



Gigglepin GP50 Single Motor Top Housing – Updated 2 Speed Conversion Drilling Instructions

If you have purchased a 2 speed gear set to fit into your existing GP50 Single Motor Top Housing, you will find in the kit the following items.

The purpose of these kits is to enable you to drill the hole in your Top Housing accurately, as it is crucial to the operation of the 2 Speed conversion.



You will need a drill (suitable for a 10mm drill bit).

Firstly remove the Top Housing from your winch – After removing the motor first.

Remove the cover plate – retaining the O-ring seal.

Strip the existing gears from the Top Housing, and remove the bearing from the inside of the casting,

This bearing will be a tight fit, if you do not have an internal bearing puller, to make removal easier, use a blow torch, warm up the casting on back side, with the bearing face down it will drop out when the casting is warm enough – CAUTION the bearing will be hot – use gloves to pick it up, this bearing is not used with the 2 Speed gears.

The motor mount bearing and filler bung can be left in place or removed.

It is prudent to degrease and clean the casting now as it makes swarf removal easier later.

Once cleaned and prepared it makes life easier to secure the Top Housing in a vice, with the cover plate side upper most and level.

For the purpose of these instructions the Top Housing is not shown in a vice.



Next take the drill jig with the 2 x metal inserts and place into the bearing pocket on the inside of the casting (where you removed the bearing from).

Ensure it is pressed home until it bottoms out, and make sure the 4mm inner metal insert is the right way up with the chamfer facing you.



Using three of the M6 Cap Head bolts – Used to secure the cover plate to the top housing, fit the drill guide as shown in the image below, ensuring the 4mm marked hole is centered over the drill jig.





Using the long 4mm drill bit, drill through the hole in the Drill Guide and the Drill Jig, drill right through the Top Housing casting.



Un bolt the Drill Guide and remove the 4mm bush from the Drill Jig, discard as they are single use.





Re install the Drill Guide with the 10mm hole lined up with the Drill Jig below, secured again with three of the M6 Cap Head bolts.



Using the 10mm drill, drill through the hole in the Drill Guide and Drill Jig, drill right through the Top Housing casting.



Lastly remove the Drill Guide and Drill Jig from your Top Housing and discard - they are single use only.(keeping the M6 Cap Head bolts to re attach your cover plate.)

Remove all the swarf from the Top Housing.

You are now ready to install the 2 Speed Gear kit.