



# Gearbox Replacement Kit

1989 and After Mowers for Groundsmaster® 200/300 Series

Model No. 108-1370

## Installation Instructions

### ⚠ WARNING

#### CALIFORNIA Proposition 65 Warning

This product contains a chemical or chemicals known to the State of California to cause cancer, birth defects, or reproductive harm.

## Loose Parts

Use the chart below to verify that all parts have been shipped.

Procedure	Description	Qty.	Use
<b>1</b>	No parts required	–	Prepare the machine.
<b>2</b>	No parts required	–	Install the gearbox.
<b>3</b>	No parts required	–	Fill the gearbox with lubricant.
<b>4</b>	Breather	1	Install the breather (Groundsmaster® 3280 machine only).



# 1

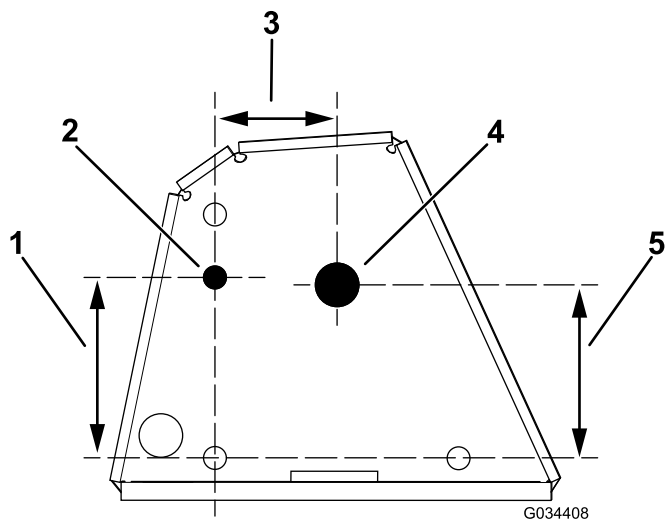
## Preparing the Machine

### No Parts Required

### Procedure

1. Park the machine on a level surface, lower the cutting unit, shut off the engine, engage the parking brake, and remove the key from the ignition switch.
2. Drill 2 holes in the gearbox-mounting bracket.

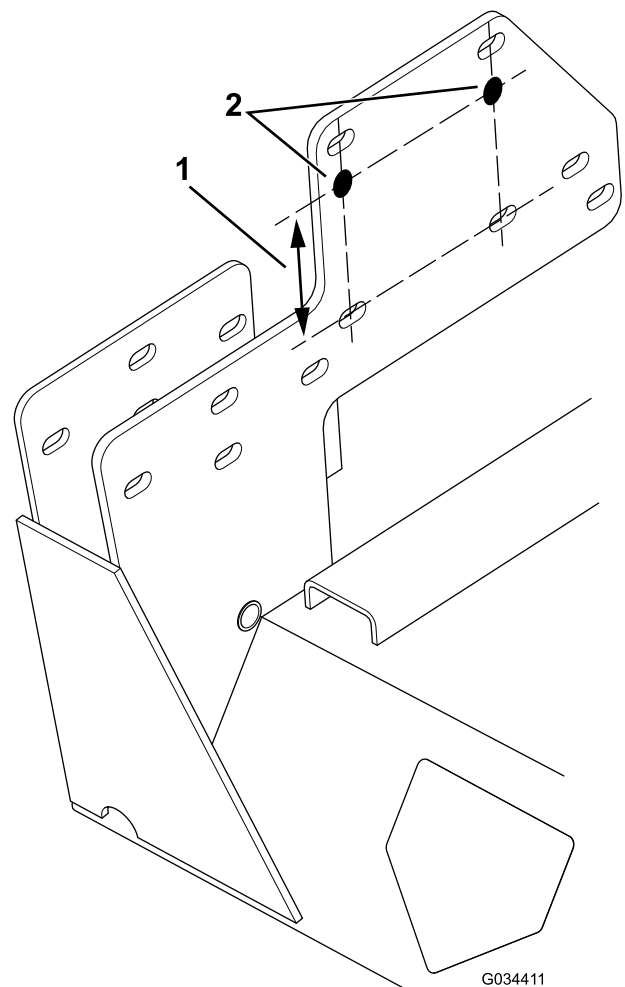
**Note:** Refer to [Figure 1](#) for the appropriate dimensions and location.



**Figure 1**

### Groundsmaster® 300 Series 72 inch Recycler

- |                                  |                                 |
|----------------------------------|---------------------------------|
| 1. 8.00 cm (3.15 inches)         | 4. 1.91 cm (0.75 inch) diameter |
| 2. 1.03 cm (0.406 inch) diameter | 5. 7.70 cm (3.03 inches)        |
| 3. 5.41 cm (2.13 inches)         |                                 |



**Figure 2**

### Groundsmaster® 300 Series 72 inch Flex Deck

- |                          |                                  |
|--------------------------|----------------------------------|
| 1. 8.00 cm (3.15 inches) | 2. 1.03 cm (0.406 inch) diameter |
|--------------------------|----------------------------------|

# 2

## Installing the Gearbox

### No Parts Required

### Procedure

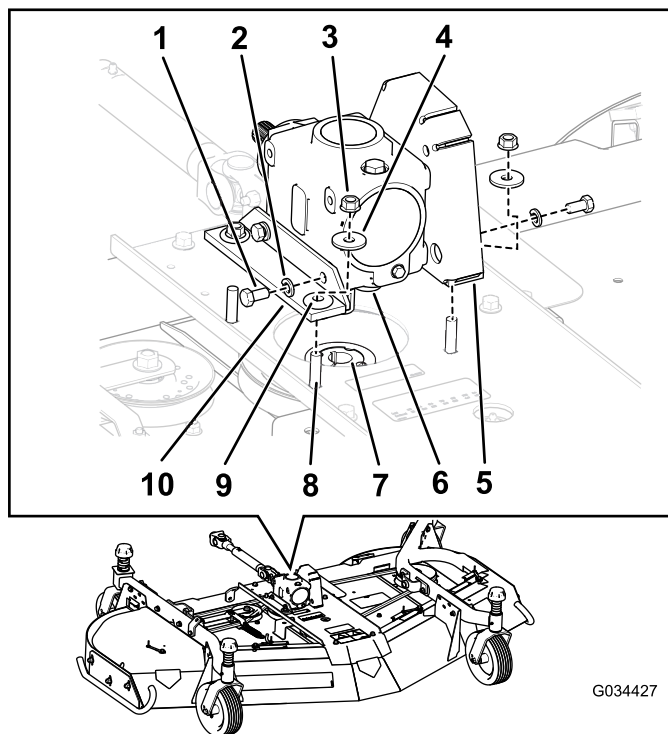
1. Relieve the tension of the belt from the gearbox pulley.
2. Remove the old gearbox including the 2 mounting brackets (Figure 3).
3. If present, inspect the rubber isolators inserted into the mounting brackets (Figure 3).

**Note:** Replace the isolators if they are worn.

4. Transfer the mounting brackets from the old gearbox to the new gearbox using the existing fasteners.
5. Transfer the drive pulley to the new gearbox using the existing taper-lock bushing and key (Figure 3).

**Note:** Be sure to set the pulley hub so that it is flush with the bottom of the gearbox shaft.

6. Install the new assembly onto the deck.
7. Install the belt.



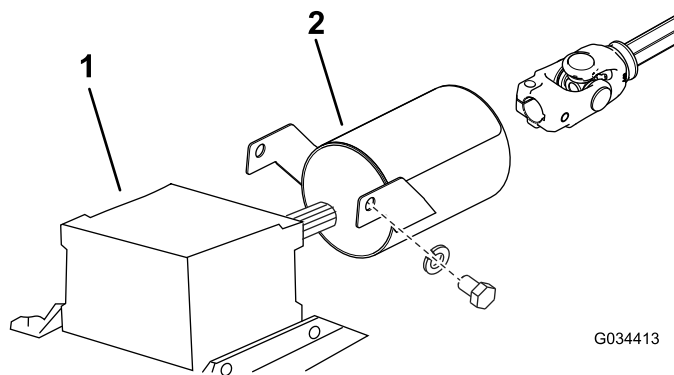
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**Figure 3**

Groundsmaster® 300 Series 72 inch Recycler Shown  
(mounting brackets vary)

- |                          |                            |
|--------------------------|----------------------------|
| 1. Short bolt (4)        | 6. Gearbox shaft           |
| 2. Split washer (4)      | 7. Taper-lock bushing      |
| 3. Flange nut (4)        | 8. Long bolt (4)           |
| 4. Washer (4)            | 9. Isolator (4)            |
| 5. Left mounting bracket | 10. Right mounting bracket |

**Note:** On some Groundsmaster® 200 Series cutting decks, the PTO guard may be mounted directly to the taller gearbox. If so, the PTO guard will not fit on the new shorter gearbox. Install a new PTO guard (Toro Part No. 107-2904) on the cutting unit (Figure 4).



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**Figure 4**

- |            |              |
|------------|--------------|
| 1. Gearbox | 2. PTO guard |
|------------|--------------|

# 3

## Filling the Gearbox with Lubricant

No Parts Required

### Procedure

1. Remove the dipstick from the top of the gearbox (Figure 5).

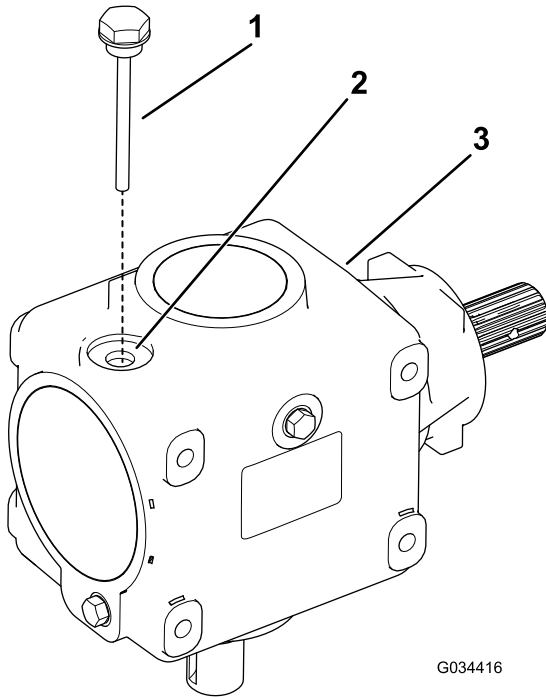


Figure 5

- |             |            |
|-------------|------------|
| 1. Dipstick | 3. Gearbox |
| 2. Port     |            |

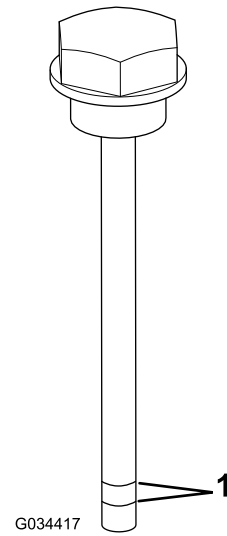


Figure 6

1. Fill lines
- 
3. Install the dipstick into the port (Figure 5) and tighten it.

2. Add 80W-90 gear oil into the port until the oil level is between the fill lines on the breather (Figure 6), with the dipstick threaded all the way into the port.

**Note:** The oil capacity is 0.41 L (14 fl oz). Always ensure that the oil level is between the fill lines **when the machine is level**.

# 4

## Installing the Breather

### Groundsmaster® 3280 Machine Only

#### Parts needed for this procedure:

1	Breather
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#### Procedure

1. Remove the solid plug installed in the gearbox, as shown in [Figure 7](#), and discard the plug.
2. Install the breather; refer to [Figure 7](#) for the appropriate orientation.

**Note:** Make sure that the top of the breather is not higher than the top of the gearbox.

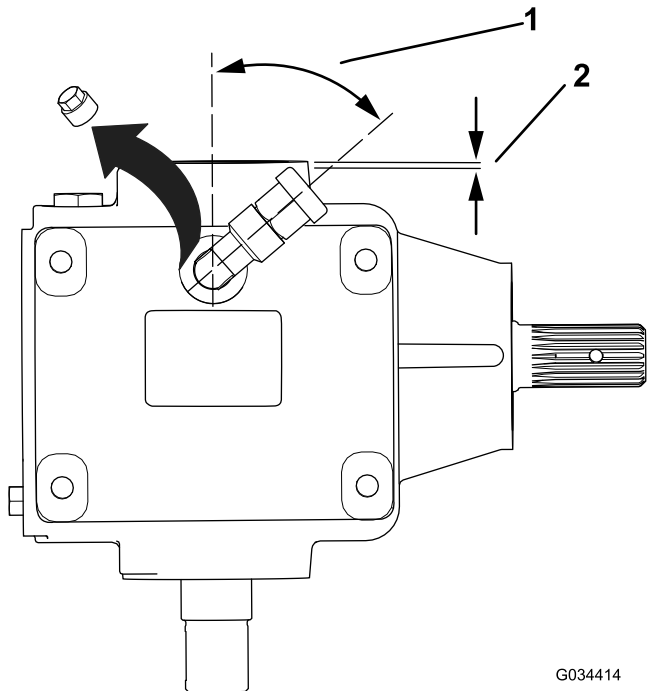


Figure 7

1. 50°
2. No more than 1.78 mm (0.07 inch)

**Notes:**

**Notes:**



**Count on it.**