

PRODUCT: PRO 3000/3200, PRO 4000/4200

RE: Front Mount Replacement

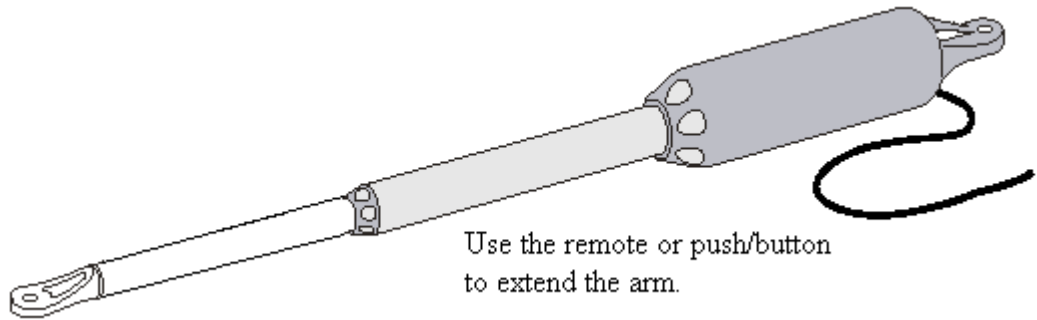
Starting April 27, 2005, GTO, Inc. is shipping PRO-SW3000/3200's and PRO-SW4000/4200's with the front mounts sealed in place. They are sealed with Blue label Lock Tite. Below are the instructions you will need to replace the front mount.

Required Tools and Products:

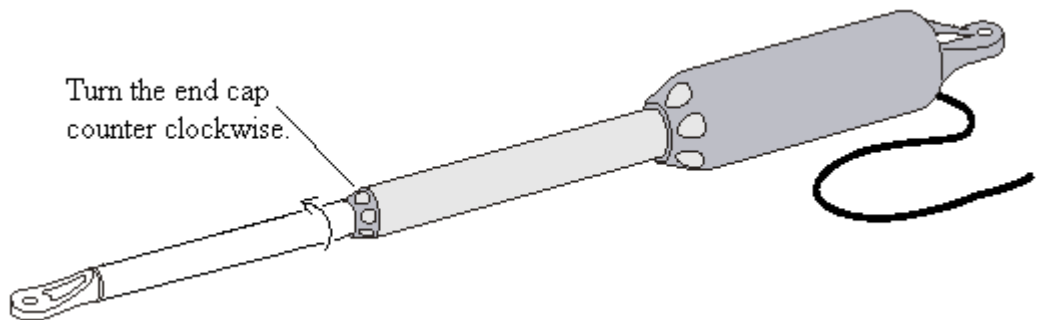
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|--|--------------------------|
| 1. Propane Torch | 2. Front Mount |
| 3. Blue Grade Lock Tite | 4. Spring Pin |
| 5. Punch (approx. 1/8") | 6. Hammer (Carpenter) |
| 7. 2 Channel Locks (about a 2 1/2" Grip) | 8. Gloves (Welder Style) |
| 9. Hand Drill with 1/8" or 5/32" Bit | 10. Center Punch |
| 11. Safety Glasses | |

Procedure

- A. Removing the broken mount (Wear your safety glasses during the repair process):
1. Extend the arm (push/pull tube) to its full extension.

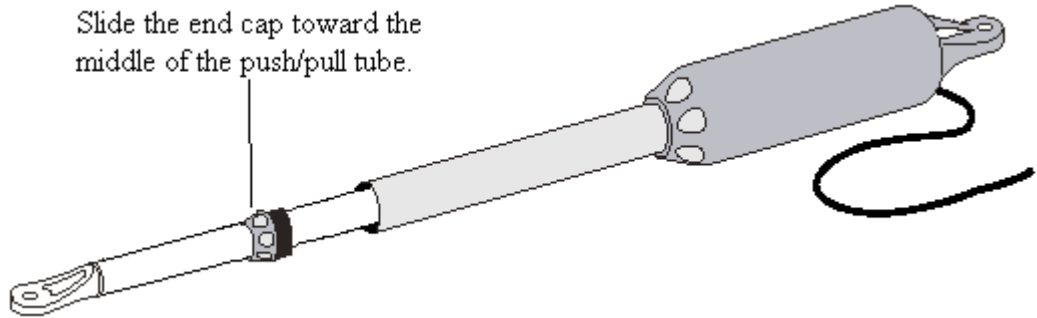


2. Loosen the end cap scraper seal.

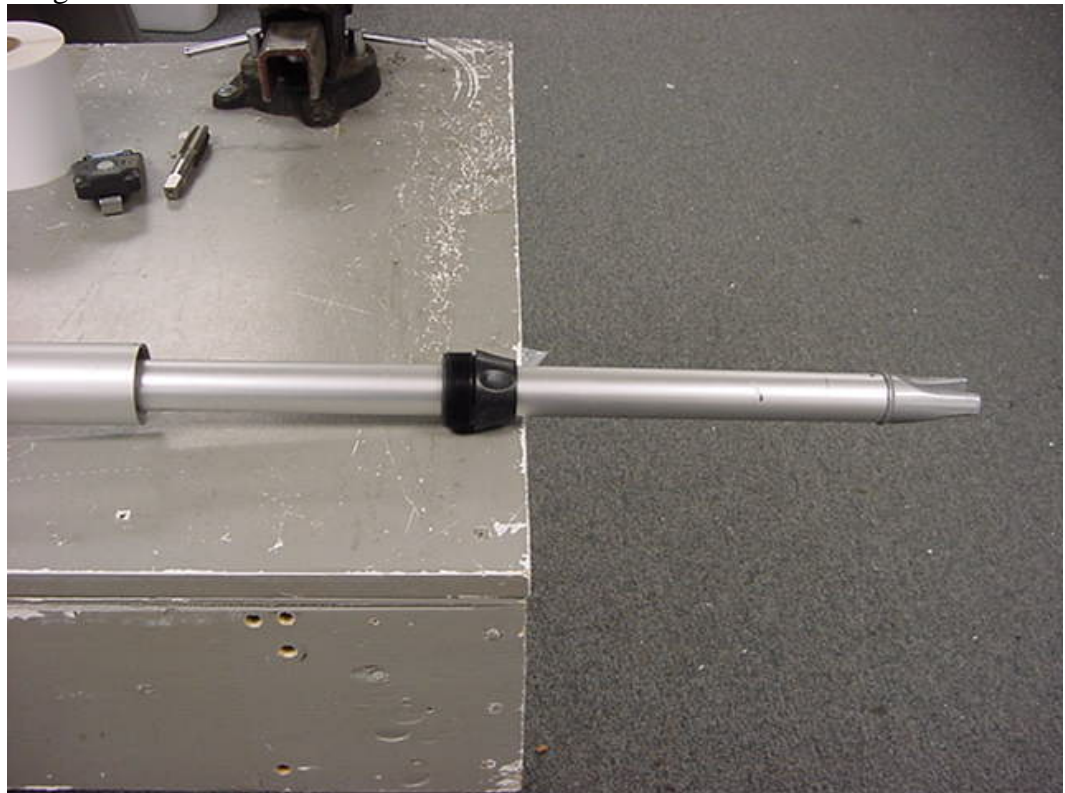


3. Slide the end cap scraper seal toward the middle of the push/pull tube.

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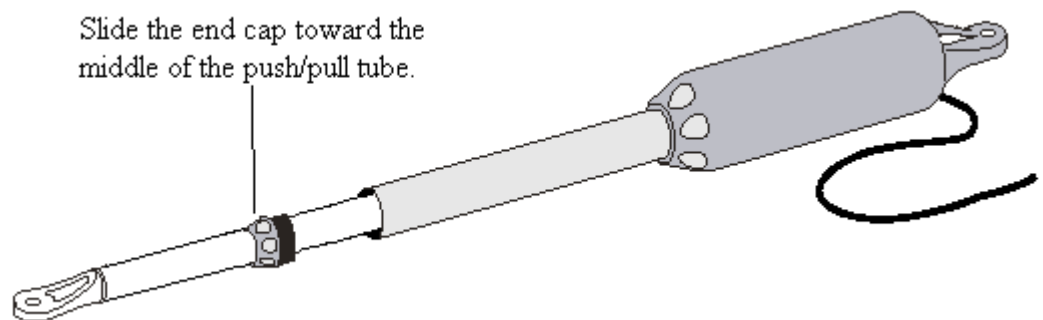


4. Rest the arm on a flat surface such as a table and allow the push pull tube to hang off the surface about 12".

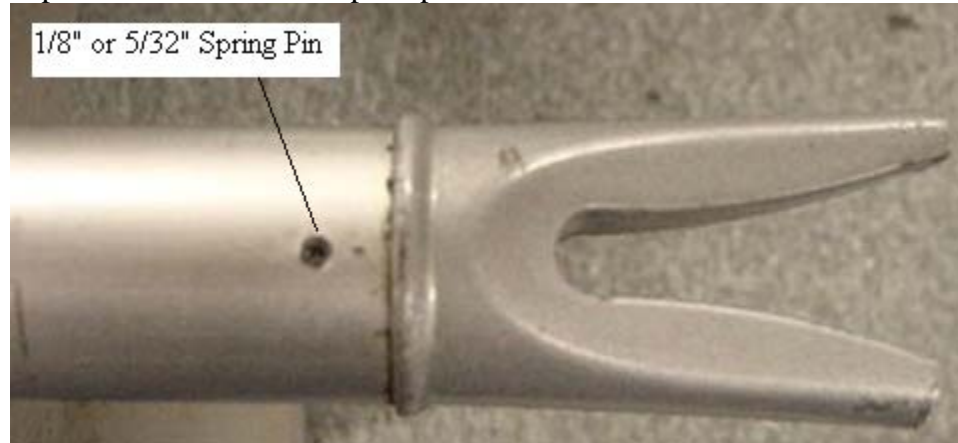


5. Make sure the scraper seal is away from the front mount (heat will damage plastic).

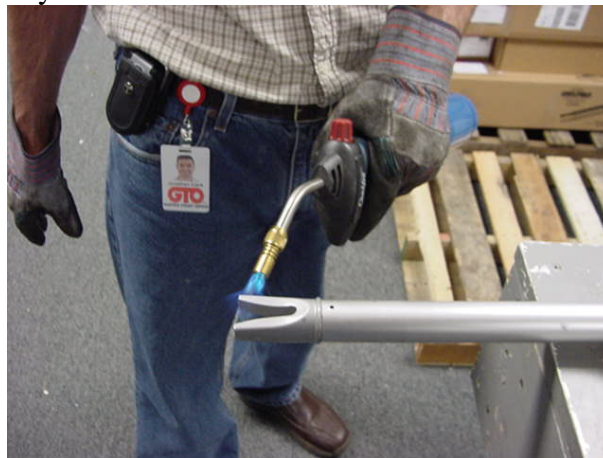
Slide the end cap toward the middle of the push/pull tube.



6. Use the punch and hammer to drive the spring pin into the body of the tube. The pin must be clear of the push/pull tube.



7. Put on the protective gloves.
8. Heat the end of the push/pull tube near the front mount with a propane torch for about 1 to 2 minutes. After this length of time, the Lock Tite should liquefy and allow you to remove the front mount.



9. Hold the end of the push/pull tube close to the housing with one set of Channel Locks. Be sure to hold very end of tube. A rag may be placed between the pliers and tube to avoid scratching or scarring the tube. Use the other set of Channel Locks to grip the front mount. Screw the front mount out of the push/pull tube before the parts cool off. Rotate the front mount in a counter clockwise direction until it is free of the tube.



Warning – Keep your limbs away from the hot areas!

B. Installing the new front mount:

1. Allow the push/pull tube to cool off before attempting to install the new front mount.
2. Thread the front mount into the Push/Pull tube about 2 turns.
3. Apply Blue Label Lock Tite to the threaded area and flange of the front mount.



4. Thread the front mount into the push/pull tube until it bottoms out on the edge of the tube.



5. Stand the arm upright (Fig 12) and allow the Lock Tite to dry. Complete drying time is 24 hours. We understand that in many cases it will not be practical to wait 24 hours. We have added a weep hole to the housing in the event that liquid does seep through the front mount. If you are doing this repair in your shop, we do recommend that you wait 24 hours.



6. When the Lock Tite is dry, you will need to center punch and drill a 1/8" or 5/32" hole (depending on the size of your spring pin) through the push/pull tube and front mount.



7. Insert the spring pin in this hole and tap it in until it is flush with the surface of the push/pull tube.



8. Screw the push/pull tube back in toward the home position. Stop it about 4" from the home position. At that point, reattach the scraper seal.



9. The arm is now ready to return to service.