

**Oklahoma Department of Labor  
Safety Standards Division**

**Air Inflatable Amusement Ride/Device Inspection Criteria**  
Revision 7

January 26, 2012

*The following criteria are provided to augment the minimum requirements of the manufacturer's guidelines for Inflatable type amusement devices. These criteria have been developed based on a review of manufacturer's requirements, and the ASTM F-24 (F 2374-06). Each owner, manager or operator who provides for public use and operation Inflatable Amusement Rides/ Devices, for the purpose of providing amusement, thrills or excitement shall abide by these criteria.*

**NOTE: ALL INFLATABLE AMUSEMENT RIDES/ DEVICES SHALL BE ERECTED AND OPERATED IN ACCORDANCE WITH THE MANUFACTURER'S GUIDELINES UNLESS IT IS DETERMINED BY THE COMMISSIONER OF LABOR THAT THE MANUFACTURER'S GUIDELINES DO NOT PROVIDE FOR THE ADEQUATE PROTECTION OF THE GENERAL PUBLIC.**

**NO INFLATABLE DEVICES SHALL BE OPENED TO THE PUBLIC BEFORE THE ANNUAL INSPECTION HAS BEEN PREFORMED FOR THE CALENDER YEAR, NO EXCEPTIONS.**

**Ride Design**

1. All Inflatable devices shall meet the requirements as outlined in ASTM- F24 (F 2374-06).
2. Toy grade Inflatable devices **SHALL NOT** be used for rental/commercial purposes, **NO EXCEPTIONS.**
3. All Inflatable devices purchased for rental/commercial purposes to be used in Oklahoma after January 1, 2007 shall meet the flame resistant requirements outlined in ASTM F 24 (F 2374-06) Standard Practice for Design, Manufacture, Operation and Maintenance of Inflatable Amusement Devices (5.5.1).

**Tie Downs**

1. All air supported devices shall be anchored per manufacturer's requirements. In some cases, the manufacturer's recommendations may be deemed inadequate. In those cases, the device shall be provided with suitable additional securing devices, determined by the ODOL inspector onsite.
2. All ground stakes/anchors shall be of sufficient diameter and length to prevent movement of the device at the maximum allowed operational wind speed. Different soil conditions may require different diameter and length stakes be available. "NOTE" 8 to 10 inch, 1/4 diameter stakes (commonly call tent stakes) provided by some manufactures are **NOT ALLOWED** for use in Oklahoma.
3. No more than two tie down ropes shall be attached to any one stake/anchor, **outdoors locations only.** "NOTE" this does not apply when anything other than ground stakes are utilized i.e.: sand

- bags, water barrels
4. On **outdoor** locations ALL tie downs shall be utilized, **No Exceptions**.
  5. In lieu of tie down stakes being used outdoors, each tie down shall be secured with minimum of 75 pounds weight, unless another weight is directed by the manufacturer, i.e. some rock walls etc. The weight shall be of sufficient amount to prevent movement of the device at the maximum allowed operational wind speed.
  6. On **indoor** locations the tie downs on all four corners, mid-point tie downs (when provided) and others as designated by the inspector shall be utilized, **No Exceptions**. Each tie downs shall be secured with a minimum of 75 pounds weight unless otherwise directed by the manufacturer, i.e. some slides, rock walls.
  7. On outdoor locations, **All** tie downs shall be utilized. **No Exceptions**.
  8. Sand bags, water barrels or metal weights may be utilized on tie downs **outdoors and indoors**, unless prohibited by the Inflatable devices manufacturer. *“NOTE” No concrete or cinder blocks will be allowed at any location.*
  9. Inflatable devices **shall not** be secured to any motor vehicle, **NO EXCEPTIONS**.
  10. Ropes, tethers and tie downs shall be sufficiently strong to prevent breakage. The minimum recommended size is ½ inch solid-braided polypropylene with a tensile strength of 3000 or 300 lb. test rated. **Knots in an tie down/strap are not permitted.**
  11. All tie down stakes, sand bags, water barrels metal weights, shall be placed or guarded as to prevent slips trips or falls.
  12. **Tie Down/straps at low points around the base.** Tie down/straps that are frayed/worn or torn shall be replaced. Tie down/straps frayed/worn or torn shall be replaced by the **manufacturer or a stitch machine** provided it is done properly. Repairs in the **center** of any strap are not permitted.
  13. **Tie Down/Straps at mid or high points.** Stitching is permitted to make a **loop at the end of the tie down/strap**, provided it is done properly with a stitch machine, using a box stitch pattern.
  14. **Seams.** Stitched seams shall be repaired provided proper material is used and sewn properly. **No glued patches** over any stitched seam are permitted.

### **Blowers**

1. Each Inflatable device shall be equipped with the proper number of blowers with the horsepower and rated air flow capacity as required by the manufacturer.
2. All such blowers shall be of the of the proper horsepower to properly maintain inflation of the Inflatable device. All blowers, extension cords and electrical boxes shall meet the requirements of the most current Code accepted Edition of the National Electrical Code.
3. All Inflatable device blowers operated in an outdoor location shall be connected to a GFI plug, *“NOTE”* if a GFI plug is not available, a GFI extension cord may be utilized, **NO EXCEPTIONS**.
4. Extension cords shall be rated for outdoor use and of sufficient gauge to support the equipment being utilized.
5. An extension cord or blower with the ground prong broken or removed shall be removed from service, **NO EXCEPTIONS**.
6. Blowers and inflation tubes shall be positioned so that they will not impede the ingress/egress of patrons.

### **Structure**

1. Inflatable devices shall not have any tears that would allow the structure to deflate.

2. Inflatable devices shall be free of any slip or trip hazards.
3. Duct tape shall not be allowed to make any major repair to Inflatable device
4. Inflatable devices shall be of a design that prevents the rapid deflation of the device in the event of a power failure or loss of air supply.
5. Inflatable devices which are designed and manufactured to be operated as totally enclosed structures without clear visibility of the surrounding exterior, shall provide exits that meet all local, state or federal requirements as applicable to Inflatable devices.
6. Seams that are torn must be re-sewn. Other holes may be patched with vinyl.

### **Operations**

1. The owner/operator shall **document in writing** that the Inflatable device has been inspected daily prior to being placed in operation. A written log shall be maintained indicating any repairs made.
2. The owner/operator shall provide a sufficient number of operators in accordance with the Mfg.'s recommendations. If there are no Mfg.'s recommendations the DOL policy will require a sufficient number of operator/attendants to insure safe operation.
3. The owner/operator shall have an emergency action plan in place to cover accidents/incidents, foul weather, guest illness. All operators shall be trained in this plan.
4. Inflatable devices shall not be operated when weather conditions make operations unsafe, i.e. high winds, thunder storms, etc. An Inflatable device shall not be operated in wind speeds above the manufacturer's stated guidelines.
5. All staff shall be identifiable by uniform or tag.
6. Rider Responsibility signage as required by the Oklahoma Amusement Ride Safety Law shall be posted at the entrance to all Inflatable devices, or provided to the operator in the rental packet.
7. Accidents and incidents resulting in injuries and/or fatalities shall be reported to the Department of Labor in strict compliance with the provisions of the Oklahoma Amusement Ride Safety Law.

***In addition to the above guidelines, all persons, firm, companies and corporations engaged in the rental of Inflatable devices shall maintain on file, and make available to the Commissioner of Labor's authorized representative upon request the following:***

1. A copy of all training that will be provided to the renter. Such training shall address, as a minimum, the proper operation of the device, set-up and safety precautions as specified by the equipment manufacturer and the Oklahoma Amusement Ride Safety Act.
2. A copy of the manufacturer's set up and operating manual.
3. A signed statement by each renter documenting he/she has received and understands all procedures for the safe operation of the ride.
4. The companies name shall be prominently displayed on each Inflatable device.
5. Proof of insurance as required by the Oklahoma Amusement Ride Safety Act.

**“NOTE” ALL INSPECTIONS AS REQUIRED BY THE OKLAHOMA AMUSEMENT RIDE SAFETY ACT, MUST BE REQUESTED 72 HOURS (3 WORKING DAYS) IN ADVANCE OF THE REQUESTED INSPECTION DATE (380:55-9-1 (c)). IN THE EVENT AN INSPECTION IS CANCELED BY AN OWNER/OPERATOR 24 HOURS NOTICE IS REQUIRED OR A FEE MAY BE CHARGED FOR THE SCHEDULED INSPECTION, 380.55.5-1 (b).**