



Castor Arms Wear at Pivot

Product: Groundsmaster 3280D/3320 Mower Decks

Feb. 18, 2010

Affected Units:	Models:	Serial Numbers:
60" Side Discharge Deck	30366	250000101-270099999
62" Rear Discharge Deck	30367	250000101-270099999
72" Side Discharge Deck	30368	250000101-270099999
72" Rear Discharge Deck	30369	250000101-270099999
62" Guardian Recycler Deck	30376	250000101-270099999
72" Guardian Recycler Deck	30379	250000101-270099999

In some conditions, the deck pivot point of the castor arms can wear as shown below. The [Pin-Clevis \(107-7904\)](#) can cut into the castor arm side wall, deforming the hole. The issue is typically a noisy or rattling deck during moving.

[Castor Arm Tube Kit \(115-0648\)](#) has been developed to address the complaint and avoid the expense of replacing the castor arms. This kit contains the parts required to repair 2 castor arms. See the attached installation instructions.

Contact your local Toro Commercial Products Distributor for more information on this issue and for assistance in ordering and installing this repair kit. Please reference Service Bulletin Rotaries 14-38 when making your inquiry.





Castor Arm Tube Kit

for 60, 62 and 72 inch Mowers for Groundsmaster 3320/3280-D
Traction Unit

Model No. 115-0648

Installation Instructions

This kit reworks the castor arms to increase the durability of the tube arms at the attachment points by adding a steel spacer.

Loose Parts

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

Procedure	Description	Qty.	Use
1	No parts required	—	Removing the castor arms.
2	Spacer Bolt (3/8 x 1 inch) Lock nut (3/8 inch)	2 1 1	Reworking the castor arm.
3	No parts required	—	Installing the castor arm.

1

Remove the Castor Arms

No Parts Required

Procedure

Remove castor arms from the deck. Refer to your *Service Manual* for instructions.

2

Rework the Castor Arm

Parts needed for this procedure:

2	Spacer
1	Bolt (3/8 x 1 inch)
1	Lock nut (3/8 inch)

Procedure

1. Locate the holes on the castor arm shown in Figure 1.

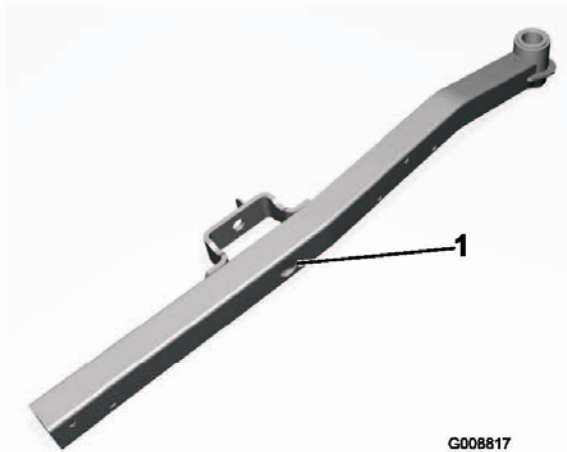


Figure 1

1. Holes to be drilled.

2. Drill out the holes in the tube to 0.948-0.958 inch diameter to accommodate the spacer seat.

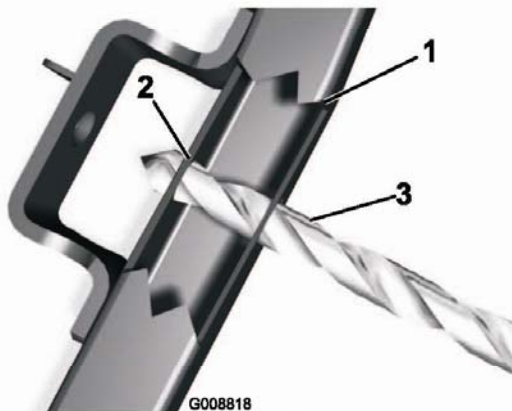


Figure 2

1. Cutaway, shown for clarity
2. Far side hole
3. Drill, 61/64 (24 mm)

3. Drill out the hole on the near side of the tube to 1.214-1.224 inch diameter to accommodate spacer's outside diameter.

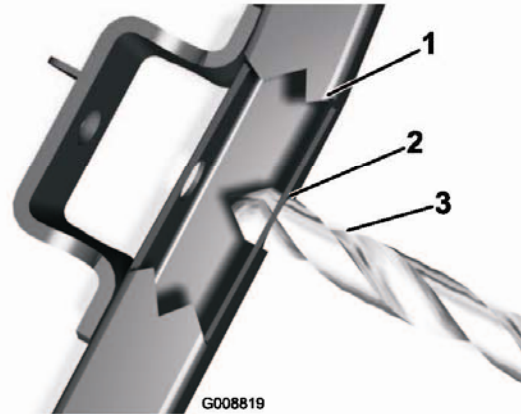


Figure 3

1. Cutaway, shown for clarity
2. Near side hole
3. Drill, 1-7/32 (31 mm)

4. Clean the holes and castor arm tube of any debris or burrs left by the drilling process.
5. Install the spacer into the hole so that the shoulder side of the spacer seats on the smaller, far side hole of the tube. Secure the spacer in place with the bolt and nut.

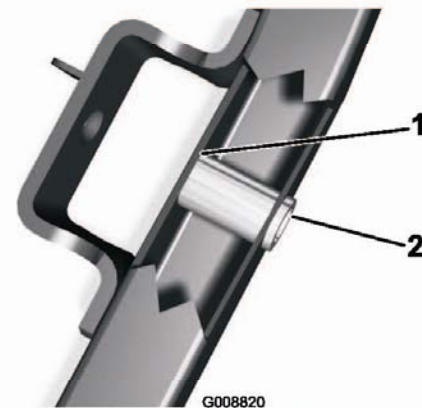


Figure 4

1. Far side hole, spacer seated
2. Spacer

6. Weld a fillet around the extended portion of spacer on the near side of the tube.



Figure 5

1. Weld fillet

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7. Once cooled, remove the bolt and nut and paint the affected surfaces to protect the arm from the elements

Note: Cover the spacer hole when painting.

8. Repeat this procedure for the other castor arm.

3

Install the Castor Arm

No Parts Required

Procedure

Install the castor arms to the deck. The pins removed previously should be installed through the spacer in the castor arms.