

GRAVELY Service Bulletin

Ariens Company
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Product Family: Pro-Turn 400 Mowers

Subject: Possible Foot Plate Weld Fracture

Dealer Action: Inspect and Install Kit

Model	Serial Number Range	Description
992230	101 – 177, 179 – 181, 183 – 184, 186 – 187, 192 – 196, 198 – 205, 208 – 223, 225, 227 – 229, 231 – 233	Pro-Turn 452
992231	101 – 111, 114 – 118, 121 – 122, 124 – 125, 130, 136, 138 – 140, 143 – 144, 146 – 147, 150 – 151, 156, 159, 161, 167, 169, 173, 175, 180, 183, 185, 187	Pro-Turn 452
992232	101 – 109, 111 – 120, 122 – 128, 130 – 139, 141 – 142, 144, 147, 152, 154, 156 – 157, 159, 171 – 174, 183 – 184, 196 – 197, 199 – 200, 204	Pro-Turn 460
992233	101 – 266, 268 – 284, 286 – 371	Pro-Turn 460
992234	101 – 181, 183, 186 – 198, 200 – 202, 204 – 243, 246 – 249, 255, 258 – 261, 263 – 265, 267, 269, 271, 275 – 287, 290 – 291, 293 – 299, 302 – 303, 310 – 312, 314 – 317, 322 – 325, 327 – 328, 333, 335, 342, 345, 354 – 355, 361, 368, 370 – 373, 377, 380, 383 – 384, 386, 388 – 389, 392 – 397, 400 – 404, 406, 409, 412	Pro-Turn 460
992235	101 – 874	Pro-Turn 460
992238	101 – 124, 126 – 162, 164 – 166	Pro-Turn 466
992239	101 – 292, 294, 296 – 300, 302 – 308, 314 – 316, 318, 501 – 504, 506 – 508, 510 – 514, 517 – 520, 522 – 524, 526 – 527, 529	Pro-Turn 472

Ariens Company has received a limited number of reports of fractured welds on the foot plate of the Gravelly Pro-Turn 400 series commercial mowers in the model and serial number ranges listed above. The foot plate is not a structural component of the frame, so this crack will not affect the structural integrity of the machine. However, the fractured welds are cosmetically unpleasing and over time the foot plate may come loose due to vibration.

To address this issue, Ariens Company has developed two cradle plates kits:

- 59214800 (52", 60" and 66" models)
- 59214900 (72" models).

The cradle plates in these kits stiffen the foot plate mounting area of the machine to prevent cracks from developing at the welds. The kits include the cradle plates along with other supplies needed to install the plates. Because welding will be required, primer and touch up paint are included. Attached is an installation instruction sheet for the kits.

Please note the following important items:

- All PT400 models shipped from Ariens Company after 7/23/2012 have been manufactured with the cradle plates installed on the frame below the foot plate.
- All unsold dealer inventory is to be updated with 59214800 or 59214900 prior to sale.
- A certified welder should be used to do the welding portion of the repair.
- All registered owners of Pro-Turn 400 units will be contacted by letter from Ariens Company about this issue. Customers will be made aware that the foot plate weld may fracture and instructed to contact their dealer if the problem occurs.
- Normal warranty applies. Flat rate for installation of 59214800 and 59214900 is 3.0 hours.
- The installation of kits 59214800 or 59214900 on a Pro-Turn 400 unit with an 892040 bagger installed will require changing the front weight bracket p/n 03969351 to p/n 04555851 to provide additional clearance for the cradle plate. Refer to Service Bulletin B-2094 for more information about this change.

Instruction Sheet

Kit Number: 59214800 & 59214900

FOOT PLATE REPAIR INSTRUCTIONS

For use on models:

59214800: 992230, 992231, 992232, 992233, 992234, 992235, 992238

59214900: 992239



WARNING: FAILURE TO FOLLOW INSTRUCTIONS could result in personal injury and/or damage to unit.

Read, understand, and follow all safety practices in Owner/Operator Manual before beginning.

Package Contents

Check the contents of your kit for the parts listed below (Figure 1):

Item	Description	Qty	Ariens P/N
1	Cradle Plate (52, 60, 66" Decks) Cradle Plate (72" Decks)	1	04554353 04554453
2	1/2"-13 x 1 1/4" Round Head Square Neck Bolt	2	06224700
3	9/16" x 1 3/8" x 7/64" Flat Steel Washer	2	06442000
4	1/2"-13 Locking Nylon Flange Nut	2	06500010
5	Gravelly Red Spray Paint	1	00008700
6	Gravelly Red Touch-up Paint	1	00026600
7	20 oz. Galvanizing Primer	1	00077800

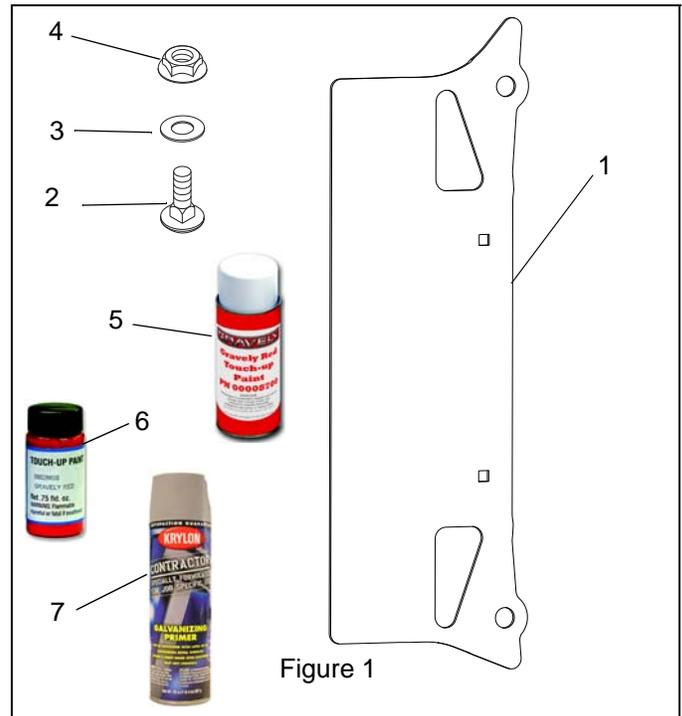


Figure 1

INSTALLATION

Remove Mower Deck

IMPORTANT: If desired the mower deck does not need to be completely removed. If this repair method is chosen the PTO belt is removed, the rear mounting pins are left in place and the deck allowed to pivot down as the front of the tractor is lifted. If deck remains attached to the tractor a welding blanket must be used to protect the deck during welding.



CAUTION: AVOID INJURY. Prior to lifting unit for repair, ensure that jack stands are strong, secure and will support the weight of the unit and mechanic. Follow all safety precautions in the unit's owner/operator manual.

1. Remove PTO belt.

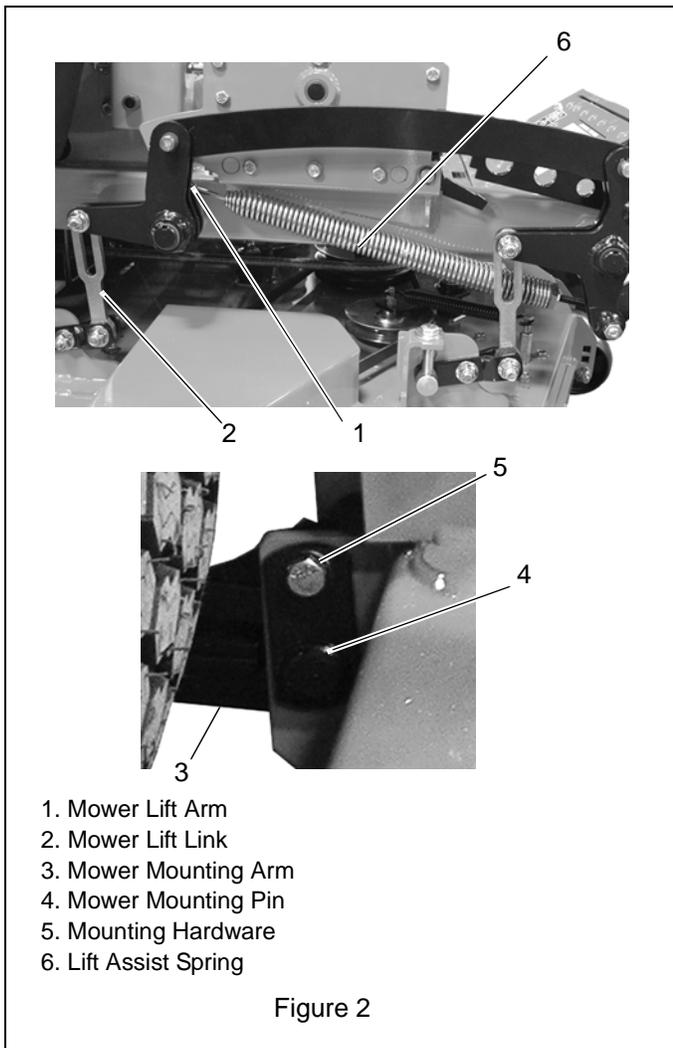


WARNING: AVOID INJURY. Mower lift arms and mower lift pedal could cause severe injury if the lift assist spring is not disconnected before disconnecting the lift links.

Springs store energy. Keep body parts well away from pinch points when removing the deck.

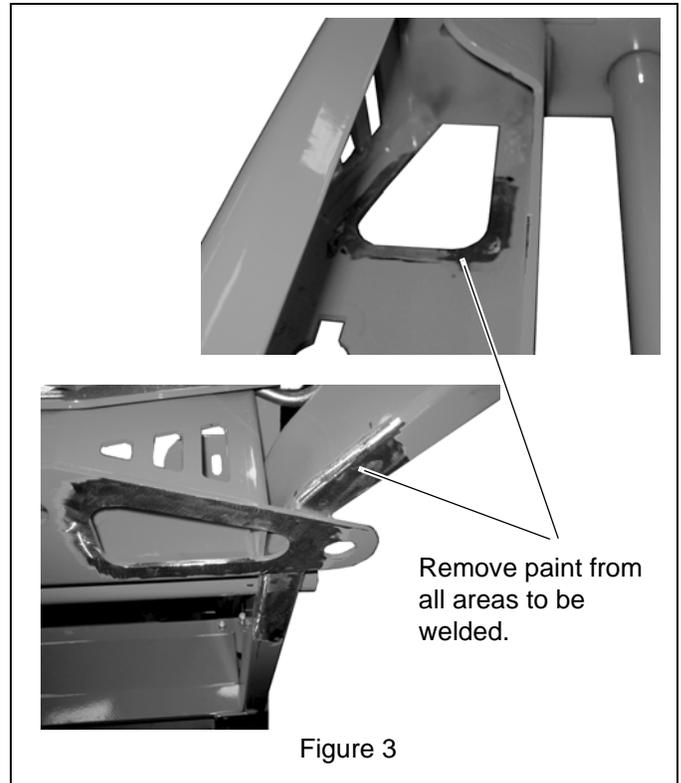
Note: Support the mower deck on blocks or jack stands before disconnecting links from mower lift arms to prevent the deck from falling.

2. Remove hardware retaining foot plate and remove.
3. Raise the deck to the transport position and disconnect the lift assist springs (6) from the mower lift arms (1) on each side of the deck.
4. Slowly lower the deck to its lowest position.
5. Remove hardware retaining all four mower lift links (2) from mower lift arms.
6. Remove the rear mower mounting pins (4) connecting the mower mounting arms (3) to the deck.
7. Slide mower deck out from under unit.



8. Remove front right and left lift arms.
9. From below front foot plate loosely install cradle plate (item 1) using two 1/2 bolts (item 2) and two flange nuts (item 4).
10. Using cradle plate as a template, mark off an area at least 3/4" from the edge of the cradle plate in all areas to be welded (see *Weld Guide* on page 4).
11. Remove the cradle plate and hardware.

12. Fully remove the paint in the marked areas (see figure 3 on page 2). Take care not to remove any steel. Clean area thoroughly prior to welding.



13. Mount and install cradle plate (item 1) using two 1/2 bolts (item 2), two flat washers (item 3), and two flange nuts (item 4). Ensure that cradle plate is centered and properly aligned before tightening hardware (see *Weld Guide* on page 4).
14. Using C-clamps and/or locking pliers ensure that all four welding surfaces are mated properly.
15. Weld the cradle plate into position using the weld guide (see *Weld Guide* on page 4). If the deck is still mounted to the tractor protect it with a welding blanket.

CAUTION: The paint on the frame can catch fire and continue to burn if it becomes too hot. Be prepared to extinguish flame immediately if it begins to burn. To keep welding zones cooler, alternate between different areas or allow frame to cool between weld beads.

16. Upon completion of welding allow frame to cool completely.
17. Dress welds as necessary and clean all areas completely with isopropyl alcohol.
18. Coat all welds an unprotected steel with galvanizing primer (item 7). Follow application instructions on primer can.
19. Coat all welds and unprotected steel with enamel paint provided with kit.



Figure 4

20. Reinstall deck and adjust per procedure found in owner's manual.
21. Reinstall foot plate.

