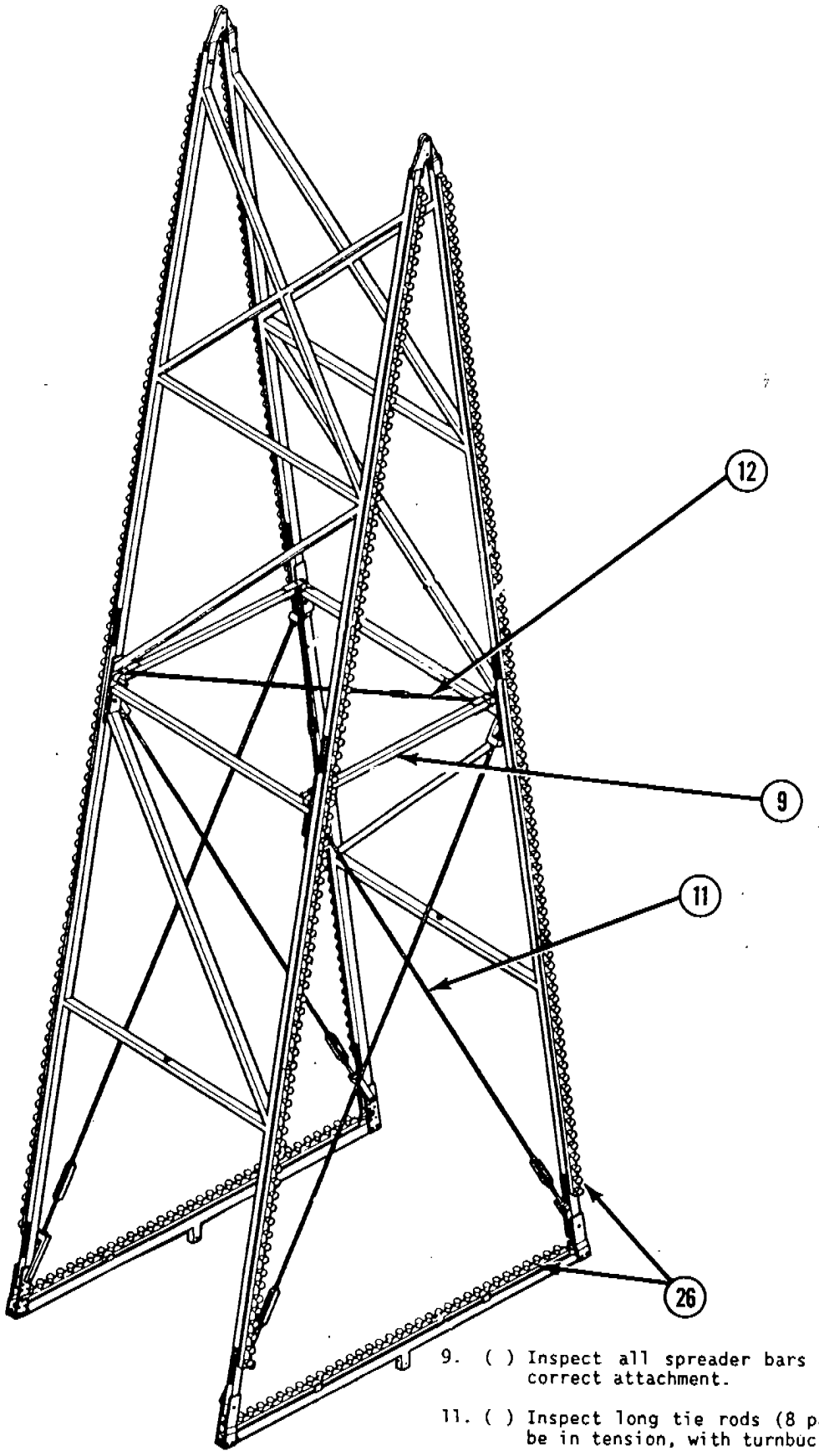
4. ( ) Inspect all trailer-to-trailer connections (ball and socket joints and pins on portable model).

6. ( ) Inspect trailer wind braces. Turnbuckles must be snug on portable model.



8. ( ) Inspect rim iron attaching pins. Pins must be installed from the outside of the wheel and secured with lynch pins.

9. ( ) Inspect all spreader bars (long and short) for correct attachment.

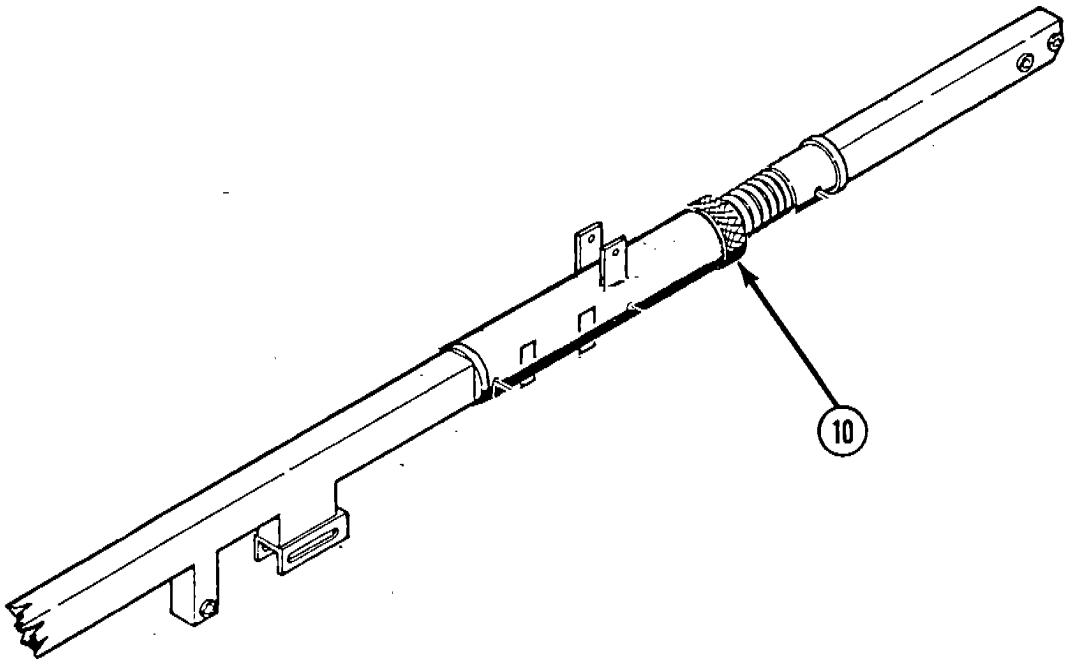


9. ( ) Inspect all spreader bars (long and short) for correct attachment.

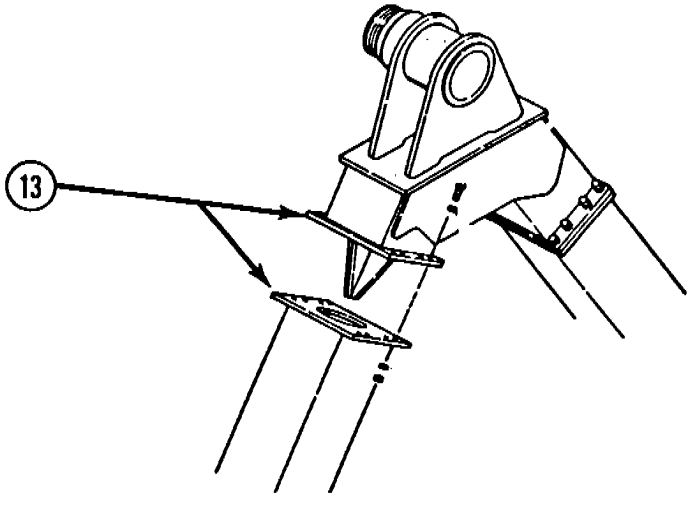
11. ( ) Inspect long tie rods (8 pairs). Tie rods must be in tension, with turnbuckles snug.

12. ( ) Inspect torsion rods (4 pairs). Torsion rods must be in tension with turnbuckles snug.

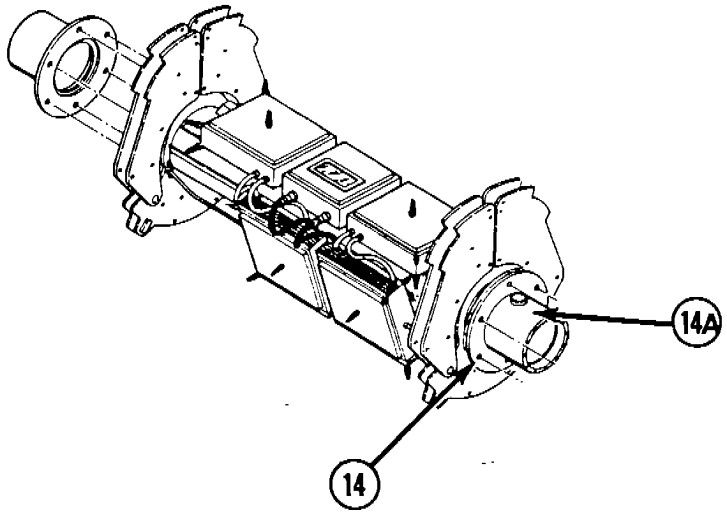
26. ( ) Covers must be in place over decorative lighting on the spreader bars and lower portion of each sweep.



10. ( ) Inspect adjustable spreader bars. Lock rings must be tight (Bulletin B400R1035-0).

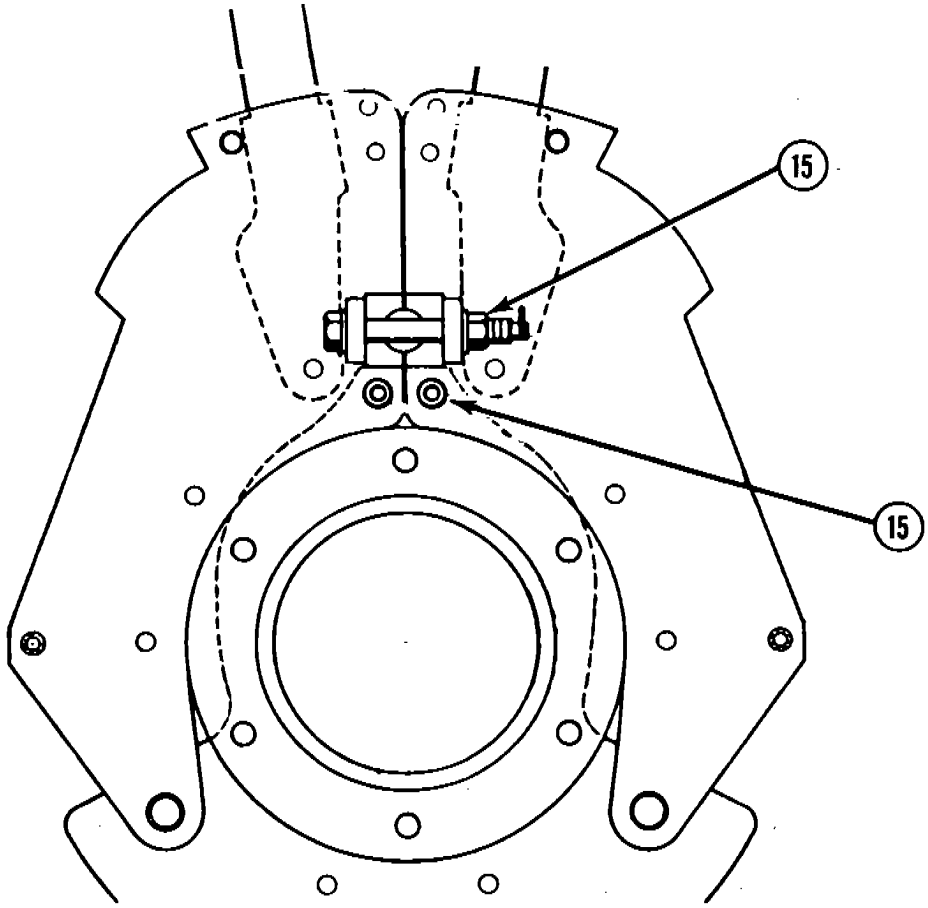


13. ( ) Inspect the mating of right hand tower legs to left hand tower legs. Check connecting capscrews for proper torque.

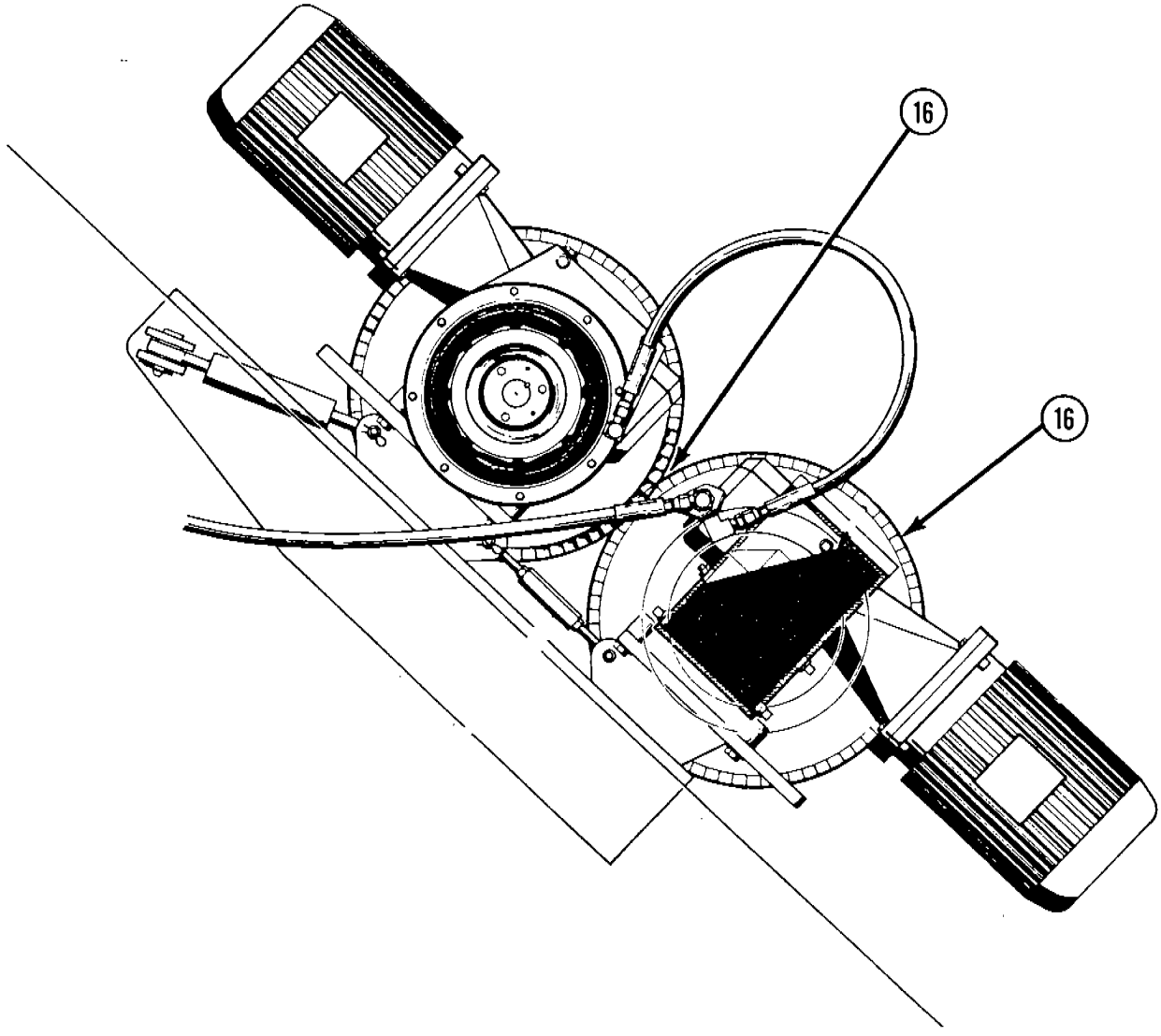


14. ( ) Check the capscrews which attach the torque tube to the hub bearing housings for proper torque (Bulletin B400R1036-0).

14A.( ) Inspect the set screws in the electrical conduit couplings in the axle hubs (Bulletin B400R1045-0).

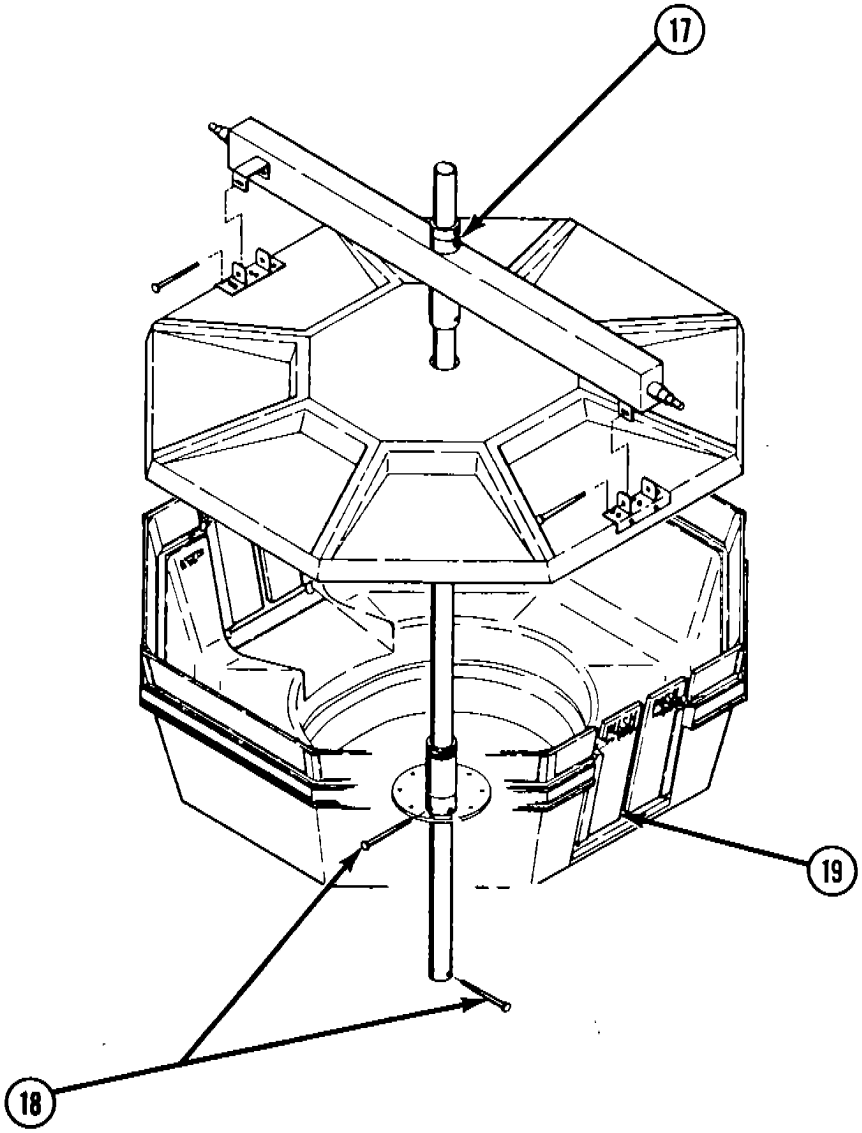


15. ( ) Inspect the four hub wing draw bolts and the four pins. The hub wings must be completely drawn together.



16. ( ) Inspect the drive tires for proper and equal pressure, contact area and tracking. Safety covers must be in place.

25. ( ) Inspect all safety placards and signs.

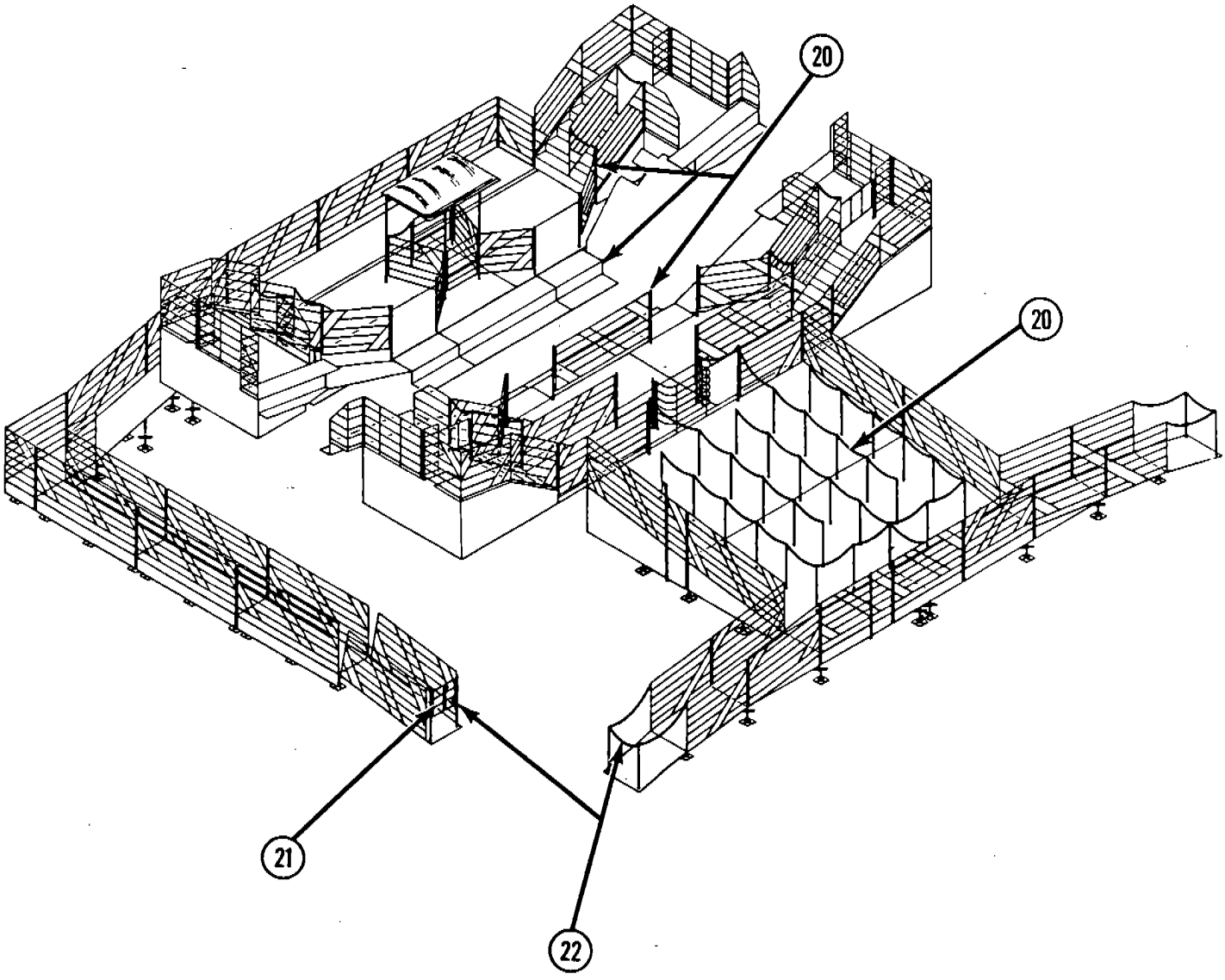


17. ( ) Inspect gondola stems for two capscrews at the top.

18. ( ) Inspect gondola stems for two pins at the bottom.

19. ( ) Check gondola doors for proper "self- closing" operation. Check door adjustment (Bulletin B400R1046-A).

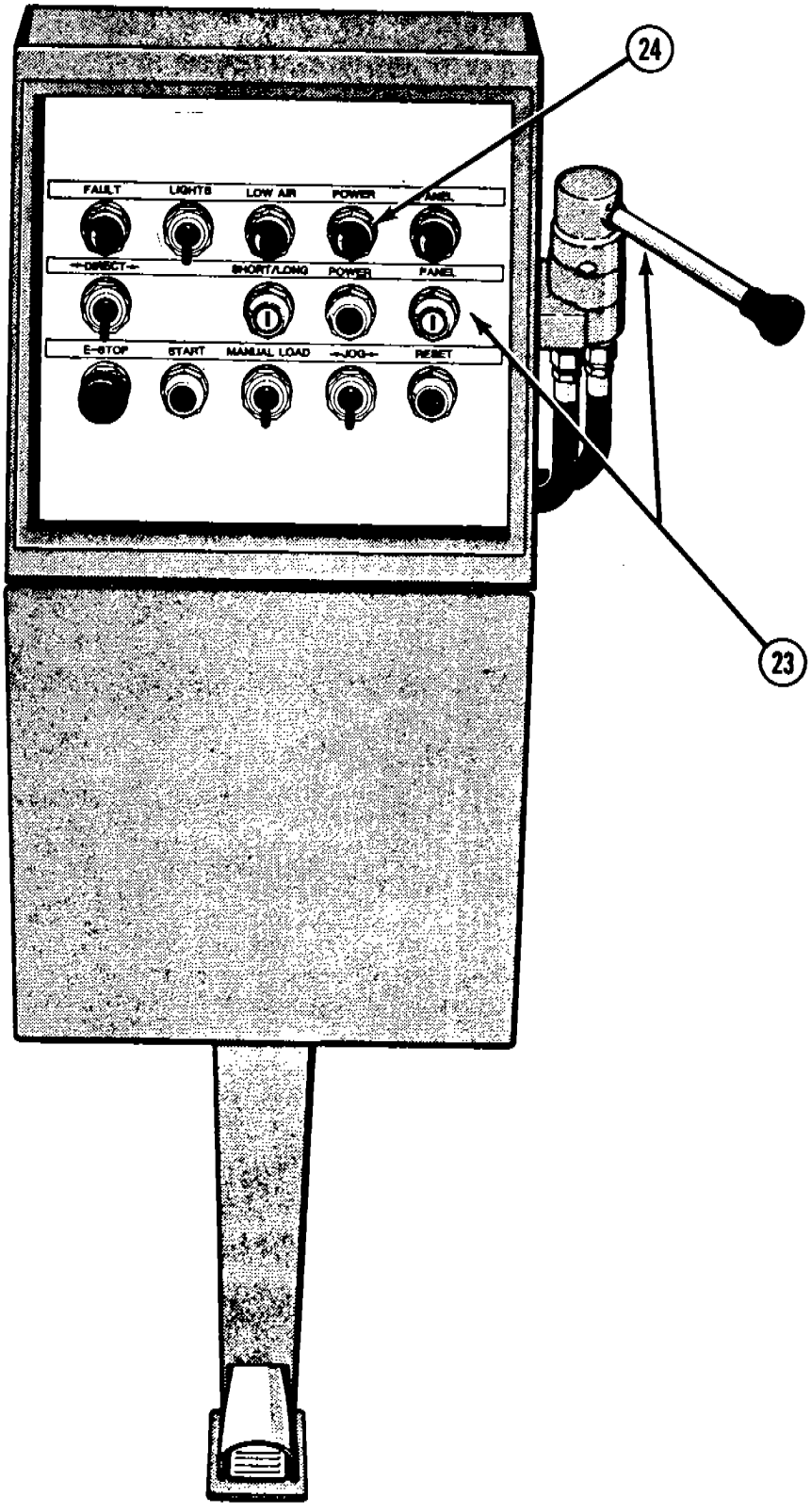
25. ( ) Inspect all safety placards and signs.



20. ( ) Inspect hand rails, floors, ramps and walkways (Bulletin B400R1043-0).

21. ( ) Inspect all gates and safety chains. All "self-closing" gates must operate properly.

22. ( ) Check all entrance and exit signs.



23. ( ) Inspect operator controls, including E-Stop and emergency brake systems.

24. ( ) Check the main power shut-down switch (shunt trip).

25. ( ) Inspect all safety placards and signs.

NUMBER: B400R1132-0

DATE: AUG. 2, 1993

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

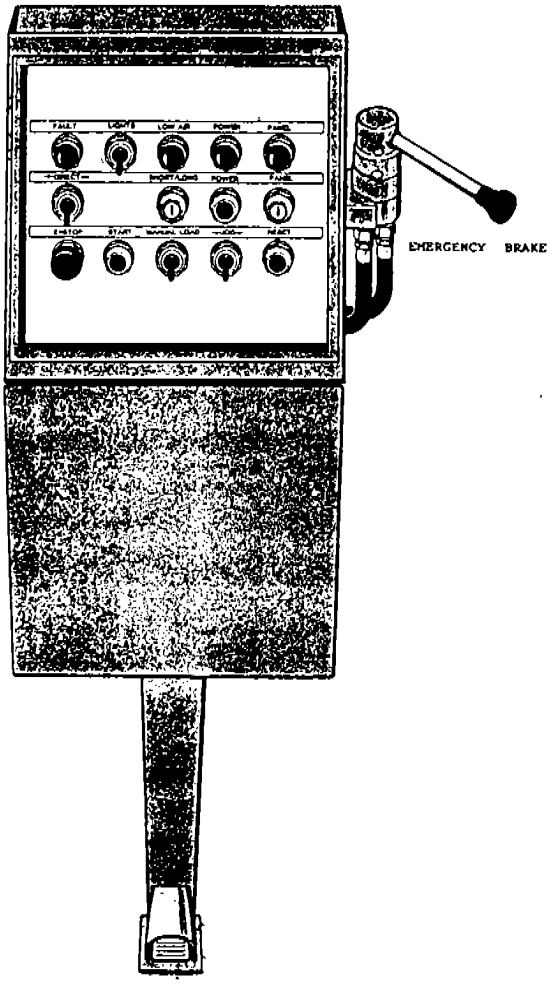
Effective Serial Number: ALL UNITS

Ride: GIANT GONDOLA WHEEL Subject: EMERGENCY BRAKE USE

The Chance Rides, Inc. GIANT GONDOLA WHEEL amusement ride is equipped with an emergency air-operated brake. This emergency brake is attached to the outside of the operator's control stand and is intended to be used in an emergency situation such as in the event of a loss of power to the ride.

If power is lost, the ride will coast to a stop. The emergency brake can then be applied. If power is not restored, the passengers can be unloaded by manually rotating the ride. In such an emergency situation, unload only two gondolas at a time to keep the wheel balanced.

In addition to the emergency procedure outlined above, Chance Rides, Inc. requires the emergency brake to be set during the installation of gondolas to the ride and removal of gondolas from the ride. This provides protection in the case of a power failure to personnel who are working around and between the gondolas.



Factory and Sales Office: 4219 Irving · P.O. Box 12328 · Wichita, Kansas 67277-2328 · (316) 942-7411 · FAX: (316) 942-7416

NUMBER: B400R1114-0

DATE: JULY 20, 1992

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Portable Units - Chance Rides, Inc.

Ride: GIANT GONDOLA WHEEL Subject: Caution Raise Floor Decal

Chance Rides, Inc. GIANT GONDOLA WHEEL amusement ride is equipped with movable floor sections in front of the tower lift cylinders. These floor sections must be lowered into place after the towers have been raised during set-up and then raised before lowering the towers during tear-down. If these floor sections are not raised prior to lowering the towers,damage to the equipment and possible injury to personnel can result.

Chance Rides, Inc. has developed a safety decal to advise operators of the need to raise the floor sections before lowering the towers. Each ride requires four decals and are available at no charge if ordered within 90 days of the date on this bulletin. All owner/operators of the above noted GIANT GONDOLA WHEELS are required to order and install these safety decals per the installation instructions found on this bulletin. Order part number 22198518.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation.

NOTICE

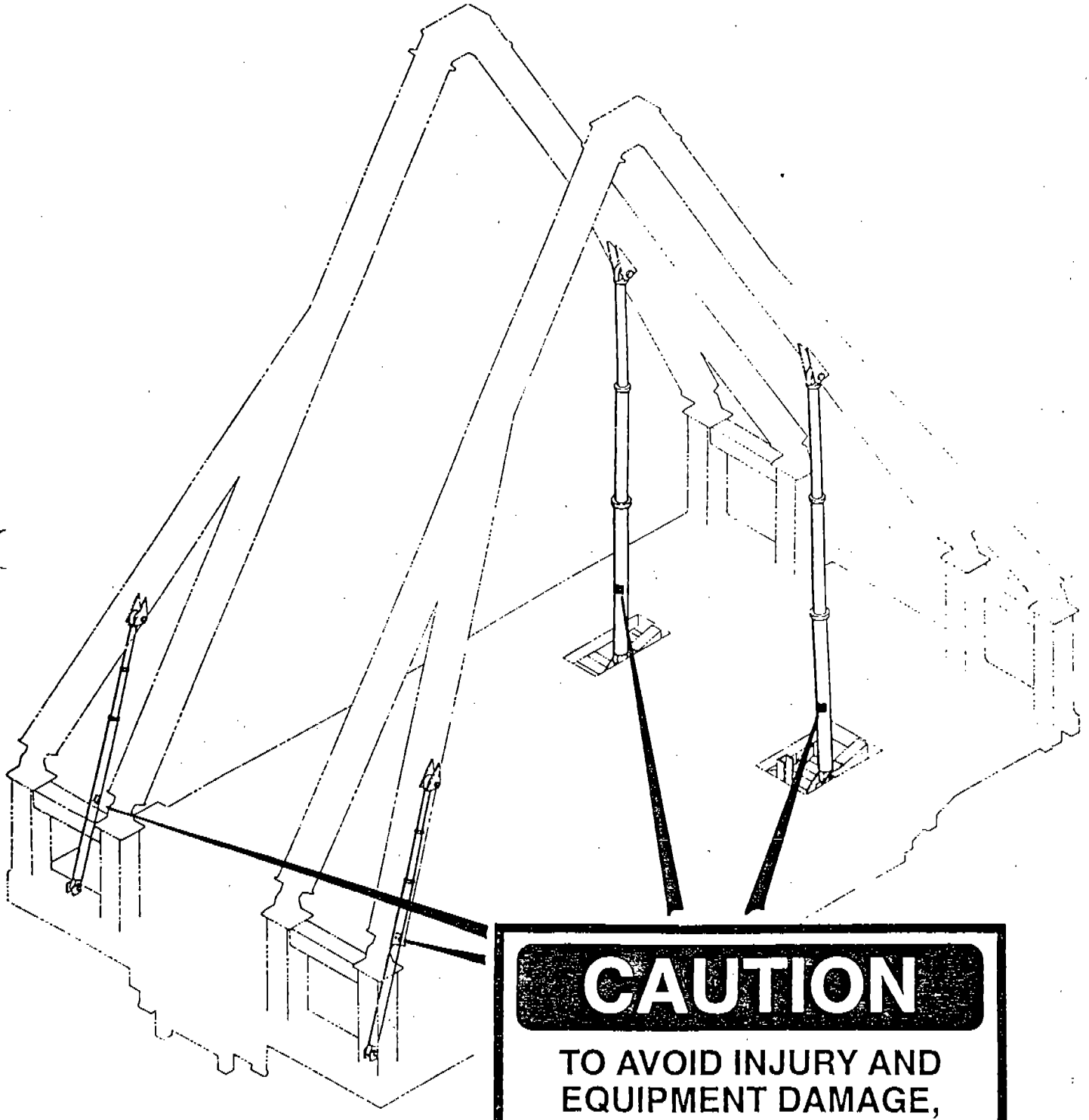
Use only those components authorized, specified or provided by Chance Rides, Inc.

Chance Rides, Inc. SPECIFICALLY DISCLAIMS ANY LIABILITY for losses associated with any unauthorized alterations and/or modifications or additions and installations of unauthorized components.

Factory and Sales Office: 4219 Irving · P.O. Box 12328 · Wichita, Kansas 67277-2328 · (316) 942-7411 · FAX: (316) 942-7416

INSTALLATION INSTRUCTIONS

1. Mount one on each of the tower lift cylinders.
2. Mount at eye level (approximately 5' above walkway) toward center of ride.



CAUTION

TO AVOID INJURY AND EQUIPMENT DAMAGE, RAISE FLOOR SECTION BEFORE LOWERING TOWER LEG

22198518

NUMBER: B400R1098-0

DATE: MAY 10, 1991

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Portable Units - Chance Rides, Inc.

Ride: GIANT WHEEL Subject: Warning Decal/Tape

Chance Rides, Inc. has added decals and tape to the GIANT GONDOLA WHEEL to alert individuals of the possible pinch points between the trailers as they are drawn together during set-up and around the hydraulic lift platform during installation of gondolas. Chance Rides, Inc. requires all owners of portable GIANT GONDOLA WHEEL amusement rides to order and install these warning items as outlined in this bulletin. Failure to comply with this bulletin could result in injury to personnel. All personnel must be made aware of potential pinch points and instructed to stay clear of these areas.

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.

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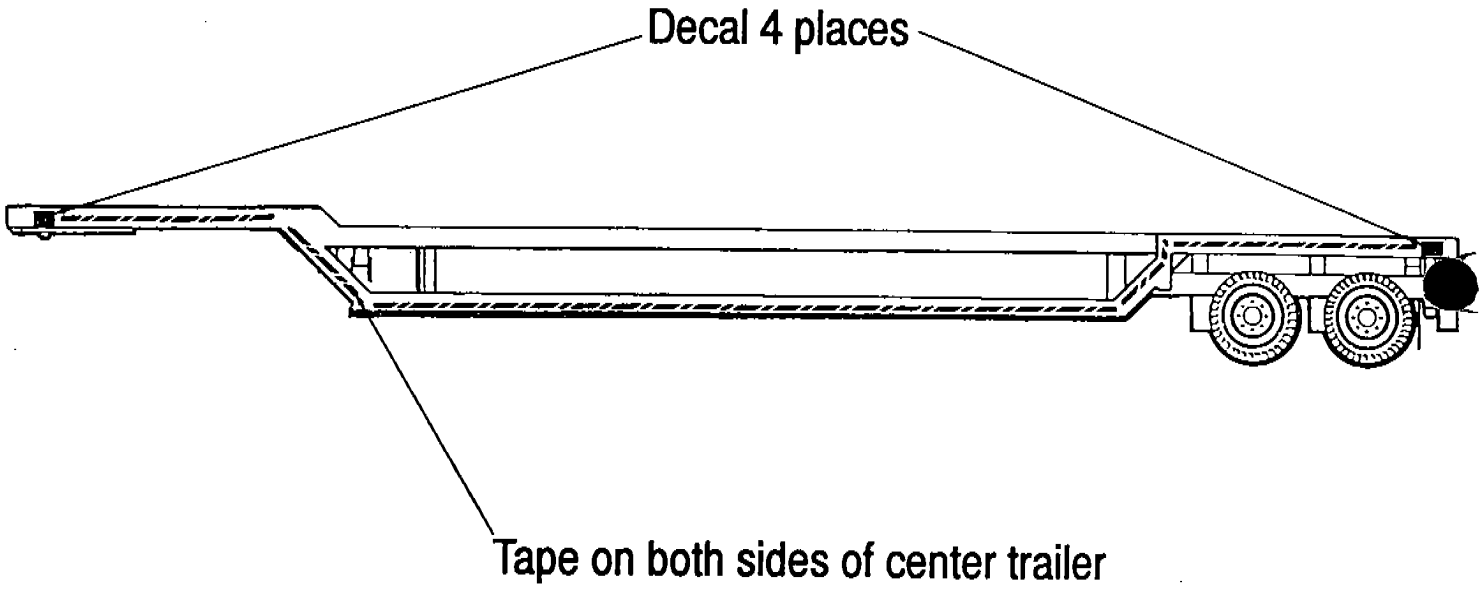
PARTS LIST

Item	Part Number	Description	Quantity
1.	26762500	Decal	8
2.	45001500	Tape	4 rolls

INSTALLATION INSTRUCTIONS

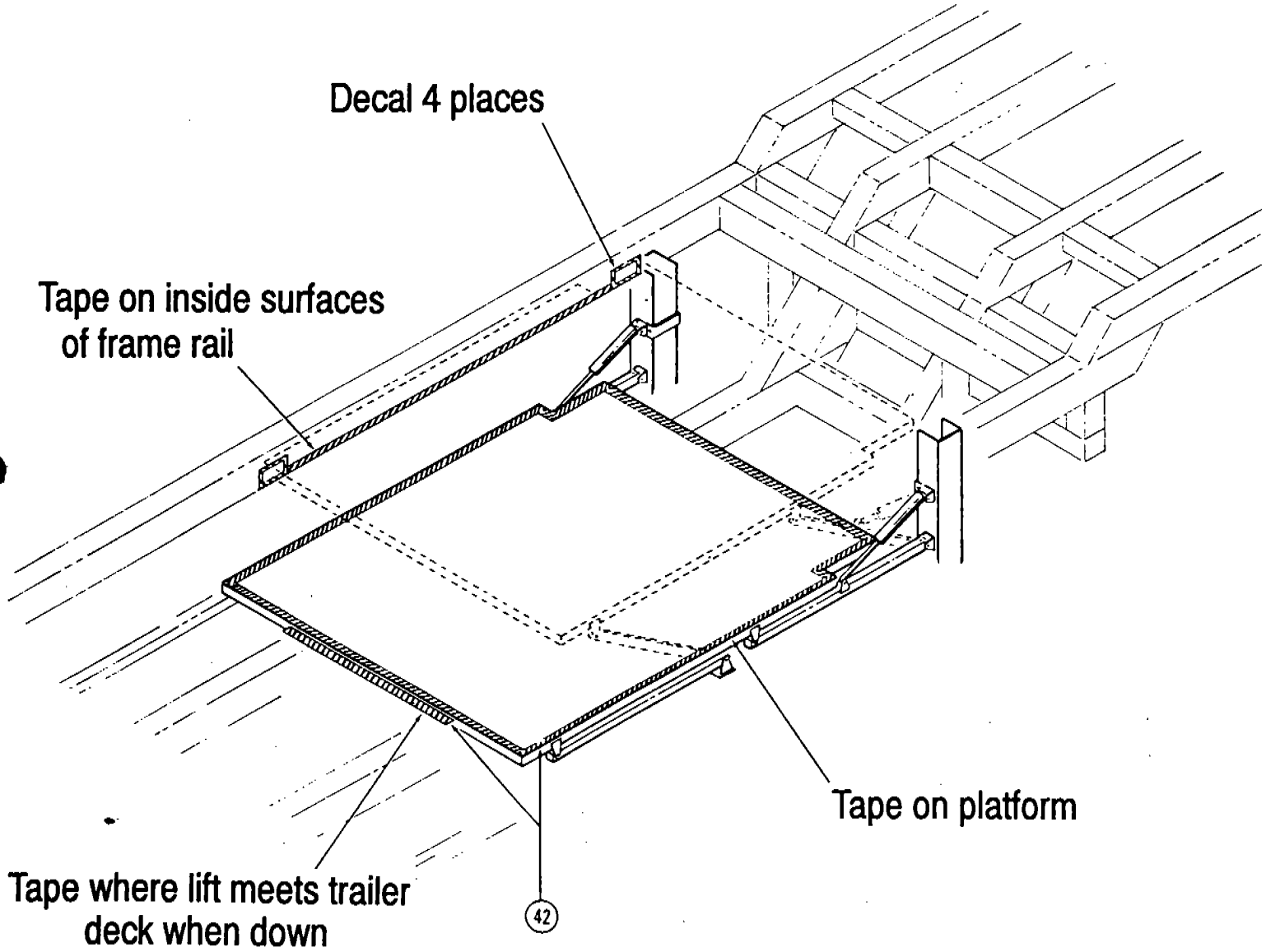
1. Apply one decal (item #1) to each of the four inside corners of the center trailer.

2. Apply tape (item #2) to both sides of the center trailer at areas where trailers come together.



3. Apply one decal (item #1) to the inside of the trailer frame at the four corners where the lift platform meets the trailer frame.

4. Apply tape (item #2) around top edge of lift platform and at points on trailer frame as shown.



[redacted]

Arcade

RECEIVED

APR 12 1994

BUREAU OF
FAIR RIDES INSPECTION

NUMBER: B400R1154-0

DATE: APR. 4, 1994

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Units

Ride: GIANT GONDOLA WHEEL Subject: Sweep and Spreader Lighting

Chance Rides, Inc. has become aware of at least one case in which all of the bases of the sweep lights enclosed by one light cover on the GIANT GONDOLA WHEEL amusement ride broke. When this occurred, the section fell from the ride.

Chance Rides, Inc. requires all owner/operators of the above noted amusement rides to follow the rework safety precautions in this Service Bulletin. Failure to follow the rework instructions outlined in this bulletin prior to the operation of the ride can result in injury to patrons and/or employees.

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.

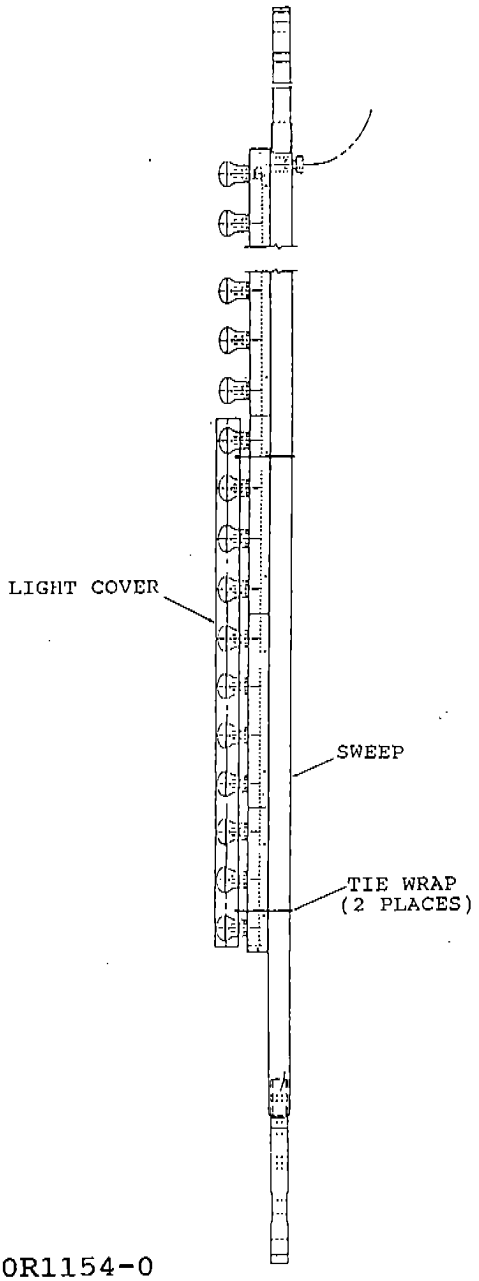
Factory and Sales Office: 4219 Irving · P.O. Box 12328 · Wichita, Kansas 67277-2328 · (316) 942-7411 · FAX: (316) 942-7416

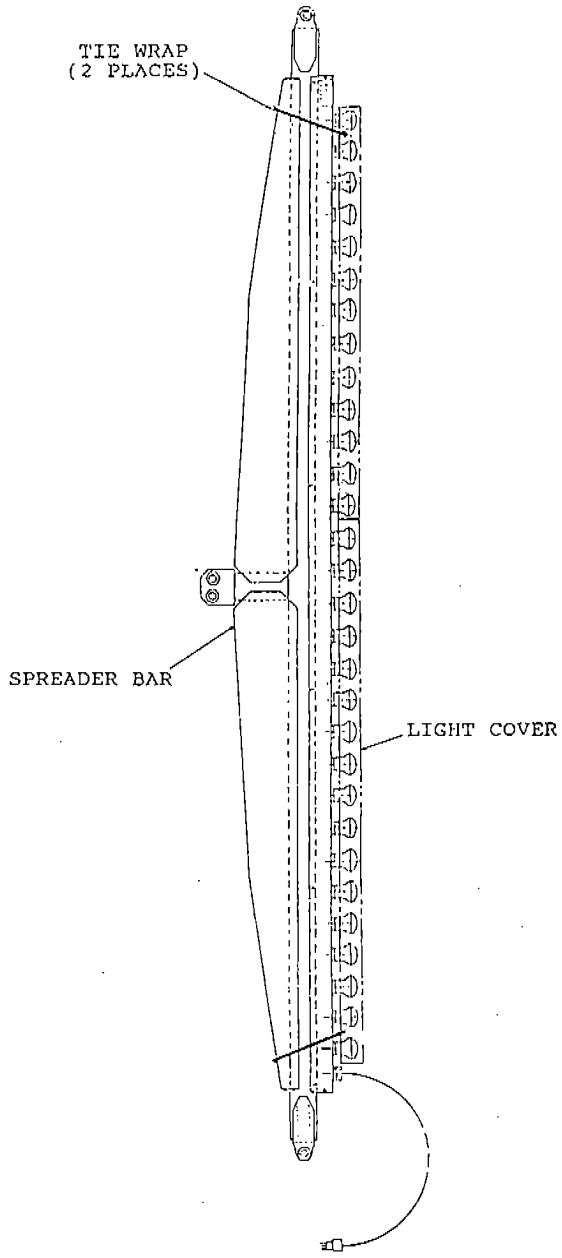
Rework Instructions

1. Remove the #10 x 2-1/4 long machine screw in the light covers located on each sweep.

2. Using 3/16 black tie wraps, secure the light covers to the sweeps. Insert one tie wrap through the holes where the machine screws were removed and fasten around the sweep. Secure each light cover at two locations. NOTE: If cover only contains one hole, drill a second hole at the opposite end of cover for the second tie wrap.

3. Perform the above steps on all spreader bar light covers as well as all sweep light covers.





Number: 400R1062-0

Date: April 16, 1990

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 400-001-88 through 400-018-90

Ride: GIANT GONDOLA WHEEL

Subject: PLC LIGHTING CONTROLLER BOX RECALL AND DECAL PLACEMENT

Chance Rides, Inc. has now improved the design of the PLC light controller box. All owners of GIANT GONDOLA WHEEL amusement rides with the above noted serial numbers are required to remove the PLC lighting controller box and return it to Chance Rides, Inc. for a factory rework.

Remove the PLC lighting controller box from the torque tube by following the instructions on the reverse side of this bulletin and as shown in illustration A. Failure to follow instructions on decals could result in electrical shock or damage to the PLC controller.

Included with the PLC lighting controller box when it is returned after the factory rework will be six CAUTION decals. These decals are to be positioned on the other six electrical boxes located on the torque tube as shown in illustration A.

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding this information, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

PLC LIGHTING CONTROLLER BOX REMOVAL PROCEDURE

1. Disconnect the four (4) electrical connectors from the box.
2. Carefully remove the four (4) bolts which hold the box in place on the torque tube.

Reverse procedure to install new PLC lighting controller box.

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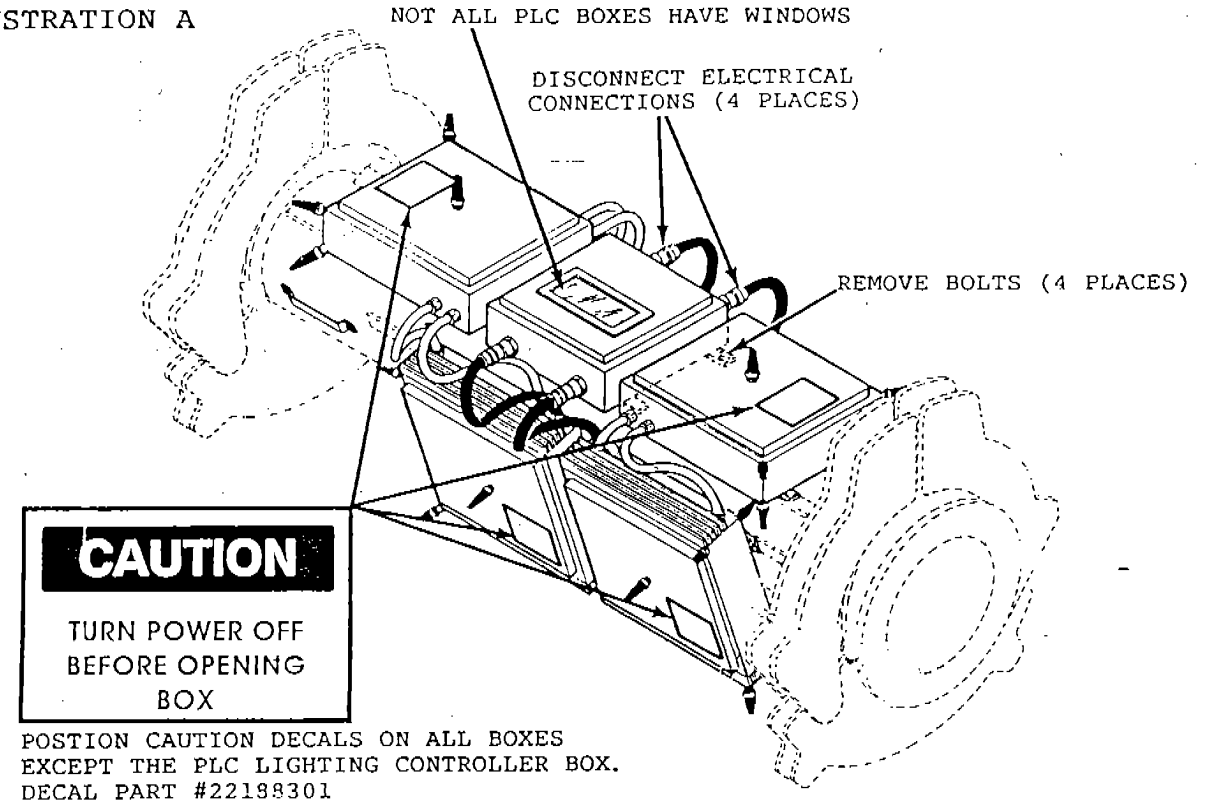
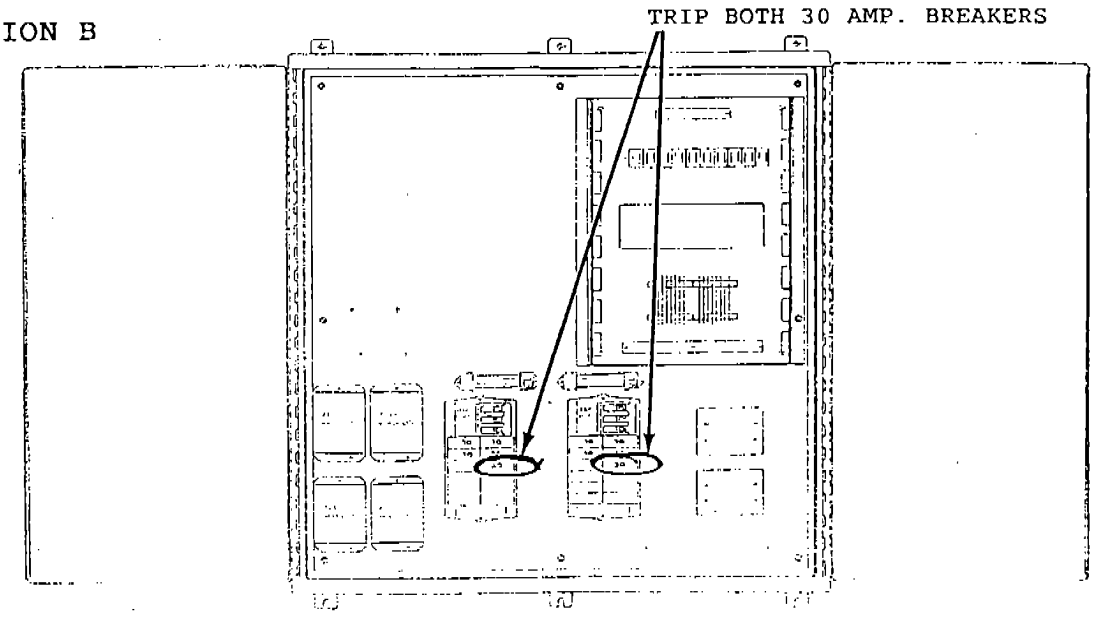
ILLUSTRATION A



POSTION CAUTION DECALS ON ALL BOXES
EXCEPT THE PLC LIGHTING CONTROLLER BOX.
DECAL PART #22188301

The new PLC lighting control box will be factory sealed and must NOT be opened by anyone other than a Chance Rides, Inc. representative. The lights can be turned on steady for purposes of checking light bulbs by turning off the two 30 amp. breakers in the main lighting control box, as shown in illustration B.

ILLUSTRATION B



Number: B400R1058-0

Date: Feb. 16, 1990

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: ALL UNITS

Ride: GIANT GONDOLA WHEEL

Subject: AXLE HUB REWORK

Chance Rides, Inc. has become aware that it is possible, if not properly torqued, for the bolts holding the axle to the hub on the GIANT GONDOLA WHEEL amusement ride to become loose. If these bolts are allowed to become loose they may work themselves out of the hub and could result in injury to passengers. A bolt keeper kit has been developed to securely hold the axle bolts to the proper torque of 800 foot pounds.

The owners of GIANT GONDOLA WHEELS as identified above are required to perform the rework described in this bulletin.

Perform the rework using the installation instructions on the reverse side of this bulletin and the parts contained in Kit No. K-400R1058-0. Each kit contains enough parts to rework one ride. Return the attached Certification of Compliance for the rework within fifteen (15) days from receipt of kit.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instruction or this rework contact the Chance Customer Service Department.

The following parts are included in Kit No. K400R1058-0. When ordering this kit, specify as to six bolt or ten bolt pattern.

Item No.	Part Number	Description	Qty Reqd. 6 Bolt Pattern	Qty Reqd. 10 Bolt Pattern
1	3-5358543	Keeper	24	40
2	3-6990400	Spacer	12	20
3	6-0844000	Hexhead Capscrew 1/2-13x4-1/4"	12	20
4	6-8553000	Washer 1/2"	24	40
5	6-4805000	Lock Nut 1/2-13	12	20

NOTICE

Use only those components authorized, specified or provided by the manufacturer. If any alterations and/or modifications or additions and installations of unauthorized components are made to the original design without the manufacturer's explicit written consent or without direct supervision by a manufacturer's representative, Chance Rides, Inc. makes no claim as to the integrity of the altered or modified ride.

Installation Instructions

1. Check each axle bolt with a torque wrench for 800 foot pounds.

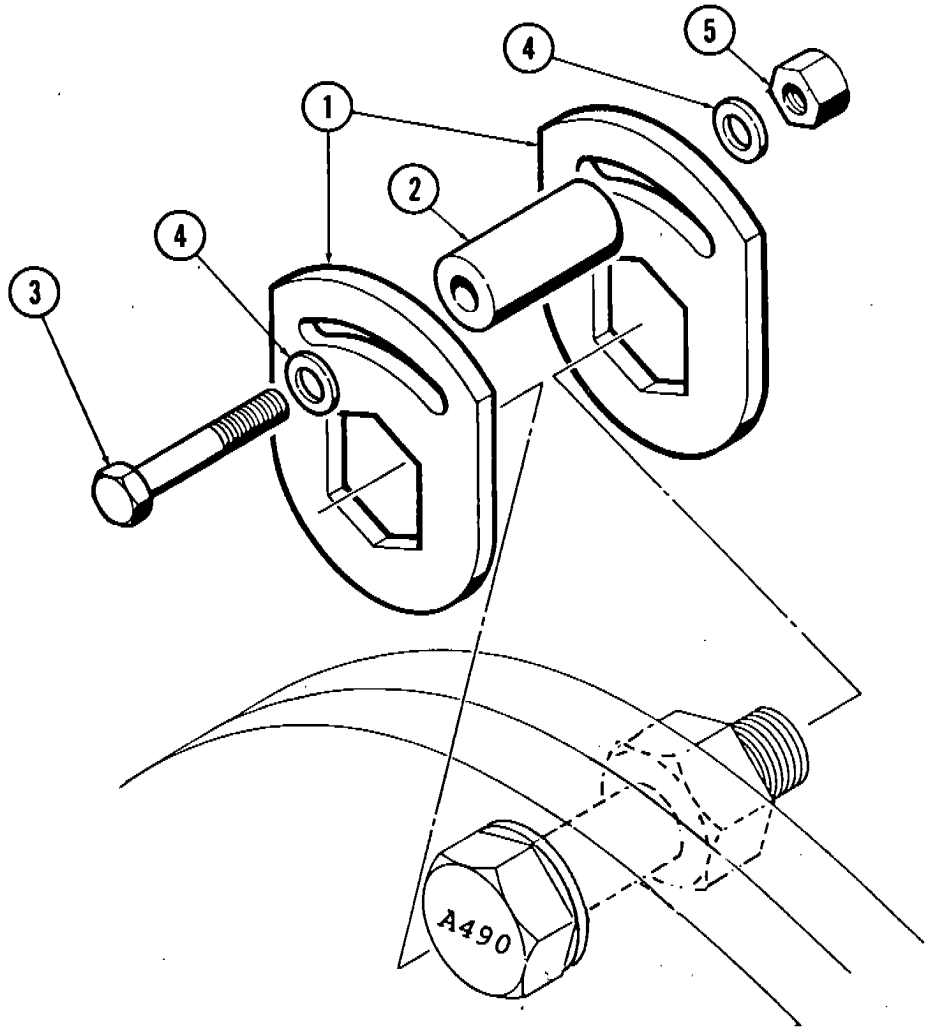
2. Place one keeper (item 1) over the axle bolt head and one keeper over the nut.

3. Insert the 1/2" Hexhead Capscrew (item 3) through the slot in the keeper, through the spacer (item 2) and through the other keeper.

4. Make sure washers (item 4) are installed as shown in the following illustration.

5. Secure the bolt with 1/2" locknut (item 5). Using a torque wrench, tighten nut to 55 foot pounds.

6. Install the rest of the keepers on both sides of the axle in the same manner.



Number: B400R1055-0

Date: Feb. 1, 1990

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: GIANT GONDOLA WHEEL Subject: PLATING ON GONDOLA STEM

It has come to the attention of Chance Rides, Inc. that there were some problems that developed during the plating process of the gondola stems. The result of this plating problem is external rusting and cosmetic only. It does not affect the integrity of the ride.

It does, however, cause a rusting discoloration of the gondola stem.

All GIANT GONDOLA WHEEL ride owners should inspect the stems for this rusting discoloration. If the problem exists, new stems may be ordered. When the original gondola stems have been returned to Chance Rides, Inc. full credit will be issued. Stems must be ordered within one year from the date of this bulletin to receive credit.

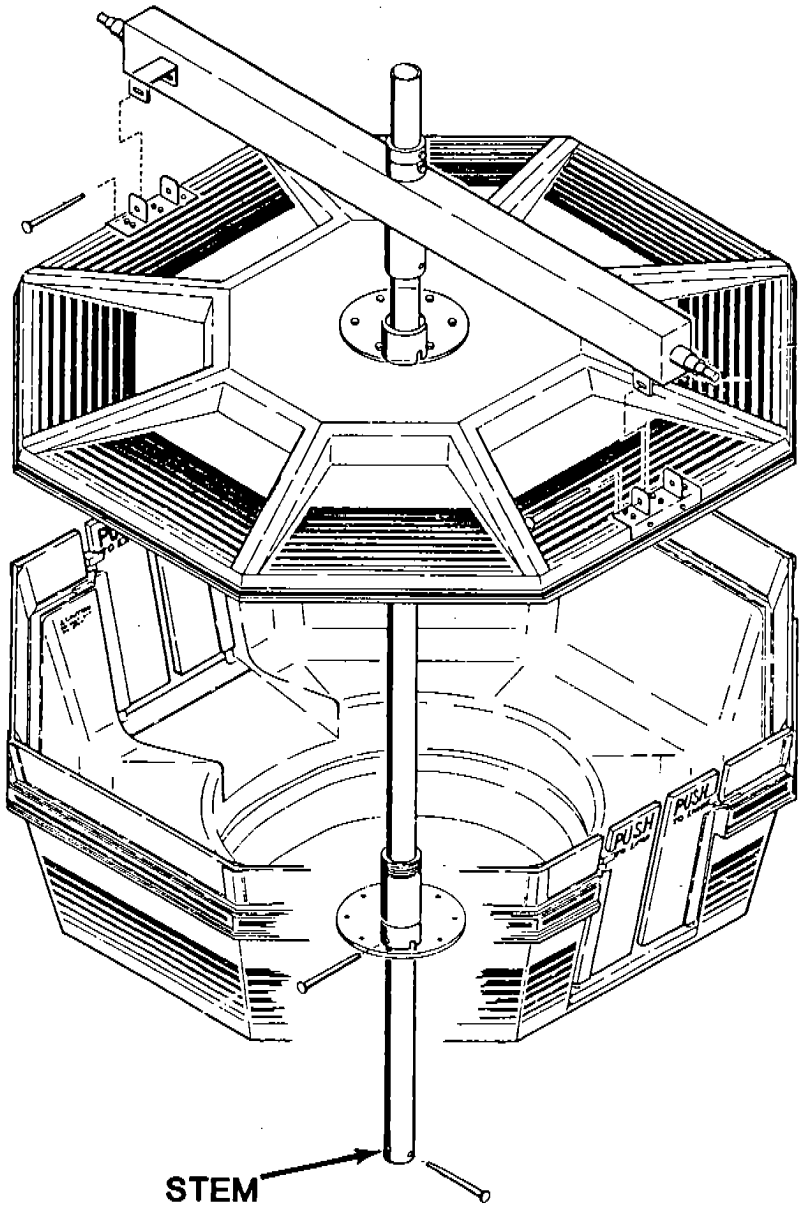
When ordering gondola stems, order part number 377-8262500.

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 the manufacturer. If any alterations and/or modifications or additions and installations of unauthorized components are made to the original design without the manufacturer's explicit written consent or without direct supervision by a manufacturer's representative, Chance Rides, Inc. makes no claim as to the integrity of the altered or modified ride.

If there are any questions regarding this inspection contact the Chance Rides Customer Service Department.


STEM

Number: B400R1054-0

Date: Jan. 19, 1990

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

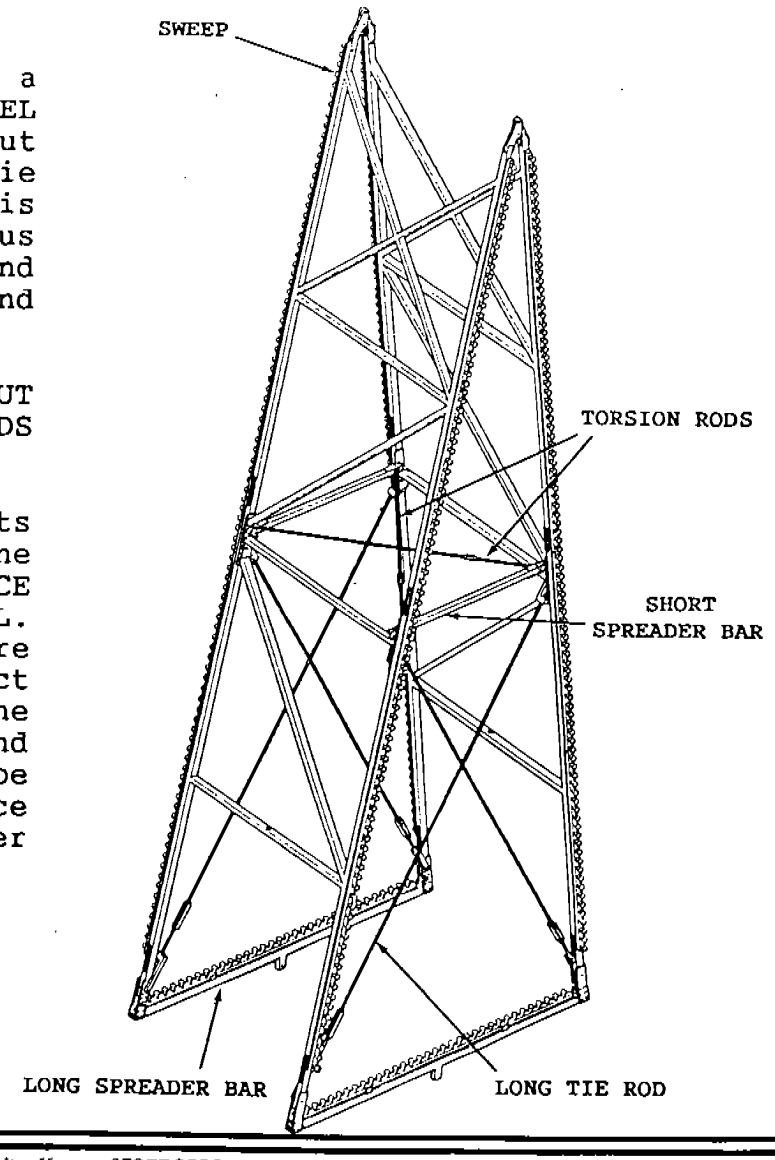
Ride: **GIANT GONDOLA WHEEL**

Subject: Tie Rod Installation

CHANCE RIDES, INC. has received a report of a GIANT GONDOLA WHEEL ride which was operated without first installing the long tie rods and torsion rods. This could have resulted in serious structural damage to the ride and possible injury to passengers and bystanders.

NEVER OPERATE THE RIDE WITHOUT THE TIE RODS AND TORSION RODS PROPERLY INSTALLED.

Always install these parts exactly as described in the set-up portion of the CHANCE OPERATION & MAINTENANCE MANUAL. The tie rods and torsion rods are necessary to maintain the correct shape and alignment of the wheel. All maintenance and set-up personnel must be instructed as to the importance of these parts and their proper installation.



Number: B400R1047-0

Date: July 17, 1989

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: **GIANT GONDOLA WHEEL** (Portable Model Only)

Subject: Trailer Leveling Instructions

Running a ride which is not properly leveled can cause stress on mechanical parts, reducing the service life of these parts. Damage can also occur to the gondolas, resulting in personal injury to passengers and/or bystanders.

The trailers for the portable model GIANT GONDOLA WHEEL are equipped with hydraulic cylinders and screw jacks for leveling the ride. Operation of these devices and proper blocking procedures are outlined in the CHANCE OPERATION AND MAINTENANCE MANUAL.

If soft ground conditions permit settling of the ride, or if the ride is improperly blocked or leveled, clearance can be reduced between the gondolas and the floors in the passenger loading areas.

Other evidence that the ride is not level is the position of the drive tires on the rim irons. Drive tires which are rubbing or are out of alignment are an indication that the trailers are not properly leveled.

DO NOT OPERATE A RIDE WHICH IS NOT PROPERLY BLOCKED OR THAT SHOWS EVIDENCE OF IMPROPER LEVELING. Reblocking and releveling the ride, as described in the CHANCE OPERATION AND MAINTENANCE MANUAL, is necessary before operation of the ride can resume.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

Number: B400R1046-A

Date: July 17, 1989

Supersedes: B400R1046-0

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: **GIANT GONDOLA WHEEL**

Subject: Gondola Door Adjustment

This bulletin supersedes Service Bulletin No. B400R1046-0. It is no longer in effect and should be destroyed.

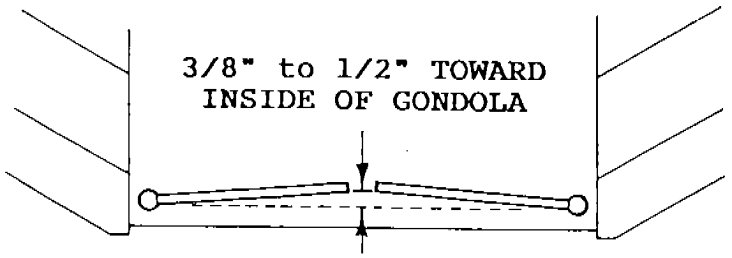
The gondola doors on the GIANT GONDOLA WHEEL will not operate properly if they are not correctly adjusted. Inspect both sets of doors on each gondola in the closed position. If the doors are not within the tolerances given below, perform the adjustment procedure that follows to properly locate the doors. The doors must be inspected weekly or at every set-up, whichever occurs first.

All work must be performed by competent, qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this inspection, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

Inspection

RIDE SERIAL NUMBERS 400-001-88 THROUGH 400-012-89

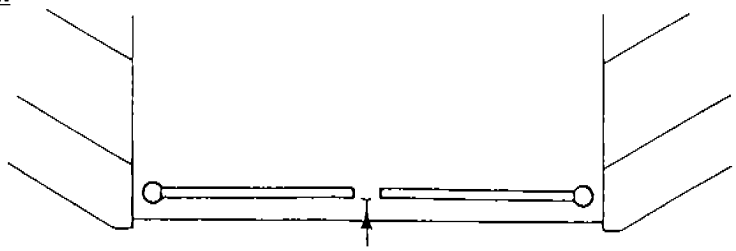
With the doors closed, and the cam pin against the stop bolt, check the alignment of the door panels. The doors must be angled slightly toward the center of the gondola as shown, not flush with each other.



If adjustment of the doors is required, follow the procedure on the reverse side of this bulletin.

RIDE SERIAL NUMBERS 400-013-89 AND ON

With the doors closed, and the cam pin against the stop bolt, check the alignment of the door panels. The doors must be flush with each other.



DOORS FLUSH WITH EACH OTHER

If adjustment of the doors is required, follow the procedure on the reverse side of this bulletin.

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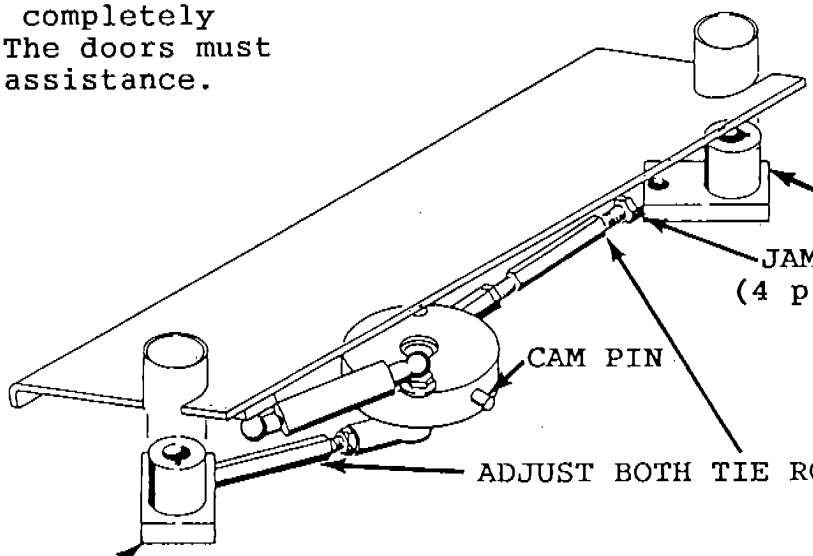
Adjustment

If adjustment of the doors is required, remove the access panel and adjust the length of the tie rods. Loosen jam nuts and turn the rod to shorten or lengthen both tie rods as required. Tighten jam nuts and replace the access panel.

Open the doors completely and release. The doors must close without assistance.



RIGHT HAND CRANK, Part No. 32080100
(Serial No. 400-001-88 through 400-012-89)

RIGHT HAND CRANK, Part No. 32080400
(Serial No. 400-013 and on)

LEFT HAND CRANK, Part No. 32080100
(Serial No. 400-001-88 through 400-012-89)

LEFT HAND CRANK, Part No. 32080300
(Serial No. 400-013 and on)

Number: B400R1045-0

Date: June 22, 1989

Supersedes:

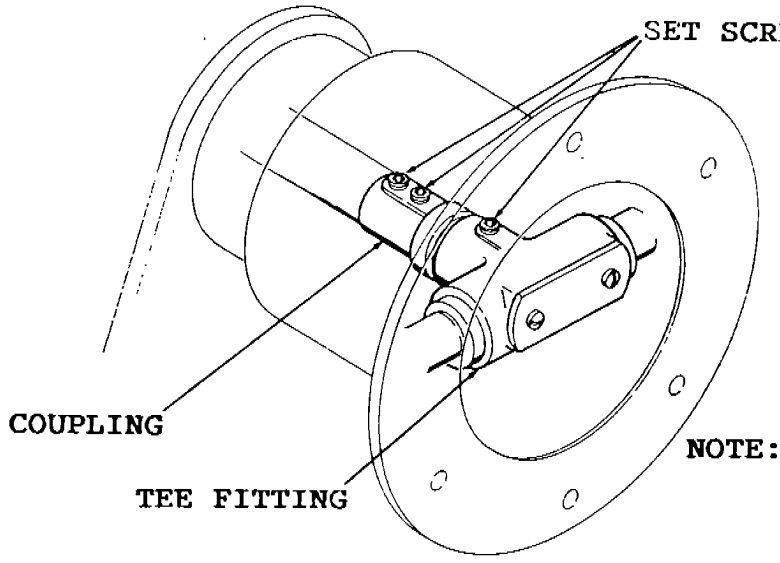
America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 400-001-88 through 400-005-88

Ride: **GIANT GONDOLA WHEEL** Subject: Axle Conduit Coupling Check

The axle hubs on the GIANT GONDOLA WHEEL are fitted with conduit to route electrical wiring to the collector rings. A metal coupling connects the collector ring axle to a tee fitting on each axle hub as shown below.



NOTE: Remove plexiglass covers as necessary to gain access to the coupling and tee.

The set screws which secure the coupling and/or tee can become loose after extended operation, causing damage to the wiring. To prevent this, check the set screws at each set up to be sure they are tight. DO NOT OVER-TIGHTEN.

If a loose set screw is found, inspect the wiring for indications of twisting or damage. Make sure the set screws in the coupling are fully engaged in the keyway in the collector ring axle.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this inspection, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

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Number: B400R1043-0

Date: July 17, 1989

Supersedes:

America's Largest Manufacturer of Amusement Rides

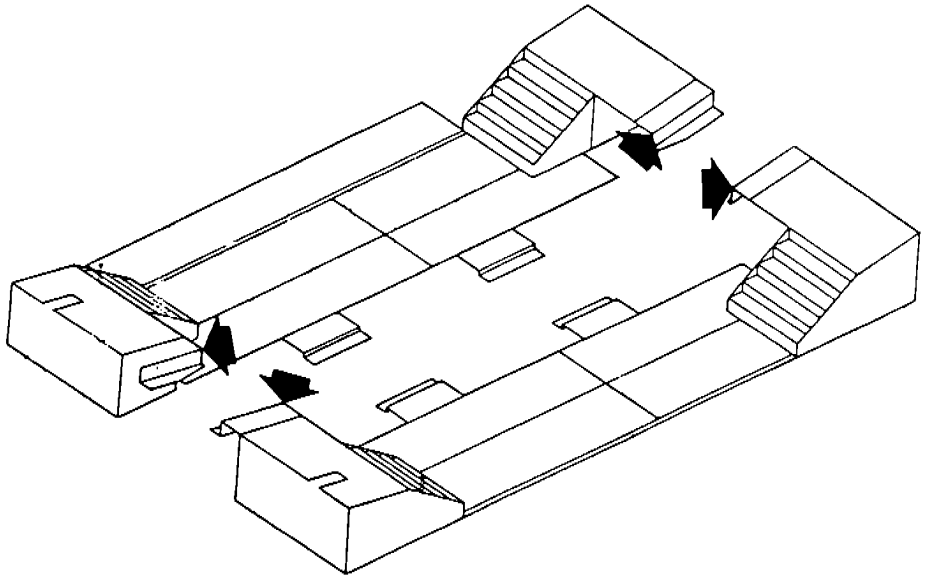
SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: **GIANT GONDOLA WHEEL** (Portable Model Only)

Subject: Floor Rework

The GIANT GONDOLA WHEEL is equipped with floor extensions in the passenger loading areas. When wind conditions cause the gondolas to swing, they can contact the floor sections shown below.



A rework has been designed to provide additional clearance between the gondolas and these floor sections. CHANCE RIDES, INC. REQUIRES ALL OWNERS OF PORTABLE MODEL GIANT GONDOLA WHEEL AMUSEMENT RIDES TO PERFORM THIS REWORK.

Use the procedure on the reverse side of this bulletin for the rework. Return the attached Certification Of Compliance within fifteen (15) days from receipt of this bulletin.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

REWORK INSTRUCTIONS

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

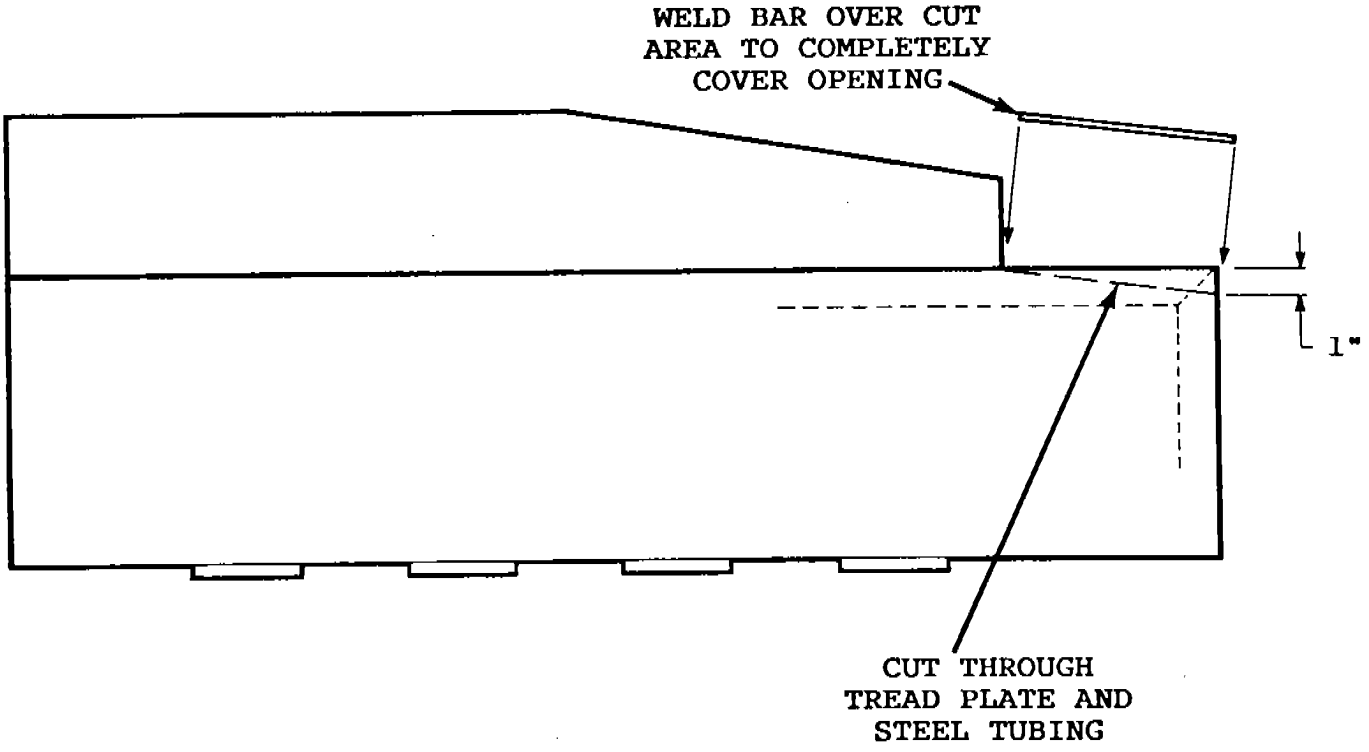
1. Remove the four floor sections shown on the previous page.

2. Mark the floor and cut as shown. Cut through the aluminum tread plate and the steel tubing.

3. Remove enough rivets to separate the aluminum tread plate from the steel tubing in the cut area. Weld a 1/8 x 1-7/8 bar to cover the cut area completely.

4. Paint the repaired area and rivet the tread plate in place.

5. Repeat the procedure for the other three floor sections.



Number: B400R1038-0

Date: May 25, 1989

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: **GIANT GONDOLA WHEEL**

Subject: Hydraulic Leveling Cylinder Plumbing Rework

Each trailer for the portable model GIANT GONDOLA WHEEL has four hydraulic leveling cylinders. If there is any leakage in the hydraulic system, the rod can lower, due to gravity and the weight of the rod. If this happens during transport of the ride, contact of the piston rod with the pavement can cause serious damage.

CHANCE RIDES, INC. has developed a plumbing rework kit to positively block the flow of hydrauic oil to and from the cyliners.

ALL OWNERS OF **GIANT GONDOLA WHEEL** AMUSEMENT RIDES ARE REQUIRED TO PERFORM THIS REWORK.

Install the kit using the instructions on the following pages of this bulletin and the parts provided. Return the attached Certification Of Compliance for the rework within fifteen (15) days from receipt of this bulletin.

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

PARTS LIST

The following parts are included in Kit No. K400R1038-0:

Item No.	Part Number	Description	Qty. Reqd.
1.	290-8441000	VALVE - Shut-Off	12
2.	685-0018600	FITTING - Adapter	12

INSTALLATION INSTRUCTIONS

1. Extend the hydraulic leveling cylinders until they almost touch the base plate. All pressure must be releived from the hydraulic system, and no weight should be on the cylinders. Remove the tube and elbow from the lower port (rod end) of the cylinder.

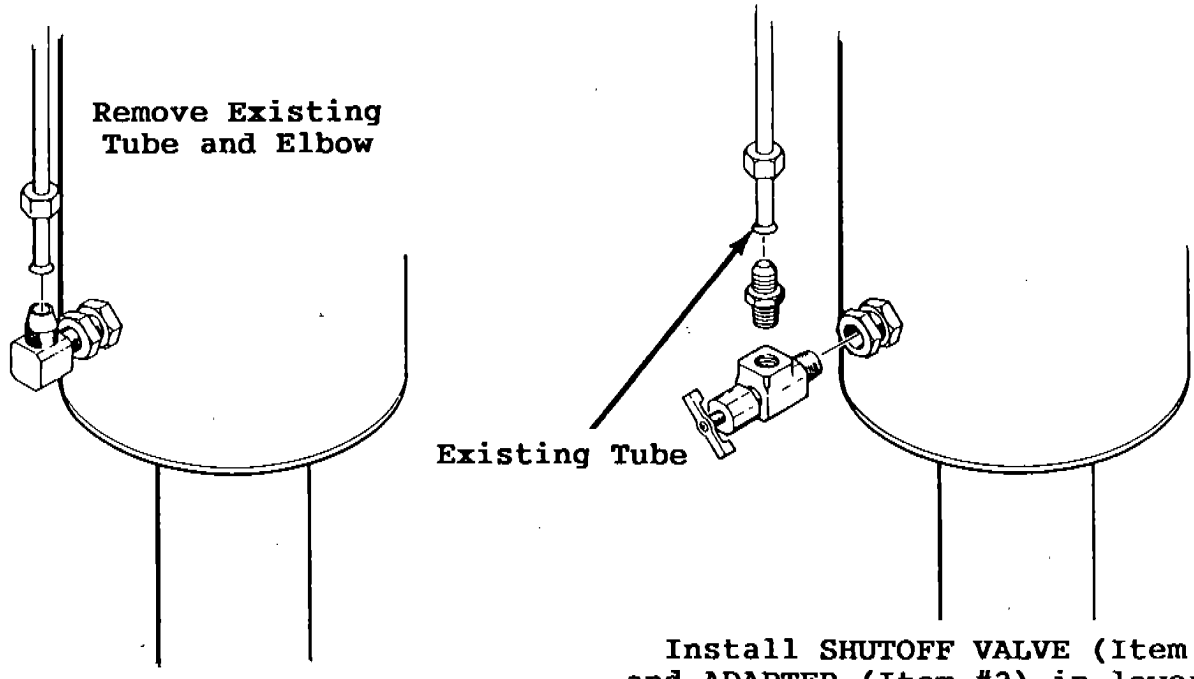
> **WARNING: THE HYDRAULIC CYLINDERS MUST BE EXTENDED, WITH NO WEIGHT ON THE CYLINDERS AND ALL PRESSURE RELIEVED FROM THE HYDRAULIC SYSTEM.**
>
> **IF ANY PLUMBING IS LOOSENED WITH THE WEIGHT OF THE RIDE ON THE HYDRAULIC CYLINDERS, THE RIDE CAN TIP, CAUSING SERIOUS PERSONAL INJURY.**

2. Install the shut-off valve (Item #1) and adapter (Item #2) into the cylinder port. Reinstall the tube.

3. Repeat the procedure on the other eleven (11) leveling cylinders.

4. Check and fill the hydraulic reservoir to replace lost oil.

5. When transporting the ride, all shut-offs must be in the CLOSED position (tightened clockwise). Always open the valves after the ride is in position and ready for set-up.



Install SHUTOFF VALVE (Item #1) and ADAPTER (Item #2) in lower port of hydraulic leveling cylinder

NUMBER: B400R1036-A

DATE: AUGUST 17, 1990

SUPERSEDES: B400R1036-0

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Units

Ride: GIANT GONDOLA WHEEL

Subject: Inspection of Torque Tube Fasteners

Service Bulletin Number B400R1036-0 has been superseded by this Service Bulletin and is no longer in effect. All copies of Service Bulletin B400R1036-0 should be destroyed.

The torque tube to tower head joint on the GIANT GONDOLA WHEEL amusement ride was designed with sufficient clamping force being achieved when each of the bolts in the joint is torqued from a 700 minimum to 850 maximum foot pounds. Chance Rides, Inc. requires all owner/operators of GIANT GONDOLA WHEELS to use a torque wrench to verify that the proper torque has been applied to each of these bolts at every set up or once each operating season, whichever occurs first.

A new decal, reflecting this 700 to 850 foot pound range, is now available. When replacing the old decal, the new one should be placed directly over the old one. Refer to the installation instruction on the reverse side of this bulletin.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding this bulletin or the instructions contained in it, contact the CHANCE RIDES, INC. CUSTOMER SERVICE DEPARTMENT.

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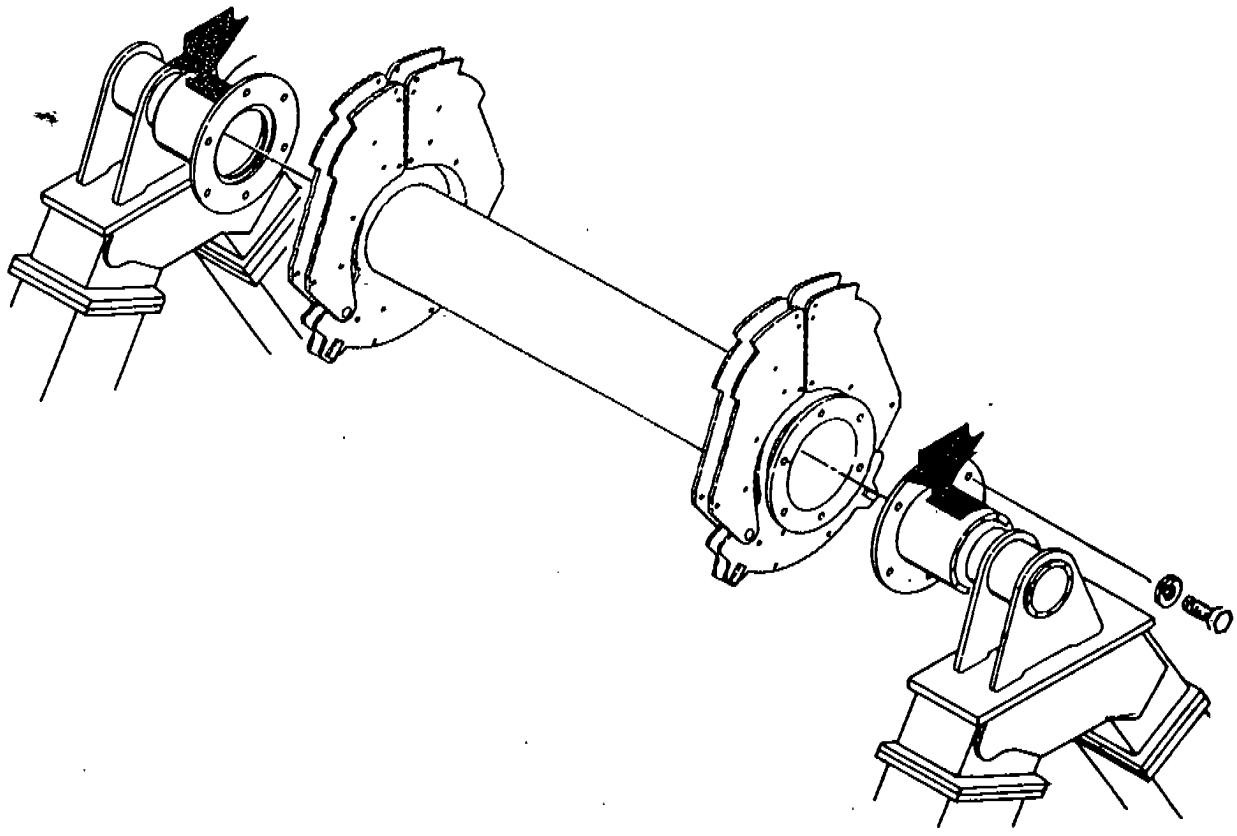
Item No.	Part Number	Description	Qty. Reqd.
1.	277-2192901	DECAL - Capscrew Tightening (400-341-001) . . .	2
2.	277-2192902	DECAL - Capscrew Inspection (400-342-001) . . .	2

INSTALLATION INSTRUCTIONS

1. Install one of decal (Item #1) on each bearing housing as shown, so that it is visible with the tower legs DOWN. Apply the new decal directly over the top of the old decal.

⚠ WARNING ⚠

TIGHTEN THE CAPSCREWS FOR THE TORQUE TUBE TO 700-850 FT-LBS. BEFORE ERECTING THE TOWER LEGS. FAILURE TO DO SO CAN CAUSE STRUCTURAL FAILURE AND RESULT IN SERIOUS INJURY TO PASSENGERS AND/OR BYSTANDERS.

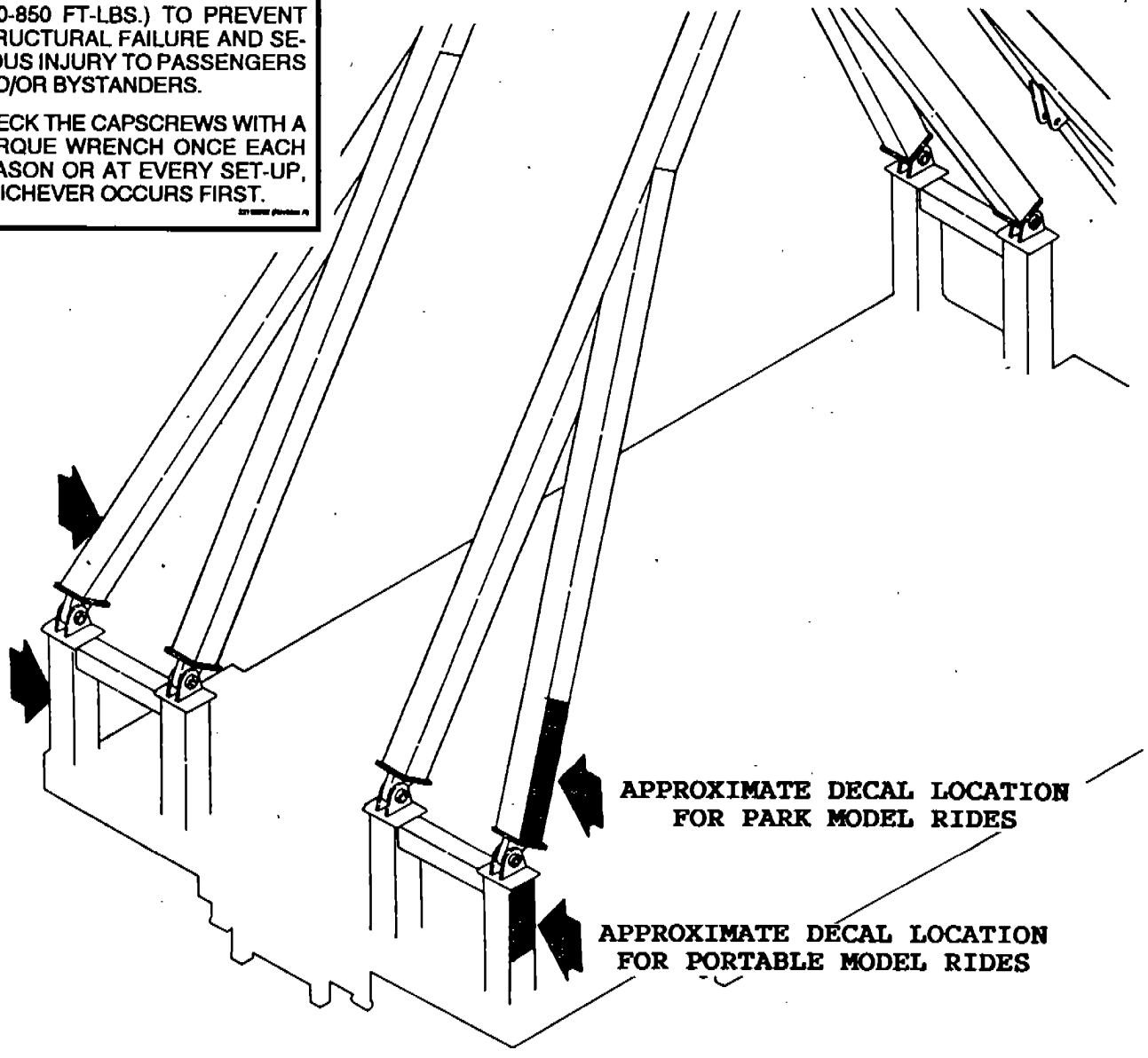


2. Install one decal (Item #2) on each tower leg as shown, so that it is easily visible by maintenance and inspection personnel. Apply the new decal directly over the top of the old decal.

⚠ WARNING ⚠

THE CAPSCREWS FOR THE TORQUE TUBE MUST BE TIGHT (700-850 FT-LBS.) TO PREVENT STRUCTURAL FAILURE AND SERIOUS INJURY TO PASSENGERS AND/OR BYSTANDERS.

CHECK THE CAPSCREWS WITH A TORQUE WRENCH ONCE EACH SEASON OR AT EVERY SET-UP, WHICHEVER OCCURS FIRST.



Number: B400R1035-0

Date: March 22, 1989

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 400-001-88 through 400-004-88 and 400-006-89

Ride: **GIANT GONDOLA WHEEL**

Subject: Hydraulic Cylinder Rework For Adjustable Long Spreader Bars

It has come to the attention of CHANCE RIDES, INC. that the hydraulic cylinders in the adjustable long spreader bars can develop leaks around the barrel. A new barrel and related cylinder parts have been designed to eliminate this leakage.

ALL OWNERS OF **GIANT GONDOLA WHEEL** AMUSEMENT RIDES WITH THE ABOVE NOTED SERIAL NUMBERS ARE REQUIRED TO PERFORM THE REWORK DESCRIBED IN THIS BULLETIN.

Perform the rework using the installation instructions on the following pages of this bulletin and the parts provided. Return the attached Certification Of Compliance for the rework within fifteen (15) days from receipt of this bulletin.

NOTE: Ride serial number 400-001-88 is provided with kit number K400R1035-1. The other rides noted above are provided with kit number K400R1035-2.

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

The following parts are included in Kit No. K400R1035-1:
(Ride Serial Number 400-001-88 Only)

Item No.	Part Number	Description	Qty. Reqd.
--	377-0415800	HYDRAULIC SPREADER BAR (400-244-001)	2

The following parts are included in Kit No. K400R1035-2:
(Ride Serial Numbers 400-002-88 through 400-004-88 and 400-006-89)

Item No.	Part Number	Description	Qty. Reqd.
1	377-2159800	BARREL - Spreader Cylinder (400-232-001) . . .	2
2	377-5286900	RING - Piston	2
3	290-6114500	O-RING	4
4	290-8556900	WASHER - Back-Up	4

INSTALLATION INSTRUCTIONS

IMPORTANT: The following procedure requires that the ride be disassembled to the point that the adjustable long spreader bars are removed. Use the reverse of the "Set-Up Procedure" in the CHANCE Operation Manual.

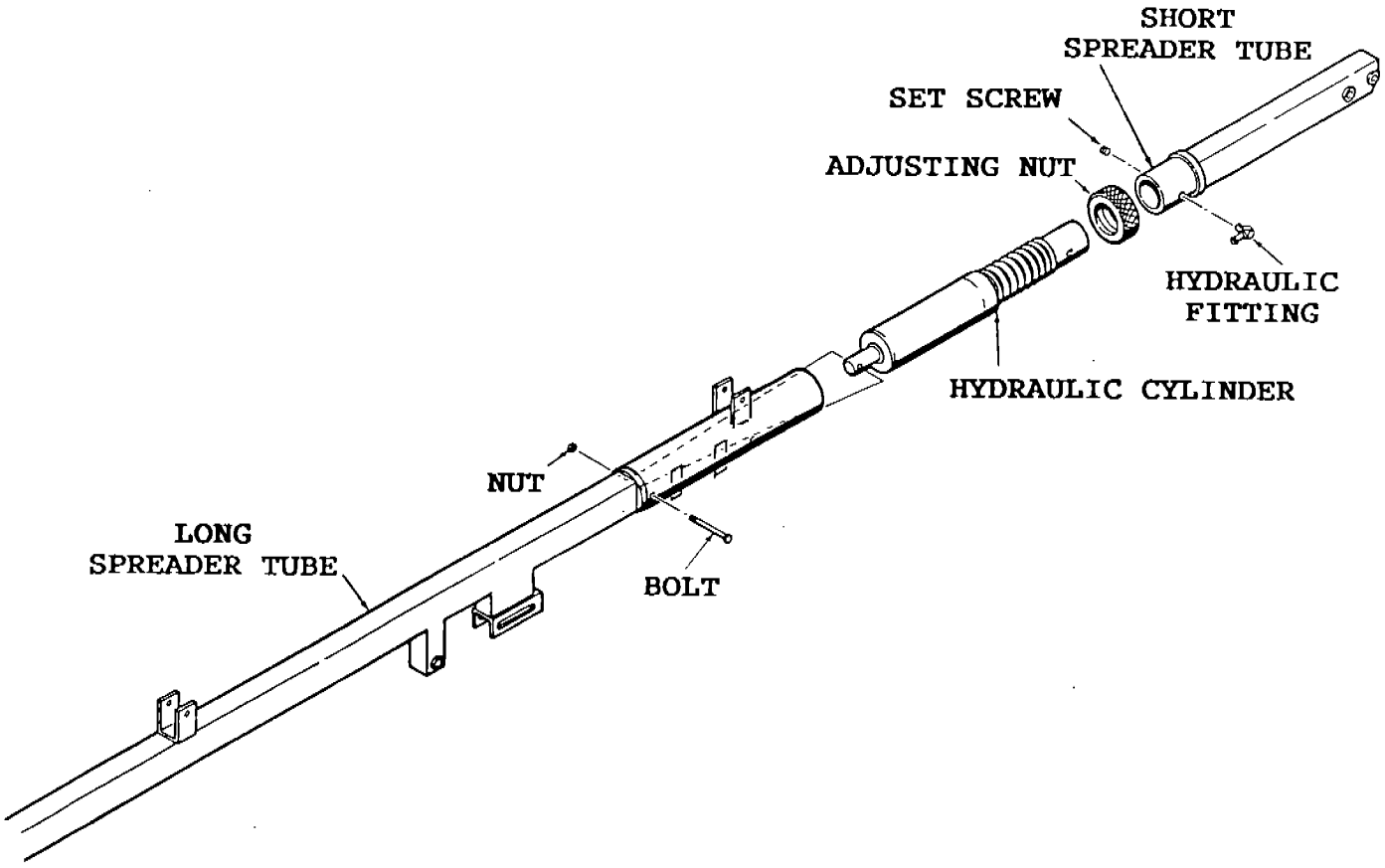
NOTE: On ride serial number 400-001-88, perform only Steps #1 and #9, replacing the entire adjustable spreader bar.

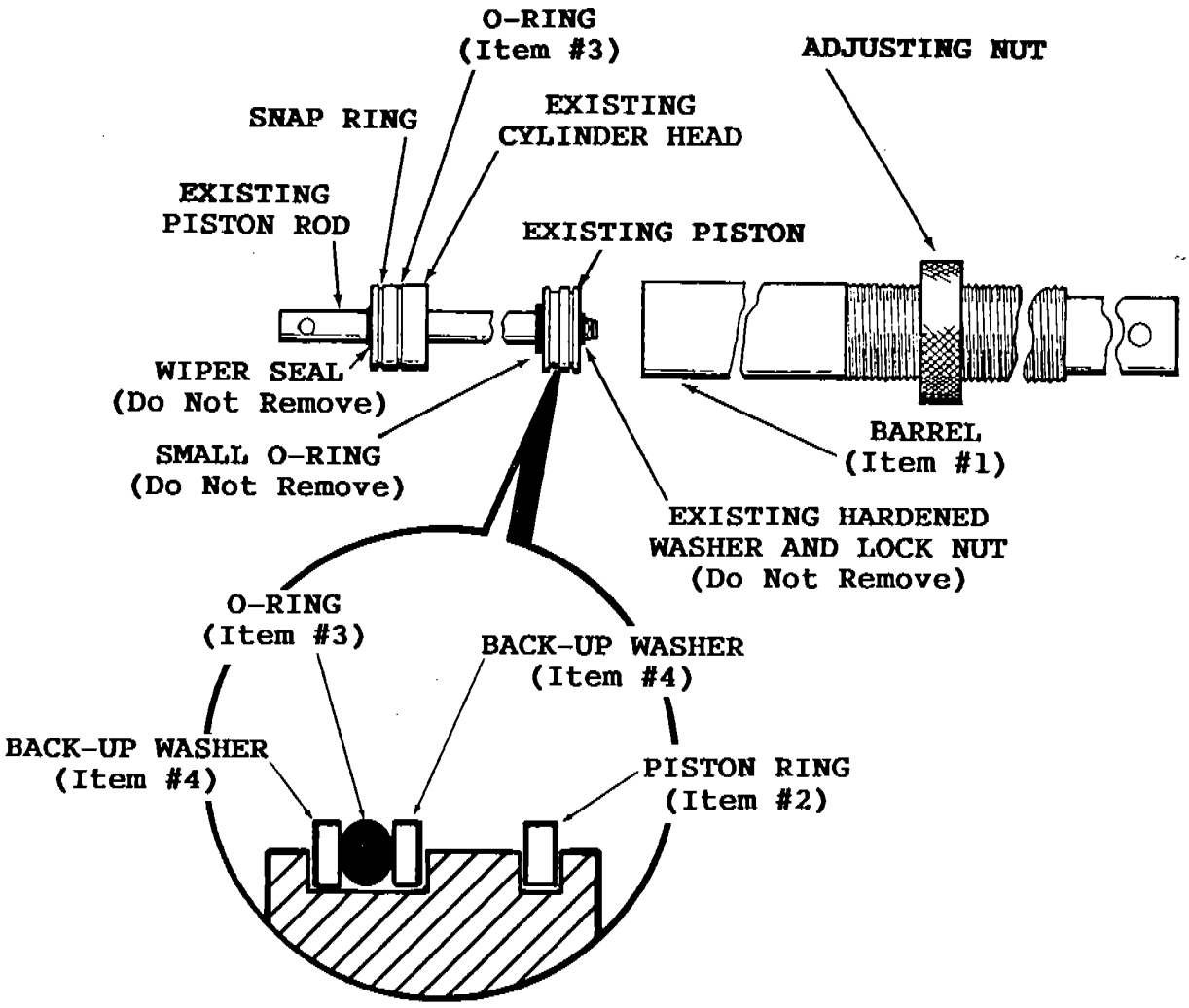
1. With the adjustable spreader bars removed from the ride, remove the bolt and nut from the rod end of the cylinder. Remove the hydraulic fitting and loosen the set screw from the other end.

2. Remove the hydraulic cylinder from the spreader bar.

NOTE: Remove the adjusting nut from the old cylinder barrel and keep it to install on the new barrel.

3. Remove the snap ring and disassemble the cylinder. Leave the cylinder head (gland), piston rod and piston assembled. Save these parts and the snap ring. Discard the old barrel and seals, except for the small O-ring and the wiper seal.





4. Install one O-ring (Item #3) on the existing cylinder head.

IMPORTANT: Lubricate all parts, including the seals, with petroleum jelly. Be careful not to damage the seals or scratch any parts when assembling them.

5. Assemble one O-ring (Item #3), two back-up washers (Item #4), and the piston ring (Item #2) on the piston.

6. Install the piston rod assembly into the barrel. Secure the cylinder head into the barrel with the existing snap ring.

7. Install the reworked cylinder into the spreader tubes. Install the bolt and nut to secure the rod end of the cylinder to the long spreader tube.

8. Align the port with the hole on the short spreader tube and install the hydraulic fitting. Tighten the set screw.

9. Install the spreader bar assembly using the "Set-Up Procedure" in the Operation Manual.

Number: B400R1031-0

Date: Nov. 17, 1988

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: All Units

Ride: GIANT GONDOLA WHEEL

Subject: Inspection Of Fasteners For T-Bar Bearing Blocks

It has been determined by CHANCE RIDES, INC. that the fasteners between the T-bar bearing blocks and the sweeps on the GIANT GONDOLA WHEEL must be checked for tightness on a regular basis. If the fasteners become loose, the T-bar can come loose, resulting in possible injury to passengers.

The owners of the above noted **GIANT GONDOLA WHEEL** amusement rides are therefore required to inspect their rides as described in this bulletin. Perform the inspection using the instructions on the reverse side of this bulletin.

The inspection must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this inspection, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

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INSPECTION PROCEDURE

Use a torque wrench to check the tightness of ALL fasteners exacty as described in the following procedure.

1. Check for 50-60 ft-lb torque on the four lower capscrews.

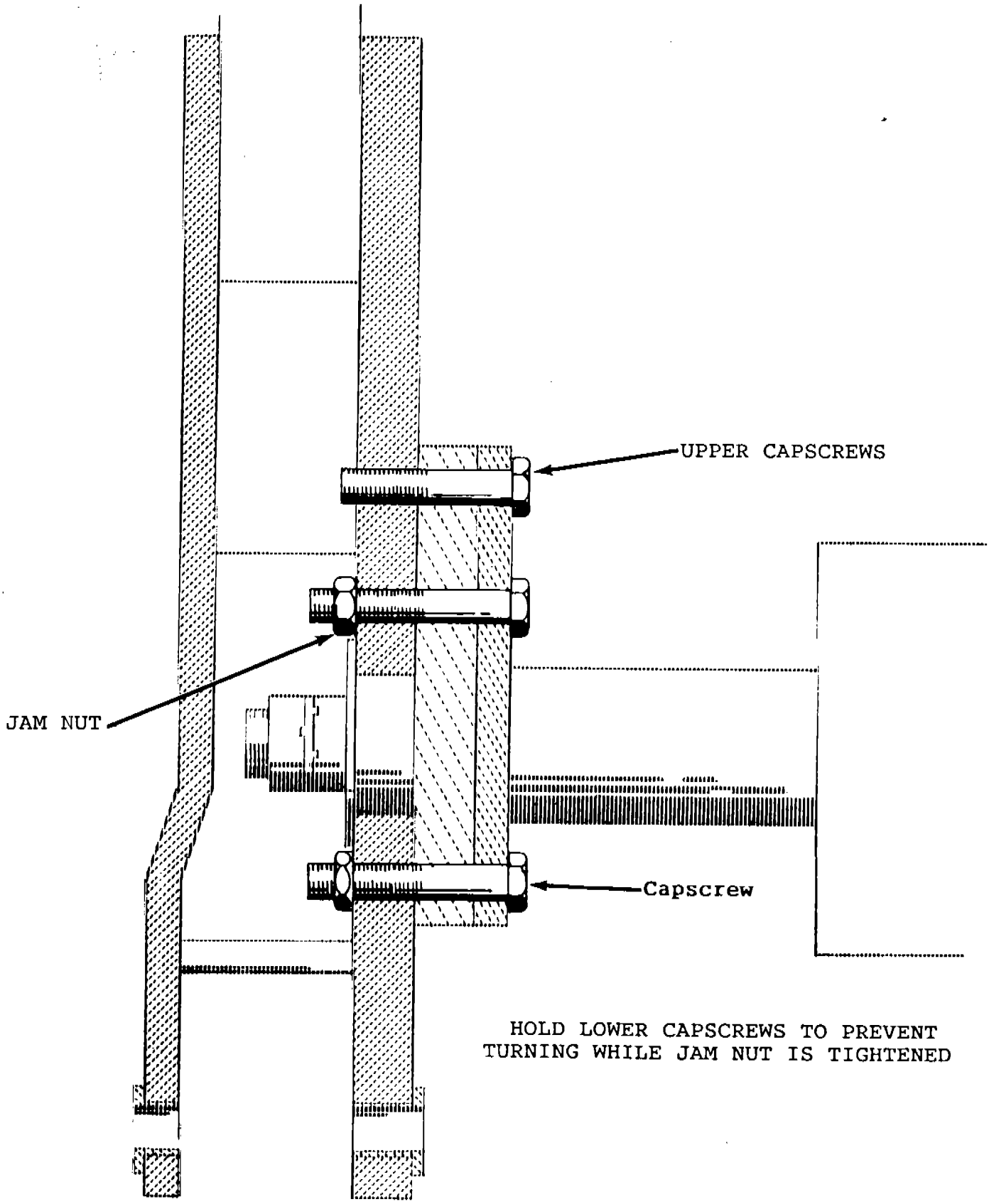
2. While holding the capscrews with a wrench to prevent turning, check for 43-51 ft-lb torque on the jam nuts inside the sweep ears.

   IMPORTANT: THE CAPSCREW MUST NOT TURN WHEN TIGHTENING THE JAM NUT.

3. Check for 50-60 ft-lb torque on the two upper capscrews.

4. Repeat Steps #1 and #2 on the remaining 39 bearing blocks.

5. Perform this inspection monthly, or at every other set-up.



HOLD LOWER CAPSCREWS TO PREVENT
TURNING WHILE JAM NUT IS TIGHTENED

Number: B400R1030-0

Date: Nov. 30, 1988

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 400-001-88 and 400-002-88

Ride: **GIANT GONDOLA WHEEL**

Subject: Retainer Clips For Rim Iron Light Bar Jumper Cables

It has come to the attention of CHANCE RIDES, INC. that, during operation of the GIANT WHEEL, the jumper cables between the rim iron light bars can come in contact with the T-bars and gondola canopies, causing abrasion of the insulation on the cables.. If the wear is severe enough, an electrical shock hazard can result. A retainer clip has been developed to securely hold the jumper cables away from moving parts.

THE OWNERS OF **GIANT GONDOLA WHEEL** AMUSEMENT RIDES WITH THE ABOVE NOTED SERIAL NUMBERS ARE REQUIRED TO PERFORM THE REWORK DESCRIBED IN THIS BULLETIN.

Perform the rework using the installation instructions on the reverse side of this bulletin and the parts provided. Return the attached Certification Of Compliance for the rework within fifteen (15) days from receipt of this bulletin.

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

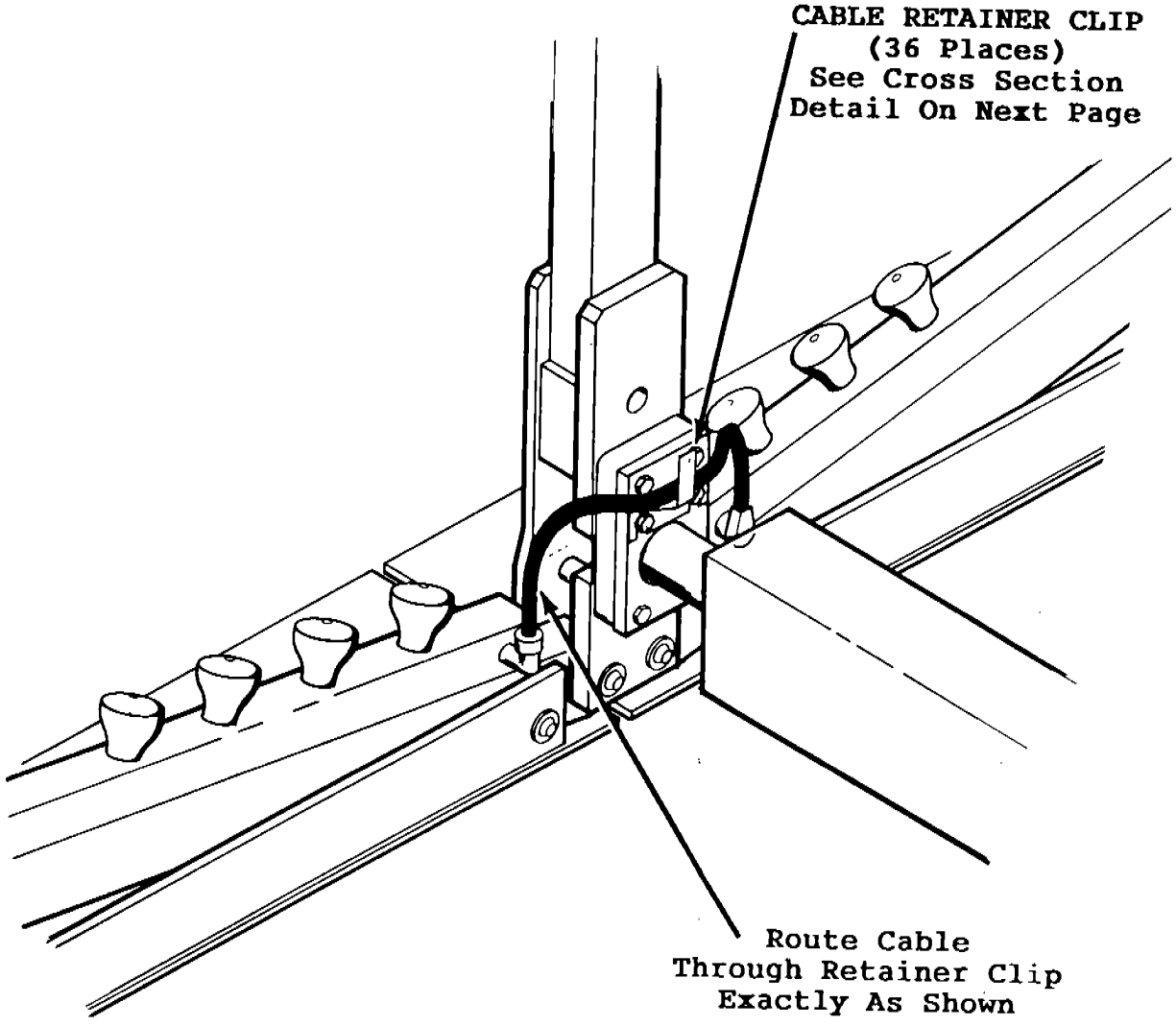
The following parts are included in Kit No. K400R1026-1:

JUMPER CABLE RETAINER CLIP KIT

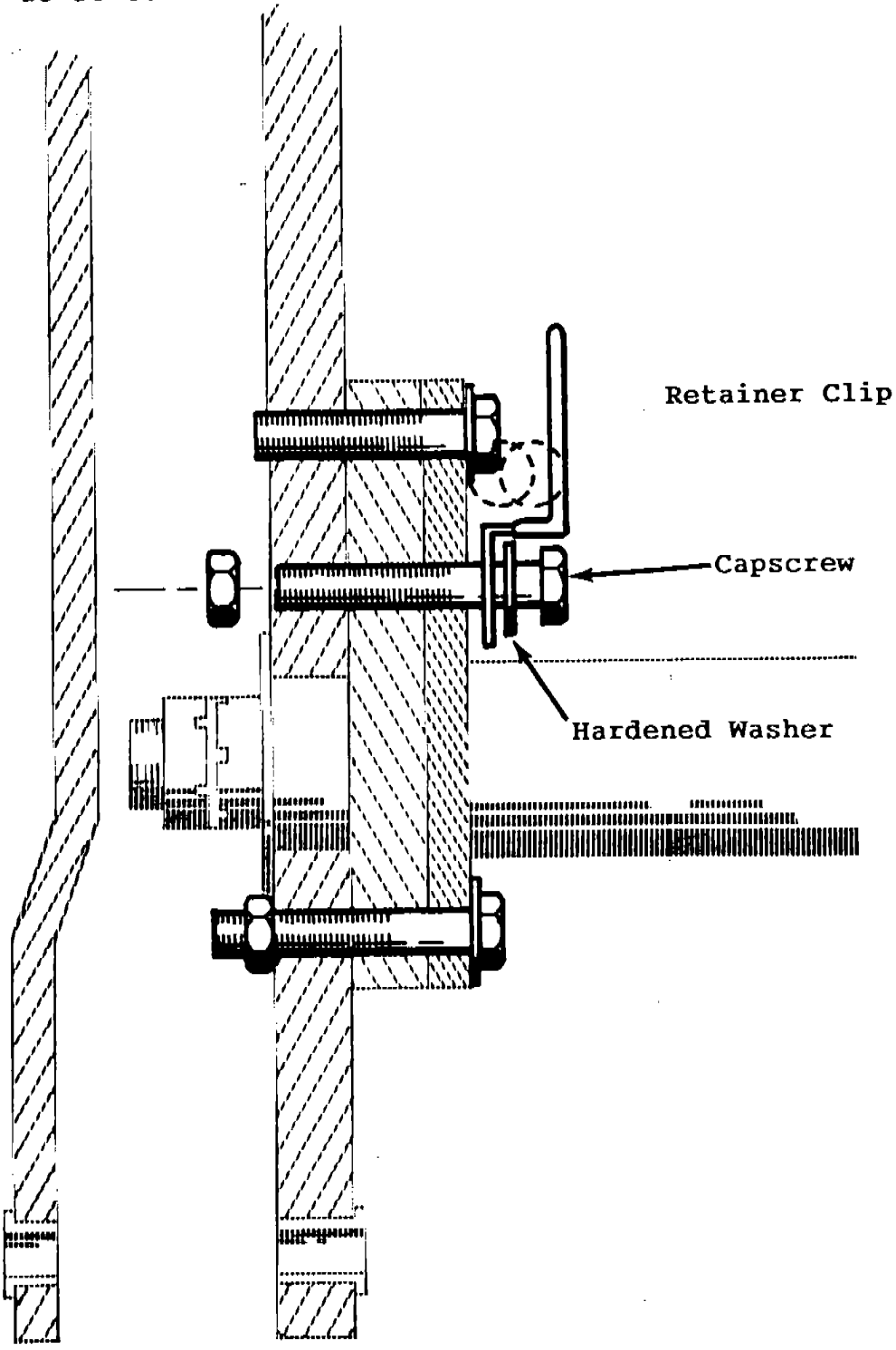
Item No.	Part Number	Description	Qty. Reqd.
1	377-1675300	CLIP - Cable Retainer (4001429-001) . . .	36

INSTALLATION INSTRUCTIONS

NOTE: DO NOT INSTALL CABLE RETAINER CLIPS FOR CABLES WHICH CONNECT TO RECEPTACLES ON THE SWEEPS.



Loosen Existing Capscrews To
Install Cable Retainer Clip
Under Existing Hardened Washers.
Tighten Capscrews To 50-60 ft-lbs.



Number: B400R1026-0

Date: October 14, 1988

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 400-001-88 through 400-003-88

Ride: **GIANT GONDOLA WHEEL** Subject: **Rim Iron Pins And Bushings**

It has come to the attention of CHANCE RIDES, INC. that, during operation of the GIANT WHEEL, the rim iron pins can rotate, causing the hairpins to come out. As a result, one or more rim iron pin could come out, possibly releasing the rim iron from the spreader bar. A rework kit has been designed to securely attach the rim irons by providing a keeper pin which prevents the rim iron pin from coming out.

ALL OWNERS OF **GIANT GONDOLA WHEEL** AMUSEMENT RIDES WITH THE ABOVE NOTED SERIAL NUMBERS PERFORM THE REWORK DESCRIBED IN THIS BULLETIN.

Perform the rework using the installation instructions on the following pages of this bulletin and the parts provided. Return the attached Certification Of Compliance for the rework within fifteen (15) days from receipt of this bulletin.

All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation. If there are any questions regarding the instructions or this rework, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

RIDE SERIAL NUMBERS 400-001-88 & 400-002-88

The following parts are included in Kit No. K400R1026-1:

Item No.	Part Number	Description	Qty. Reqd.
1		BUSHING - Rim Iron (400-254-002)	160
2	290-5238300	LYNCH PIN - 1/4"	160

RIDE SERIAL NUMBER 400-003-88

The following parts are included in Kit No. K400R1026-2:

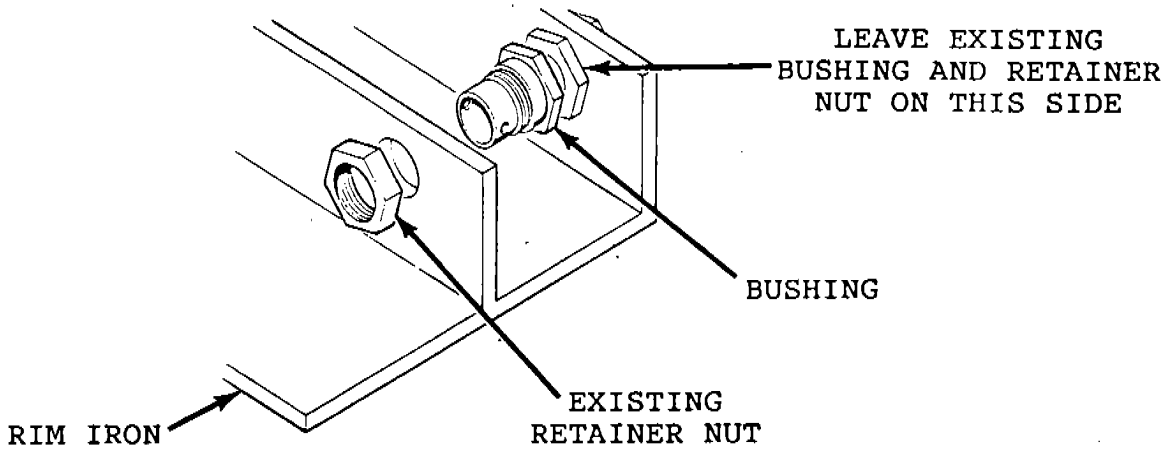
Item No.	Part Number	Description	Qty. Reqd.
1		BUSHING - Rim Iron (400-241-002)	160
2	290-5238300	LYNCH PIN - 1/4"	160

INSTALLATION INSTRUCTIONS

1. Remove a rim iron from the ride.

2. Remove the bushings on the drive tire side of the rim iron. Discard the bushings, but save the retainer nuts.

3. Install the new bushings and secure them with the retainer nuts.



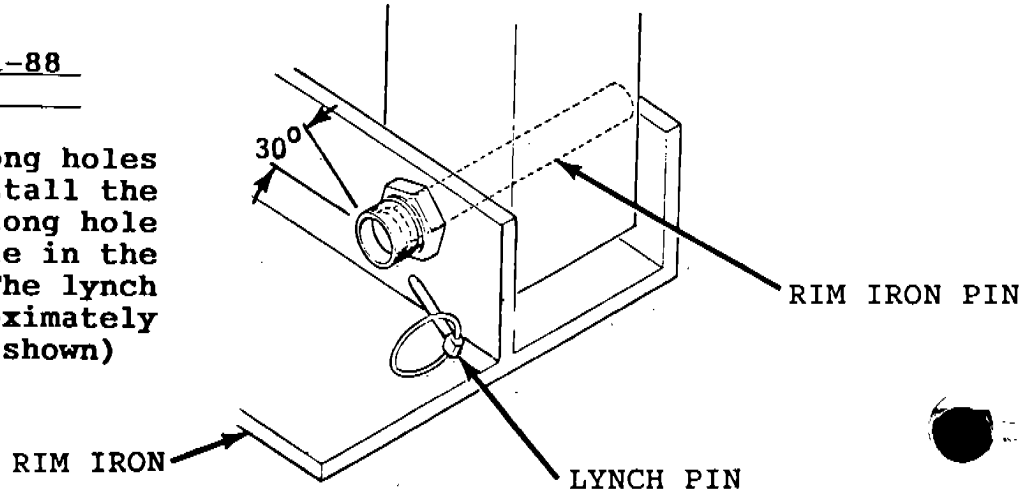
4. Install the rim iron using the existing pins and the lynch pins (Item # 2) as shown

IMPORTANT: Install the rim iron pin from the drive tire side, with the lynch pin installed behind the head of the rim iron pin.

5. Repeat the procedure on all remaining rim irons.

SERIAL NUMBERS 400-001-88
and 400-002-88

All bushings have oblong holes for rim iron pins. Install the new bushings so the oblong hole is aligned with the hole in the existing bushing. (The lynch pin hole will be approximately 30° off horizontal, as shown)



NUMBER: B400R1147-0

DATE: JAN. 14, 1994

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Units

Ride: GIANT GONDOLA WHEEL Subject: Gondola Door Inspection

Chance Rides, Inc. has become aware that the door rod actuator on the GIANT WHEEL gondola door could fail if improperly adjusted or maintained, refer to Chance Rides, Inc. bulletin number B400R1046-A. If this occurred the door could swing outward, contacting the ride structure as the ride is being operated. The Chance Rides, Inc. owner's manual cautions owner/operators of the need to maintain the GIANT GONDOLA WHEEL amusement ride to the manufacturer's specifications and particularly, not to operate the ride unless all parts of the gondola and the gondola doors are in good condition.

All owner/operators of the above noted amusement rides are required to inspect the door actuator mechanisms. Any parts that are bent, show excessive wear or otherwise do not meet the manufacturer's specifications must be replaced. The torque of the shoulder bolt holding the crank disc assembly must also be checked. Proper torque for this bolt is 19 to 24 foot pounds.

All work must be performed by qualified personnel, capable of understanding the function of the parts and their proper installation.

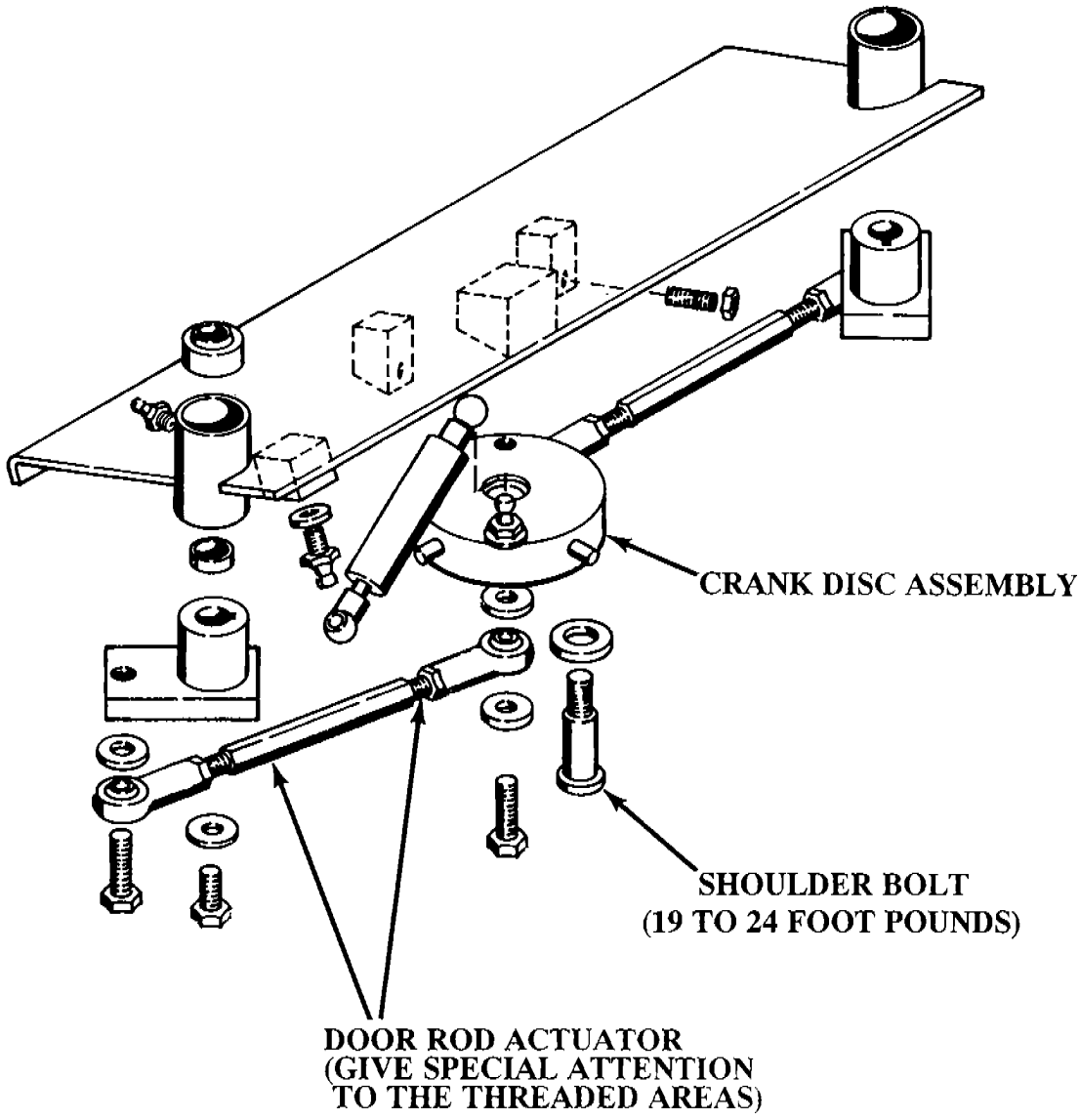
NOTICE

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.

Complete the inspection and return the Certification Of Compliance within fifteen (15) days from the receipt of the bulletin.

Factory and Sales Office: 4219 Irving · P.O. Box 12328 · Wichita, Kansas 67277-2328 · (316) 942-7411 · FAX: (316) 942-7416



NOTE: If shoulder bolt holding the crank disc assembly is loose, remove, clean and reinstall using red Locktite and 19 to 24 foot pounds of torque.

NUMBER: B400R1154-0

DATE: APR. 4, 1994

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

~~Effective Serial Number: All Units~~

Ride: GIANT GONDOLA WHEEL Subject: Sweep and Spreader Lighting

Chance Rides, Inc. has become aware of at least one case in which all of the bases of the sweep lights enclosed by one light cover on the GIANT GONDOLA WHEEL amusement ride broke. When this occurred, the section fell from the ride.

Chance Rides, Inc. requires all owner/operators of the above noted amusement rides to follow the rework safety precautions in this Service Bulletin. Failure to follow the rework instructions outlined in this bulletin prior to the operation of the ride can result in injury to patrons and/or employees.

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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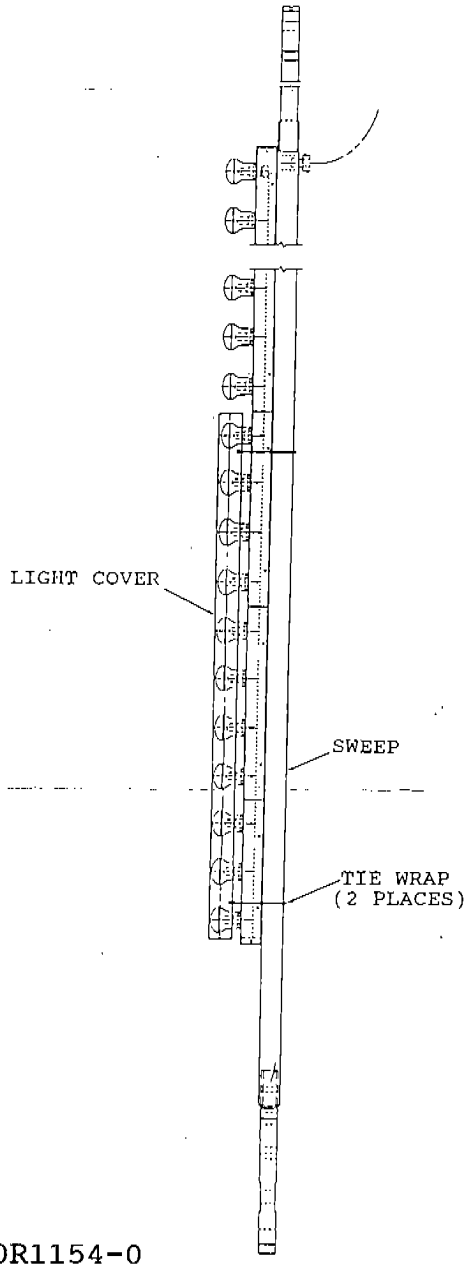
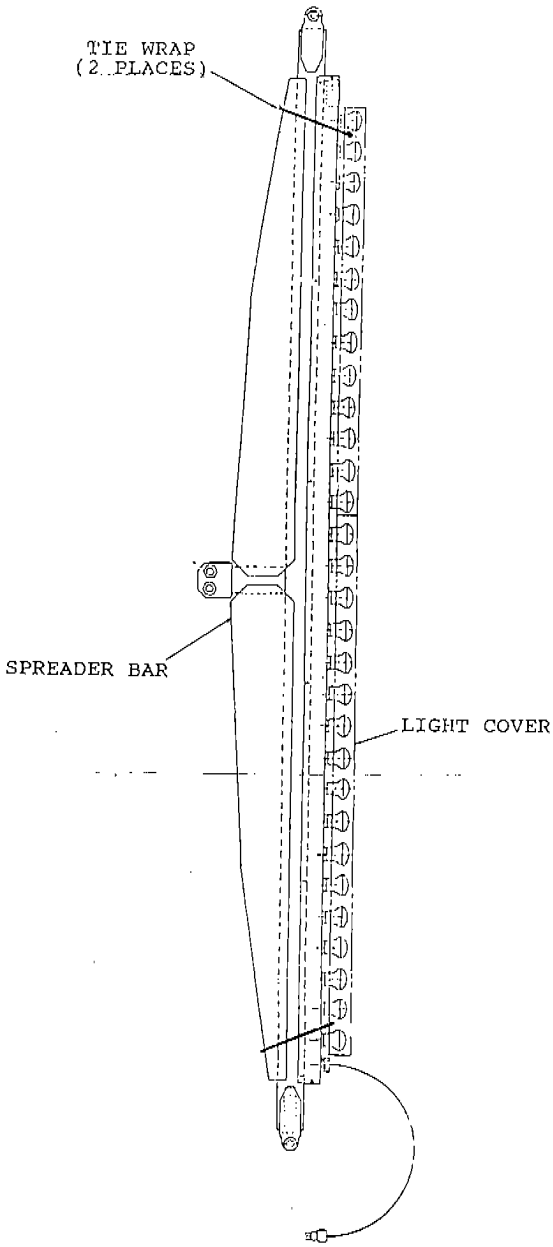
Rework Instructions

1. Remove the #10 x 2-1/4 long machine screw in the light covers located on each sweep.

2. Using 3/16 black tie wraps, secure the light covers to the sweeps. Insert one tie wrap through the holes where the machine screws were removed and fasten around the sweep. Secure each light cover at two locations. NOTE: If cover only contains one hole, drill a second hole at the opposite end of cover for the second tie wrap.

3. Perform the above steps on all spreader bar light covers as well as all sweep light covers.





NUMBER: B400R1175-0

DATE: May 17, 1996

SUPERSEDES:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Number: All Portable Units

Ride: GIANT GONDOLA WHEEL Subject: Bolting Flange Annual Inspection

Chance Rides, Inc. has become aware of at least one case on a GIANT GONDOLA WHEEL amusement ride in which the weld around the bolting flange to the torque tube or the bearing housing has cracked. In this case, an inspection revealed evidence that the capscrews securing the torque tube to the bearing housing had not been properly tightened. Failure to properly tighten these capscrews could result in serious personal injury to the operators, passengers, and bystanders, as well as structural damage to the ride. At each set-up, the capscrews in these bolting flanges must be torqued to between 700 and 850 foot pounds, using a properly calibrated torque wrench, refer to Chance Service Bulletin numbers B400R1036A and B400R1058-0.

All owner/operators of the above noted amusement rides are required to inspect the bolting flanges annually using magnetic particle inspection as described in this bulletin. All inspections must be performed by a Level II or III person who is certified in magnetic particle inspection.

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.

The following magnetic particle inspection technique meets the requirements of ASTM E709.

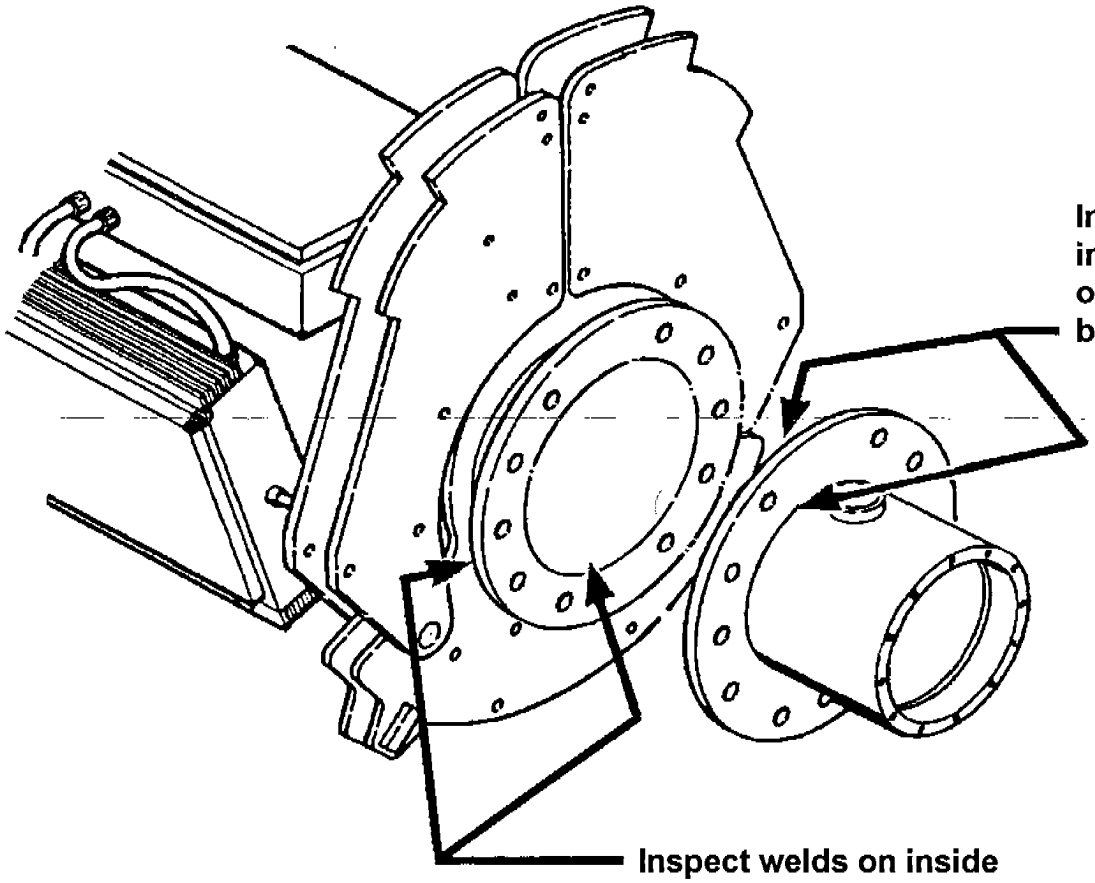
1. **PRE-CLEAN:**
   * Clean the weld area around the inside and outside of the bolting flanges on the torque tube and the bearing housing (8 places). This cleaning is to remove rust, paint or other contaminates.

2. **MAGNETIZATION PROCESS:**
   * Using an A.C. yoke with articulating legs, position yoke over weld so flux field is 90 degrees to the weld.

   * Use continuous method for applying particles and current.

3. **INSPECTION:**
   * Thoroughly inspect all weld areas for linear indications.
   * If any linear indications are found, **do not operate the ride,** contact the Chance Rides, Inc. Customer Service Department at 1-800-242-6231.

4. **POST-CLEAN:**
   * Remove magnetic particles from weld areas.



GIANT GONDOLA WHEEL

Field inspection and test guide

Manual number 24329304

CHANCE RIDES INC.

GIANT GONDOLA WHEEL

Field inspection and test guide

Contents

CHANCE RIDES, INC.
4219 Irving
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phone (316) 942-7411
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fax (316) 942-7416

Introduction

Proper maintenance is essential to the safe operation of this ride. The tests and inspection points outlined in this field guide are not intended to replace the recommended maintenance schedule. This guide does not contain maintenance and repair procedures and should only be used as a ride inspection and test guide.

When repairs are necessary use only those components authorized, specified or provided by the manufacturer. If any alterations, modifications and/or additions, installations of unauthorized components are made to the original design without the manufacturer's explicit written consent or without direct supervision by a manufacturer's representative, CHANCE RIDES, INC., makes no claims as to the integrity of the altered or modified ride (product).

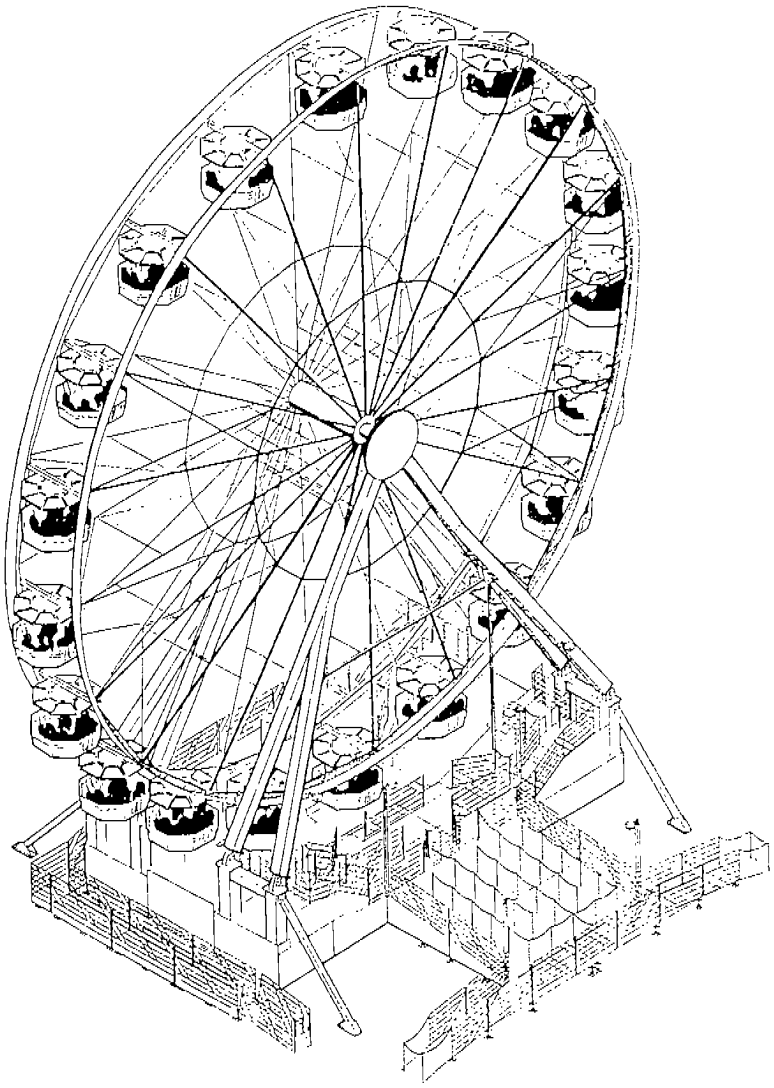
Information in this field inspection and testing guide applies only to products manufactured by CHANCE RIDES, INC. built after January 1, 1986 (**Giant Gondola Wheel** serial number 400-00188 and on)..

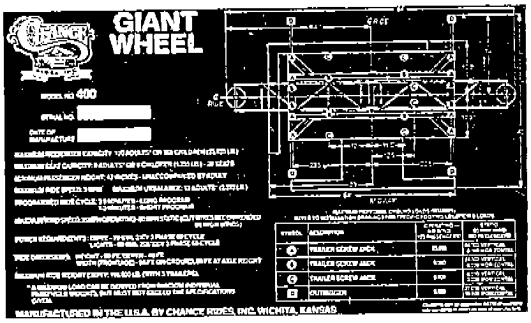
CHANCE RIDES, INC., reserves the right to make improvements in design or changes in specifications at any time without incurring any obligation to such changes.

Ride description

The **Giant Gondola Wheel** is mounted on either three trailers (portable model) or a stationary base, anchored to the ground (park model). The wheel is driven by 8 tower-mounted electric motors, each equipped with an air brake.

The ride information plaque is mounted to the front left tower leg. It lists specifications, operating dimensions, ground loads, as well as model and serial number and date of manufacture.





The ride information plaque is mounted to the front left hand stub tower.

The terms "right hand" and "left hand" as used in this manual are determined by standing in front of the ride and facing the ride.

Detailed operation and maintenance information is available in the *Giant Gondola Wheel Operation And Maintenance Manual* (manual number 24360600). For more information, or to order manuals, contact CHANCE RIDES, INC.

Operation

Operating controls

1. Fault indicator light - If this red light is on, a fault is indicated and the ride will not operate.

2. Lights switch - This switch controls the decorative lighting on the ride.

3. Low air pressure indicator light - This red light comes on if air pressure is not sufficient to operate the ride. Do not start the ride.

4. Main power indicator light - This green light is on when the main power circuit breaker is on.

5. Control panel power indicator light - This green light is on when the panel power switch is turned on.

6. Direction switch - This switch selects the direction of ride rotation.

7. Program switch - This key-operated switch selects the short or long ride program for the "RUN" mode. Do not change the program switch after the ride is started.

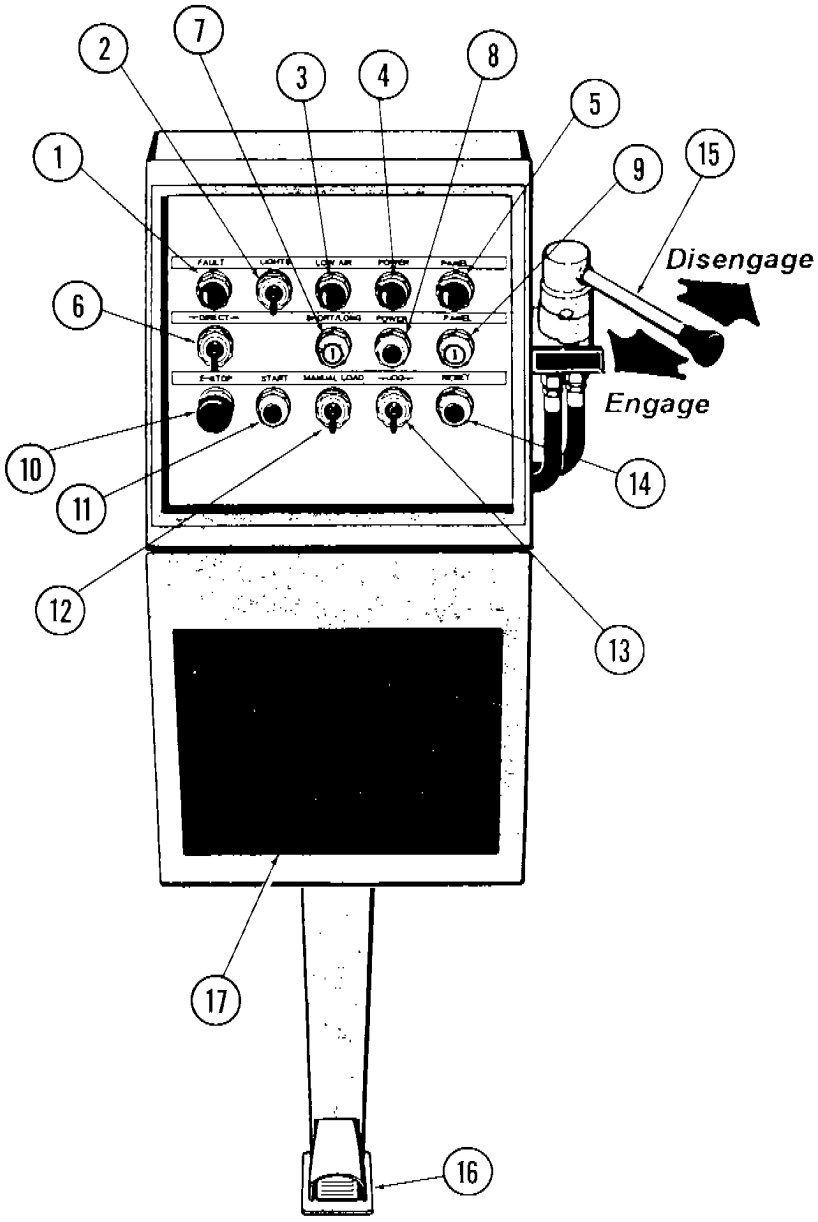
8. Power switch - This switch turns off the main power circuit breaker in the motor control cabinet.

9. Control panel power switch - This key-operated switch turns on the power to the control panel.

10. E-stop switch - This switch interrupts the drive program. The ride will come to a normal, programmed stop.

11. Start switch - Use this switch to start the programmed ride cycle. The following conditions must exist for the ride to operate:

-Main power and control panel power indicator lights must be on.



Operator's control panel

1. Fault indicator light
2. Lights switch
3. Low air pressure indicator light
4. Main power indicator light
5. Control panel power indicator light
6. Direction switch
7. Program switch
8. Power switch
9. Control panel power switch
10. E-stop switch
11. Start switch
12. Manual load switch
13. Jog switch
14. Reset switch
15. Emergency brake
16. Operator presence switch
17. Operation procedure decal
MUST BE PRESENT AT ALL TIMES

- Fault indicator light must be off.
- Operator presence switch must be depressed.

12. Manual load switch - This switch allows the operator to rotate the ride to any position for loading of passengers. The operator presence switch must also be depressed.

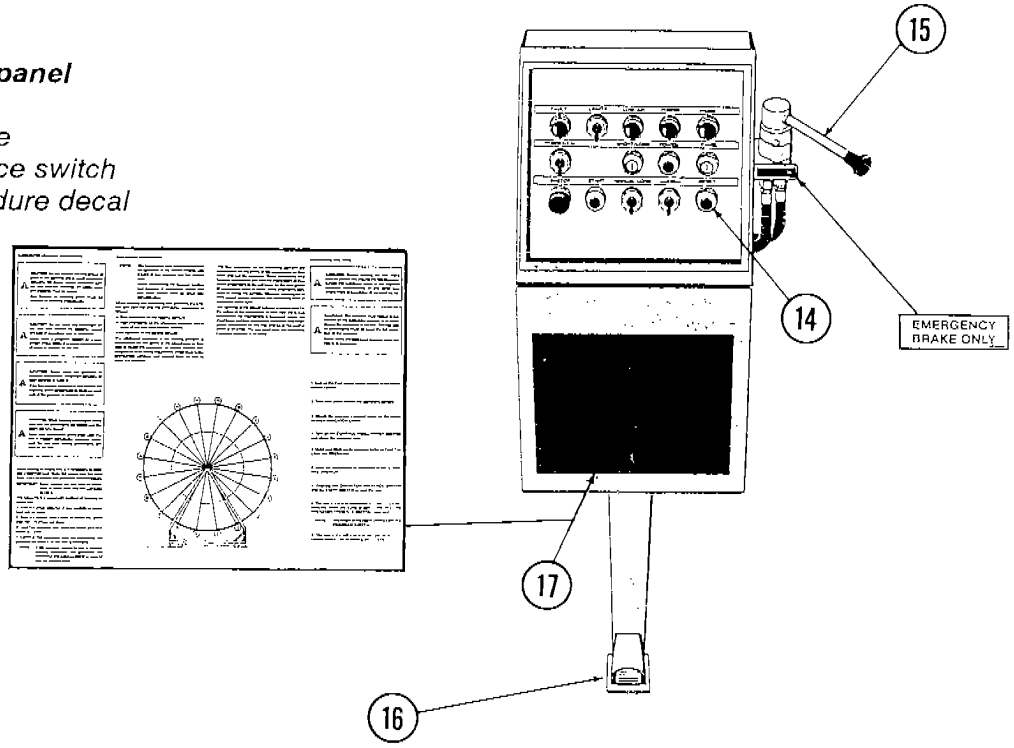
13. Jog switch - The jog feature allows the operator to slowly rotate the ride. The operator presence switch must also be depressed.

14. Reset switch - Push this switch if the fault indicator light comes on.

15. Emergency brake - Do not use the emergency brake during normal operation. It is for emergency use, such as when electrical power to the ride is lost. The brake must be disengaged before starting the ride, and is inoperative during normal programmed operation.

16. Operator presence switch - This foot switch must be depressed to operate the start, manual load or jog switches. If the switch is released, the drive program is interrupted and the ride will come to a normal, programmed stop.

Operator's control panel
14. Reset switch
15. Emergency brake
16. Operator presence switch
17. Operation procedure decal



Operating the ride (test cycle)

The operation procedure is provided on a decal, mounted on the inside of the control console cover. Make sure this decal is legible. Test the operation of all controls. Throughout the ride cycle, check for correct speed and proper brake operation.

Check the overall performance of the ride based on previous operating performances of the individual ride.

General inspection and testing

Testing

Field performance testing of amusement rides[1]

The following specifications conform with ASTM F846 standard guide for *Testing Performance Of Amusement Rides And Devices*, in effect on date of ride manufacture.

Erection or installation testing

Each erection or installation of a ride shall be given an inspection prior to carrying passengers that shall include but not be limited to the following:

a. Determine that ride has been erected according to the set-up procedures in the operations manual.

b. Inspect field inspection points listed in the *Field Inspection Guide*.

c. Visual check of all passenger carrying devices including restraint devices and latches, and the pins and capscrews securing them.

d. Visual inspection of entrances, exits, stairways and ramps and devices securing them.

e. Test of all communications equipment necessary for operation of the ride or device.

f. Operate the ride to determine that direction of travel conforms to the information plate, ride manual field inspection guide of specification sheet.

g. Operate the ride for a minimum of three ride cycles to determine that the ride speed does not exceed the speed specified in the information plate, ride manual field inspection guide of specification sheet.

Daily pre-opening inspection

This inspection shall include a daily inspection of all items as specified in the previous item (erection or installation testing).

1 B090R1002-0 May 14, 1986

Documented field performance and operational testing
Documentation and certification shall be performed by a person who by demonstrated education and field experience is knowledgeable with construction, erection, operation, maintenance and repair of amusement rides.

Operational load testing
Any operational test including load testing performed on a ride shall be completely non-destructive in nature. Overload testing exceeding the rated limits listed on the information plate, operation manual, field inspection guide or specification sheet shall be deemed inappropriate. Where maximum total passenger weight is not readily available, passenger capacity multiplied by 170 pounds per adult and/or 90 pounds per child may be used.

Non destructive testing with inert loads can be accomplished only with special care as to placement of the load so that it is centered both vertically and horizontally as would be the load of the passenger it replaces. Extra seat reinforcement must be used to offset any load concentration created. Such tests shall be documented and certified as non-destructive by the person making the test and the agency requiring it. Results of all load tests shall be communicated to the factory upon completion by the certifying agency.

Conducting a non-destructive operational load test assures the testing agency only that it will carry a given load in a given way at a given moment and in no way assures future safety of the ride.

Conducting a destructive load or overload test also assures the testing agency that it will carry a given load in a given way at a given moment and in no way assures future safety of the ride. However, it also introduces the probability of inflicting serious irreparable damage to the ride that may or may not be apparent at the time of the test.

CHANCE RIDES, INC. considers inert load testing of any nature appropriate only for situations requiring experimental development of stress-strain testing during prototype development. A certificate of load test on the prototype and certification that each production ride met the design criteria when it was manufactured is available from the factory upon request.

Non-destructive testing[2]

REFERENCE STANDARD *1. ASTM-F24 Standard On Amusement Rides And Devices*
a. F846-86 Testing Performance Of Amusement Rides
b. F853-86 Maintenance Procedures For Amusement Rides And Devices
c. F893-87 Inspection Of Amusement Rides And Devices

CHANCE RIDES, INC., at the time of design and manufacture, determines by calculations and testing of a prototype amusement ride the appropriateness for use, of not only the parts, but the entire system of a newly designed ride. These calculations and tests are utilized to, as feasibly as possible, determine the requirements for expected design life of major components. Based on this design criteria, CHANCE RIDES, INC. does not identify critical components on amusement rides to be singled out for non-destructive testing.

If through field experience, there is an indication that a structural or mechanical problem may develop on rides currently operating, CHANCE RIDES, INC. will notify owners by bulletin of the recommended procedures to inspect and correct the possible problem. Any possible defect which could affect the continued safe or proper operation of the ride should be reported immediately to the manufacturer by the owner/operator. This information is necessary so that a determination can be made for either the repair or replacement of the possible defective parts.

Field repairs should not be undertaken without the approval and proper instructions from the manufacturer and should be performed by qualified personnel. These persons should have a complete understanding of both the component's function and the manufacturer's instructions.

It is the responsibility of the individual inspector to thoroughly inspect the ride as he deems necessary based on his knowledge and field experience and manufacturer's recommendations. If the inspector finds an area or component that could be a problem, structural or otherwise, the factory should then be notified. It is then the responsibility of the inspector to ensure that the manufacturer's recommendations for repair,

replacement or otherwise have been completed and are in compliance with the required specifications.

Load testing is a destructive form of testing and is not recommended by the manufacturer, as per previous topic "Field performance testing of amusement rides."

Fasteners

Capscrews

Capscrews used by CHANCE RIDES, INC. are classified as functional load-carrying capscrews if:

- They are used as tension members in the erection or operation of the ride

and/or

- The are required to resist shear through friction-type connections in the erection or operation of a ride.

Capscrews are selected with consideration to grade, size and quantity, using joint capacities based on tightness torques of 60% rated yield and group joint efficiencies of 62.5%

Torque requirements[20]

Capscrews must be tightened to the torque values listed in the torque chart. These values were selected to produce a tightening torque range of 60% to 70% of proof load, when tightened with a hardened washer under the nut or capscrew head (whichever is accessible for tightening). When the capscrew is tightened from the head end, apply anti-seize lubricant to the shank end of the capscrew. When the threads are lubricated, use 10% less torque to tighten the capscrew.

DO NOT TIGHTEN CAPSCREWS OVER THE RECOMMENDED TORQUE. This can damage the capscrew, due to variances in coefficients of friction and torque wrench accuracy.

Always use a torque wrench. It is impossible to accurately measure the tightness of a capscrew by other methods. Torque wrenches must be checked for accuracy twice each operating season.

20 5090R1075-0 May 25, 1990

Size Diameter - Threads/inch	Foot pound torque range (see notes 1 and 2) with locknut and hardened washer	
	SAE J429 Grade 5 ASTM A325	SAE J429 Grade 8 ASTM A490
1/4 - 20	5-6	7-8
1/4 - 28	6-7	8-10
5/16 - 18	11-13	15-18
5/16 - 24	12-15	17-21
3/8 - 16	19-24	27-33
3/8 - 24	22-27	31-38
7/16 - 14	30-35	45-55
7/16 - 20	35-40	50-60
1/2 - 13	50-60	65-80
1/2 - 20	55-65	75-90
5/8 - 11	95-115	130-160
5/8 - 18	105-130	150-180
3/4 - 10	165-200	235-285
3/4 - 16	185-225	260-320
7/8 - 9	270-325	380-460
7/8 - 14	295-360	415-505
1 - 8	400-490	565-690
1 - 12	440-535	620-755
1 1/8 - 7	495-600	800-975
1 1/8 - 12	555-675	900-1095
1 1/4 - 7	700-850	1135-1380
1 1/4 - 12	775-940	1255-1525
1 1/2 - 6	1215-1480	1975-2395
1 1/2 - 12	1370-1660	2220-2700

Torque chart

Torques for functional load carrying cold finished hex head capscrews with dry rolled threads, used with locknuts (see note 3), and tightened with an ASTM A325 hardened washer under the capscrew or locknut head (whichever is accessible for tightening).

This torque range will develop 60% to 70% of proof load.

Refer to ***Replacement of capscrews and locknuts*** *for conditions requiring replacement*

NOTES

1. Use anti-seize lubricant on capscrew shank when tightened from head end.

2. Use 10% less torque when anti-seize or other lubricant is used on threads.

3. Use same torque range for holes tapped in steel.

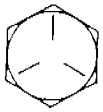
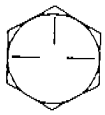
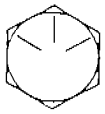
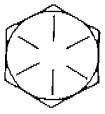
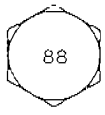
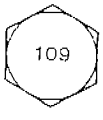
Capscrew grades

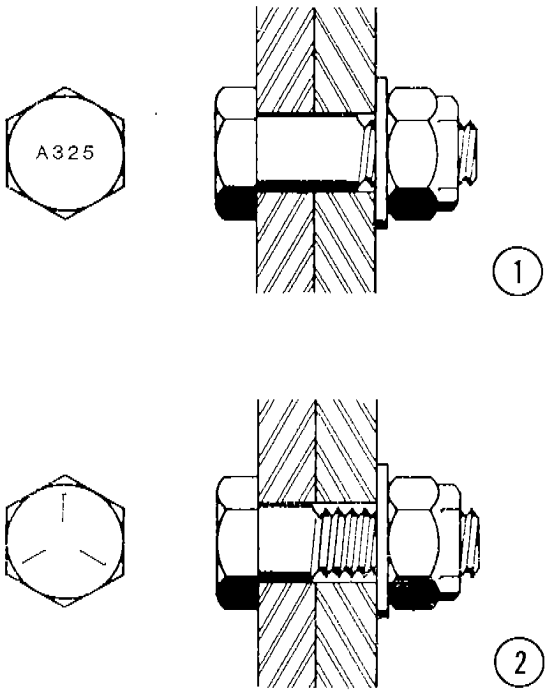
CHANCE RIDES, INC. uses only grade 5 or better capscrews and grade 8 locknuts, with A325 hardened washers for functional loads. The *Grade markings chart* shows the capscrew markings to be found on CHANCE rides. The manufacturer's identification symbols must be present on all functional load carrying capscrews.

CHANCE RIDES, INC. requires the use of cold-formed hex head capscrews with rolled threads. Hex bolts and hot formed hex head capscrews are not recommended because they may have machined threads and can have die seams along the shank.

NEVER REPLACE CAPSCREWS OR NUTS WITH PARTS OF A LESSER GRADE, OR DIFFERENT LENGTHS THAN THOSE SHOWN IN THE CHANCE PARTS CATALOG.

Grade markings for functional load carrying capscrews
Manufacturer's identification symbols must be present on all capscrews

Correct markings	Examples of unacceptable markings
SAE J429 Grade 5 Medium carbon 81,000 yield 	 **Grade 5.1** Low carbon  **Grade 5.2** Low carbon martensitic
ASTM A325 Type 1 Medium carbon Longer shank and shorter thread length than Grade 5 81,000 yield  **ASTM A325 Type 3** Corrosion resisting Longer shank and shorter thread length than Grade 5 81,00 yield 	 **ASTM A325 Type 2** Low carbon martensitic
SAE J429 Grade 8 Medium carbon 130,00 yield 	 **ISO R898** Class 8.8 Medium carbon 92,000 yield 
ASTM A490 Alloy steel Longer shank and shorter thread length than Grade 8 130,00 yield 	 **ISO R898** Class 10.9 Alloy steel 130,000 yield 



Capscrew comparison
1. ASTM A325 Capscrew
Longer shank
shorter threads
2. Grade 5 capscrew
Shorter shank
longer threads

Replacement of capscrews and locknuts
When permanently installed capscrews and locknuts are disassembled for repair or adjustment, they must be replaced if they have been in service over five (5) years, or corrosion, or other damage requires over-torquing for removal. If a torque wrench is not used to measure excessive removal torques, the capscrews and locknuts must be replaced.

Capscrews and locknuts which are frequently disassembled for portability must be replaced each operating season. If the capscrews and locknuts become damaged, corroded or require excessive torque for removal, they must be replaced. If a torque wrench is not used to measure excessive removal torques, the capscrews and locknuts must be replaced.

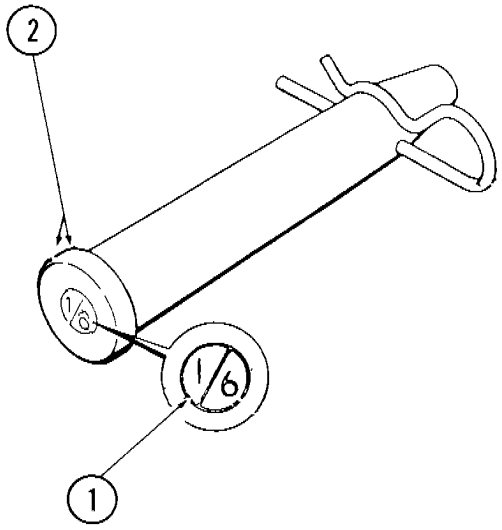
Pins[16]

Tapered pins used on amusement rides are subject to deterioration due to improper use and wear. CHANCE RIDES, INC. specifies certain pins for certain applications on

amusement rides. These pins have been developed over a period of years, taking into account size, design, material and hardness characteristics.

Use only the pins specified by CHANCE RIDES, INC. These pins are identified as shown in the following illustration. Always use the correct hairpin.

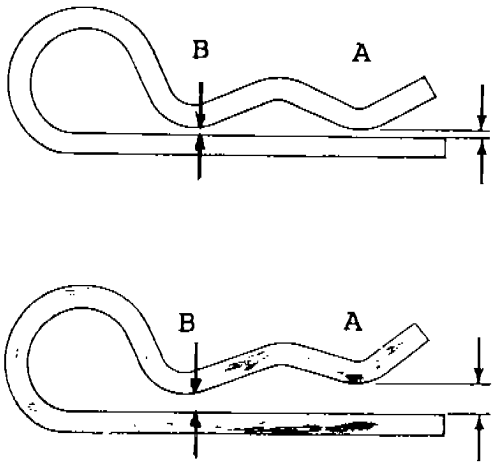
Pin identification
1. Date of manufacture
2. Rounded edges



Use care when installing and removing tapered pins. Since these pins are hardened (as are hammers and punches) care must be taken to strike the pin straight on. Striking a pin at an angle can cause the pin to chip, resulting in personal injury. For this reason APPROVED SAFETY GLASSES OR GOGGLES MUST BE WORN AT ALL TIMES when tapered pins are being installed or removed. If a tapered pin is chipped, bent, or "mushroomed" on either end, discard it and replace it with a new pin.

Pin keepers
All keepers (R-keys, hair pins, lynch pins, etc.) must be inspected for wear. If a keeper is bent out of shape or "sprung", it must be replaced.

Hairpins are expendable parts. After repeated use, they become worn and "sprung" as shown.

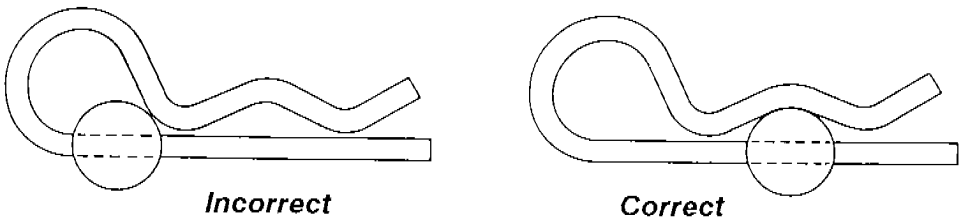


Acceptable hair pins
Dimension "A" equals dimension "B" in a relaxed position

Unacceptable hair pins
Dimension "A" is greater than dimension "B" in a relaxed position

NEVER ATTEMPT TO BEND A HAIR PIN BACK INTO SHAPE. REPLACE IT WITH A NEW PART.

The correct installation of a hairpin is shown. Incorrectly installed hairpins are more likely to fail, and will distort after only a few uses.



Incorrect ***Correct***

CHANCE RIDES, INC. recognizes and recommends the safety procedures specified in *ASTM Standards F770 Operation Procedures for Amusement Rides and Devices and F853 Maintenance Procedures for Amusement Rides and Devices.*

Inspection

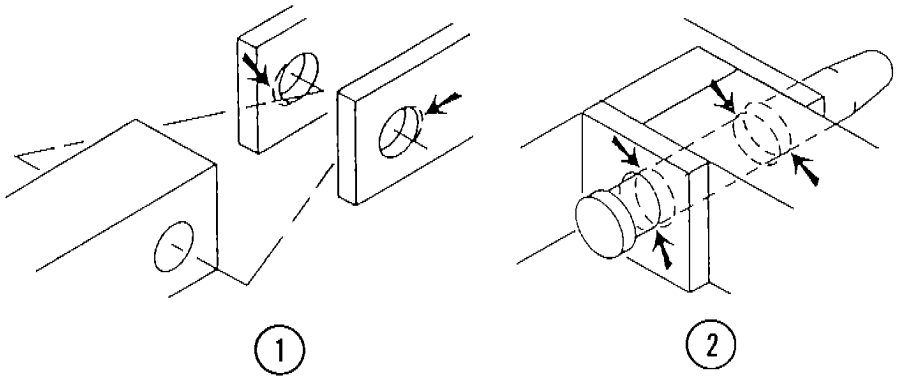
Joint inspection

Some joints will appear to wear rapidly on new rides. This is usually a result of the holes not aligning in the mating parts. When this condition occurs it results in "point contact". A joint with this condition will generally wear rapidly until the load is distributed evenly over the fastener and the parts.

If in doubt about the condition of a bolt, pin or hole on a new ride consult CHANCE RIDES, INC., and replace as required.

1. Inspect stationary joints for "egg-shaped" wear and loose pins.

1. Stationary joint wear
2. Stationary joint-misaligned holes resulting in point contact



2. Inspect moving joints for wear and lubrication.

3. Inspect welded structural joints for cracking or fatiguing.

4. Inspect bolted structural joints for cracking, fatiguing and proper bolt tightness.

5. Inspect pins and keepers on all pin joints for wear and proper installation.

6. Inspect all pins for proper CHANCE identification marks.

Cable inspection[19]

Replace cables if any of the following conditions exist. If more than one cable is used, cables must be replaced as a set.

1. Severe corrosion
   a. Rust appearing to stem from interior of cable.
   b. Cable appears clean but previous corrosion is evident from pitted condition in wires.

2. Severe stretching occurring in a short section of cable, indicated by a marked reduction in the diameter of the cable.

3. Severe physical damage such as kinking, crushing or "bird caging".

19 B090R1071-0 May 25, 1990

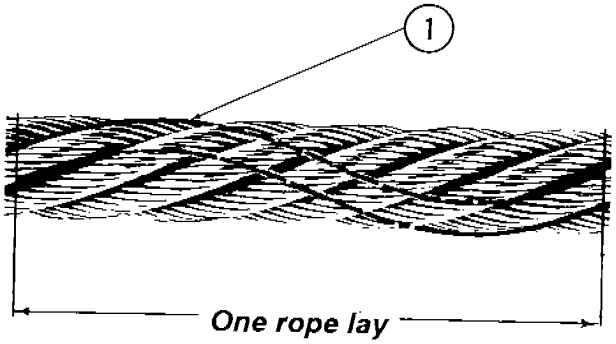
Kinking

Crushing

Bird caging

4. One strand being 75% broken through.

5. A number of wires, equal to the number in a strand, broken in the length of one rope lay.



"Lay" as a unit of measure

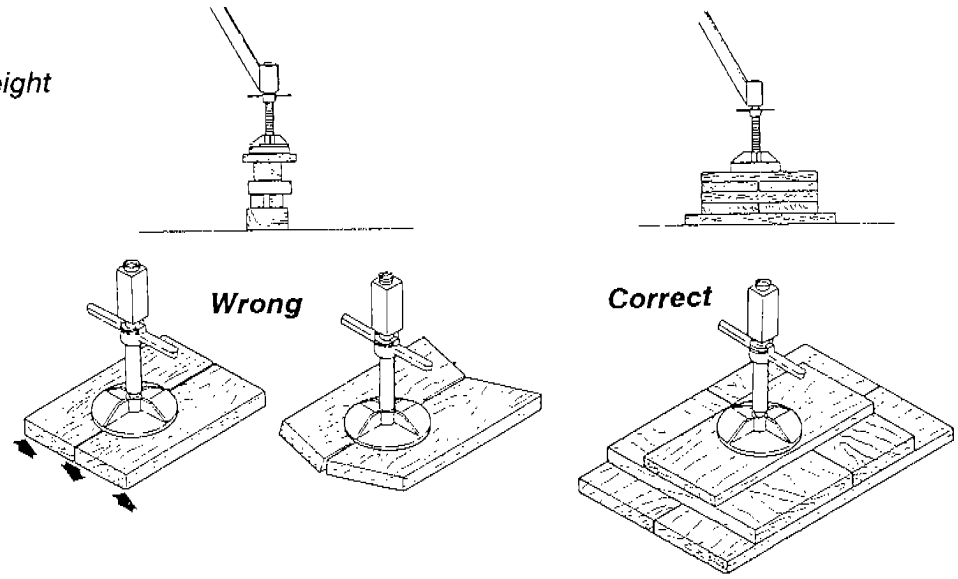
1. One strand

Leveling and blocking (portable models)[12]

1. Inspect leveling and blocking at each set up and at the start of each day (rides erected in soft locations require more frequent inspection).

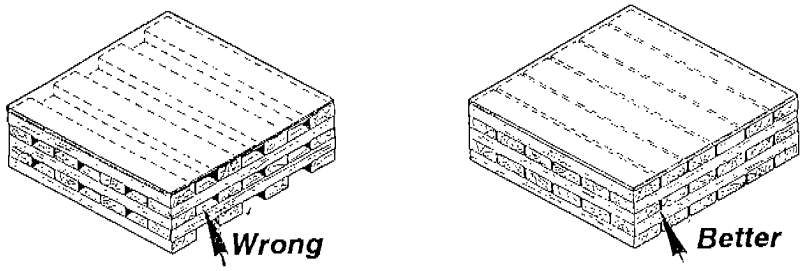
2. Inspect for proper cross blocking or crib blocking. Cross blocking distributes weight evenly.

Always cross block
Cross blocking distributes weight evenly.



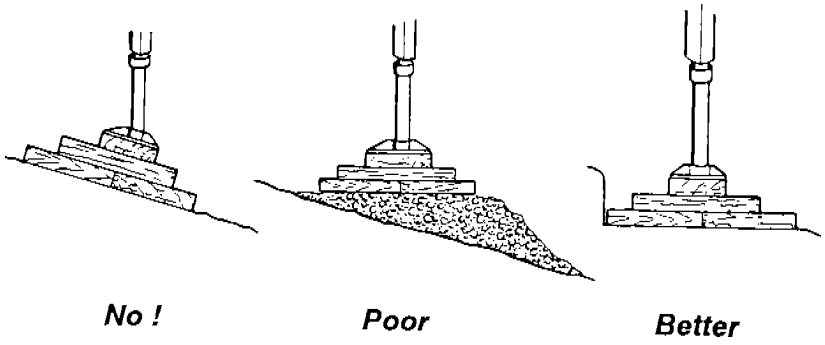
To avoid crushing under load "crib" blocking should be spaced no more than 1/4" for drainage.

"Crib" blocking
Large voids can let blocking crush under load. 1/4" spaces allow adiquate drainage.



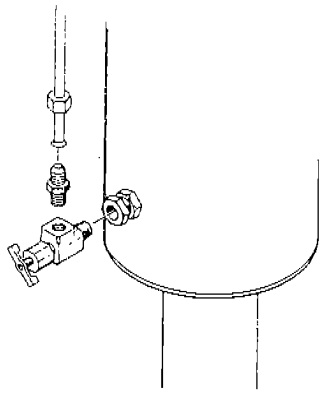
3. Inspect blocking for proper contact with ground.

4. Level ground under blocking.by digging where possible, instead of filling. Fill dirt will be soft and allow settling.



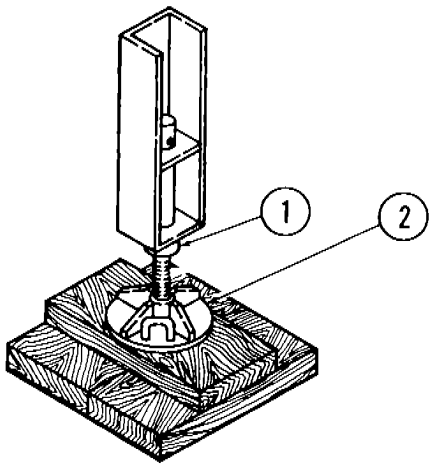
Blocking on a slope
Level the ground beneath blocking by digging where possible. Don't fill, the fill dirt will be soft allowing the ride to tilt

5. Inspect hydraulic leveling jacks for leaks at every set-up. The hydraulic jacks are for leveling purposes only. They must be retracted and their shut-off valves closed during normal ride operation. Likewise, they must be fully retracted and their shut-off valves closed before transporting the ride.[8]



The hydraulic leveling cylinder must have a shutoff valve in its lower port

6. Check the lock rings on all screw jacks for tightness.



1. Locking ring
2. Base

General safety guidelines

The following is a list of general safety rules to which everyone should adhere.

1. All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation.

2. Inspect the ride before each day of operation to determine that no portion of the ride is damaged, missing or worn in such a manner that unsafe conditions can develop.

3. Perform the manufacturer's recommended maintenance procedures at the intervals and in the manner specified in the operation and maintenance manual.

4. Study each job carefully to determine all hazards so that necessary safety precautions can be taken.

5. Examine safety devices (tools, ladders, etc.) before they are used to make sure they are in good condition. Ladders must be clean and unpainted.

6. Use the proper tool or equipment for each job. All hand electric power tools must be properly grounded.

7. Wear close fitting, comfortable clothing when working on or near moving parts or live electrical circuits. Avoid finger rings, jewelry or other articles which can be caught in moving parts or come in contact with electrical circuits.

8. Protect your eyes by wearing approved safety glasses or goggles.

9. Wear a hard hat at all times. When working in elevated areas, use a safety belt.

10. When work performed is hazardous, never work alone.

11. If guards are removed from equipment, make sure they are replaced before leaving the job.

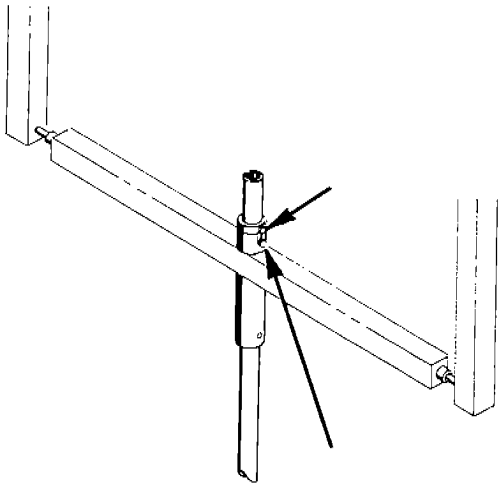
12. Clean up after each job, disposing of surplus materials.

13. Keep a record of parts replaced and the date of replacement. Inform the manufacturer of any replacement requirements which are frequent or cause unsafe conditions.

14. Make modifications and additions only as outlined in manufacturer's service and safety bulletins.

Vehicle inspection

1. Inspect the attachment of the stem to the t-bar. The upper capscrew secures the collar to the stem; the lower capscrew must be engaged in the t-bar slot.



The collar must be secured to the stem by a capscrew. A second capscrew, installed directly below the collar, must engage in the slot in the T-bar as shown. These capscrews are not removed for normal set-up and tear-down.

NOTE: *On ride serial number 400-00188, the stem is secured to the t-bar with two capscrews.*

2. Inspect the pins which secure the canopy to the t-bar.

NOTE: *On ride serial number 400-00188, the canopy is secured to the stem by a tapered pin. A pin guard covers the pin to prevent tampering.*

3. Inspect the pins securing gondola to the stem. The slot on the gondola must be engaged on the bottom pin, with the second pin securing the gondola to the stem.

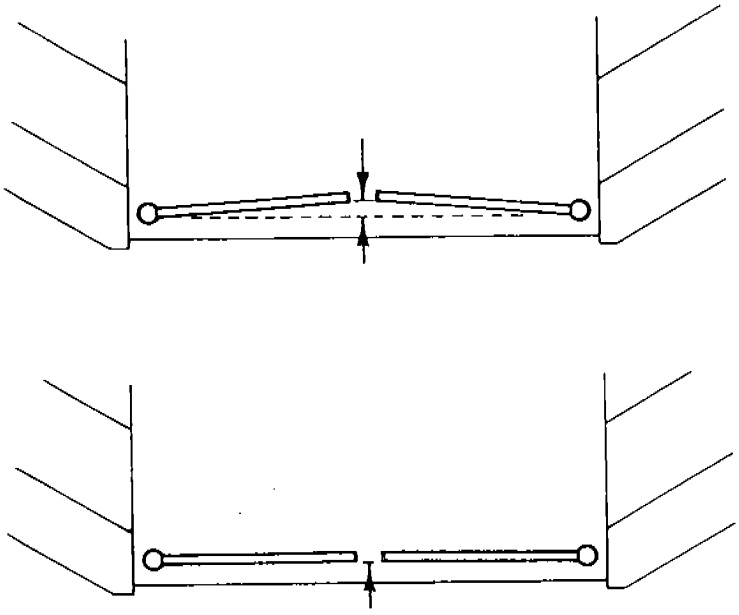
4. Gondolas must be installed so entrance and exit decals can be read from the correct direction

5. Gondolas must be installed in numerical order.

6. Check doors for proper alignment.[11]

Ride serial numbers 400-00188 through 440-012-89 must angle inward 3/8" to 1/2".

Ride serial number 400-013-89 and on have doors that are flush.

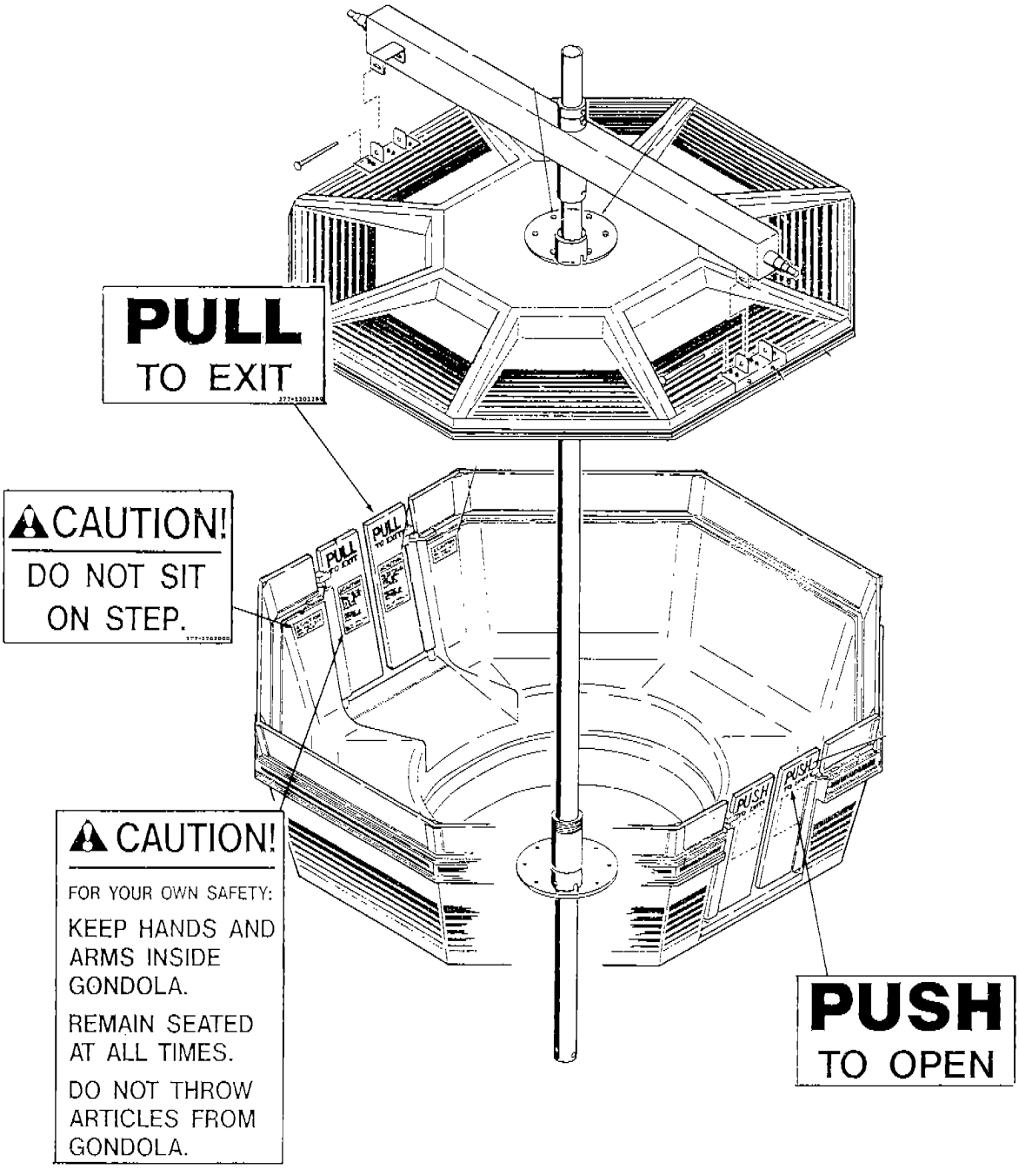


7. Doors must close without assistance

8. Doors must have proper decals

9. Inspect overall gondola appearance. Exterior abrasions can indicate ride leveling and set-up problems.[15]

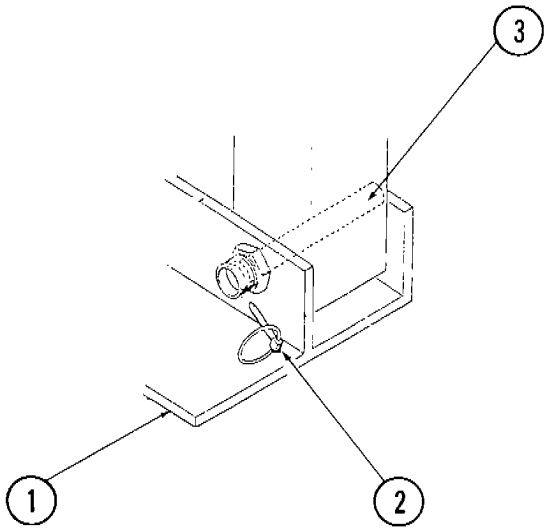
11 B400R1046-A July 17, 1989
15 B400R1055-0 February 1, 1990


PULL
TO EXIT
CAUTION!
DO NOT SIT
ON STEP.
CAUTION!
FOR YOUR OWN SAFETY:
KEEP HANDS AND ARMS INSIDE GONDOLA.
REMAIN SEATED AT ALL TIMES.
DO NOT THROW ARTICLES FROM GONDOLA.
PUSH
TO OPEN

Sweep inspection

1. Inspect rim iron pins and bushings for proper installation[3]. The rim iron pins must be installed from the drive tire side with the lynch pin behind the head of the rim iron pin.

NOTE: *On ride serial numbers 400-00188 and 400-00288, all bushings have oblong holes for the rim iron pins.*



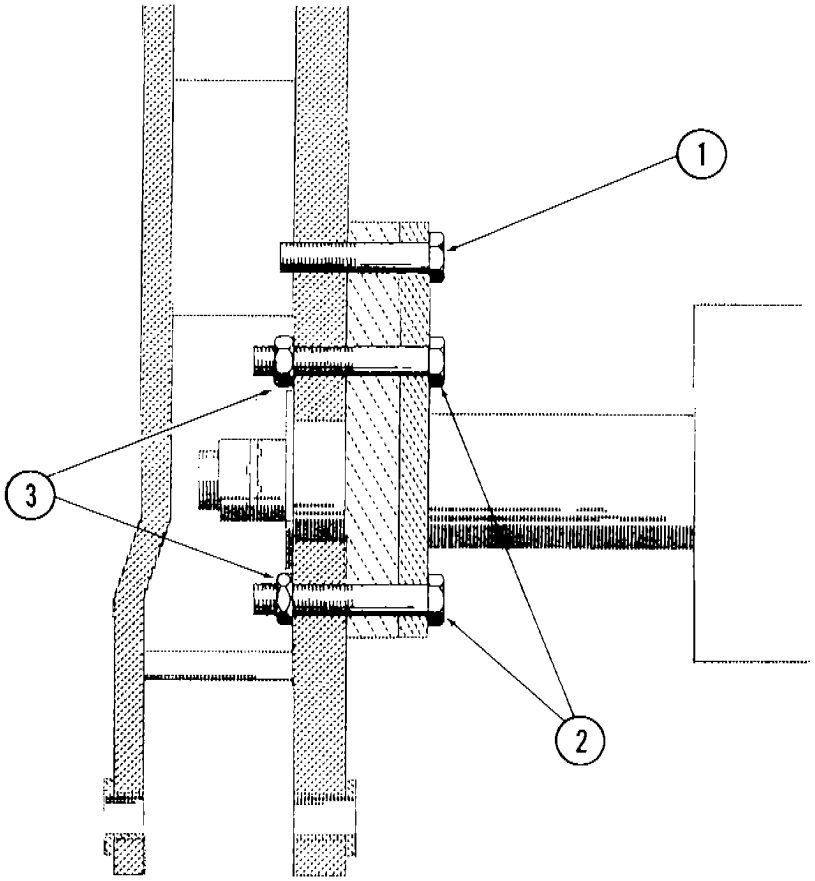
Rim iron pins must be installed fron the drive tire side, with the lynch pin installed behind the head of the rim iron pin.

1. *Rim iron*
2. *Lynch pin*
3. *Rim iron pin*

2. Inspect drive tire tracking on rim irons. Tires which run out of alignment or are rubbing can indicate that trailers are not properly leveled.

3. Inspect T-bar bearing block fasteners for proper torque monthly or at every set-up. Check the four upper capscrews first. Then, while holding the capscrews with a wrench, check the jam nuts. Do not let capscrews turn when checking jam nut torque. Last, check the two lower capscrews.[5]

3 B400R1026-0 October 14, 1988
5 B400R1031-0 November 17, 1988



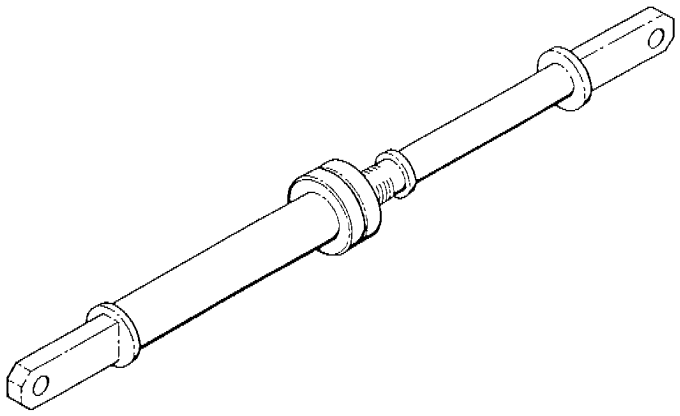
T-bar bearing block

Check the four lower capscrews first. Then, while holding the capscrews with a wrench, check the jam nuts. Do not let capscrews turn when checking jam nut torque. Last, check the two lupper capscrews.

1. *Upper capscrews 50-60 ft-lbs*
2. *Lower capscrews 50-60 ft-lbs*
3. *Jam nut 43-51 ft-lbs*

4. Inspect the installation of all spreader bars and their attaching hardware. All pins must be secured with hair pins.

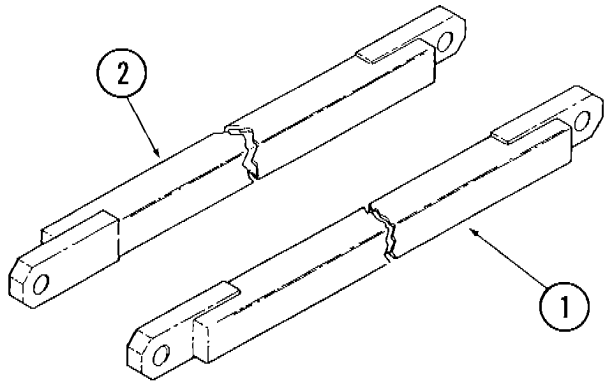
5. Inspect the adjustable short spreader bar. It must be in compression, with the lock ring tightened.



Adjustable short spreader bar

6. The short spreader bar between sweep #1 and #2 must have straight ends, not offset.

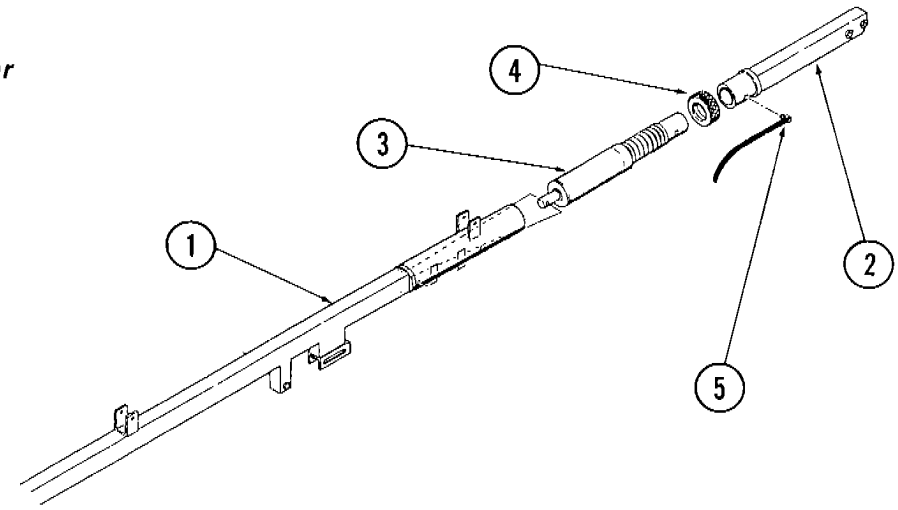
1. *Straight spreader bar end*
2. *Offset spreader bar end*



7. Inspect the adjustable long spreader bars for hydraulic leaks.[6]

9. Inspect adjustable long spreader bars for proper hydraulic pressure of 1,000 psi. This must be checked during the set-up procedure. Once this pressure is reached, the lock ring is tightened and the hose is disconnected.

Adjustable long spreader bar
1. *Long spreader tube*
2. *Short spreader tube*
3. *Hydraulic cylinder*
4. *Lock nut*
5. *Hydraulic fitting*

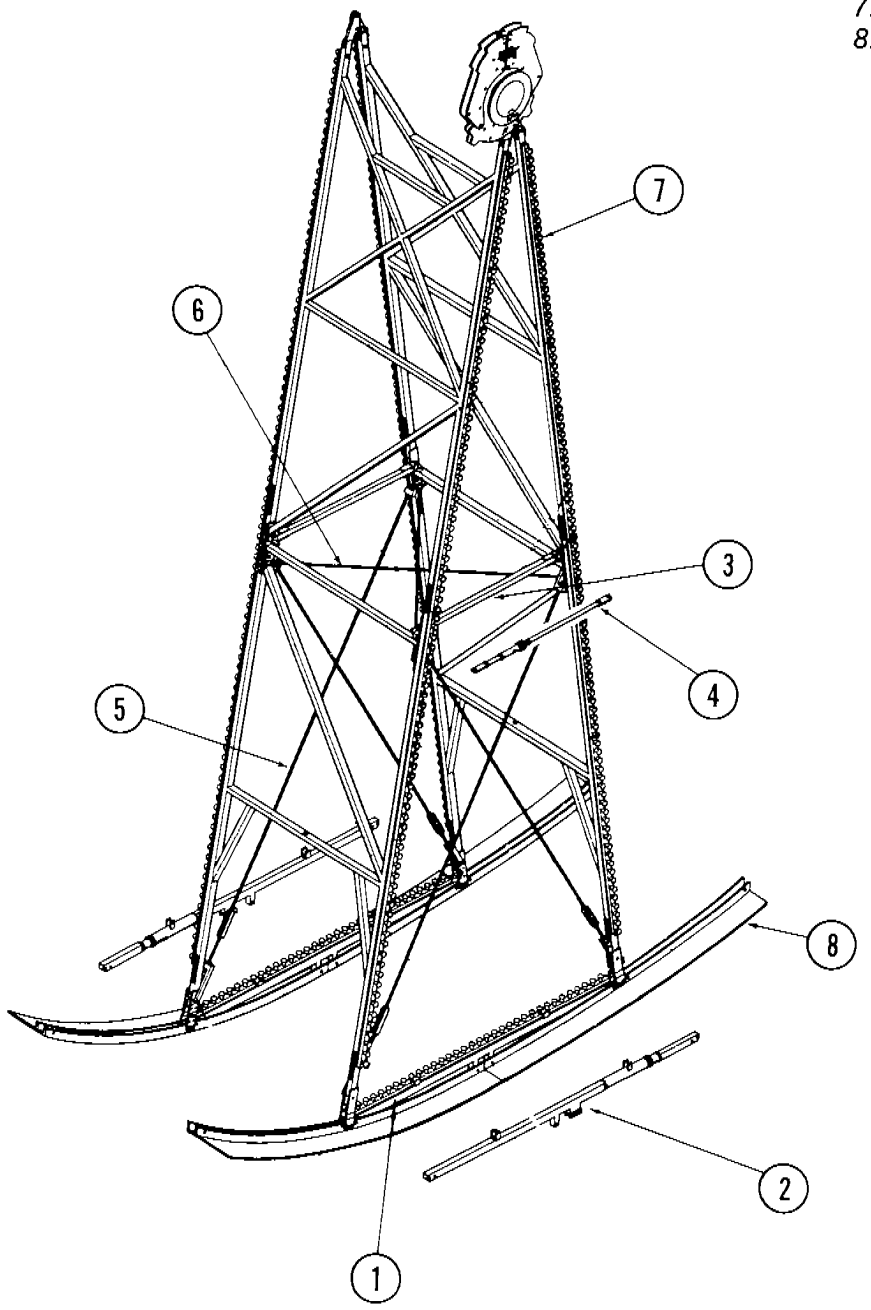


10.Inspect for tie rods and torsion rods in their proper locations. Both types of rods must be in tension with turnbuckles tight[14].

6 B100R1035-0 March 22, 1989
14 B400R1054-0 January 19, 1990

Sweep and rim iron assembly

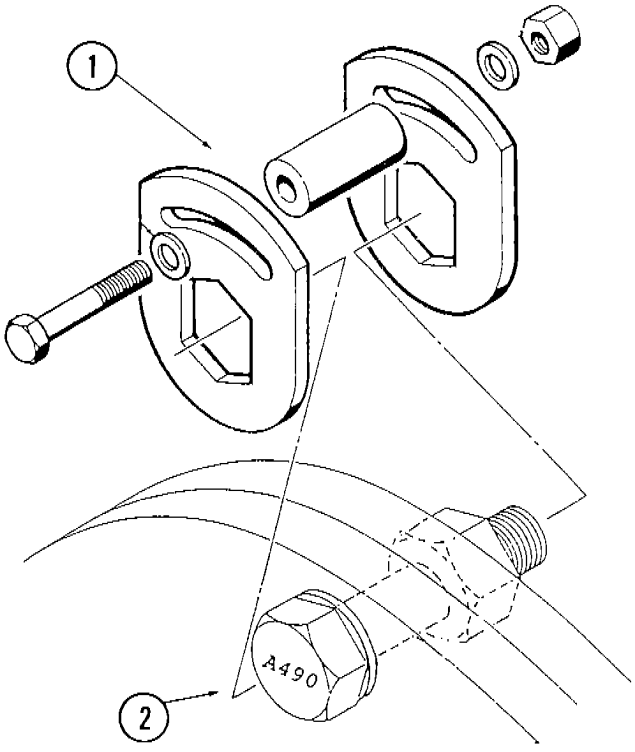
1. Long spreader bar
2. Adjustable long spreader bar
3. Short spreader bar
4. Adjustable short spreader bar
5. Tie rod
6. Torsion rod
7. Sweep
8. Rim iron



Axle and hub inspection

1. Inspect tear-down pins and hair pins for proper installation.

2. Inspect the capscrews which attach the torque tube to the hub bearing housings for proper torque of 700 to 850 ft-lbs. Keepers must be installed.[7] [17]

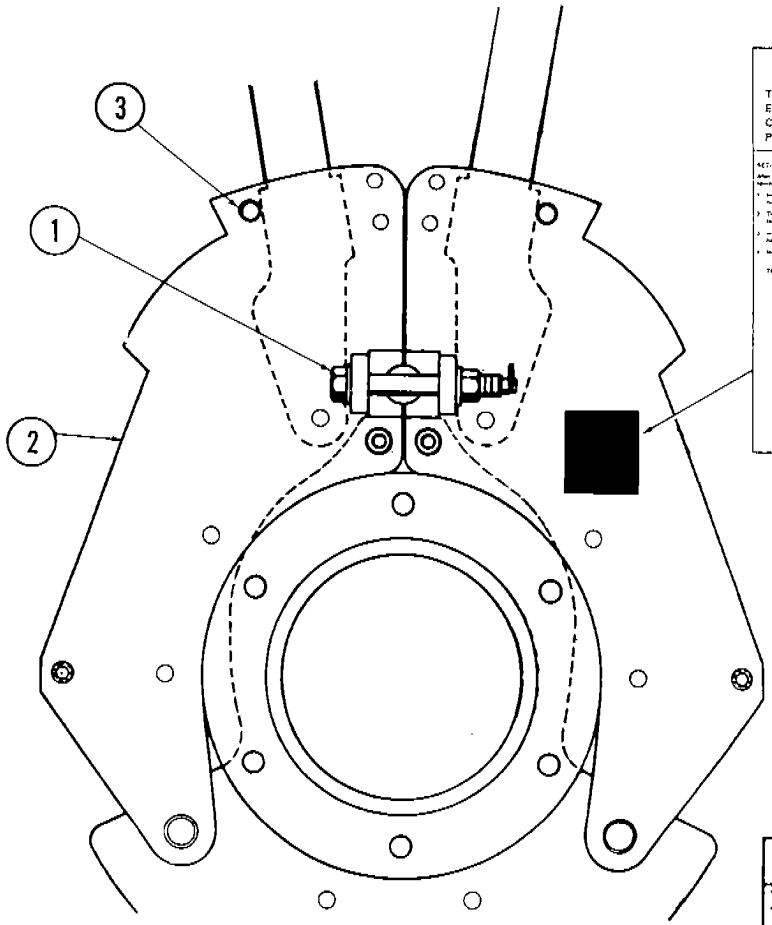


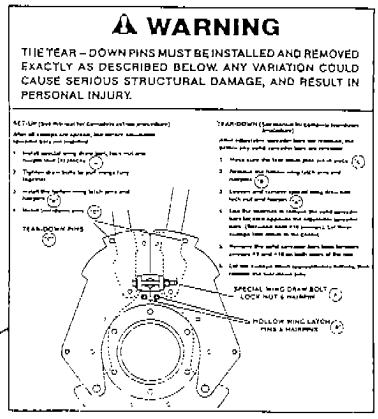
Keepers (shown) must be installed on the torque tube capscrews
1. *Keeper*
2. *Torque tube capscrew*

3. Inspect the four hub wing bolts and pins. The hub wings must be completely drawn together.

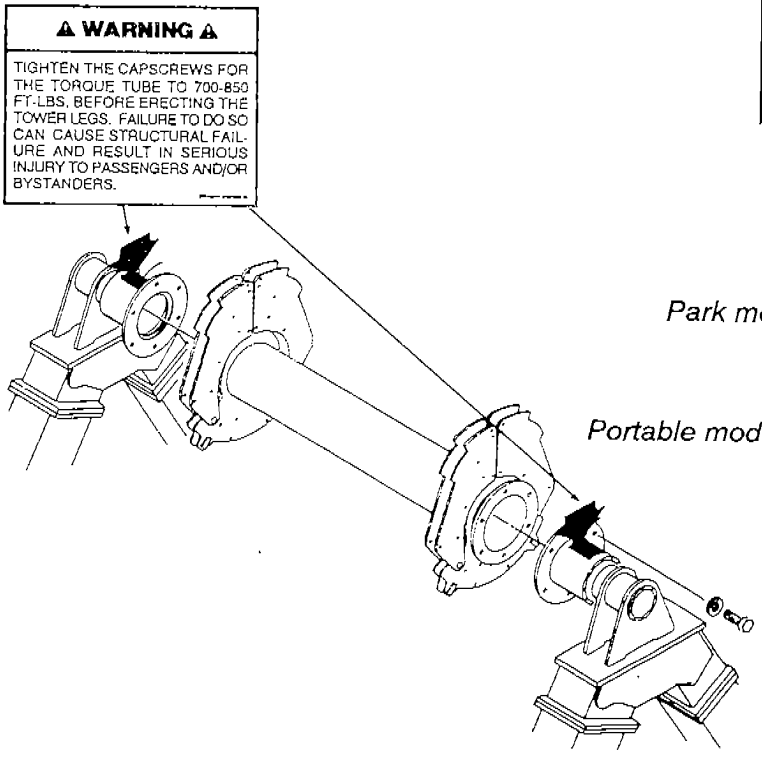
4. Inspect torque tube and tower legs for proper decal installation.

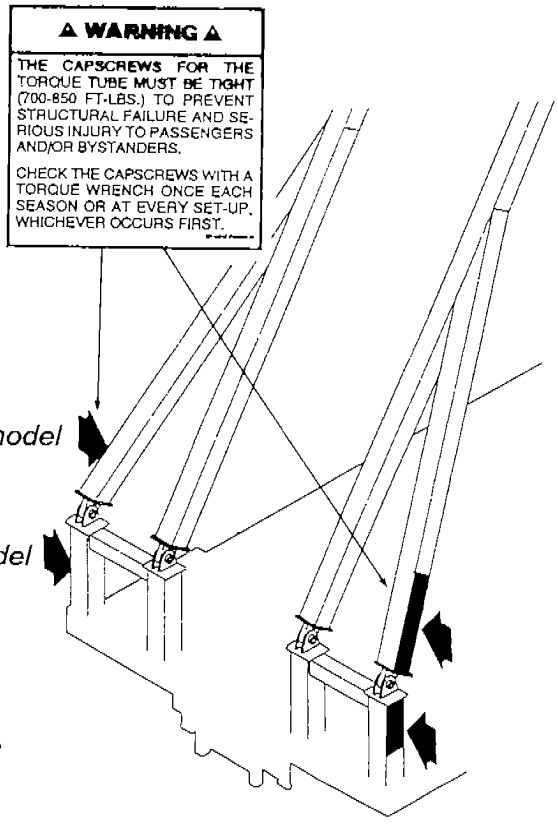
7 B400R1036-A August 17 1990
17 B400R1058-A February 16, 1990





1. *Wing bolts*
2. *Hub wings*
3. *Tear-down pins*

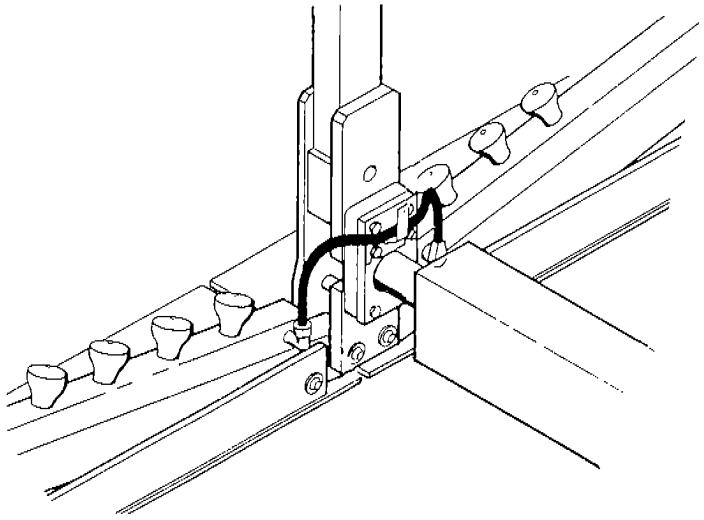




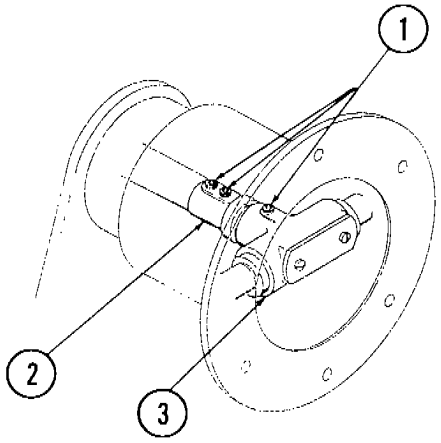
Electrical and lighting inspection

1. Inspect for rim iron jumper cable retaining clips on ride serial numbers 400-00188 and 400-00288.[4]

Jumper cable routes through retaining clip as shown



2. Inspect set screws at axle conduit coupling for tightness[10] ride serial numbers 400-00188 through 400-00588.



1. Set screws
2. Coupling
3. Tee fitting

NOTE:
Remove plexiglass covers as necessary to gain access to coupling and tee.

4 B400R1030-0 November 30, 1988
10 B400R1045-0 June 22, 1989

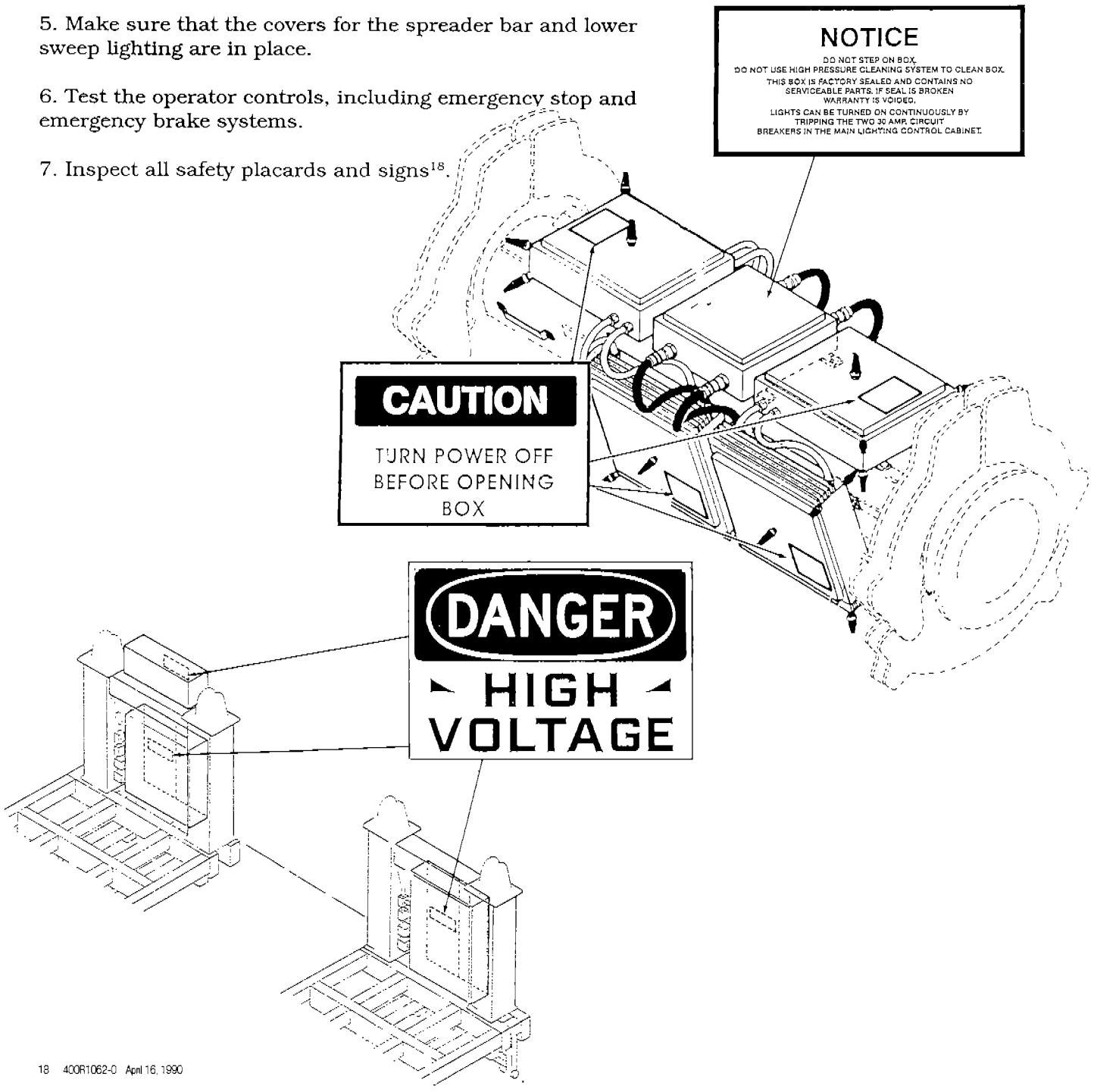
3. Inspect cable leads, electrical connections and grounding per local code.

4. Check the operation of the main power switch on the control console.

5. Make sure that the covers for the spreader bar and lower sweep lighting are in place.

6. Test the operator controls, including emergency stop and emergency brake systems.

7. Inspect all safety placards and signs[18].

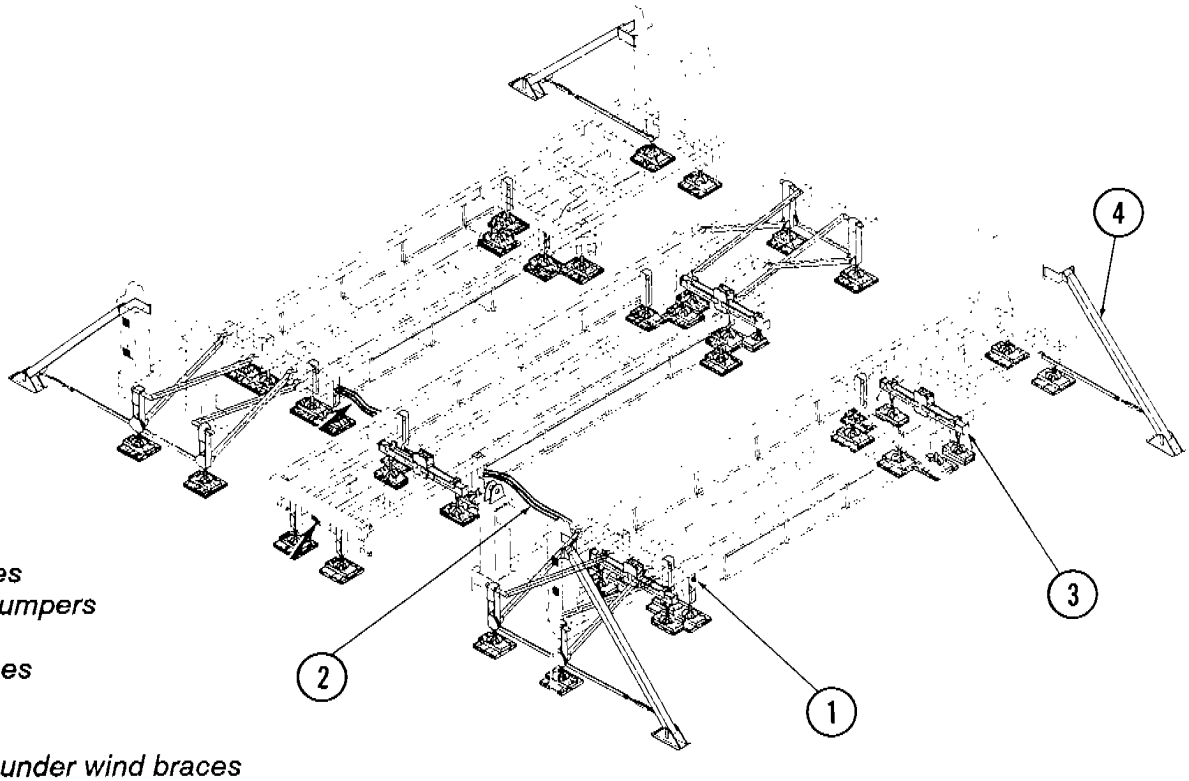


Trailer and base inspection

1. Inspect mounting locations on park model rides at regular service intervals.

2. Inspect all trailer to trailer connections.

3. Inspect trailer wind braces. Turnbuckles must be snug.



1. Receptacles
2. Hydraulic jumpers
3. Tracks
4. Wind braces

NOTE:
Do not block under wind braces

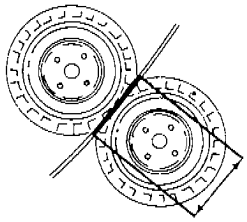
Drive, hydraulic and air inspection

1. Check the air pressure in the brake air system. Pressure must be 100 psi at the reservoir, and 40 psi at the regulator.

2. Inspect the entire air system for leaks.

3. Inspect the drive tires for wear and proper pressure, lug bolt torque, contact area and tracking. Drive tires that are rubbing or out of alignment can, indicate that the trailers are not properly leveled[12]. Drive covers must be in place.

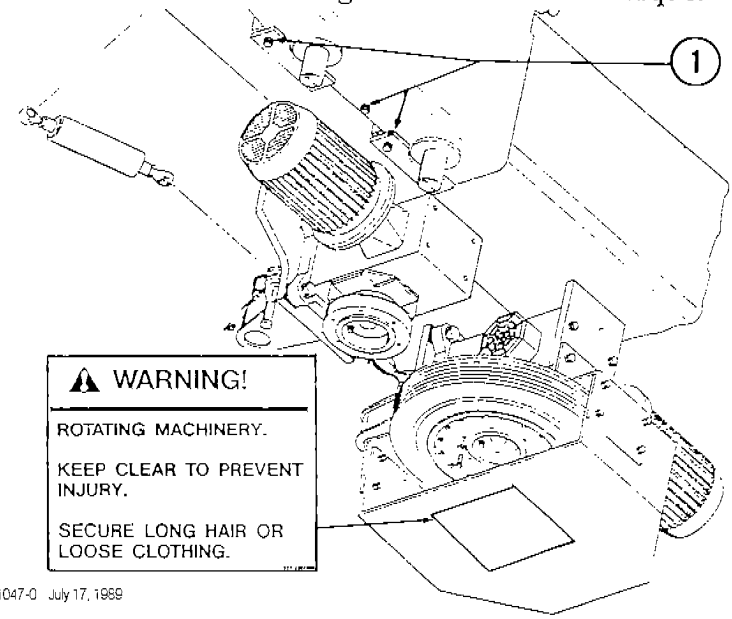
Drive tires should contact rim iron in an area that is 5 to 6 1/2" long. Drive tire pressure is 45 psi. Lug bolt torque is 22 ft-lbs.



4. Inspect hydraulic fittings for excessive leaking.

5. Inspect all safety placards and signs.

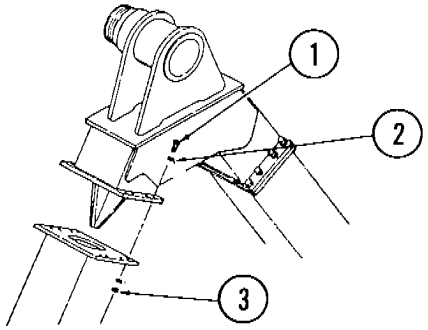
6. Tighten drive mount retaining screws to 55 ft-lbs torque.



1. Retaining screws
Tighten drive mount retaining screws to 55 ft-lbs.

Tower leg and structure inspection

1. Inspect the mating of right and left hand tower legs.



1. Capscrew
2. Hardened washer
3. Nut

Tighten to 185 ft-lbs, using a torque wrench on the nuts.

2. Check tower mating capscrews for proper torque.

3. Inspect all structures for cracks, bad welds, and other signs of fatigue.

4. Inspect erection cylinders for excessive leaks.

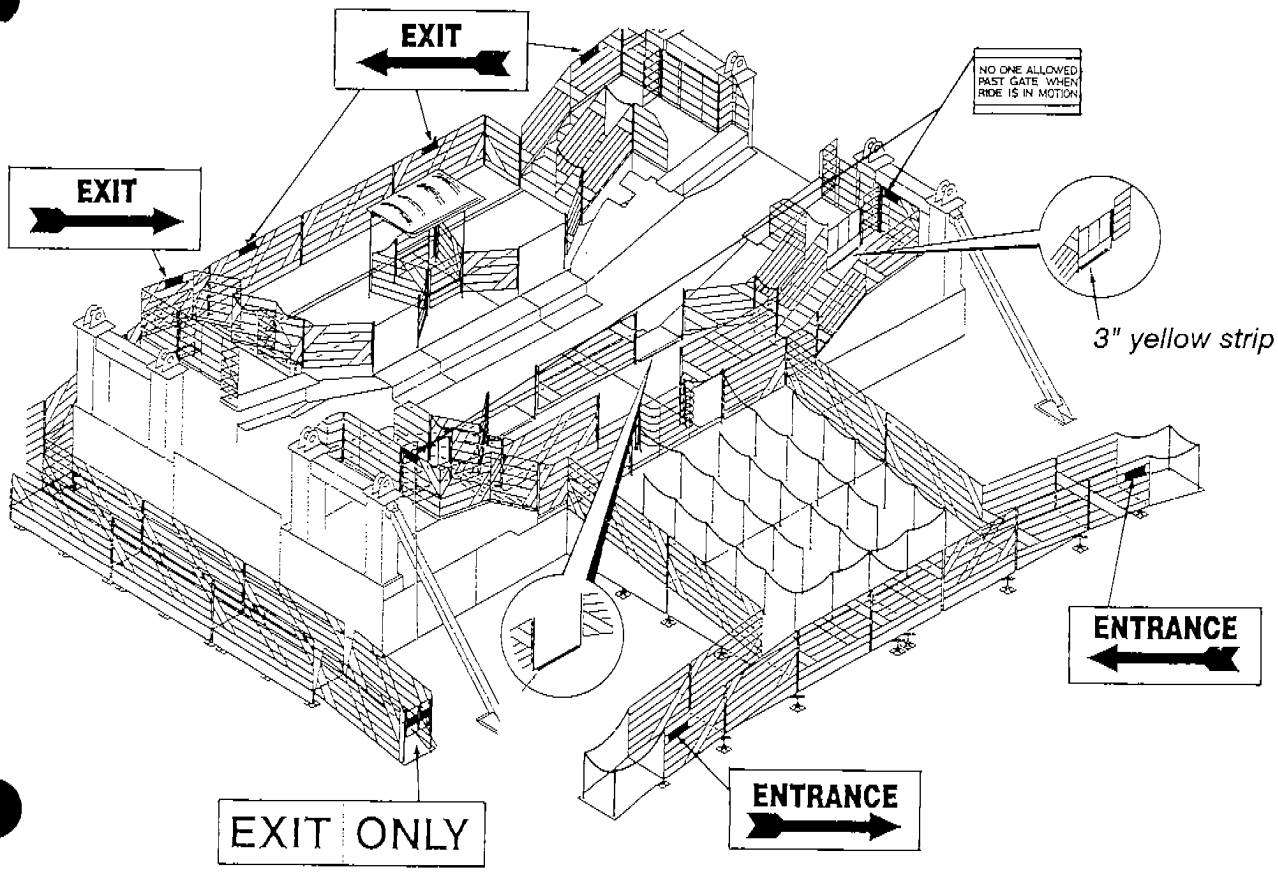
Platform and fence inspection

1. Inspect hand rails, ramps and walkways.[13]

2. Inspect all gates and queue line chains. All self-closing gates must operate properly.

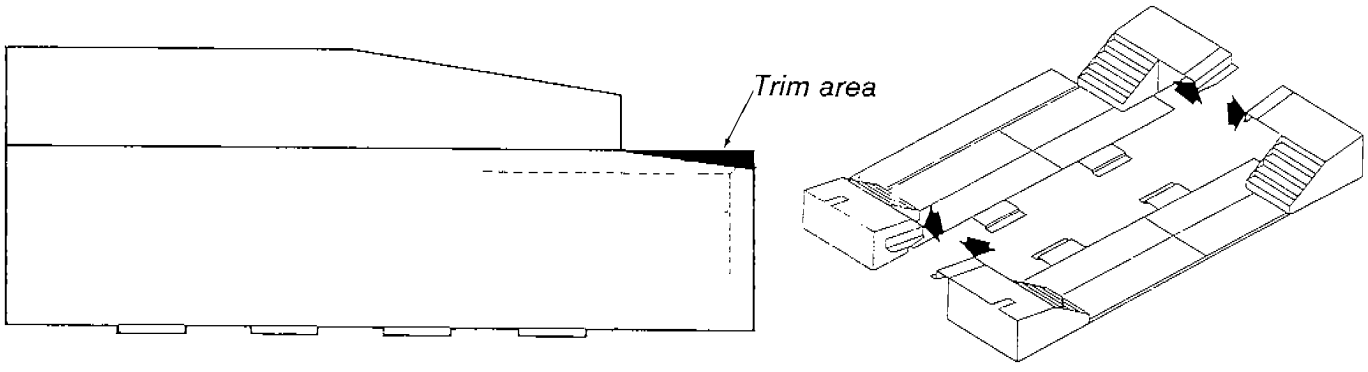
3. Check all entrance and exit signs.

4. Inspect all safety signs and placards.



5. Inspect floor for proper gondola clearance. Inadequate clearance, especially in the areas shown, can indicate leveling or set-up problems.[9, 12]

NOTE: *Ride serial numbers 400-00188 through 400-01289 must have floor extensions trimmed as shown.*



9 8400R1043-0 July 17, 1989
12 8400R1047-0 July 17, 1989

Material handling equipment inspection (portable model)

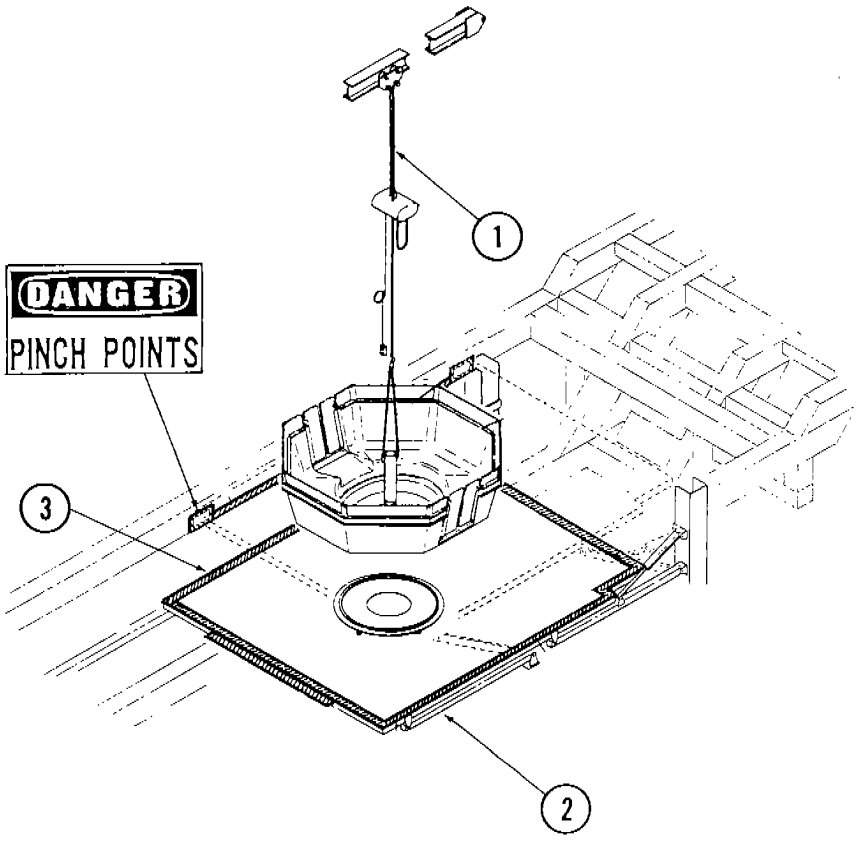
1. Inspect the overall condition of all cables, winches and rigging. Look for broken, worn or missing parts.

2. Inspect block and tackle for hoist track. The rope must not be cut or frayed.

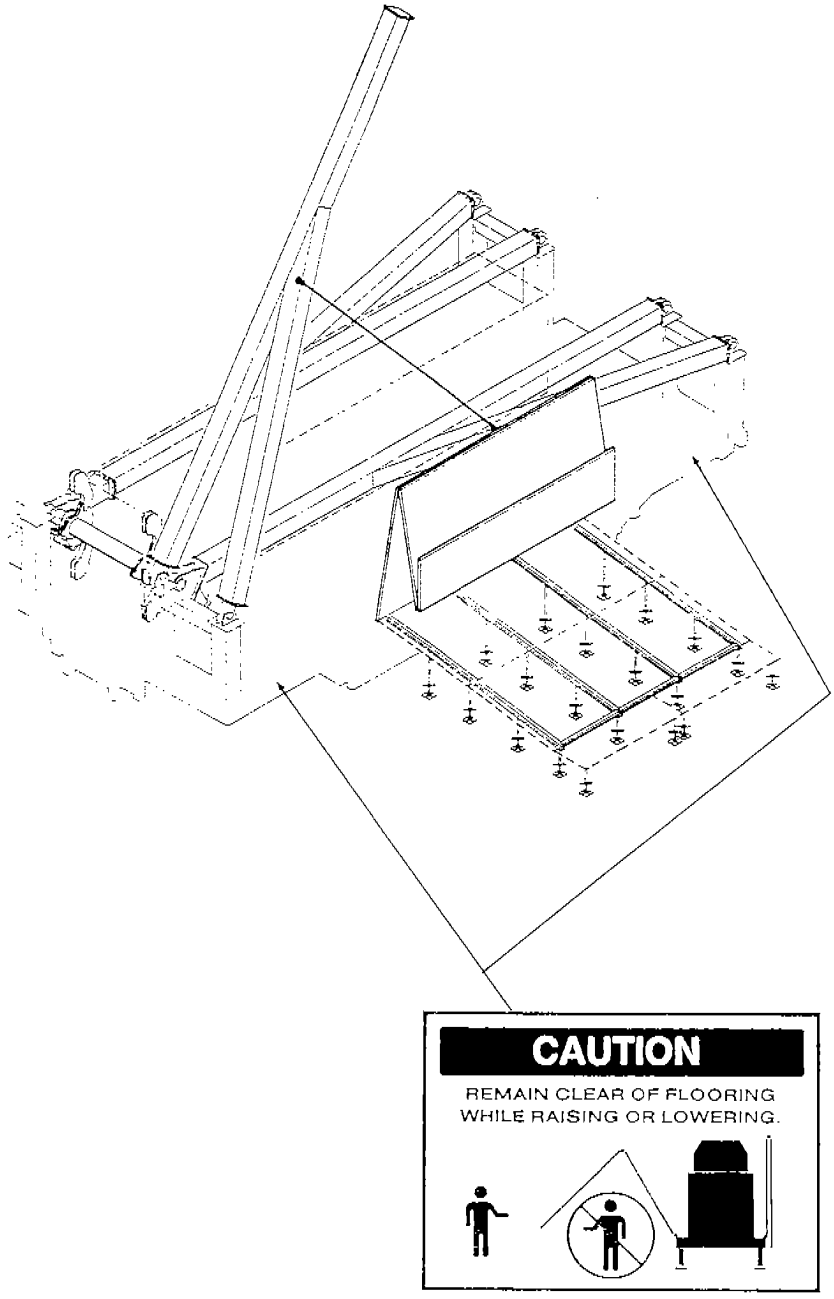
3. Check for proper operation of the hoist and track. The nylon strap must not be cut or frayed.

4. Check the operation of the lifting platform. All decals and warning stripes must be in place.

5. Inspect all safety signs and placards.[21]



1. Nylon strap
2. Lifting platform
3. Yellow abd black safety tape


CAUTION
REMAIN CLEAR OF FLOORING
WHILE RAISING OR LOWERING.

Bibliography

The following service bulletins and manuals are referenced in the preceding text. Service bulletins issued after publication of this guide are located at the back of each section. Any future bulletin releases affecting a ride will be provided by CHANCE RIDES, INC. Bulletins received after receipt of this guide should be considered updates to this guide.

CHANCE RIDES, INC.
4219 Irving
P.O. Box 12328
Wichita, KS 67277-2328

Giant Gondola Wheel Operation and Maintenance Manual
277-4360600
August, 1988

1. *Field Performance Testing Of Amusement Rides*
   B090R1002-0
   May 14, 1986

2. *Non-destructive Testing*
   B090R1022-0
   March 21, 1988

3. *Rim Iron Pins And Bushings*
   B400R1026-0
   October 14, 1988

4. *Retainer Clips For Rim Iron Light Bar Jumper Cables*
   B400R1030-0
   November 30, 1988

5. *Inspection Of Fasteners For T-bar Bearing Blocks*
   B400R1031-0
   November 17, 1988

6. *Hydraulic Cylinder Rework For Adjustable Long Spreader Bar*
   B400R1035-0
   March 22, 1989

7. *Inspection Of Torque Tube Fasteners*
   B400R1036-A
   August 17, 1990

8. *Hydraulic Leveling Cylinder Plumbing Rework*
   B400R1038-0
   May 25, 1989

9. *Floor Rework*
   B400R1043-0
   July 17, 1989

10. *Axle Conduit Coupling Check*
    B400R1045-0
    June 22, 1989

11. *Gondola Door Adjustment*
    B400R1046-A
    July 17, 1989

12. *Trailer Leveling Instructions*
    B400R1047-0
    July 17, 1989

13. *Crowd Controls*
    B400R1049-0
    September 15, 1989

14. *Tie Rod Installation*
    B400R1054-0
    January 19, 1990

15. *Plating On Gondola Stem*
    B400R1055-0
    February 1, 1990

16. *General Safety - Taper Pins*
    B090R1056-0
    February 9, 1990

17. *Axle Hub Rework*
    B400R1058-0
    February 16, 1990

18. *PLC Lighting Controller Box Recall And Decal Placement*
    B400R1062-0
    April 16, 1990

19. *Cable Inspection*
    B090R1071-0
    May 25, 1990

20. *Replacement And Torque Requirements For Functional Load Carrying Capscrews*
    B090R1075-0
    May 25, 1990

21. *Safety Decal*
    B090R1083-0
    August 17, 1990

DIVISION OF STANDARDS
FAIR RIDES INSPECTION

MEMORANDUM

DATE: May 3, 1996

TO: All Inspectors and Supervisors

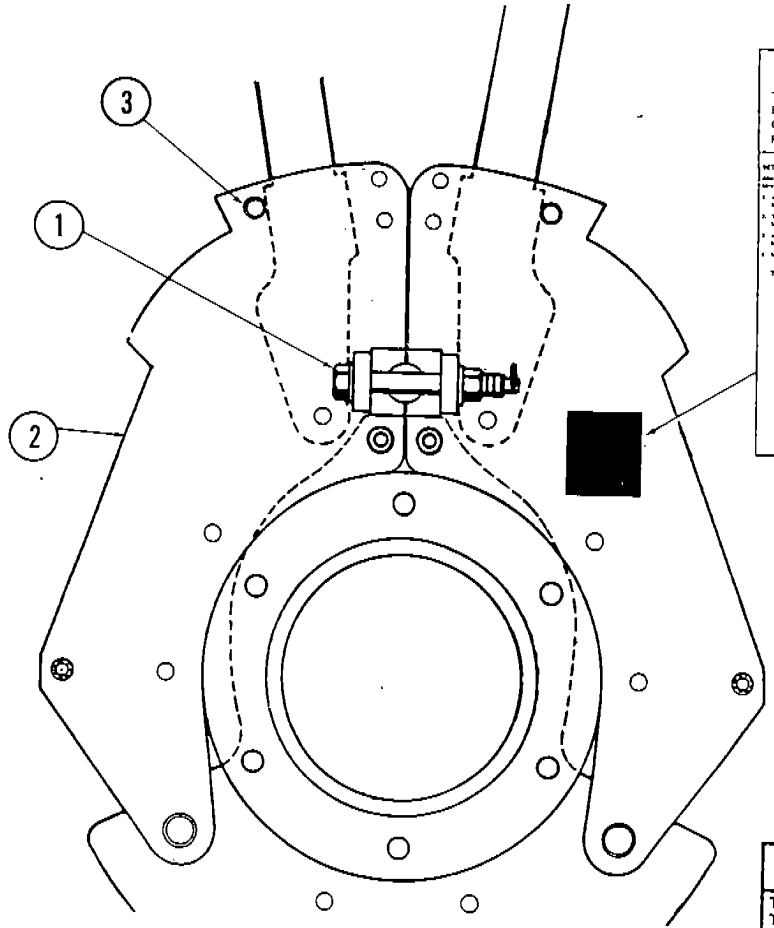
FROM: Ron Safford

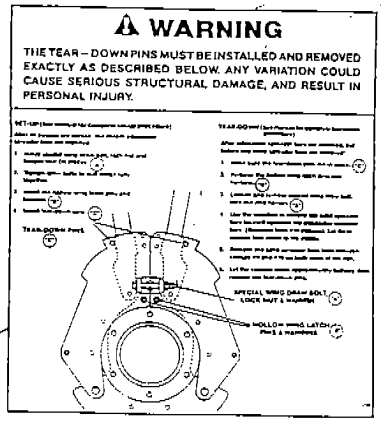
SUBJ: **CHANCE GIANT GONDOLA WHEEL**
<><><><><><><><><><><><><><><><><><><><>

Please be advised that Reithoffer's Giant Gondola Wheel developed a crack on the main axle where the end Flange is welded to the portion of the axle transported on the center trailer. I have also learned of two other Chance Gondola Wheels which cracked in the flange area. In both instances, the crack was only 4-5 inches long. One was Farrow's last summer and the other was Pugh Shows in Minnesota also last summer.

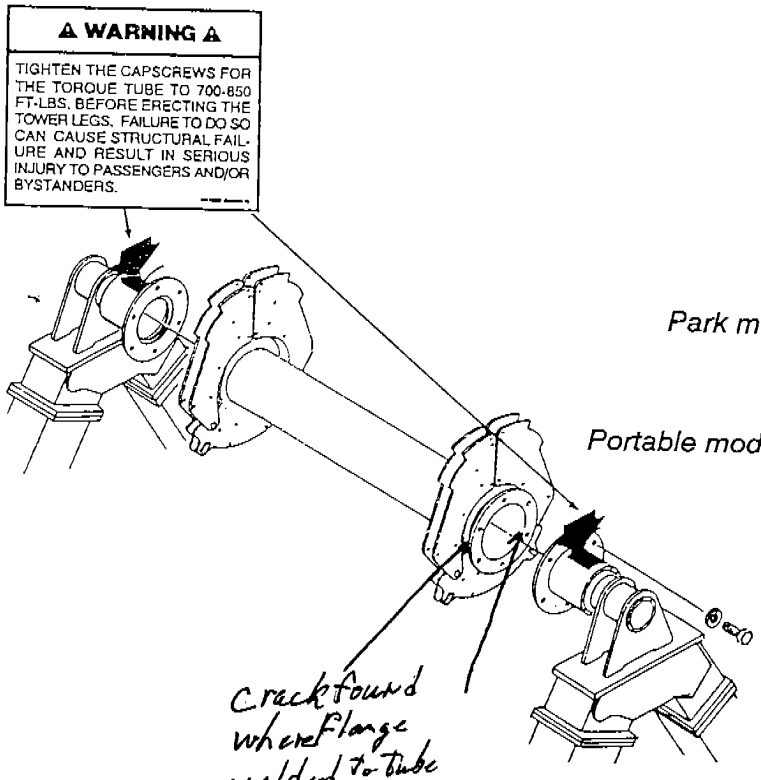
I expect we will soon have a bulletin on this ride.

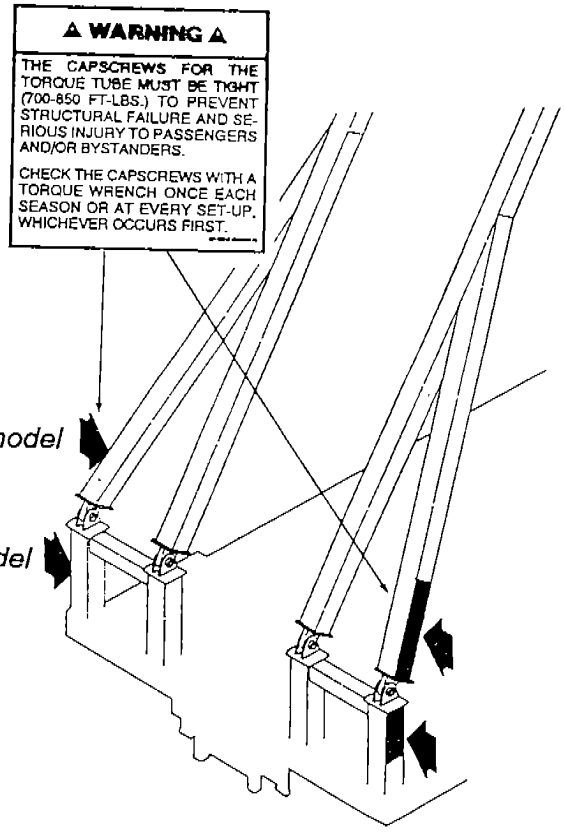
RS/sm





1. *Wing bolts*
2. *Hub wings*
3. *Tear-down pins*





M E M O R A N D U M

DATE: May 2, 1996

TO: Inspection Personnel

FROM: Ron Safford RS

SUBJ: **PERMIT EXPIRATION**

<><><><><><><><><><><><><><><><><><><><>

There have been a few instances in the past where we accepted the permit expiration as the last day of the month stamped rather than the date of annual inspection. This practice is no longer a valid option and all permits expire on the anniversary of the annual inspection.

RS/sm

DIVISION OF STANDARDS
FAIR RIDES INSPECTION

MEMORANDUM

DATE: May 3, 1996

TO: All Inspectors and Supervisors

FROM: Ron Safford

SUBJ: **OBSERVATIONS**

< > < > < > < > < > < > < > < > < > < > < > < > < > < > < > < > < > < > < > < > < >

1. Issue new plates when the old plate is lost ($100) or it is the first time the device or attraction is being permitted. If it changes owners, keep the old plate, but issue new permit.

2. Check annual inspection for each piece, not just the company. Sometimes all devices and attractions are not on the annual.

3. Check insurance for each device and attraction, not just the company. Policies may be issued for a specific list of devices and attractions. Others are not insured.

4. Use checklist to avoid errors.

5. Get application for each permit and a certificate of insurance.

6. Use correct confirmation numbers when on the weekly schedule or the office gives you a confirmation number. Use 00 only when none has been assigned.

7. Submit reports, application, invoices, together and in a very timely manner.

8. Get check with invoice. It is illegal to operate without payment. So only let the check be mailed with my permission.

RS/sm

AMUSEMENTS OF AMERICA
America's Most Imaginative Midway
24301 S.W. 137th Ave. ★ Miami, Florida 33032
Phone: (305) 258-2020 ★ Fax.: (305) 258-2945

RON SAFFORD
904 488-9023

FACSIMILE TRANSMISSION COVER SHEET

DATE:	04/15/94
SENT TO:	CHANCE RIDES
LOCATION:	WICHITA, KS
ATTN:	STEVE LAYCOCK
FAX NO.:	316 941-1617 942-0401
FROM:	BILL COSTAGLIOLA
LOCATION:	PRINCETON, FL

RECEIVED
APR 15 1994
BUREAU OF
FAIR RIDES INSPECTION

TOTAL NUMBER OF PAGES INCLUDING THIS COVER PAGE: 1

IF NOT RECEIVED INTACT, PLEASE ADVISE AT (305) 258-2020

REGARDING: COUNTERFEIT 3/16" BLACK TIE WRAPS

I have become aware of a situation which may interest you. Last week, a seedy looking character wearing dark glasses tried to sell me tie wraps out of the back of his car. He claimed that they were industrial strength, grade 8 black 3/16" tie wraps, rated for use on Chance Gondola and Century Wheels and NASA space shuttles. I got suspicious because he was selling these wraps for about 10 per cent of the price we usually pay for tie wraps of this high quality. Upon closer examination, I found out that these tie wraps were really 1/8" white ones that had been covered with black eye mascara to make them look thicker and fuller.

Due to the critical nature 3/16" black tie wraps play in the design and construction of your rides, I felt it was my duty to inform you of this despicable situation. I would not be able to live with myself if someone were to be injured due to the failure of one of these counterfeit tie wraps.

Bill

SPECIFICATIONS

This ride conforms with all applicable ASTM amusement ride standards in effect on the date of manufacture.

SEATING

Number of gondolas 20
Maximum number of passengers per gondola ..... 6 adults* or 8 children
Maximum total weight per gondola ..... 1,296 lbs.
Maximum total number of passengers ..... 120 adults* or 160 children
Maximum total passenger weight ..... 25,920 lbs.
Minimum passenger height ..... 42 inches (unaccompanied by adult)
Loading ..... 4 gondolas simultaneously
Maximum unbalance ..... 12 adults* (2,592 lbs.)

PERFORMANCE

Direction of travel ..... Clockwise and counter-clockwise
Ride speed ..... (maximum) 2.5 rpm
Maximum wind speed (operating) ..... 35 mph
Maximum wind speed (static) ..... 80 mph
(guy wires recommended in high winds)

MAXIMUM RIDE WEIGHT (empty) ..... 195,000 lbs.

DRIVE ..... 60 hp electric

POWER REQUIREMENTS

Total ..... 130 kW
Drive ..... 70 kW
Lights ..... 60 kW
Minimum/Maximum line voltage 208/240

LIGHTING ..... 110 volt programmed incandescent

TRAILERING

	Front Trailer	Center Trailer	Rear Trailer	Van Trailer
Height	13 ft. 6 in.	13 ft. 6 in.	13 ft. 6 in.	13 ft. 6 in.
Width	8 ft. 6 in.	8 ft. 6 in.	8 ft. 6 in.	8 ft.
Length	48 ft.	48 ft.	48 ft.	45 ft.
Total Weight	59,150	59,500	58,900	31,300
Rear Axle Weight	33,400	34,000	32,500	19,300
King Pin Weight	25,750	25,500	26,400	12,000

ERECTION

Towers lift into position with trailer-mounted hydraulic cylinders. All spokes are raised in place with tower legs.

*A maximum load can be derived from random individual passenger weights, but must not exceed the specifications given.

Specifications are effective as of publication date. Because we try to improve every Chance product, these specifications are subject to change without notice.

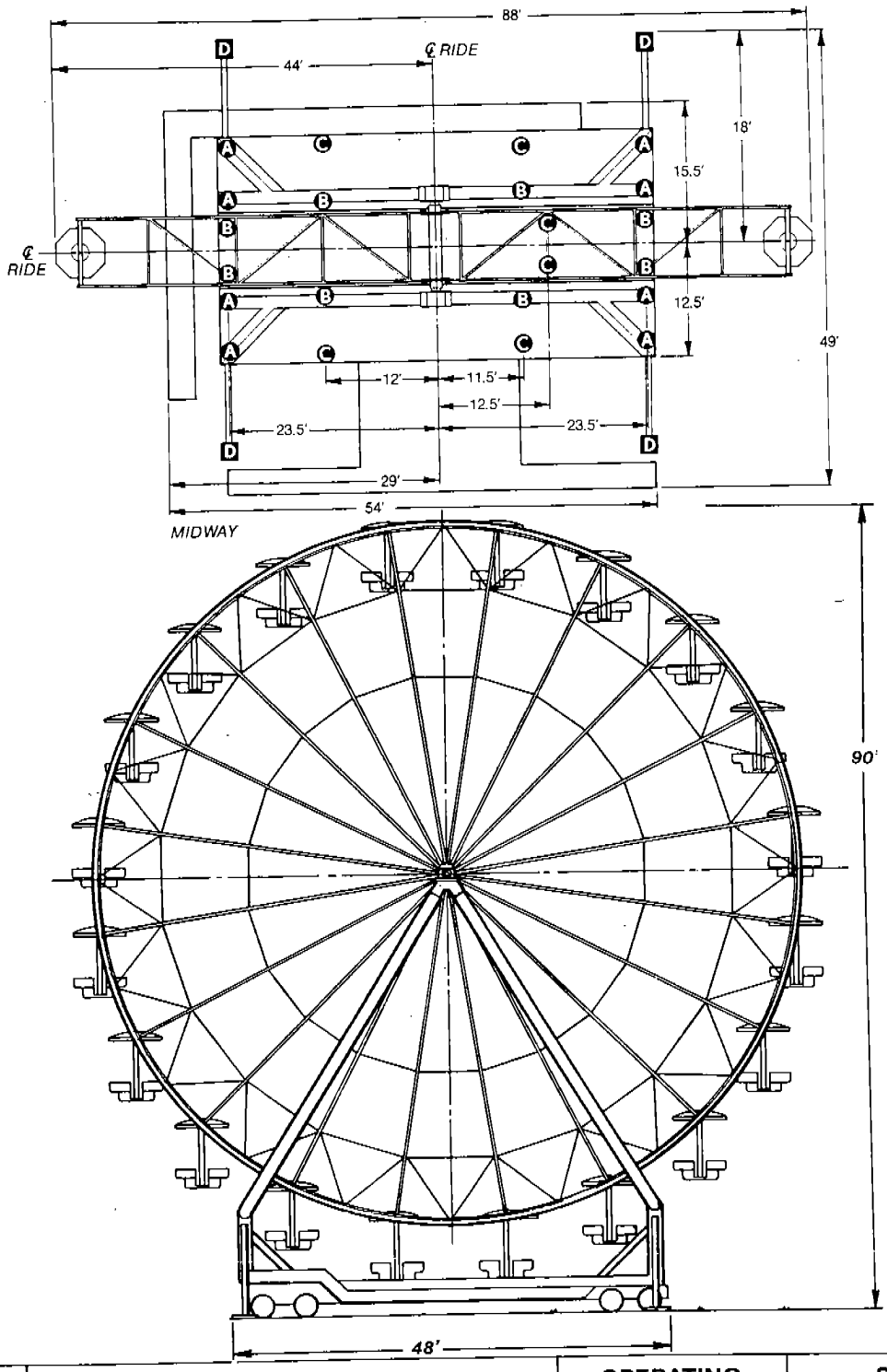
PORTABLE MODEL **GIANT GONDOLA WHEEL**

CHANCE RIDES INC.

America's Largest Manufacturer of Amusement Rides

4219 Irving
P.O. Box 12328
Wichita, KS 67277-2328

Telephone (316) 942-7411
Telex: 910 9976518 (CHANCE WIC)
FAX: (316) 942-7416



SYMBOL	DESCRIPTION	OPERATING — NO WIND 120 PASSENGERS*	STATIC 80 MPH WIND NO PASSENGERS
A	TRAILER SCREW JACK	25,000	44,000 VERTICAL 8,000 HORIZONTAL
B	TRAILER SCREW JACK	9,000	24,000 VERTICAL 6,000 HORIZONTAL
C	TRAILER SCREW JACK	5,000	6,000 VERTICAL 2,000 HORIZONTAL
D	OUTRIGGER	5,000	27,000 VERTICAL 16,000 HORIZONTAL