



Customer Service Bulletin Commercial Business Group

Reelmaster® 223-D and 5100-D

Model/Serial Range: Model Number: **Serial Numbers:**

03500/03501	00000-99999
03502/03504	20001-39999

Subject: **Cutting Unit Stop Pin (roll pin) shears or falls out.**

The roll pin is a protection device designed to shear if the Cutting Unit strikes an object. If the roll pin fails, it may be performing as designed. However, there are other factors that may contribute to a failure of the roll pin. Listed below are some potential causes.

- A. The punched slot in the lift arm may have a sharp edge on the bottom surface. A sharp edge can cause the pin to shear when it suddenly bottoms out.
- B. Lowering the Cutting Units to the ground while turning can exert enough force to damage or deflect the roll pin.
- C. Driving of the machine at transport speeds over rough terrain without the cutting units fully raised (switch in "Enable"), may cause damage to the roll pin.

If you experience roll pin failures, the following suggestions may extend roll pin life. Parts mentioned are available through your local Toro distributor.

1. Always install a roll pin with the split seam facing the end of the slot. Install Cable Tie (3290-378) through the center of the roll pin.
2. Remove any sharp edges from the bottom of the slot (file or grind).
3. Train operators to reduce speed in rough terrain and avoid lowering the cutting units while in the process of turning. Drop cutting units only while moving straight ahead.
4. Train the operator to transport in the "Enable" mode between cutting areas so the cutting units are in a fully raised position.
5. Drill a 13/64" (5.1mm) hole in the side of the Arm Joint as noted in the diagram. Thread the hole with a 1/4-20 UNC Tap. Install Set Screw (92-9097) into the threaded hole so that it contacts the split seam of the roll pin.

NOTE: Arm Joint (75-3010) used on current products include this modification.

