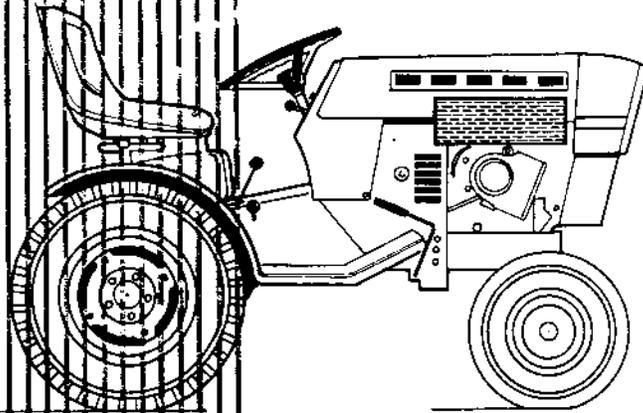


Sears

MODEL NO.
917.25191



OWNER'S MANUAL

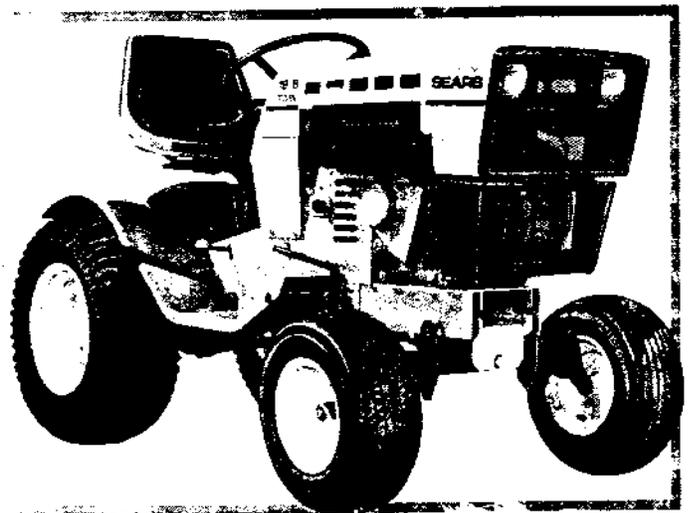
18/6 TWIN
GARDEN TRACTOR

Assembly

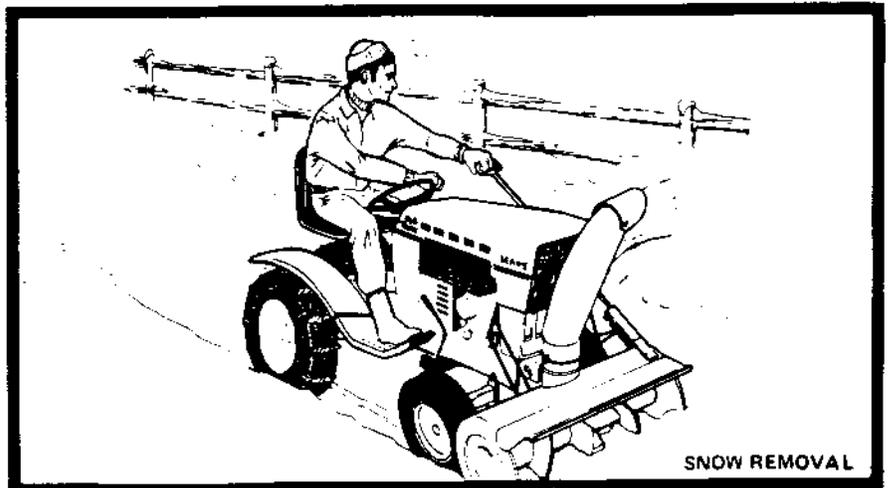
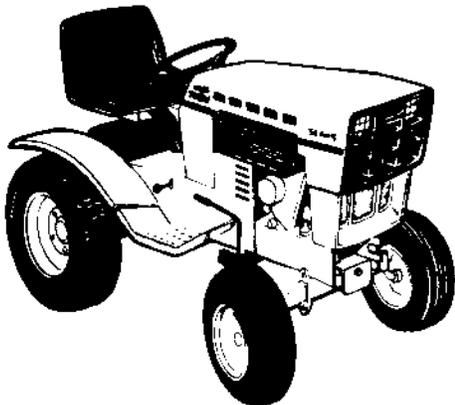
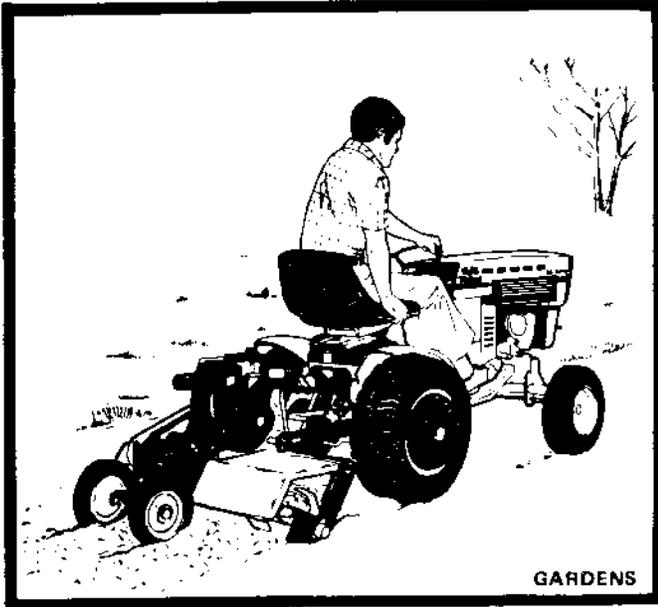
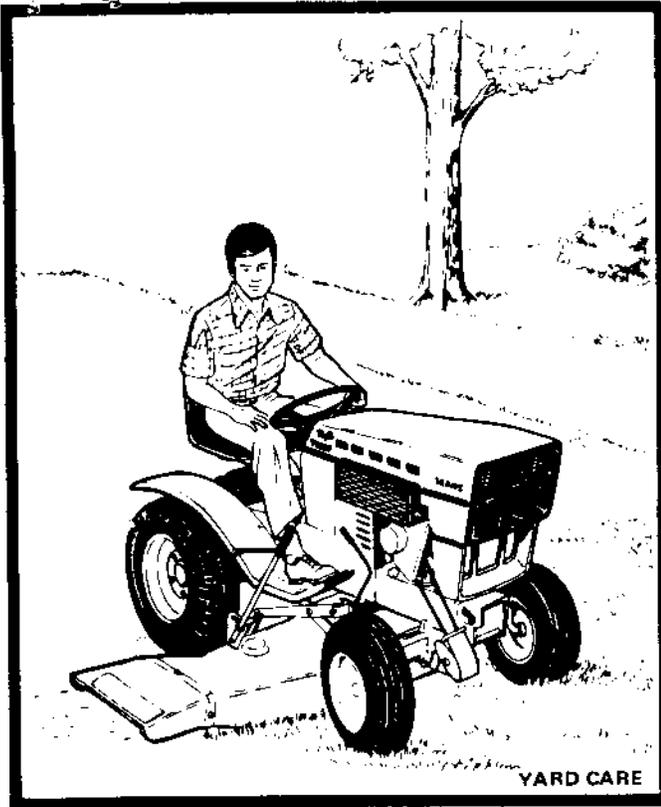
Operation

Maintenance

Repair Parts



IMPORTANT
READ FULLY FOR
SAFE OPERATION
AND INSTRUCTIONS
CAREFULLY



CONGRATULATIONS on your purchase of a Sears 18/6 Twin Garden Tractor. It has been designed, engineered and manufactured to give you dependability and performance. Should you experience any problem you cannot easily remedy, please contact your nearest Sears, Roebuck and Co. or Simpsons Sears Limited store. They have competent, well-trained technicians and the proper tools and parts to service or repair this unit.

Please read and retain this manual. The instructions will enable you to assemble, operate and maintain your Tractor properly. Always observe the "RULES FOR SAFE OPERATION".

YOUR NEW 18/6 TWIN GARDEN TRACTOR FEATURES...

OPPOSED-PISTON, FOUR CYCLE, TWIN-CYLINDER 18 H.P. ENGINE--to run smoothly and quietly with plenty of power to take on a variety of yard, gardening or snow removal tasks.

SAFETY INTERLOCK SYSTEM--allows engine to start only when tractor Clutch-Brake Pedal is depressed and Attachment Clutch Lever is in "OFF" position.

ALL-GEAR TRANSMISSION--six speeds forward, two reverse speeds--to let you select the proper match for the terrain and the job. Auto-type differential helps guard against turf scuffing.

SERVICE HOUR METER--lets you know at a glance, when maintenance is due.

CONTROL PANEL--with Throttle, Choke, Light Switch, Ignition Switch, Service Hour Meter and Electric Lift Switch for Three Point Hitch conveniently grouped for ease of use.

ATTACHMENT VERSATILITY--handles a large variety of Sears Yard and Garden Tractor Attachments including . . .

42 AND 48 INCH MOWERS with three "high-lift" blades to lift grass up for level cuts.

LITTER WHISK LAWN SWEEPER is more efficient than conventional lawn sweepers because of its wheel-less design; only the rotary brush touches the ground.

SELF POWERED ROTO SPADER prepares soil for new lawns and gardens with a 30 to 38 inch wide tilling path.

OTHER SOIL TILLAGE ATTACHMENTS including Plow, Disc Harrow, Drag Harrow and Cultivator.

CHEVRON TIRES for added traction in loose soil, gravel or snow.

SNOW BLOWER handles wet, heavy or powdery snow with ease.

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| ASSEMBLY INSTRUCTIONS | 2 | REPAIR PARTS | 12 |
| OPERATION INSTRUCTIONS | 4 | | |

FULL ONE YEAR WARRANTY ON ELECTRIC START TRACTOR

For one year from the date of purchase, when this tractor is used for personal household purposes, Sears will repair any defect in material or workmanship in this tractor, except the battery, at no charge. If the tractor is used for commercial or rental purposes, this warranty applies for only 30 days from the date of purchase.

FULL 90-DAY WARRANTY ON BATTERY

For 90 days from the date of purchase, if any battery included with the tractor proves defective in material or workmanship and will not hold a charge, Sears will replace the battery at no charge.

LIMITED WARRANTY ON BATTERY

From the 91st day until one year from the date of purchase, if any battery included with the tractor proves defective in material or workmanship and will not hold a charge, Sears will replace the battery, charging 1/12th of the price of the new battery for each full month from the date of purchase.

Warranty service is available by simply contacting the nearest Sears store or Service Center throughout the United States.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

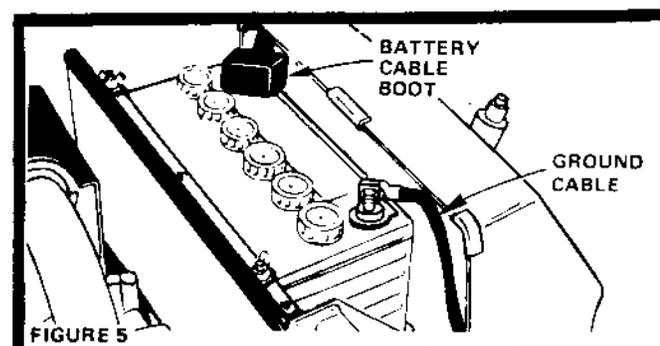
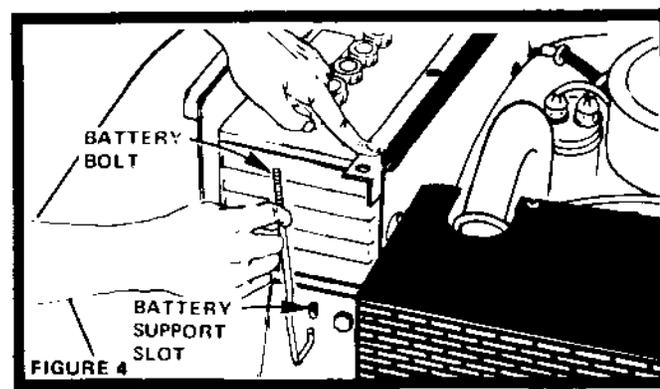
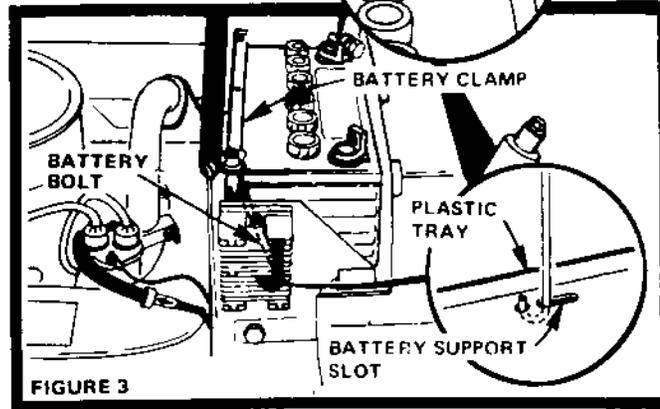
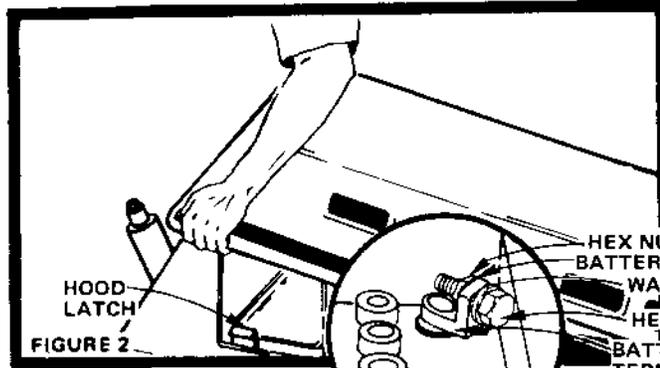
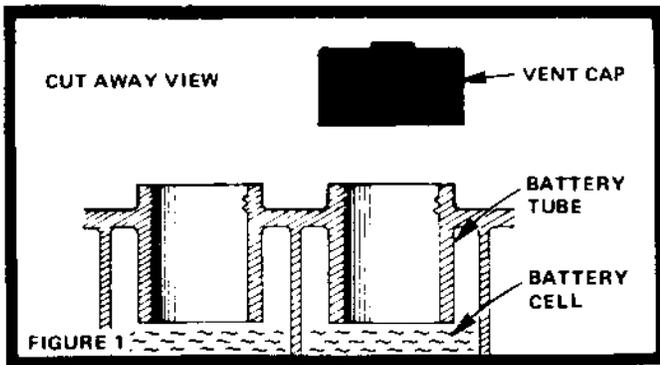
Sears, Roebuck and Co.
Sears Tower
BSC 41-3
Chicago, IL 60684

RULES FOR SAFE OPERATION

1. Know the controls and how to stop quickly. READ THE OWNER'S MANUAL.
2. Do not allow children to operate the vehicle. Do not allow adults to operate it without proper instruction.
3. Do not carry passengers. Keep children and pets a safe distance away.
4. Clear the work area of objects which might be picked up and thrown.
5. Disengage all attachment clutches and shift into neutral before attempting to start the engine.
6. Disengage power to attachments and stop the engine before leaving the operator's position.
7. Disengage power to attachments and stop the engine before making any repairs or adjustments.
8. Disengage power to attachments when transporting or not in use.
9. Take all possible precautions when leaving the vehicle unattended, such as disengaging the power-take-off, lowering the attachments, shifting into neutral, setting the parking brake, stopping the engine, and removing the key.
10. Do not stop or start suddenly when going uphill or downhill. Mow up and down the face of slopes (not greater than 15°); never across the face.
11. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
12. Stay alert for holes in the terrain and other hidden hazards.
13. Use care when pulling loads or using heavy equipment.
 - a. Use only approved drawbar hitch points.
 - b. Limit loads to those you can safely control.
 - c. Do not turn sharply. Use care when backing.
 - d. Use counterweights or wheel weights when suggested in this owner's manual.
14. Watch out for traffic when crossing or near roadways.
15. When using any attachments, never direct discharge of material toward bystanders nor allow anyone near the vehicle while in operation.
16. Handle gasoline with care - it is highly flammable.
 - a. Use approved gasoline containers.
 - b. Never remove the cap of the fuel tank or add gasoline to a running or hot engine, or fill the fuel tank indoors. Wipe up spilled gasoline.
 - c. Open doors if the engine is run in the garage - exhaust fumes are dangerous. Do not run the engine indoors.
17. Keep the vehicle and attachments in good operating condition, and keep safety devices in place.
18. Keep all nuts, bolts and screws tight to be sure the equipment is in safe working condition.
19. Never store the equipment with gasoline in the tank inside a building where fumes may reach an open flame or spark. Allow the engine to cool before storing in any enclosure.
20. To reduce fire hazard, keep the engine free of grass, leaves or excessive grease.
21. The vehicle and attachments should be stopped and inspected for damage after striking a foreign object, and the damage should be repaired before restarting and operating the equipment.
22. Do not change the engine governor settings or overspeed the engine.
23. When using the vehicle with mower, proceed as follows:
 - a. Mow only in daylight or in good artificial light.
 - b. Never make a cutting height adjustment while the engine is running if the operator must dismount to do so.
 - c. Shut the engine off when removing the grass catcher or unclogging chute.
 - d. Check the blade mounting bolts for proper tightness at frequent intervals.
24. Check the grass catcher bags frequently for wear or deterioration. Replace with new bags for safety protection.



LOOK FOR THIS SYMBOL TO POINT OUT IMPORTANT SAFETY PRECAUTIONS. IT MEANS -- ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED.



To assemble and adjust your Tractor you will need:
one 7/16", 9/16" and 3/4" Wrench

ASSEMBLY

1. Remove Shipping Wires, Battery, Steering Wheel and Bag of Parts.
2. Filling and charging Battery (before installing) **NOTE: SEE DETAILED INSTRUCTIONS PACKAGED WITH BATTERY.**



WEAR EYE AND FACE SHIELD.

- a. Fill Battery with electrolyte to bottoms of tubes in cells (Fig. 1). **NOTE: DO NOT OVERFILL. OVERFILLING WILL RESULT IN DAMAGE TO TRACTOR.**



WASH HANDS OR CLOTHING IMMEDIATELY IF ACCIDENTALLY IN CONTACT WITH ELECTROLYTE.

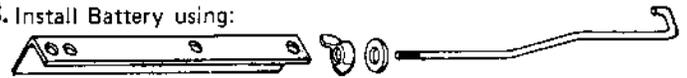
- b. Check level of electrolyte after 30 minutes. Add additional electrolyte if necessary. **NOTE: Tighten Vent Caps securely,**
- c. Charge Battery at a rate not exceeding three amperes for about two and one half hours.



DO NOT SMOKE. FUMES FROM CHARGED ELECTROLYTE ARE EXPLOSIVE.

- d. Neutralize excess electrolyte for disposal by adding it to four inches of water in a five gallon plastic container. Stir with a wooden or plastic paddle while adding baking soda until the addition of more soda causes no more foaming.

3. Install Battery using:



Battery Clamp, two Wing Nuts, two Battery Bolts,



four Flat Washers, two Hex Bolts and two Hex Nuts found in Bag of Parts.

- a. Push down and slightly spread rear sides of Hood to release Hood Latches. Lift Hood from rear sides (Fig. 2).
- b. Remove tape from Plastic Tray. Position Plastic Tray so that drain hole in Tray is over round hole of Battery Support.
- c. Place Battery in Plastic Tray (Battery Terminals to rear of Tractor) (Fig. 3).
- d. Hook one Battery Bolt into slot on the left side of Battery Support (Fig. 3). Fasten Battery Clamp (inner slot) to Battery Bolt with a Flat Washer and Wing Nut.
- e. Hook remaining Battery Bolt to right side of Battery Support and fasten Battery Clamp to it with a Flat Washer and Wing Nut (Fig. 4). Tighten Wing Nuts securely.
- f. Place a Flat Washer over the end of a Hex Bolt. Secure RED Battery Cable to Positive (+) Battery Terminal with a Hex Bolt (Washer attached) and Hex Nut (Fig. 5). Tighten Nut securely. Place Boot over Terminal.



POSITIVE TERMINAL MUST BE CONNECTED FIRST TO PREVENT SPARKS FROM ACCIDENTAL GROUNDING.

- g. Place remaining Flat Washer over the end of the remaining Hex Bolt. Secure BLACK Ground Cable to Negative (-) Battery Terminal with Hex Bolt (Washer attached) and Hex Nut (Fig. 5). Tighten Nut securely.

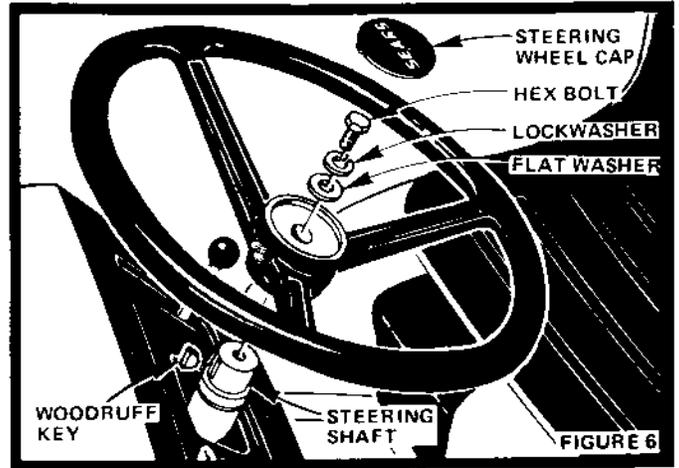
4. Install Steering Wheel using:

Flat Washer, Lockwasher, and Hex Bolt assembled on end of Steering Shaft:



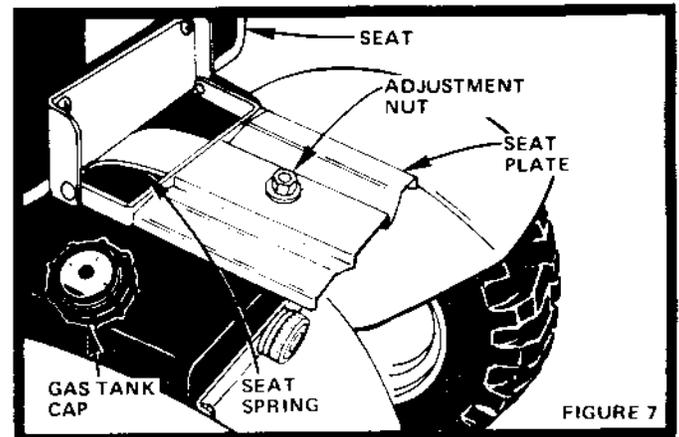
Woodruff Key, and Steering Wheel Cap found in Bag of Parts.

- Remove Hex Bolt, Lockwasher and Flat Washer from Steering Shaft (Fig. 6).
- Insert Woodruff Key in Keyway of Steering Shaft and slide Steering Wheel over Shaft and Key. NOTE: BE SURE WOODRUFF KEY IS SECURE IN STEERING SHAFT.
- Fasten with Flat Washer, Lockwasher and Hex Bolt (Fig. 6). Tighten securely.
- Insert Steering Wheel Cap in place.



INITIAL ADJUSTMENTS

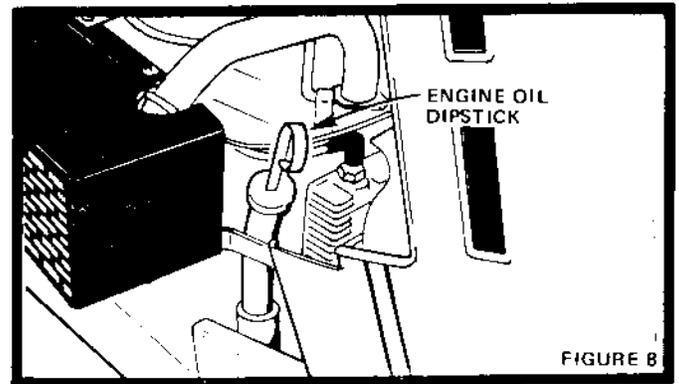
- Reduce Tire pressure to 12 pounds in front and rear Tires. (Tires were overinflated for shipping purposes).
- Seat position may be adjusted forward or backward by loosening Nut in Seat Plate (Fig. 7). NOTE WHEN RE-TIGHTENING NUT AFTER ADJUSTMENT, MAKE SURE SEAT PLATE HAS NOT TWISTED OUT OF ALIGNMENT WITH SEAT SPRING.
- A spark arrester muffler is available as an accessory part for your tractor. Check legal requirements in your area.



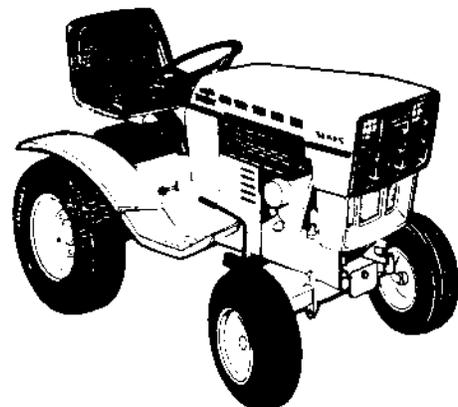
INITIAL SERVICE

NOTE: BE CAREFUL NOT TO ALLOW DIRT TO ENTER THE ENGINE WHEN CHECKING OR ADDING OIL OR FUEL.

- Check Engine Oil Level with Tractor on level ground. Wipe dipstick (Fig. 8) clean, push it in tight for a few seconds, remove and read Oil Level. If necessary, add Oil until "FULL" mark is reached. In summer use S.A.E. 30 (SC, SD or SE) Oil. In winter (below 32°F.) use S.A.E. 10W30 (SC, SD or SE) or 10W40 (SC, SD or SE). In extreme cold (below 0°F.) use S.A.E. 5W20 (SC, SD or SE). NOTE: DO NOT OVERFILL.
- Fill Fuel Tank (Fig. 7) with fresh regular grade lead-free or leaded gasoline. Capacity is 3 - 1/4 gallons. NOTE: DO NOT SWITCH FROM LEADED TO LEAD-FREE GASOLINE.



FILL TO BOTTOM OF GAS TANK FILLER NECK. DO NOT OVERFILL. WIPE OFF ANY SPILLED OIL OR FUEL.



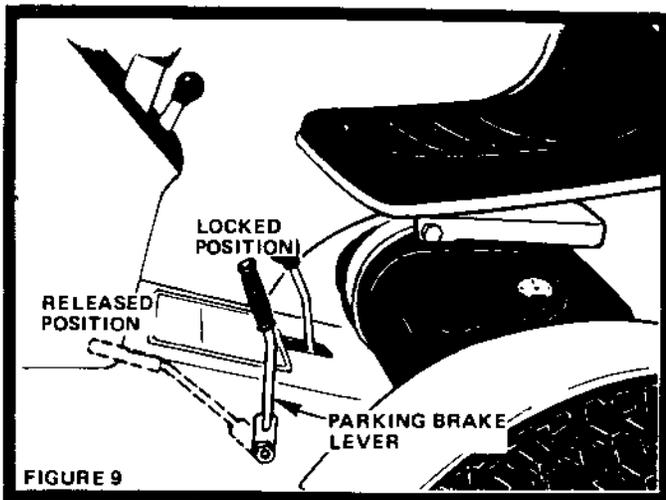


FIGURE 9

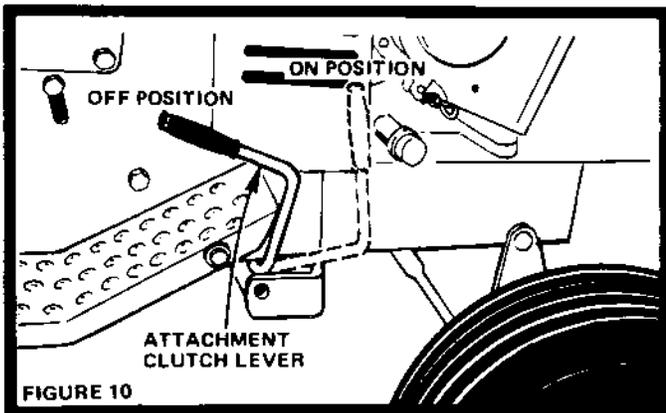


FIGURE 10

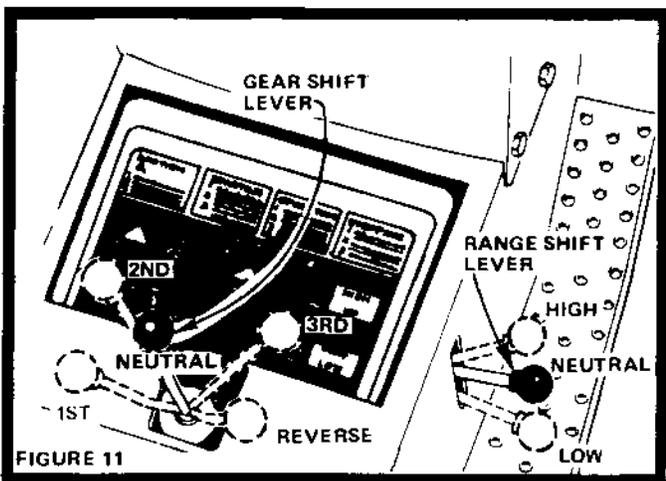


FIGURE 11

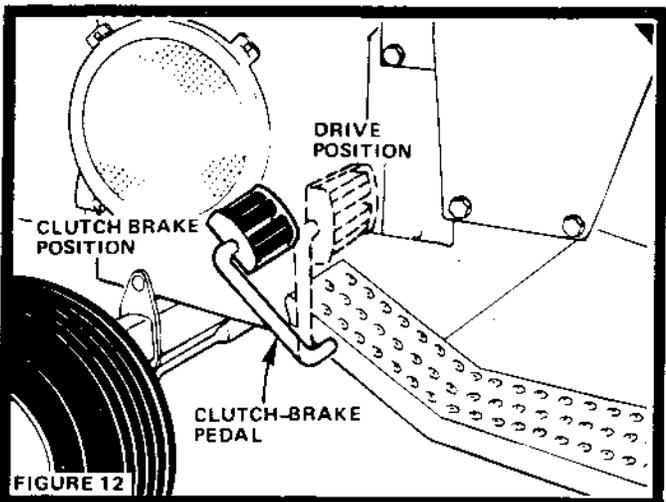


FIGURE 12

OPERATION

STARTING THE ENGINE

1. Place Parking Brake Lever in locked position (Fig. 9).
2. Place Attachment Clutch Lever in "OFF" position (Fig. 10).
3. Place Gear Shift Lever in neutral "N" position (Fig. 11).
4. Move Range Shift Lever to "N" neutral position (Fig. 11).
5. Push Clutch-Brake Pedal into brake position (Fig. 12).
6. Move Throttle Control Lever to middle position (Fig. 13).
7. Pull Choke out (Fig. 13).
8. Turn Ignition Key to "START" position until Engine starts (Fig. 13). Release key into "ON" position.

NOTE: DO NOT RUN STARTER CONTINUOUSLY FOR MORE THAN THIRTY SECONDS AT A TIME. If engine does not start after several attempts, move throttle Control Lever to "FAST" position, wait a few minutes, and try again.

NOTE: The Electric Lift Switch (Fig. 13) raises or lowers an attachment when used with a Three Point Hitch (optional equipment).

WARMING UP THE ENGINE

Move Throttle Control Lever to slow position. Push Choke in as engine warms. **NOTE:** ALLOW ENGINE TO WARM UP FOR A FEW MINUTES BEFORE OPERATING.

When restarting a warm engine, move Throttle Control Lever to middle position, Choke may not have to be used.

ALWAYS WEAR SUBSTANTIAL FOOTWEAR AND AVOID LOOSE FITTING CLOTHING THAT COULD GET CAUGHT IN MOVING PARTS.



LEARN TO START, STOP AND REVERSE YOUR TRACTOR IN A LARGE, OPEN SPACE.

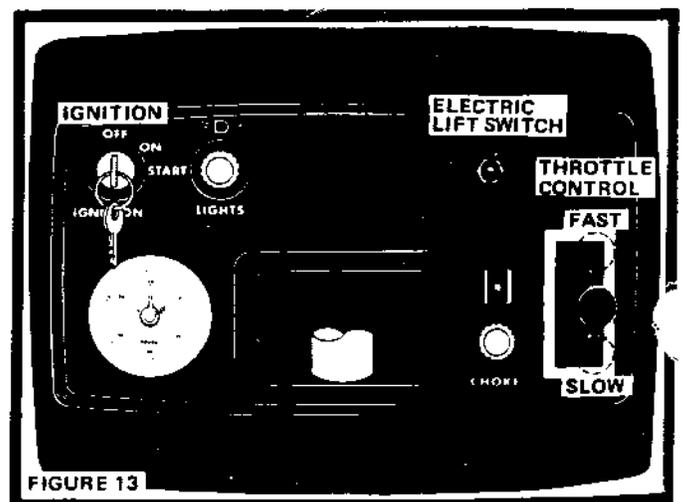


FIGURE 13

TRACTOR OPERATION

1. With engine running and warm, place Throttle Lever in middle position.
2. Push Clutch-Brake Pedal down to brake position.
3. Move Gear Shift Lever to "2ND" and Range Shift Lever to "LOW".
4. Release Parking Brake.
5. Release Clutch-Brake Pedal SLOWLY to start forward movement.
6. If ground travel is too slow move Throttle Lever to fast position or press Clutch-Brake pedal and shift to a different gear. NOTE: ALWAYS SELECT A GROUND TRAVEL SPEED THAT WILL SUIT THE TERRAIN AND THE ATTACHMENT BEING USED.

BRING TRACTOR TO COMPLETE STOP BEFORE SHIFTING GEARS.



NEVER PLACE YOUR HANDS OR FEET IN OR UNDER ANY POWERED ATTACHMENT OR NEAR ANY MOVING PART WHILE TRACTOR OR ANY POWERED ATTACHMENT IS RUNNING.

STOPPING YOUR TRACTOR

1. Reduce Throttle Lever to "SLOW" position.
2. Push Clutch-Brake Pedal into Brake position.
3. Release Attachment Clutch.
4. Move Gear Shift Lever to neutral "N".
5. Place Parking Brake in "LOCK" position.
6. Release Clutch-Brake Pedal.



MAKE SURE PARKING BRAKE WILL HOLD TRACTOR SECURE.

7. Turn Ignition Key to "OFF" position.



REMOVE KEY WHEN LEAVING TRACTOR TO PREVENT UNAUTHORIZED USE.

TRANSPORTING YOUR TRACTOR

For pushing or towing your tractor, place Gear Shift Lever and Range Shift Lever in neutral position (Fig. 11). NOTE: DO NOT TOW YOUR TRACTOR FASTER THAN SIX MILES PER HOUR.

TRACTOR OPERATION ON HILLS

1. Choose one of the lowest gears BEFORE starting up or down hills.



DO NOT DRIVE UP OR DOWN HILLS WITH SLOPES GREATER THAN 15°, AND DO NOT DRIVE ACROSS ANY SLOPE.

2. Avoid shifting or stopping on hills.
 - a. If slowing is necessary, move Throttle Control to middle position.
 - b. If stopping is necessary, push Clutch-Brake Pedal quickly to brake position to prevent rolling.
 - c. Engage Parking Brake and shift to lowest speed range.
 - d. Partially release Clutch-Brake Pedal (until forward movement begins).
 - e. Release Parking Brake.
 - f. Completely release Clutch-Brake Pedal.
3. Make all turns gradually.

STARTING YOUR TRACTOR WITH A LOW BATTERY

If your Battery is too low to start the engine, it should be recharged. If "Jumper Cables" are used for emergency starting follow this procedure: NOTE: YOUR TRACTOR IS EQUIPPED WITH A 12 VOLT NEGATIVE GROUNDED SYSTEM. THE OTHER VEHICLE MUST ALSO BE A 12 VOLT NEGATIVE GROUNDED SYSTEM.



LEAD-ACID BATTERIES GENERATE EXPLOSIVE GASSES. KEEP SPARKS, FLAME, AND SMOKING MATERIALS AWAY FROM BATTERIES. ALWAYS SHIELD EYES AROUND BATTERIES.

1. Connect each end of the RED cable to the POSITIVE (+) terminals of each battery (taking care not to short against chassis).
2. Connect one end of the BLACK cable to the NEGATIVE (-) terminal of "GOOD" battery.
3. Connect the other end of the cable to ENGINE BLOCK or good CHASSIS GROUND on tractor (away from Gas Tank or Battery).
4. Disconnect cables in reverse order:
 - a. Engine Block or chassis
 - b. Negative terminal of "GOOD" battery
 - c. Positive terminals



DO NOT USE YOUR TRACTOR BATTERY TO START OTHER VEHICLES.

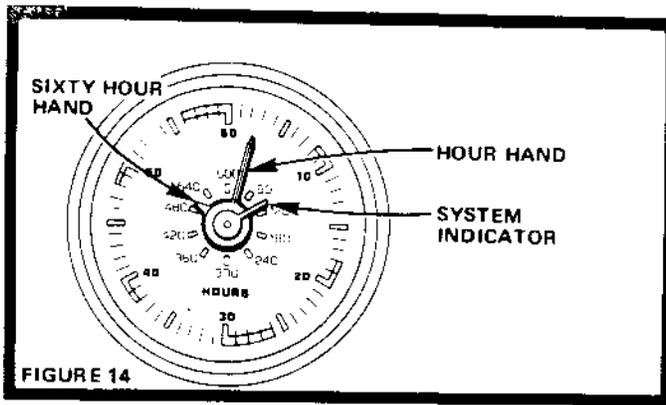


FIGURE 14

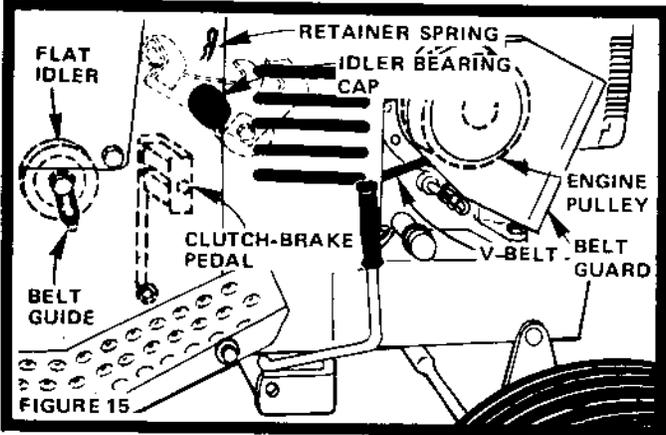


FIGURE 15

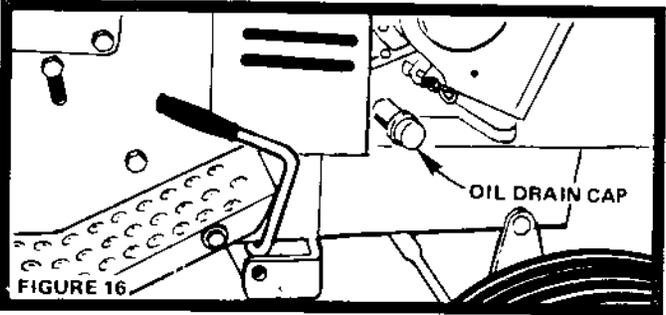


FIGURE 16

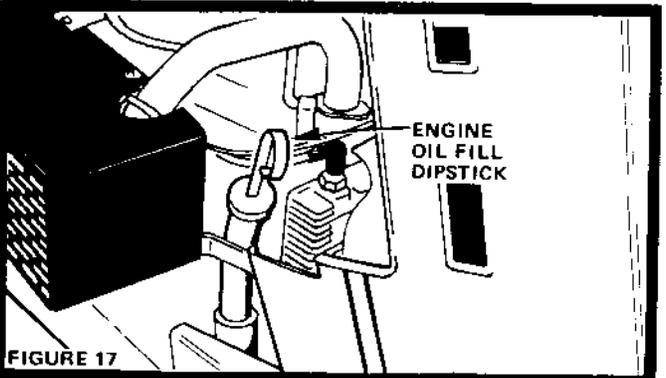


FIGURE 17

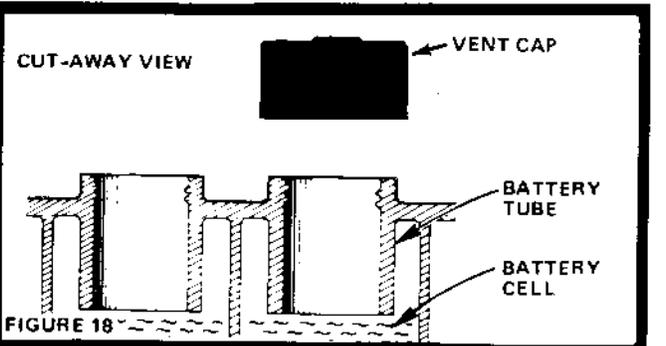


FIGURE 18

MAINTENANCE

To keep your tractor running better, longer; perform necessary service using the following Maintenance Schedule and the Service Hour Meter (Fig. 14) on the tractor dash. The Service Hour Meter records the number of hours of tractor operation. Read the Hour Hand on the outer dial; e mark indicating one hour of operation. Read the Sixty ' Hand on the inner dial; each mark indicating sixty hour operation. The System Indicator moves visibly when the Ignition Key is in the "ON" position, indicating the system operational.



DISCONNECT SPARK PLUG WIRES TO PREVENT ACCIDENTAL STARTING BEFORE MAKING ANY INSPECTION, ADJUSTMENT (EXCEPT CARBURETOR) OR REPAIR.

FIRST 2 HOURS:

1. CHECK V-BELT TENSION

- A new V-Belt may stretch after the first few hours of operation. If Clutch-Brake Pedal, in drive position (Fig. 15), is considerably to the front or rear of the vertical position, the V-Belt is out of adjustment and must be re-tensioned.
- Secure Clutch-Brake pedal in brake position (relaxing V-Belt tension) by tying to front axle.
 - Hold Nut on inside of Flat Idler and loosen Flat Idler Bolt.
 - Move Flat Idler in frame slot 1/4 inch down (to tighten), up (to loosen) V-Belt tension. Tighten Bolt.
 - Release Clutch-Brake Pedal. It should return to approximately vertical position.



CHECK TO MAKE SURE TRACTOR DOES NOT START WITHOUT FULLY DEPRESSING CLUTCH-BRAKE PEDAL.

NOTE: FOR LONGER V-BELT LIFE, ALWAYS KEPT BELT TENSIONED PROPERLY, START TRACTOR MOVEMENT WITH THROTTLE CONTROL IN MIDDLE POSITION, AND ALWAYS REPLACE WITH SEARS V-BELTS.

2. CHANGE ENGINE OIL

- Changing Oil after the first two hours will help eliminate break-in residue which might be damaging to your Engine.
- Note: Be careful not to allow dirt to enter the Engine when changing oil.
- Drain Oil with Engine warm. Unscrew Oil Drain Cap (Fig. 16) and catch Oil in a suitable container. Replace Cap.
 - Refill Engine Oil (Fig. 17). In summer use S.A.E. 30 (SC, SD or SE) Oil. In winter (below 32°F.) use S.A.E. 10W30 (SC, SD or SE) or 10W40 (SC, SD or SE). In extreme cold (below 0°F.) use S.A.E. 5W20 (SC, SD or SE). Capacity is 3 - 1/2 pints without Oil Cartridge change. NOTE: DO NOT OVERFILL.

FREQUENTLY:

1. CHECK BATTERY

- Electrolyte solution level in each Battery Cell should be even with bottoms of tubes in cells (Fig. 18). Add distilled water if necessary. NOTE: DO NOT OVERFILL.
- Keep Battery and Terminals clean. Refer to page 10.
- Keep Battery bolts tight.
- Keep Vent Caps tight and small Vent holes in caps open.
- Recharge SLOWLY at 3 amperes if specific gravity electrolyte falls below 1.225.

2. CHECK TIRE PRESSURE

Tire pressure in front and rear Tires should be 12 pounds.

3. CLEAN AIR SCREEN

Air Screen and Guard (Fig. 21) must be kept free of dirt and chaff to prevent Engine damage from overheating.

EVERY 5 HOURS:

1. CHECK ENGINE OIL LEVEL



DO NOT CHECK ENGINE OIL LEVEL WITH ENGINE RUNNING.

Several minutes after stopping Engine, check Engine Oil Level with Tractor on level ground. Wipe dipstick (Fig. 17) clean, push it down tight for a few seconds, remove and read Oil Level. If necessary, add Oil until "FULL" mark is reached. In summer use S.A.E. 30 (SC, SD or SE) Oil. In winter (below 32°F.) use S.A.E. 10W30 (SC, SD or SE) or 10W40 (SC, SD or SE). In extreme cold (below 0°F.) use S.A.E. 5W20 (SC, SD or SE). NOTE: DO NOT OVER-FILL.

2. LUBRICATE STEERING AND FRONT WHEELS

There are six Grease Fittings on your Tractor (Fig. 19). Using a Grease Gun, give each Grease Fitting two shots of Extreme Pressure Lubricating Grease Amdex No. 1 (Available at your local Sears Service Center).

3. OIL PIVOT POINTS

Place several drops of SAE 30 Oil at points where parts move against each other, especially:

- a. Idler Bearing (Fig. 15)
 - Remove Plastic Cap.
 - Remove Retainer Spring from Idler Shaft.
 - Move Idler and Shaft outward and lubricate exposed Shaft.
 - Return Idler and Shaft to original position, replace Retainer Spring, and reposition Cap.
- b. Front Axle Pivot (Fig. 19)

EVERY 25 HOURS: (EVERY 15 HOURS IF OPERATING IN VERY DUSTY CONDITIONS)

1. CLEAN AIR FILTER & FOAM PRE-CLEANER

- a. Unscrew Wing Nut (Fig. 20) to remove Air Filter Cover, Paper Air Filter Element and Foam Pre-Cleaner.
 - b. Clean dust from Paper Air Filter Element by gently tapping Element on a flat surface.
 - c. Wash Foam Pre-Cleaner in detergent and water.
 - d. Rinse, squeeze (rather than twist) and allow to dry thoroughly.
 - e. Coat with three tablespoons of S.A.E. 30 Engine Oil, knead to distribute evenly, and squeeze out excess.
 - f. Check Paper Air Filter Element. Replace if excessively dirty.
 - g. Re-Assemble Air Filter and re-position on Tractor.
- NOTE: NEVER RUN ENGINE WITH AIR CLEANER REMOVED.

2. CLEAN AIR SCREEN

Air Screen and Guard (Fig. 21) must allow free-flow of air to prevent Engine damage from overheating. Remove Air Screen and Guard and clean with a wire brush to remove dirt and chaff and stubborn dried gum and fibers.

3. CHANGE ENGINE OIL

The best time to change Engine Oil is at the end of a days operation when all dirt and foreign material is suspended in the hot Oil. Refer to page 6.

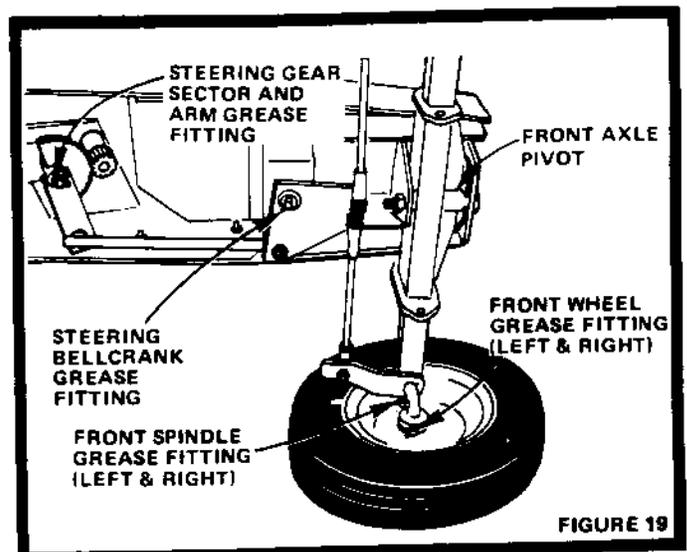


FIGURE 19

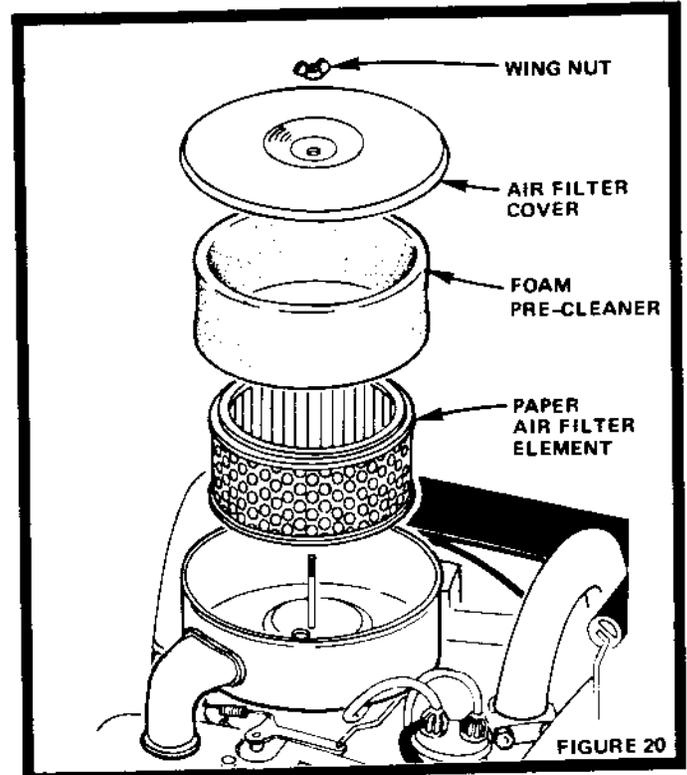


FIGURE 20

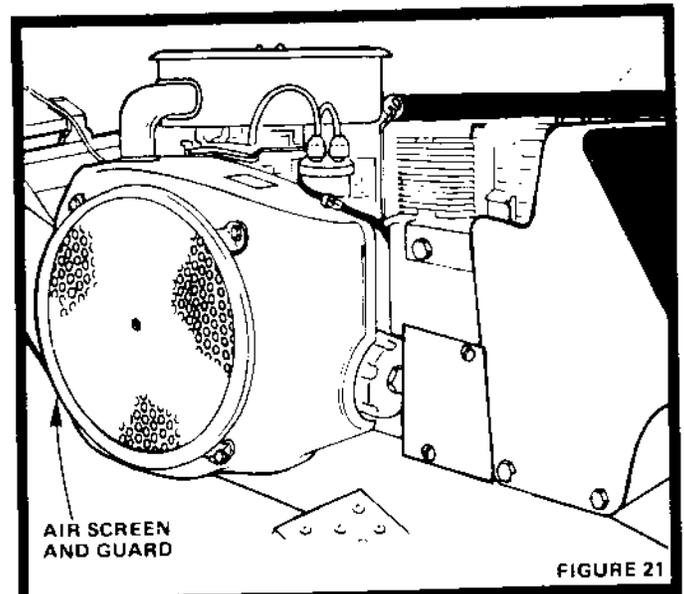
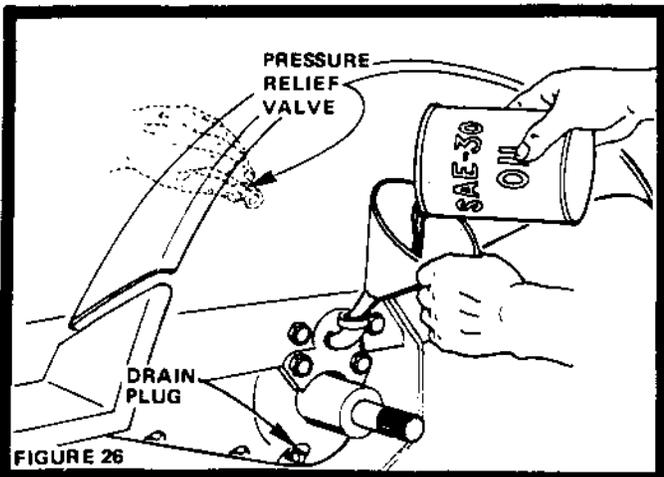
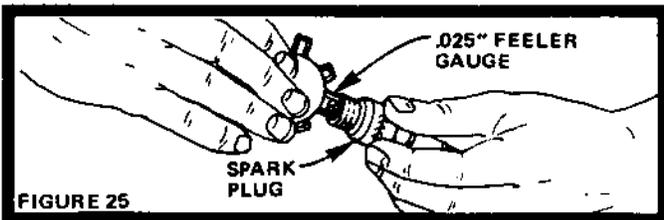
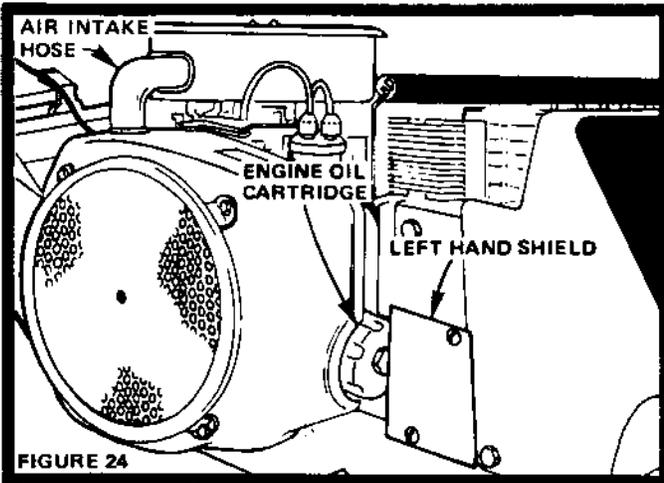
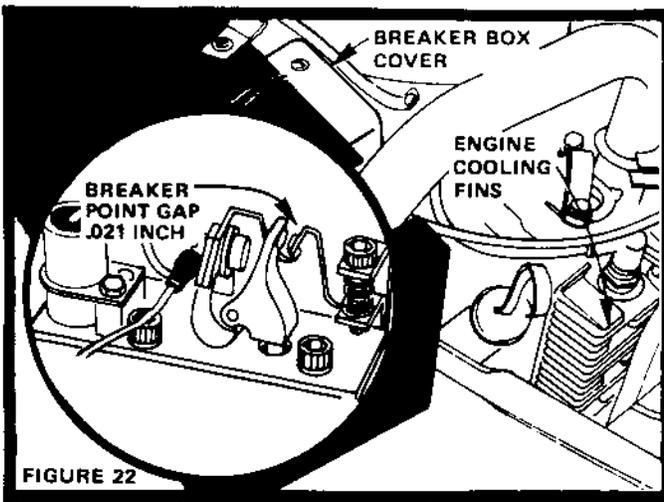


FIGURE 21



EVERY 50 HOURS:

1. CLEAN ENGINE COOLING FINS

Remove any dust, dirt or oil from Engine Cooling Fins (Fig. 22) to prevent Engine damage from overheating.

2. CHECK TRANSAXLE OIL LEVEL

- Block up Rear Axle securely or use a Sears Tractor Jack. Remove Left rear wheel by removing E-Ring.
- Remove Filler Plug (Fig. 23) from Transaxle. Oil Level should be even with Filler Plug threads. Add S.A.E. 30 Motor Oil if necessary.
- Check Pressure Relief Valve located on R.H. side near top (Fig. 26). It should spring completely closed when pulled out by hand.
- Reposition wheel. Secure with E-Ring.

3. REPLACE ENGINE OIL CARTRIDGE

- Drain Engine Oil. Refer to page 6.
- Remove Left Hand Shield (Fig. 24).
- Turn 1" Hex on Cartridge end to remove and replace Oil Cartridge (1/2 turn beyond point of contact). NOTE: DO NOT OVERTIGHTEN.
- Refill engine oil. Refer to page 6. Capacity is 4 pints with Oil Cartridge change. NOTE: DO NOT OVERFILL.

EVERY 100 HOURS:

1. CLEAN SPARK PLUGS AND RESET GAP

Wire brush carbon deposits from Spark Plug Electrodes and reset gap at .025 inch. (Fig. 25). Replace Spark Plugs if they show signs of fouling or electrode erosion.

2. CHECK BREAKER POINTS

Replace Points if they are pitted or burned.

- Remove Air Intake Hose that connects to Blower Housing (Fig. 24). This provides an access to view Timing Mark.
- Remove Spark Plugs and Belt Guard and turn Engine Pulley (Fig. 15) clockwise by hand until 21°BTC mark on gear cover aligns with mark on flywheel. Turn another 1/4 turn to ensure points are fully open.
- Remove Breaker Box Cover (Fig. 22) by loosening Screw, and lift off to remove.
- Replace Points, if necessary.
- Using an Allen Head Wrench, adjust Set Screw for .021 inch between Points. Measure Point Gap with a Flat Feeler Gauge. NOTE: MAKE SURE FEELER GAUGE IS CLEAN AND FREE OF GREASE, OIL, OR DIRT. No other adjustment or alignment is necessary. Setting point gap accurately adjusts Engine Timing.
- Replace Breaker Box Cover, Spark Plugs and Cables and Air Intake Hose.

3. LUBRICATE BALL JOINTS

- Move Rubber Boots to expose Ball Joints on Tie Rods and Steering Link (Fig. 28).
- Coat Ball Joints with Silicone Spray Lubricant.
- Reposition Rubber Boots.

EVERY 200 HOURS:

1. REPLACE PAPER AIR FILTER ELEMENT

Refer to page 7.

2. REPLACE BREAKER POINTS

Refer to step 2, above.

EVERY 480 HOURS: CHANGE TRANSAXLE OIL

- Block up Rear Axle securely or use a Sears Tractor Jack. Remove Left Rear Wheel by removing E-Ring.
- Drain Transaxle Oil by removing Drain Plug (Fig. 26) and catching Oil in suitable container. Replace Drain Plug.
- Refill Transaxle with S.A.E. 30 Motor Oil. Capacity is 4 quarts. Pressure Relief Valve located on R.H. side near top may be held open to allow Transaxle to fill more quickly.
- Check Pressure Relief Valve. It should spring completely closed when pulled out by hand and released.
- Reposition wheel. Secure with E-Ring.

AS NEEDED:

1. REPLACE IN-LINE FUEL FILTER

If fuel filter is clogged, obstructing fuel flow to carburetor, replacement is required.

- With Engine cool, remove and plug Fuel Line Sections as removed from both ends of Fuel Filter (Fig. 27).
- Place new Fuel Filter in position in Fuel Line (arrow on side of Filter in direction of fuel flow).



BE SURE THERE ARE NO FUEL LINE LEAKS AND THAT FUEL LINE IS IN PROPER POSITION IN HOSE CLAMPS.

2. TOE-IN ADJUSTMENT

If any parts in Front Axle or Steering Mechanism are being replaced, Tie Rod adjustment is required.

- Loosen Jam Nuts (Fig. 28) at each end of Tie Rod Adjustment Sleeves.
- Adjust both Tie Rods so that Tie Rod Joints measure from 10 to 10 - 1/8 inches from center to center.
- Tighten Jam Nuts, making sure Tie Rod Joints are parallel (180°) to each other. This adjustment secures proper Front Wheel Toe-in and steering operation.

3. BRAKE ADJUSTMENT

If Clutch-Brake Pedal (Fig. 29) has more than approximately 4 inches of travel from vertical to full brake position then brake adjustment is necessary.

- Loosen Jam Nut (Fig. 29) in order to turn turnbuckle clockwise (from in front of tractor) one turn at a time until Clutch-Brake Pedal regains 4 inches of travel.
- Tighten Jam Nut against Turnbuckle.

4. PARKING BRAKE ADJUSTMENT

If Parking Brake will not hold tractor, Parking Brake adjustment is necessary.

- Loosen Parking Brake Hex Nuts (Fig. 29).
- Place Parking Brake Lever in locked position.
- Hold Clutch-Brake Pedal in brake position and tighten first Hex Nut finger tight against Bushing.
- Release Clutch-Brake Pedal and turn first Hex Nut two turns more against Bushing.
- Tighten second Hex Nut against first Hex Nut.

5. CARBURETOR ADJUSTMENT

If Engine lacks power or does not idle properly, the Carburetor may need adjustment.

- Main Fuel (High Speed) Screw (Fig. 30) should not require adjustment. If resetting is necessary, turn clockwise, closing finger tight ONLY, then turn counterclockwise 1 - 1/4 turn.
- Turn Idle Adjusting Needle (Fig. 30) clockwise, closing finger tight ONLY, and then turn counterclockwise one turn.
- Start Engine and allow to warm for five minutes.
- Make final adjustments with Engine running and Gear Shift Lever in Neutral position.
 - Turn Idle Adjusting Needle counterclockwise until Engine runs "rough" then clockwise until Engine begins to miss. Return Screw to a point midway between these extremes.
 - Throttle Stop Screw (Fig. 30) should not require adjustment. If resetting is necessary, set to obtain the slowest engine speed that will allow smooth acceleration.

6. RE-TENSION V-BELT

It may be occasionally necessary to re-tension V-belt. (See page 6).



CHECK TO MAKE SURE TRACTOR DOES NOT START WITHOUT FULLY DEPRESSING CLUTCH-BRAKE PEDAL.

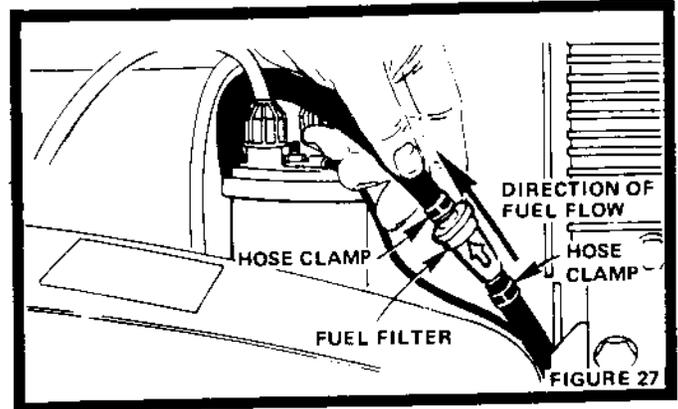


FIGURE 27

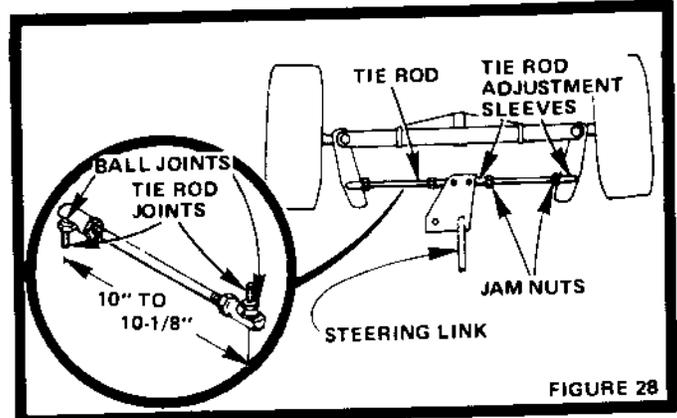


FIGURE 28

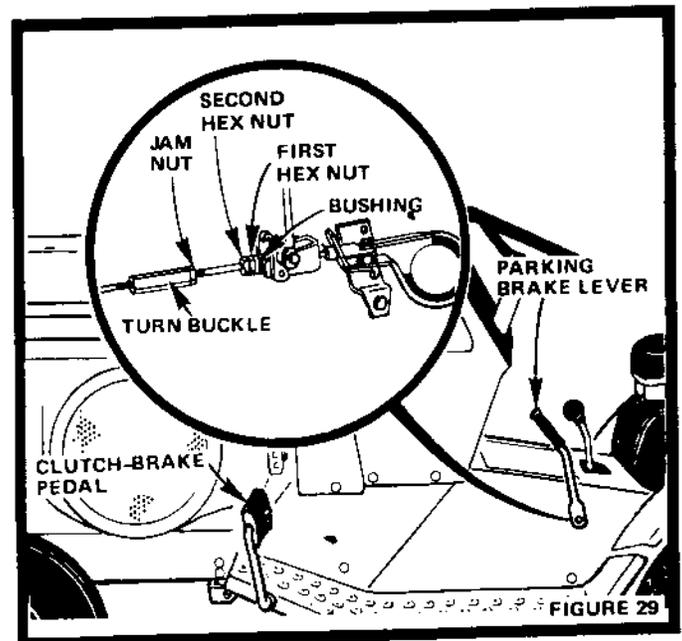


FIGURE 29

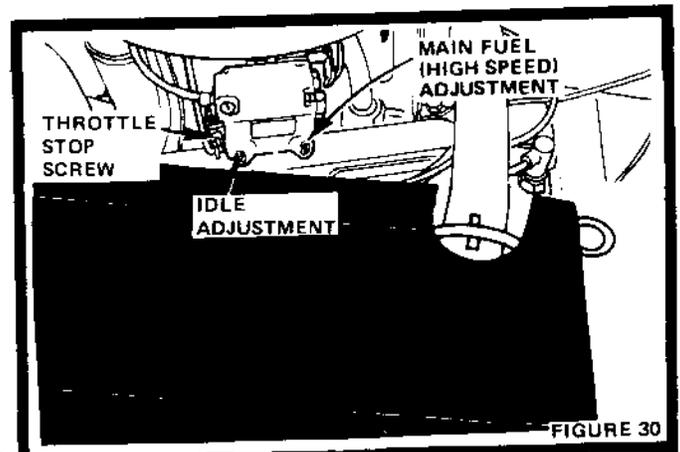


FIGURE 30

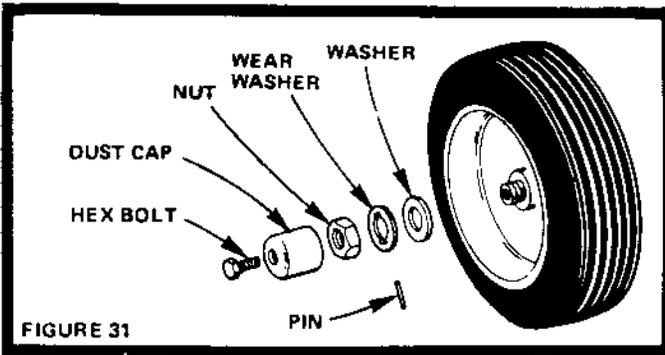


FIGURE 31

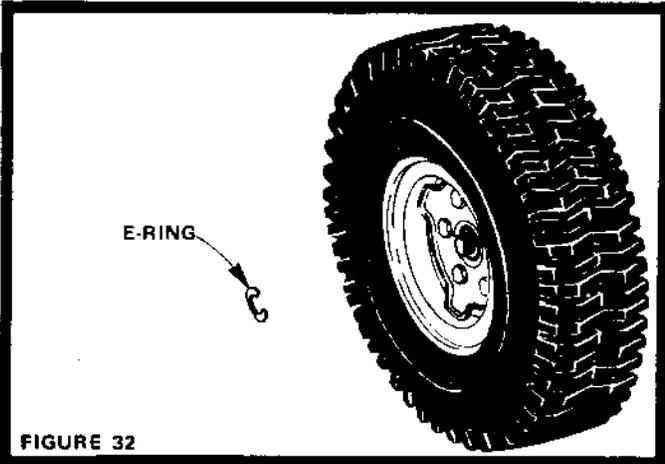


FIGURE 32

7. CLEAN BATTERY AND TERMINALS

Corrosion and dirt on the Battery and Terminals cause the Battery to "leak" power and hinders the operation of the charger.

- a. Remove the Battery from the Tractor and wash with four tablespoons of baking soda to one gallon of water. **NOTE: BE CAREFUL NOT TO GET THE SOLUTION INTO THE CELLS.** Rinse the Battery with plain water, dry and reinstall on Tractor.
- b. Clean terminals with a wire brush until bright. Replace Battery Cables. Coat terminal connections with Vaseline.

8. TIRE CARE

- a. Maintain tire pressure in front and rear tires of 12 pounds.
- b. Keep tires free of gasoline, oil, or insect control chemicals which can destroy rubber.
- c. Avoid stumps, stones, deep ruts and other hazards that may cause tire damage.
- d. Removing front wheel for tire repair (Fig. 31).
 - Block up front axle securely or use a Sears Tractor Jack.
 - Remove Hex Bolt and Dust Cap.
 - Remove Nut, Wear Washer, Pin and Washer to allow wheel removal.
 - Repair tire and reassemble.
- e. Removing rear wheel for tire repair (Fig. 32):
 - Block up rear axle securely or use a Sears Tractor Jack.
 - Remove E-Ring to allow wheel removal.
 - Repair tire and reassemble. Snap E-Ring securely in axle groove.

9. FINISH

Keep tractor finish free of gasoline, oil, insect chemicals or battery electrolyte. Protect painted surfaces with Automotive type wax.

| SERVICE RECORD | SERVICE DATES | | | | | |
|-----------------------------------------------|---------------|---------------|----------------|----------------|-----------------|-----------------|
| | FREQUENTLY | EVERY 5 HOURS | EVERY 25 HOURS | EVERY 50 HOURS | EVERY 100 HOURS | EVERY 200 HOURS |
| FILL IN DATES AS YOU COMPLETE REGULAR SERVICE | | | | | | |
| Check Engine Oil Level | / | / | / | / | / | / |
| Change Engine Oil | | / | / | / | / | / |
| Replace Engine Oil Cartridge | | | / | / | / | / |
| Oil Pivot Points | / | / | / | / | / | / |
| Lubricate Front Wheels & Steering | / | / | / | / | / | / |
| Check Transaxle Oil Level | | | / | / | / | / |
| Change Transaxle Oil | | | | / | / | / |
| Clean Air Screen | / | / | / | / | / | / |
| Clean Air Filter & Foam Pre-Cleaner | | / | / | / | / | / |
| Replace Paper Air Filter Element | | | | / | / | / |
| Clean Engine Cooling Fins | | | / | / | / | / |
| Clean Spark Plugs & Reset Gap | | | | / | / | / |
| Check Breaker Points | | | | / | / | / |
| Replace Breaker Points | | | | / | / | / |
| Check Battery Levels | / | / | / | / | / | / |
| Check Tire Pressure | / | / | / | / | / | / |

TROUBLE SHOOTING

| POSSIBLE CAUSE | POSSIBLE REMEDY |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| WILL NOT START Clutch-Brake Pedal in drive position Attachment Clutch Lever in "ON" position No gasoline in Fuel Tank, clogged Fuel Filter or Fuel Line Blown Fuse Dead Battery | Press Pedal into brake position Move Lever to "OFF" position Fill Tank with Gasoline. Check Fuel Line, Fuel Filter and Carburetor (clean if necessary) Check for fault and replace Fuse Recharge or replace Battery |
| HARD TO START Choked improperly, flooded Engine Clogged Fuel Filter Clogged Fuel Tank Dirty Air Cleaner Spark Plugs dirty or improper gap Defective Battery Defective Ignition or loose wiring Water in gasoline or old fuel Improper Carburetor adjustment | Push Choke in, place Throttle Control in middle position and run starter several times to clear out gas Remove and replace Remove and clean Remove and clean Clean, adjust gap or replace Recharge or replace Check the wiring and Spark Plugs Drain Fuel Tank and Carburetor, use fresh fuel and clean Spark Plugs Make necessary adjustments |
| ENGINE MISSES OR LACKS POWER Engine overload Clogged Fuel Filter Clogged Fuel Tank Partially plugged Air Cleaner Improper Carburetor adjustment Dirty Air Screen Low oil level or dirty oil Spark Plugs dirty, improper gap or wrong type Faulty ignition Poor compression Oil in gasoline | Shift to a lower gear or reduce load Remove and replace Remove and clean Remove and clean Make necessary adjustments Clean Air Screen and Cylinder Fins Add or change oil Clean, reset gap or replace Check Spark Plugs and for loose wires Major Engine overhaul Drain and refill Gas Tank and Carburetor |
| ENGINE OVERHEATS Dirty Air Screen Low oil level or dirty oil Dirty Engine Partially plugged Muffler Partially plugged Air Cleaner Stale fuel or improper Carburetor adjustment | Clean Air Screen Add or change oil Clean Cylinder Fins Remove and clean Muffler Remove and clean Use fresh fuel and adjust Carburetor |
| NO LIGHTS No Headlights or Taillight with Light Switch Knob pulled out | Check Light Fuse under dash, replace Taillight Bulb or Sealed Beam Headlights |
| WON'T CHARGE Blown Fuse Defective Battery | Check for fault and replace Replace |

STORAGE

1. ENGINE OIL

Drain (with engine warm) and replace with clean engine oil. Refer to page 6.

2. FUEL SYSTEM

- Drain fuel tank and carburetor by allowing the engine to run out of gasoline. NOTE: GASOLINE LEFT IN YOUR ENGINE WILL LEAVE GUM DEPOSITS CLOGGING FUEL SYSTEM.
- Dispose of gasoline if not to be used. NOTE: GASOLINE STORED FOR SEVERAL MONTHS LOSES ITS VOLATILITY (ABILITY TO BURN EFFECTIVELY).

3. CYLINDER

- Remove Spark Plugs.
- Pour one ounce of oil through spark plug hole into cylinder.

- Turn ignition key to "START" position for a few seconds to distribute oil.
- Replace Spark Plugs.

4. BATTERY

- Remove battery if tractor is not used regularly during winter months. Store in cool, dry place (above 50°F). NOTE: DO NOT STORE BATTERY DIRECTLY ON CEMENT SURFACE.
- Check electrolyte charge each month and recharge if below 1.225 specific gravity. NOTE: BATTERIES NOT IN USE FOR SEVERAL MONTHS AND NOT KEPT FULLY CHARGED, PRODUCE SULPHUR DEPOSITS ON PLATES WHICH CANNOT BE REMOVED BY RECHARGING.

5. GENERAL CLEANING

- 11 - Clean engine, battery, finish, etc. of all foreign matter.

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

MAIN FRAME, DASH AND GRILL

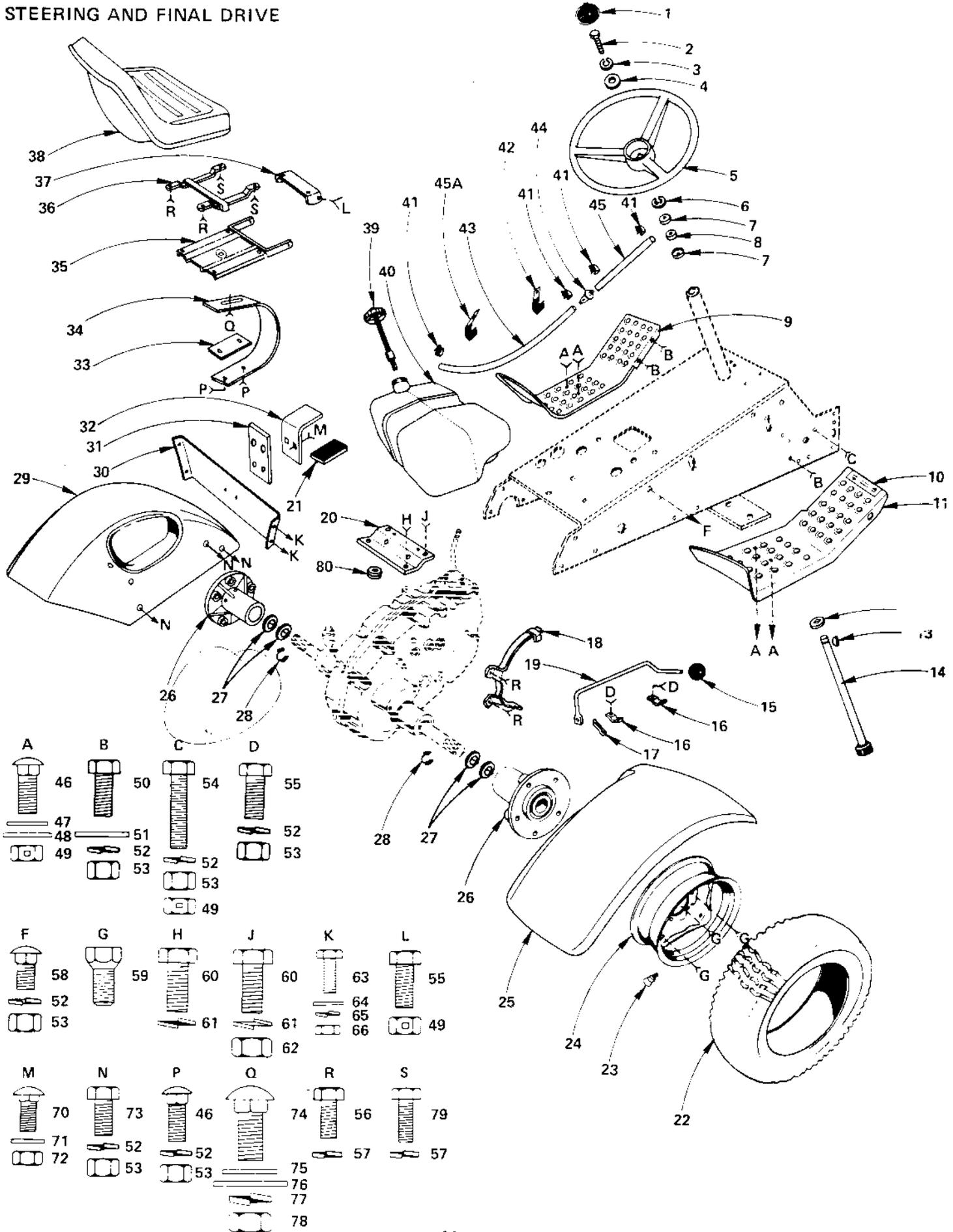
| PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION | |
|----------|-------------|-----------------------------------------|----------|-------------|-----------------------------------------|
| 1 | 2676R | | 68 | 9687R | Battery Heat Shield |
| 2 | 9410R | | 69 | 7874R | Hood Seal |
| 3 | 9409R | | 70 | 8855R | Battery Tray |
| 4 | 9852R | | 71 | 7728R | Cover-L.H. |
| 5 | 2672R | | 72 | 7732R | Bracket - Battery Support |
| 6 | 8768H | | 73 | 7835R | Bracket - Rectifier |
| 7 | 2794R | | 74 | 9598R | Decal - Hood R.H. Front |
| 8 | 7937R | | 75 | 634A551 | Hood Ass'y. |
| 9 | 7938R | | 76 | 8028R | Decal - Instruction |
| 10 | 2674R | | 77 | 9563R | Decal - Wiring |
| 11 | 2673R | | 78 | STD551025 | *Washer 9/32 x 5/8 x 16 Ga. |
| 12 | 2696R | | 79 | STD551125 | *Lockwasher 1/4 |
| 13 | 2697R | | 80 | STD541025 | *Hex Nut 1/4 - 20 UNC |
| 14 | STD541031 | *Hex Nut 5/16 - 18 UNC | 81 | 5554P | Phillips Pan Hd. Thd. Cutting Screw |
| 15 | 663A149 | Muffler Clamp (Inc. Key No. 14) | | | 10 - 16 Hi-Lo Thrd. x 1/2 |
| 16 | 8376R | Heat Shield Carburetor | 82 | STD522515 | *Hex Bolt 1/4 - 20 x 1 - 1/2 Grade 5 |
| 17 | 7742R | Muffler | 83 | 1605H | Locknut 1/4 - 20 UNC |
| 19 | 634A706 | Muffler Guard Ass'y. | 84 | STD522507 | *Hex Bolt 1/4 - 20 x 3/4 |
| 20 | STD551031 | *Washer 11/32 x 11/16 x 16 Ga. | 85 | STD523107 | *Hex Bolt 5/16 - 18 x 3/4 |
| 21 | 8058R | Grill Cable | 86 | STD551131 | *Lockwasher 5/16 |
| 22 | 7746R | Grill Brace | 87 | STD601005 | *Phillips Pan Hd. Thd. Cutting Screw |
| 23 | 634A844 | Engine, Onan 18 H.P. BG-MS3272A | | | 10 - 24 x 3/8 Type T |
| 24 | 9396E | Sq. Key 1/4 x 2 | 88 | STD601003 | *Sltd. Pan Hd. Thd. Cutting Screw |
| 25 | 8245R | Belt Retainer Finger | | | 10 - 24 x 3/8 Type 23 |
| 26 | 634A104 | Engine Pulley w/Set Screws | 89 | STD512505 | *Phillips Pan Hd. Machine Screw |
| 27 | 634A527 | Belt Guide Weldment | | | 1/4 - 20 x 1/2 |
| 28 | 8704H1 | Spacer | 90 | 3008P | Hex Bolt 5/16 - 18 x 1/2 |
| 29 | 4939M | Retainer Spring | 91 | STD551031 | *Washer 11/32 x 11/16 x 16 Ga. |
| 30 | 9011H | Belt Retainer | 92 | STD523110 | *Hex Bolt 5/16 - 18 x 1 |
| 31 | 634A659 | Belt Guard Weldment | 93 | STD541031 | *Hex Nut 5/16 - 18 UNC |
| 32 | 8238H | Split Spacer | 94 | 4540P | Hex Forged Socket Hdless. Set Screw |
| 33 | 9776H | Clip | | | 5/16 - 18 x 1/2 |
| 34 | 3531R | "J" Clip | 95 | STD523710 | *Hex Bolt 3/8 - 16 x 1 |
| 35 | 8269R | Muffler Guard Bracket | 96 | STD551137 | *Lockwasher 3/8 |
| 36 | 634A820 | Hood Latch | 97 | STD541037 | *Hex Nut 3/8 - 16 UNC |
| 37 | 8457R | Support Bumper | 98 | STD551037 | *Washer 13/32 x 13/16 x 16 Ga. |
| 38 | 634A762 | Battery Support Bracket (Inc. Key 39) | 99 | 3154P | Sl. Fil. Hd. Machine Screw |
| 39 | 7756R | Bearing | | | 1/4 - 20 x 2 - 1/4 |
| 40 | 8006R | Cap | 100 | 347H | Huglock Nut 1/4 - 20 UNC |
| 41 | 7729R | Cover - R.H. | 101 | STD523112 | *Hex Bolt 5/16 - 18 x 1 - 1/4 |
| 42 | 4379H | Handle Grip | 102 | STD533110 | *Sq. Neck Carriage Bolt 5/16 - 18 x 1 |
| 43 | 7945R | Attachment Clutch Lever | 103 | STD523712 | *Hex Bolt 3/8 - 16 x 1 - 1/4 |
| 44 | 5002P | E-Ring | 104 | 5557P | Hex Washer Hd. Thd. Cutting Screw |
| 45 | 634A785 | Hanger Weldment R.F. - Front | | | 1/4 - 20 x 1/2 Type 1 |
| 46 | 7944R | Belt Tightener Arm | 105 | 61P | Sq. Neck Carriage Bolt - Short Shoulder |
| 48 | 7810H | Locknut 3/8 - 24 UNF | | | 3/8 - 16 x 1 Gr. 5 |
| 49 | 634A814 | Hanger Weldment - Rear | 106 | 3035P | Hex Bolt 7/16 - 14 x 1 - 1/4 |
| 50 | 634A787 | Drawbar and Weldnuts | 107 | STD551143 | *Lockwasher 7/16 |
| 51 | 634A355 | Hanger Weldment - L.H. - Front | 108 | STD523707 | *Hex Bolt 3/8 - 16 x 3/4 |
| 52 | 7931R | Choke Control | 109 | 5394H | Locknut 3/8 - 16 UNC |
| 53 | 9900R | Throttle Control (Inc. Key 61, 62 & 63) | 110 | 6055P | Hex Sl. Hd. Machine Screw w/Sems |
| 55 | 9634R | Decal (Shift Pattern) | | | Int. Tooth Lockwasher 10 - 32 x 1/4 |
| 56 | 634A888 | Chassis Ass'y. (Inc. Key 57 & 58) | 111 | 53P | Sq. Neck Carriage Bolt 10 - 24 x 1/2 |
| 57 | 6468H | Bearing | 112 | 1535P | Washer 7/32 x 7/16 x 18 Ga. |
| 58 | 4766H | Bearing | 113 | STD551110 | *Lockwasher No. 10 |
| 59 | 634A749 | Engine Mount Ass'y. | 114 | STD541010 | *Hex Nut 10 - 24 UNC |
| 60 | 2665R | Grill Spacer | 115 | STD522505 | *Hex Bolt 1/4 - 20 x 1/2 |
| 61 | 9903R | Throttle Wire & Casing | 116 | STD523715 | *Hex Bolt 3/8 - 16 x 1 - 1/2 |
| 62 | 8204R | Clamp | 117 | STD541137 | *Hex Nut 3/8 - 24 UNF |
| 63 | 8203R | Throttle Control Lever | 118 | 2514P | Cotter Pin 1/4 x 1 |
| 64 | 634A874 | Dashboard (Inc. Key Nos. 66 and 67) | 119 | STD610807 | *Screw, Pan Hd. Slotted 8 x 3/4 Type AB |
| 65 | 9402R | Battery Support | 120 | STD523712 | *Hex Bolt 3/8 - 16 x 1 - 1/4 Gr. 5 |
| 66 | 1998R | Clip - Dashboard | | | |
| 67 | 8571R | Clip - Dashboard, Center | | | |

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

STEERING AND FINAL DRIVE



REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

STEERING, AND FINAL DRIVE

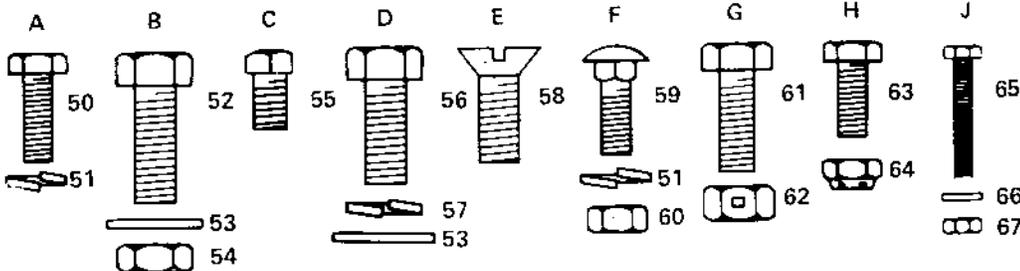
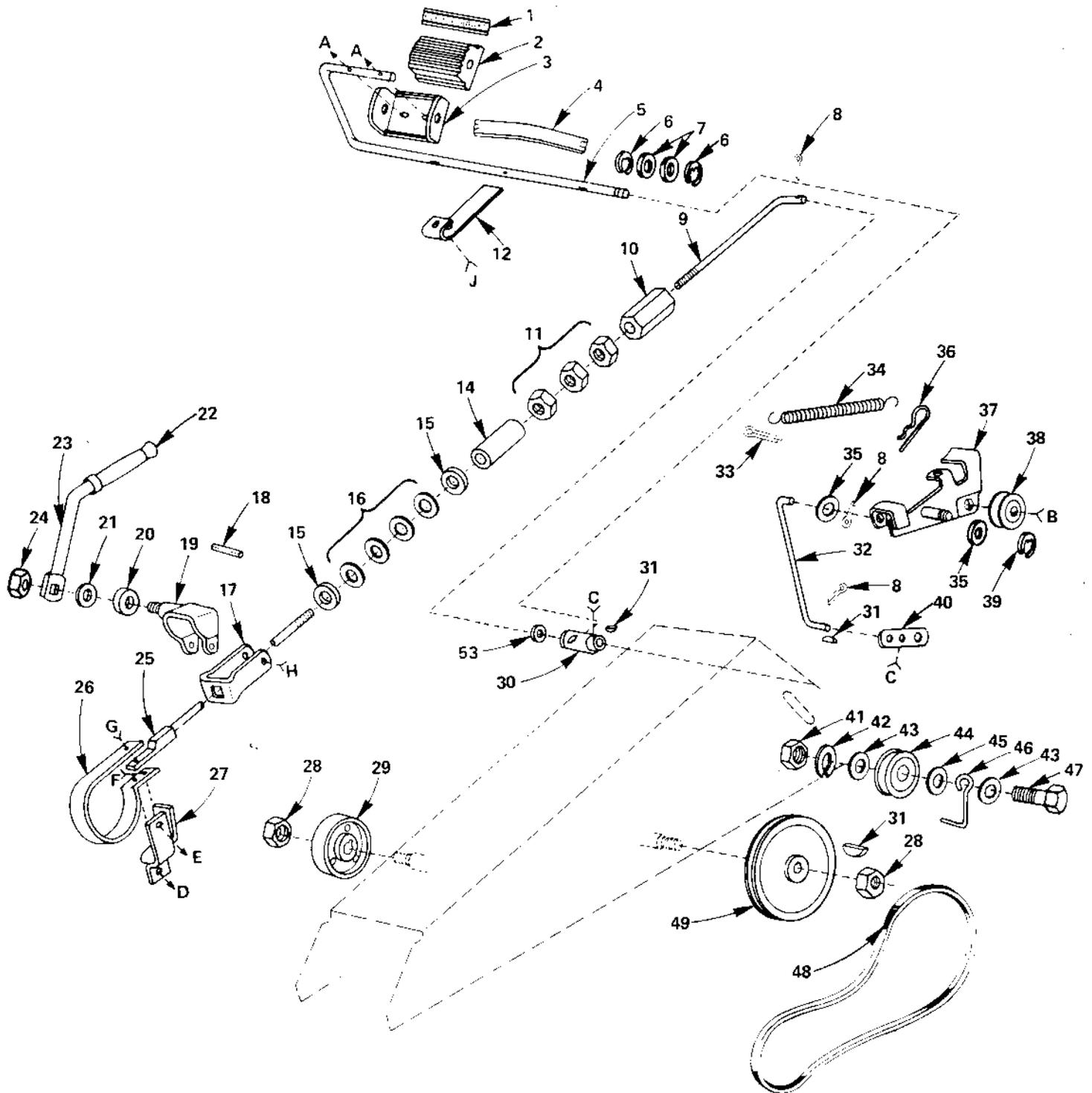
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|---------|-----------|---------------------------------|---------|-----------|--------------------------------------------------------|
| 1 | 8866R | Steering Wheel Insert | 46 | 61P | Sq. Nk. Sht. Shld. Carr. Bolt 3/8 - 16 x 1 Gr. 5 |
| 2 | STD523710 | *Hex Bolt 3/8 - 16 x 1 | 47 | STD551037 | *Washer 13/32 x 13/16 x 16 Ga. |
| 3 | STD551137 | *Lockwasher 3/8 | 48 | 1519P | Washer 15/32 x 1 x 12 Ga. |
| 4 | 1559P | Washer 7/16 x 1 x 10 Ga. | 49 | 5394H | Locknut 3/8 UNC |
| 5 | 4820R | Steering Wheel | 50 | STD523712 | *Hex Bolt 3/8 - 16 x 1 - 1/4 |
| 6 | 5003P | E-Ring | 51 | 1557P | Washer 13/32 x 13/16 x 11 Ga. |
| 7 | 9007H | Cap | 52 | STD551137 | *Lockwasher 3/8 |
| 8 | 5949H | Rubber Bushing | 53 | STD541037 | *Hex Nut 3/8 - 16 UNC |
| 9 | 7903R | Foot Rest - L.H. | 54 | STD523715 | *Hex Bolt 3/8 - 16 x 1 - 1/2 |
| 10 | 8900R | Decal (Attach. Clutch) | 55 | 3022P | Hex Bolt 3/8 - 16 x 7/8 |
| 11 | 7904R | Foot Rest - R.H. | 56 | STD523107 | *Hex Bolt 5/16 - 18 x 3/4 |
| 12 | 1553P | Washer 57/64 x 1 - 1/4 x 16 Ga. | 57 | STD551131 | *Lockwasher 5/16 |
| 13 | 9858M1 | Woodruff Key 3/16 x 5/8 | 58 | STD533707 | *Sq. Neck Carriage Bolt 3/8 - 16 x 3/4 |
| 14 | 634A626 | Steering Shaft and Pinion | 59 | 1304H | Hub Bolt |
| 15 | 7987R | Control Knob | 60 | 3034P | Hex Bolt 7/16 - 14 x 1 |
| 16 | 6442H | Shift Rod Bracket | 61 | STD551143 | *Lockwasher 7/16 |
| 17 | 2511P | Cotter Pin 3/16 x 1 | 62 | STD541043 | *Hex Nut 7/16 - 14 UNC |
| 18 | 634A22A | Belt Guide | 63 | STD522503 | *Hex Bolt 1/4 - 20 x 3/4 |
| 19 | 6477H | Range Shift Rod | 64 | STD551025 | *Washer 9/32 x 5/8 x 16 Ga. |
| 20 | 9594R | Transmission Bracket | 65 | STD551125 | *Lockwasher 1/4 |
| 21 | 8357R | Fuel Tank Pad | 66 | STD541025 | *Hex Nut 1/4 - 20 UNC |
| 22 | 8054R | Rear Tire 23 x 10.00 - 12 | 70 | STD533107 | *Short Shoulder Sq. Neck Carriage Bolt 5/16 - 18 x 3/4 |
| 23 | 795R | Tire Valve | 71 | STD551031 | *Washer 11/32 x 11/16 x 16 Ga. |
| 24 | 8658R | Rear Wheel | 72 | 1685H | Lock Nut 5/16 - 18 UNC |
| 25 | 9428R | Fender - R.H. | 73 | STD523707 | *Hex Bolt 3/8 - 16 x 3/4 |
| 26 | 634A692 | Wheel Hub - Rear | 74 | 25P | Carriage Bolt 1/2 - 13 x 1 - 1/4 Gr. 5 |
| 27 | 7563R | Axle Thrust Washer | 75 | 1578P | Washer 3/4 x 1 - 1/8 x 11 Ga. |
| 28 | 5845R | Retaining Ring | 76 | 1560P | Washer 17/32 x 1 - 1/2 x 11 Ga. |
| 29 | 9427R | Fender - L.H. | 77 | STD551150 | *Lockwasher 1/2 |
| 30 | 2656R | Bracket - Tail Light | 78 | STD541050 | *Hex Nut 1/2 - 13 UNC |
| 31 | 634A823 | Seat Stop and Bracket | 79 | STD523108 | *Hex Bolt 5/16 - 18 x 7/8 |
| 32 | 634A824 | Fuel Tank Retainer and Pads | 80 | 9547R | Rubber Grommet |
| 33 | 8141H | Seat Spring Reinforcement | --- | 9815R | Owners Manual |
| 34 | 7898R | Seat Spring | | | |
| 35 | 634A776 | Seat Plate Weldment | | | |
| 36 | 634A532 | Seat Bracket Weldment | | | |
| 37 | 7897R | Bracket, Seat Pivot | | | |
| 38 | 9545R | Seat | | | |
| 39 | 7886R | Fuel Gauge | | | |
| 40 | 7885R | Fuel Tank | | | |
| 41 | 6999R | Fuel Line Clamp | | | |
| 42 | 2751R | Clip - Fuel Line | | | |
| 43 | 7834R | Fuel Line (Long) | | | |
| 44 | 7741R | Fuel Filter | | | |
| 45 | 7833R | Fuel Line (Short) | | | |
| 45A | 9297R | Clip - Fuel Line | | | |

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

BRAKE AND CLUTCH



REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

BRAKE AND CLUTCH

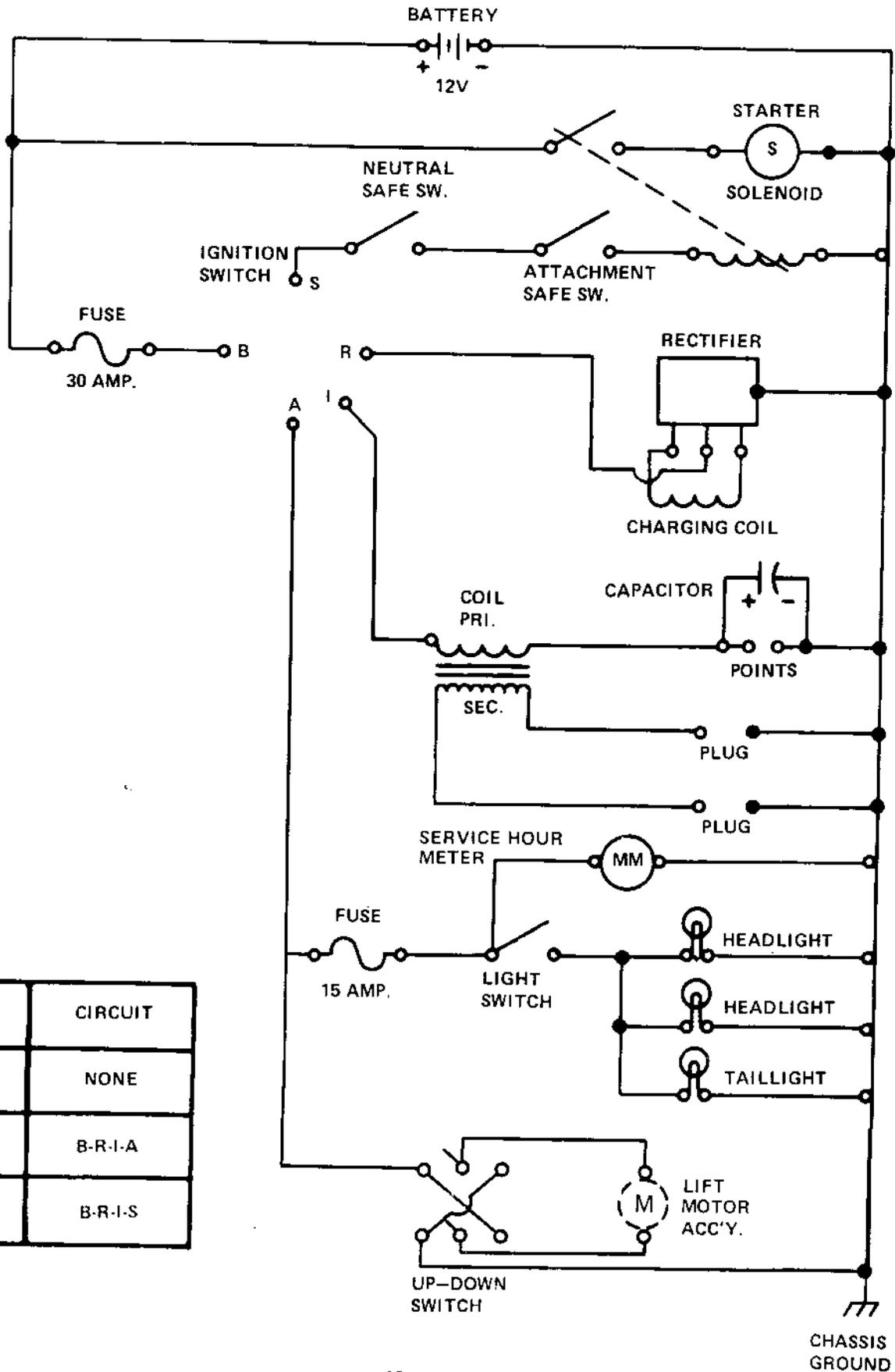
| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|-----------|------------------------------------|---------|-----------|--------------------------------------------------|
| 1 | 8899R | Clutch - Brake | 37 | 634A754 | Idler Bracket Weldment |
| 2 | 8882R | Foot Pedal | 38 | 634A86 | Idler, Bolt & Nut (Inc. Key No's. 52 & 54) |
| 3 | 8765H | Foot Pedal Bracket | 39 | 5002P | E-Ring |
| 4 | 9008H | Spring | 40 | 626A31A | Steering Arm Assembly |
| 5 | 7818R | Foot Pedal Shaft | 41 | STD541043 | *Hex Nut 7/16 - 14 UNC |
| 6 | 5001P | E-Ring | 42 | STD551143 | *Lockwasher 7/16 |
| 7 | 1527P | Washer 21/32 x 7/8 x 16 Ga. | 43 | 1518P | Washer 15/32 x 11/16 x 16 Ga. |
| 8 | 2505P | Cotter Pin 1/8 x 3/4 | 44 | 6635H | Flat Idler |
| 9 | 2202R | Brake Rod - Front | 45 | 1520P | Washer .469 I.D. x 1 - 1/8 x 11 Ga. |
| 10 | 6417H | Turnbuckle | 46 | 6479H1 | Belt Finger |
| 11 | STD541037 | *Hex Nut 3/8 - 16 UNC | 47 | 3262P | Hex Bolt 7/16 - 14 x 2 - 1/2 |
| 12 | 7823R | Safety Start Actuator | 48 | 2692R | V-Belt |
| 14 | 2201R | Bushing | 49 | 6461H2 | Pulley, Transmission |
| 15 | 1557P | Washer 13/32 x 13/16 x 11 Ga. | 50 | STD522507 | *Hex Bolt 1/4 - 20 x 3/4 |
| 16 | 2263R | Spring Washer | 51 | STD551125 | *Lockwasher 1/4 |
| 17 | 2197R | Parking Brake Yoke | 52 | STD623710 | *Fin. Hex Bolt 3/8 - 24 x 1 |
| 18 | 175H | Roll Pin | 53 | STD551037 | *Washer 13/32 x 13/16 x 16 Ga. |
| 19 | 634A489 | Lock Bracket Assembly | 54 | STD541337 | *Hex Jam Locknut 3/8 - 24 UNF |
| 20 | 2221R | Parking Brake Spacer | 55 | 4501P | Sq. Hd. Set Screw 5/16 - 18 x 1/2 |
| 21 | 5999H | Spring Washer | 56 | 3022P | Hex Bolt 3/8 - 16 x 7/8 |
| 22 | 4379H | Handle Grip | 57 | STD551137 | *Lockwasher 3/8 |
| 23 | 626A341 | Parking Lock Handle Assembly | 58 | 3164P | Flat Hd. Machine Screw - Undercut 3/8 - 16 x 3/4 |
| 24 | 7810H | Gripco Centerlock Nut 3/8 - 24 UNF | 59 | 11P | Sq. Neck Carriage Bolt 1/4 - 20 x 5/8 |
| 25 | 626A365 | Brake Rod Assembly | 60 | STD541025 | *Hex Nut 1/4 - 20 UNC |
| 26 | 634A167 | Brake Band and Lining | 61 | STD523108 | *Hex Bolt 5/16 - 18 x 7/8 |
| 27 | 634A168 | Brake Bracket Assembly | 62 | 1685H | Locknut 5/16 - 18 UNC |
| 28 | 9204H | Lock Nut 1/2 - 20 UNF | 63 | 3244P | Hex Bolt 1/4 - 28 x 5/8 Gr. 5 |
| 29 | 648H1 | Brake Drum | 64 | 9071H | Huglock Nut 1/4 - 28 UNF |
| 30 | 634A838 | Brake Arm Assembly | 65 | 3326P | Hex Hd. Mach. Screw 6 - 32 x 1 |
| 31 | 9858M1 | Woodruff Key | 66 | STD551006 | *Washer 5/32 x 3/8 x 20 Ga. |
| 32 | 9288R | Clutch Rod | 67 | 562P | Centerlock Nut 6 - 32 UNC |
| 33 | 2514P | Cotter Pin 1/4 x 1 | | | |
| 34 | 6486H | Spring | | | |
| 35 | STD551050 | *Washer 17/32 x 1 - 1/16 x 21 Ga. | | | |
| 36 | 4939M | Retainer Spring | | | |

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

SCHEMATIC DIAGRAM



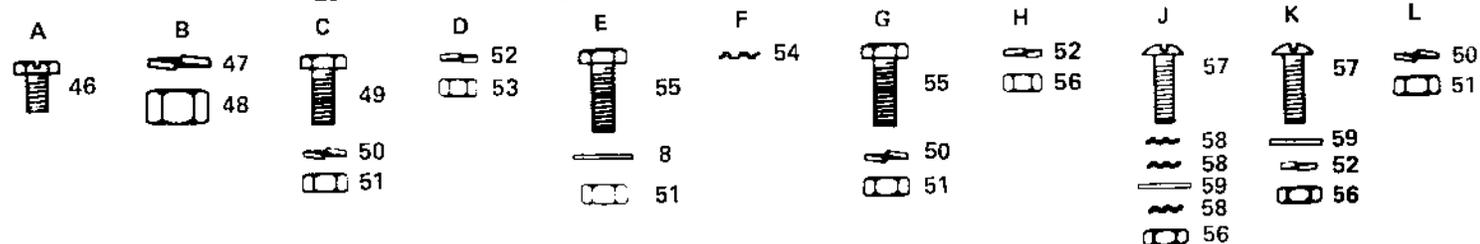
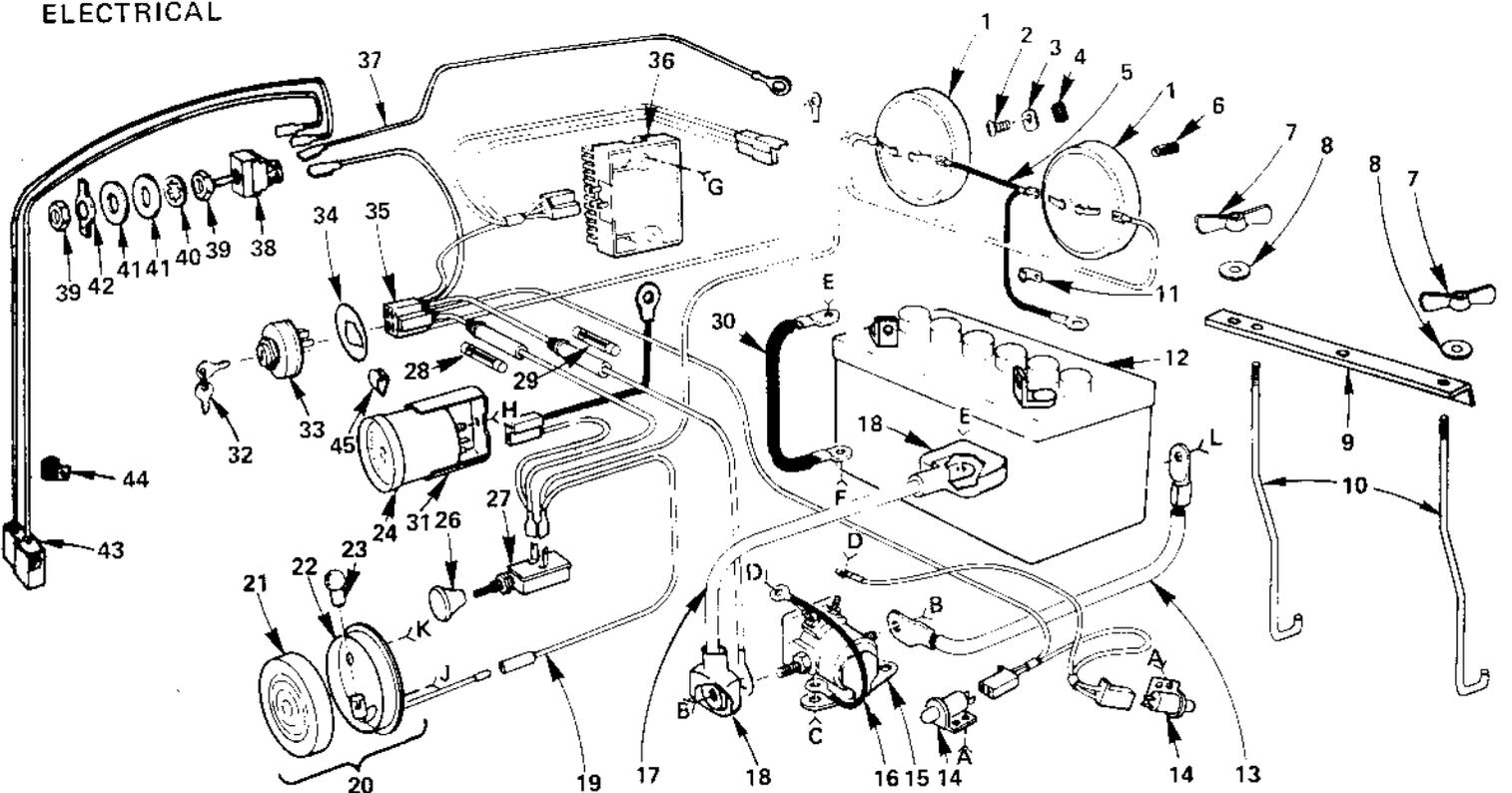
| POSITION | CIRCUIT |
|----------|---------|
| OFF | NONE |
| RUN | B-R-I-A |
| START | B-R-I-S |

another free manual from www.searstractormanuals.com

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

ELECTRICAL

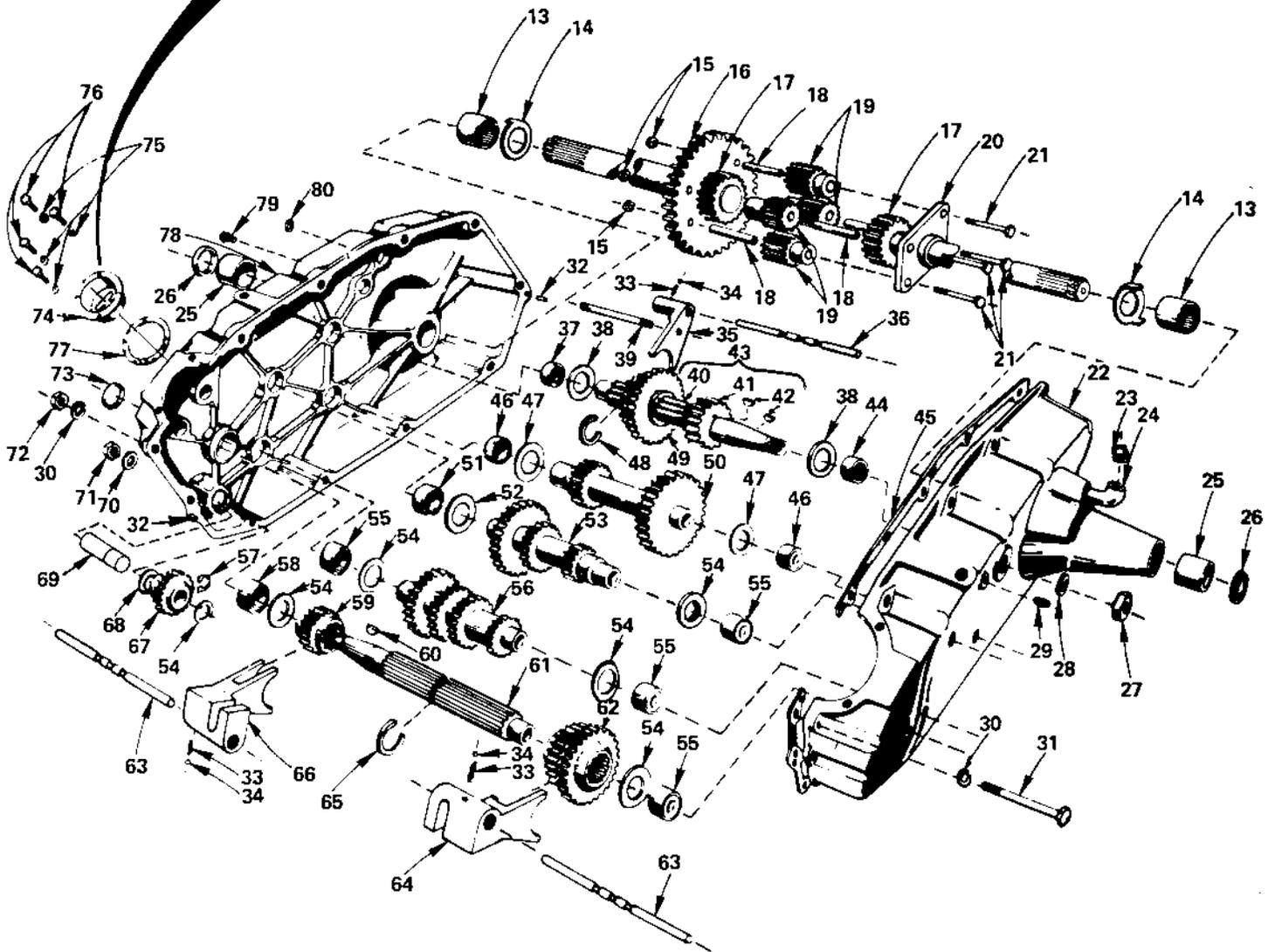
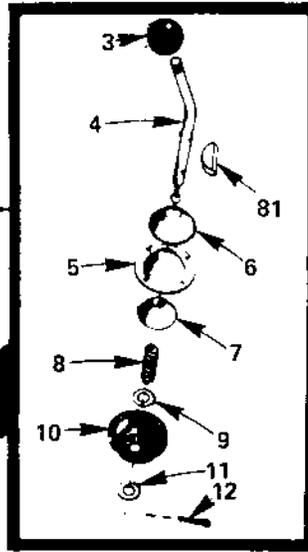
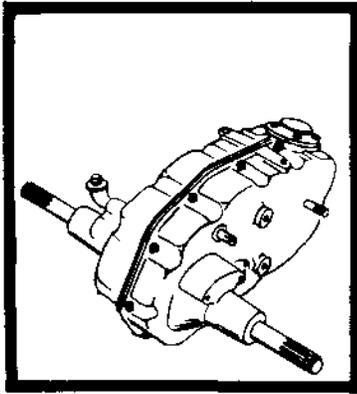


| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|-------------------------------------------------------|---------|-----------|----------------------------------------------------------------------|
| 1 | 6452R | Headlight | 32 | 7552H | Key Set |
| 2 | 5554P | Phillips Pan Hd. Thd. Cutting Screw No. 10 - 16 x 1/2 | 33 | 2683R | Ignition Switch |
| 3 | 8768H | Mounting Clip | 34 | 8656R | Terminal Identifier |
| 4 | 8784H1 | Rubber Spacer | 35 | 9565R | Wire Harness - Main |
| 5 | 8031R | Headlight Ground Wire | 36 | 7753R | Regulator - Rectifier |
| 6 | 9197H | Hose | 37 | 9698R | Wire, Ground Lift Switch |
| 7 | 3748M | Wing Nut 1/4 - 20 UNC | 38 | 8984R | Switch, Elec. Lift |
| 8 | 1509P | Washer 5/16 x 3/4 x 16 Ga. | 39 | 566P | Hex Nut, Steel 7/16 - 32 NS - 2A |
| 9 | 9400R | Battery Clamp | 40 | 7319R | Lockwasher, Internal Tooth |
| 10 | 2685R | Battery Bolt | 41 | 1518P | Washer 15/32 x 11/16 x 16 Ga. |
| 11 | 4171R | Insulated Clip | 42 | 9349R | Switch Plate |
| 12 | 8859R | Battery - "Sears Die-Hard" | 43 | 8985R | Lift Motor Harness |
| 13 | 2235R | Cable - Solenoid to Starter | 44 | 5320R | Clip, Wire |
| 14 | 7755R | Safety Switch | 45 | 8615R | Clip |
| 15 | 7754R | Solenoid | 46 | 5534P | Slotted Hex Indented Hd. Self Tapping Screw No. 10 - 24 x 3/8 Type 1 |
| 16 | 8027R | Wire - Ground to Solenoid | 47 | STD551131 | *Lockwasher 5/16 |
| 17 | 2226R | Battery Cable | 48 | STD541331 | *Hex Jam Nut 5/16 - 24 UNF |
| 18 | 8856R | Terminal Cover | 49 | STD522506 | *Hex Bolt 1/4 - 20 x 5/8 |
| 19 | 8030R | Light Harness | 50 | STD551125 | *Lockwasher 1/4 |
| 20 | 8089H | Tail Light (Inc. Key No. 21, 22, 23) | 51 | STD541025 | *Hex Nut 1/4 - 20 UNC |
| 21 | 8292H | Lens - Taillight | 52 | STD551110 | *Lockwasher No. 10 |
| 22 | 8293H | Housing - Taillight | 53 | STD541110 | *Hex Nut No. 10 - 32 UNF |
| 23 | 8291H | Bulb No. 1895 2 Candle Power | 54 | 1402P | Ext. Tooth Lockwasher 3/8 |
| 24 | 7763R | Maintenance Meter | 55 | STD522507 | *Hex Bolt 1/4 - 20 x 3/4 |
| 26 | 7794R | Light Switch Knob | 56 | STD541010 | *Hex Nut No. 10 - 24 UNC |
| 27 | 7793R | Light Switch | 57 | STD511005 | *Std. Truss Hd. Mach. Screw 10 - 24 x 1/2 |
| 28 | 2212R | Fuse - 15 Amp. | 58 | 1404P | Ext. Tooth Lockwasher No. 10 |
| 29 | 6347R | Fuse - 30 Amp. | 59 | STD551010 | *Washer 7/32 x 1/2 x 18 Ga. |
| 30 | 2753R | Battery Cable - Ground | | | |
| 31 | 8066R | Maintenance Meter Bracket | | | |

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

TRANSAXLE



REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

TRANSAXLE

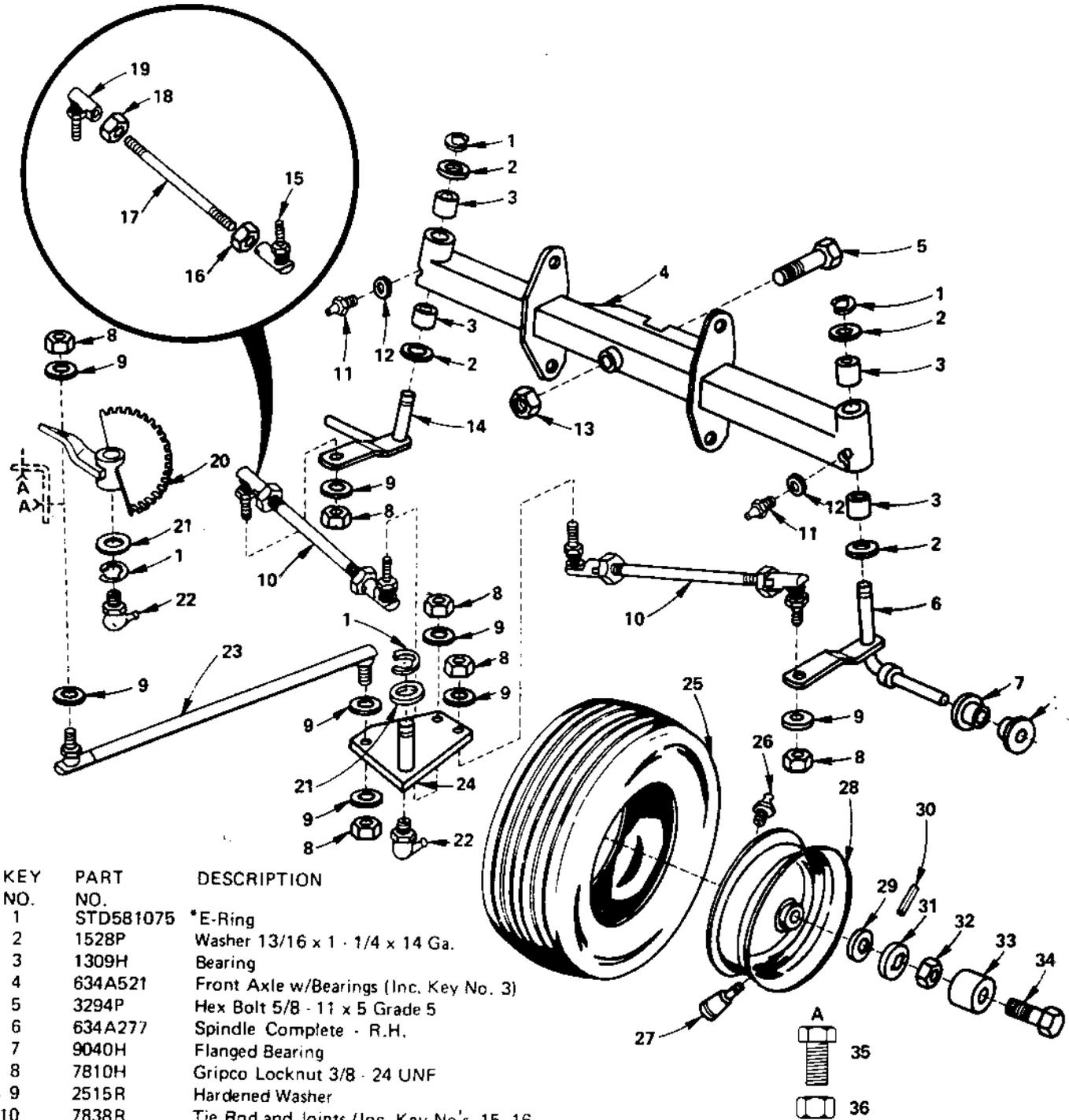
| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|-----------|------------------------------------------------------------------------------|---------|-----------|--------------------------------------------------|
| 1 | 633A92 | Transaxle Assembly Less Brake Drum & Shift Lever (Inc. Key No's. 13 thru 80) | 44 | 8119M | Needle Bearing |
| 2 | 633A82 | Gear Shift Lever Assembly (Inc. Key No's. 3 thru 12 and 81) | 45 | 6275H | Gasket - Gearcase |
| 3 | 7987R | Control Knob | 46 | 8117M | Needle Bearing |
| 4 | 9635R | Gear Shift Lever | 47 | 7396H | Thrust Bearing Race |
| 5 | 633A85 | Gear Shift Ball Cover and Pin | 48 | 6276H | Snap Ring - Crescent Type |
| 6 | 9013R | Gear Shift Cap | 49 | 633A14 | High - Low Range Gears and Hub |
| 7 | 8739H1 | Shift Lever Guide Ball | 50 | 633A33 | 4th Reduction Shaft and Gears |
| 8 | 4924H | Spring | 51 | 7398H | Needle Bearing |
| 9 | STD551043 | *Washer 15/32 x 59/64 x 16 Ga. | 52 | 7395H | Thrust Bearing Race |
| 10 | 8105R | Shift Mechanism Seal | 53 | 633A31 | 2nd Reduction Shaft and Gears |
| 11 | 1525P | Washer 9/16 x 15/16 x 11 Ga. | 54 | 1370H | Thrust Bearing Race |
| 12 | 2505P | Cotter 1/8 x 3/4 | 55 | 4895H | Needle Bearing |
| 13 | 3039R | Needle Bearing | 56 | 633A30 | Speed Change Gears and Shaft |
| 14 | 6256H | Axle Thrust Washer | 57 | 5001P | E-Ring |
| 15 | 7810H | Centerlock Gripco Nut 3/8 - 24 UNF | 58 | 4894H | Needle Bearing |
| 16 | 8662H | Final Drive Gear | 59 | 6231H | Low Speed Pinion |
| 17 | 633A73 | Axle Shaft and Gear | 60 | 9858M1 | Woodruff Key |
| 18 | 6252H1 | Bushing - Differential Pinion | 61 | 6218H | Input Shaft |
| 19 | 8657H | Differential Pinion | 62 | 633A11 | Intermediate and High Speed Pinions |
| 20 | 6263H1 | Differential Carrier | 63 | 6216H | Shift Fork Shaft |
| 21 | 3056P | Hex Bolt 3/8 - 24 x 3 - 1/4 1" Thread Length | 64 | 4219R | Shift Fork - L.H. |
| 22 | 633A89 | Gear Case and Bearings - L.H. | 65 | 4926H | Snap Ring - Crescent Type |
| 23 | 4002P | Pipe Plug 1/2 - 14 N.P.T. | 66 | 6262H | Shift Fork - R.H. |
| 24 | 4003P | 90 Street Elbow 1/2 - 14 N.P.T. | 67 | 1153R | Reverse Idler Gear |
| 25 | 9039R | Sintered Iron Bearing | 68 | 7392H | Reverse Idler Thrust Washer |
| 26 | 7393R | Oil Seal | 69 | 7384H | Reverse Idler Shaft |
| 27 | 9204H | Lock Nut | 70 | 1167R | Sealing Washer |
| 28 | 6271H | Oil Seal | 71 | 541P | Hex Jam Nut 7/16 - 20 UNF |
| 29 | 4001P | Pipe Plug 1/4 - 18 N.P.T. | 72 | STD541031 | *Hex Nut 5/16 - 18 UNC |
| 30 | 1007P | Lockwasher 5/16 Extra Heavy | 73 | 6270H | Oil Seal |
| 31 | STD523115 | *Hex Bolt 5/16 - 18 x 1 - 1/2 Gr. 5 | 74 | 633A19 | Gear Shift Gate and Reinforcement |
| 32 | 6277H | Dowel Pin | 75 | STD551131 | *Lockwasher 5/16 |
| 33 | 6272H | Spring - Shift Fork Detent | 76 | STD523108 | *Hex Bolt 5/16 - 18 x 7/8 |
| 34 | 7392M | Steel Ball | 77 | 6274H | Gasket - Shift Ball Cover |
| 35 | 6260H | Shift Fork High - Low Range | 78 | 633A90 | Gear Case, Reverse Idler Shaft and Bearings R.H. |
| 36 | 6217H | High - Low Range Shift Fork Shaft | 79 | 5855H | Pressure Relief Valve |
| 37 | 8118M | Needle Bearing | 80 | 6269H | Oil Seal |
| 38 | 6266H | Thrust Bearing Race | 81 | 7835M | Woodruff Key |
| 39 | 6215H | High - Low Range Shift Shaft | | | |
| 40 | 6221H | 3rd Reduction Gear Shaft | | | |
| 41 | 8659H | 4th Reduction Pinion | | | |
| 42 | 2228M | Woodruff Key | | | |
| 43 | 633A32 | 3rd Reduction Shaft and Gear (Inc. Key No's. 40, 41 & 42) | | | |

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

FRONT AXLE



| KEY NO. | PART NO. | DESCRIPTION |
|---------|-----------|---------------------------------------------------------|
| 1 | STD581075 | *E-Ring |
| 2 | 1528P | Washer 13/16 x 1 - 1/4 x 14 Ga. |
| 3 | 1309H | Bearing |
| 4 | 634A521 | Front Axle w/Bearings (Inc. Key No. 3) |
| 5 | 3294P | Hex Bolt 5/8 - 11 x 5 Grade 5 |
| 6 | 634A277 | Spindle Complete - R.H. |
| 7 | 9040H | Flanged Bearing |
| 8 | 7810H | Gripco Locknut 3/8 - 24 UNF |
| 9 | 2515R | Hardened Washer |
| 10 | 7838R | Tie Rod and Joints (Inc. Key No's. 15, 16, 17, 18 & 19) |
| 11 | 6855M | Grease Fitting |
| 12 | 1505P | Washer 9/32 x 1/2 x 14 Ga. |
| 13 | 4764H | Huglock Nut 5/8 x 11 UNC |
| 14 | 634A278 | Spindle Complete L.H. |
| 15 | 8515R | Tie Rod Joint (R.H. Thread) |
| 16 | STD541350 | *Hex Jam Nut 1/2 - 20 (R.H. Thread) |
| 17 | 634A819 | Tie Rod and Nuts (Inc. Key No's. 16 & 18) |
| 18 | 559P | Hex Jam Nut 1/2 - 20 (L.H. Thread) |
| 19 | 8514R | Tie Rod Joint (L.H. Thread) |
| 20 | 634A813 | Steering Gear Sector and Arm |
| 21 | 1552P | Washer 49/64 x 1 - 1/4 x 16 Ga. |
| 22 | 6842M | Grease Fitting |
| 23 | 7837R | Drag Link and Joints |
| 24 | 634A98 | Steering Bell Crank Weldment |
| 25 | 2169R | Front Tire 16 x 6.50 - 8 |

| KEY NO. | PART NO. | DESCRIPTION |
|---------|-----------|-------------------------------------|
| 26 | 6856M | Grease Fitting 1/4 - 28 Taper Thrd. |
| 27 | 795R | Tire Valve |
| 28 | 2892R | Front Wheel and Bearings |
| 29 | 1562P | Washer 25/32 x 1 - 1/2 x 16 Ga. |
| 30 | 8798H | Roll Pin 5/32 x 1 |
| 31 | 8785H | Wear Washer |
| 32 | 4831H | Elastic Nut 3/4 - 16 UNF |
| 33 | 8763H | Dust Cap-Outer |
| 34 | 3008P | Hex Bolt 5/16 - 18 x 1/2 |
| 35 | STD623710 | *Hex Bolt 3/8 - 24 x 1 |
| 36 | STD541337 | *Hex Nut 3/8 - 24 |

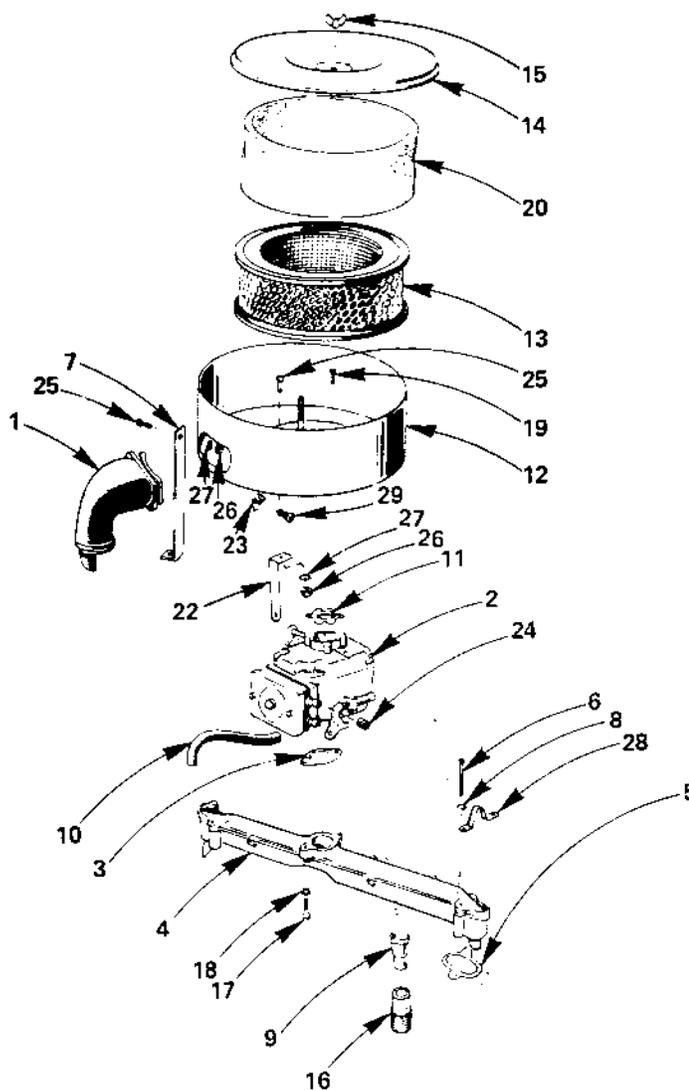
*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

FUEL SYSTEM GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A



| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|--------------------------------------------------|---------|----------|--------------------------------------------------------|
| 1 | 140-1169 | Tube, Air Intake (Air Cleaner to Blower Housing) | 15 | 865-0020 | Nut, Wing - Air Cleaner Cover (1/4 - 20) |
| 2 | 142-0568 | †Carburetor, Gasoline (With Integral Fuel Pump) | 16 | 505-0815 | Nipple, Exhaust (1 x 3") |
| 3 | 145-0438 | Gasket, Carburetor Mounting | 17 | 800-0023 | Screw, Hex Head Cap (1/4 - 20 x 1 - 3/8") |
| 4 | 154-1468 | Manifold, Intake | 18 | 850-0040 | Washer, Spring Lock (1/4") |
| 5 | 154-1744 | Gasket, Intake - Manifold | 19 | 815-0377 | Screw, Round Head with Nylon Seal (No. 10 - 32 x 3/8") |
| 6 | 800-0034 | Screw, Hex Head Cap (5/16 - 18 x 2 - 1/4") | 20 | 140-1259 | Wrapper, Air Cleaner Element |
| 7 | 140-1198 | Support, Air Cleaner | 22 | 140-1313 | Bracket, Air Cleaner Support |
| 8 | 850-0045 | Washer, Spring Lock (5/16") | 23 | 518-0328 | Clip, Bracket, Cable |
| 9 | 155-1365 | Insert, Exhaust Pipe | 24 | 149-1321 | Cap, Fuel Pump |
| 10 | 503-0740 | Hose, Fuel Pump Vacuum | 25 | 800-0003 | Screw, Hex Head Cap (1/4 - 20 x 1/2") |
| 11 | 140-1215 | Gasket, Air Cleaner Mtg. | 26 | 862-0001 | Nut, Hex - Steel (1/4 - 20) |
| 12 | 140-1213 | Housing, Air Cleaner | 27 | 853-0013 | Washer, Lock - ET (1/4") |
| 13 | 140-1216 | Element, Air Cleaner | 28 | 403-1021 | Bracket, Lifting |
| 14 | 140-1168 | Cover, Air Cleaner | 29 | 5592P | Sld. Pan Hd. Self Tap Screw Type AB No. 8 x 3/4 |

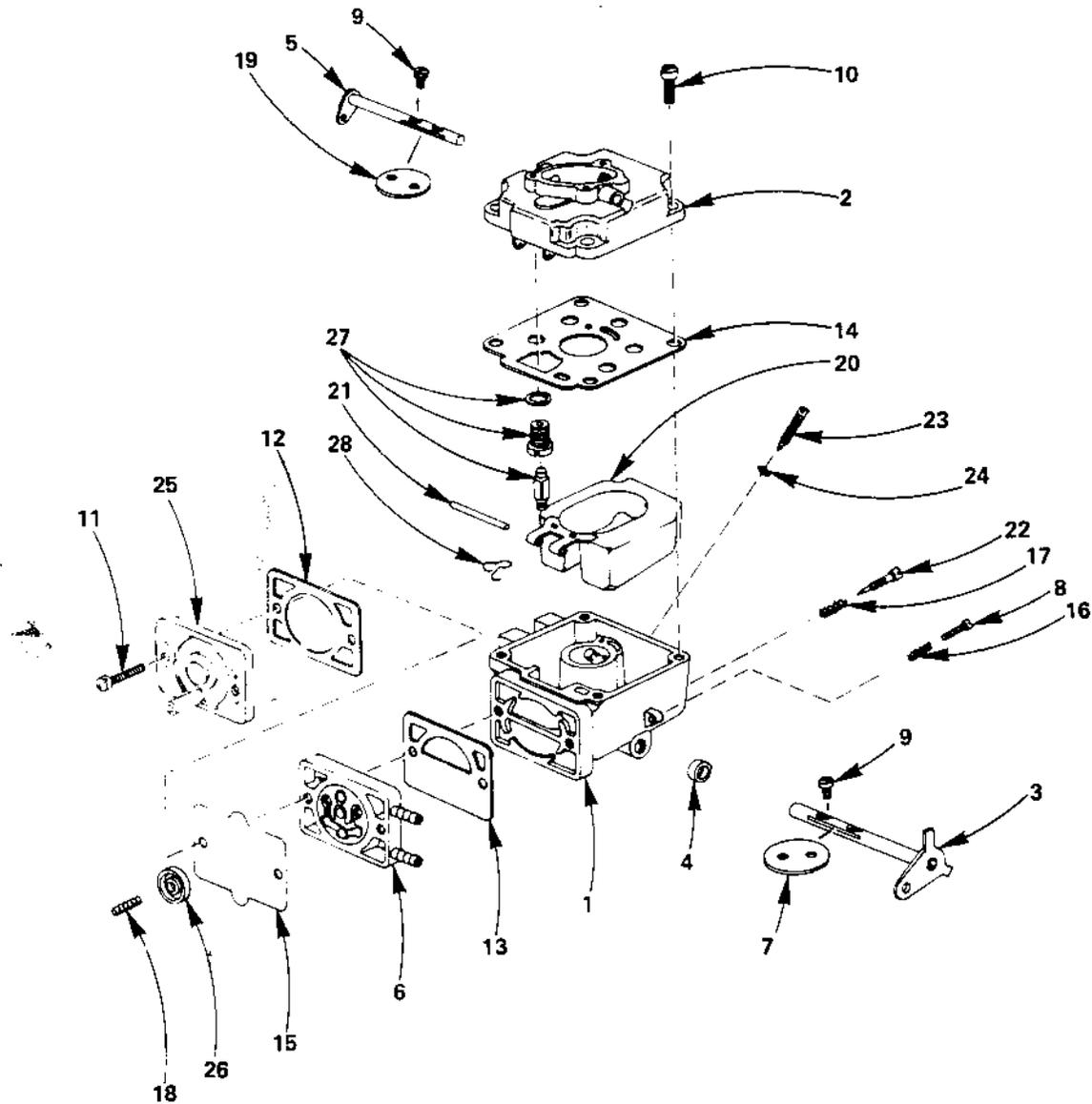
† - See separate group for components.

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

CARBURETOR PARTS GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A



| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|----------------------------------|---------|----------|------------------------------------|
| 1 | 142-0568 | Carburetor Assembly, Complete | 17 | 142-0282 | *Spring, Idle Needle |
| 2 | 142-0574 | Body Assembly, Lower | 18 | 142-0545 | *Spring, Pump Diaphragm |
| 3 | 142-0573 | Sleeve Assembly | 19 | 142-0546 | Fly, Choke |
| 4 | 142-0534 | *Shaft Assembly, Throttle | 20 | 142-0547 | Float and Lever Assembly |
| 5 | 142-0535 | †Packing, Shaft | 21 | 142-0548 | *Shaft, Float Lever |
| 6 | 142-0536 | Shaft Assembly, Choke | 22 | 142-0016 | *Needle, Idle |
| 7 | 142-0537 | *Valve Plate Assembly | 23 | 142-0549 | Needle Assembly, Power |
| 8 | 142-0538 | Fly, Throttle | 24 | 142-0550 | †Gasket, "O" Ring |
| 9 | 142-0064 | Screw, Throttle Stop | 25 | 142-0551 | Cover, Pump |
| 10 | 142-0334 | *Screw, Fly Mounting | 26 | 142-0552 | *Plate, Pump Spring |
| 11 | 142-0539 | Screw, Bowl Cover Mounting | 27 | 142-0553 | *Valve Assembly, Float |
| 12 | 142-0540 | Screw, Pump Cover | 28 | 142-0554 | Clip, Float Valve |
| 13 | 142-0541 | †Gasket, Base to Diaphragm | | 142-0571 | *Gasket Set (Includes Parts Marked |
| 14 | 142-0542 | †Gasket, Plate to Base | | 142-0570 | Repair Kit (Includes Parts Marked |
| 15 | 142-0572 | †Gasket, Sleeve Assembly to Base | | | |
| 16 | 142-0555 | *Diaphragm, Pump | | | |
| 17 | 142-0544 | Screw, Throttle Stop | | | |

† - Included in 142-0571 Gasket Set.

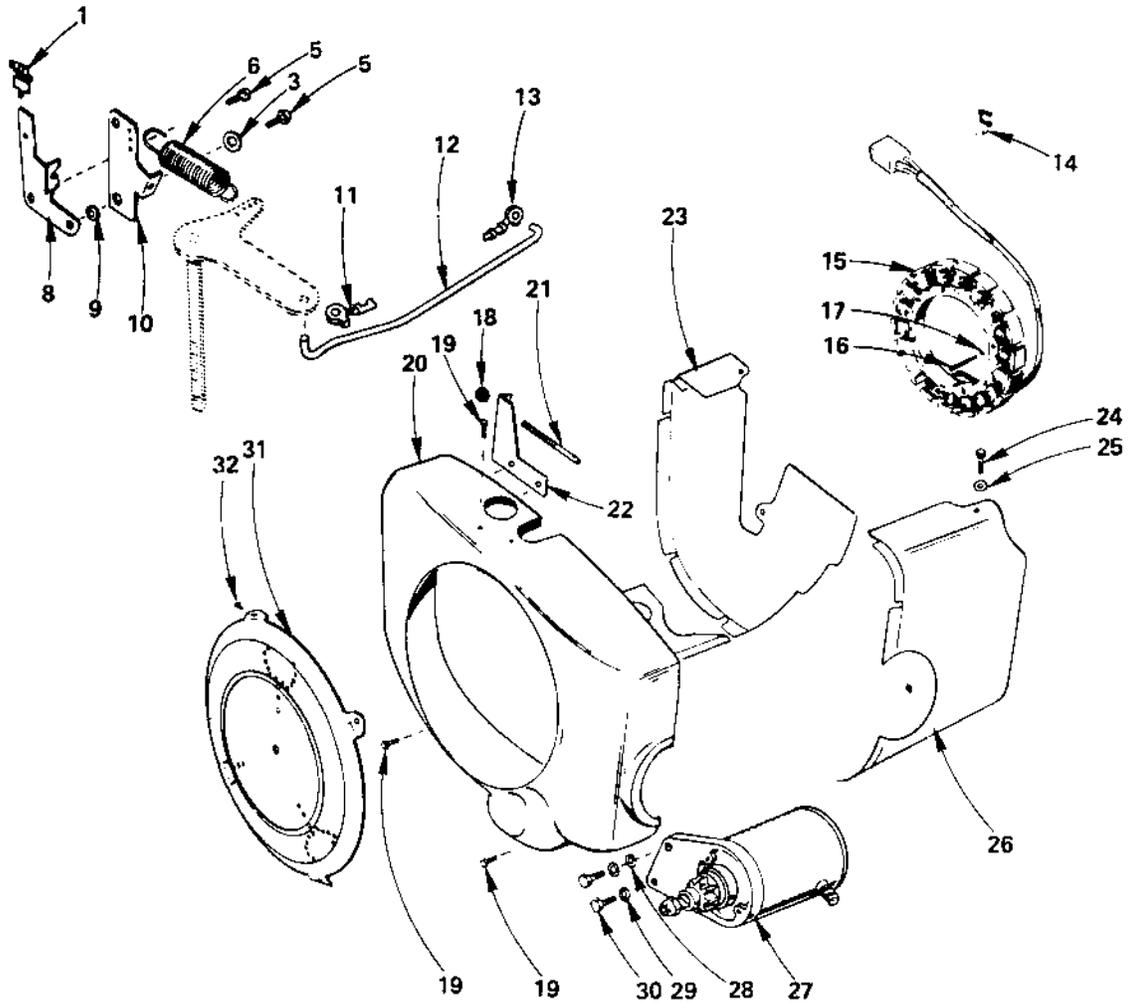
* - Included in 142-0570 Repair Kit.

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

GOVERNOR, STARTER,
CHARGING ALTERNATOR AND
BLOWER HOUSING GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A



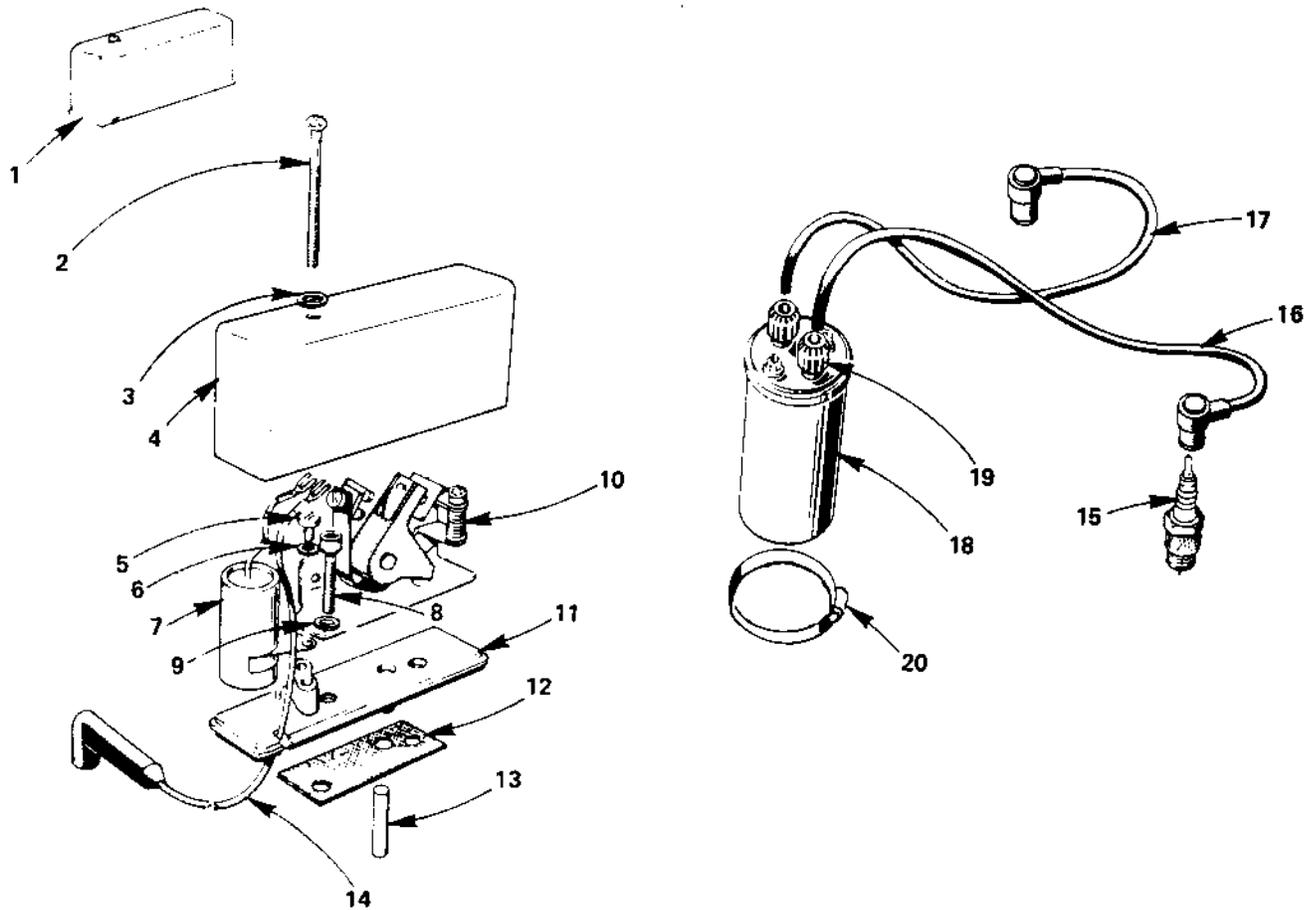
| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|---------------------------------------------------|---------|----------|--------------------------------------------------------------|
| 1 | 518-0176 | Clip, Throttle Cable | 19 | 815-0261 | Screw, Hex Head Cap (1/4 - 20 x 7/16") |
| 5 | 821-0010 | Screw, Hex Cap - Flange Locking (1/4 - 20 x 1/2) | 20 | 134-2991 | Housing, Blower |
| 6 | 150-1214 | Spring, Governor | 21 | 150-1418 | Stud, Governor |
| 8 | 150-1343 | Bracket, Governor Mounting | 22 | 150-1433 | Bracket, Governor Control |
| 9 | 150-1269 | Bushing, Governor Control | 23 | 134-2989 | Housing, Cylinder Air - Left |
| 10 | 150-1576 | Arm, Governor Control | 24 | 815-0290 | Screw, Hex Head Cap (1/4 - 20 x 5/8") |
| 11 | 870-0278 | Clip, Governor Control Rod to Governor Arm | 25 | 526-0021 | Washer, Flat - Steel (17/64" I.D. x 3/4" O.D. x 1/16" Thick) |
| 12 | 150-1350 | Rod, Governor Control | 26 | 134-2988 | Housing, Cylinder Air - Right |
| 13 | 518-0004 | Clip, Governor Control Rod to Carburetor | 27 | 191-0933 | Starter, 12 Volt (For Components see separate group) |
| 14 | 167-0188 | Clip, Alternator Lead Support | 28 | 526-0113 | Washer, Flat - Steel (11/32" I.D. x 1" O.D. x 3/32" Thick) |
| 15 | 191-1102 | Stator, Charging Alternator | 29 | 850-0045 | Washer, Spring Lock (5/16") |
| 16 | 813-0108 | Screw Round Head - Steel (No. 10 - 32 x 1 - 1/2") | 30 | 800-0512 | Screw, Hex Head Cap (5/16 - 18 x 1") |
| 17 | 850-0030 | Washer, Spring Lock (No. 10) | 31 | 134-3213 | Guard, Blower Housing |
| 18 | 870-0131 | Nut, Hex (No. 10 - 32) | 32 | 815-0378 | Screw, Ind. Hex Head w/ET (No. 14 x 1/2") |

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

IGNITION GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A



| KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|--------------------------------------------------------|
| 1 | 160-1210 | Box Assembly, Breaker (includes Parts Marked *) |
| 2 | 812-0108 | *Screw, Machine - Round Head (No. 10 - 14 x 1 - 1/2") |
| 3 | 526-0008 | *Washer, Flat (13/64" I.D. x 7/16" O.D. x 1/32" Thick) |
| 4 | 160-1176 | *Cover, Breaker Box |
| 5 | 815-0358 | *Screw, Tapping - Hex Head (No. 8 - 32 x 5/16") |
| 6 | 850-0025 | *Washer, Lock - Spring (No. 8) |
| 7 | 312-0196 | *Condenser, Ignition |
| 8 | 802-0034 | *Screw, Cap - Socket Head (1/4 - 20 x 3/4") |
| 9 | 850-0038 | *Washer, Lock - Spring - High Collar (1/4") |
| 10 | 160-1183 | *Point Assembly, Breaker |
| 11 | 160-1172 | *Base, Breaker Box |
| 12 | 160-1150 | *Gasket, Breaker Box |
| 13 | 160-1151 | Plunger, Breaker Point Assembly |
| 14 | 336-2132 | Lead, Breaker Points to Coil |
| 15 | 167-0237 | Plug, Spark |
| 16 | 167-1557 | Cable, Spark Plug (17") |
| 17 | 167-1581 | Cable, Spark Plug (15") |
| 18 | 166-0535 | Coil, Ignition |
| 19 | 166-0604 | Nut, Coil Cable (Part of 166-0535 Coil) |
| 20 | 503-0311 | Clamp, Coil Mounting |

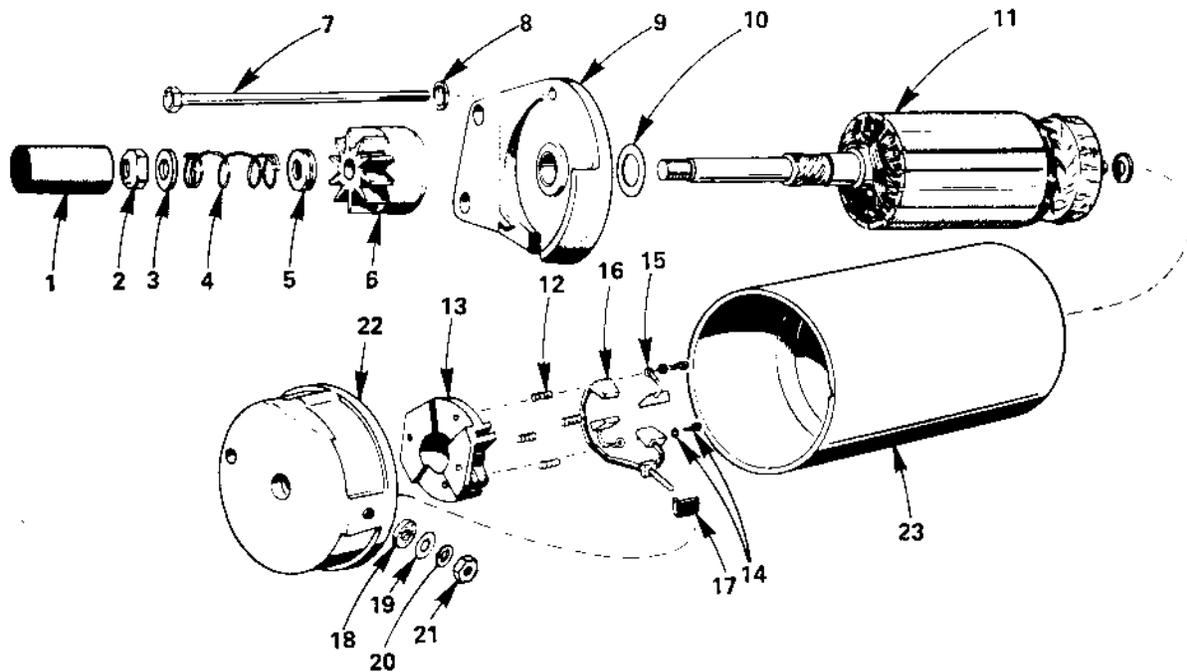
* - Parts included in 160-1210 Breaker Box Assembly.

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

STARTER PARTS GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A



| KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|--------------------------------------------------------------|
| | 191-0933 | Starter, 12 Volt (Complete) |
| 1 | 191-1034 | Cover, Dust |
| 2 | 191-1045 | Nut, Stop |
| 3 | 191-1046 | Washer, Stop Nut |
| 4 | 191-1035 | Spring, Anti-drift |
| 5 | 191-1047 | Spacer, Dust Cover |
| 6 | 191-1036 | Drive Assembly |
| 7 | 191-1048 | Screw, Hex Cap |
| 8 | 850-0040 | Washer, Lock |
| 9 | 191-1037 | Cap, Assembly, Drive End |
| 10 | 191-1038 | Washer, Armature Thrust |
| 11 | 191-1039 | Armature |
| 12 | ▲ | †*Spring, Brush |
| 13 | ▲ | †Brush Holder |
| 14 | ▲ | †Screw and Lockwasher |
| 15 | ▲ | †*Brush, Ground |
| 16 | ▲ | †*Stud and Brush Assembly, Input |
| 17 | ▲ | †Bushing, Insulation - Input Stud |
| 18 | ▲ | †Washer, Insulation - Input Stud |
| 19 | ▲ | †Washer, Flat - Input Stud |
| 20 | ▲ | †Washer, Lock - Input Stud |
| 21 | ▲ | †Nut, Securing - Input Stud |
| 22 | 191-1040 | Cap Assembly, Commutator (Includes Parts Marked †) |
| 23 | ▲ | Housing, Starter Motor |
| | 191-1041 | Repair Kit, Brush, Spring and Stud (Includes Parts Marked *) |

† - Included in the 191-1040 Cap Assembly.

* - Included in the 191-1041 Brush, Spring and Stud Kit.

▲ - Not Sold Separately

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

CYLINDER BLOCK GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A

| KEY NO. | PART NO. | DESCRIPTION | KEY NO. | PART NO. | DESCRIPTION |
|---------|-------------|----------------------------------------------------------------|---------|-------------|-----------------------------------------------------------------|
| 1 | 110-2397 | Block Assembly, Cylinder (Includes Parts Marked †) | 28 | | INSERT, VALVE SEAT EXHAUST |
| 2 | 123-1174 | Spring, Breather Valve | | 110-1824 | †Standard |
| 3 | 123-1175 | Valve, Breather | | 110-1824-02 | .002" Oversize |
| 4 | 123-1173 | Baffle, Breather | | 110-1824-05 | .005" Oversize |
| 5 | 526-0018 | Washer, Flat - Steel (17/64" I.D. x 5/8" O.D. x 1/16" Thick) | | 110-1824-10 | .010" Oversize |
| | | | | 110-1824-25 | .025" Oversize |
| 6 | 110-2274 | Cover, Valve Compartment (L.H.) | | | INTAKE |
| 7 | 110-1879 | Cover, Valve Compartment (R.H.) | | 110-0197 | †Standard |
| 8 | 110-1921 | Gasket, Valve Cover | | 110-0197-02 | .002" Oversize |
| 9 | 517-0048 | †Plug, Extension - Camshaft | | 110-0197-05 | .005" Oversize |
| 10 | 104-0776 | †Shim, Rear Bearing Plate (.005") | | 110-0197-10 | .010" Oversize |
| 11 | 110-2287 | Gasket, Cylinder Head | | 110-0197-25 | .025" Oversize |
| 12 | | HEAD, CYLINDER | 29 | 526-0122 | Washer, Flat - Steel (11/32" I.D. x 23/32" O.D. x 10 Gauge) |
| | 110-2273 | Right Side (No. 2 Cylinder) | | | |
| | 110-2272 | Left Side (No.1 Cylinder) | 30 | 110-1807 | †Guide, Valve |
| 13 | 800-0051 | †Screw, Hex Head Cap - Steel (3/8 - 16 x 1 - 1/4") | 31 | 110-0539 | Spring, Valve |
| | | | 32 | 110-0639 | Lock, Valve and Spring Retainer |
| 14 | 123-1277 | Tube, Breather | 33 | | *BEARING, CRANKSHAFT - FRONT (FLANGED) |
| 15 | | BEARING, CRANKSHAFT - REAR (INCLUDES THRUST WASHER) | | 101-0432 | †Standard |
| | 101-0450 | †Standard | | 101-0432-02 | .002" Undersize |
| | 101-0450-02 | .002" Undersize | | 101-0432-10 | .010" Undersize |
| | 101-0450-10 | .010" Undersize | | 101-0432-20 | .020" Undersize |
| | 101-0450-20 | .020" Undersize | | 101-0432-30 | .030" Undersize |
| | 101-0450-30 | .030" Undersize | 34 | 800-0046 | Screw, Hex Head Cap (3/8 - 16 x 3/4") - Cylinder Block Wet Hole |
| 16 | 104-0575 | †*Washer, Crankshaft Bearing Thrust | | | |
| 17 | 101-0415 | †Gasket, Bearing Plate | 35 | 526-0066 | Washer, Flat - Copper (25/64" I.D. x 9/16" O.D. x 1/16" O.D.) |
| 18 | 101-0439 | †Plate, Bearing (Excludes Bearings) | | | |
| 19 | 101-0405 | †Bearing, Camshaft (Precision) | 36 | 110-0068 | †Gasket, Valve Guide (Intake) |
| 20 | 509-0041 | †Seal, Bearing Plate | 37 | 800-0010 | Screw, Hex Head Cap (1/4 - 20 x 1 - 3/4") |
| 21 | 516-0072 | †Pin, Main Bearing Stop | | | |
| 22 | 526-0063 | Washer, Flat - Copper (17/64" I.D. x 7/16" O.D. x 1/32" Thick) | 38 | 149-1299 | Tube, Fuel Pump Vacuum |
| | | | 39 | | SCREW, HEX HEAD CAP |
| 23 | 110-0904 | Rotocap, Valve | | 800-0540 | 5/16 - 18 x 1 - 5/8" |
| 24 | | TAPPET, VALVE | | 800-0541 | 5/16 - 18 x 2" |
| | 115-0006 | Standard | 40 | 123-0865 | Filter, Breather Tube |
| | 115-0006-02 | .002" Oversize | 41 | 520-0820 | Stud, Cylinder Block Wet Hole (Lower) |
| | 115-0006-05 | .005" Oversize | | | |
| 25 | 850-0050 | †Washer, Lock (3/8") | | | |
| 26 | 120-0735 | †Tube, Crankcase Oil | | | |
| 27 | | VALVE | | | |
| | 110-1808 | Intake | | | |
| | 110-1809 | Exhaust | | | |

† - Included in 110-2397 Cylinder Block Assembly.

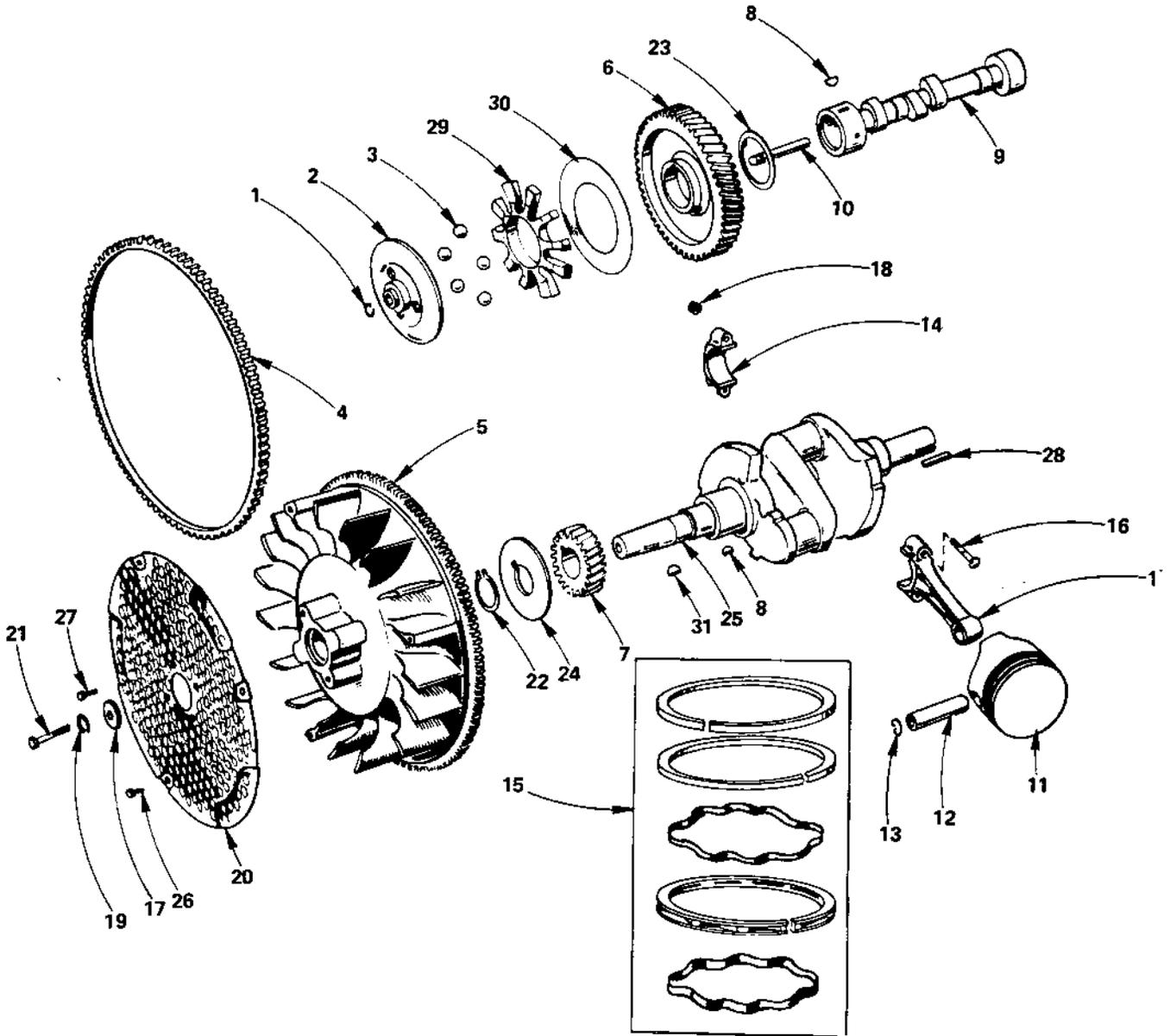
* - Replacement Front Flange Bearing replaces unflanged bearing and thrust washer.

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

CRANKSHAFT, FLYWHEEL, CAMSHAFT
AND PISTON GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A



another free manual from www.searstractormanuals.com

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

CRANKSHAFT, FLYWHEEL, CAMSHAFT AND PISTON GROUP

ONAN ENGINE MODEL NUMBER BG-MS/3272A

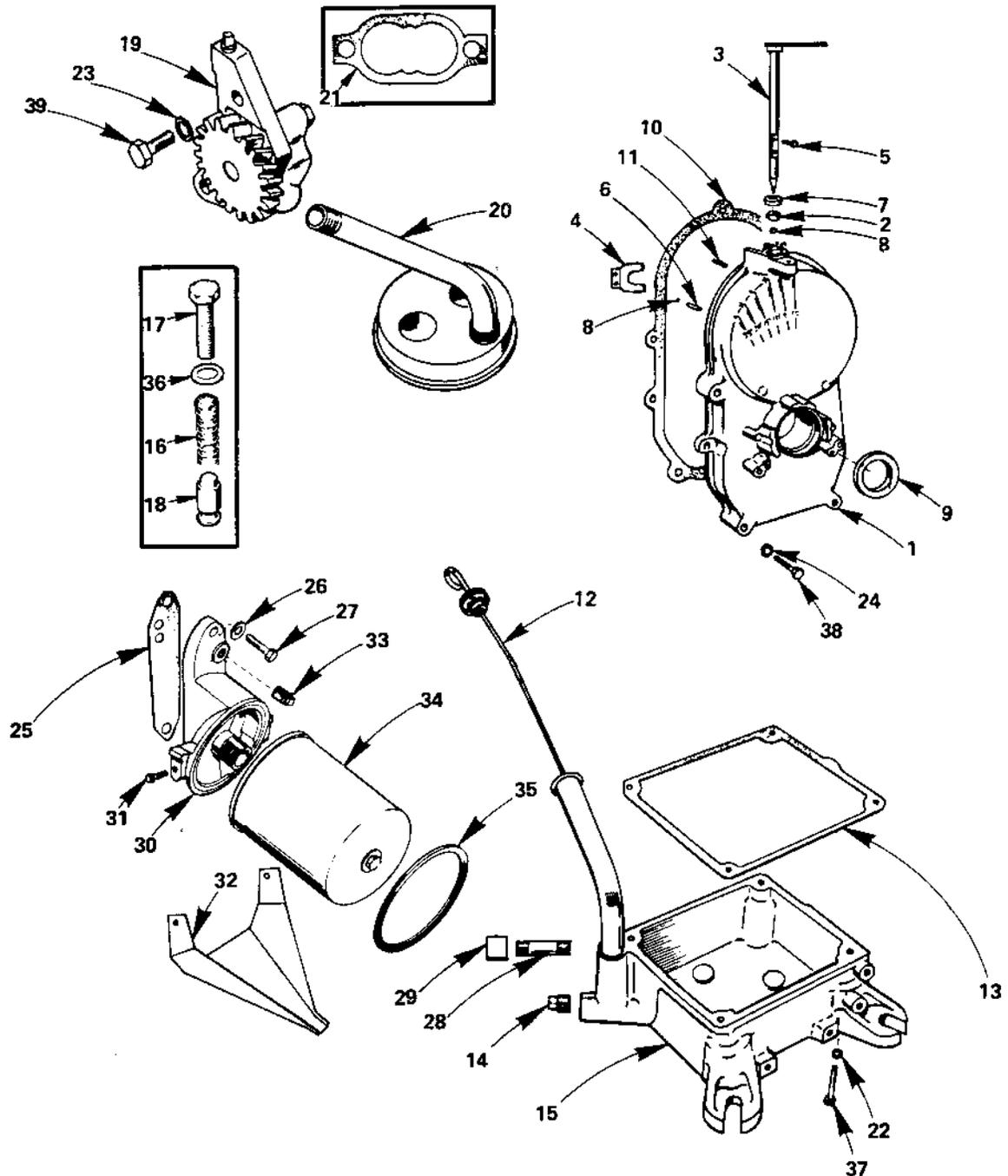
| KEY NO. | PART NO. | DESCRIPTION |
|---------|-------------|--------------------------------------------------------------------|
| 1 | 150-0078 | Ring, Camshaft Center Pin |
| 2 | 150-1116 | Cup, Governor |
| 3 | 510-0015 | Ball, Fly - Governor |
| 4 | 104-0779 | Gear, Ring - Flywheel |
| 5 | 134-3209 | Flywheel (Includes Ring Gear and Magnet Ring) |
| 6 | 105-0332 | Gear, Camshaft (Includes Flyball Spacer and Plate) |
| 7 | 104-0032 | Gear, Crankshaft |
| 8 | 515-0001 | Key (1/2" Diameter x 1/8") |
| 9 | 105-0402 | Camshaft (Includes Center Pin) |
| 10 | 150-0075 | Pin, Camshaft Center |
| 11 | | PISTON AND PIN (INCLUDES RETAINING RINGS) |
| | 112-0143 | Standard |
| | 112-0143-05 | .005" Oversize |
| | 112-0143-10 | .010" Oversize |
| | 112-0143-20 | .020" Oversize |
| | 112-0143-30 | .030" Oversize |
| | 112-0143-40 | .040" Oversize |
| 12 | 112-0122 | Pin, Piston |
| 13 | 518-0311 | Ring, Piston Pin Retaining |
| 14 | | ROD ASSEMBLY, CONNECTING |
| | 114-0247 | Standard |
| | 114-0247-10 | .010" Oversize |
| | 114-0247-20 | .020" Oversize |
| | 114-0247-30 | .030" Oversize |
| 15 | | RING SET, PISTON |
| | 113-0186 | Standard |
| | 113-0186-05 | .005" Oversize |
| | 113-0186-10 | .010" Oversize |
| | 113-0186-20 | .020" Oversize |
| | 113-0186-30 | .030" Oversize |
| | 113-0186-40 | .040" Oversize |
| 16 | 114-0228 | Bolt, Special - Connecting Rod |
| 17 | 526-0017 | Washer, Flat - Steel (15/32" I.D. x 1 - 1/4" O.D. x 1/4" Thick) |
| 18 | 870-0137 | Nut, Locking - Connecting Rod Cap |
| 19 | 850-0055 | Washer, Spring Lock (7/16") |
| 20 | 134-3212 | Guard, Flywheel |
| 21 | 104-0170 | Screw, Hex Head Cap (7/16 - 14 x 4") |
| 22 | 518-0014 | Ring, Retaining - Crankshaft Gear Washer |
| 23 | 105-0004 | Washer, Camshaft Gear Thrust |
| 24 | 104-0043 | Washer, Crankshaft Gear Retainer |
| 25 | 104-0919 | Crankshaft |
| 26 | 821-0010 | Screw, Hex Head Cap - Locking Flange (1/4 - 20 x 1/2") |
| 27 | 821-0014 | Screw, Hex Head Cap - Locking Flange (5/16 - 18 x 1/2") |
| 28 | 515-0103 | Key, Crankshaft Stub (1/4 x 1/4 x 2) |
| 29 | 150-1257 | Spacer, Governor Flywheel |
| 30 | 150-0077 | Plate, Governor Flyball |
| 31 | 515-0227 | Key Kit |

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

GEAR COVER, OIL BASE AND
OIL PUMP GROUP

ONAN ENGINE MODEL NUMBER BF-MS/3272A



another free manual from www.searstractormanuals.com

REPAIR PARTS

18/6 TWIN-GARDEN TRACTOR--MODEL NO. 917.25191

GEAR COVER, OIL BASE AND OIL PUMP GROUP

ONAN ENGINE MODEL
NUMBER BF-MS/3272A

| KEY NO. | PART NO. | DESCRIPTION |
|---------|----------|----------------------------------------------------------------------------------|
| 1 | 103-0498 | Cover Assembly, Gear (Includes Parts Marked *) |
| 2 | 510-0105 | *Bearing, Governor Shaft |
| 3 | 150-1470 | *Shaft and Arm Assembly, Governor |
| 4 | 150-1187 | *Yoke Governor Shaft |
| 5 | 815-0046 | *Screw, Yoke Retaining |
| 6 | 516-0130 | *Pin, Governor Cup Stop |
| 7 | 509-0008 | *Seal, Oil - Governor Shaft |
| 8 | 510-0014 | *Ball, Bearing - Governor Shaft |
| 9 | 509-0040 | *Seal, Gear Cover |
| 10 | 103-0408 | Gasket, Gear Cover |
| 11 | 516-0141 | Pin, Gear Cover Mounting (5/16 x 7/8") |
| 12 | 123-1292 | Cap and Indicator, Oil Fill |
| 13 | 102-0693 | Gasket, Oil Base Mounting |
| 14 | 505-0056 | Plug, Oil Drain |
| 15 | 102-0741 | BASE, OIL For Engines With Extended Oil Drain |
| 16 | 120-0140 | Spring, Oil By-Pass Valve |
| 17 | 801-0050 | Screw, Hex Head Cap (3/8 - 24 x 1") - Oil By - Pass |
| 18 | 120-0398 | Valve, Oil By - Pass |
| 19 | 120-0491 | Pump, Oil - Complete (NOTE: Internal parts not sold separately) |
| 20 | 120-0713 | Intake, Oil Pump (Includes: Cup, Screen and Pipe) |
| 21 | 120-0161 | Gasket Kit, Oil Pump |
| 22 | 850-0050 | Washer, Spring Lock (3/8") |
| 23 | 850-0040 | Washer, Spring Lock (1/4") |
| 24 | 526-0065 | Washer, Flat - Copper (21/64" I.D. x 9/16" O.D. x 1/16" Thick) |
| 25 | 122-0321 | Gasket, Oil Filter Adapter |
| 26 | 526-0065 | Washer, Flat - Copper (21/64" I.D. x 9/16" O.D. x 1/16" Thick) |
| 27 | 800-0028 | Screw, Hex Head Cap (5/16 - 18 x 1") |
| 28 | 505-0176 | Nipple, Pipe - Oil Drain (1/2 x 3 - 1/2") |
| 29 | 505-0158 | Cap, Pipe (1/2") |
| 30 | 122-0320 | Adapter, Oil Filter |
| 31 | 815-0194 | Screw, Hex Head (No. 10 - 32 x 3/8") |
| 32 | 122-0360 | Drain, Oil Filter |
| 33 | 502-0080 | Plug, Oil Filter Adapter |
| 34 | 122-0406 | Filter, Oil |
| 35 | 122-0347 | Seal, Air - Oil Filter |
| 36 | 526-0066 | Washer, Flat - Copper (25/64" I.D. x 9/16" O.D. x 1/16" Thick) - By - Pass Valve |
| 37 | 800-0056 | Screw, Hex Head Cap (3/8 - 16 x 2 - 1/2") |
| 38 | 800-0032 | Screw, Hex Head Cap (5/16 - 18 x 1 - 3/4") - Gear Cover Mounting |
| 38 | 800-0545 | Screw, Hex Head Cap (5/16 - 18 x 2 - 3/4") - Gear Cover Mounting |
| 39 | 800-0007 | Screw, Hex Head Cap (1/4 - 20 x 1") |

* - Included in Gear Cover Assembly.



**MODEL NO.
917.25191**

HOW TO ORDER REPAIR PARTS

MODEL NUMBER

The Model Number will be found on the Model Plate attached to the Battery Heat Shield, in front of the Battery. Always mention the Model Number when requesting service or repair parts for your Garden Tractor.

REPAIR PARTS

All parts listed herein may be ordered from any SEARS, ROEBUCK AND CO. or SIMPSONS-SEARS LIMITED retail or catalog store.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

- THE PART NUMBER
- THE PART DESCRIPTION
- THE MODEL NUMBER
- THE NAME OF MERCHANDISE

If the parts you need are not stocked locally, your order will be electronically transmitted to a Sears Repair Parts Distribution Center for "expedited handling".



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