

*Dartron*

**Issuing Entity:**  
**Dartron Industries, Inc**

**P. O. Box 13114**  
**Salem, Oregon 97309**  
**Phone: 503-362-2341**  
**Fax: 503-362-2536**

[www.dartronrides.com](http://www.dartronrides.com)

**Bulletin #** SR-5H-903

**Release Date:** March 26, 1999

**Effective Date:** March 26, 1999

**Supersedes:** N/A

**Completion Date:** June 30, 1999

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## SERVICE BULLETIN

Ride Manufacturer: Dartron Industries, Inc.

Affected Production Dates: 1973-1991

Ride Name: Hurricane

Affected Serial #'s 201061-5H, 108021-5H, 203011-5H,  
204021-5H, 502151-5H, 611222-5H, 604052-5H,  
611181-5H, 701291-5H, 702133-5H, 702282-5H,  
704016-5H, 711031-5H, 711101-5H, 712051-5H,  
712151-5H, 801192-5H

Model #

### **Abstract of Issue:**

**Reason for release:** Dartron has determined that the changes explained below are necessary for the assured safe operation of the Hurricane ride. These changes will be implemented on all new production and must be retrofitted on previously manufactured Hurricane rides by Dartron Industries, Inc.

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

**Inspection:** Before implementing changes explained below remove the cars from the sweeps. Find the grease zerk on the end of the sweep. Add lubrication to this zerk until the cavity is full. Inspect the bolt or roll pin shown as item 20 on Attachment I. Be sure the bolt is a grade 8. Inspect to be sure that it is not damaged and capable of maintaining the pin in its bore and prohibits the pin from rotating. Replace with a 3/8 NX x 4" grade 8 bolt and grade 8-nyloc nuts if any damage is found. Car bucket must also rotate freely in relation to the sweep, indicating that the bushings in the sweep end are not binding on the shaft. Keeper bolt orientation must also be as shown in Attachment I in order to clear the pin retainer.

**Pin Retainer:**

Attachment I show the pin retainers that must be bolted to both sides of the car buckets that are attached to the end of the sweeps on all Hurricanes. With the pin retainers in place the shaft will be retained in position in the sweep even without the proper functioning of the pin-locating bolt. Using an electric drill, drill 1 hole in both sides of the sweep bucket. The location of these holes is shown in Attachment I at 2 7/8". Bolt the pin retainers on with one bolt so that the tab of the retainer covers the end of the bucket pin. Now use the retainer as a jig to drill through for the lineup of the second 3/8 hole. Bolt the retainer in place using grade 8 bolts, grade 8 nyloc nuts and flat washers, as called out in the material list in Attachment I. Insert the bolt from the inside to the outside of the bucket. Place the nyloc nut on the outside face of the bucket so it can be easily inspected. Torque to 40 ft lbs. The flat washers are located under the bolt head and under the nyloc nut.

**Material Required:** Contact Steve Jones at Dartron who will supply 12 pin retainers at no cost. The Hurricane owners must supply the exact hardware shown on the material list found on Attachment I.

**Inspection Required:** Daily inspection of the buckets is required. The inspection must insure that (1) the sweep endpin is lubricated, (2) the pin-locating bolt is in place and functioning properly, (3) both pin retainers are securely bolted to the sides of the bucket.