

Dartron

**Issuing Entity:**  
Dartron Industries, Inc

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**Bulletin # SR-5K-003**

**Release Date: January 27, 2004**

**Effective Date: January 27, 2004**

**Supersedes: N/A**

**Completion Date: Before Operating**

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## SAFETY BULLETIN

Ride Manufacturer: Dartron Industries, Inc.

Affected Production Dates: 08/98 – 08/99

Ride Name: Cliff Hanger

Affected Serial #'s: 806081-5K, 807121-5K, 810061-5K,  
810283-5K, 901011-5K, 902221-5K, 903021-5K,  
903272-5K, 905101-5K

**Abstract of Issue:** As a result of an incident involving a Cliff Hanger ride in Florida Dartron is now aware that after a combination of events the Car Hanger Stem to Arch Assembly joint could fail. For this reason Dartron is requiring that all Cliff Hanger rides have a back up device that will support the car and its passengers in the event of a separation of the Arch Assembly from the Stem. Tests conducted by Dartron demonstrate that the factory-installed Arch Assembly to Car joint back up cable will safely suspend the car and its passengers in the event of a failure of the Stem to Arch Assembly joint. To identify the joint see Page 2 of this Bulletin and for more information on the factory installed cable see Page 3 of this Bulletin.

The factory-installed cable is an approved back up device for the Stem to Arch Assembly joint. No action is required for Cliff Hanger rides with a factory-installed cable.

The Cliff Hanger rides listed above have a different back up device for the Arch Assembly to Car joint and do not have factory-installed cables. The above listed Cliff Hanger rides must install the back up device described in this Bulletin as a back up for the Arch Assembly to Stem joint.

**Reason for release:** To ensure that the Cliff Hanger rides not equipped with a factory approved cable retrofit the Dartron approved back up device described herein.

### **Action to be taken:**

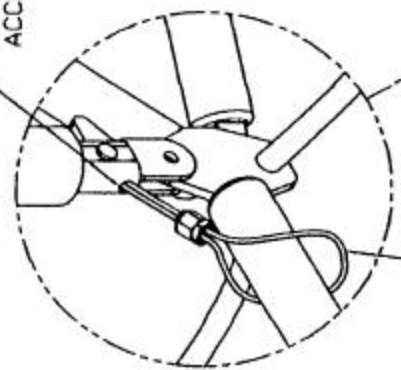
1. The retrofit back up device must be ordered from Dartron Industries.
2. The back up device consists of:
  - a) Arch Assembly to Stem strap.
  - b) Stem to Welded Pipe strap.
  - b) Cable that is inserted through the Arch Assembly and attached to the car. Cable does not enter the stem.
3. Install the Back Up device as shown on Page 2 of this Bulletin.

ITEM	QTY.	DESCRIPTION	LENGTH	UNIT	COMMENTS	USED
B063-RK-01	1	10 GA. SHEET X 2 1/2"	15 5/8"		FIBER	
B063-RK-02	1	10 GA. SHEET X 3"	8 7/8"		FIBER	
B063-RK-03	2	3/8 NC-16 GRADE 8 BOLTS				
B063-RK-04	4	3/8" STAINLESS STEEL FLATE WASHER				
B063-RK-05	2	3/8 NC-16 NUT				
B063-RK-06	2	3/16 STAINLESS STEEL AIRCRAFT CABLE				
B063-RK-07	2	3/16 VIBE ROPE CLAMP				
B063-RK-08						

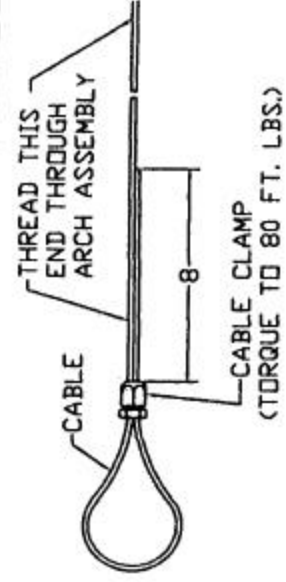
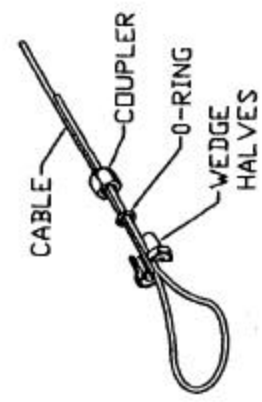
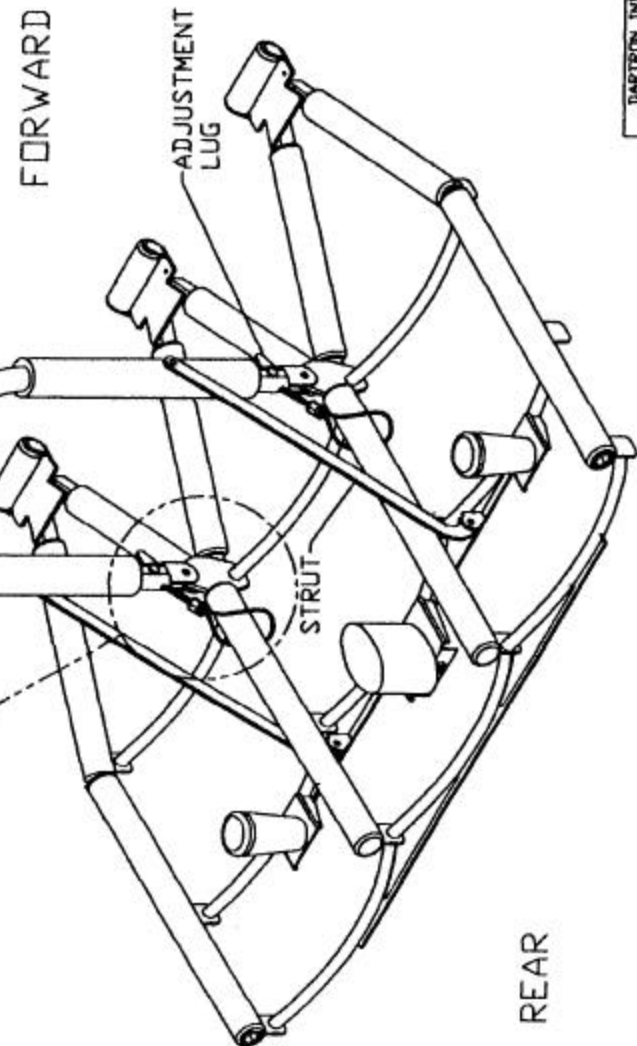
### INSTALLATION INSTRUCTIONS

1. SLIDE PART # 2 UP UNTIL IT TOUCHES THE ROUND TUBE.
2. LOCATE AND DRILL HOLES IN THE STEM. 13/32 DIA THRU.
3. INSTALL PARTS #1 THROUGH #5 AS SHOWN.
4. TIGHTEN NUTS #5 180 DEGREES PAST SNUG.
5. INSTALL THE CABLE THROUGH THE ARCHED TUBE AS SHOWN.
6. ESTABLISH THE FINAL LENGTH OF THE CABLE WITH THE ARCH LAID OVER FLAT. (CRACKED POSITION).

DRILL & DEBUR 1/2" HOLE FOR CABLE ACCESS.



SAFETY CABLE



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DARTRON IND., INC.		REVISIONS		DATE		BY	
NO. OF REV.	DATE	DESCRIPTION	BY	DATE	BY	DATE	BY
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# PASSENGER CARRIER INSPECTION GUIDE

- 1) INSPECT FASTENERS RETAINING MAIN HANGER BLOCK PIVOT PIN TO INSURE 1/2" BOLT JAM NUT, NYLOCK NUT & COTTER PIN IS INSTALLED.
- 2) SHOCK MOUNT BRK'TS ON SWEEPS #5 & #10 HAVE REMOVABLE PINS, EXAMINE TO SEE THAT PINS ARE SECURE & R KEYS ARE ALL INSTALLED IN BOTH SHOCK MOUNT BRK'T & LOWER HANGER BLOCK.
- 3) CHECK BOLTS & NYLOCK NUTS ON UPPER & LOWER SAFETY LOOP TO DETERMINE THAT FASTENERS ARE INTACT & SECURE.
- 4) CHECK LOWER HANGER BLOCK PIN FOR EXTERNAL RETAINING RING & ROLL PINS.
- 5) CHECK CAR STEM TO HANGER BLOCK PINS DAILY VERIFY THAT LYNCH PIN & R KEY ARE IN PLACE & PINS ARE SECURE.
- 6) CHECK MODIFIED BOLT IN CAR STEM & STEM TO CAR BOLT & NYLOCK NUT TO DETERMINE THEY ARE SAFE & NUTS HAVE NOT BACKED OFF.
- 7) CHECK CAR STRUT PINS ON CAR FRAME & R KEYS TO INSURE THEY ARE IN PLACE & SECURED.
- 8) EXAMINE PIVOT POINT ON RESTRAINT TO DETERMINE THAT ALL SHAFTS ARE EXTENDED & HINGES ARE LOCKED IN PLACE.
- 9) CHECK CAR HANDLE PIN TO INSURE R KEY IS SNAPPED IN PLACE.
- 10) SAFETY CABLE IS THREADED THROUGH BOTH SIDES OF CAR STEM & SECURED TO CAR FRAME

