



Lift Pivot Support Fracture

Product: RM 5010 series

April 20, 2010

Affected Units:

Reelmaster 5010 Series

Models:

03660

03670

03680

03690

03691

Serial Numbers:

260000101 – 290999999

260000101 – 290999999

260000101 – 290999999

260000101 – 290999999

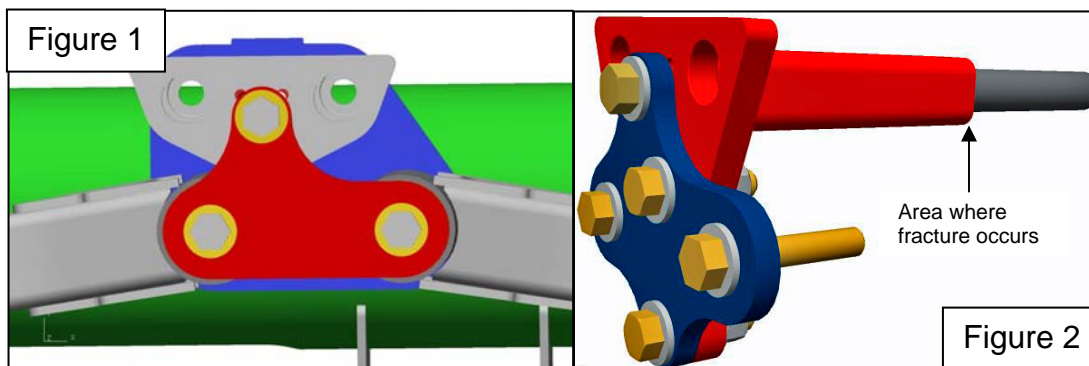
290000101 – 290999999

Situation:

The pivot area for the #4 and #5 lift arms can fracture when the hardware is allowed to remain loose for an extended time. Ensuring the hardware remains tight has been the subject of previous service bulletins. In rare instances where the hardware is allowed to run loose, a twisting force is applied to the support area and can lead to fractures of the pivot support area. (Figure 1)

Instructions:

Should a fracture occur in the pivot support area, use Lift Support Frame Repair Kit (119-6950) to repair the area. Figure 2 is a representation of the kit contents. Inspect the two Lift Arm Pivot Shafts (95-8531) for wear and replace as necessary. Pivot shafts must be ordered separately.





Lift Support Frame Repair Kit

Reelmaster® 5010 Series Traction Unit

Model No. 119-6950

Form No. 3364-587 Rev A

Installation Instructions

Installation

1. Position the traction unit on a level surface, lower the lift arms/cutting units and stop the machine. Remove the key from the ignition switch to prevent accidental starting.
2. Remove the #1 and #4 cutting units, lift cylinders and lift arms from the machine. Refer to the Toro Service Manual for the removal instructions.
3. Remove the (2) bolts and washers securing the lift cylinder pivot shafts to the lift plate (Figure 1). Remove the lift cylinder pivot shafts and the frame tube, if loose.

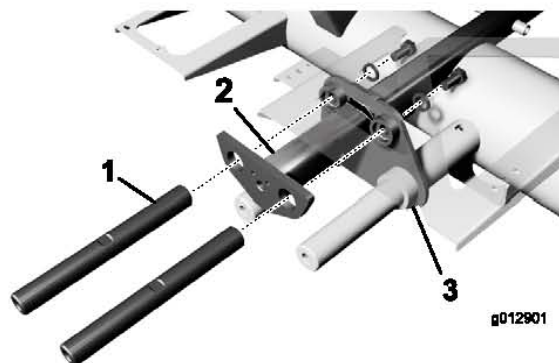


Figure 1

1. Lift cylinder pivot shaft (2)
2. Frame tube
3. Lift plate

4. Cut off any remaining tube protruding from the lift plate (Figure 2). Also, grind the tube flush to the lift plate.

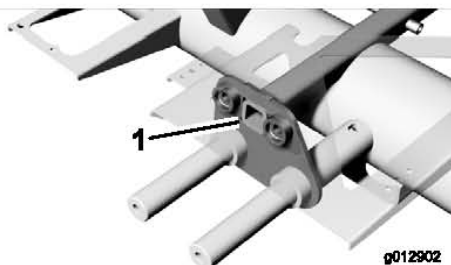


Figure 2

1. Grind frame tube flush

5. Using the dimension shown in Figure 3, locate, mark and drill a 5/8 inch diameter hole through the top and bottom walls of the frame tube. Center the holes on the tube.

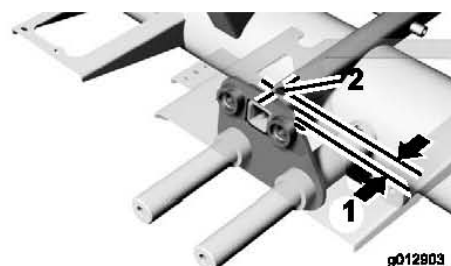


Figure 3

1. 1-1/4 inches
2. 5/8 inch diameter hole

6. Insert the new frame stub into the frame tube, positioning as shown in Figure 4.

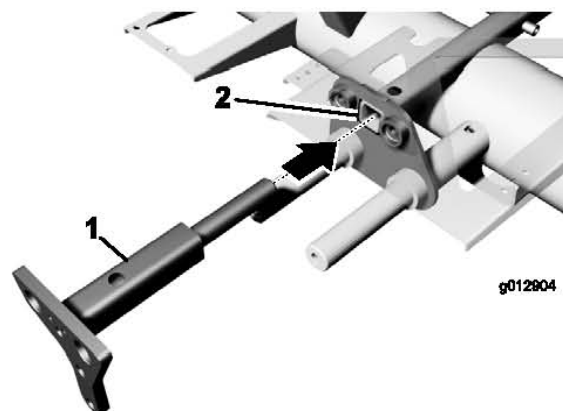


Figure 4

1. New frame stub
2. Frame tube

7. Loosely install the new bridge plate to the pivot shafts with (2) bolts (1/2 x 2-1/2 inch) and washers (1/2 inch) (Figure 5).
8. Loosely install the bridge plate to the frame stub plate with a bolt (1/2 x 1-1/4 inch) and washer (1/2 inch) (Figure 5).
9. Loosely install the bridge plate to the frame stub plate with (2) bolts (1/2 x 1-3/4 inch), washers (1/2 inch) and flange nuts (1/2 inch) (Figure 5).



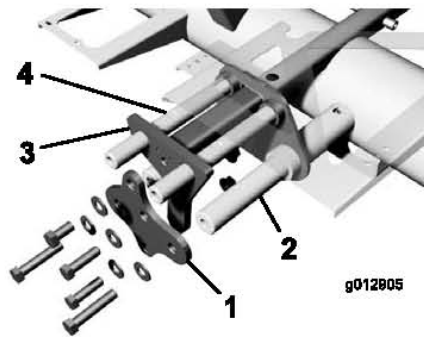


Figure 5

- | | |
|--------------------|----------------------------------|
| 1. Bridge plate | 3. Frame stub plate |
| 2. Pivot shaft (2) | 4. Lift cylinder pivot shaft (2) |

10. Insert the lift cylinder pivot shafts through the stub shaft plate and secure them to the lift plate with the bolts and washers previously removed (Figure 5).
11. Tighten all the bridge plate mounting fasteners.

Note: The distance between the back of the frame stub plate and the front of the lift plate should be 6.06 inches (Figure 6). If this is not the distance, check for damage.

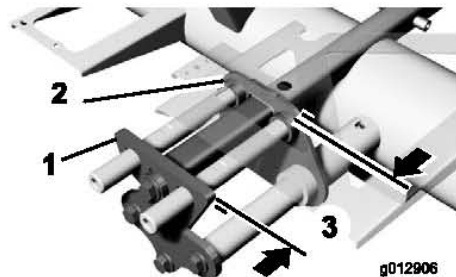


Figure 6

- | | |
|---------------------|----------------|
| 1. Frame stub plate | 3. 6.06 inches |
| 2. Lift plate | |

12. Secure the top and bottom of the frame stub to the lift plate with a 1/4 inch fillet weld (Figure 7).

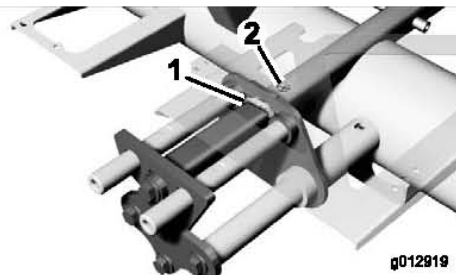


Figure 7

- | | |
|---------------------------------|-------------------|
| 1. Fillet weld (top and bottom) | 2. Plug weld here |
|---------------------------------|-------------------|

13. Remove the lift cylinder pivot shafts.

14. Secure the sides of the frame stub to the lift plate with a 1/4 inch fillet weld.
15. Using the newly drilled holes in the frame tube, plug weld the stub shaft to the tube (Figure 7).
16. Remove all the bridge plate mounting bolts, washers and flange nuts (Figure 8). Remove the bridge plate.

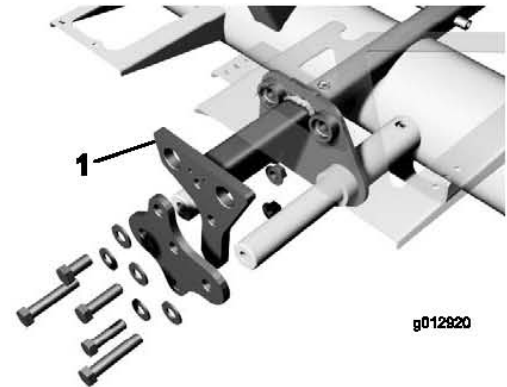


Figure 8

1. Bridge plate

17. Insert the lift cylinder pivot shafts through the stub shaft plate and secure them to the lift plate with the bolts and washers previously removed (Figure 9).

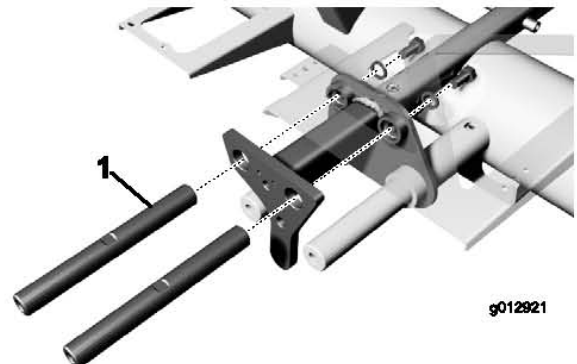


Figure 9

1. Lift cylinder pivot shaft (2)

18. Install the lift arms onto the pivot shafts and secure with the new bridge plate and the fasteners as described in steps 7 through 9. Apply Loctite to all the bolt threads prior to installation
19. Install the lift cylinders and secure them with the fasteners previously removed.
20. Install the cutting units and secure them with the hardware previously removed.

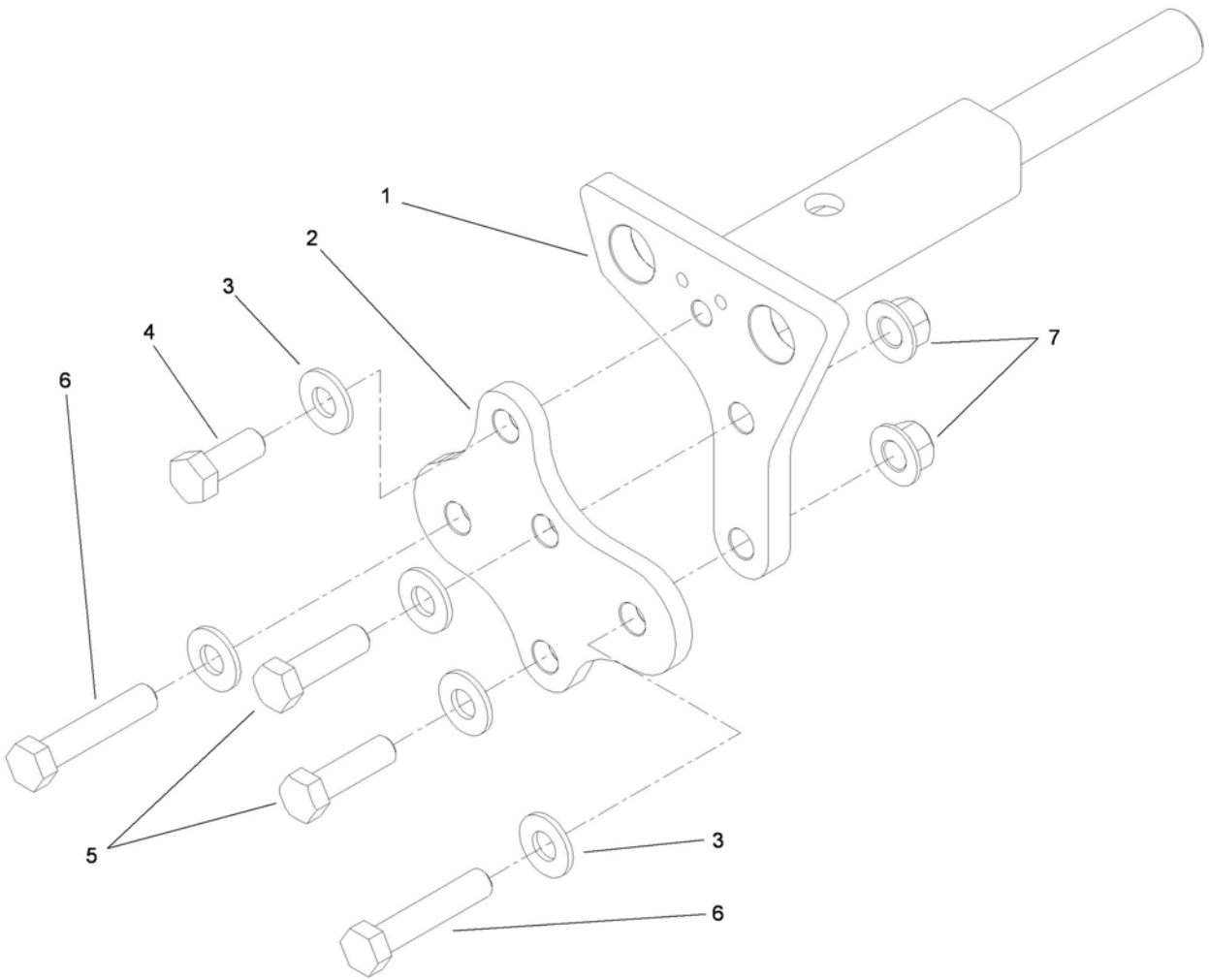


Count on it.

Form No. 3364-588 Rev A

Parts Catalog

Lift Support Frame Repair Kit Reelmaster® 5010 Series Traction Unit Model No. 119-6950



Lift Support Frame Repair Assembly

Ref.	Part Number	Qty.	Description
1	119-6951-01	1	Stub Frame ASM
2	119-6954-01	1	Plate-Bridge
3	87-7270	5	Washer-Thrust
4	325-5	1	Screw-HH
5	325-7	2	Screw-HH
6	325-10	2	Screw-HH
7	99-5107	2	Nut-Lock