Customer Service Bulletin
Commercial Business Group

Groundsmaster® 455-D

Model/Serial Range:	Model Number:	Serial Numbers:
	30401	20001-49999

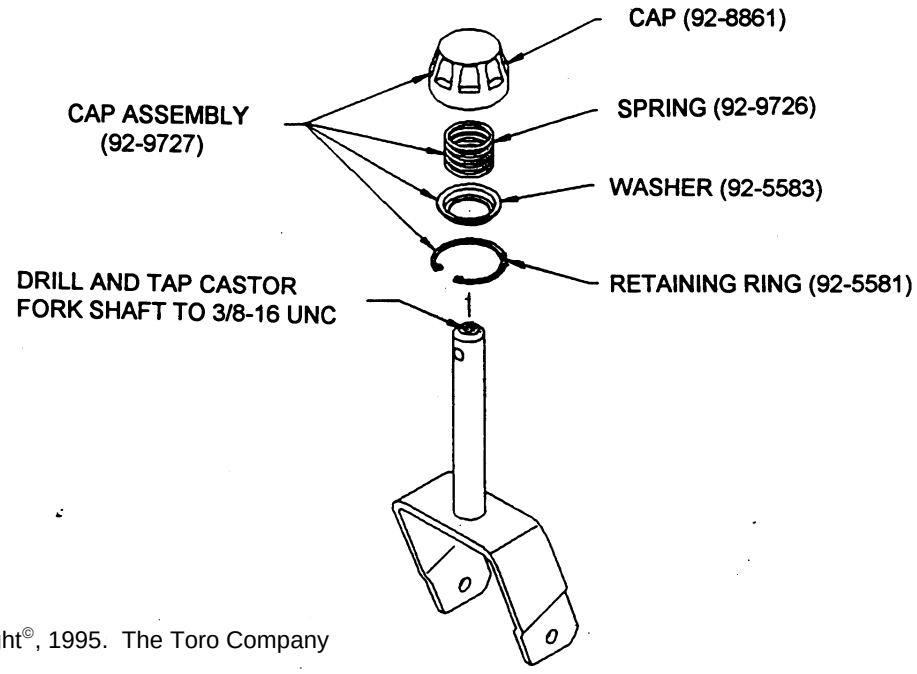
Subject: Prevention of spinning Castor Forks.

Cap Assembly (92-9727) is available through your local Toro distributor and can be installed onto the Castor Fork. When the Cap is tightened in place, it compresses the spacers to resist the spinning action of the Castor Fork. Installation instructions are located below.

NOTE: When changing height-of-cut, ensure that all spacer washers and Height-of-Cut Spacers are installed on the Castor Forks Operating without a complete set of spacers/washers will prevent the Cap Assembly from controlling the Castor Fork.

NOTE: The exterior of the Castor Fork Shaft is case hardened to a depth of .02 - .03 inch. Since the inside surface of the cross hole is also case hardened, it will resist drilling and threading. Use a sharp drill/tap, gentle pressure, cutting oil, and back the tap out often when penetrating the cross hole. Castor Fork (92-7750) and (92-7752) have pre-drilled shafts which may be preferred to drilling and threading.

1. Grind off enough material from the top of the shaft to expose the soft metal and allow the shaft to be drilled.
2. Locate the center of the shaft and mark the spot with a center punch.
3. Drill a 5/16 inch hole down and through the cross hole.
4. Thread the hole using a 3/8-16NC tap.
5. Install all spacers and washers. Firmly hand tighten the Spring Caps. If desired, a few drops of medium strength blue Loctite® 242 may be added to the threads to prevent loosening.



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