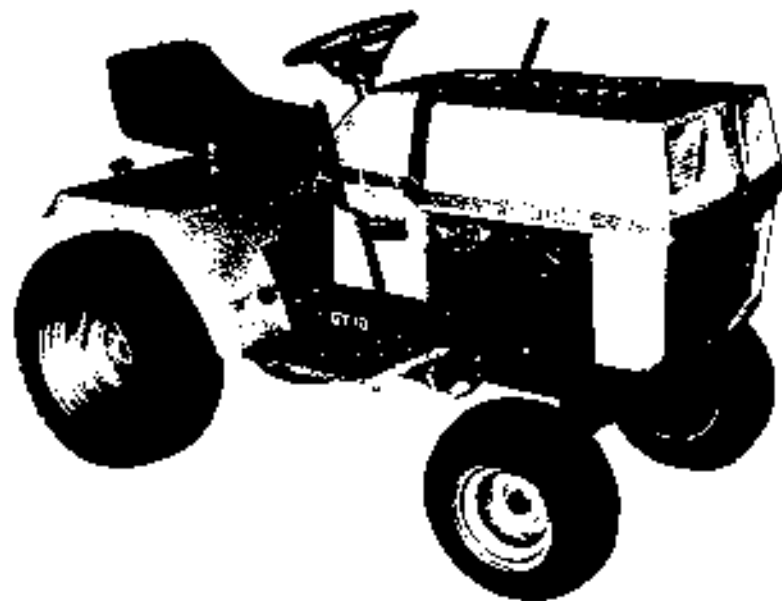


Sears

**OWNERS
MANUAL**

**MODEL NO.
917.253744**



Apr 1985

**Caution:
Read Rules for
Safe Operation
and Instructions
Carefully**

**GT/18 TWIN
6 SPEED
GARDEN TRACTOR**

**Assembly
Installation
Operation
Repair Parts**

CONGRATULATIONS on your purchase of a Sears GT18 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. 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 GT 18 GARDEN TRACTOR FEATURES . . .

CRAFTSMAN 18 H.P. TWIN-CYLINDER ENGINE—cool-running performance and long life with plenty of power to take on a variety of yard, gardening or snow removal tasks.

INTERLOCK SWITCH 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. Automotive-type differential helps guard against turf scuffing.

CONTROL PANEL—with Throttle, Choke, Light Switch, Ignition Switch, Ammeter and Parking Brake Lever—conveniently grouped for ease of use.

MODEL NUMBER 917253744
SERIAL NUMBER 3214612647

THE MODEL AND SERIAL NUMBERS WILL BE FOUND ON THE MODEL PLATE DECAL ATTACHED TO THE TOP RIGHT REAR CORNER OF FENDER UNDER REAR CORNER OF SEAT. (REFER TO PAGE 18).

YOU SHOULD RECORD BOTH MODEL AND SERIAL NUMBERS AND KEEP IN A SAFE PLACE FOR FUTURE REFERENCE.

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

MANUAL OR ELECTRIC LIFT.

44 INCH MOWER with three "high-lift" blades to stand grass up for level cuts.

SELF POWERED ROTO TILLER prepares soil for new lawns and gardens with a 30 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.

48 INCH DOZER BLADE levels or moves dirt and gravel or removes snow.

42 INCH SNOW BLOWER handles wet, heavy powdery snow with ease.

REAR GRADER AND LEVELER BLADE levels new yards, grading lanes, drive ways and parking areas.

FULL ONE YEAR WARRANTY ON ELECTRIC START RIDING EQUIPMENT (EXCLUDING BLADE(S), BLADE ADAPTER(S), SPARK PLUG(S), AIR CLEANER(S))

For one year from date of purchase, when this riding equipment is maintained, operated, and tuned up according to the operating and maintenance instructions in the owner's manual, Sears will repair free of charge any defect in material or workmanship in this electric start riding equipment.

This warranty excludes blade(s), blade adapter(s), spark plug(s), and air cleaner(s) which are expendable and become worn during normal use.

This warranty does not cover:

- tire replacement or repair caused by punctures from outside objects (such as nails, thorns, stumps, or glass) and
- repairs necessary because of operator abuse or negligence, including the failure to maintain the equipment according to instructions contained in the owner's manual; and
- riding equipment used for commercial or rental purposes.

FULL 90-DAY WARRANTY ON BATTERY

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

Warranty service is available by contacting the nearest Sears store or Service Center in the United States. This warranty applies only while this product is in use in 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
Dept 898-731A
Chicago, IL 60684

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RULES FOR SAFE OPERATION	BELOW	MAINTENANCE INSTRUCTIONS	6
ASSEMBLY INSTRUCTIONS	2	TROUBLE SHOOTING	13
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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 or without having read the owners manual.
3. Do not carry passengers. Keep children and pets a safe distance away.
4. Always wear substantial footwear. Do not wear loose fitting clothing that could get caught in moving parts.
5. Keep your eyes and mind on your tractor, mower and the area being cut. Don't let other interests distract you.
6. Do not attempt to operate your tractor or mower when not in the drivers seat.
7. Always get on or off your tractor from the operators left hand side.
8. Clear the work area of objects which might be picked up and thrown.
9. Disengage all attachment clutches and return speed control lever to neutral before attempting to start the engine.
10. Disengage power to attachments and stop the engine before leaving the operator's position.
11. Disengage power to mower, stop the engine and disconnect spark plug wire(s) from spark plug(s) before cleaning, making an adjustment or repairs.
12. Disengage power to attachments when transporting or not in use.
13. Take all possible precautions when leaving the vehicle unattended, such as disengaging the power-take-off, lowering the attachments, returning drive control lever to neutral, shifting into neutral, setting the parking brake, stopping the engine and removing the key.
14. 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. Refer to page 32.
15. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
16. While going up or down slopes, place Gear Shift Control Lever in 1st gear and Range Shift Lever in "LO" (Low) position to negotiate the slope without stopping.
17. Never mow in wet or slippery grass, when traction is unsure or at a speed which could cause a skid.
18. Stay alert for holes in the terrain and other hidden hazards.
19. Do not drive too close to creeks, ditches and public highways.
20. Exercise special care when mowing around fixed objects in order to prevent the blades from striking them. Never deliberately run tractor or mower into or over any foreign object.
21. Never shift gears until tractor comes to a stop.
22. Never place hands or feet under the mower, in discharge chute or near any moving parts while tractor or mower are running. Always keep clear of discharge chute.
23. 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 counterweight or wheel weights when suggested in the owner's manual.
24. Watch out for traffic when crossing or near roadways.
25. When using any attachments, never direct discharge of material toward bystanders nor allow anyone near the vehicle while in operation.
26. 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.
27. Keep the vehicle and attachments in good operating condition, and keep safety devices in place.
28. Keep all nuts, bolts and screws tight to be sure the equipment is in safe working condition.
29. 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.
30. To reduce fire hazard, keep the engine free of grass, leaves or excessive grease. Do not clean product while engine is running.
31. Except for adjustment; DO NOT operate Engine if air cleaner or cover directly over carburetor air intake is removed. Removal of such part could create a fire hazard.
32. DO NOT OPERATE WITHOUT A MUFFLER OR TAMPER WITH THE EXHAUST SYSTEM. Damaged mufflers or spark arresters could create a fire hazard. Inspect periodically and replace if necessary.
33. 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.
34. Do not change the engine governor settings or overspeed the engine; severe damage or injury may result.
35. 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.
36. Check the grass catcher bags frequently for wear or deterioration. Replace with new bags for safety protection.
37. Do not operate the mower without the entire grass catcher, on mowers so equipped, or the deflector shield in place.
38. Disengage power to mower before backing up. Do not mow in reverse unless absolutely necessary and then only after careful observation of the entire area behind the mower.

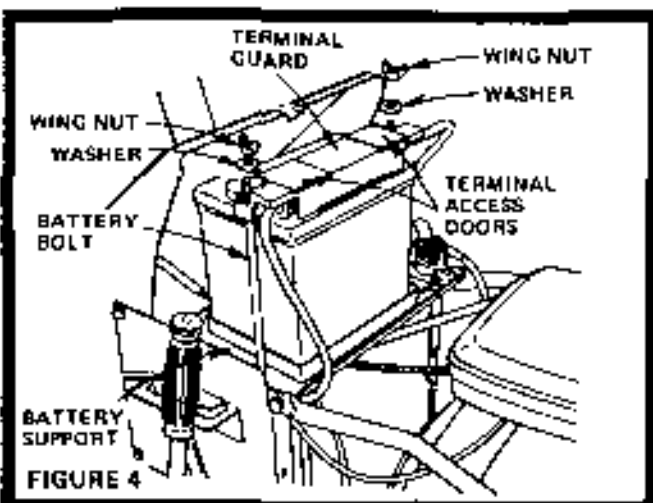
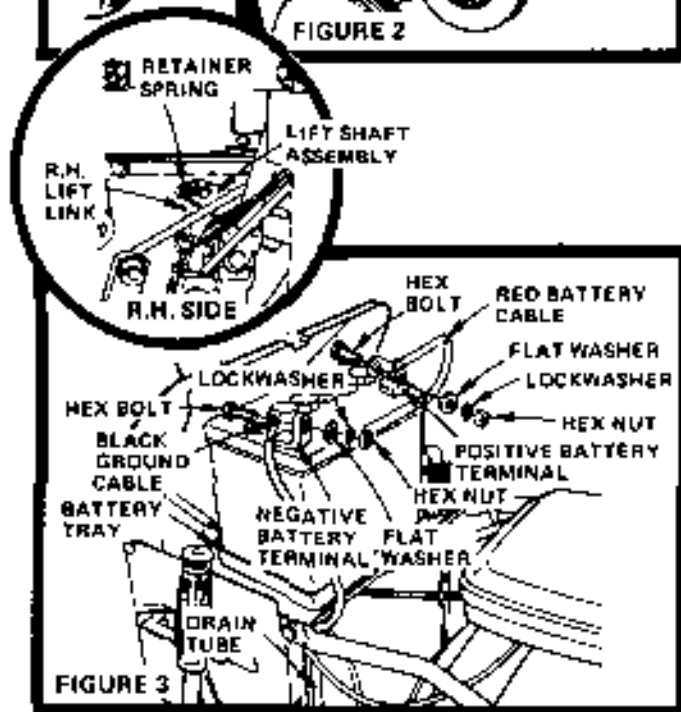
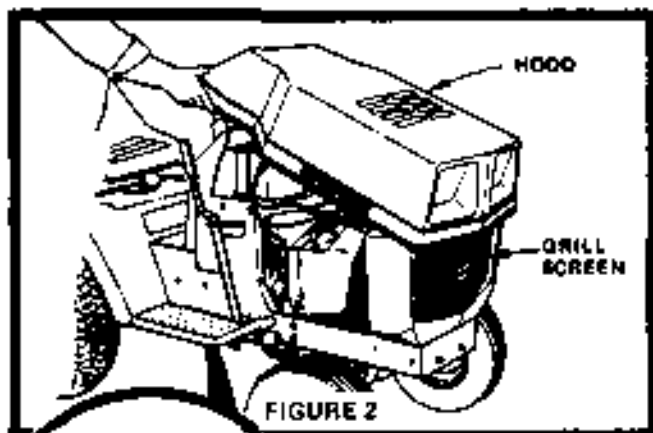
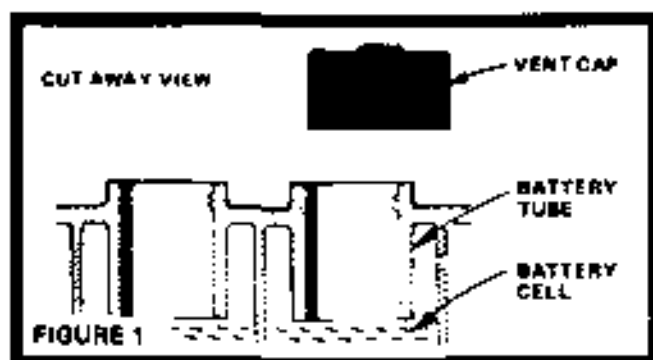


LOOK FOR THIS SYMBOL TO POINT OUT IMPORTANT SAFETY PRECAUTIONS. IT MEANS - ATTENTION! BECOME ALERT! YOUR SAFETY IS INVOLVED.

WARNING

This unit is equipped with an internal combustion engine and should not be used on or near any unimproved forest covered, brush covered or grass-covered land unless the engine's exhaust system is equipped with a spark arrester meeting applicable local or state laws (if any). If a spark arrester is used, it should be maintained in effective working order by the operator.

In the State of California the above is required by law (Section 4442 of the California Public Resources Code). Other states may have similar laws. Federal laws apply on federal lands. See your Authorized Service Center for spark arrester muffler part number 674A380.



ASSEMBLY

To assemble and adjust your Tractor you will need: one 3/4" and one 9/16" sockets and two 7/16" wrenches

NOTE: RIGHT HAND (R.H.) AND LEFT HAND (L.H.) ARE DETERMINED FROM OPERATOR'S POSITION.

1. Remove Fasteners holding Tractor to skid. Also remove Battery, Steering Wheel and Bag of Parts.

WEAR EYE AND FACE SHIELD.



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

DO NOT SMOKE, FUMES FROM CHARGED ELECTROLYTE ARE EXPLOSIVE.

2. Fill and charge Battery (before installing). NOTE: SEE DETAILED INSTRUCTIONS PACKAGED WITH BATTERY.
 - a. Fill Battery with electrolyte to bottoms of tubes in cell (Fig. 1). NOTE: DO NOT OVERFILL. OVERFILLING WILL RESULT IN DAMAGE TO TRACTOR.
 - 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
 - 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.



DO NOT SHORT BATTERY TERMINALS.



BEFORE INSTALLING BATTERY, REMOVE METAL BRACELETS, WRISTWATCH BANDS, RINGS, ETC. FROM YOUR PERSON.

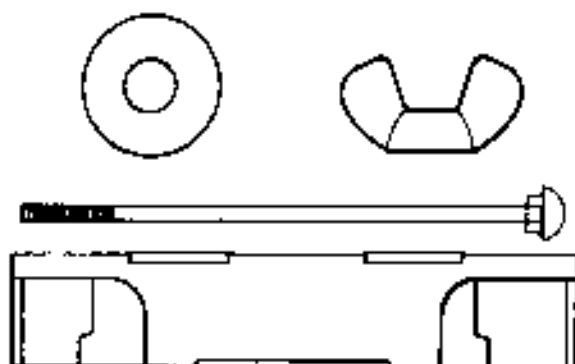
3. Install Battery.
 - a. Lift hood from rear side (Fig. 2).
 - b. Remove tape from Plastic Tray. Make sure Drain Tube (Fig. 3) is fastened to Drain Hole in Battery Tray and Battery Tray is positioned in hole of Battery Support.
 - c. Place Battery in Plastic Tray (Battery Terminals to front of Tractor) (Fig. 3).
4. Connect Battery Cables using: two Hex Bolts, two Flat Washers, two Lockwashers and two Hex Nuts (shown full size below) found in Bag of Parts



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

- a. Connect RED Battery Cable to Positive (+) Battery Terminal with Hex Bolt, Flat Washer, Lockwasher and Hex Nut (Fig. 3). Tighten securely.
- b. Connect BLACK Ground Cable to Negative (-) Battery Terminal with remaining Hex Bolt, Flat Washer, Lockwasher and Hex Nut (Fig. 3). Tighten securely.

5. Install Battery using two Flat Washers, two Wing Nuts (shown full size below) and



two Battery Bolts and one Terminal Guard found in Bag of Parts.

- Using the square hole on one side of the Battery Support (Fig. 4) insert one Battery Bolt, head of Bolt down. Fasten the Battery Bolt to the Terminal Guard using Washer and Wing Nut as shown in Fig. 4.
- Assemble the remaining Battery Bolt to other side of Battery Support and fasten Terminal Guard to it with remaining Flat Washer and Wing Nut. Tighten Wing Nuts securely by hand (Fig. 4).

NOTE: USE TERMINAL ACCESS DOORS (FIG. 4) FOR:

- Inspection for secure connections (tighten hardware).
- Inspection for corrosion.
- Testing battery.
- Jumping (if required).
- Charging (if required)

WHEN NOT IN USE, KEEP TERMINAL ACCESS DOORS CLOSED.

6. Close Hood.

7. Install Steering Wheel.

NOTE: POSITION FRONT WHEELS FORWARD.

- Remove Hex Washer Head Bolt, Lockwasher and Large Washer from Steering Column (Fig. 5).
- Position Steering Wheel over Steering Wheel Insert.
- Secure Steering Wheel to Steering Column using Hex Bolt, Lockwasher and Large Washer (Fig. 5).
- Snap Steering Wheel Cap in place on Steering Wheel. Steering Wheel Cap found in Bag of Parts

NOTE: A SPARK ARRESTER MUFFLER (PAGE 23) IS AVAILABLE AS AN ACCESSORY PART FOR YOUR TRACTOR. CHECK LEGAL REQUIREMENTS IN YOUR AREA.

INITIAL PREPARATION

ENGINE

- This engine has been shipped filled with oil. 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, SE or SF) Oil. In winter (below 32°F.) use S.A.E. 10W30 (SC, SD, SE or SF). In extreme cold (below 0°F.) use S.A.E. 5W20 (SC, SD, SE or SF). DO NOT USE 10W40 OIL. NOTE: DO NOT OVERFILL. Capacity is 3 pints.

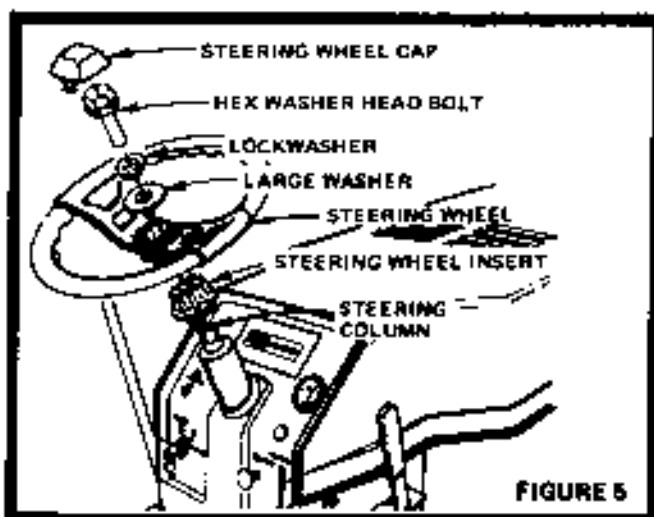


FIGURE 5

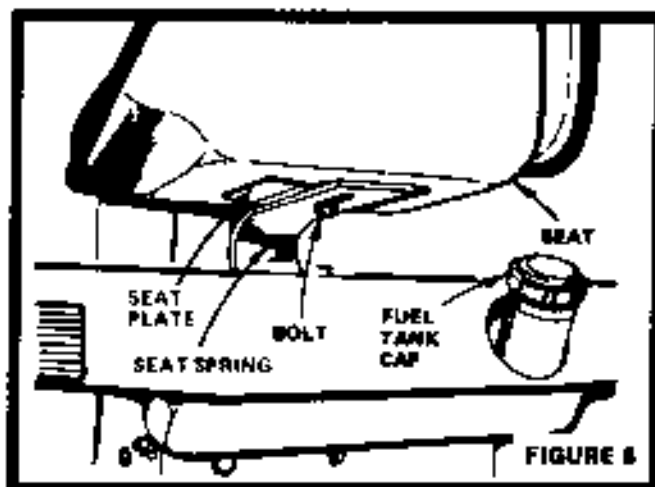
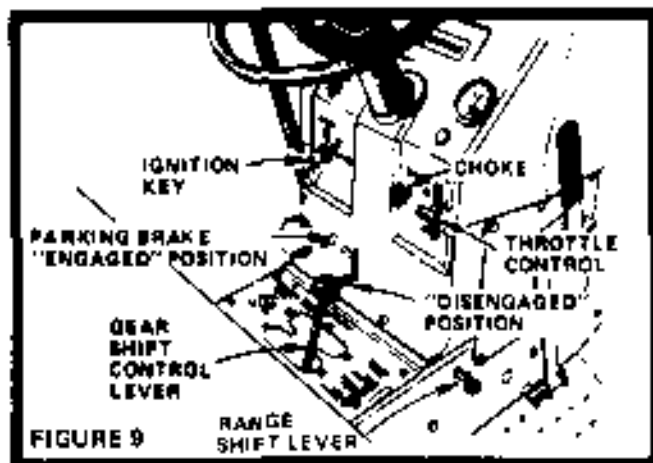
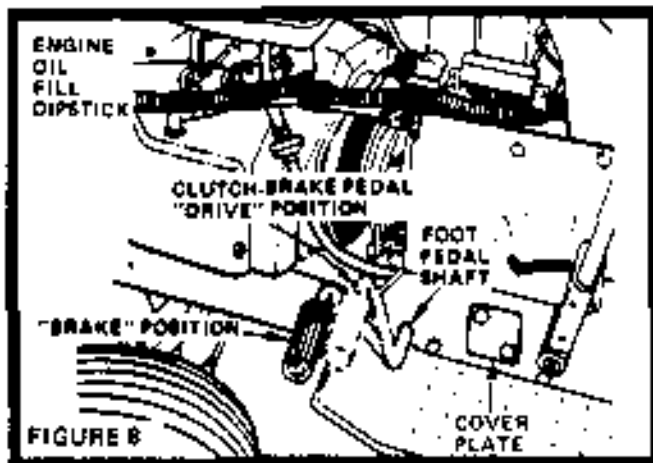
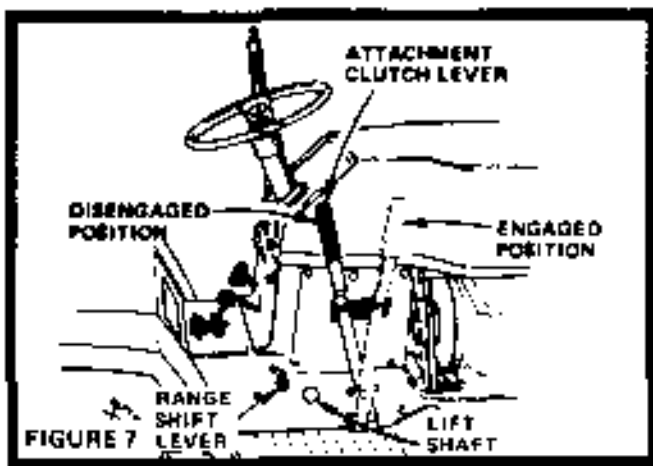


FIGURE 6



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

- Fill Fuel Tank (Fig. 6) with clean, fresh lead free, low lead or regular grade leaded gasoline. The use of lead free gasoline produces fewer combustion deposits which will result in longer valve life. Capacity is 3 1/2 gallons.
- WARNING** Do not use Gasohol. The alcohols in the gasohol react with water content in the fuel and tend to form strong acids which can corrode metal parts, even eat rubber and plastics.
- Reduce Tire pressure to 14 pounds in front and 10 pounds in rear tires. (Tires were overinflated for shipping purposes).
- Adjust Seat forward or backward to accommodate operator by loosening Bolt (Fig. 6). Retighten Bolt securely making sure Seat Plate has not twisted out of alignment with Seat Spring.



OPERATION



CAUTION

1. Keep all shields in place.
2. Before leaving operator's position:
 - a. Shift transmission to neutral.
 - b. Set Parking Brake.
 - c. Disengage Attachment Lever.
 - d. Shut off engine.
 - e. Remove Ignition Key.
3. Wait for all movement to stop before servicing machine.
4. Keep people and pets a safe distance away from machine.
5. Always wear substantial footwear and avoid loose fitting clothing that could get caught in moving parts.

STARTING THE ENGINE



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

NOTE. THIS TRACTOR IS EQUIPPED WITH INTERLOCK SWITCHES TO PREVENT STARTING OF THE TRACTOR ENGINE WHILE THE ATTACHMENT CLUTCH LEVER IS IN THE ENGAGED POSITION (FIG. 7) AND THE CLUTCH BRAKE PEDAL IS IN DRIVE POSITION (FIG. 8).



IMMEDIATELY REPLACE SWITCHES THAT ARE NOT IN PROPER WORKING ORDER. DO NOT ATTEMPT TO DEFEAT THE PURPOSE OF THESE SWITCHES.

1. Place Attachment Clutch Lever in "DISENGAGED" position (Fig. 7).
2. Push Clutch-Brake Pedal fully into brake position (Fig. 8).
3. Place Gear Shift Control Lever in "N" neutral, start position and Range Shift Lever in "N" neutral position (Fig. 9).
4. Pull Choke out (Fig. 9).
5. Move Throttle Control to middle position (Fig. 9).
6. Turn Ignition Key to "START" position until Engine starts (Fig. 9). 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 to "F" (fast) position, wait a few minutes and try again.

NOTE: ALLOW ENGINE TO WARM UP FOR A FEW MINUTES BEFORE ENGAGING CLUTCH OF TRACTOR OR ATTACHMENT.

7. When restarting a warm engine, move Throttle Control halfway between "S" (slow) and "F" (fast) position. Choke may not have to be used.

TRACTOR OPERATION

1. With engine running and warm, place Throttle Control midway between "S" (slow) and "F" (fast) position.
2. Push Clutch Brake Pedal down firmly (Fig. 8). Move Gear Shift Control Lever to desired gear and Range Shift Lever to "LO" (Low) position (Fig. 9).
3. Release Clutch Brake Pedal SLOWLY to start forward or rearward movement.
4. If ground travel is too slow, move Throttle Control to "F" (fast) position or press Clutch Brake Pedal and shift to a different gear.

NOTE: BRING TRACTOR TO COMPLETE STOP BEFORE SHIFTING GEARS. ALWAYS SELECT A GROUND TRAVEL SPEED THAT WILL SUIT THE TERRAIN AND THE ATTACHMENT BEING USED.



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.



DO NOT OPERATE THE MOWER WITHOUT EITHER THE ENTIRE GRASS CATCHER, ON MOWERS SO EQUIPPED, OR THE DEFLECTOR SHIELD IN PLACE.

STOPPING YOUR TRACTOR

1. Push Clutch Brake Pedal into full "BRAKE" position.
2. Place Parking Brake Lever in "ENGAGED" position and release pressure from Clutch Brake Pedal should remain in brake position. NOTE: MAKE SURE PARKING BRAKE WILL HOLD TRACTOR SECURE.
3. Move Shift Control Lever to "NEUTRAL" position.
4. Place Attachment Clutch Lever in "DISENGAGED" position.
5. Move Throttle Control to "S" (slow) position.
6. 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 Control Lever and Range Shift Lever to "N" neutral position (Fig. 9). NOTE: DO NOT TOW YOUR TRACTOR FASTER THAN SIX MILES PER HOUR.

TRACTOR OPERATION ON HILLS

1. Choose the lowest gear BEFORE starting up or down hills.



DO NOT DRIVE UP OR DOWN HILLS WITH SLOPES GREATER THAN 16°, AND DO NOT DRIVE ACROSS ANY SLOPE. REFER TO PAGE 32.

2. AVOID STOPPING OR SHIFTING ON HILLS.

a. If slowing is necessary, move Throttle Control Lever to middle position.



LEAVE ENOUGH ROOM WHEN STOPPING AND STARTING TO ALLOW SLIGHT TRACTOR ROLL DOWNHILL AS CLUTCH-BRAKE PEDAL MOVES THROUGH CLUTCH POSITION.

b. If stopping is absolutely necessary, push Clutch Brake Pedal quickly to brake position and lock Parking Brake.

c. To restart your tractor, make sure tractor is in 1st gear and that you have allowed room to roll slightly downhill. Unlock Parking Brake and release Clutch Brake Pedal SLOWLY to start tractor forward movement.

3. Make all turns slowly.

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 GASES. KEEP SPARKS, FLAME, AND SMOKING MATERIALS AWAY FROM BATTERIES. ALWAYS WEAR EYE PROTECTION 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 fully charged 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 of tractor.
 - b. Negative terminal of fully charged battery.
 - c. Positive terminals.

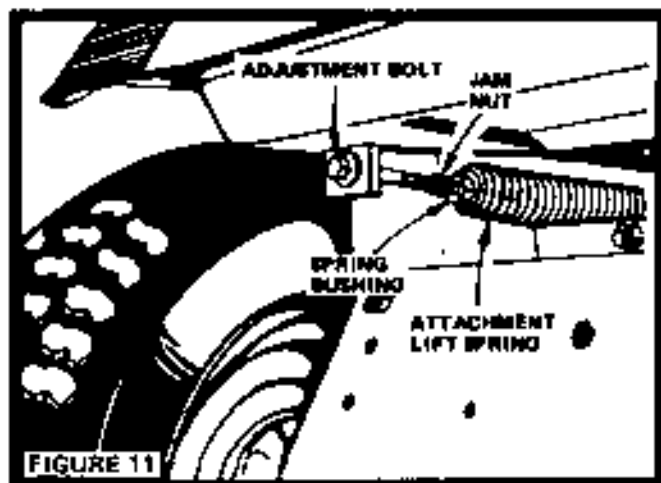


FIGURE 11

ATTACHMENT LIFT ADJUSTMENT

Due to different weights of Attachments, the Attachment Lift Spring may require adjustment. The Adjustment Bolt is located on rear of tractor top left side (Fig. 11).

1. Holding Spring Bushing with Wrench, loosen Jam Nut.
2. Turn Adjustment Bolt clockwise (↻) to extend Spring and reduce lift effort (for heavier Attachments).
3. Turn Adjustment Bolt counterclockwise (↺) (for light Attachments).
4. Retighten Jam Nut against Spring Bushing.

NOTE: DO NOT ADJUST FOR MAXIMUM SPRING TENSION WHEN USING LIGHT ATTACHMENTS SUCH AS A MOWER, ADJUST LIFT SPRING TO AID IN LIFTING ATTACHMENT. DON'T OVER POWER SPRING, WHEN REMOVING ATTACHMENT ALWAYS ADJUST WITH SPRING TENSION TO ITS LOWEST POSITION.

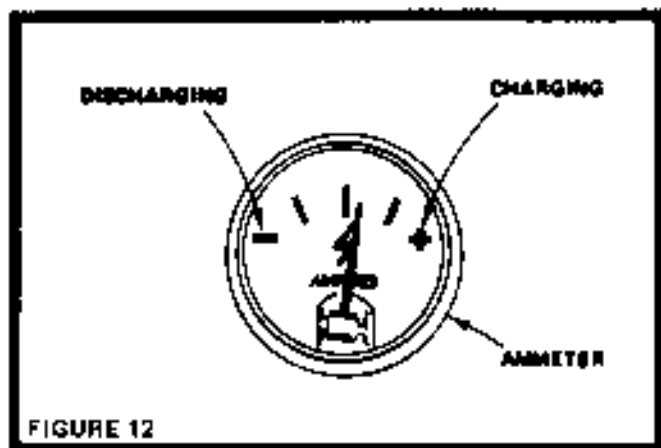


FIGURE 12

MAINTENANCE

To keep your tractor running better, longer, perform necessary service using the following Maintenance Schedule.

Each time you start your tractor, check your Ammeter (Fig. 12). The needle should move towards the + (charging) mark indicating the battery is being charged as you operate the tractor. The headlights will not show a discharge on the ammeter because they are not connected to the battery (they have their own electrical source, see page 14). If you have a lift motor connected it will show a discharge when being operated.



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

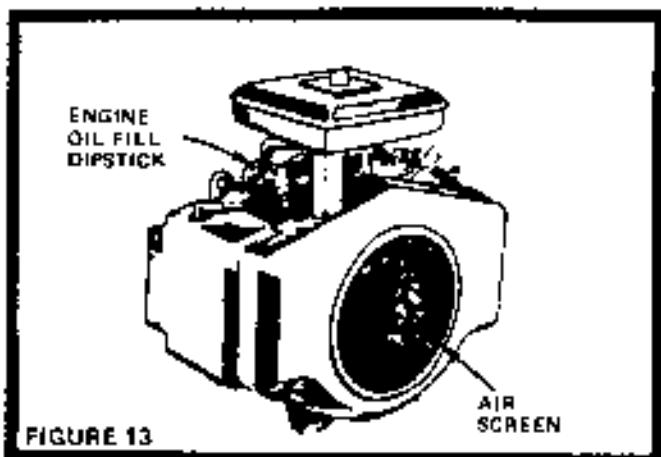


FIGURE 13

FIRST 2 HOURS

1. 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.

- a. The best time to drain Oil is with the Engine warm, when dirt and foreign material is suspended in the Oil. Unscrew Oil Drain Plug (Fig. 14) and catch Oil in a suitable container. Replace Plug.
- b. Refill Engine Oil (Fig. 13) In summer use S.A.E. 30 (SC, SD, SE or SF) Oil. In winter (below 32°F.) use S.A.E. 10W30 (SC, SD, SE or SF). In extreme cold (below 0°F.) use S.A.E. 5W20 (SC, SD, SE or SF). DO NOT USE 10W40 OIL. Refill capacity is 3 pints. **NOTE: DO NOT OVERFILL.**

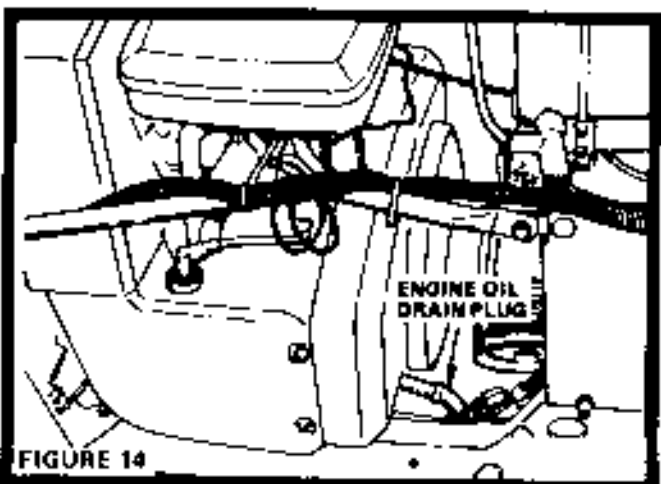


FIGURE 14

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. 13) 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, SE or SF) Oil. In winter (below 32°F) use S.A.E. 10W30 (SC, SD, SE or SF). In extreme cold (below 0°F) use S.A.E. 5W20 (SC, SD, SE or SF). DO NOT USE 10W40 OIL. NOTE: DO NOT OVERFILL.

EVERY 25 HOURS

(EVERY 15 HOURS IF OPERATING IN VERY DUSTY CONDITIONS)

1. CLEAN AIR FILTER

- Unscrew Knob (Fig. 16) to remove Cover.
 - Remove Nut and Washer to remove Cartridge Plate, Paper Cartridge and Oil Foam Pre-Cleaner.
 - Wash Foam Pre-Cleaner in detergent and water.
 - Rinse, squeeze (rather than twist) and allow to dry thoroughly.
 - Coat with three tablespoons of S.A.E. 30 Engine Oil, squeeze to distribute evenly, and squeeze out excess.
 - Check Paper Cartridge. Replace if excessively dirty.
 - Reassemble Paper Cartridge and re-position on Tractor.
- NOTE: NEVER RUN ENGINE WITH AIR CLEANER REMOVED AS DIRT (DUST) WILL DAMAGE THE ENGINE.

2. CLEAN AIR SCREEN

Air Screen (Fig. 18) must allow free-flow of air to prevent Engine damage from overheating. Clean with a wire brush, compressed air or water pressure to remove dirt, chaff, stubborn dried gum and fibers.

3. CHANGE ENGINE OIL

The best time to drain 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.

4. CLEAN FRONT GRILL SCREEN

The Front Grill Screen (Fig. 2) must allow free flow of air to prevent engine damage from overheating.

- Remove Grill Screen by removing two screws.
- Brush off debris.
- Replace Grill Screen and secure screws.

5. LUBRICATE STEERING AND FRONT WHEELS

There are four Grease Fittings on your Tractor (Fig. 15). Using a Grease Gun, give each Grease Fitting two shots of Extreme Pressure Lubricating Grease Amdex No. 1 or equivalent (available through your Sears Service Center).

6. OIL PIVOT POINTS

Place several drops of S.A.E. 30 Oil at points where parts move against each other, especially:

- Front Axle Pivot (Fig. 15)
- Hood Hinges.
- Foot Pedal Shaft (both ends) (Fig. 8)
- Lift Shaft (both ends) (Fig. 7).
- Steering Plate (Fig. 15).

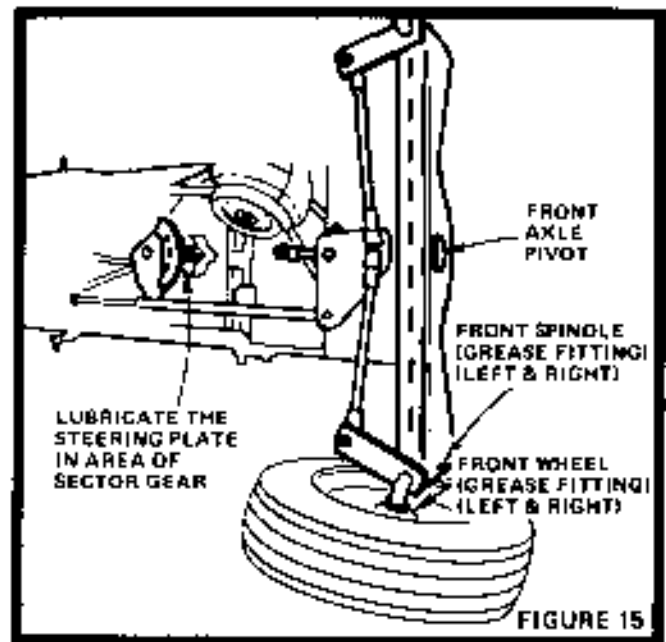


FIGURE 15

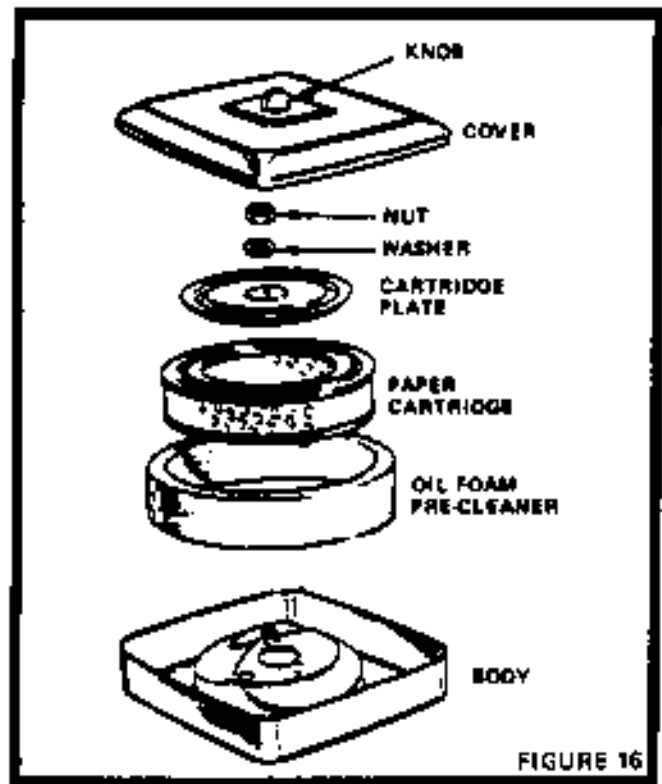


FIGURE 16

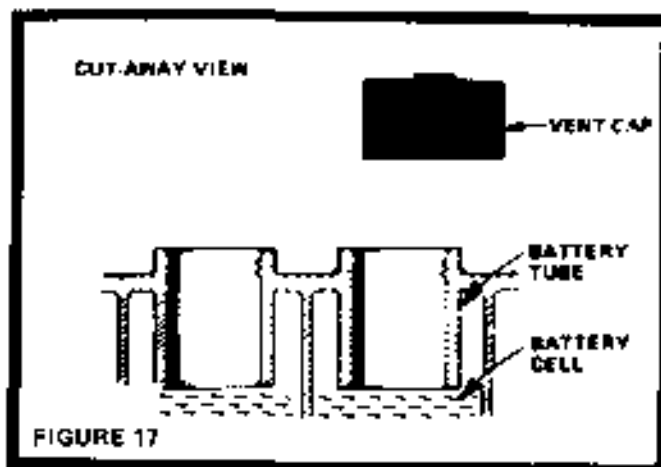


FIGURE 17

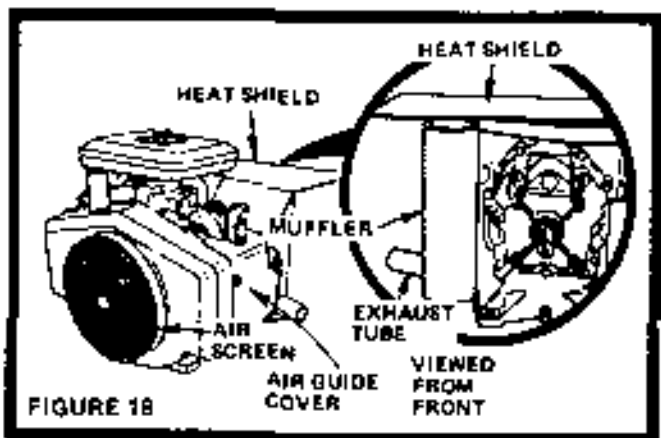


FIGURE 18

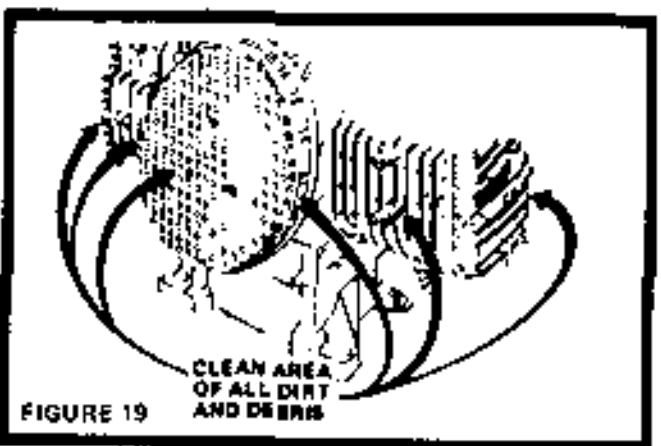


FIGURE 19

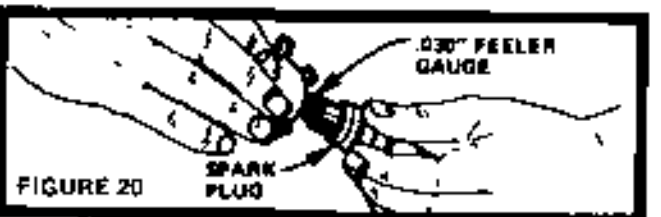


FIGURE 20

7. CHECK BATTERY

- Electrolyte solution level in each Battery Cell should be even with bottoms of tubes in cells (Fig. 17). Add distilled water if necessary. **NOTE: DO NOT OVERFILL.**
- Keep Battery and Terminals clean. Refer to step B.
- Keep Battery Bolts tight.
- Keep Vent Caps tight and small vent holes in Caps open.
- Recharge **SLOWLY** at 3 amperes if necessary.

B. 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.

- 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 SODA SOLUTION INTO THE CELLS.** Rinse the Battery with plain water, dry and re-install on Tractor.
- Clean terminals and cable ends with a wire brush until bright. Replace Battery Cables. Coat terminal connections with Vaseline.

EVERY 50 HOURS

1. CLEAN ENGINE COOLING FINS

Remove any dust, dirt or oil from Engine Cooling Fins to prevent Engine damage from overheating (Fig. 19). Air Guide Covers must be removed (Fig. 18).

2. MUFFLER

Do not operate the tractor without a Muffler (Fig. 18) or tamper with the exhaust system. Damaged Mufflers or spark arresters could create a fire hazard. Inspect periodically and replace if necessary. If your engine is equipped with a spark arrester screen assembly, remove every 50 hours for cleaning and inspection. Replace if damaged.

EVERY 100 HOURS

1. REPLACE SPARK PLUGS

Replace Spark Plugs at the beginning of each season or every 100 hours, whichever comes first. Gap should be set at .030 inch (Fig. 20).

2. LUBRICATE BALL JOINTS

- Move Rubber Boots to expose Ball Joints on Tie Rods and Steering Link (Fig. 23).
- Coat Ball Joints with Silicone Spray Lubricant.
- Reposition Rubber Boots.

EVERY 200 HOURS

1. REPLACE AIR CLEANER PAPER CARTRIDGE

Refer to page 7.

2. REPLACE IN-LINE FUEL FILTER

- Remove Hose Clamps from Fuel Lines at Fuel Filter (Fig. 22).
- Remove Fuel Filter (Fig. 22).
- Place new Fuel Filter in position with fuel line (arrow on side of Filter in direction of Fuel Filter) and reinstall Hose Clamps.

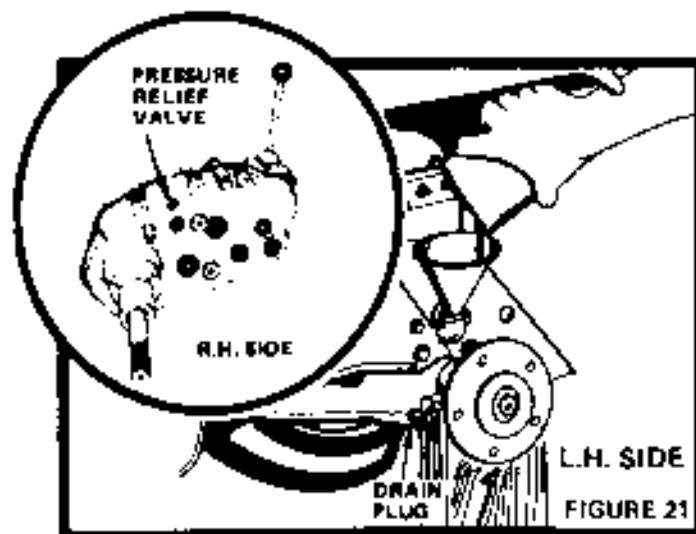


BE SURE THERE ARE NO FUEL LINE LEAKS AND THAT HOSE CLAMPS ARE PROPERLY INSTALLED.

EVERY 500 HOURS

1. CHANGE TRANSAXLE OIL

- Block up Rear Axle (Fig. 24) securely or use a Tractor Jack. Remove left Rear Wheel by removing Hub Bolts.
- Drain Transaxle Oil by removing Drain and Filler Plugs (Fig's. 21 & 24) and catching Oil in suitable container. Replace Drain Plug.
- Refill Transaxle with S.A.E. 30 (SC, SD or SE) Motor Oil. Capacity is 5 quarts. Pressure Relief Valve (R.H. side of Transaxle) (Fig. 21 - Inset) 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 Hub Bolts.



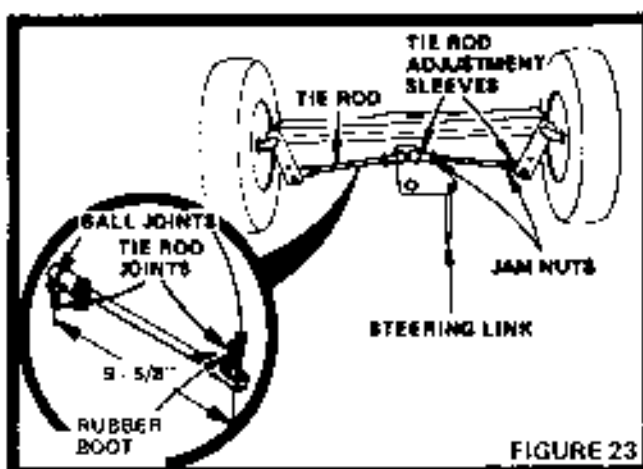
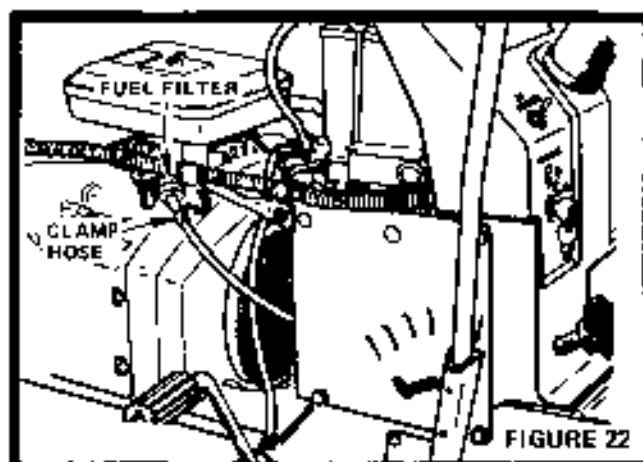
AS NEEDED

- Make sure all nuts and bolts are tight and cotter pins are secure. Observe all safety precautions. Keep Tractor well lubricated (refer to page 7).

2. TOE-IN ADJUSTMENT

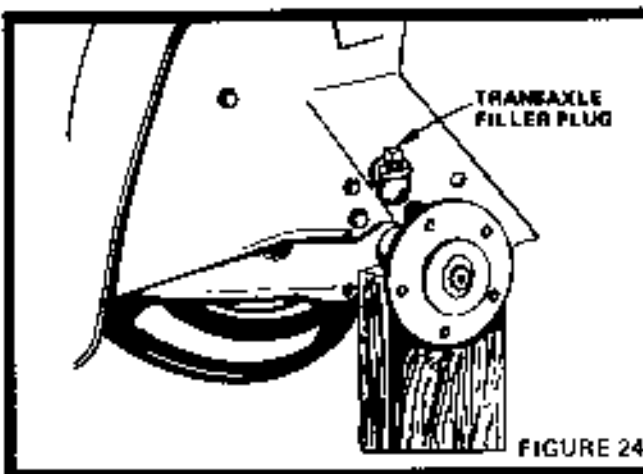
If any parts in Front Axle or Steering Mechanism are being replaced, Toe-in adjustment is required.

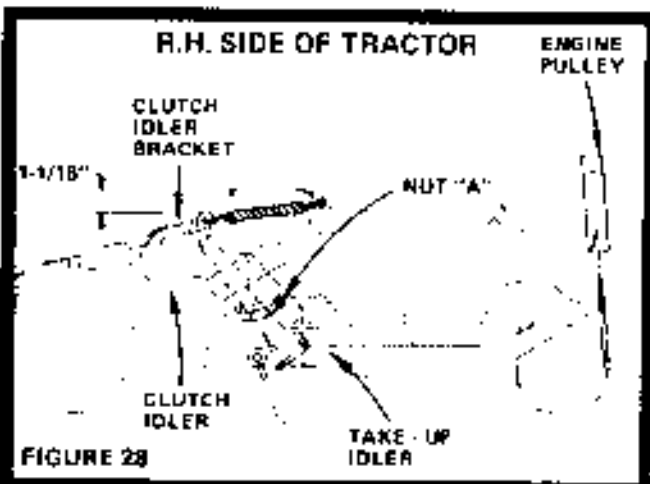
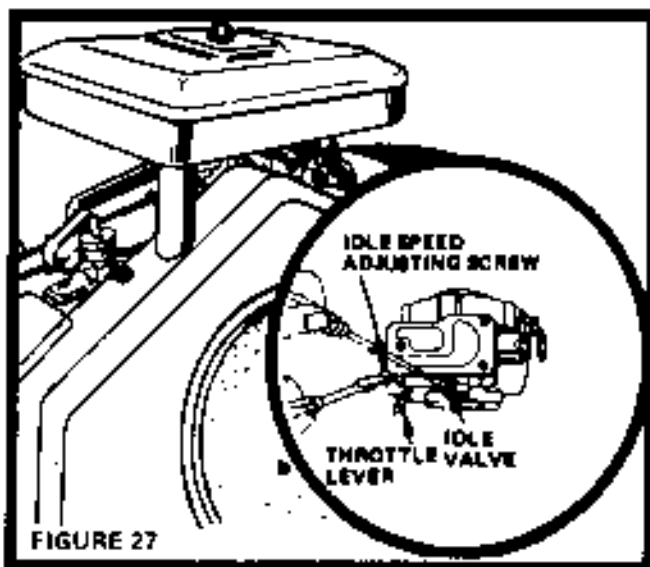
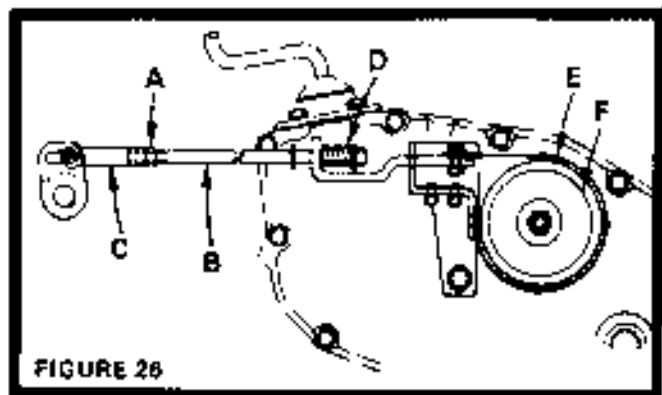
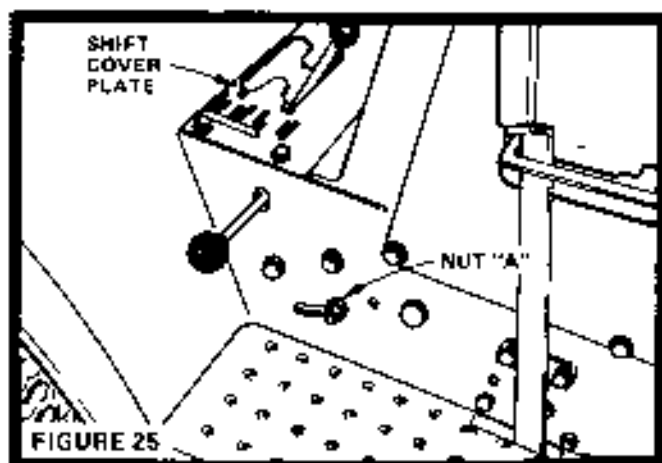
- Loosen Jam Nuts (Fig. 23) at each end of Tie Rod Adjustment Sleeves.
- Adjust both Tie Rods so that Tie Rod Joints measure 9 - 5/8" from center to center (Fig. 23).
- On front of front tires measure distance from center to center (measurement No. 1).
- On rear of front tires measure distance from center to center (measurement No. 2).
- Compare measurements - measurement No. 1 should be 1/8 - 1/4 less than measurement No. 2.
- If not adjust each Tie Rod equally to get correct measurement.
- 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. CHECK TRANSAXLE OIL LEVEL

- Remove Filler Plug (Fig. 24) from Transaxle. Oil Level should be even with Filler Plug threads. Add S.A.E. 30 Motor Oil if necessary.
- Check Pressure Relief Valve (Fig. 21 - Inset) located on R.H. side near top. It should spring completely closed when pulled out by hand and released.





4. BRAKE ADJUSTMENT



IF TRACTOR REQUIRES MORE THAN SIX FEET STOPPING DISTANCE IN HIGHEST GEAR ON A LEVEL DRY CONCRETE OR PAVED SURFACE THEN BRAKE MUST BE ADJUSTED.

- Remove (4) Hex Washer Head Tapping Screws from Shift Cover Plate (Fig. 25), located on top of tractor frame. Remove the Cover Plate.
- Loosen Jam Nut (A) on Brake Rod (B) at Clevis (C) (Fig. 26). If you find it difficult to loosen Jam Nut (A) (Fig. 26) remove Cover Plate (Fig. 8) in L.H. Frame Rail.
- Rotate Brake Rod (B) counterclockwise, (↺) turning Brake Rod out of Clevis (C) four to six turns (Fig. 26).
- Start tractor with Transmission in "NEUTRAL" position.
- Depress Brake-Clutch Pedal to the point where Belt (Fig. 28) stops moving. Hold Brake-Clutch Pedal in position by engaging Parking Brake (Fig. 9). If Belt begins to move after engaging Parking Brake, depress Brake-Clutch Pedal to next notch on Parking Brake.
- Shut engine off. Rotate Brake Rod (B) clockwise by hand, turning Brake Rod into Clevis (C), until tight. Tighten Jam Nut (A) on Brake Rod (B) at Clevis (C) (Fig. 26).
- Reinstall Shift Cover Plate and four (4) Mounting Screws. If Cover Plate was removed in step b it should be replaced.

5. CARBURETOR ADJUSTMENT

Never attempt to change maximum engine speed. This is preset at the factory and should only be changed by a qualified service technician who has the necessary equipment.

- High Speed is fixed, no adjustment is possible.
- Adjust Carburetor Idle Valve to suggested initial setting.
 - Turn Idle Valve clockwise (↻) closing finger tight ONLY, and then turn counterclockwise (↺) 1 1/2 turns (Fig. 27). CAUTION: Valve may be damaged if turned in too far.



REFER TO "STARTING THE ENGINE", PAGE 4.

- Start Engine and allow to warm for five minutes. Make final adjustments with Engine running.
 - With Throttle Control in "SLOW" position, hold Throttle Lever against Idle Stop and set Idle Speed Adjusting Screw to give an engine speed of 1400 RPM. Turn Idle Valve clockwise (↻) slowly until engine begins to miss and then open 1/2 turn counterclockwise (↺).
 - Set Idle Speed Screw to give engine speed of 900 RPM. When Throttle Lever is released from Idle Stop, engine speed should be between 1000 and 1400 RPM, controlled by governor.
- NOTE: ALL ABOVE SPEED AND FUEL MIXTURE ADJUSTMENTS MUST BE DONE WITH THE THROTTLE LEVER HELD AGAINST THE IDLE STOP AND AT SPEEDS NOTED.**

6. V-BELT ADJUSTMENT

A new V-Belt may stretch after the first few hours of operation resulting in loss of ground speed.

- To tighten Belt, remove (4) Hex Washer Head Tapping Screws from Shift Cover Plate (Fig. 25) located on top of tractor frame. Remove the Cover Plate.
- Place Parking Brake Lever in "ENGAGED" position. Refer to "Stopping Your Tractor" page 5.

- c. Loosen Nut "A" located on outside of R.F.L. Chassis Frame (Fig. 25), slide Take-Up Idler down approximately 1/2" and tighten Nut "A".
- d. Disengage Parking Brake.
- e. Check position of Clutch Idler Bracket (Fig. 28).
- f. Repeat steps b thru e until a 1 - 1/16" dimension is obtained.
- g. Tighten Nut "A" securely.
- h. Reinstall Shift Cover Plate and (4) Screws removed in step a.

7. V-BELT REPLACEMENT

BELT REMOVAL

The Belt on this tractor is special for this application. When replacing belts always replace with Sears belts.

- a. Disconnect Negative Ground Battery Cable.
- b. Set Parking Brake.
- c. Remove Belt Guard from Engine Pulley (Fig. 28B) and remove Belt from Engine Pulley.
- d. Remove (3) Bolts and Nuts holding Idler Sheaves to frame (Fig. 28A).
- e. Disassemble Dual Idler Sheaves and remove Belt (Fig. 28B).
- f. Loosen Nuts on Grooved Take-Up Idler and Flat Clutch Idler. Slip Belt free of Belt Guides (Fig. 28B).
- g. Remove Transaxle Belt Guard and remove Belt.

BELT REPLACEMENT

- a. Reassemble new Belt with Dual Idler Sheave Assembly.
NOTE: V-IDLER IS POSITIONED TOWARD THE INSIDE OF TRACTOR AND FLAT IDLER TO THE OUTSIDE. LOCATING TAB ON "V" IDLER BELT GUIDE MUST BE TOUCHING "V" IDLER BRACKET (FIG. 29 - L.H. INSET); LOCATING TAB ON FLAT IDLER BELT GUIDE MUST BE TOUCHING FLAT IDLER BRACKET (FIG. 29 - R.H. INSET).

- b. Position Belt on Grooved Take-Up Idler and Flat Clutch Idler (Fig. 28B). Tighten nuts.
- c. Assemble Belt to Transaxle. Reassemble Transaxle Belt Guard.
- d. Assemble Belt to Engine Pulley. Reassemble Engine Belt Guard.
- e. Reconnect Negative Ground Battery Cable.
NOTE: WHEN A NEW BELT IS INSTALLED, YOU MUST CHECK BELT ADJUSTMENT. REFER TO BELT ADJUSTMENT.

8. TIRE CARE

- a. Maintain tire pressure in front at 14 pounds and rear tires at 10 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. 30).
 - Block up front axle securely.
 - Remove Klip Ring and Washer to allow wheel removal.
 - Repair tire and reassemble. Replace washer and snap Klip Ring securely in axle groove.
- e. Removing rear wheel for tire repair.
 - Block up rear axle securely.
 - Remove (5) Hub Bolts to allow wheel removal.
 - Repair tire and reassemble. Replace and tighten Hub Bolts securely.



WHEN MOUNTING TIRES, UNLESS BEADS ARE SEATED, OVERINFLATION CAN CAUSE A FATAL EXPLOSION.

9. FINISH

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

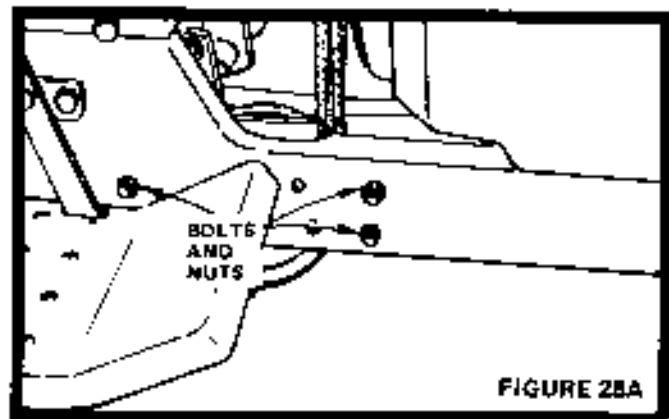


FIGURE 28A

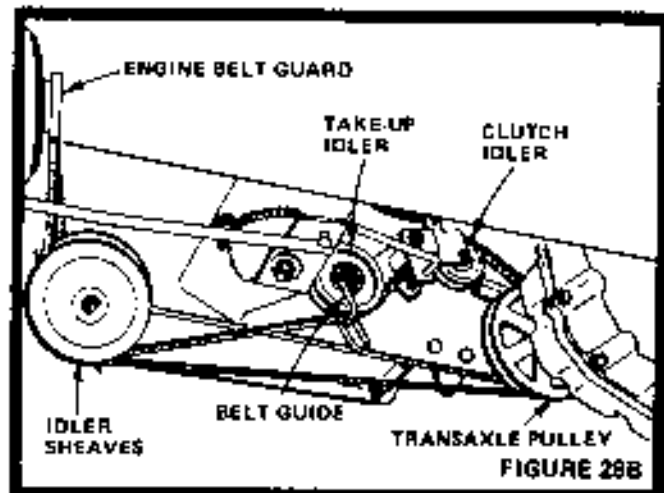


FIGURE 28B

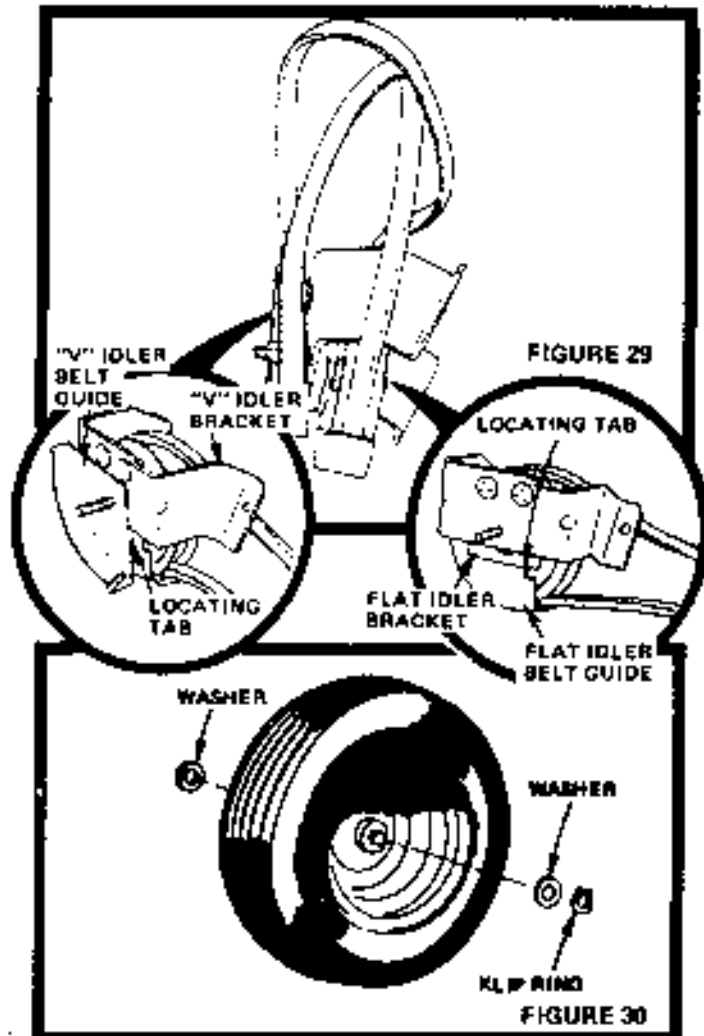


FIGURE 29

FIGURE 30

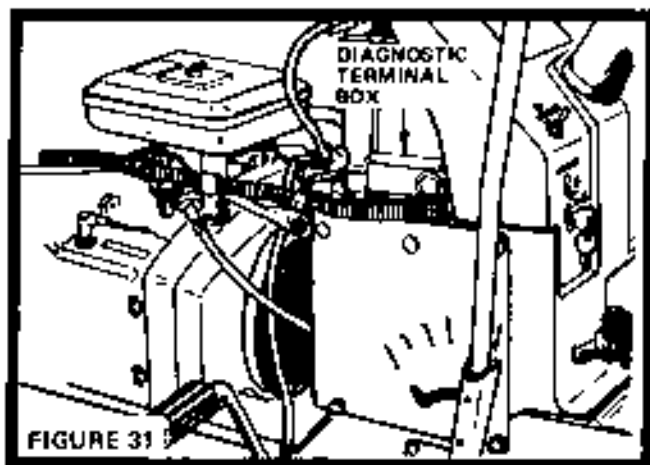


FIGURE 31

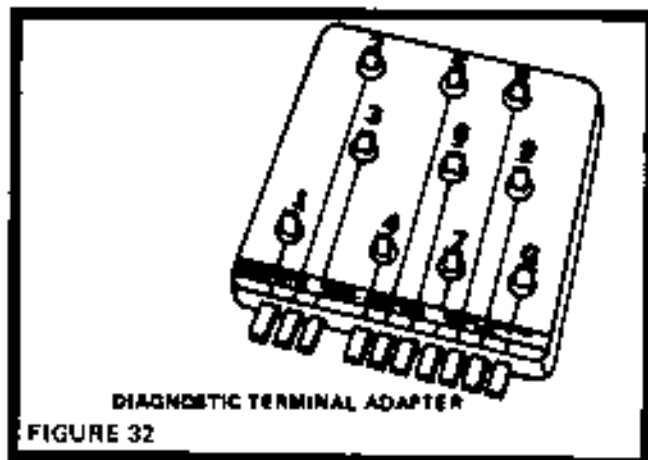


FIGURE 32

10. DIAGNOSTIC TERMINAL BOX

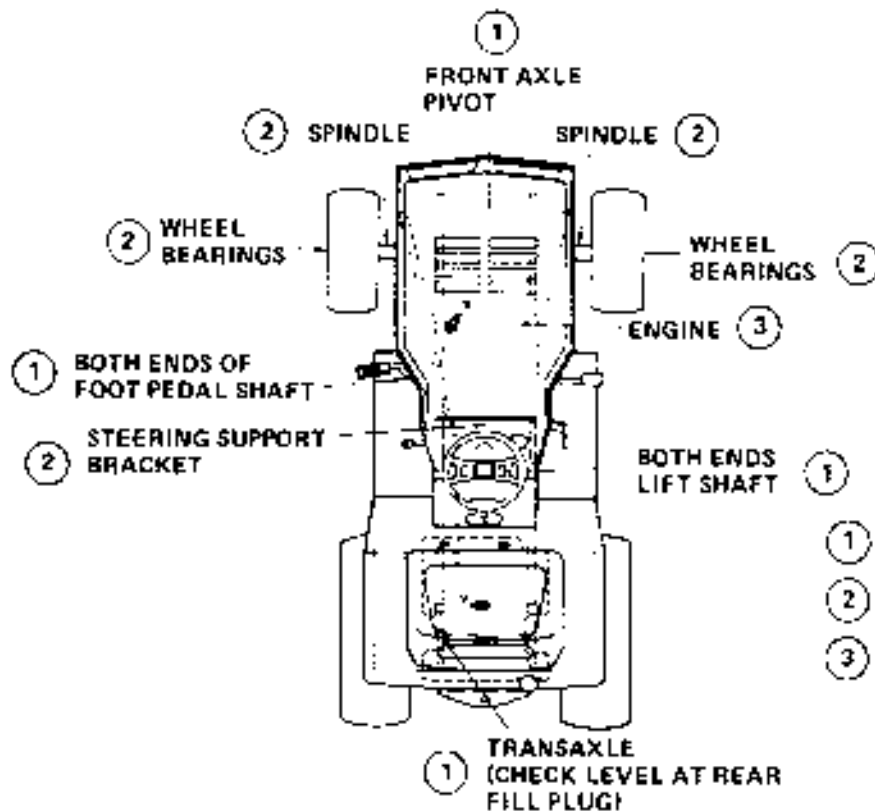
a. Your Tractor is equipped with a Tractor Diagnostic Terminal Box which is used to simplify electrical system diagnosis. The location of the Diagnostic Terminal Box is shown in Fig. 31. The Diagnostic Terminal Box provides access to a number of test points within the electrical system of the tractor.

NOTE: WHEN USING THE DIAGNOSTIC TERMINAL BOX - ENGINE TO BE STOPPED AND IGNITION OFF. USE PROPER EQUIPMENT IN THE CHECKING OF ELECTRICAL SYSTEM THROUGH THE DIAGNOSTIC TERMINAL BOX.

b. The Diagnostic Terminal Box is designed to accept the Diagnostic Terminal Adapter (optional) (Fig. 32), which is available from Sears (Part No. 677A823). If you order the Adapter, also order the Test Procedure Manual (Manual No. B441J), showing diagnostic procedures and components of electrical circuits.

c. To perform the testing with the Diagnostic Terminal Box, a quality multimeter or automotive analyzer is required.

LUBRICATION CHART



- ① SAE 30 MOTOR OIL
- ② EXTREME PRESSURE LUBRICATING GREASE AMDEX NO. 1
- ③ REFER TO ENGINE OIL SPEC'S. (UNDER INITIAL PREPARATION IN OWNERS MANUAL)

TROUBLE SHOOTING

POSSIBLE CAUSE	POSSIBLE REMEDY
WILL NOT START Clutch-Brake Pedal in drive position Attachment Clutch Lever in "ENGAGED" position No gasoline in Fuel Tank or clogged Fuel Line or Fuel Filter Blown Fuse Dead Battery Defective Ignition or loose Wiring Spark Plug fouled	Push Pedal into brake position (Fig. 8) Move Lever in "DISENGAGED" position (Fig. 7). Fill Tank with fresh Gasoline. Check Fuel Line (Fig. 22) and Carburetor (clean if necessary) Check for fault and replace Fuse Recharge or replace Battery Check Wiring Replace Spark Plug and adjust gap (Fig. 20)
HARD TO START Choked, improperly, flooded Engine Clogged Fuel Tank, Fuel Line, or Fuel Filter Spark Plug fouled Defective Battery Defective Ignition or loose wiring Water in gasoline or old fuel Improper Carburetor adjustment Poor compression	Place Throttle Control in fast position (Fig. 9) and run starter several times to clean out gas Remove and clean (Fig. 22) Replace Spark Plug and adjust gap (Fig. 20) Recharge or replace Check the wiring and Spark Plug Drain Fuel Tank and Carburetor, use fresh fuel and replace Spark Plug Make necessary adjustments (Fig. 27) Major engine overhaul
ENGINE MISSES OR LACKS POWER Engine overloaded Clogged Fuel Filter Clogged Fuel Tank Partially plugged Air Cleaner Improper Carburetor adjustment Dirty Air Screen Low oil level Spark Plug fouled, improper gap or wrong type Faulty ignition Poor compression Gasoline in oil Dirty Air Cleaner	Shift to a lower gear or reduce load Remove and replace (Fig. 22) Remove and clean Remove and clean (Fig. 16) Make necessary adjustments (Fig. 27) Clean Air Screen, Cylinder Fins (Fig. 18) & Muffler area Add or change oil (Fig. 14) Replace Spark Plugs and adjust gap (Fig. 20) Check Spark Plugs and for any loose wires Major Engine overhaul Drain Engine oil and refill Remove and clean (Fig. 16)
ENGINE OVERHEATS Dirty Air Screen Low oil level Dirty Engine Partially plugged Muffler Improper Carburetor adjustment	Clean Air Screen (Fig. 13) Add or change oil (Fig. 14) Clean Cylinder Fins, rotating Screen and Muffler area Remove and clean Muffler (Fig. 18) Adjust Carburetor (Fig. 27)
NO LIGHTS No Headlight with Light Switch in "ON" position and engine running	Check Wire Connections and Switch. Replace Light Bulbs
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

NOTE: THE USE OF A FUEL ADDITIVE, SUCH AS STABIL, OR AN EQUIVALENT, WILL MINIMIZE THE FORMATION OF FUEL GUM DEPOSITS DURING STORAGE. SUCH AN ADDITIVE MAY BE ADDED TO THE GASOLINE IN THE FUEL TANK OF THE ENGINE, OR TO THE GASOLINE IN A STORAGE CONTAINER.

If Sta-Bal is not used all fuel should be removed from fuel tank.

a. 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.

b. Dispose of gasoline if not to be used. NOTE: GASOLINE STORED FOR SEVERAL MONTHS LOSES ITS VOLATILITY (ABILITY TO BURN EFFECTIVELY).

3. CYLINDERS

a. Remove Spark Plugs.

b. Pour one ounce of oil through spark plug holes into cylinders.

c. Turn Ignition Key to "START" position for a few seconds to distribute oil.

d. Replace with new Spark Plugs.

4. BATTERY

a. 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 CONCRETE SURFACE

b. Recharge each month if necessary. NOTE: BATTERIES NOT IN USE FOR SEVERAL MONTHS AND NOT KEPT FULLY CHARGED, PRODUCE SULPHATE DEPOSITS ON PLATES WHICH CANNOT BE REMOVED BY RECHARGING

5. GENERAL CLEANING

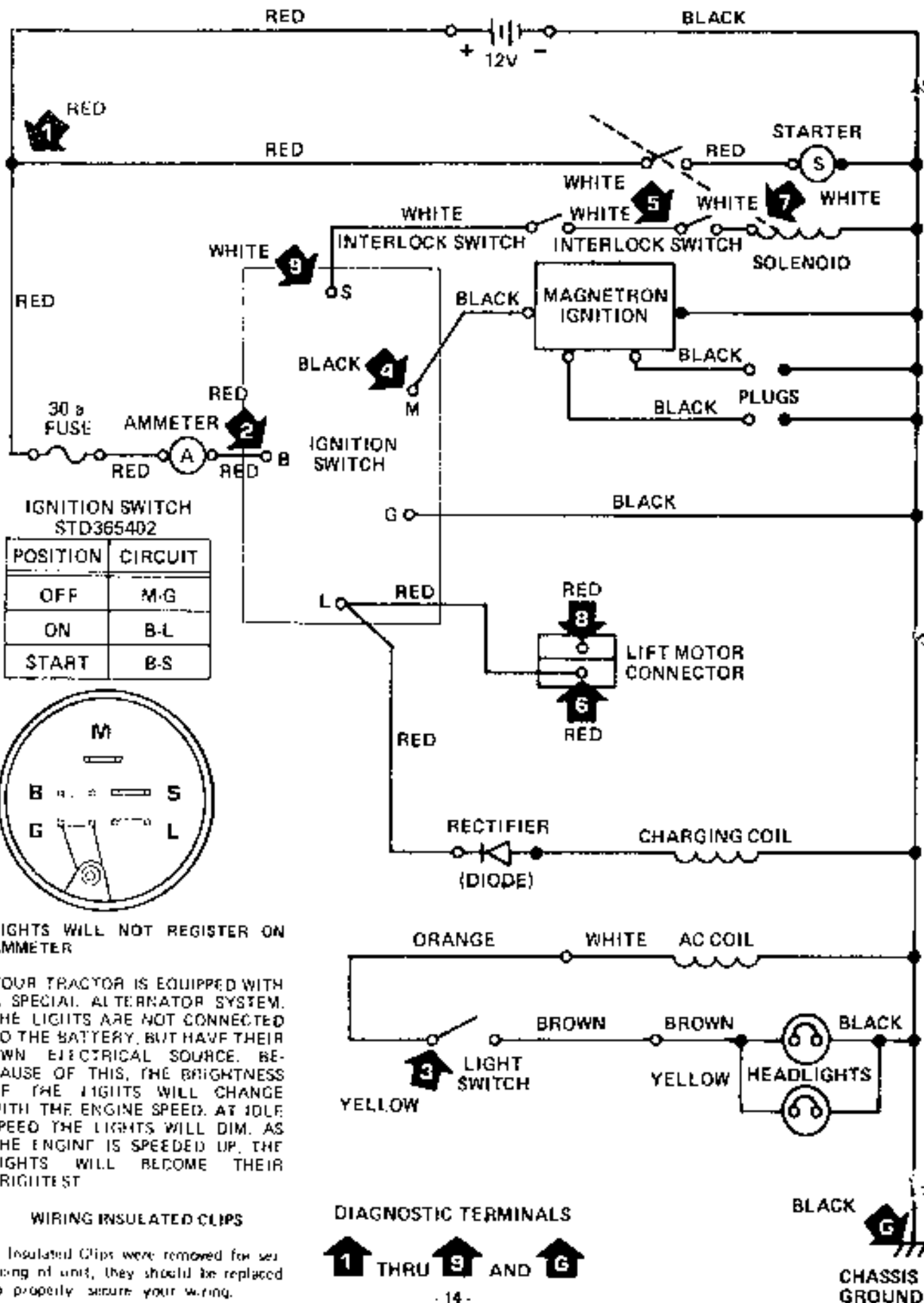
Clean engine, battery, seat, finish, etc. of all foreign matter.

6. STORE IN A CLEAN AND DRY AREA.

Seas, Roebuck and Co. reserves the right to make any changes in design or improvements without imposing any obligation to install the same upon its items heretofore manufactured.

REPAIR PARTS

SEARS GT/18 TWIN MODEL NUMBER 917.253744



LIGHTS WILL NOT REGISTER ON AMMETER

YOUR TRACTOR IS EQUIPPED WITH A SPECIAL ALTERNATOR SYSTEM. THE LIGHTS ARE NOT CONNECTED TO THE BATTERY, BUT HAVE THEIR OWN ELECTRICAL SOURCE. BECAUSE OF THIS, THE BRIGHTNESS OF THE LIGHTS WILL CHANGE WITH THE ENGINE SPEED. AT IDLE SPEED THE LIGHTS WILL DIM. AS THE ENGINE IS SPEEDED UP, THE LIGHTS WILL BECOME THEIR BRIGHTEST

WIRING INSULATED CLIPS

If Insulated Clips were removed for servicing of unit, they should be replaced to properly secure your wiring.

DIAGNOSTIC TERMINALS

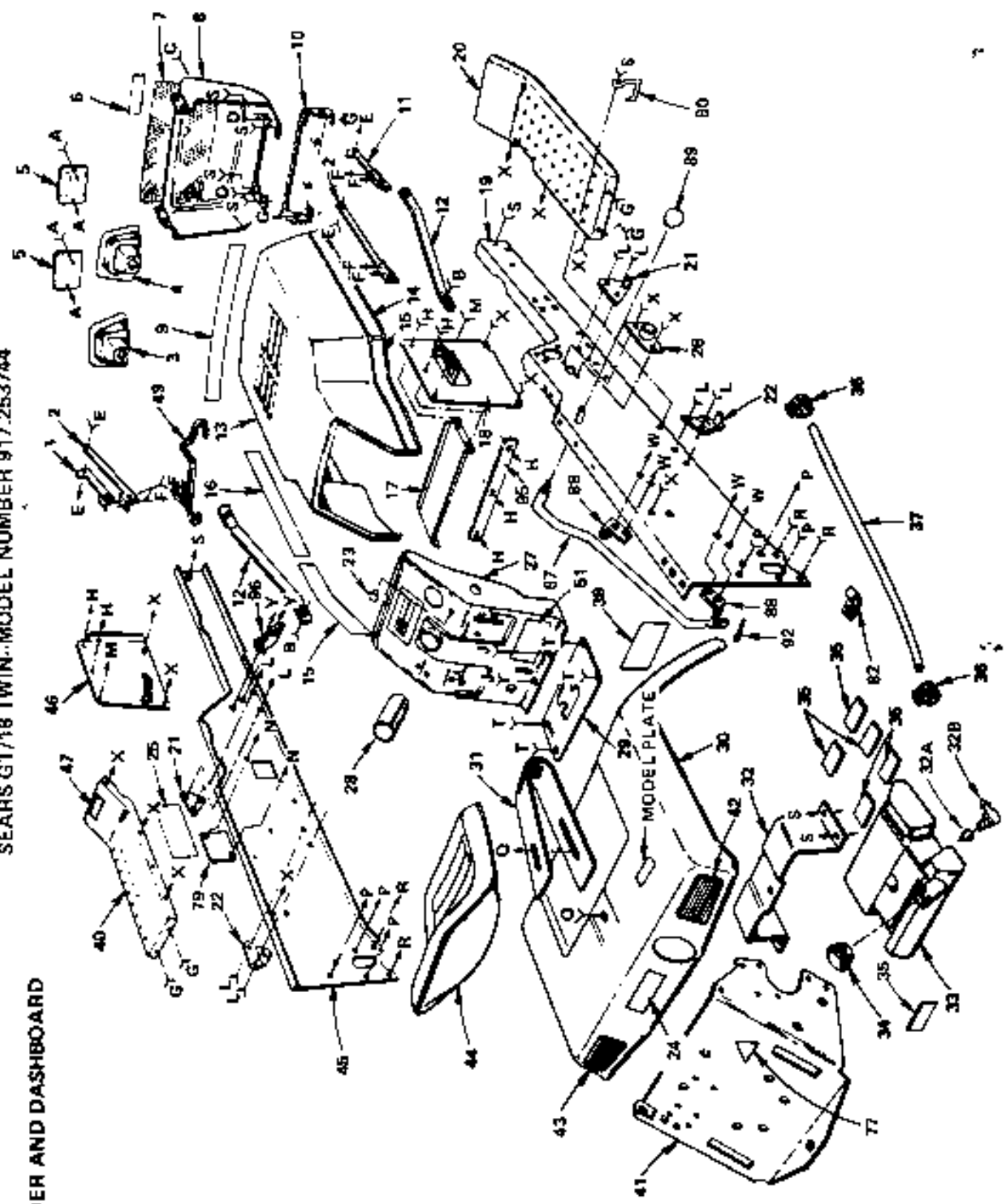
1 THRU 3 AND 6

BLACK
7
CHASSIS GROUND

REPAIR PARTS

SEARS GT/18 TWIN..MODEL NUMBER 917.253744

CHASSIS, FENDER AND DASHBOARD



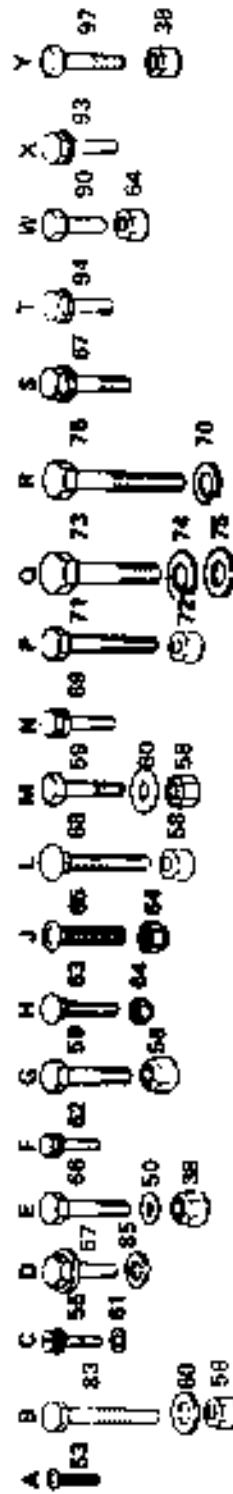
REPAIR PARTS

SEARS GT/18 TWIN-MODEL NUMBER 917 253744

CHASSIS, FENDER AND DASHBOARD

KEY NO.	PART NO	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	677A875	Strap Assembly - Hinge	33	3616J	Tank - Fuel	66	7605J	Bolt - Shoulder 1/4 - 20
2	677A432	Strap Assembly - Hinge	34	4808J	Cap - Fuel	67	17490612	Screw - Hex Washer Hd Type TT Thread Rolling 3/8 - 16 x 3/4
3	678H570	Bezel - L.H.	35	6431J	Pad - Spacer			Bolt - Rd. Hd. Sq. Nk. Carriage 3/8 - 16 x 3/4 Gr. 5
4	678H571	Bezel - R.H.	36	6999R	Clamp - Hose	68	72140608	Screw - Hex Thd Cutting 1/4 - 20 x 1/2
5	3600J	Lens - Headlamp	37	100346K	Fuel Line	69	17720408	Screw - Hex Thd Cutting 1/4 - 20 x 1/2
6	101232L	Logo - Decal	38	7368U400	Nut - Crownlock 1/4 - 20	70	STD551143	*Lockwasher 7/16
7	101235L	Screws - Grill	39	4910J	Decal - Caution	71	74760715	Bolt - Hex 7/16 - 14 x 1
8	677H937	Grill	40	677H787	Foot Rest - L.H.	72	7368K700	Nut - Crownlock 7/16 - 14
9	7091J	Decal - Strip Hood Front	41	678H624	Drawbar Assembly	73	510525010	*Bolt - Hex 1/2 - 13 x 1 Gr. 5
10	677H4983	Bracket - Frame, Front	42	4903J	Decal - Reflector R.H.	74	STD551150	Lockwasher 1/2
11	677A876	Strap Assembly - Hinge	43	4902J	Decal - Reflector L.H.	75	19171912	Washer 17/32 x 1 3/16 x 12 Ga.
12	100725M	Brace - Grill	44	476J	Seat	76	74760740	Bolt - Hex 7/16 - 14 x 2 - 1/2
13	678H108	Hood	45	104700X	Rail - Frame L.H.	77	5224J	Safety Standard Stocker Plate Cover
14	7052J	Decal - Strip Hood R.H.	46	678H611	Panel - Side L.H.	78	678H729	Plate Cover
15	4904J	Decal - Strip Hood	47	4900J	Decal Clutch/Brake	79	101361K	Retainer - Bolt, Lower
16	7090J	Decal - Strip Hood L.H.	48	5592J	Guard Belt, Main Dr.	80	27511R	Clip - Fuel Line
17	678H4614	Support - Battery	49	19090816	Washer 9/32 x 1/2 x 16 Ga.	81	74760814	Bolt - Hex 3/8 - 16 x 7/8
18	678H4610	Panel - Side R.H.	50	8497J	Decal Instruction	82	19131614	Washer 13/32 x 1 x 14 Ga
19	104689X	Rail - Frame R.H.	51	17990808	Screw - Cross Recess Pan Hd. No. 8 - 18 Hi. - Lo x 1/2	83	101345M	Rod Shift Hi. - Lo
20	678H433	Foot Rest - R.H.	52	17511208	Screw - Hex Slotted Hd. Packaged Self Tapping Type AB No. 12 x 1/2	84	101346K	Bracket - Rod, Shift Hi. - Lo
21	678H447	Bracket Ass'y. - Hanger, Front	53	17490616	Screw - Hex Washer Hd. Thd. Rolling 3/8 - 16 x 1	85	100196K	Knob
22	678H760	Bracket Ass'y. - Hanger, Rear	54	73680600	Nut Crownlock 3/8 - 16	86	STD523107	*Bolt - Hex 5/16 - 18 x 3/4 Gr. 5
23	8022J	Plug - Dash	55	STD523707	*Bolt - Hex 3/8 - 16 x 3/4	87	76970616	Cotter Pin 3/16 x 1
24	7178J	Decal - Caution	56	8018J	Washer 7/32 x 5/8 x 16 Ga.	88	17490608	Screw - Hex Washer Hd. Thd. Rolling 3/8 - 16 x 1/2 Type TT
25	101363X	Decal - Feature	57	17411310	Screw - Hex Washer Head No. 13 - 16 Hi. - Lo x 5/8	89		Screw - Hex Washer Thd. Cutting 1/4 - 20 x 1/2
26	678H4643	Bracket Lever, Control	58	72140506	Bolt Round Hd. Square Neck Carriage 5/16 - 18 x 3/4 Gr. 5	90	7959J	Support - Guard
27	8017J	Dash	59	73680500	Nut - Crownlock 5/16 - 18	91	104601X	Bracket - Switch
28	100714L	Sleeve - Steering Cover, Shift - Gate	60	74180512	Screw - Truss Hd. Cross Recess 5/16 - 18 x 3/4	92	STD522507	*Bolt - Hex 1/4 - 20 x 3/4
29	101365X	Fender	61			93		
30	677H788	Fender	62			94		
31	677H779	Spring - Seat	63			95		
32	677H778	Bracket Ass'y. - Fender	64			96		
32A	3645J	Bushing	65			97		
32B	6710J	Stem - Tank, Fuel						

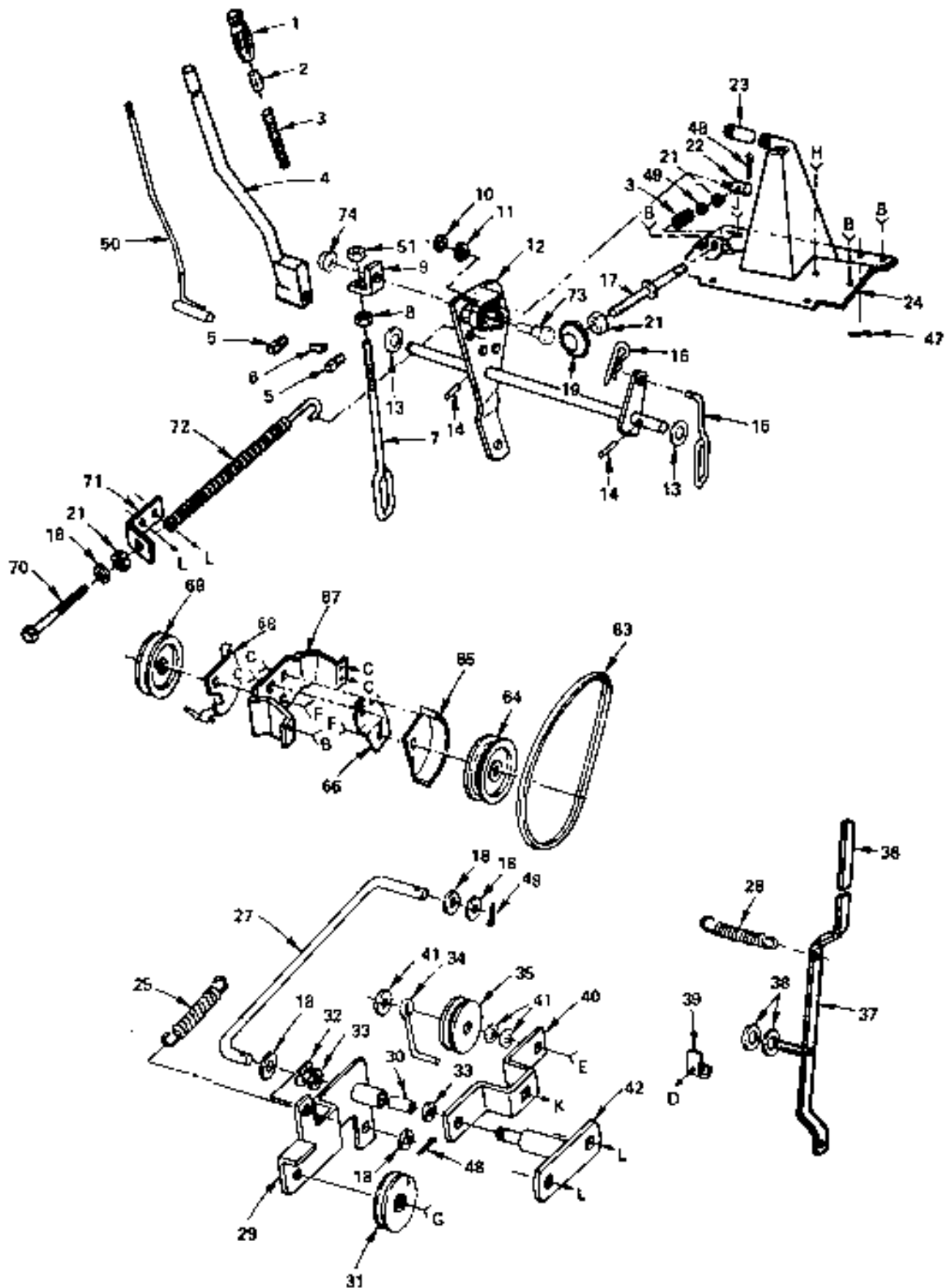
*STANDARD HARDWARE - PURCHASE LOCALLY



REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744

LEVER CONTROLS



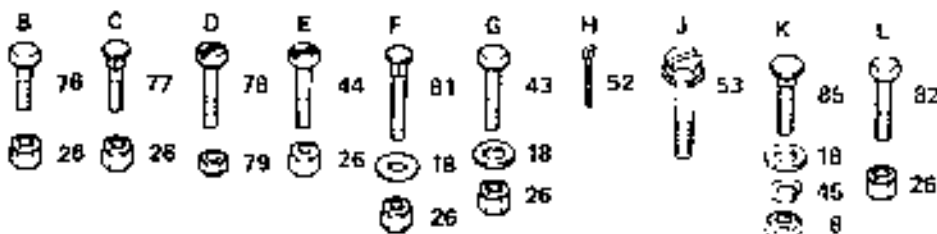
REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744

LEVER CONTROLS

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	2895K	Grip - Handle	37	104564X	Shaft Assembly - Lever, Control
2	8016J	Plunger - Lever, Hand	38	19171216	Washer 17/32 x 3/4 x 16 Ga.
3	2876H	Spring	39	5348J	Actuator, Interlock
4	104569X	Lever Assembly, Hand Kit Inc. Key No's. 2, 3 and 2 each 51	40	101347L	Bracket - Flat Idler
5	23180606	Set Screw - Hex Socket Forged 3/8 - 16 x 3/8 Nylon Patch	41	19131413	Washer 13/32 x 7/8 x 13 Ga.
6	8330H	Key - Woodruff 1/4 x 1	42	101358K	Bracket Assembly - Clutch
7	7598J	Link - Lift, L.H.	43	STD523715	* Bolt - Hex 3/8 - 16 x 1 - 1/2
8	STD541037	* Hex Nut 3/8 - 16	44	STD523720	* Bolt - Hex 3/8 - 16 x 2
9	7594J	Bracket - Lift, L.H.	45	STD551137	* Lockwasher, 3/8
10	12000037	E - Ring	47	76020816	Cotter Pin 1/4 x 1
11	19151216	Washer 15/32 x 3/4 x 16 Ga.	48	STD500907	* Cotter Pin 3/32 x 3/4
12	104448X	Shaft Assembly - Lift	49	19131016	Washer 13/32 x 5/8 x 16 Ga.
13	19292016	Washer 29/32 x 7/8 x 16 Ga.	50	674A249	Rod Assembly - Lever
14	5142H	Pin - Roll 3/16 x 1 - 1/4	51	73600600	Nut - Lock w/Washer 3/8 - 16
15	8488J	Link - Lift, R.H.	52	76020616	Pin - Cotter 3/16 x 1
16	4839M	Spring, Retaining	53	17490612	Screw - Hex Washer Hd. Tld. Hd. Inc. 3/8 - 16 x 3/4 Type TT
17	100735K	Rod - Lift, Adjustment	63	101342N	1/2-Belt
18	STD551037	* Washer 13/32 x 13/16 x 16 Ga.	64	2083R	Flat Idler
19	100734K	Handle - Adjust, Lift	65	5256J	Guide - Belt, Flat Idler
21	STD541237	* Nut - Hex, Jam 3/8 - 16	66	5255J	Bracket - Flat Idler
22	678H450	Yrunion - Stop Depth	67	5252J	Bracket - "V" Idler
23	9038R	Bearing	68	102671X	Guide - Belt, "V" Idler
24	101274N	Support Assembly - Dash. Steering	69	101344L	Pulley - "V" Idler
25	101355X	Spring - Extension	70	5328J	Bolt - Adjust, Spring, Assist
26	73680600	Nut - Crownlock 3/8 - 16	71	678H445	Bracket - Spring, Assist
27	101356L	Rod - Clutch	72	678H641	Spring Assembly - Assist, Lift
28	101276L	Spring - Extension	73	7901J	Shoulder Bolt
29	101349L	Bracket Assembly - Clutch w/Bearing	74	73900400	Flanged Hex Locknut 1/4 - 20
30	101350K	Bearing - Idler	76	STD523707	* Bolt - Hex 3/8 - 16 x 3/4
31	8646R	Idler - Grooved	77	72140606	Bolt - Round Hd. Sq. Nk. Carriage 3/8 - 16 x 3/4 Gr. 5
32	12000039	Clip Ring	78	STD511010	* Screw - Hex No. 10 - 24 x 1
33	207J	Washer, Hardened	79	73631000	Nut - Lock No. 10 - 24
34	101348L	Retainer - Belt, Flat Idler	81	72140614	Bolt - Rd. Hd. Short Sq. Nk. Carriage 3/8 - 16 x 1 - 3/4 Gr. 5
35	104360X	Idler - Flat	82	STD523710	* Bolt - Hex 3/8 - 16 x 1 Gr. 5
36	4617J	Grip - Handle	85	72140608	Bolt - Rd. Hd. Sq. Nk. Carriage 3/8 - 16 x 1

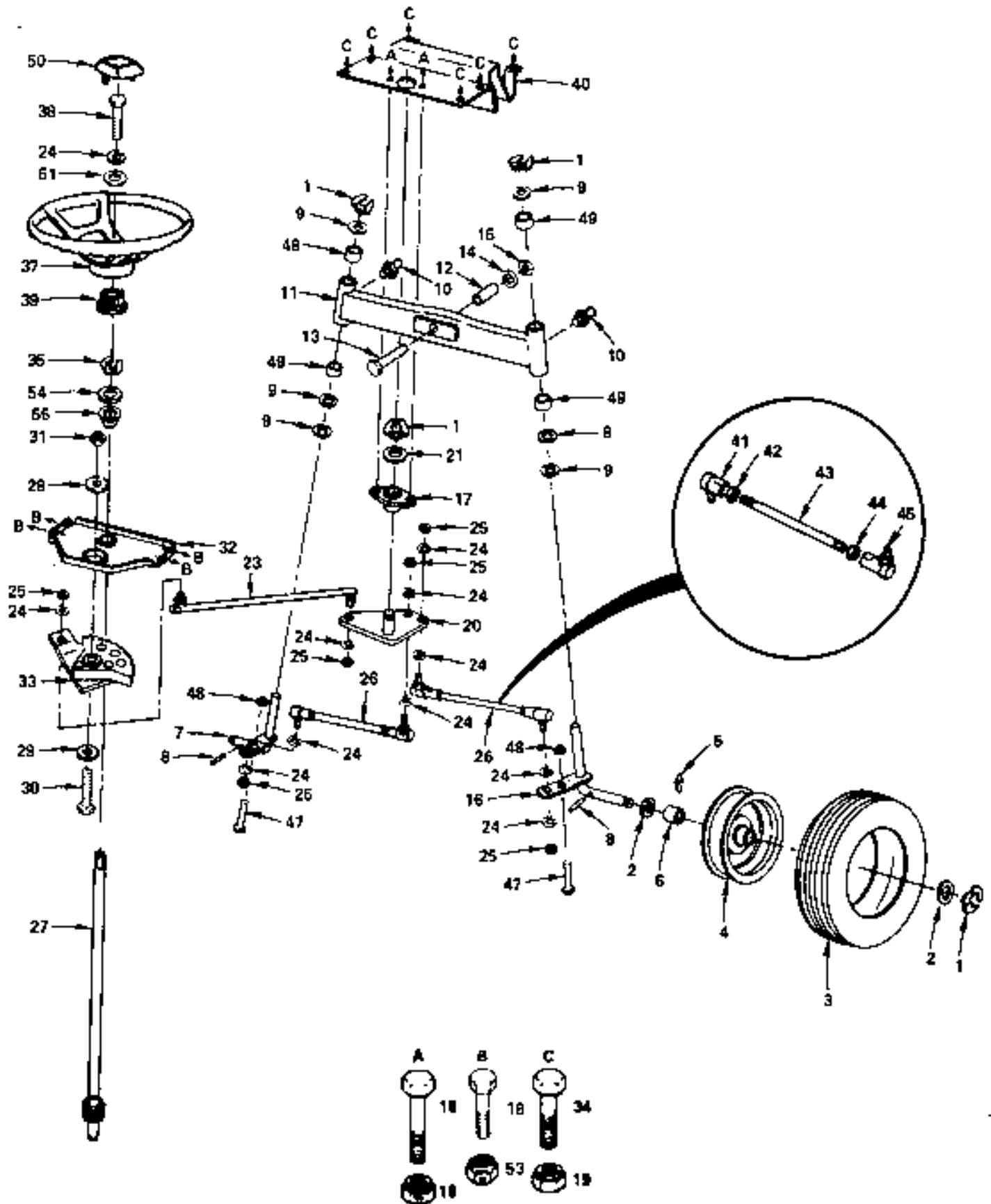
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REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744

STEERING



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REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744

STEERING

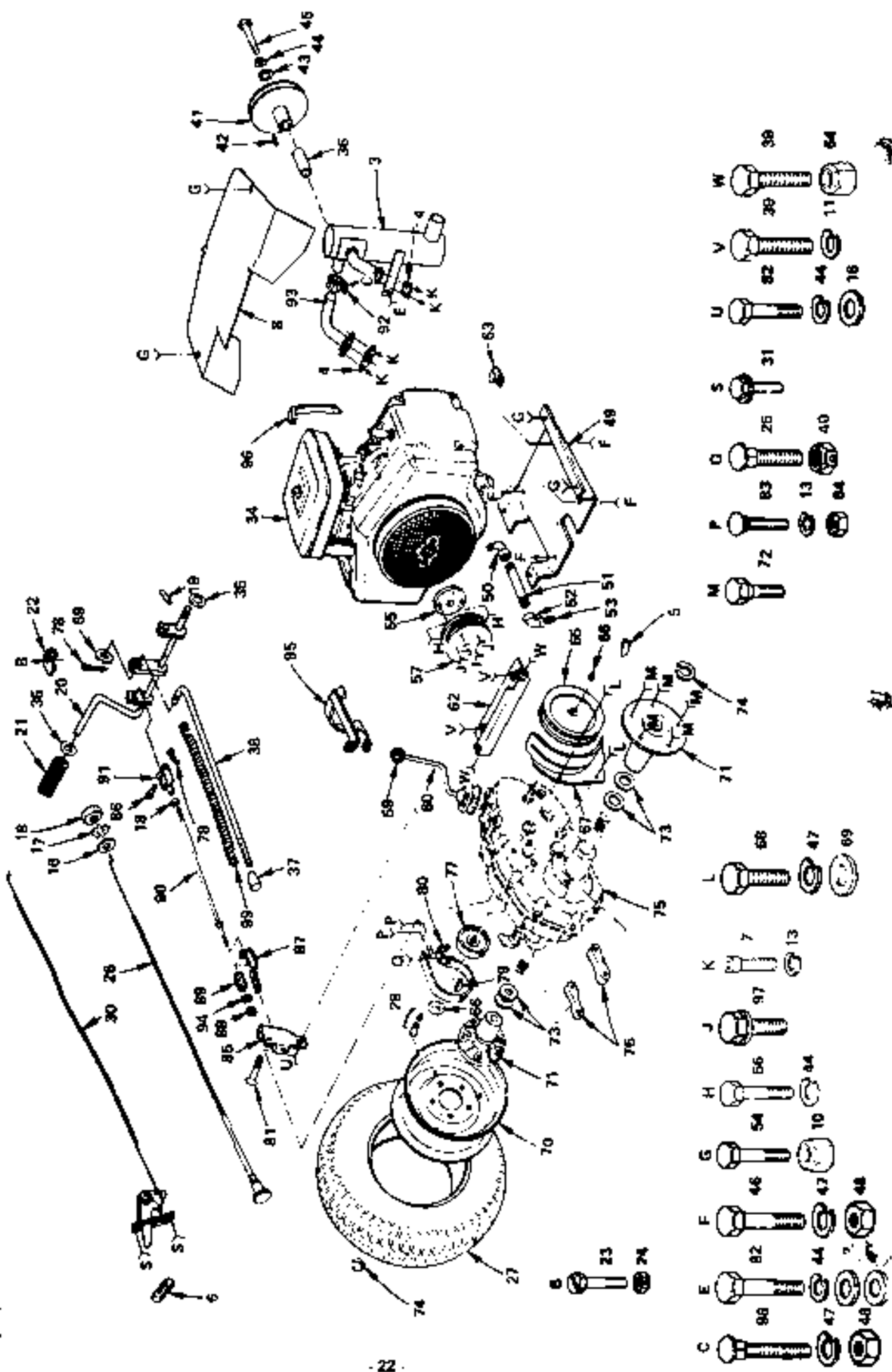
KEY NO.	PART NO.	DESCRIPTION
1	12000029	Clip Ring
2	19252016	Washer 3/2 x 1 - 1/4 x 16 Ga.
3	3641J	Tire - 16 x 6.50
...	4445-41	Tube - Tire (not furnished with Tractor)
4	9541R	Front Wheel (Inc. Key No. 5 & 2 of Key No. 6)
5	8858M	Grease Fitting
6	9040H	Flanged Bearing
7	678H616	Spindle Assembly, L.H.
8	9530R	Pin - Groove, 3/16 x 1 - 1/4
9	6266H	Race - Thrust
10	8855M	Fitting - Grease
11	674A244	Axle Assembly - Front (with Bearings)
12	5296J	Tube - Pivot, Axle
13	74781044	Bolt - Hex 5/8 - 11 x 2 - 3/4 Gr. 5
14	STD551162	* Lockwasher 5/8
15	STD541062	* Nut - Hex 5/8 - 11
16	678H615	Spindle Assembly, R.H.
17	5292J	Bushing, Bellcrank
18	STD523710	* Bolt - Hex 3/8 - 16 x 1 Gr. 5
19	73680600	Nut - Crownlock 3/8 - 16
20	677H998	Bellcrank Assembly
21	19292016	Washer 28/32 x 1 - 1/4 x 16 Ga.
23	102443X	Drag Link
24	STD551137	* Lockwasher 3/8
25	STD541137	* Nut - Hex 3/8 - 24
26	7990J	Tie Rod
27	102458X	Shaft Assembly - Steering
29	19172810	Washer 17/32 x 1 - 5/8 x 10 Ga.
30	74760832	Bolt - Hex 1/2 - 13 x 2
31	73680800	Nut - Crownlock 1/2 - 13
32	102439X	Bracket Assembly - Support, Steering (Inc. Key No. 55)
33	102097X	Sector Assembly
34	STD523707	* Bolt - Hex 3/8 - 16 x 3/4
35	12000034	Clip Ring
37	100713N	Wheel - Steering
38	74040616	Bolt - Hex Slotted Washer Head 3/8 - 16 x 1
39	100711L	Insert - Wheel, Steering
40	677H992	Bracket - Axle
41	8922R	Tie Rod Joint L.H. Thread
42	73700800	Nut - Hex Jam 3/8 - 24 L.H.
43	7819J	Tie Rod
44	STD541337	* Nut - Hex Jam 3/8 - 24
45	8921R	Tie Rod Joint R.H. Thread
47	STD523720	* Bolt - Hex 3/8 - 16 x 2 Gr. 5
48	73510600	Nut - Keps 3/8 - 16
49	1309H	Bearing
50	100710L	Cap - Wheel, Steering
51	678H500	Washer
53	73680600	Nut - Crownlock 3/8 - 16
54	6266H	Bearing - Thrust
55	104239X	Bearing - Flange

* STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

SEARS GT/18 TWIN-MODEL NUMBER 917.253744

CLUTCH - BRAKE



REPAIR PARTS

CLUTCH - BRAKE

SEARS GT/18 TWIN-MODEL NUMBER 917.253744

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
2	19131210	Washer 13/32 x 3/4 x 10 Ga.	40	1685H	Centerlock Nut 5/16 - 18	75	101340R	Transaxle - 5 Speed
3	100228N	Muffler	41	7974J	Pulley - Drive Attachment	76	4196J	Spacer - Transaxle
4	8545J	Gasket - Muffler	42	9396E	Key - 1/4 x 2	77	214J	Drum - Brake
5	9858M1	Woodruff Key	43	19122405	Washer 3/8 x 1 - 1/2 x 5 Ga.	78	STD560507	Pin - Cotter 3/32 x 3/4
6	81159	Knob - Throttle Control	44	STD551137	*Lockwasher - 3/8	79	2228M	Woodruff Key
7	74570412	Screw - Hex Socket Hd. 1/4 - 20 x 3/4	45	74610628	Bolt - Hex 3/8 - 24 x 1 - 3/4	80	7920J	Brake Band
8	100715N	Shield - Heat	46	STD523112	*Bolt - Hex 5/16 - 18 x 1 - 1/4 Gr. 5	81	74370612	Screw - Mach. Undercut Flat Hd. 3/8 - 16 x 3/4
10	73690600	Nut - Crownlock 3/8 - 16	47	STD551131	*Lockwasher 5/16	82	74760614	Bolt - Hex 3/8 - 16 x 7/8
11	STD551143	*Lockwasher 7/16	48	STD541031	*Nut - Hex 5/16 - 18	83	72140405	Bolt - Rd Hd. Sa. Neck
13	STD551125	*Lockwasher 1/4	49	677H918	Base - Engine	84	STD541025	Carrage 1/4 - 20 x 5/8 Gr. 5
16	STD551037	*Washer 13/32 x 13/16 x 16 Ga.	50	13210200	Elbow - 1/4 NPT Street	85	5105J	*Nut - Hex 1/4 - 20
17	11050600	Lockwasher 3/8 Ext. Tooth	51	13280220	Nipple - 1/4 NPT x 2 - 1/7	86	677A637	Bracket Assembly, Brake
18	STD541137	*Nut - Hex 3/8 - 24	52	13200200	Elbow - 1/4 NPT 90°	87	7229J	Pin - Clevis
19	5142H	Pin - Roll 3/16 x 1 - 1/4	53	13020200	Plug - 1/4 NPT Square Head	88	73530600	Guide - Rod, Brake
20	104375X	Shaft Assembly - Pedal, Foot	54	STD523707	*Bolt - Hex 3/8 - 16 x 3/4	88	7241J	Nut - Hex Centerlock with Nylon 3/8 - 24
21	8683R	Cover - Pedal, Foot	55	104577X	Adapter - Pulley	88	5308J	Spring - Compression
22	5304J	Actuator - Switch, Interlock	56	STD523710	*Bolt, Hex Head 3/8 - 16 x 1 Gr. 5	90	100604K	Rod - Brake
23	STD511010	*Screw - Hex No. 10 - 24 x 1	57	101343L	Pulley - Ground Drive	91	100000K	Yoke
24	STD541410	*Nut - Lock No. 10 - 24	59	100196K	Knob - Control	92	100000K	Clamp - Tube, 1 - 1/8 (Inc. 1 ea. Key No. 88, 87 and 48)
25	72110506	Bolt - Rd. Hd. Short Sq. Neck	60	633A109	Gear Shift Lever Assy.	93	100229L	Tube - Exhaust
26	6894J	Carrage 5/16 - 18 x 3/4 Gr. 5	62	7952J	Bracket Support, Transaxle	94	19131614	Washer 13/32 x 1 x 14 Ga.
27	3795A	Control - Choke	63	8021J	Clip - Insulated	95	100592D	Guard - Assembly - Belt
27	7259H	Tire - Rear 23 x 8.50 - 12	64	73680700	Nut - Crownlock 7/16 - 14	96	7192J	Cable Tie
28	785A	Tube - Tire (Not Furnished with Tractor)	65	101341M	Pulley - Transaxle	97	17190512	Screw - Hex Washer Hd. Cut. 5/16 - 18 x 3/4 Type T
28	785A	Tire Valve	66	9204H	Locknut - 1/2 - 20	98	STD533112	*Bolt - Carrage Rd. Hd. Short Sa. Neck 5/16 - 18 x 1 - 1/4
30	5695J	Control - Throttle	67	104282X	*Guard - Belt, Transaxle	99	104659X	Spring - Ext.
31	17720408	Screw - Hex Washer Hd. Thrd. Forming 1/4 - 20 x 1/2	68	STD523107	*Bolt - Hex 5/16 - 18 x 3/4 Gr. 5			
34	102870X	Engine - 18 H.P. Twin, Model No. 422437, Type No. 0679-02	69	19111216	Washer 11/32 x 3/4 x 16 Ga.			
35	19252016	Washer 25/32 x 1 - 1/4 x 16 Ga.	70	9528R	Wheel - Rear			
36	7875J	Spacer 1 x 1 - 1/4 x 1.062	71	634A682	Rear Wheel Hub & Bushing			
37	71873	Plunger - Cap	72	1304H	Bolt - Hub			
38	6784619	Rod - Brake, Parking	73	7663R	Washer - Thrust			
38	74760716	Bolt - Hex 7/16 - 14 x 1	74	72000034	Clip Ring			

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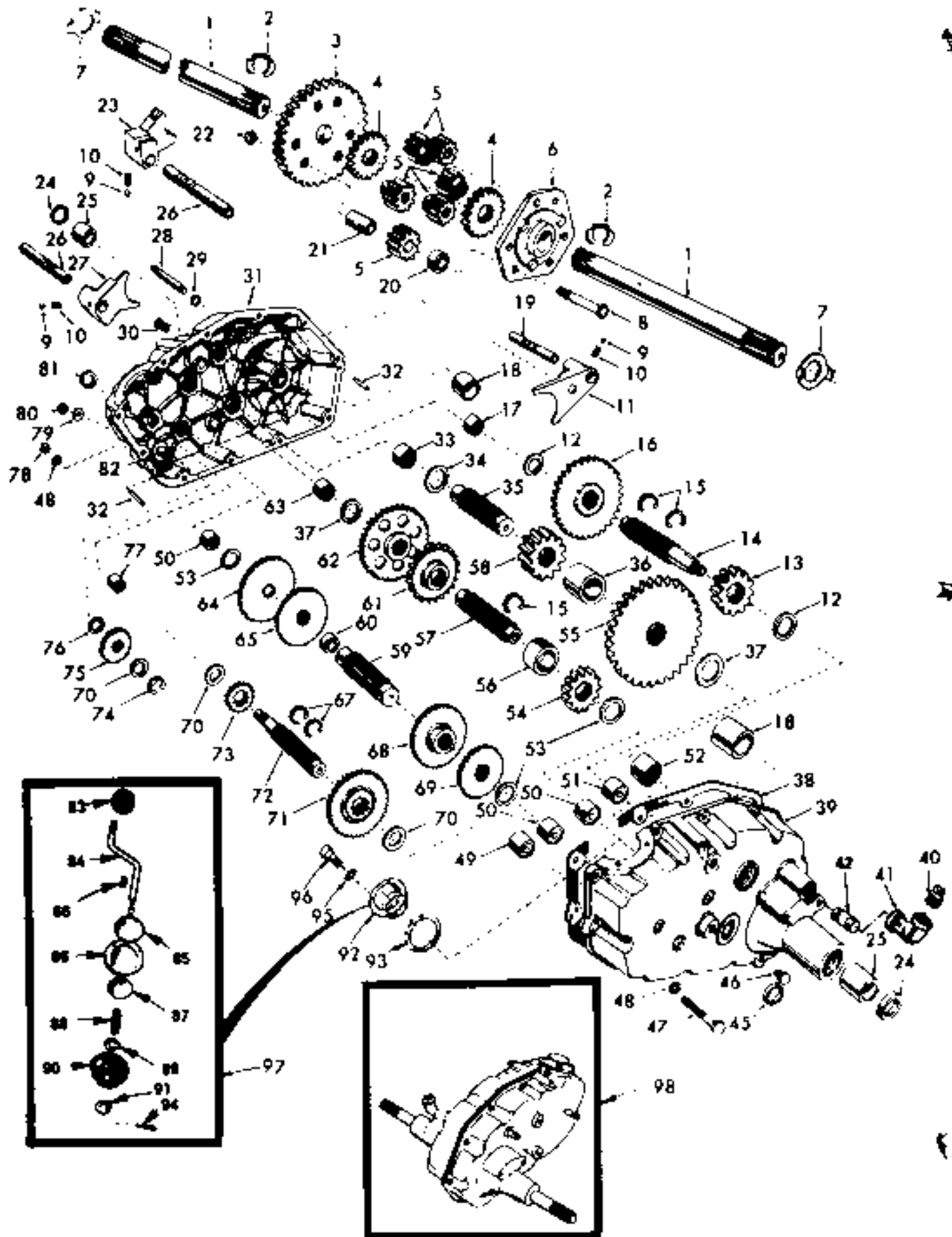
OPTIONAL EQUIPMENT

SPARK ARRESTER MUFFLER 874A380

REPAIR PARTS

SEARS GT/18 TWIN-MODEL NUMBER 917.253744

TRANSAXLE



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REPAIR PARTS

SEARS GT/18 TWIN-MODEL NUMBER 917.253744

TRANSAXLE

KEY NO.	PART NO.	DESCRIPTION*	KEY NO.	PART NO.	DESCRIPTION
1	4197R	Axis Shaft	49	4895H	Needle Bearing
2	5845R	Retaining Ring	50	4222R	Needle Bearing
3	4199R	Final Drive Gear	51	1529R	Needle Bearing
4	4218R	Differential Gear	52	8119M	Needle Bearing
5	4215R	Differential Pinion	53	4220R	Thrust Bearing Race
6	4217R	Differential Carrier	54	4209R	3rd Reduction Pinion - Low
7	8256H	Axle Thrust Washer	55	4213R	4th Reduction Gear
8	74020852	Hex Bolt 3/8 - 24 x 3 - 1/4 (1 1/2" Thread Length)	56	4442R	3rd Reduction Pinion Spacer
9	7392M	Steel Ball	57	4195R	2nd Reduction Gear Shaft
10	6272H	Spring Shift Fork Detent	58	4214R	Final Drive Pinion
11	4985R	Shift Fork, High - Low Range	59	4194R	1st Reduction Gear Shaft
12	6266H	Thrust Bearing Race	60	7528R	1st Reduction Shaft Spacer
13	4212R	4th Reduction Pinion	61	4208R	3rd Reduction Pinion - High
14	4198R	3rd Reduction Gear Shaft	62	4207R	2nd Reduction Gear
15	6276H	Snap Ring - Crescent Type	63	7398H	Needle Bearing
16	633A63	High - Low Range Gears	64	4203R	Low Speed Gear and 2nd Reduction Pinion Cluster
17	6118M	Needle Bearing	65	4204R	Reverse Gear
18	8740H1	Sintered Iron Bearing	66	2898J	Key - Hi - Pro 1/8 x 17/32
19	6217H	Shift Fork Shaft, High - Low Range	67	4926H	Snap Ring - Crescent Type
20	4218R	Differential Pinion Spacer	68	4205R	Intermediate Speed Gear
21	6252H1	Differential Pinion Bushing	69	4206R	High Speed Gear
22	7810H	Gripco Centerlock Nut 3/8 - 24	70	1370H	Thrust Bearing Race
23	4986R	Shift Fork - L.H.	71	633A69	Intermediate and High Speed Cluster Pinions
24	7393R	Oil Seal	72	208J	Input Shaft
25	992R1	Sintered Iron Bearing	73	4201R	Low Speed Pinion
26	6218H	Shift Fork Shaft	74	1200002	E-Ring
27	6262H	Shift Fork - R.H.	75	1153R	Reverse Idler Gear
28	101416X	Shift Shaft, High - Low Range	76	7392H	Reverse Idler Thrust Washer
29	6269H	Oil Seal	77	3990H	Needle Bearing
30	5855H	Pressure Relief Valve	78	STD541031	*Hex Nut 5/16 - 18
31	701414X	Gearcase, Reverse Idler Shaft and Bearings - R.H. (Inc. Key No's, 17, 18, 25, 33, 50, 63, 76, 77 and 82)	79	1167R	Sealing Washer
32	6277H	Dowel Pin	80	73360700	Hex Jam Nut 7/16 - 20
33	4225R	Needle Bearing	81	6270H	Oil Seal
34	7396H	Thrust Bearing Race	82	7384H	Reverse Idler Shaft
35	4198R	4th Reduction Gear Shaft	83	100196K	Control Knob
36	4200R	4th Reduction Gear Spacer	84	5384J	Gear Shift Lever - Bent
37	7395H	Thrust Bearing Race	85	2978J	Gear Shift Cap
38	6275H	Gearcase Gasket	86	633A85	Gear Shift Ball Cover and Pin
39	633A84	Gearcase and Bearings - L.H. (Inc. Key No's, 18, 25, 49, 50 (2), 51 and 62)	87	8739H1	Shift Lever Guide Ball - Keyed
40	13060400	Pipe Plug 1/2 - 14 N.P.T.	88	4924H	Spring
41	13200400	Elbow 90°, 1/2 - 14 N.P.T.	89	19151516	Washer 15/32 x 15/16 x 18 Ga.
42	13280424	Pipe Nipple 1/2 - 14 N.P.T.	90	8105R	Shift Mechanism Seal
45	6271H	Oil Seal	91	19181511	Washer 9/16 x 15/16 x 12 Ga.
46	13060200	Pipe Plug 1/4 - 18 N.P.T.	92	75J	Gear Shift Gate and Reinforcement
47	STD523115	*Hex Bolt 5/16 - 18 x 1 - 1/2 Grade 5	93	6274H	Shift Ball Cover Gasket
48	10140500	Lockwasher 5/16 Extra Heavy	94	76020412	Cotter 1/8 x 3/4
			95	STD551131	*Lockwasher 5/16
			96	STD523108	*Hex Bolt 5/16 - 18 UNC x 7/8
			97	633A109	Gear Shift Lever Ass'y.
			98	101340R	Transaxle Assembly Less Brake Drum & Shift Lever

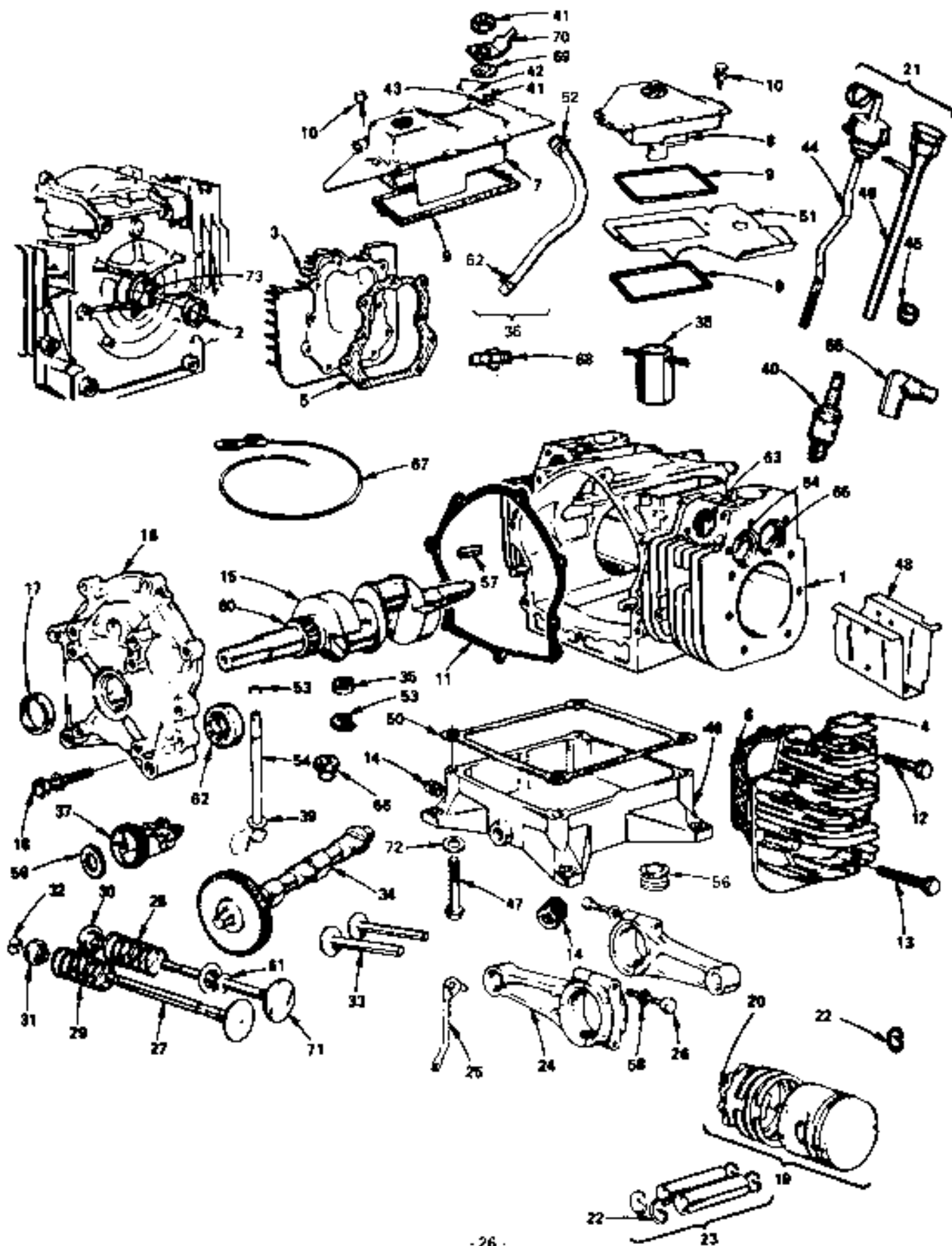
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REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744
ENGINE--MODEL NUMBER 422437, TYPE NUMBER 0679-02

CYLINDER, CRANKSHAFT AND ENGINE BASE GROUP



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REPAIR PARTS

SEARS GT/18 TWIN-MODEL NUMBER 917,253744
ENGINE-MODEL NUMBER 422437, TYPE NUMBER 0679-02

CYLINDER, CRANKSHAFT AND ENGINE BASE GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	394900	Cylinder Assembly	35	271318	Foam Seal - Governor Shaft
2	391086	Seal - Oil	36	393244	Pipe - Fuel (Inc. Key No. 52)
3	212481	Head - Cylinder No. 1	37	394348	Gear - Governor
4	212482	Head - Cylinder No. 2	38	89838	Wrench - Spark Plug
5	270884	*Gasket - Cylinder Head No. 1	39	220863	Washer - Gov. Crank (inside)
6	270883	*Gasket - Cylinder Head No. 2	40	394539	Plug - Spark (Resistor) (2 - 3/8 high - 80 mm)
7	393243	Breather Assembly No. 1	41	90676	Nut - Hex B - 32
8	393153	Breather Assembly No. 2	42	231174	Terminal
9	27803	*Gasket - Valve Cover	43	280180	Grommet - Insulator
10	93394	Screw - Sem	44	394014	Cap and Dipstick - Oil Filler
11	270882	*Gasket - Crankcase Cover 1/84" Thick	45	88838	Seal - Filler Tube
11	271145	*Gasket - Crankcase Cover .006" Thick	46	392782	Tube - Oil Filler
11	271146	*Gasket - Crankcase Cover .009" Thick	47	93783	Screw - Hex Hd.
12	93113	Screw - Cylinder Head (2 - 15/16" long)	48	223055	Trough - Dipper
13	93111	Screw - Cylinder Head (1 - 15/16" long)	49	394391	Base - Engine
14	91084	Plug - Oil Drain	50	270881	*Gasket - Engine Base
16	394430	Crankshaft	51	222700	Baffle - Air
18	394535	Cover Assembly - Crankcase	52	83063	Clamp - Fuel Pipe
17	291875	Seal - Oil	53	93851	Retainer - E-Ring
18	93847	Screw - Crankcase Cover Mtg. Sem	54	394396	Crank - Governor
19	394661	Piston Assembly - Standard (Inc. Key No's. 20 & 22)	55	86536	Elbow - Spark Plug
19	394662	Piston Assembly - .010" O.S.	56	93448	Plug - Hex Socket
19	394663	Piston Assembly - .020" O.S.	57	222698	Key - Flywheel
19	394664	Piston Assembly - .030" O.S.	58	220883	Washer
20	394665	Ring Set - Piston - Standard	59	222773	Washer - Thrust
20	391781	Ring Set - Piston - .010" O.S.	60	231321	Gear - Timing
20	391782	Ring Set - Piston - .020" O.S.	61	393606	Seal Assy. and Retainer
20	391783	Ring Set - Piston - .030" O.S.	62	393741	Bearing - Ball (P.T.O. side)
21	394023	Dipstick and Tube Assembly (Inc. Key No's. 44, 45 & 46)	63	230655	*Guide - Exhaust Valve
22	280924	Lock - Piston Pin	64	210940	*Seat - Exhaust Valve (Standard)
23	299681	Pin Assembly - Piston - Standard (Inc. Key No. 22)	65	261463	*Seat - Intake Valve (Standard)
23	391286	Pin Assembly - Piston - .005" O.S.	66	261559	Lower Bushing - Gov.
24	394306	Rod Assembly - Connecting	67	391115	Wire - Ground
25	223053	Dipper - Connecting Rod	68	230318	Connector - Fuel Pipe
26	92909	Screw - Connecting Rod	69	92791	Washer - Lock Shakeproof
27	390420	Valve - Exhaust	70	83722	Terminal - Spade
28	66908	Spring - Intake Valve	71	261528	Valve - Intake
29	28828	Spring - Exhaust Valve	72	92268	Washer
30	221596	Retainer - Intake Valve	73	261623	*Bearing - Cylinder
31	292280	Rotocoil - Exhaust			
32	83830	Retainer - Exhaust Valve Rotocoil			
33	261368	Tappet - Valve			
34	212415	Gear - Cam			

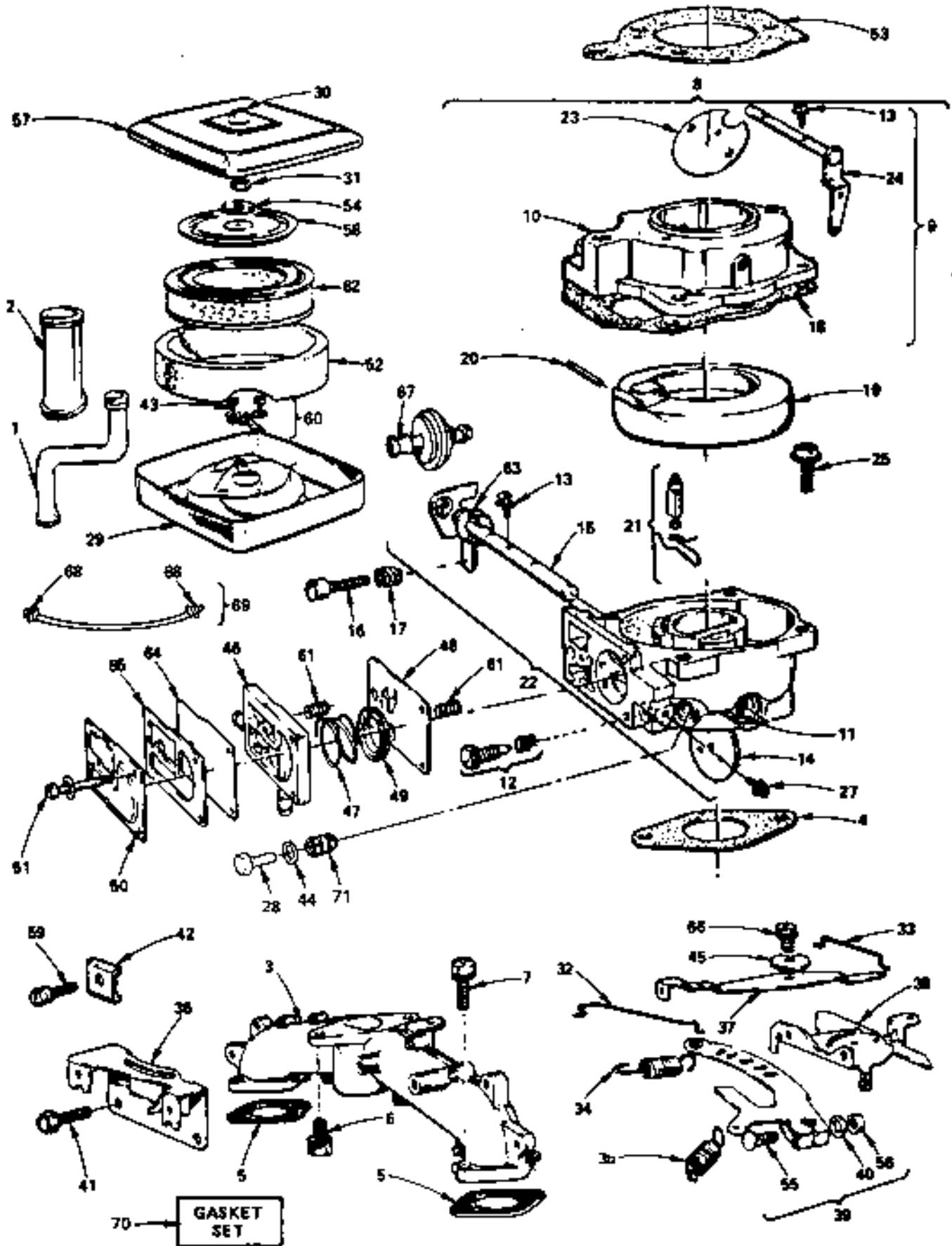
*Inc. in Gasket Set - 394501

*Special Tools required to install

REPAIR PARTS

SEARS GT/18 TWIN-MODEL NUMBER 917.253744
ENGINE-MODEL NUMBER 422437, TYPE NUMBER 0679-02

AIR CLEANER-CARBURETOR GROUP



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REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744
ENGINE--MODEL NUMBER 422437, TYPE NUMBER 0679-02

AIR CLEANER--CARBURETOR GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	280185	Tube - Breather	32	281444	Link - Governor
2	280198	Tube - Intake	33	261531	Link - Speed Control
3	392970	Manifold Ass'y. - Intake	34	261720	Spring - Governor
4	271412	+*Gasket - Carb. Mtg.	35	261563	Spring - Governed Idle
5	270884	*Gasket - Intake Manifold Mtg.	36	222807	Bracket - Speed Control
6	93415	Screw - Carb. Mtg. Sem	37	222828	Lever - Speed Control
7	93208	Screw - Intake Manifold Mtg. Sem	38	394324	Plate Ass'y. Governor Control
8	397245	Carburetor Ass'y. (Inc. Key No's. 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 28, 44, 46, 47, 48, 49, 50, 51, 61, 63, 64 & 65)	39	393846	Lever Ass'y. - Governor (Inc. Key No's. 40, 55 & 56)
9	397241	Body Ass'y. - Upper Carb. (Inc. Key No's. 10, 13, 18, 23 & 24)	40	222289	Washer
10	394505	Body - Upper Carb.	41	93888	Screw - Sem
11	231209	Bushing - Throttle Shaft	42	221535	Clamp - Casing
12	292881	+*Valve Ass'y. - Carb. Idle	43	93893	Screw - Sem
13	93499	Screw - Throttle and Choke Valve Mtg. Sem	44	280474	O-Ring Seal
14	221939	Valve - Throttle	45	231172	Bushing - Speed Control
15	392672	Shaft and Lever - Throttle	46	280197	Body - Pump
16	91920	Screw - Mech. Fil. Hd. 8 - 32 x 5/8	47	261395	xSpring - Pump
17	26157	Spring - Throttle Adj.	48	270888	xDiaphragm
18	271008	+*Gasket - Carburetor Body	49	221377	xCap - Spring
19	298514	Floater - Carburetor	50	222515	Cover - Diaphragm
20	230896	+Pin - Floater Hinge	51	93829	Screw - Diaphragm Cover
21	299096	+*Valve - Fuel Inlet	52	271271	Element - Air Cleaner
22	397270	Body - Lower Carb. (Inc. Key No's. 11, 13, 14, 15 & 65)	53	271411	+*Gasket - Air Cleaner
23	222010	Valve - Choke	54	271180	Washer
24	392673	Shaft and Lever - Choke	55	93853	Bolt - Governor Lever
25	93495	Screw - Hex Head Sem 10/32 x 5/8	56	92278	Nut - Hex 10 - 24
26	93878	Screw - Casing Clamp	57	223001	Cover - Air Cleaner
27	231346	Plug	58	222836	Cartridge Plate - Air Cleaner
28	222752	Body - Air Cleaner	59	93496	Screw - Sem
29	212292	Knob - Air Cleaner	60	392643	Mounting Strap Ass'y. - Air Cleaner (Inc. Key No. 43)
30	93715	Nut - Hex	61	261358	xSpring
31			62	394018	Cartridge - Air Cleaner
			63	271013	+*Washer - Choke Shaft
			64	270889	xDiaphragm - Damping
			65	271025	xGasket - Carb. Pump
			66	93892	Screw - Sem
			67	394358	Filter - Fuel
			68	93053	Clamp - Fuel Pipe
			69	299146	Fuel Line (28") (cut to required length)
			70	394501	Gasket Set
			71	231338	Jet - Needle Valve
			---	393397	Repair Kit - Pump
			-	394502	Carburetor Overhaul Kit

*INCLUDED IN GASKET SET - 394501

+INCLUDED IN CARBURETOR OVERHAUL KIT - 394502

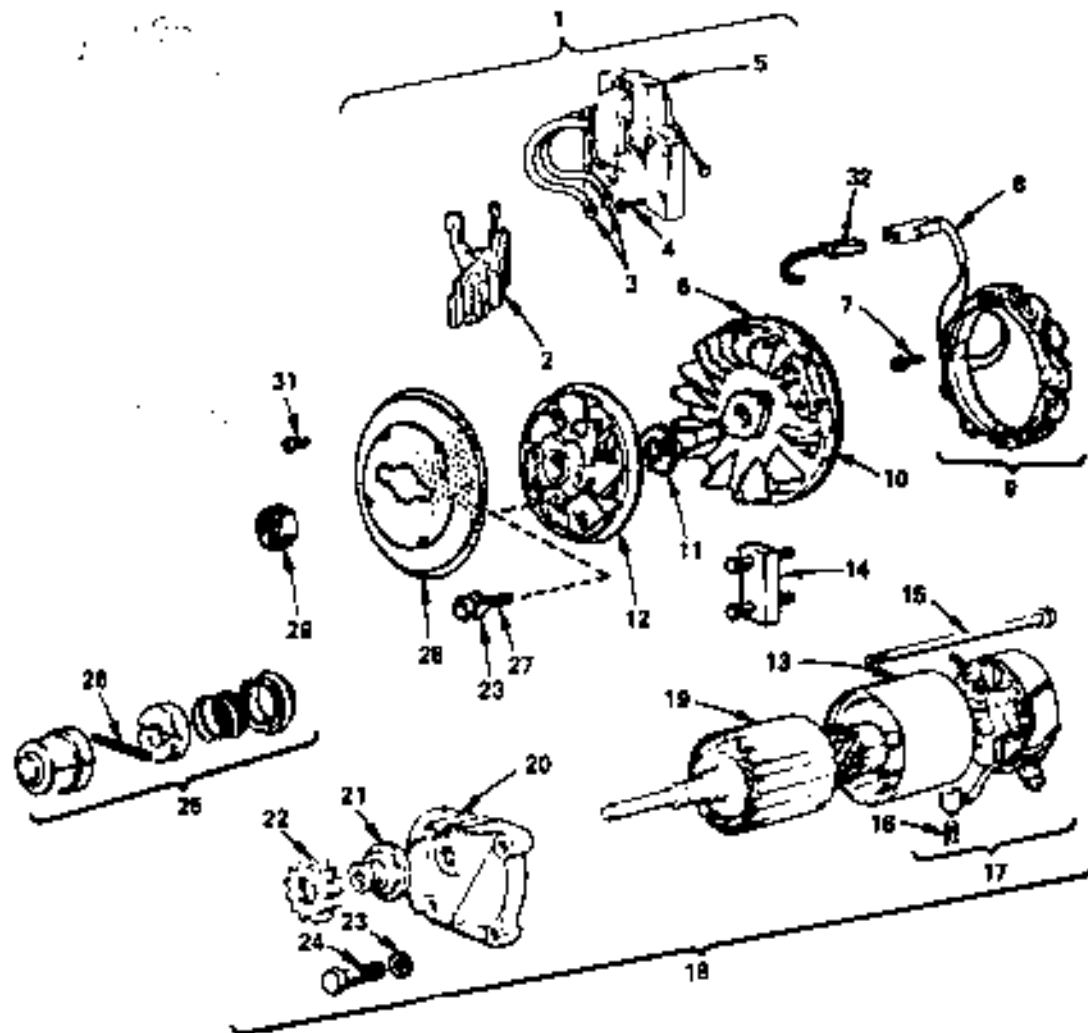
xINCLUDED IN CARBURETOR OVERHAUL KIT - 394502 AND PUMP REPAIR KIT - 393397

oHIGH ALTITUDE - JET-NEEDLE VALVE PART NO. 231333

REPAIR PARTS

SEARS GT/10 TWIN--MODEL NUMBER 917.253744
ENGINE--MODEL NUMBER 422437, TYPE NUMBER 0679-02

STARTER MOTOR GROUP

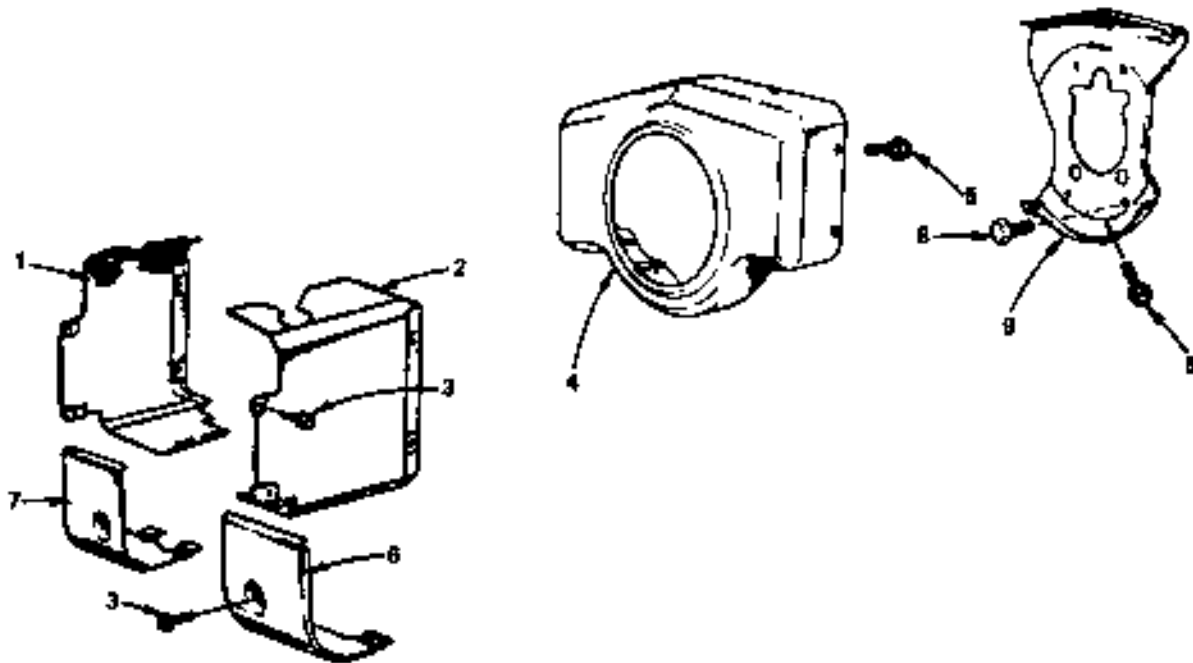


KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	394891	Armature Group (Inc. Key No's. 2, 3 & 5)	18	395538	Brush Set
2	394970	Trigger Coil Ass'y. Magnatron Ignition	17	395537	Commutator End Cap Ass'y. - Starter (Inc. Key No. 16)
3	221798	Terminal - Ignition Coils	18	394808	Motor - Starting (Inc. Key No's. 13, 15, 16, 17, 19, 20, 21, 22, 23 & 24)
4	83381	Screw - Armature Mtg. Sem.	19	390837	Armature Assembly (Motor)
5	394988	Armature Ass'y.	20	394860	Drive End Cap Ass'y. - Starter
6	392958	Flywheel and Ring Gear Ass'y.	21	391135	Clutch Ass'y. - Starter
7	93621	Screw - Sem.	22	280104	Gear - Starter
8	393458	Diode and Connector Ass'y. (Dual Circuit)	23	90366	Lockwasher
9	393474	Stator - Alternator (Dual Circuit) (Inc. Key No. 8)	24	91162	Screw - Hex Hd. - 5/16 - 18 x 1 - 1/2"
10	391382	Gear - Flywheel Ring (Includes Mounting Parts)	25	393254	Kit - Pinion Spring (Inc. Key No. 26)
11	22806	Nut Flywheel Lock	26	33754	Roll Pin
12	212418	Fan - Booster	27	92674	Screw - Hex Hd.
13	393825	Housing Assembly	28	223008	Screen - Rotating
14	19203	Puller - Flywheel (Optional Accessory)	29	231247	Nut - Hex
15	94003	Thru Bolt	31	93805	Screw - Sem.
			32	393362	Alternator Harness Ass'y.

REPAIR PARTS

SEARS GT/18 TWIN--MODEL NUMBER 917.253744
 ENGINE--MODEL NUMBER 422437, TYPE NUMBER 0679-02

MUFFLER, AIR GUIDE AND HOUSING GROUP

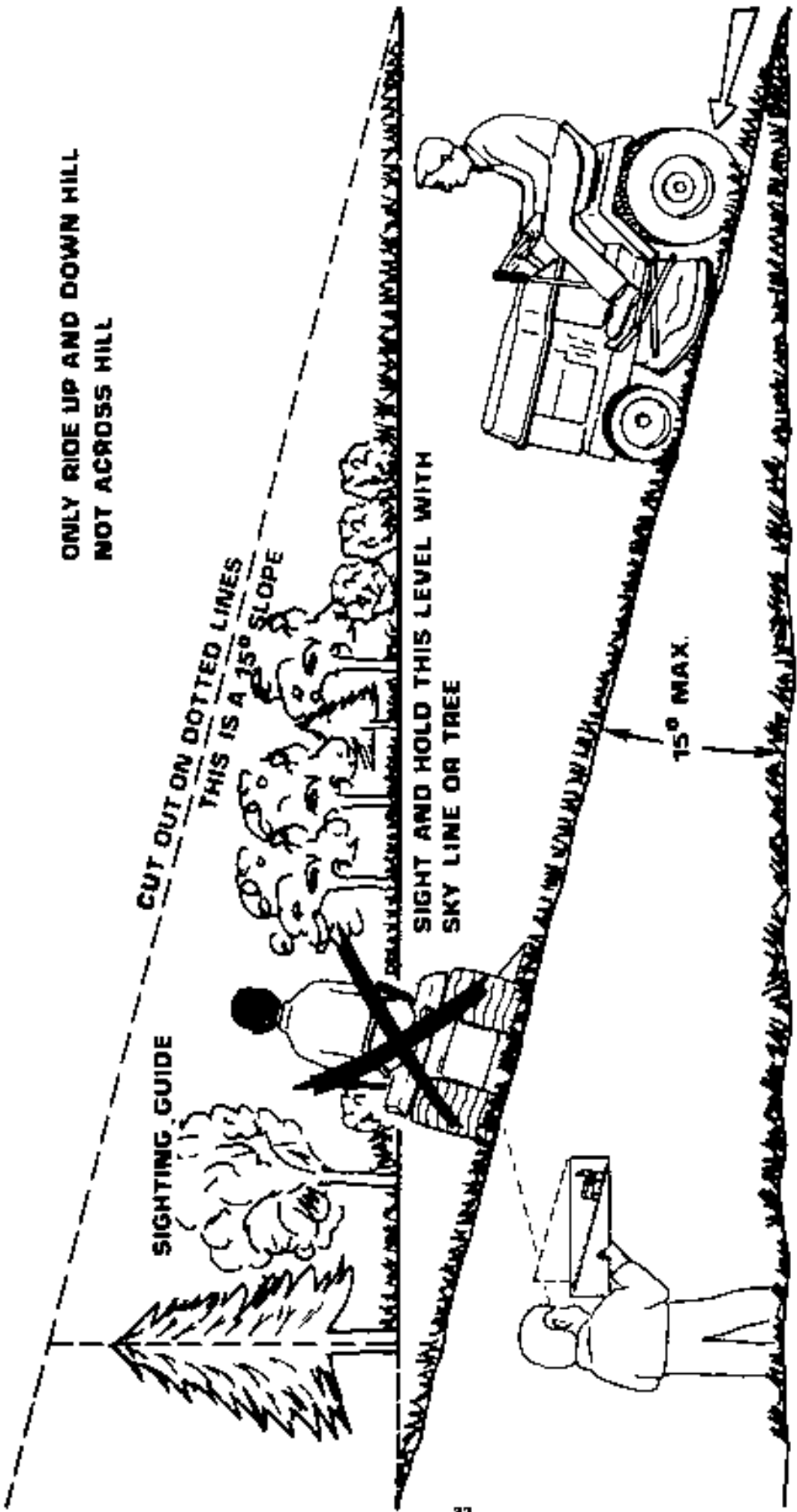


KEY NO.	PART NO.	DESCRIPTION
1	222848	Cover - Air Guide
2	222849	Cover - Air Guide
3	93163	Screw - Sem
4	392681	Housing - Blower
5	93158	Screw - Sem

KEY NO.	PART NO.	DESCRIPTION
6	222847	Shield - Cylinder
7	222848	Shield - Cylinder
8	93777	Screw - Hex Hd. (Back Plate to Cylinder)
9	392934	Back Plate Ass'y.

SUGGESTED GUIDE FOR SIGHTING SLOPES FOR SAFE OPERATION

ONLY RIDE UP AND DOWN HILL
NOT ACROSS HILL



Operate your Tractor up and down the face of slopes (not greater than 15°); never across the face. Make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.



SERVICE NOTES

another free manual from www.searstractormanuals.com

Sears

**OWNERS
MANUAL**

**MODEL NO.
917.253744**

**HOW TO ORDER
REPAIR PARTS**

GT/18 TWIN 6 SPEED GARDEN TRACTOR

The Model Number will be found on the Model Plate Decal attached to the top right rear corner of Fender under rear corner of seat. Always mention the Model Number when requesting service or parts for your Garden Tractor.

All parts listed herein may be ordered from any Sears Service Center and most Sears Stores.

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".