

MFG: CHANCE RIDES, INC.
NAME: ROCK & ROLL
TYPE: NON-KIDDIE

ROK-N-ROL

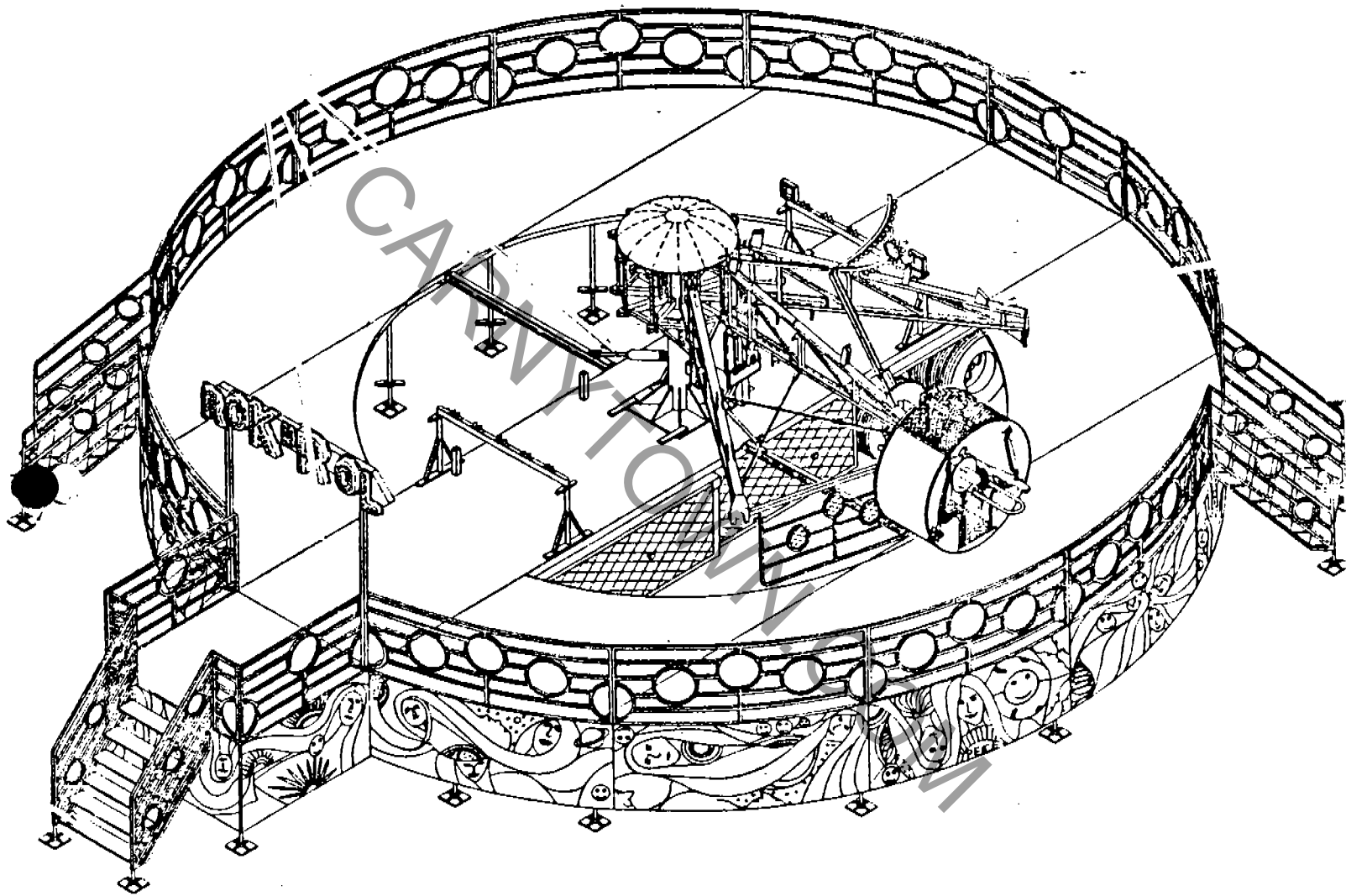
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ROK-N-ROL

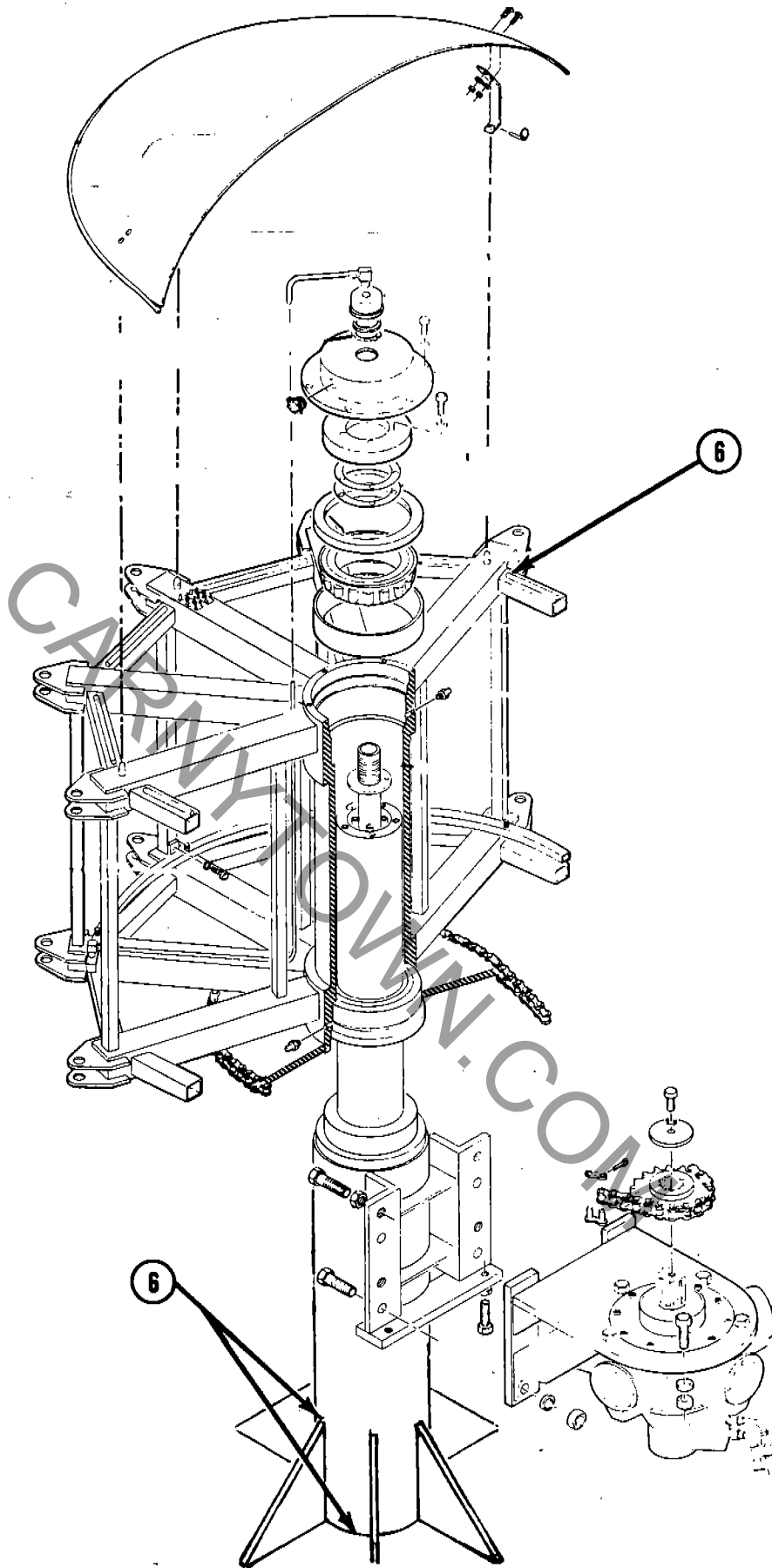
Ride Serial Number _____ Owner _____ Date _____

FIELD INSPECTION POINTS

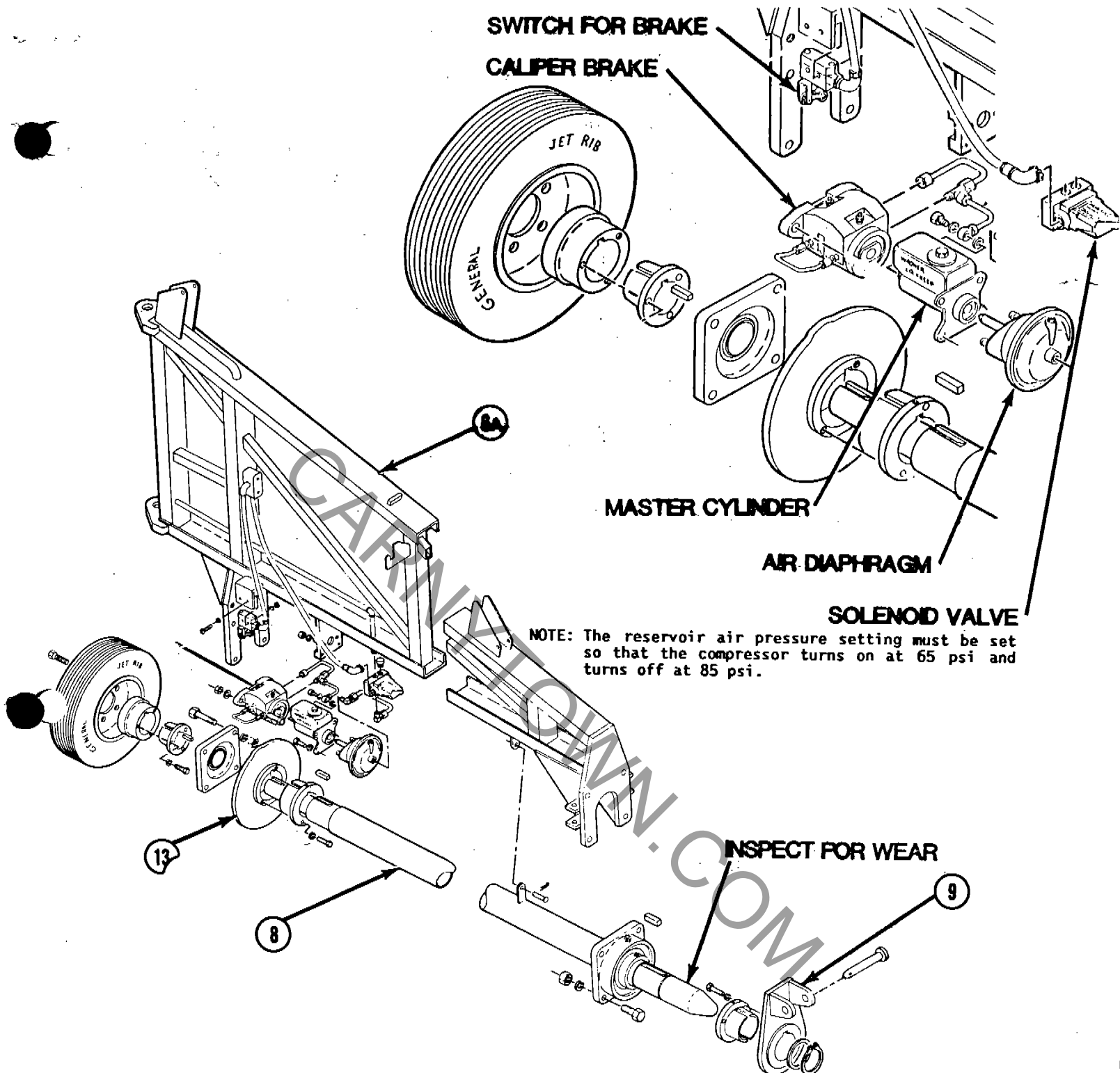
1. () Inspect blocking and leveling.
2. () Inspect lock nuts on leveling jacks.
3. () Inspect hydraulic valves for leveling jacks.
4. () Inspect cable leads, electrical connections and grounding per local code.
5. () Inspect fences and steps for proper installation and leveling. Check all jack stands.
6. () Inspect hub and spindle for cracks.
- 6A. () Inspect sweeps and pins for cracks.
7. () Inspect floor and lift arm hinges for cracks (Bulletin 55).
8. () Inspect the looping shaft for cracks and wear. Inspect the seat spindle for wear (Bulletin B22-0319-00).
9. () Inspect the pin holding the seat to the looping shaft.
10. () Inspect the seats for cracks. Hand rail and seat belt must be in place (Bulletins B22-0319-00 and B22-0320-00).
11. () Inspect the seat belt clamps for proper operation (Bulletins B22-0290-00, B22-0290-0A and B22-0320-00).
12. () Inspect floor jacks for proper installation.
13. () Inspect the holding brake on each seat, including the master cylinder, caliper brake, solenoid air valve, air diaphragm, brake switch and track limit switch (Bulletin 21).
14. () Check the ride speed - 6 rpm maximum.
15. () Check ride for excessive vibration.
16. () Inspect the structure for cracks, bad welds, etc.
17. () Inspect electrical wiring for short circuits, bad wires, etc.
18. () Inspect for hydraulic leaks.
19. () Inspect overall appearance of ride for cleanliness and general overall upkeep.



14. () Check the ride speed - 6 rpm maximum.



6. () Inspect hub and spindle for cracks.

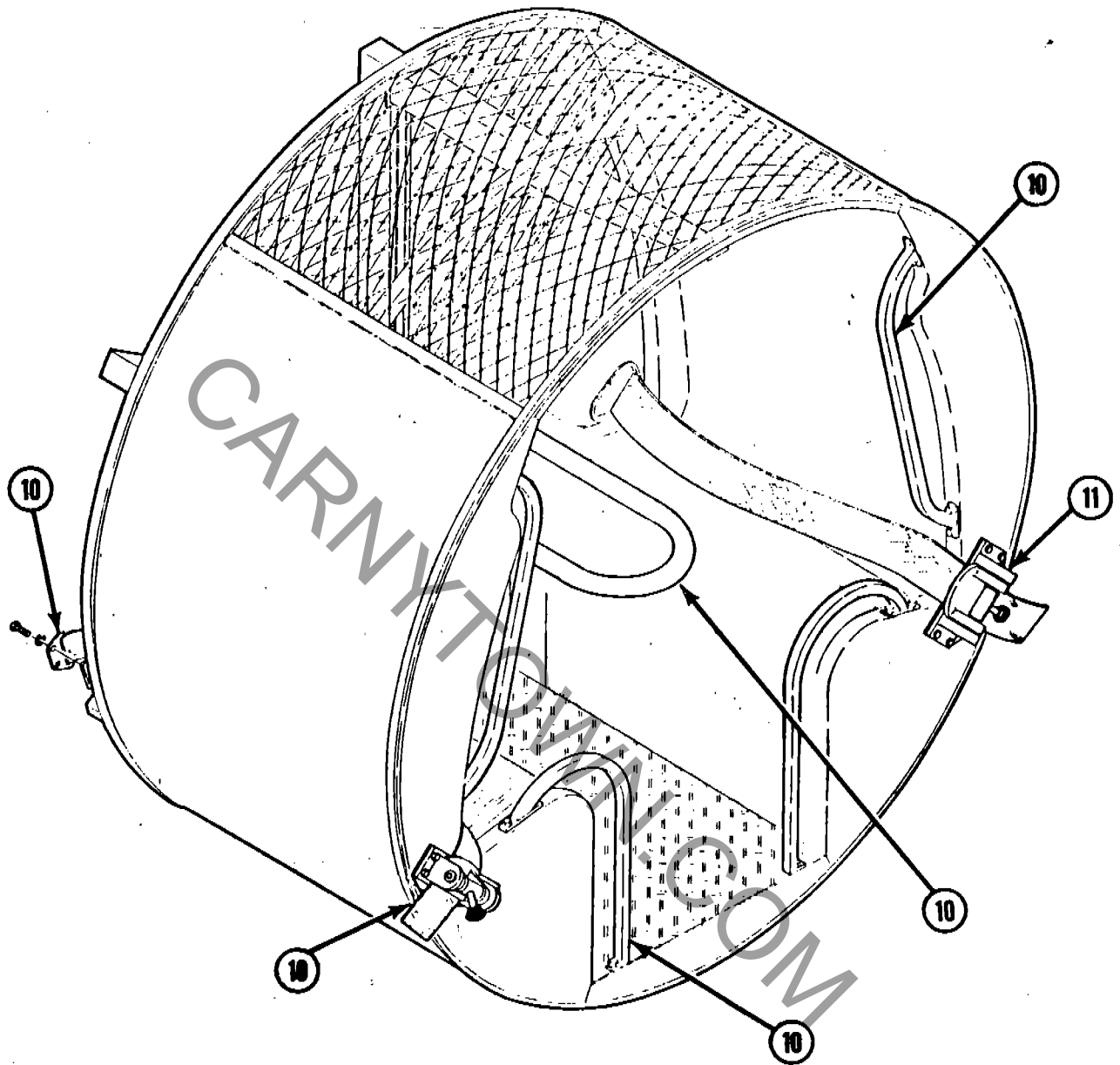


6A.() Inspect sweeps and pins for cracks.

8. () Inspect the looping shaft for cracks and wear. Inspect the seat spindle for wear (Bulletin B22-0319-00).

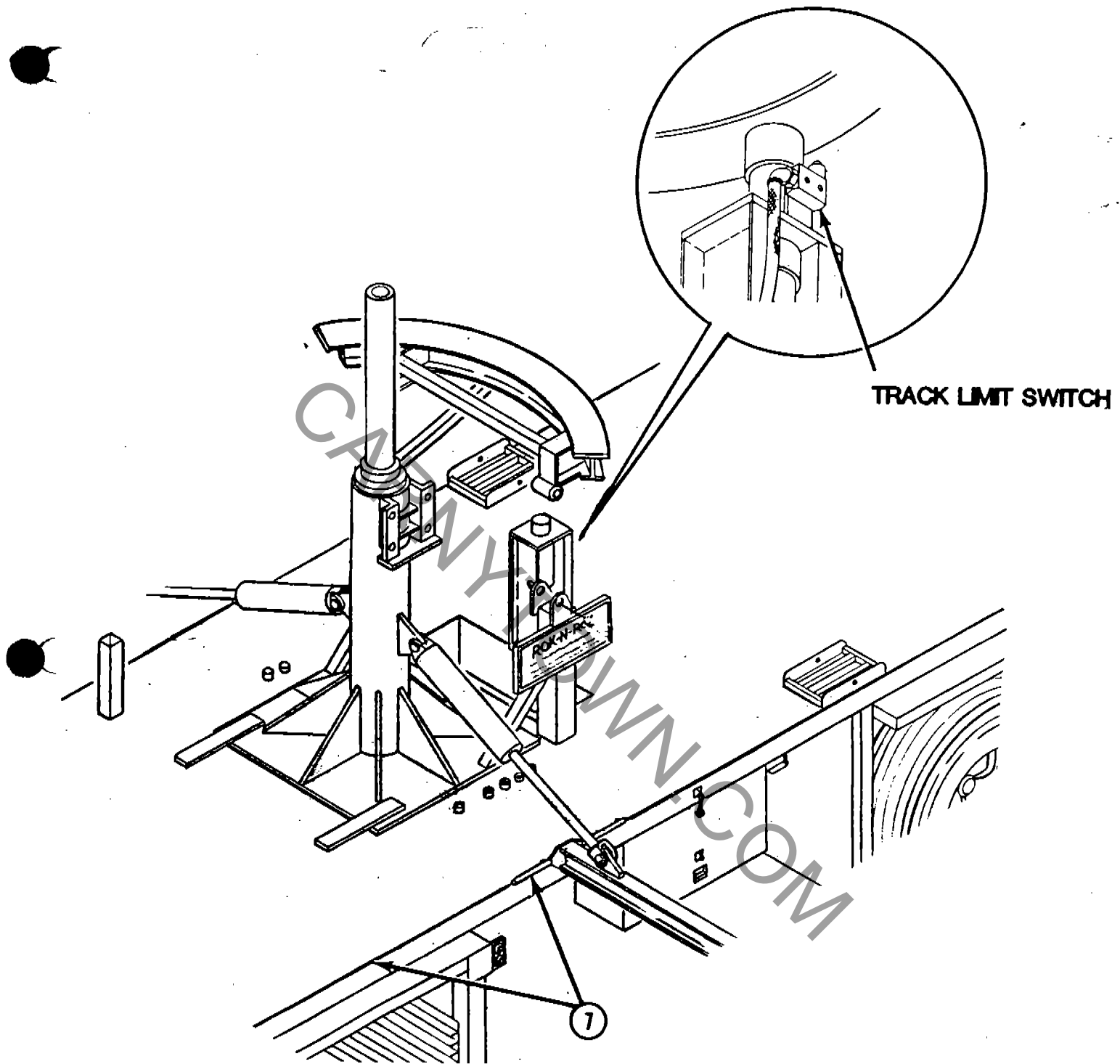
9. () Inspect the pin holding the seat to the looping shaft.

13. () Inspect the holding brake on each seat, including the master cylinder, caliper brake, solenoid air valve, air diaphragm, brake switch and track limit switch (Bulletin 21).



10. () Inspect the seats for cracks. Hand rail and seat belt must be in place (Bulletins B22-0319-00 and B22-0320-00).

11. () Inspect the seat belt clamps for proper operation (Bulletins B22-0290-00, B22-0290-0A and B22-0320-00).



- 7. () Inspect floor and lift arm hinges for cracks (Bulletin 55).
- 13. () Inspect the holding brake on each seat, including the master cylinder, caliper brake, solenoid air valve, air diaphragm, brake switch and track limit switch (Bulletin 21).

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Number: A22-0320-00

Date: April 20, 1988

Supersedes:

America's Largest Manufacturer of Amusement Rides

SAFETY ALERT

Effective Serial Numbers: 72-3101 through 77-3134

Ride: ROK-N-ROL

Subject: Seat Belt Latch



WARNING: FAILURE TO COMPLY WITH THIS SAFETY ALERT BULLETIN CAN RESULT IN INJURY TO PASSENGERS.

Effective immediately, CHANCE MANUFACTURING COMPANY, INC. requires all owners of ROK-N-ROL amusement rides to perform the modification described in this bulletin.

Perform the modification using the instructions on the following pages of this bulletin. Return the attached Certification Of Compliance 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 modification, contact the CHANCE CUSTOMER SERVICE DEPARTMENT immediately.

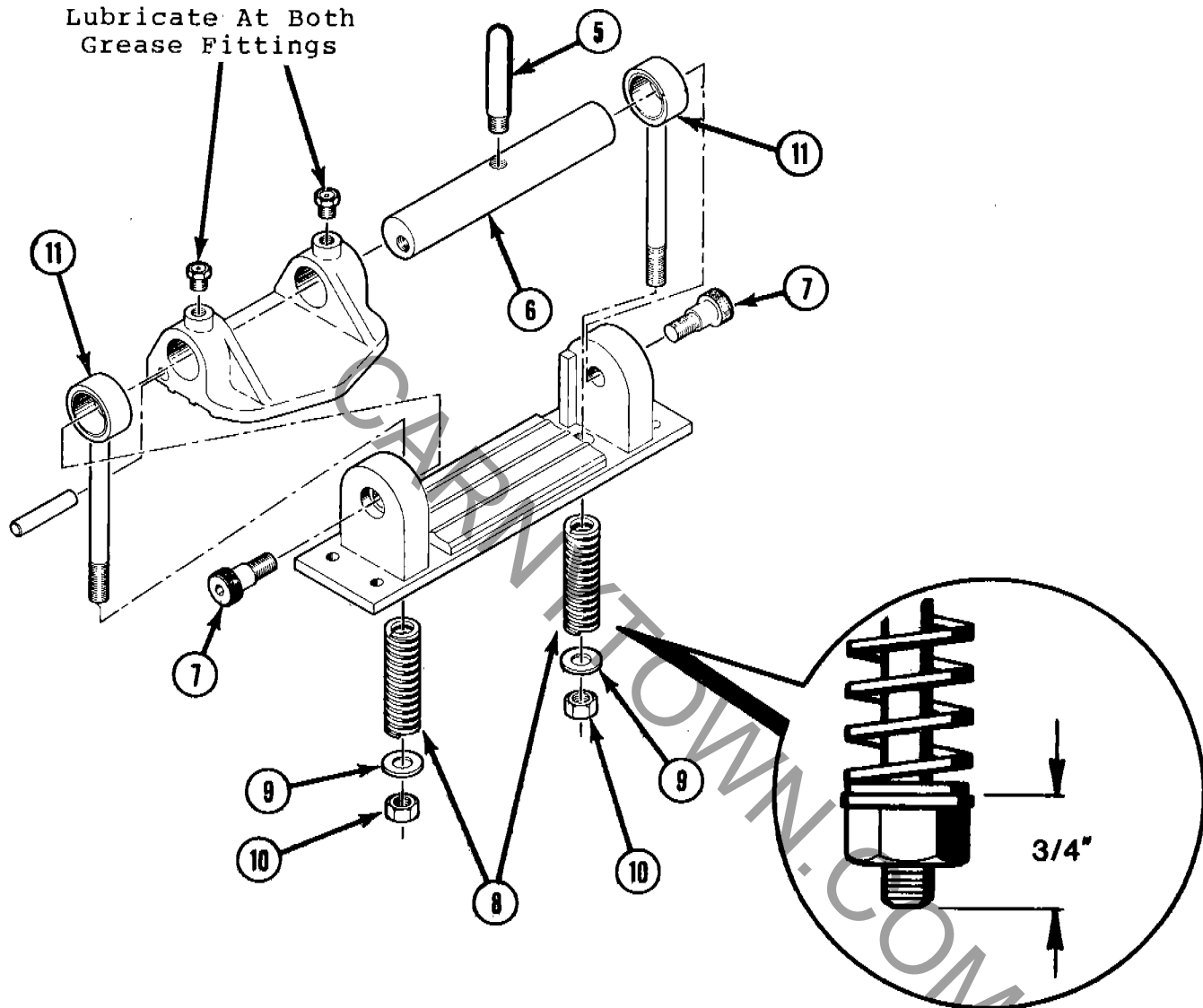
Order Kit No. K22-0320-00, Seat Belt Latch Kit to perform the modification. The kit includes the following parts:

<u>Item</u>	<u>Part No.</u>	<u>Description</u>	<u>Qty.</u>
1	322-53382	SEAT BELT LATCH PLATE - R.H. (373-118-001)	.. 10
2	322-53383	SEAT BELT LATCH PLATE - L.H. (373-118-002)	.. 10
3	686-07004	BOLT (1/4-20 x 1) 80
4	696-85370	LOCKWASHER (1/4) 80
5	322-32520	HANDLE (373-108-016) 20
6	322-65697	SHAFT (373-108-018) 20
7	686-12264	SHOULDER BOLT (1/2 x 1/2 x 3/8-16) 40
8	290-71895	SPRING 40
9	696-85310	WASHER (3/8) 40
10	691-47816	LOCKNUT (3/8-16) 40
11	322-17630	EYE BOLT (373-108-005) 40

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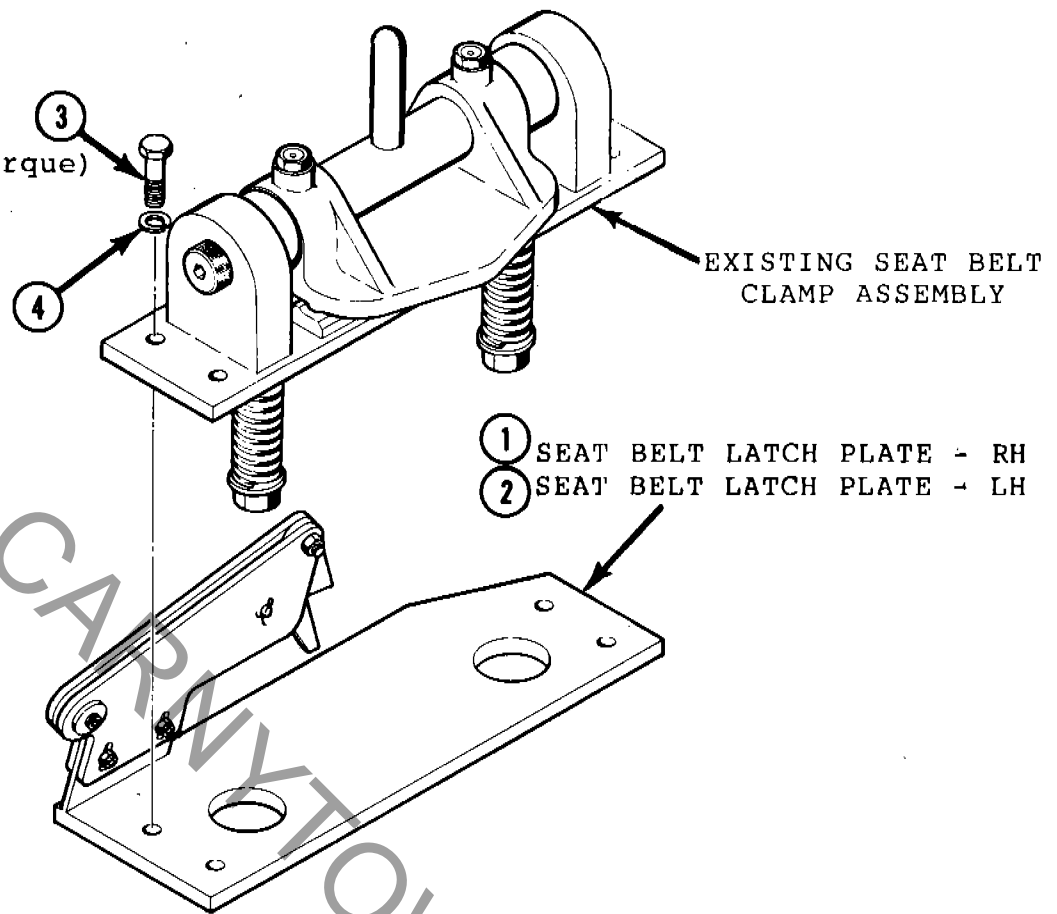
INSTALLATION INSTRUCTIONS



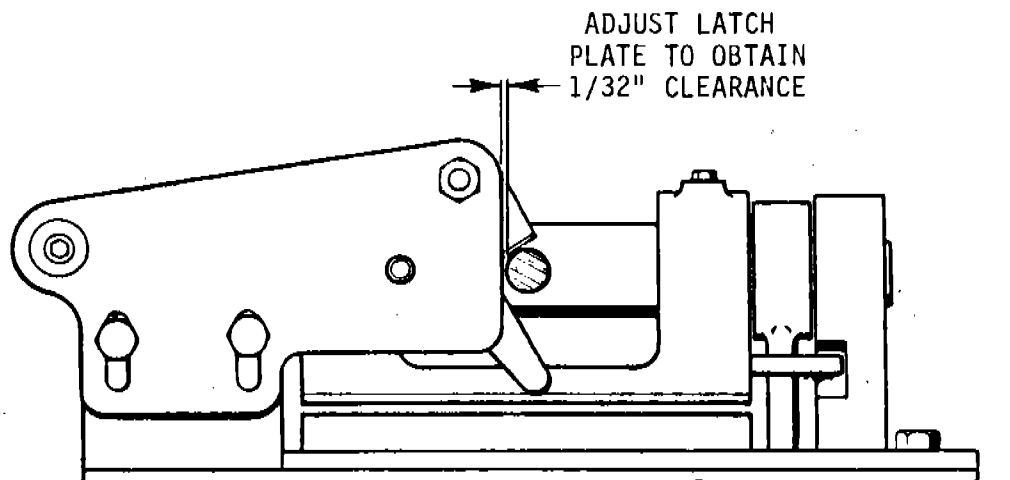
Tighten Nut To Obtain
Correct Spring Preload
As Shown

1. Remove the seat belt clamp and discard the attaching hardware. Disassemble the seat belt clamp and inspect all the components. The handle (Item #5) and shaft (Item #6) must be replaced with the new parts provided in the kit. The new handle is larger in the threaded area for increased strength. Also replace the shoulder bolts (Item #7), eye bolts (Item #11), springs (Item #8), washers (Item #9) and locknuts (Item #10). If any other parts are worn or damaged, order replacement parts from the CHANCE CUSTOMER SERVICE DEPARTMENT.

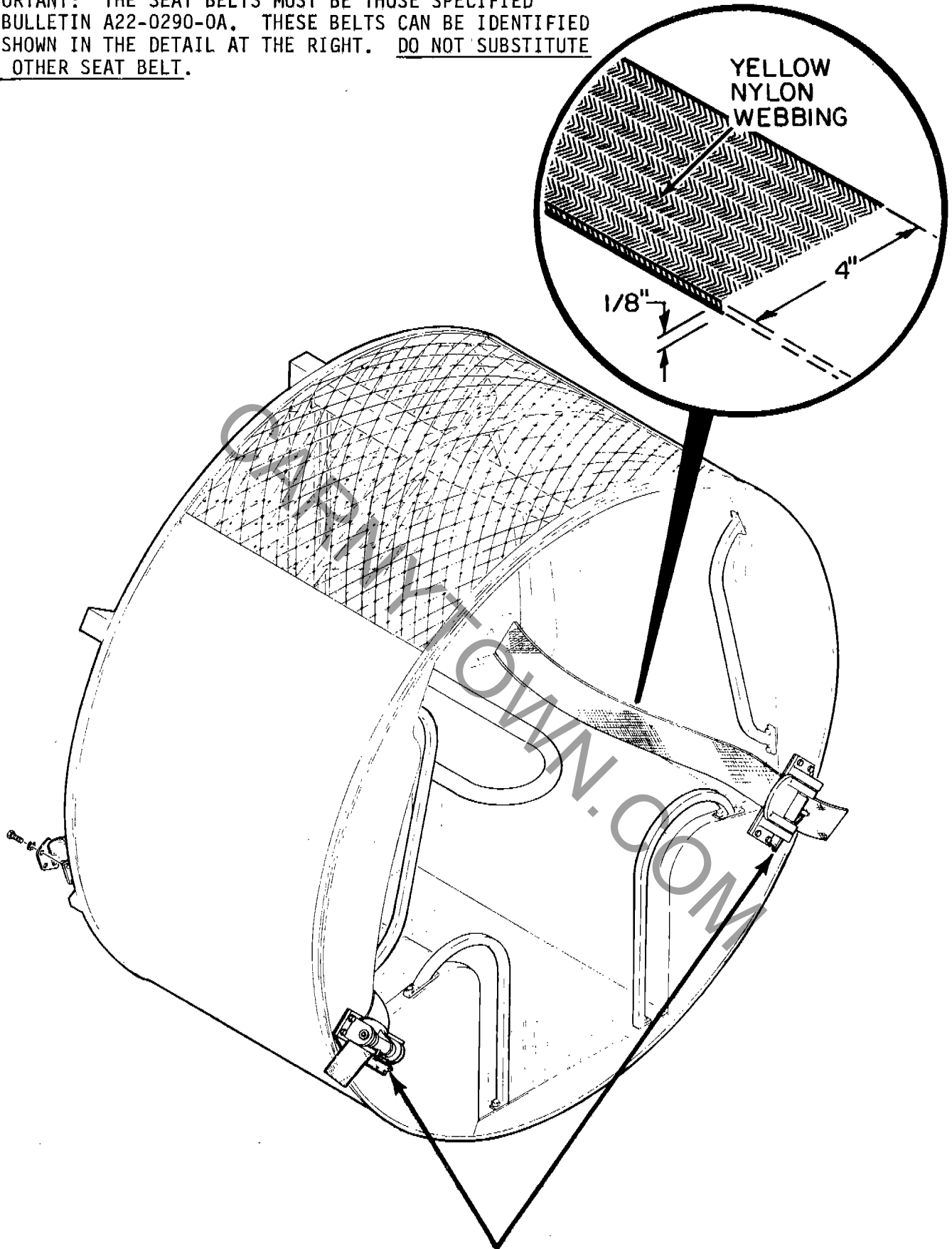
(5-6 ft-lb. torque)



2. Reassemble the seat belt clamp. Install the seat belt latch plate under the seat belt clamp as shown using the new bolts and lockwashers provided. Adjust the latch plate to obtain the clearance shown between the handle and the latch plate. Tighten the bolts to 5-6 ft-lb torque

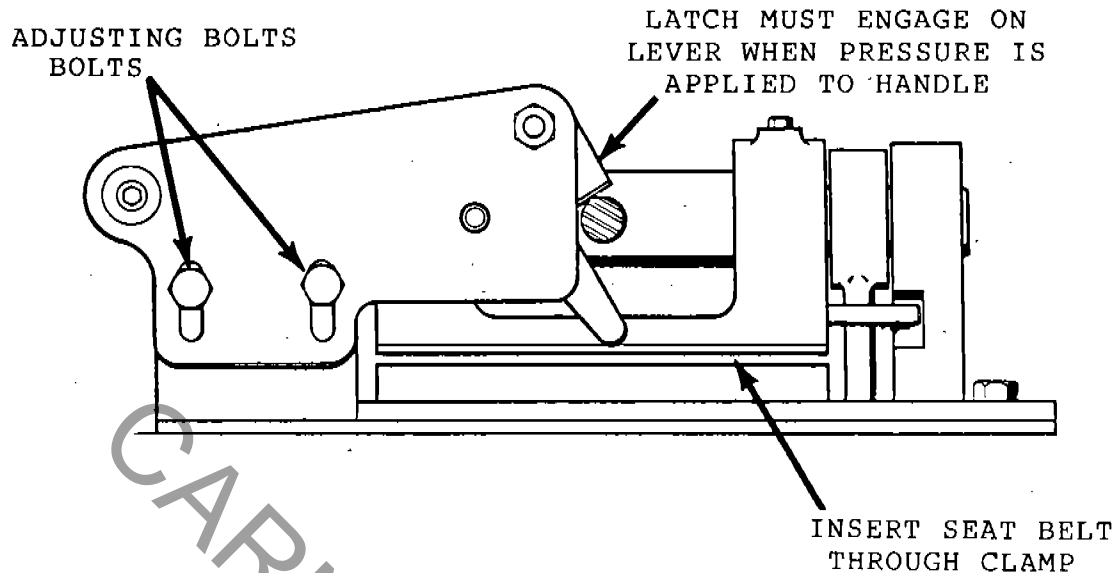


IMPORTANT: THE SEAT BELTS MUST BE THOSE SPECIFIED IN BULLETIN A22-0290-0A. THESE BELTS CAN BE IDENTIFIED AS SHOWN IN THE DETAIL AT THE RIGHT. DO NOT SUBSTITUTE ANY OTHER SEAT BELT.




IMPORTANT: The seat belt latch plates are provided as right hand and left hand parts. Install them as shown so that the latch lever is in the lowest position on the seat.

3. Adjust the latch plate as described below:



- Loosen adjusting bolts.
- Insert the seat belt through the seat belt clamp and apply the clamp
- Adjust the latch so that it engages on the clamp lever when pressure is applied to the clamp handle.
- Tighten the adjusting bolts to 5-6 ft-lb. torque.

4. Repeat Steps #1, #2 and #3 for all remaining seats.

 **WARNING: NEVER OPERATE THE RIDE WITH THE SEAT BELT LATCH OUT OF ADJUSTMENT. ALWAYS PUSH DOWN ON THE SEAT BELT CLAMP HANDLE AND BE SURE THE SEAT BELT LATCH ENGAGES SECURELY.**

Inspect the condition of the seat belts, clamps and latches daily. The clamp must operate freely without binding. Do not attempt to repair a worn broken or damaged part. Replace it with a new part.

ADJUST THE SEAT BELT LATCH AT MONTHLY INTERVALS TO COMPENSATE FOR NORMAL WEAR OF PARTS. ALWAYS TIGHTEN THE ADJUSTING BOLTS TO THE CORRECT TORQUE.

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Number: B22-0319-00
Date: March 25, 1988

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 72-3101 through 77-3134

Ride: ROK-N-ROL Subject: Seat Spindle Repair

CHANCE MANUFACTURING CO., INC. has developed a kit to repair worn seat spindles on the sweeps of ROK-N-ROL amusement rides with the above noted serial numbers. The rework consists of welding repair sleeves into the seat frames, plus turning the seat spindles to a corresponding size.

Perform the inspection as described on the following page of this bulletin to determine whether or not your ride requires this repair. If repair is necessary, order kit number K22-0319-00. The kit includes parts to repair one complete ride.

Install the kit using the instructions in this bulletin. All work must be performed by competent, qualified mechanics, capable of understanding the function of the parts and their proper installation.

Fill out the attached Certification Of Compliance for the inspection and/or the repair within fifteen (15) days of receipt of this bulletin. If there are any questions regarding the instructions or this repair, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

PARTS LIST

Kit No. K22-0319-00, Seat Spindle Repair, includes the following:

<u>Item</u>	<u>Part No.</u>	<u>Description</u>	<u>Qty.</u>
1	322-68374	REPAIR SLEEVE (K22-0319-01)	10
2	686-67868	BOLT - Grade 8 (3/8-16 x 1-3/4)	30
3	696-85531	WASHER - Hardened (3/8)	30
4	---	INSTALLATION DRAWING (373-150-001)	1

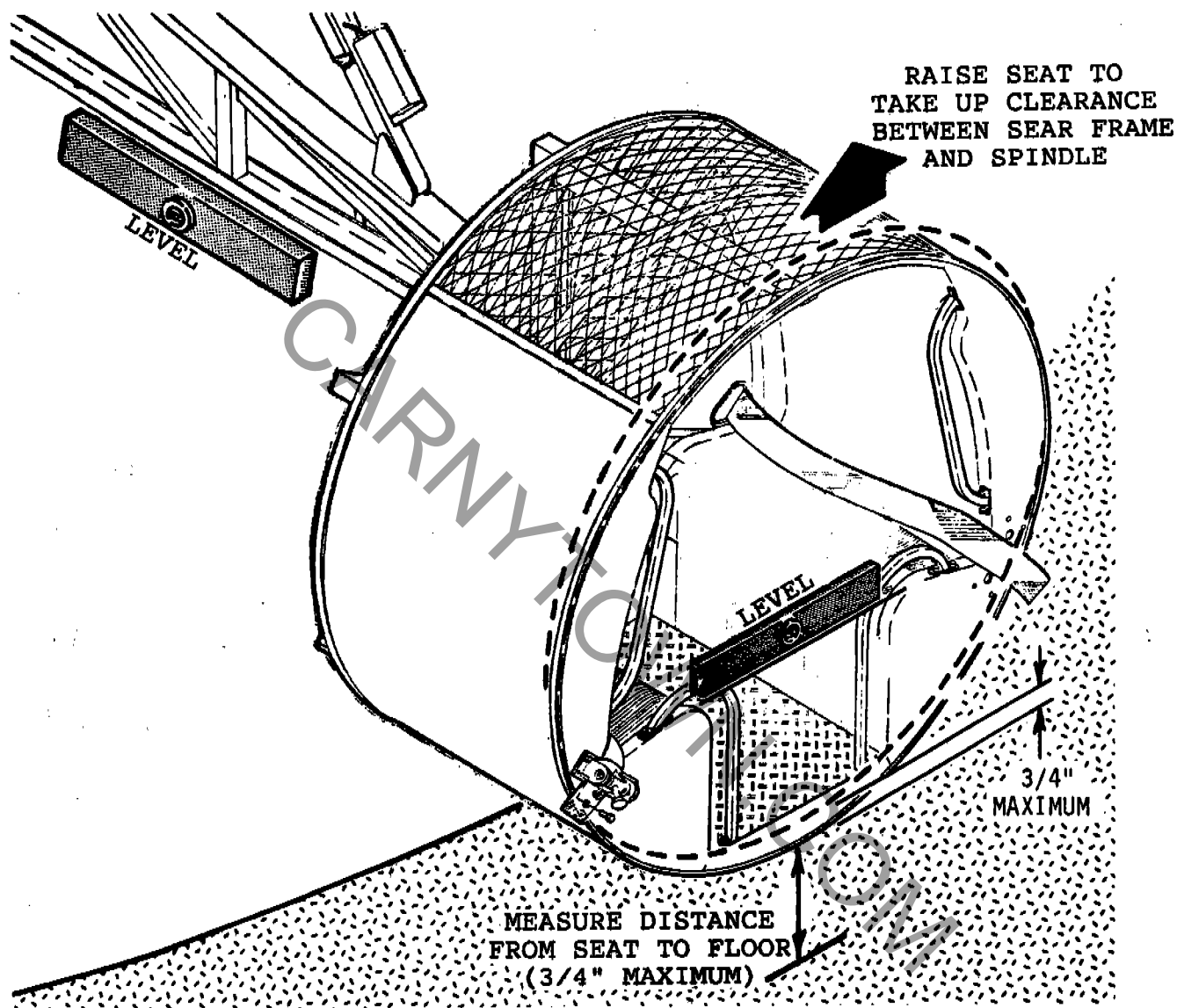
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INSPECTION PROCEDURE

Check each seat spindle for excessive wear using the following procedure.

1. The ride must be set up and level, as for normal operation. The sweeps and each seat must be level.



2. Measure the distance from the floor to the bottom of the seat as shown, and record this measurement.

3. Raise the seat as shown, taking up the clearance between the seat frame and the spindle. Measure and record the distance between the same spot on the floor and the bottom of the seat.

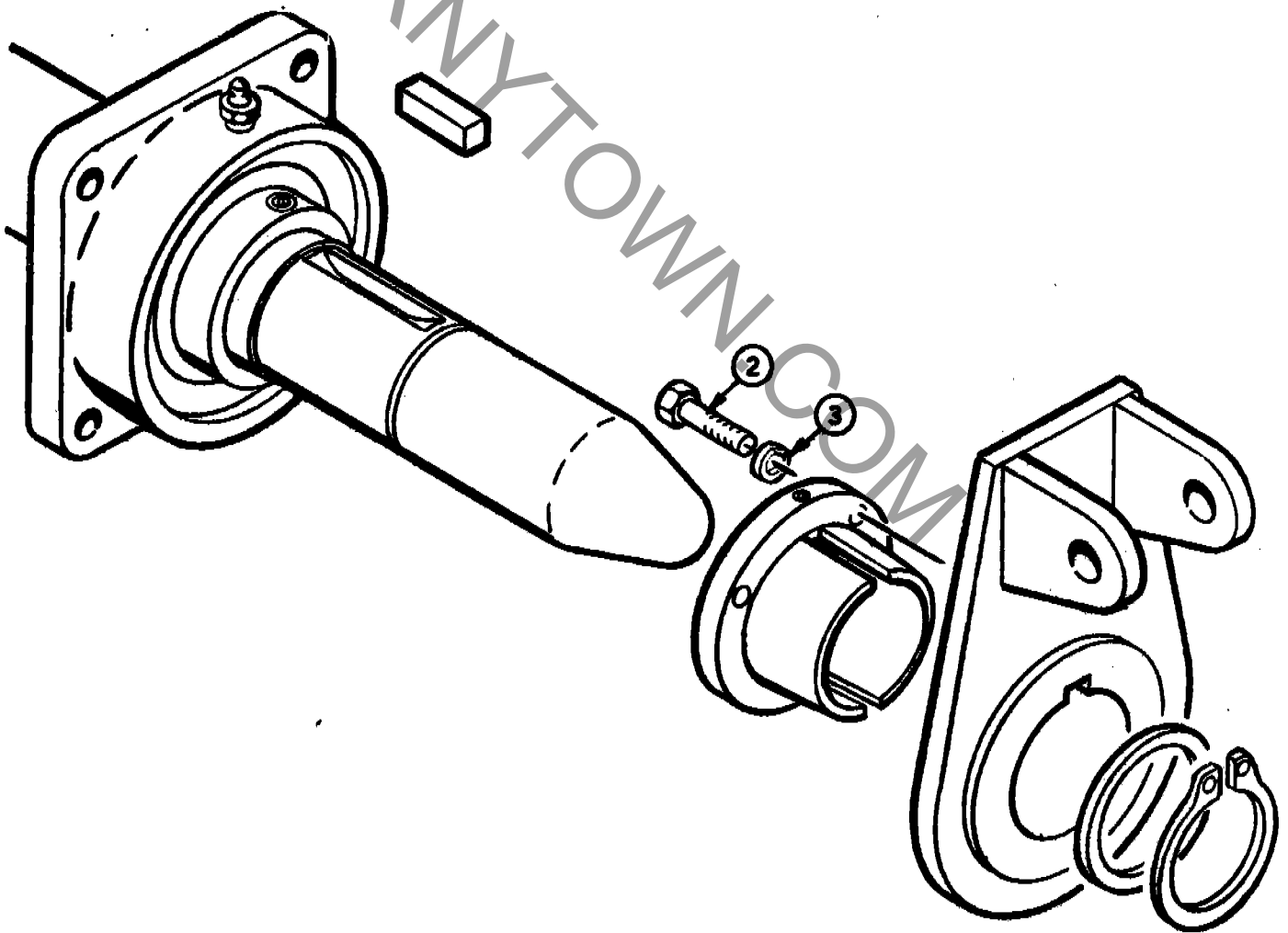
4. Subtract the measurement in Step 3 from the measurement in Step 2. If the difference exceeds 3/4", excessive wear is indicated.

5. Repeat Steps #2, #3 and #4 on all remaining seats. IF EXCESSIVE WEAR IS INDICATED ON ANY SEAT, ALL SEAT SPINDLES AND SEAT FRAMES MUST BE REPAIRED AS DESCRIBED IN THIS BULLETIN.

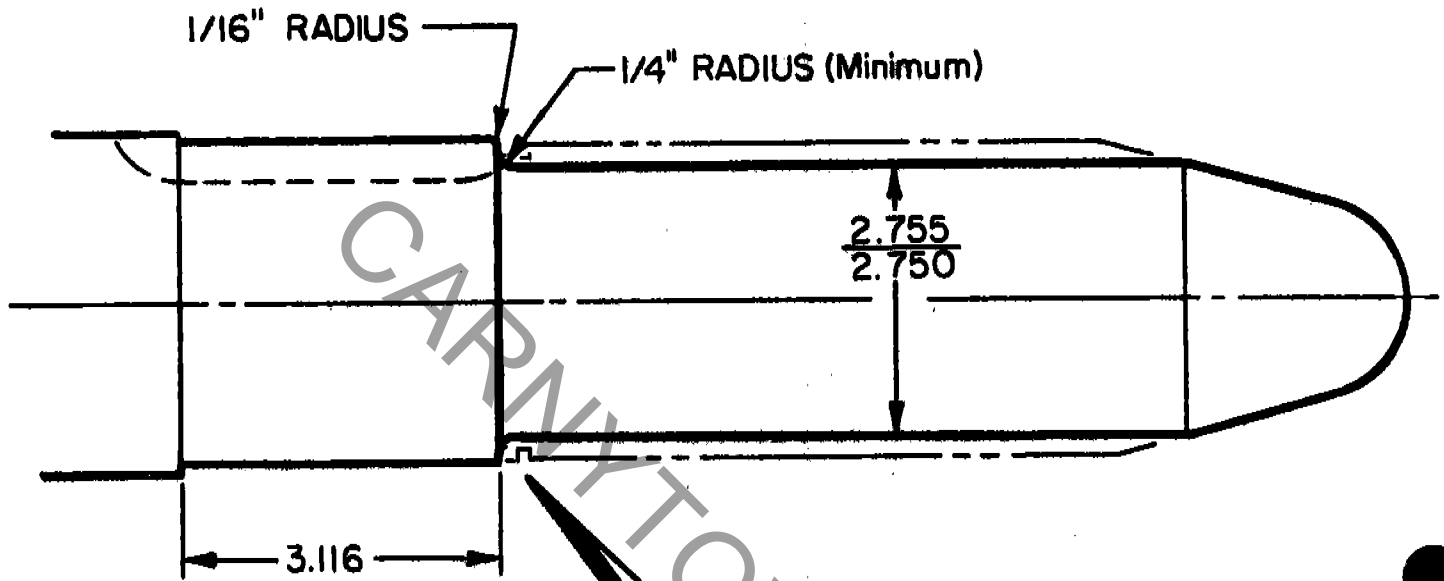
INSTALLATION INSTRUCTIONS

1. Remove the seats from the sweeps.
2. Remove the looping shaft from the sweep and disassemble it as shown below.

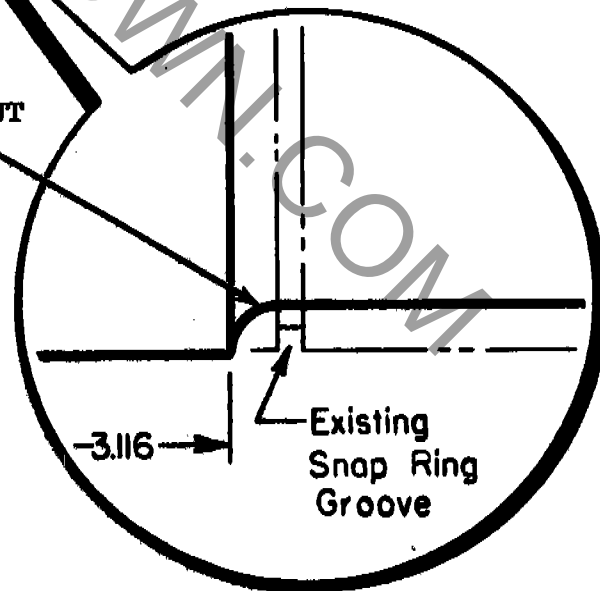
NOTE: Inspect the bearings, collars, keys, and all other looping shaft parts while it is disassembled. Replace all broken, worn or missing parts before assembling the looping shaft.



3. Turn the seat spindles to the dimensions shown in the following drawing. If seat spindle is worn beyond the dimensions shown, contact the CHANCE CUSTOMER SERVICE DEPARTMENT.

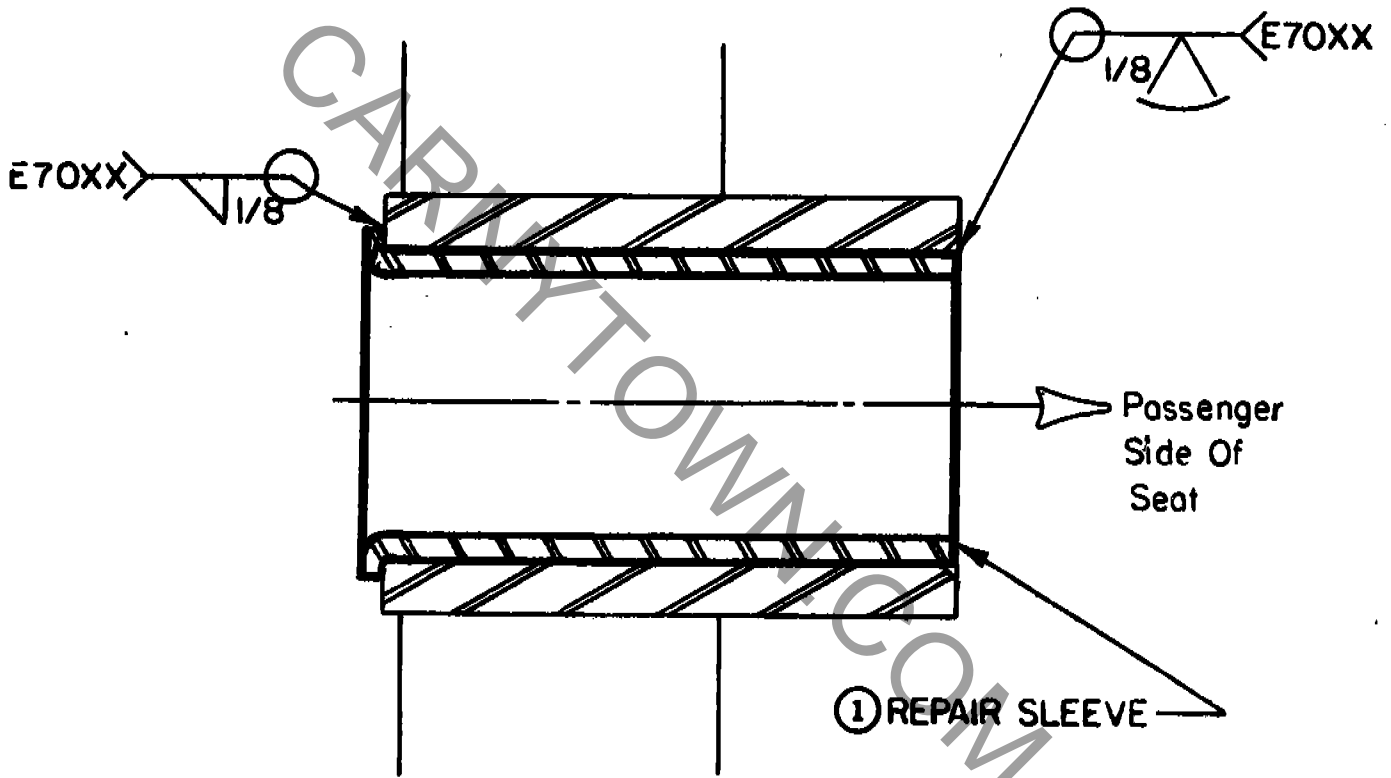


IMPORTANT: ABSOLUTELY NO UNDERCUT ALLOWED IN THIS AREA.



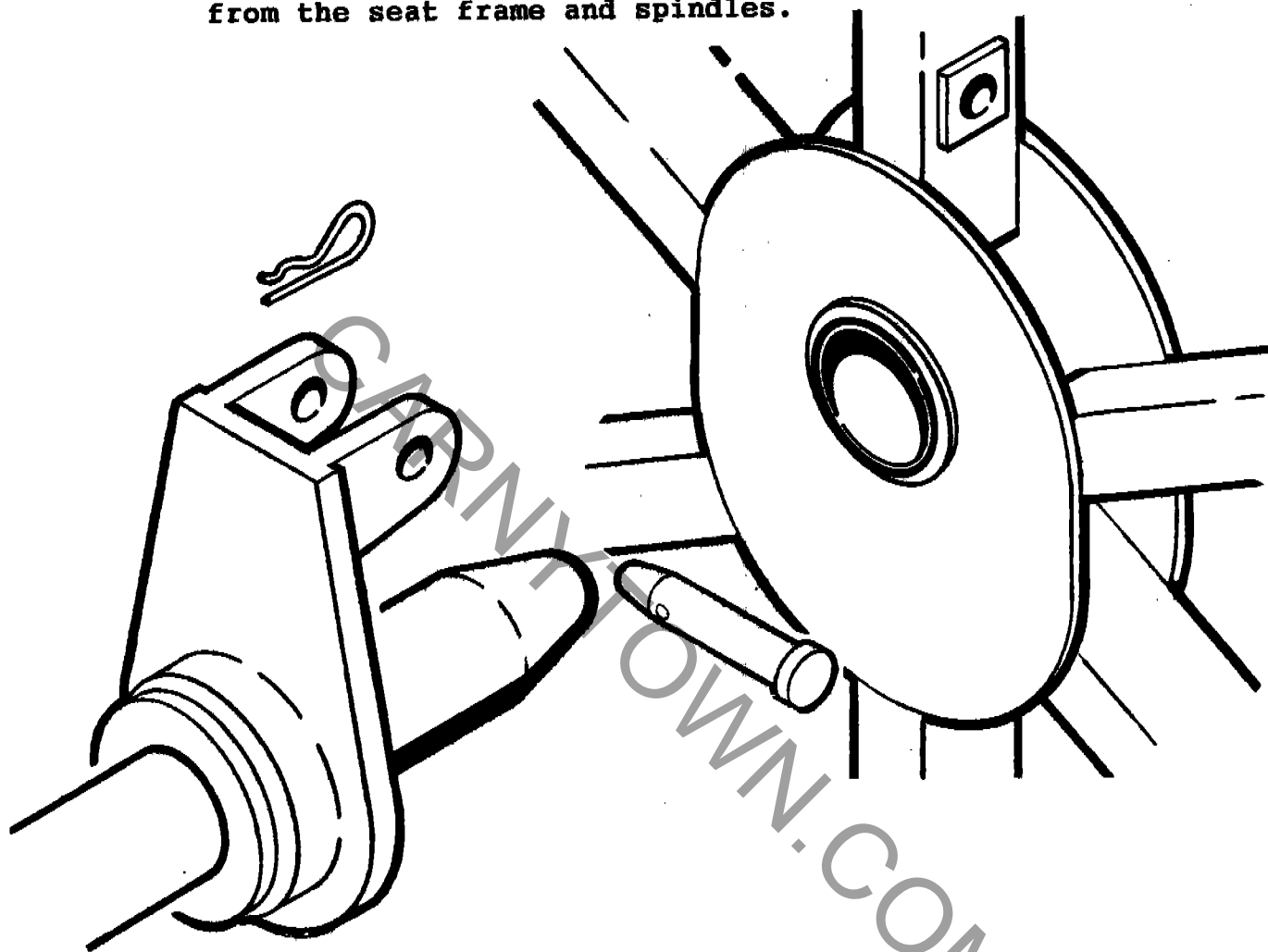
4. Reassemble the looping shafts, omitting the washers and snap rings (Refer to 373-150-001). Use the new grade 8 bolts and hardened washers (Items #2 and #3) provided in the kit. Tighten to 27 - 33 ft-lb.

5. Install and weld a repair sleeve into each car frame as shown in the following drawing.



6. Liberally apply No. 2 lithium base grease to the spindles. Reinstall all seats on spindles, using the pin and hairpin through the seat hub and sweep frame (Refer to Drawing No. 373-150-001).

NOTE: Apply grease at each set-up to obtain maximum service life from the seat frame and spindles.



NOTE: If the repair sleeve is too tight on the spindle, sand or hone the inside diameter of the repair sleeve. DO NOT MACHINE THE SHAFT FURTHER.



Number: A22-0290-0A

Date: May 30, 1987

Supersedes: B22-0290-00

America's Largest Manufacturer of Amusement Rides

SAFETY ALERT

Effective Serial Numbers: 72-3101 through 77-3134

Ride: ROK-N-ROL

Subject: Seat Belt System



WARNING: FAILURE TO COMPLY WITH THIS SAFETY ALERT BULLETIN CAN RESULT IN INJURY TO PASSENGERS.

Service Bulletin Number B22-0290-00 is superseded by this Safety Alert Bulletin. It is no longer in effect and should be destroyed.

Effective immediately, CHANCE MANUFACTURING COMPANY, INC. requires all owners of ROK-N-ROL amusement rides to stop operation of their rides until the modification described in this bulletin has been performed.

Perform the modification using the instructions on the following page of this bulletin. Return the attached Certification Of Compliance within seven (7) 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 modification, contact the CHANCE CUSTOMER SERVICE DEPARTMENT immediately.

Order seat belts, part number 322-05435, to perform the modification.

INSTALLATION INSTRUCTIONS

5/16-18 CAPSCREWS
(11-13 lb-ft. torque)

ORIGINAL EQUIPMENT
SEAT BELT
(NYLON WEBBING)

1/4-20 CAPSCREWS
(7-8 lb-ft. torque)

EXISTING CLAMP
ASSEMBLY

REMOVE SEAT
BELT WITH
PUNCHED HOLES

REMOVE
PIN PLATES
AND HAIRPINS

ORIGINAL EQUIPMENT

NEW STYLE

1. Remove the new style pin plates, hairpins and seat belts from all the seats. These seat belts have punched holes for positive locking over the pin plate, in addition to the clamp assembly.

2. Install the original equipment seat belts (part number 322-05435). These seat belts are made of nylon webbing without holes and retained by the clamp assembly.

NOTE: The same clamp assembly and attaching hardware are used for both the new style and original equipment seat belt system.



Number: 55

Date: 6-6-73

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers:

Ride: ROK-N-ROL
CHANCE BUILT

Subject: FLOOR LIFT HYDRAULIC CYLINDER
CLEVIS END

Due to several reports of failures of the floor lift hydraulic cylinder clevises, we checked with the cylinder manufacturer for an explanation. They informed us that one group of clevises, from their supplier, had an extremely high silicon content and for that reason, were not of sufficient strength. This group of castings, along with several other groups, were all used in the same time period that we purchased our hydraulic cylinders for the ROK-N-ROLS. Due to the fact that the cylinders you have on your ride may or may not have faulty clevises, we are sending all ROK-N-ROL owners two new clevises to replace the clevises on their ride. We are requesting all owners to make this change as soon as possible and to destroy the old clevises, as they may be from the faulty group and should not be used as spares.

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Number: 21

Date: 8/28/72

Supersedes:

America's Largest Manufacturer of Amusement Rides

SERVICE BULLETIN

Effective Serial Numbers: 1 THROUGH 16

Ride: ROK-N-ROL

Subject: LEAKING MASTER CYLINDERS

ROK-N-ROL OWNERS

This kit is to correct the problem of leaking Master Cylinders. The Air Chambers are overstroking the cylinders, causing the cups inside of cylinders to be damaged. This allows brake fluid to leak by the cups and out the end of the cylinder. In addition, the leaking cylinders will only hold pressure for a short time, resulting in the loss of brakes.

All of the parts included in this kit should be installed immediately, regardless of whether or not all of the Master Cylinders are leaking.

The following items compose the complete kit, along with instructions for installation.

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>
10	FD-344	Primary Cup
10	FD-1311	Secondary Cup
10	373-165	Plunger

TOOLS REQUIRED:

Medium size standard screwdriver
11/16 Open end wrench
3/4 Open end wrench

Hacksaw
Tape measure
Plastic bucket

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MODIFYING AIR CHAMBER

1. Disconnect the air supply tube (A) from the Air Chamber, and remove the nuts that secure chamber to sweep.
2. Remove the Air Chamber and saw off the plunger or piston rod so that 3/16 inch protrudes above the face of the chamber or until piston rod is flush with the brass ring that secures the diaphragm. See Figure 3.

INSTALLING NEW CUPS IN MASTER CYLINDER

NOTE

It is not necessary to remove Master Cylinders from ride to install new cups.

3. Remove the Retaining Wire from back of cylinder by prying lightly under it with a screwdriver.

CAUTION

The Retaining Wire and Piston Stop Plate will pop out very suddenly. Use caution to avoid losing any parts.

4. Remove piston and Primary Cup from cylinder.
 - A. To remove Primary Cup, push against one side of it until it flips over; as it will then be easy to remove.

CAUTION

When removing primary cup, be careful not to scar the cylinder walls with the screwdriver.

5. Install new Primary Cup in cylinder.
6. Remove Secondary Cup from piston, by stretching it over the lip on the piston.
7. Install a new Secondary Cup on piston by lubricating it with brake fluid and stretching onto piston.
8. Position piston and stop plate in cylinder and secure with Retaining Wire.
9. Reinstall the Air Chamber, placing the new plunger rod over the end of the sawed-off piston rod on the Air Chamber.
10. Refill Master Cylinders with brake fluid.
11. Bleed brakes per instructions on page 21 of the "ROK-N-ROL" Operation Manual.

Figure 1. Assembled View of Brakes

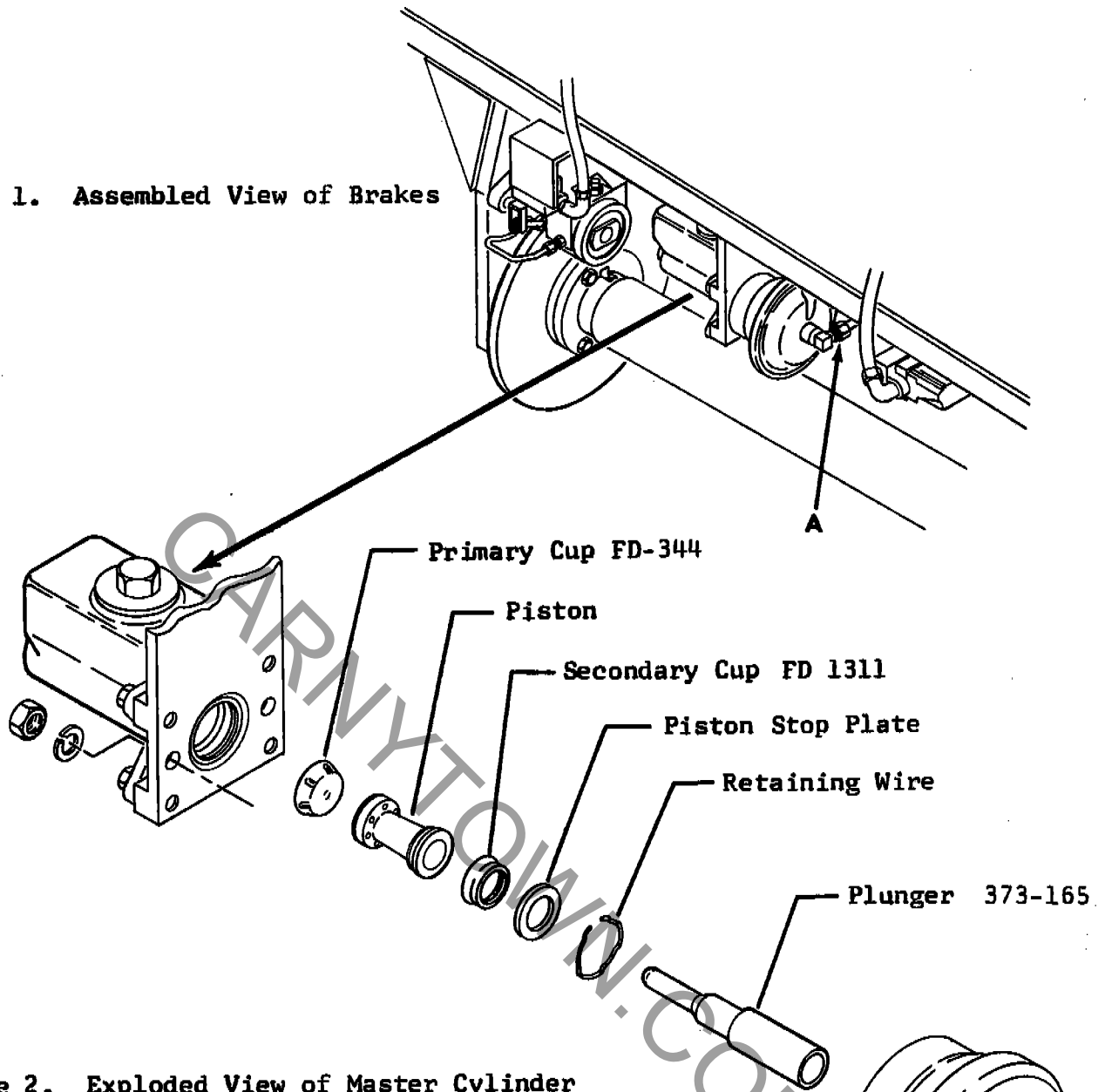


Figure 2. Exploded View of Master Cylinder

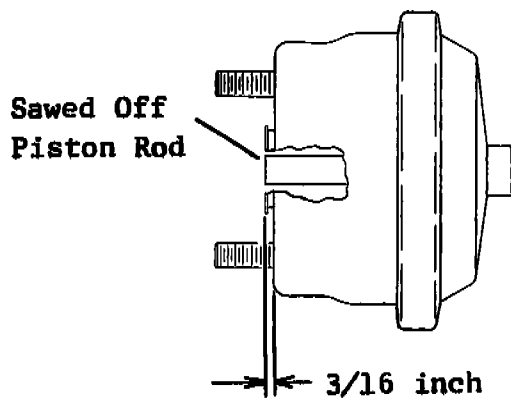


Figure 3. Air Chamber Modification

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