



Gusset Kit

For Z593 Series Z Master Mowers

Model No. 110-3946

Installation Instructions

Note: Determine the left and right sides of the machine from the normal operating position.

Loose Parts

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

Step	Description	Qty.	Use
1	Gussets	2	Use the gussets as a template to drill the new holes.
	Bolt (3/8 x 1 inch)	1	
	Bolt (3/8 x 7/8 inch)	1	
	Flange nut (3/8 inch)	2	
2	Gussets	2	Install the new mounting plate.
	Bolt (3/8 x 1 inch)	1	
	Bolt (3/8 x 7/8 inch)	7	
	Flange nut (3/8 inch)	8	

Step

1

Drilling the Holes for the Gussets

Parts needed for this step:

2	Gussets
1	Bolt (3/8 x 1 inch)
1	Bolt (3/8 x 7/8 inch)
2	Flange nut (3/8 inch)

Procedure

- Clean any debris from the rear frame of the machine.
- To mark the holes for the left gusset, remove the bolt holding the fixed idler pulley bracket as shown in Figure 1.

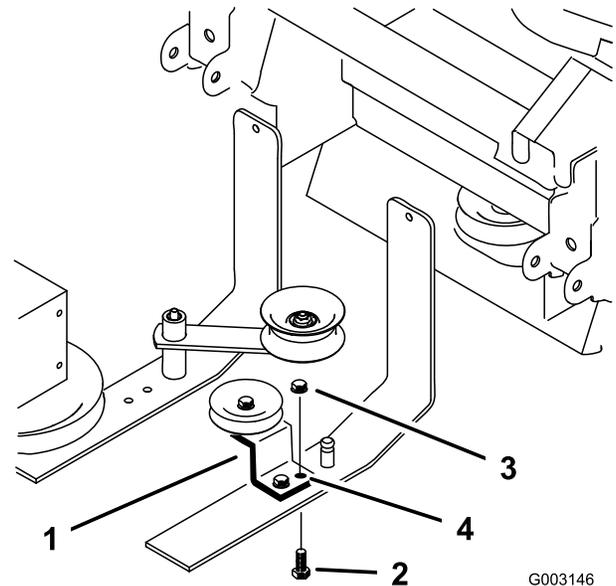


Figure 1

- Install the left gusset with a bolt (3/8 x 1 inch) and a flange nut (3/8 inch) through the existing hole in the fixed idler bracket and frame (Figure 2.) Do not over tighten the bolt and make sure the gusset is against the rear frame.
- To mark the holes for the right gusset, use the existing hole in the frame as shown in (Figure 2.).

5. Install the right gusset with a bolt (3/8 x 7/8 inch) and a flange nut (3/8 inch) through the existing hole in the frame. Do not over tighten the bolt and make sure the gusset is against the rear frame.

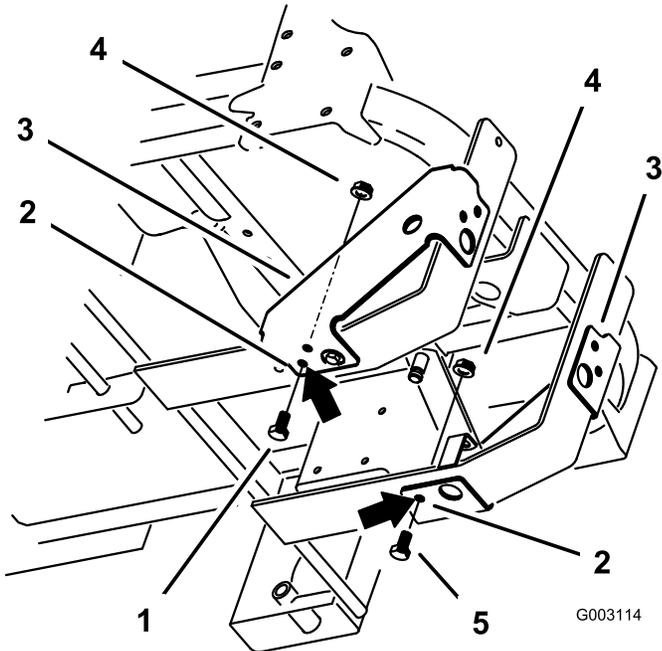


Figure 2

- | | |
|-------------------------|--------------------------|
| 1. Bolt, (3/8 x 1 inch) | 4. Flange nut (3/8 inch) |
| 2. Existing hole | 5. Bolt,(3/8 x 7/8 inch) |
| 3. Gusset | |

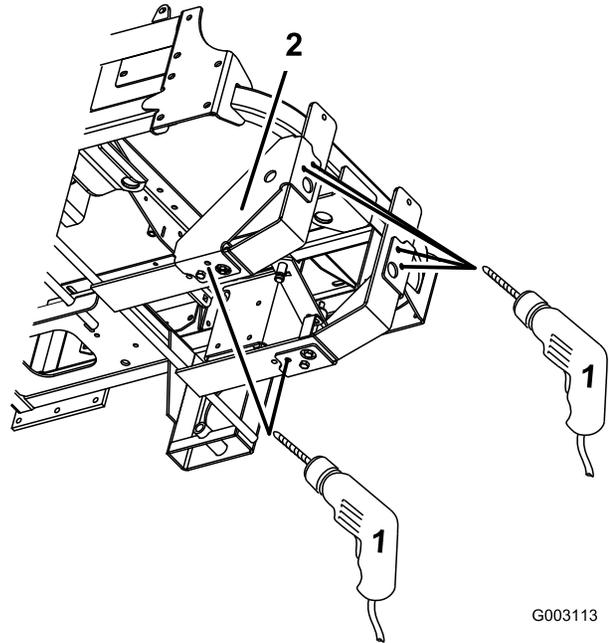


Figure 3

1. Drill 13/32 inch diameter
2. Gusset holes here

Step **2**

Installing the Gussets

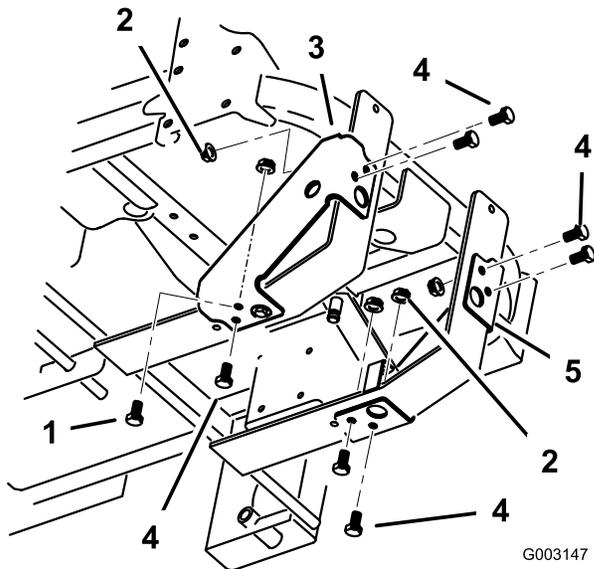
Parts needed for this step:

2	Gussets
1	Bolt (3/8 x 1 inch)
7	Bolt (3/8 x 7/8 inch)
8	Flange nut (3/8 inch)

Procedure

6. Mark and center punch the locations for the holes in the gussets (Figure 3).
7. Remove the gussets and drill 13/32 inch diameter holes at the marked locations (Figure 3).

1. Install the left gusset with a bolt (3/8 x 1 inch) and a flange nut (3/8 inch) through the existing hole in the fixed idler bracket and frame (Figure 2). Install 3 bolts (3/8 x 7/8 inch) and 3 flange nuts (3/8 inch) in the holes drilled for the left gusset.
2. Install the right gusset with a 4 bolts (3/8 x 7/8 inch) and 4 flange nuts (3/8 inch) through the existing hole in the frame.



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Figure 4

- | | |
|--------------------------|--------------------------|
| 1. Bolt, (3/8 x 1 inch) | 4. Bolt,(3/8 x 7/8 inch) |
| 2. Flange nut (3/8 inch) | 5. Right gusset |
| 3. Left gusset | |



Count on it.