

OWNER'S MANUAL

18 H.P. GARDEN TRACTOR MODELS NUMBER GTK181AR AND GTK181AT

1188502482



GTK181AT
1188502482

LAWN AND GARDEN
OUTDOOR POWER EQUIPMENT

ROPER

OUTDOOR POWER EQUIPMENT

DIVISION OF ROPER CORPORATION

12052 MIDDLEGROUND ROAD
SAVANNAH, GEORGIA 31419

CONGRATULATIONS . . .

on your purchase of a Roper 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 authorized service dealer. He has well-trained technicians and the proper tools and parts to service or repair this unit.

Please read and retain this manual. Following the "Rules For Safe Operation", "Assembly", "Operation", and "Maintenance" instructions will help you achieve a long, safe, service life for your Roper Garden Tractor.

LIMITED WARRANTY

Roper Corporation warrants to the original consumer purchaser that this product as manufactured is free from defects in materials and workmanship. For a period of two (2) years from date of purchase by the original consumer purchaser, we will repair or replace, at our option, without charge for parts or labor incurred in replacing parts, any part which we find to be defective due to materials or workmanship. This warranty is subject to the following limitations and exclusions:

Engine Warranty: All engines on Roper products have a separate Warranty extended by the individual Engine Manufacturer; said Warranty must be referred to in the event of a service requirement (see page 45).

Transaxle/Transmission Warranty: Some Roper products have a Transaxle/Transmission supplied by other manufacturers. Such Transaxle/Transmissions are warranted by that manufacturer and said Warranty must be referred to in the event of a service requirement.

Battery Warranty: On products equipped with a battery, Roper will replace, without charge to you, any battery which we find to be defective in manufacture during the first year of ownership. Battery must be maintained in accordance with instructions in the product literature.

The warranty period for any products used for rental or commercial purposes is limited to 90 days from the date of original purchase.

This warranty applies only to products which have been properly assembled, adjusted and operated in accordance with instructions found in product literature for your product. This warranty does not apply to any product which has been subject to alterations, misuse, abuse, improper assembly, installation, or delivery damages.

Exclusions: Excluded from this warranty are belts, blades, blade adapters, normal wear, normal adjustments, standard hardware and normal maintenance.

In the event you have a claim under this warranty, you must return the product to an authorized Roper Outdoor Power Equipment service dealer.

Should you have any unanswered questions concerning this warranty, please contact:

In U.S.A. contact:
Roper Outdoor Power Equipment
Service Department
12052 Middleground Rd.
Savannah, Georgia 31419

In Canada contact:
Roper Canada Limited
1040 Jayson Court
Mississauga, Ontario L4W2V5

giving the model number, serial number and date of purchase of your product and the name and address of the authorized Roper dealer from whom it was purchased.

THIS WARRANTY DOES NOT APPLY TO INCIDENTAL OR CONSEQUENTIAL DAMAGES AND IMPLIED WARRANTIES ARE LIMITED TO THE SAME TIME PERIODS STATED HEREIN FOR ROPER'S EXPRESSED WARRANTIES. Some states do not allow the limitation of consequential damages or limitation of how long an implied warranty may last, so the above limitations or exclusions may not apply to you. This warranty gives you specific legal rights and you may have other rights which vary from state to state.

This is a Limited Warranty within the meaning of that term as defined in the Magnuson-Moss Act of 1975.

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RULES FOR SAFE OPERATION

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 page 28 for part number identification)

another free manual from www.seartractormanuals.com

1. Know the controls and how to stop quickly. READ THIS OPERATOR'S MANUAL and instructions furnished with your tractor.
2. Do not allow children to operate the machine. Do not allow adults to operate it without proper instruction.
3. Do not carry passengers. Do not mow when children and others are around.
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. Do not 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 operator's left hand side.
8. Clear the work area of objects (wire, rocks, etc.) which might be picked up and thrown.
9. Disengage all attachment clutches and return gear shift control to neutral before attempting to start the engine.
10. Disengage power to attachments and stop the engine before leaving the operator's position.
 1. Disengage power to mower, stop the engine and disconnect spark plug wire(s) from spark plug(s) before cleaning, making an adjustment or repair. Be careful to avoid touching hot muffler or engine components.
 2. Disengage power to attachments when transporting or not in use.
11. Take all possible precautions when leaving the vehicle unattended. Disengage the power-take-off, lower the attachments, return gear shift control lever to neutral, set the parking brake, stop the engine and remove the key.
12. 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 44.
13. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
14. While going up or down slopes choose a speed low enough to negotiate the slope without stopping. To reduce speed, move gear shift control lever to neutral position.
15. Never mow in wet or slippery grass, when traction is unsure or at a speed which could cause a skid.
16. Stay alert for holes in the terrain and other hidden hazards. Keep away from drop-offs.
17. Do not drive too close to creeks, ditches and public highways.
18. 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 objects.
19. Never shift gears until tractor comes to a stop.
20. 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.
21. 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 counter lights. 1. Use lights when suggested in the owner's manual.
22. Watch out for traffic when crossing or near roadways.
23. When using any attachments, never direct discharge of material toward bystanders nor allow anyone near the vehicle while in operation.
24. Handle gasoline with care - it is highly flammable.
 - a. Use approved gasoline containers.
 - b. Never remove the fuel cap of the fuel tank to add gasoline to a running engine. Never fill tank indoors, always clean up spilled gasoline.
 - c. Open doors if the engine is run in the garage - exhaust fumes are dangerous. Do not run the engine indoors.
25. Keep the vehicle and attachments in good operating condition, and keep safety devices in place and working.
26. Keep all nuts, bolts and screws tight to be sure the equipment is in safe working condition.
27. 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.
28. To reduce fire hazard, keep the engine free of grass, leaves or excessive grease. Never attempt to clean product while engine is running.
29. Except for adjustments: 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.
30. Do not operate without a muffler or tamper with exhaust system. Damaged mufflers or spark arresters could create a fire hazard.
31. 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.
32. Do not change the engine governor settings or overspeed the engine; severe damage or injury may result.
33. When using the vehicle with mower, proceed as follows:
 - a. Mow only in daylight or in good artificial light.
 - b. Shut the engine off when unclogging chute.
 - c. Stop the engine and disconnect the spark plug wire(s) from spark plug(s) and check the blade mounting bolts for proper tightness at frequent intervals.
34. Do not operate the mower without entire grass catcher, or on mowers so equipped or the deflector shield in place.
35. 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.
36. Under normal usage the grass catcher bag material is subject to deterioration and wear. It should be checked frequently for bag replacement. Replacement bags should be checked to ensure compliance with the original manufacturer's recommendations or specifications.



CAUTION:

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

LOOK FOR THIS WORD TO POINT OUT IMPORTANT EQUIPMENT PRECAUTIONS.

CUT AWAY VIEW



FIGURE 1

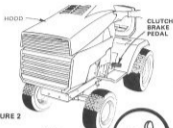


FIGURE 2



FIGURE 3



FIGURE 4

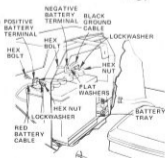


FIGURE 5

ASSEMBLY

To assemble and adjust your Tractor you will need: 3/4" wrench, one 9/16" wrench, two 7/16" wrenches, two 1/2" wrenches, utility knife, and tire pressure gauge.

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

1. Remove Battery, Steering Wheel, Seat and Seat Pan. **NOTE: CLUTCH-BRAKE PEDAL (FIG. 2) HAS BEEN SHIPPED IN THE "BRAKE" POSITION.**
2. Cut down four corners and fold down carton.
3. Lower mower deck to floor.
4. Shift unit into neutral and release the parking brake.

WEAR EYE AND FACE SHIELD.



WASH HANDS OR CLOTHING IMMEDIATELY IF ACCIDENTALLY IN CONTACT WITH BATTERY ACID.

DO NOT SMOKE. FUMES FROM CHARGED BATTERY ACID ARE EXPLOSIVE.

5. Fill and charge Battery (before installing). **NOTE: SEE DETAILED INSTRUCTIONS PACKAGED WITH BATTERY VENT CAPS FOUND IN BAG OF PARTS.**

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

b. Check level of battery acid after 30 minutes. Add additional electrolyte if necessary. **NOTE: TIGHTEN VENT CAPS SECURELY.**

c. Charge Battery at a rate of six amperes for one hour.

d. Neutralize excess battery acid 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, WRIST-WATCH BANDS, RINGS, ETC. FROM YOUR PERSON.

6. Install Battery.

a. Lift Hood from rear sides (Fig. 2).

b. Remove Hood Assembly by removing Ext./Int. Tooth Lockwashers and Wing Nuts (Fig. 3).

c. Disconnect Light Wiring Harness (Fig. 4).

d. Pivot Hood Assembly forward and remove from Tractor (Fig. 4).

e. Remove tape from Plastic Tray. Make sure Drain Tube is fastened to Drain Hole in Battery Tray and Battery Tray is positioned in hole of Battery Support.

f. Place Battery in Plastic Tray (Battery Terminals to rear of Tractor) (Fig. 5).

g. 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.

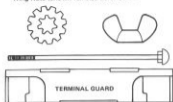


POSITIVE TERMINAL MUST BE CONNECTED FIRST TO PREVENT SPARKS FROM ACCIDENTAL GROUNDING.

h. Connect RED Battery Cable to Positive (+) Battery Terminal with Hex Bolt, Flat Washer, Lockwasher and Hex Nut (Fig. 5). Tighten securely.

i. Connect BLACK Ground Cable to Negative (-) Battery Terminal with remaining Hex Bolt, Flat Washer, Lockwasher and Hex Nut (Fig. 5). Tighten securely.

- j. Secure Battery using: two Int./Ext. Lockwashers, two Wing Nuts (shown full size below) and



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

- Using the forward square hole on one side of the Battery Support (Fig. 5) insert one Battery Bolt, head of Bolt down. Fasten the Battery Bolt to the Terminal Guard using Int./Ext. Lockwasher and Wing Nut as shown in Fig. 6.

- Assemble the remaining Battery Bolt to other side of Battery Support and fasten Terminal Guard to it with remaining Int./Ext. Lockwasher and Wing Nut. Tighten Wing Nuts securely by hand (Fig. 6).

NOTE: USE TERMINAL ACCESS DOORS (FIG. 6) 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.

DO NOT START ENGINE UNTIL MOWER SUSPENSION BRACKET HAS BEEN RELEASED. SEE MOWER AND DRIVE BELT INSTALLATION, PAGE 16.

- k. Reinstall Hood Assembly to Tractor and tighten Int./Ext. Tooth Lockwasher & Wing Nut. Reconnect Light Wiring Harness.

- Close Hood.

Install Steering Wheel.

NOTE: POSITION FRONT WHEELS FORWARD.

- Remove Hex Bolt, Lockwasher and Large Washer (Fig. 7) from steering Column.
- Position Steering Wheel over Steering Wheel Adapter.
- Secure Steering Wheel to Steering Column using Large washer, Lockwasher and Hex Bolt (Fig. 7).
- Snap Steering Wheel Insert in place on Steering Wheel.

INSTALL SEAT

SEAT POSITION SHOULD BE ADJUSTED FORWARD OR BACKWARD SO THAT THE OPERATOR CAN COMFORTABLY REACH CLUTCH/BRAKE PEDAL AND SAFELY OPERATE TRACTOR (Fig. 8).

- Place Seat on Seat Pan. Screw Hand Adjustment Knob, Washer and Shoulder Bolt into Seat (Fig. 8) Adjustment Knob, Washer and Shoulder Bolt, Washer found in bag of parts.
 - Tighten Shoulder Bolt and Washer using a 1/2" wrench.
 - Hand tighten Adjustment knob.
 - Place Seat in operating position. Sit on the seat and press Clutch/Brake Pedal all the way down. If operating position is not comfortable, adjust Seat.
 - To adjust: Raise Seat, loosen Hand Adjustment Knob, slide Seat to desired position, tighten Hand Adjustment Knob securely.
9. A Spark Arrester Muffler (page 28) is available as an accessory part for your tractor. Check legal requirements in your area.

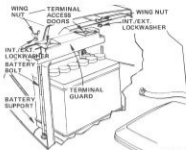


FIGURE 6

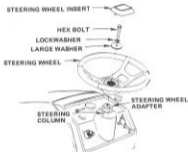


FIGURE 7

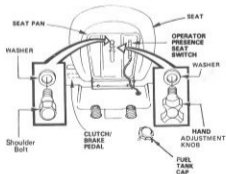
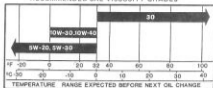


FIGURE 8

RECOMMENDED SAE VISCOSITY GRADES



USE HIGH-QUALITY DETERGENT OIL OF API (AMERICAN PETROLEUM INSTITUTE) SERVICE CLASS SF.

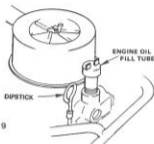


FIGURE 9

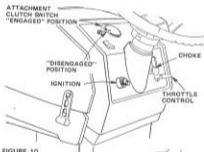


FIGURE 10

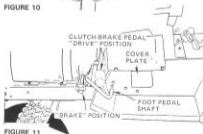


FIGURE 11

INITIAL SERVICE

1. This engine has been shipped filled with summer weight oil. Check Engine Oil Level with Tractor on level ground. Wipe Dipstick (Fig. 9) clean, screw it in tight for a few seconds, remove and read Oil Level. If necessary, add Oil until "FULL" mark is reached.

NOTE: DO NOT OVER FILL. Capacity is 1-1/2 quarts. Dipstick assembly must be securely assembled into tube at all times when engine is operating.

2. Fill Fuel Tank (Fig. 8) 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.



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

CAUTION: EXPERIENCE INDICATES THAT ALCOHOL BLENDED FUELS (CALLED GASOHOL OR USING ETHANOL OR METHANOL) CAN ATTRACT MOISTURE WHICH LEADS TO SEPARATION AND FORMATION OF ACIDS DURING STORAGE. ACIDIC GAS CAN DAMAGE THE FUEL SYSTEM OF AN ENGINE WHILE IN STORAGE.

TO AVOID ENGINE PROBLEMS THE FUEL SYSTEM SHOULD BE EMPTIED BEFORE STORAGE FOR 30 DAYS OR LONGER. DRAIN THE GAS TANK, START THE ENGINE AND LET IT RUN UNTIL THE FUEL LINES AND CARBURETOR ARE EMPTY. USE FRESH FUEL NEXT SEASON. SEE STORAGE INSTRUCTIONS FOR ADDITIONAL INFORMATION.

NEVER USE ENGINE OR CARBURETOR CLEANER PRODUCTS IN THE FUEL TANK OR PERMANENT DAMAGE MAY OCCUR.

3. Reduce Tire pressure to 14 PSI in front and 10 PSI in rear Tires. (Tires were overinflated for shipping purposes.)

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 WHILE THE ATTACHMENT CLUTCH IS IN THE ENGAGED POSITION (FIG. 10) AND THE CLUTCH/BRAKE PEDAL IS IN DRIVE POSITION (FIG. 11).



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

NOTE: THIS TRACTOR IS EQUIPPED WITH AN OPERATOR PRESENCE SENSING SWITCH. ANY ATTEMPT BY THE OPERATOR TO LEAVE THE SEAT WITH THE ENGINE RUNNING AND THE ATTACHMENT CLUTCH ENGAGED WILL SHUT OFF THE ENGINE.

1. Place Attachment Clutch Switch in "DISENGAGED" position (Fig. 10).
2. Push Clutch-Brake Pedal fully into brake position (Fig. 11).
3. Place Gear Shift Control Lever in "N" (neutral) start position (Fig. 13) and Range Shift Lever in "N" (neutral) position (Fig. 12).
4. Pull Choke out (Fig. 10).
5. Move Throttle Control to middle position (Fig. 10).
6. Turn Ignition Key (Fig. 10) to "START" position until Engine starts. NOTE: DO NOT RUN STARTER CONTINUOUSLY FOR MORE THAN TEN SECONDS PER/MINUTE. If engine does not start after several attempts, move Throttle Control to "F" (fast) position, wait a few minutes and try again.
7. Push Choke in.
NOTE: ALLOW ENGINE TO WARM UP FOR A FEW MINUTES BEFORE ENGAGING CLUTCH OF TRACTOR OR ATTACHMENT.
8. When restarting warm engine, move Throttle Control midway between "S" (slow) and "F" (fast) position, Choke may not have to be used.

OPERATION



BEFORE DRIVING THE TRACTOR, INSTALL MOWER OR REMOVE FRONT MOWER SUSPENSION BRACKET (FIG. 34).

1. Keep all shields in place.
2. Before leaving operator's position:
 - a. Shift transmission to neutral.
 - b. Set Parking Brake.
 - c. Disengage Attachment Clutch Switch.
 - 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.

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. 11). Move Gear Shift Control Lever (Fig. 13) to desired gear and Range Shift Lever (Fig. 12) to "LO" (low) position.
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 push 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.

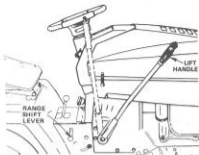


FIGURE 12

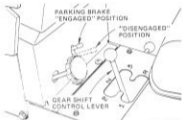


FIGURE 13



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 (Fig. 13) 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 Gear Shift Control Lever to "N" (neutral) position.
4. Place Attachment Clutch Switch in "DISENGAGED" position.
5. Move Throttle Control to "S" (slow) position.
6. Turn Ignition Key to "OFF" position. Never use Choke to stop engine.



REMOVE KEY WHEN LEAVING TRACTOR TO PREVENT UNAUTHORIZED USE.

TRANSPORTING YOUR TRACTOR

For pushing or towing your tractor, place Gear Shift Control Lever (Fig. 13) and Range Shift Lever (Fig. 12) to "N" (neutral) positions. NOTE: DO NOT TOW YOUR TRACTOR FASTER THAN SIX MILES PER HOUR.

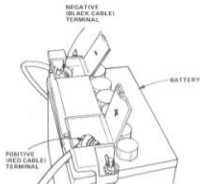


FIGURE 14



FIGURE 15

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 15°, AND DO NOT DRIVE ACROSS ANY SLOPE. REFER TO PAGE 44.

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)(Fig. 14).
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.

MAINTENANCE

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

Each time you start your tractor, check the Ammeter (Fig. 15) The Amp. needle should move towards the + (charging) mark indicating the battery is being charged as you operate the tractor. The headlights will show a discharge on the ammeter because they are connected to the battery. If you have a lift motor connected it will show a discharge when being operated.



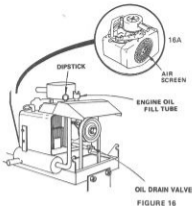
DISCONNECT SPARK PLUG WIRES TO PREVENT ACCIDENTAL STARTING BEFORE MAKING ANY INSPECTION, ADJUSTMENT OR REPAIR (EXCEPT CARBURETOR).

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.

- The best time to drain Oil is with the Engine warm, when dirt and foreign material are suspended in the Oil. Unscrew Oil Drain Valve (Fig. 16) and catch Oil in a suitable container. Close Valve.
- Refill Engine Oil (Fig. 16). DO NOT OVERFILL. See chart, page 4. Refill capacity is 1-1/2 quarts. Replace dipstick.



DAILY OR EVERY 8 HOURS

1. CHECK ENGINE OIL LEVEL

Several minutes after stopping Engine, check Engine Oil Level with Tractor on level ground. Wipe dipstick clean (Fig. 16), push it in tight for a few seconds, remove and read Oil Level. If necessary, add Oil until "FULL" mark is reached. NOTE: DO NOT OVERFILL. Dipstick assembly must be securely assembled into tube at all times when engine is operating.

EVERY 25 HOURS

(EVERY 15 HOURS IF OPERATING IN VERY DUSTY CONDITIONS)

1. CHANGE ENGINE OIL

The best time to drain Engine Oil is at the end of a day's operation when all dirt and foreign material is suspended in the hot Oil. Refer to page 4.

2. LUBRICATE STEERING AND FRONT WHEELS

There are four Grease Fittings on your Tractor (Fig. 17). Using a Grease Gun, give each Grease Fitting two shots of Extreme Pressure Lubricating Grease Amdex No. 1 or equivalent (available through your Roper dealer).

3. 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. 17).
- Hood Hinges.
- Foot Pedal Shaft (both ends) (Fig. 11).
- Lift Shaft (both ends) (Fig. 12).
- Seaming Plate (Fig. 17).

4. 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 step 5.
- Keep Battery Bolts tight.
- Keep Vent Caps tight and small vent holes in Caps open.
- Recharge at 6 amperes for 1 hour if necessary.

5. 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 reinstall on Tractor.
- Clean terminals and cable ends with a wire brush until bright. Replace Battery Cables. Coat terminal connections with Vasoline after connecting cables.

6. CLEAN AIR SCREEN

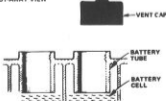
Air Screen (Fig. 16A) must allow free-flow of air to prevent Engine damage from overheating. Clean with a wire brush, compressed air or water pressure to remove dirt, chaff, stubborn dried gum and fibers.



DO NOT CHECK ENGINE OIL LEVEL WITH ENGINE RUNNING.



CUT-AWAY VIEW



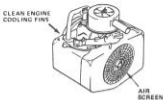


FIGURE 19

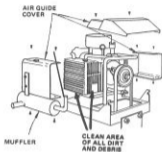


FIGURE 20

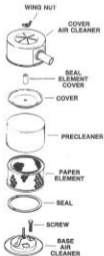


FIGURE 21

7. CLEAN AIR CLEANER AND PRE-CLEANER

- Unscrew Wing Nut (Fig. 21) to remove Cover.
- Remove Foam Pre-Cleaner by sliding it off the Paper Cartridge.
- Wash Foam Pre-Cleaner in liquid detergent and warm water.
- Wrap Foam Pre-Cleaner in cloth and allow to air dry.
- Lightly wipe Foam Pre-Cleaner with engine oil. DO NOT SATURATE. Squeeze to remove excess oil.
- Install Foam Pre-Cleaner over Paper Cartridge.
- Reassemble Cover and screw down tight.

Yearly or every 100 hours, whichever comes first, remove paper cartridge. Clean by tapping gently on flat surface. If very dirty, replace cartridge. Service more often if necessary.

NOTE: NEVER RUN ENGINE WITH AIR CLEANER REMOVED AS DIRT (DUST) WILL DAMAGE THE ENGINE.

EVERY 50 HOURS

(OPERATING IN DUSTY CONDITIONS MAY REQUIRE MORE FREQUENT SERVICING)

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. 20).

2. MUFFLER

Do not operate the tractor without a Muffler (Fig. 20) or tamper with the exhaust system. Damaged Mufflers or spark arrestors could create a fire hazard. Inspect periodically and replace if necessary. If your engine is equipped with a spark arrestor 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 .025 inch (Fig. 22). NOTE: Do not clean the Spark Plugs in a machine using abrasive grit. Some grit could remain in the spark plugs and enter the engine causing extensive wear and damage.



FIGURE 22

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.

3. REPLACE AIR CLEANER PAPER CARTRIDGE

Refer to step 7 in 25 Hour Service (Fig. 21).

EVERY 200 HOURS

1. REPLACE IN-LINE FUEL FILTER

- Remove Hose Clamps from Fuel Lines at Fuel Filter (Fig. 24).
- Remove Fuel Filter (Fig. 24).
- Place new Fuel Filter in position with fuel line (arrow on Hose Clamps).



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

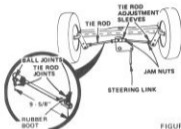


FIGURE 23

AS NEEDED

- Make sure all nuts on 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.

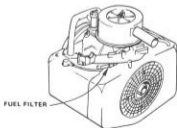


FIGURE 24



FIGURE 25

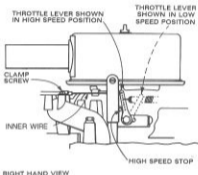


FIGURE 26

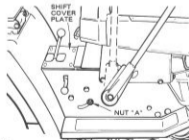


FIGURE 27

3. THROTTLE CABLE ADJUSTMENT

Never attempt to change maximum engine speed. This is preset at the factory (3400 \pm 100 RPM) and should only be adjusted by a qualified service technician.

- Loosen Clamp holding Throttle Cable at Carburetor (Fig. 26).
- Push Throttle on Dash to full speed "F" position.
- Pull outer Cable until tight (Fig. 26).
- Tighten Clamp on outer Cable (Fig. 26).

4. ADJUST CARBURETOR

- With the Engine stopped, turn the adjusting needle "in" (clockwise) until it bottoms lightly (Fig. 25).
- Preliminary Settings: Turn the adjusting needle "out" (counterclockwise) from lightly bottomed to 1 - 1/4 turn.
- Start the engine and run at half-throttle for 5 to 10 minutes to warm-up. The engine must be warm before making final settings (steps d and e).
- Idle Speed Setting: Place the throttle control into the idle or slow position. Set the idle speed to 1300 RPM (\pm 50 RPM) by turning the idle speed adjusting screw in or out. Check the speed using a tachometer (Fig. 25).
- Idle Fuel Needle Setting: Place the throttle into the idle or slow position. Turn the idle fuel adjusting needle "out" (counterclockwise) from the preliminary setting until the engine speed decreases (rich). Note the position of the needle (Fig. 25).

5. GROUND DRIVE V-BELT ADJUSTMENT

To assure maximum belt life check belt adjustment seasonally.

- To tighten Belt, remove (4) Hex Washer Head Tapping Screws from Shift Cover Plate (Fig. 27) located on top of tractor frame. Remove the Cover Plate.
- Place Parking Brake Lever in "ENGAGED" position. Refer to "Stopping Your Tractor", page 5.
- Loosen Nut "A" located on outside of R.H. Chassis Frame (Fig. 27), slide Take-Up Idler (Fig. 26) down approximately 1/2" and tighten Nut "A".
- Disengage Parking Brake.
- Check position of Clutch Idler Bracket (Fig. 28).
- Repeat steps b thru e until a 1 - 1/16" dimension is obtained between top of Pin and top of Frame as shown in Fig. 28 - Inset.
- Tighten Nut "A" securely. NOTE: AFTER ADJUSTING V-BELT YOU MUST READJUST BRAKE, SEE STEP 6.
- Reinstall Shift Cover Plate and (4) Screws removed in step a.

6. 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. 27), located on top of tractor frame. Remove the Cover Plate.
- Loosen Jam Nut (G) on Brake Rod (B) at Clevis (C) (Fig. 29). If you find it difficult to loosen Jam Nut (G), remove Cover Plate in L.H. Frame Rail.
- Rotate Brake Rod (B) counterclockwise, (↺) turning Brake Rod out of Clevis (C) four to six turns.
- Start tractor with Transmission in "N" (neutral) position.
- Depress Brake-Clutch Pedal to the point where Belt stops moving. Hold Brake Clutch Pedal in position by engaging Parking Brake. 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 (G) on Brake Rod (B) at Clevis (C) (Fig. 29).
- Reinstall Shift Cover Plate and four (4) Mounting Screws. If Cover Plate was removed in step b it should be replaced.

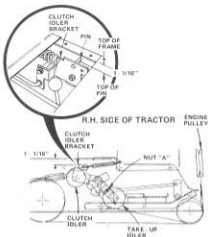


FIGURE 28

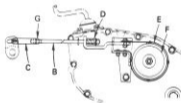


FIGURE 29

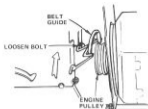


FIGURE 30

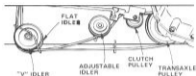


FIGURE 31

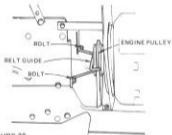


FIGURE 32

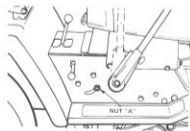


FIGURE 33

7. V-BELT REPLACEMENT

BELT REMOVAL

The belt on this tractor is special for this application. Always replace with the Roper belt number in the parts list. It is not necessary to remove mower.

- Raise hood and disconnect negative ground battery cable.
- Set parking brake (to get belt slack).
- Loosen (do not remove) two Engine Pulley Belt Guide Bolts and swing R.H. side of Belt Guide up. Tighten L.H. Bolt to hold Belt Guide in position (Fig. 30).
- Roll Belt off Engine Pulley.
- Roll Belt off "V" Idler, Flat Idler and Adjustable Idler Pulleys (Fig. 31).
- Pull Belt off Clutch Pulley - between Pulley and Frame. Pull Belt off Transaxle Pulley.
- Loosen Nut "A" on R.H. outside of Frame (Fig. 33).

BELT INSTALLATION

NOTE: THERE IS A BELT INSTALLATION DECAL UNDER LEFT HAND FOOTREST.

- Push Belt down from Engine Pulley area. Place back (flat) side of Belt on Flat Idler. (Flat Idler is next to Frame.)
- Place Belt on Adjustable Idler and over Clutch Pulley. "V" (inarrow) part of Belt should engage Clutch Pulley.
- Place Belt around Transaxle Pulley. "V" part of Belt should engage Transaxle Pulley.
- Make sure "V" part of Belt engages "V" Idler (Fig. 31).
- Roll Belt over Engine Pulley.
- Loosen L.H. Engine Pulley Belt Guide Bolt and swing Belt Guide onto R.H. Bolt. Tighten L.H. and R.H. Bolts securely (Fig. 32).
- Release Parking Brake. NOTE: WHEN A NEW BELT HAS BEEN INSTALLED, YOU MUST CHECK V-BELT ADJUSTMENT (PAGE 10) AND BRAKE ADJUSTMENT (PAGE 11).

B. TIRE CARE

- Maintain tire pressure in front at 14 PSI and rear tires at 10 PSI.
- Keep tires free of gasoline, oil, or insect control chemicals which can destroy rubber.
- Avoid stumps, stones, deep ruts and other hazards that may cause tire damage.
- Removing front wheel for tire repair (Fig. 34).
 - Block up front axle securely.
 - Remove Hub Caps, Klip Rings and Washers to allow wheel removal.
 - Repair tire and reassemble. Replace Washers and snap Klip Ring Securely in axle groove. Replace Hub Cap.
- Removing rear wheel for tire repair.
 - Block up rear axle securely.
 - Remove Hub Cap and (b) Hub Bolts to allow wheel removal.
 - Repair tire and reassemble. Replace and tighten Hub Bolts and Hub Cap securely.

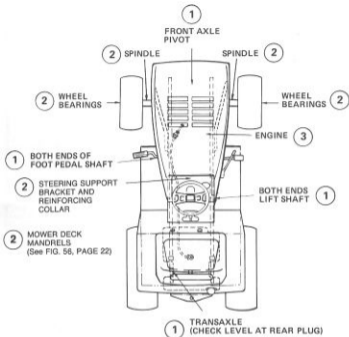


WHEN MOUNTING TIRES, BEADS MUST BE SEATED. OVERINFLATION CAN CAUSE A FATAL EXPLOSION.



FIGURE 34

LUBRICATION CHART



- 1** SAE 30 (SD, SE OR SF) MOTOR OIL
- 2** EXTREME PRESSURE LUBRICATING GREASE AMDEX NO. 1
- 3** REFER TO ENGINE OIL SPEC'S. (UNDER INITIAL SERVICE IN OWNER'S MANUAL, PAGE 4)

SERVICE RECORD FILL IN DATES AS YOU COMPLETE REGULAR SERVICE	SERVICE DATES					
	AS NEEDED	EVERY 8 HOURS	EVERY 25 HOURS	EVERY 50 HOURS	EVERY 100 HOURS	EVERY 200 HOURS
Change Engine Oil (see chart, page 4)				✓		
Lubricate Pivot Points (see page 13)				✓		
Check Brake Operation	✓					
Clean Air Screen		✓				
Clean Air Filter and Precleaner		✓				
Replace Air Cleaner Paper Cartridge				✓	✓	
Clean Engine Cooling Fins				✓		
Replace Spark Plug				✓	✓	
Check Battery Level				✓		
Check Tire Pressure	✓					
Replace Fuel Filter					✓	
Clean Battery and Terminals				✓		
Check Muffler				✓		
Lubricate Ball Joints					✓	
Tire In Adjustment	✓	✓				
Carburetor Adjustment	✓	✓				
V-Belt Adjustment	✓	✓				

STORAGE

1. ENGINE OIL

Drain (with engine warm) and replace with clean engine oil. Refer to page 4.

2. FUEL SYSTEM

It is important to prevent gum deposits from forming in essential fuel system parts such as the carburetor, fuel filter, fuel hose, or tank during storage. Also, experience indicates that alcohol blended fuels (called gasohol or using ethanol or methanol) can attract moisture which leads to separation and formation of acids during storage. Acidic gas can damage the fuel system of an engine while in storage. To avoid engine problems, the fuel system should be emptied before storage of 30 days or longer. Follow these instructions.

- Drain fuel tank and carburetor by allowing the engine to run out of gasoline.
- Dispose of gasoline if not to be used. NOTE: GASOLINE STORED FOR SEVERAL MONTHS LOSES ITS VOLATILITY (ABILITY TO BURN EFFECTIVELY).

3. CYLINDERS

- Remove Spark Plugs.
- 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

- Remove battery if tractor is not used regularly during winter months. Store in cool, dry place (above 50°F.).
- Re-charge 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.

Roper Corporation reserves the right to make any changes in design or improvements without imposing any obligation to install the same upon its items heretofore manufactured.

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. 11). Move Lever to "disengaged" position (Fig. 10). Fill Tank with fresh Gasoline. Check Fuel Line (Fig. 24). and Carburetor (clean if necessary). Check for fault and replace Fuse Recharge or replace Battery Check Wiring Replace Spark Plugs and adjust gap (Fig. 22).
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. 10) and turn starter several times to clean out gas Remove and clean (Fig. 24). Replace Spark Plugs and adjust gap (Fig. 22). Recharge or Replace Check wiring and Spark Plugs Drain Fuel Tank and Carburetor, use fresh fuel and replace Spark Plugs Make necessary adjustments (Fig. 25) 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. 24). Remove and clean Remove and Clean (Fig. 21) Make necessary adjustments (Fig. 25) Clean Air Screen, Cooling Fins (Fig. 20) and Muffler Add or change oil (Fig. 9) Replace Spark Plugs and adjust gap (Fig. 22) Check Spark Plugs and check for any loose wires Major Engine overhaul Drain Engine oil and refill Remove and clean (Fig. 21)
ENGINE OVERHEATS Dirty Air Screen Low oil level Dirty Engine Partially Plugged Muffler Improper Carburetor adjustment	Clean Air Screen (Fig. 19) Add or change oil (Fig. 9) Clean Cylinder Fins, Air Screen and Muffler area Remove and Clean Muffler (Fig. 20) Adjust Carburetor (Fig. 25)
NO LIGHTS No Headlights with Light Switch in "ON" position and engine running	Check Wire Connection and Switch. Replace Light Bulbs
WON'T CHARGE Blown Fuse Defective Battery or loose wiring	Check for fault and replace Repair wiring or replace battery
OPERATOR PRESENCE SYSTEM WILL NOT SHUT DOWN ENGINE WHEN OPERATOR LEAVES SEAT NOTE: This tractor is equipped with an operator presence sensing system. Any attempt by the operator to leave the seat with the engine run- ning and the attachment clutch engaged will shut down the engine.	Engage attachment clutch Check all wire connections Check seat switch Check operator presence relay Check PTO Switch

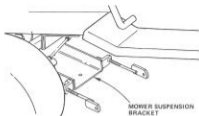


FIGURE 35

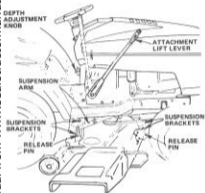


FIGURE 36

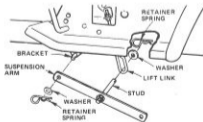


FIGURE 37

MOWER AND DRIVE BELT INSTALLATION

Your tractor has been shipped with the Mower Suspension Bracket banded to the frame. Remove bands and lower Mower Suspension Bracket (Fig. 35).

MOWER INSTALLATION

1. Remove banding from Suspension Arms and Gauge Wheels, Set Gauge Wheels aside for later assembly.
2. Slide Mower under Tractor, Deflector to right hand side.
3. Slide Front Suspension Brackets into Mower Brackets. Retain with Release Pins (Fig. 36). Turn Depth Adjustment Knob counterclockwise (⤴) until it stops, Push Attachment Lift Lever forward to lower mower to ground.
4. Slide Studs through Lift Links on both sides of Tractor (Fig. 37). Retain with Washers and Retainer Springs.
5. Place the Suspension Arms on Brackets on both sides of Frame (Fig. 37). Retain with Washers and Retainer Springs.
6. Turn Depth Adjustment Knob (Fig. 36) clockwise (⤵) to remove slack from Mower Suspension.
7. Remove L.H. & R.H. Belt Keeper (Fig. 38) from Primary Mandrel. Roll Mower Drive Belt over Primary Mandrel.
8. Insert Gauge Wheel Bar into Bracket, Retain with Clevis Pin and Resiner Spring (Fig. 39).

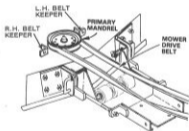


FIGURE 38

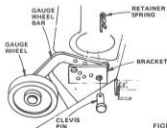


FIGURE 39

DRIVE BELT INSTALLATION

1. Place Mower Drive Belt over Clutch Pulley and under Idler Pulley and Tension Pulley (Fig. 40). NOTE: PULL LEVER UP TO SWING TENSION PULLEY FOR BELT CLEARANCE. Make sure narrow "V" side of Belt is engaged with each pulley.
2. Pull Mower Drive Belt over Front Mower Suspension Bracket (Fig. 41).

BELT ADJUSTMENT

1. Lower mower.
2. If dimension "A" on Idler Bracket Assembly measures $1\frac{1}{4}$ " or less, Mower Drive Belt must be adjusted (Fig. 40 - Inset).
3. Disengage Attachment Clutch Switch.
4. Remove Bolt, Washer & Washer, Lockwasher and Nut from Idler Pulley (Fig. 40 - Inset) (original position).
5. Place V-Belt and Idler Pulley in "NEW" Pulley position (Fig. 40 - Inset). Replace Bolt, Washers, Lockwasher and Nut. Tighten securely.
6. Check V-Belt for proper installation on all Pulley Grooves.

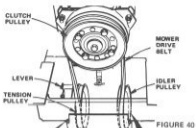
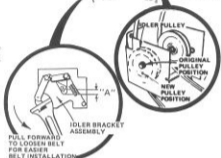


FIGURE 40



MOWER ADJUSTMENT

With the engine stopped, adjust the mower while tractor is parked on level ground or driveway. NOTE: MOWER SHOULD BE IN LOWEST CUTTING POSITION. Make sure tire pressures are 14 PSI in front; 10 PSI in rear.

SIDE TO SIDE ADJUSTMENT

1. Use a ruler to make sure bottom of curl at rear of mower deck are the same height from the ground on each side. Measure from points indicated w/arrows (Fig. 45).
2. If adjustment is required, snap out Access Cover on L.H. side of tractor above Foot Rest (Fig. 42).
3. Move Attachment Lift Lever to full "UP" position (Fig. 43).
4. To lower right side of mower, loosen Nut "B" and screw Nut "A" down on Adjustment Rod (Fig. 42).
5. To lower left side of mower, loosen Nut "B" and screw Nut "A" up on Adjustment Rod.
6. Adjust until both rear mower flanges are the same height from bottom of curl to above ground level. Tighten Nuts "A" and "B" securely. Snap Access Cover in place.

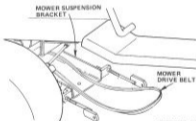


FIGURE 41

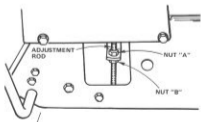


FIGURE 42

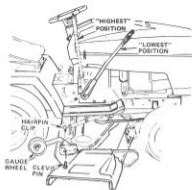


FIGURE 43

FRONT TO REAR ADJUSTMENT

Move Attachment Lift Lever to full "UP" position (Fig. 43). After leveling side to side, measure Bottom of Curl at R.H. Front Flanges at FRONT AND REAR OF MOWER. The R.H. Front Flanges should measure 3/4" lower than at the R.H. REAR flange (Fig. 45). If adjustment is required follow the procedure below.

1. TO RAISE FRONT OF MOWER
Loosen Nuts "D". Screw Nuts "C" up onto Suspension Arms (Fig. 44). NOTE: SCREW NUTS "C" ON BOTH SUSPENSION ARMS THE SAME NUMBER OF TURNS SO MOWER WILL REMAIN LEVEL. Tighten Nuts "D" securely.
2. TO LOWER FRONT OF MOWER
Loosen Nuts "C". Screw Nuts "D" down Suspension Arms, NOTE: SCREW NUTS "D" THE SAME NUMBER OF TURNS SO MOWER WILL REMAIN LEVEL. Tighten Nuts "C" securely.
3. With mower deck at desired height, set Gauge Wheels (Fig. 43) to lowest position without touching the ground.

Use adjustment Lift Lever to set mower at the approximate cutting height you need. Use Clevis Pins (Fig. 43) to set gauge wheels at lowest point without touching the ground.

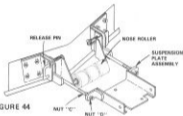


FIGURE 44

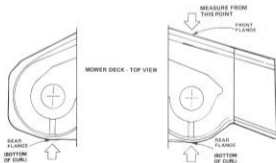


FIGURE 45

MOWER OPERATION

When ready to mow, lower Attachment Lift Lever (Fig.46) to preferred mower height. Select a gear that allows mowing at full throttle. This allows the mower blades to lift and cut the grass efficiently.

NOTE: THIS TRACTOR IS EQUIPPED WITH AN OPERATOR PRESENCE SENSING SWITCH. ANY ATTEMPT BY THE OPERATOR TO LEAVE THE SEAT WITH THE ENGINE RUNNING AND THE ATTACHMENT CLUTCH ENGAGED WILL SHUT OFF THE ENGINE.

MOWER ENGAGEMENT

Pull Attachment Clutch Switch (Fig.47) out and up to engage clutch. There will be an engine hesitation as the clutch engages.

DEPTH ADJUSTMENT

Fine adjustment of mower height is controlled by the Depth Adjustment Knob. Turn clockwise (↻) to raise mower, Turn counterclockwise (↺) to lower mower (Fig.47).



NEVER REMOVE DEFLECTOR. KEEP HANDS AND FEET FROM UNDER MOWER.

Use the Runner on the right hand side as a guide; the blade cuts approximately an inch outside the runner (Fig.48).



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 clutch.
 - 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.



NEVER ENGAGE ("ENGAGE" POSITION) MOWER EXCEPT WHEN SITTING ON TRACTOR SEAT.

TIRE CHAINS CANNOT BE USED WITH THE MOWER HOUSING ATTACHED.



READ THE "RULES FOR SAFE OPERATION" CAREFULLY BEFORE OPERATING YOUR MOWER. REFER TO PAGE 3.

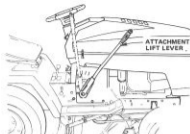


FIGURE 46

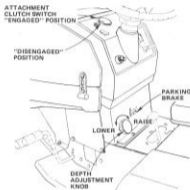


FIGURE 47

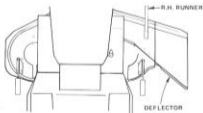


FIGURE 48



FIGURE 49

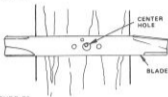


FIGURE 50

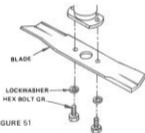


FIGURE 51

- Use Attachment Lift Lever to lower mower into cutting position. Start mowing at slow speed and increase ground speed by increasing throttle as conditions will permit. Average cutting height is approximately 2 - 1/2 to 2 - 3/4 inches. Height of cut can be adjusted by means of the Depth Adjustment Knob (Fig. 47). Turn Depth Adjustment Knob clockwise (↻) or counterclockwise (↺) to match preselected Lift Control Lever mowing height.
- Drive so that clippings are discharged onto the area that has been cut. Have the cut area to the right of the machine. This will result in a more even distribution of clippings and more uniform cutting. When mowing large areas (Fig. 49), start by turning to the right so that the clippings will be discharged away from shrubs, fences, driveways, etc. After one or two rounds, mow in the opposite direction making left hand turns until finished. If grass is extremely tall, it should be mowed twice. The first time cut relatively high. The second time to the desired height. The left hand side of mower should be used for trimming.

MOWER MAINTENANCE INSTRUCTIONS



BEFORE MAKING ANY INSPECTION, ADJUSTMENT OR REPAIR: PUSH TRACTOR CLUTCH-BRAKE PEDAL COMPLETELY INTO BRAKE POSITION. MOVE GEAR SHIFT CONTROL LEVER TO "N" NEUTRAL POSITION. PLACE PARKING BRAKE IN "ENGAGED" POSITION. DISENGAGE ATTACHMENT CLUTCH SWITCH (FIG. 47).

SHUT OFF THE ENGINE. MAKE ABSOLUTELY SURE THE BLADES AND ALL MOVING PARTS HAVE COMPLETELY STOPPED. REMOVE THE IGNITION KEY. DISCONNECT THE SPARK PLUG WIRES FROM THE SPARK PLUGS AND KEEP WIRES AWAY FROM THE PLUGS TO PREVENT INJURY FROM ACCIDENTAL STARTING.

BLADE CARE

For best results mower blades must be kept sharp. The blades can be sharpened with a few strokes of a file or on a grinding wheel. We suggest they be sharpened after every 15 hours of mowing. Do not attempt to sharpen while on mower.

- When grinding, care should be taken to maintain blade balance and the blade should be checked for proper balance before installation on mower. Unbalanced or bent blade will cause excessive vibration when running and eventual damage to mower or engine. Replace bent or damaged blades.
To check Blade balance, drive a nail into a beam or wall. Leave about one inch of the straight nail exposed. Place Center Hole of clean Blade over the head of the nail (Fig. 50). NOTE: CENTER HOLE OF BLADE ON NAIL. IF BLADE IS PROPERLY BALANCED, BLADE SHOULD REMAIN IN POSITION SHOWN IN FIG. 50. IF EITHER END OF THE BLADE MOVES DOWNWARD, BLADE IS NOT BALANCED AND MUST BE REPLACED.
- To ensure satisfactory operation, it is recommended that before the start of each mowing season, the old blades be discarded and replaced with new blades.

BLADE REPLACEMENT

It is not necessary to remove mower from tractor for blade replacement. Raising the Attachment Lift Lever will permit access to blades.

- Remove the Hex Head Bolts, Lockwasher and Flat Washer (Fig. 51).
- Install new blade with SHARP EDGE DOWN and secure with Flat Washer, Lockwasher and Hex Head Bolt. TIGHTEN SECURELY.



ALWAYS USE GRADE 5 HEAT TREATED BOLTS TO ATTACH BLADES. CHECK BOLTS IN BLADES OCCASIONALLY TO MAKE SURE BOLTS ARE TIGHT. TORQUE BOLTS 25 - 35 FT. LBS.



A GRADE 5 HEAT TREATED BOLT CAN BE IDENTIFIED BY THREE LINES INDICATED ON THE BOLT HEAD AS SHOWN AT LEFT.

DAILY MAINTENANCE

Make sure all nuts on bolts are tight, cotter pins and retainer springs are secure. Keep blades sharp. Observe all safety precautions. Keep mower well lubricated.

CLEANING MOWER



DISCONNECT SPARK PLUG WIRES TO PREVENT ACCIDENTAL STARTING BEFORE CLEANING.

Water pressure from a garden hose will remove fresh clippings from underside of mower. Clean mower after each mowing.

POWER TAKE-OFF CLUTCH

The Power Take-Off Clutch (Fig. 52) should provide years of service. The Clutch incorporates a built in brake that stops the Pulley almost immediately. Eventually, the internal brake will wear so the mower blades will not stop as recommended. Adjustment should be made by a Roper Service Technician.

OUTER BLADES DRIVE BELT (CENTER TO OUTER MANDRELS)

BELT ROUTING DECAL UNDER MOWER DECK COVER.

1. Remove Mower from Tractor (see page 22).
2. Remove Top Cover Self Tapping Screws, and Nut from Idler Arm Bolt.
3. Roll Belt over the top of the R.H. Mandrel.
4. Pull Belt off all other Mandrels.
5. Remove any dirt and grass which may have accumulated around Mandrels and Idler Arm.
6. Check Deck Idler Arm Assembly and Flat Idler to see that they rotate freely (Fig. 53).
7. Be sure spring is hooked in Deck Idler Arm Assembly and on belt in Mower Housing (Fig. 53).
8. Install new Belt in groove of L.H. Mandrel Sheave, lower groove of Center Mandrel Sheave and around Flat Idler as shown (Fig. 53).

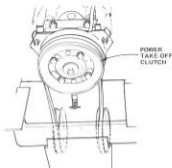


FIGURE 52

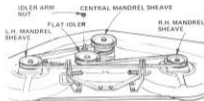


FIGURE 53

9. From a position at discharge end of mower, roll Belt into groove of R.H. Mandrel Sheave (Fig. 53).
10. Rotate Center Mandrel Sheave by hand to make sure Belt is in grooves properly.



BLADES WILL ROTATE WITH CENTER MANDREL SHEAVE.

11. Reassemble Top Cover to Deck. Tighten all Screws securely.
12. Install Mower to tractor (see page 16).

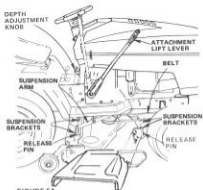


FIGURE 54

REMOVING MOWER FROM TRACTOR

1. Lower Mower.
2. Pull the four (4) Release Pins out of Suspension Brackets (Fig.54).
3. Pull back on Attachment Lift Lever and lock into place.
4. Slide Mower forward, remove L.H. & R.H. Belt Keeper and remove Belt from Primary Mandrel.
5. Raise Attachment Lift Lever, Slide Mower out from under tractor.

NOTE: IF AN ATTACHMENT OTHER THAN THE MOWER DECK IS TO BE MOUNTED ON THE TRACTOR, THE L.H. AND R.H. SUSPENSION ARMS (FIG. 54) SHOULD BE REMOVED FROM TRACTOR.

NOTE: WHEN OPERATING TRACTOR WITHOUT MOWER, REMOVE IDLER BRACKET FROM FRONT OF TRACTOR.

1. Pull Belt up through Idler Bracket and out of tractor. Use Lever to swing Tension Pulley for Belt removal.
2. Remove Lockwashers and Nuts from Idler Bracket (Fig. 55).

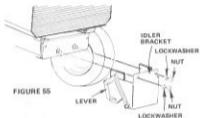


FIGURE 55

STORAGE

Remove mower from tractor for winter storage. When mower is to be stored for a period of time, clean it thoroughly, remove all dirt, grease, leaves, etc. Give blades and underside of housing a good coat of grease or rust preventative. Store in a clean dry area.

Each mandrel should be greased thru the Grease Fitting located between mower blade and underside of the mower housing (Fig. 57). Give each Grease Fitting 6 shots of Grease. Wipe fitting clean before greasing. Use high performance extreme pressure lubricating grease, (Amdex No. 1 EP or equivalent). Wipe mandrel clean of excess grease.

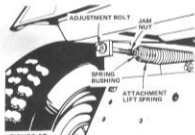


FIGURE 56

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.56).

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 lighter 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.

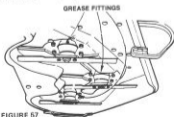
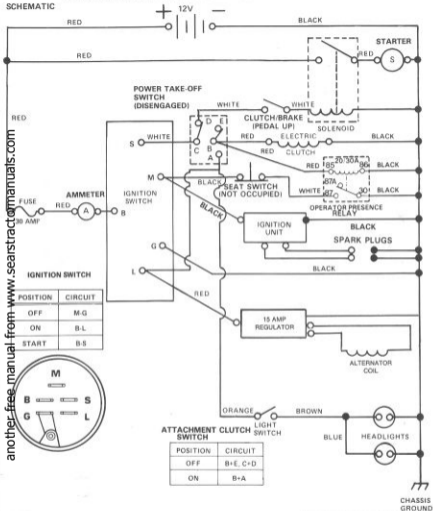


FIGURE 57

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

SCHEMATIC



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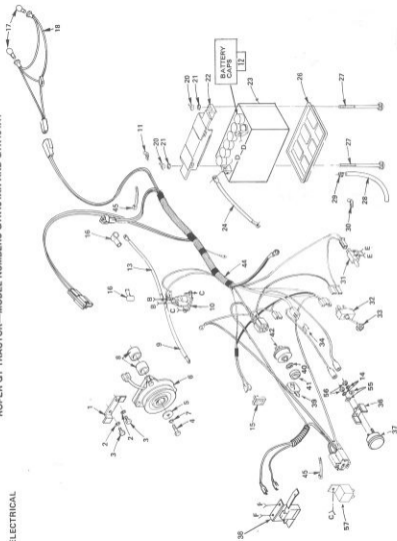
WIRING INSULATED CLIPS

NOTE: IF WIRING INSULATED CLIPS WERE REMOVED FOR SERVICING OF UNIT, THEY SHOULD BE REPLACED TO PROPERLY SECURE YOUR WIRING.

REPAIR PARTS another free manual from www.searstractmanuals.com

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

ELECTRICAL



REPAIR PARTS

ELECTRICAL

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	11282X	Stop - Clutch	33	4022J	Nut - Hex
2	10040800	Washer - Lock, 3/8	34	6347B	Fuse - 30 Amp
3	74760812	Bolt - Hex 3/8 - 16 x 3/4	35	73051000	Nut - Keys No. 10 - 32
4	74810720	Bolt - Hex 7/16 - 20 x 1 - 1/4 GR5	36	6009J	Bracket - Armrest
5	10635X	Washer	37	8433R	Ammeter
6	109550X	Clutch - Electric	38	121064X	Switch, Start
7	10040700	Washer - Lock 7/16	39	109434X	Key
8	106387X	Spacer - Clutch	40	109788X	Nut - Ignition
9	4206J	Cable - Battery	41	109787X	Bezel - Ignition
10	109081X	Solenoid	42	4406R	Switch - Ignition
11	4171R	Clip - Insulated	43	74841008	Screw - Slot - Pan HD 10-32 x 1/2
12	12035K	Battery Caps	44	110939X	Harness - Ignition
13	5115J	Cable - Starter	45	7192J	Cable Tie
14	10101000	Lockwasher	47	10090400	Lockwasher 1/4
15	110712X	Switch - Light	48	73350400	Nut - Hex-Jam 1/4 - 20
16	715J	Cover - Terminal	49	17190408	Screw - Hex Washer Hd, Cutting 1/4 - 20 x 1/2
17	7652J	Bulb - Light	50	74760412	* Bolt - Hex Hd, 1/4 - 20 x 3/4
18	112859X	Harness - Light Socket	51	19091016	Washer 9/32 x 5/8 x 16 Ga.
20	73490400	Nut - Wing 1/4 - 20	52	10040400	* Lockwasher 1/4
21	11030400	Washer - Lock 1/4 Int./Ext. Fourth	53	73220400	* Nut - Hex 1/4 - 20
22	102476X	Guard - Terminal	54	71031008	Screw - Hex Washer Hd, No. 12 - 14 x 1/2 TYP.
23	927J	Battery	55	19070818	Washer 7/32 x 1/2 x 18 Ga.
24	4297J	Cable - Ground	56	73911000	Nut
26	7603J	Tray - Battery	57	109748X	Assembly - Relay
27	72240460	Bolt - Carriage 1/4 - 20 x 7 - 1/2	---	110546K	Owner's Manual (English)
28	100641K	Tube - Plastic	---	11057X	Owner's Manual (French)
29	109595X	Clamp - Hose	---	101038K	Tractor Instruction, Tractor 15" Slope (English)
30	100207K	Clip	---	10157X	Tractor Instruction, Tractor 15" Slope (French)
31	104445X	Switch - Interlock			
32	4021J	Switch - P.T.O.			

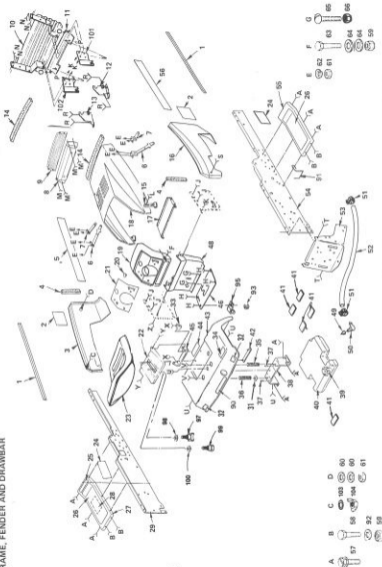
*STANDARD HARDWARE—PURCHASE LOCALLY



REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

FRAME, FENDER AND DRAWBAR



REPAIR PARTS

FRAME, FENDER AND DRAWBAR

KEY PART NO.	DESCRIPTION	KEY PART NO.	DESCRIPTION	KEY PART NO.	DESCRIPTION
1	106466X Decal-Strip, hood	37	105531X Nut-Push	72	17211018 Screw-Hex Washer Hd. Tap. No. 10-18 x 5/8 Type AB
2	106535X Decal-Size Panel, 18 H.P.	38	105520X Bracket-Fender	73	104755X "J" Fastener
3	106723X388 Strip-Frame, L.H.	39	109462X Cup-Fuel	74	7605J Nut-Crowlock 1/4-20
4	106724X Strip-Frame, R.H.	40	106020X Tank-Fuel	75	73550400 Nut-Crowlock 1/4-20
5	106743X Decal-Hood, L.H.	41	106082X Pad-Spacer	76	17190412 Screw-Hex Washer Thd. Rod, 1/4-20 x 3/4 Type T
6	106744X Strip Assembly-High, Rear	42	105511X Strap-Fender	77	174800512 Screw-Hex Washer Hd. Thd. Rod, 5/16-18 x 3/4 Type T
7	106745X Strip Assembly-High, Front	43	105933X388 Fender	78	19111212 Washer 11/32 x 3/4 x 12 Ga
8	106453X Decal-Assembly	44	106974X Decal-Caution (GTK181AR only)	79	74981020 Screw-Spich. Cr. Pan No. 10-24 x 1-1/4
9	106395X Lens	44	106558X Decal-Caution (GTK181AT only)	80	7206J Spacer Spd. No. 10 x 3/4
10	106438X Grill Assembly	45	106543X Cover, Shift-Date (GTK181AR only)	81	19070618 Washer 7/32 x 1/2 x 18 Ga.
11	105419X388 Strap-Grill	46	106426X12 Cover, Shift-Date (GTK181AT only)	82	52 73731000 Nut-Acqs No. 10-24
12	110853X Support-Grill, R.H.	46	106426X12 Cover, Shift-Date (GTK181AT only)	83	74760716 Bolt-Hex 7/16-14 x 1
13	110852X Support-Grill, L.H.	48	104608X Dash Assembly	84	73960700 Nut-Lock 7/16-14
14	106498X Strip-Foam	49	3645J Bushing	85	174506528 Screw-Hex Washer Thd. Rolling 3/8 x 16 x 1/2
15	105805X Latch-Hood	50	8710J Stern-Tank Fuel	86	120608X Washer 7/16 x 2 x 10 Ga.
16	108311X388 Panel-Side, R.H.	51	6599R Clamp-Hose	88	155252X Bolt-Shoulder
17	7985J Support-Battery	52	7834R Fuel Line	89	108456X Decal (GTK181AR only)
18	106370X388 Hood	53	7802J Drawbar	90	104810X Decal
19	106796X Plug-Dash	54	110882X Rail-Frame-R.H.	91	105500X Retainer, Bell, Lower
20	8022J Plug-Dash	55	105462X388 Footrest-R.H.	92	191312 Washer 13/32 x 13/16 x 17 Ga.
21	110790X Decal-Dashboard (GTK181AR only)	56	104648X Footrest-L.H.	93	109641X Grommet
22	110791X Decal-Dashboard (GTK181AT only)	57	17490612 Screw-Hex Washer Thread Rolling 3/8 x 16 x 3/4	94	4171R Knob
23	110840X Seat	58	74760612 Bolt-Hex 3/8-16 x 3/4	97	120068X Washer 17/32 x 1.3-1/16 x 12 Ga
24	106450X Decal-Frame Garden Tractor	59	73800600 Nut-Lock 3/8-16 x 16 Ga.	98	19171512 Bolt Shoulder 5/16-18
25	4900J Decal-Cutch/Brake (GTK181AR only)	60	1901216 Washer 3/32 x 3/4 x 16 Ga.	100	1915159E Washer 15/32 x 1 x 16 Ga.
26	101892X Decal-Cutch/Brake (GTK181AT only)	61	33220400 Nut-Hex 1/4-20	101	110884X Bracket Assy, Pencil Frame R.H.
27	105654X Footrest-L.H.	62	74760616 Washer-Lock 1/4	102	110883X Bracket Assy, Pencil Frame L.H.
28	106668X Decal-Drive Belt Schematic	63	74760616 Washer-Lock 1/4	103	11030400 Washer Lock 1/4 in./Ext. Tooth
29	110693X Rail-Frame-L.H.	64	19131316 Washer 13/32 x 13/16 x 16 Ga.	104	73490400 Nut-Wing 1/4-20
30	120599X "Washer"	65	74760616 Washer-Lock 1/4	105	74760603 Bolt-Hex 3/8-16 x 1-1/4
31	106320X Reflector-Tailight	66	72140556 Carriage 5/16-18 x 3/4		
32	2751R CIP-Insulated	69	7419P008 Screw-Cr. Pan Mach. No. 10-24 x 1/2		
33	7178J Decal-Caution (GTK181AR only)	70	10073000 Washer, Lock No. 10		
34	101893X Decal-Caution (GTK181AT only)	71	2029J Nut-Weld		
35	121007X Spring-Compression R.H.				
36	121068X Spring-Compression L.H.				

... The operation of the operator presence system (See page 4) requires that the correct washer be installed under the left hand seat spring only. A similar washer is not used under the right hand spring.

*STANDARD HARDWARE—PURCHASE LOCALLY

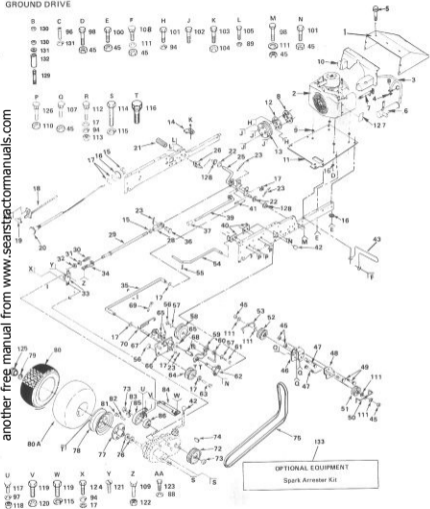


REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

GROUND DRIVE

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REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

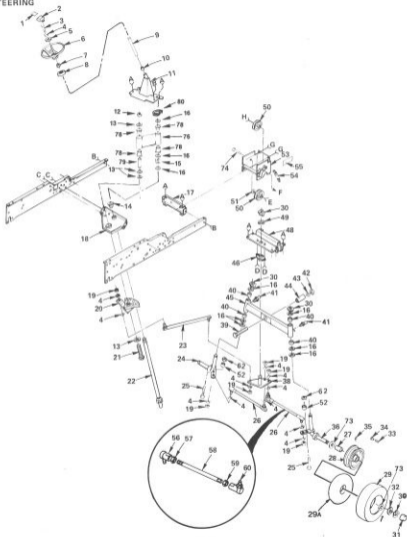
GROUND DRIVE		KEY NO.	PART NO.	DESCRIPTION
		65	207J	Washer, Hardened
		66	105592X	Bracket, Clutch w/Bearing (Incl. Key No. 68)
1	126368X	67	12000039	Klip Ring
2	M18S	68	105705X	Bearing, Idler
		69	76020816	Pin, Cotter, 1/4 x 1
		70	101355X	Spring, Extension
3	110891X			Tube Assembly - Exhaust
4	120237X			Gasket - Muffler
5	17670407	72	120332X	Pulley, Transaxle
6	120829 X	73	9204H	Nut, Lock, 1/2 - 20
7	5767H	74	9858M1	Key - Woodruff 3/16 x 5/8
8	110947X	75	110883X	V-Belt
9	110889X	76	7963R	Washer, Thrust, Axle
10	-----	77	634A892	Bushing Assembly and Wheel Hub
11	110867X	78	106277X	Rim Assy., Rear
12	104577X	79	12000034	Klip Ring
13	120331X	80	4607R	Tire, Rear
14	5304J	80A	7154J	Tube, Rear/Not furnished with tractor)
15	73610600	81	59192	Cap, Valve
16	11050600	82	65139	Stem, Valve
17	19131316	83	2228M	Key, Woodruff No. 9 3/16 x 3/4
18	110878X	84	120404X	Bracket, Support, Transaxle
19	61159	85	7920J	Band, Brake
20	110879X	86	214J	Drum, Brake
21	8883R	87	74780412	* Bolt, Hex, 1/4 - 20 x 3/4
22	19252016	88	19091016	* Washer, 9/32 x 5/8 x 16 Ga.
23	76020312	89	73690400	Nut, Crownlock 1/4 - 20
		93	74790612	Bolt, Hex, 3/8 - 16 x 3/4
25	104375X	94	10040600	* Lockwasher - 3/8
		95	19131210	Washer 13/32 x 3/4 x 10 Ga.
		96	74570512	Screw, Hex Socket Hd. 5/16-16 x 3/4
28	100604K	97	10040400	* Lockwasher 1/4
29	5308J	98	74780620	* Bolt - Hex 3/8-16 x 1-1/4 Gr. 5
30	7241J	99	11050500	Washer - Lock Ext. Tooth 5/16
31	19131614	100	74760612	* Bolt - Hex 3/8 - 16 x 3/4
32	73530600	101	74780616	* Bolt - Hex Head 3/8 - 16 x 1 Gr. 5
33	677A637	102	17190512	Screw, Hex 5/16 - 18 x 3/4
34	7229J	103	74321016	Screw - Fin 10 - 24 x 1
35	101356L	104	73631000	* Nut - Lock No. 10 - 24
36	5102J	105	74760412	* Bolt - Hex Head 1/4 - 20 x 3/4
37	71673	107	72110606	* Bolt, Carriage 3/8 - 16 x 3/4 Gr. 5
39	109767X	108	72140610	* Bolt, Carriage 3/8 - 16 x 1 - 1/4
40	105598X	109	72110506	* Bolt, Carriage 5/16 - 18 x 3/4
41	5142H	110	73680500	Nut, Lock 5/16 - 18
42	100196K	111	19131612	Washer, 13/32 x 1 x 12 Ga.
43	108885X	112	72140608	* Bolt, Carriage 3/8 - 16 x 1
		113	73220600	* Nut, Hex 3/8 - 16
45	73680600	114	74780724	Bolt, Hex 7/16 - 14 x 1 - 1/2
46	121063X	115	10040700	Lockwasher, 7/16
47	72110616	116	1304H	Bolt, Hub
48	121085X	117	72140405	* Bolt, Carriage, 1/4 - 20 x 5/8
49	72140606	118	73220400	* Nut - Hex 1/4 - 20
50	120157X	119	74760716	* Bolt - Hex 7/16 - 14 x 1
51	102403X	120	73680700	Nut - Crownlock 7/16 - 14
52	101344L	121	74370612	Screw, Mach. Udrout. Flat Head, 3/8 - 16 x 3/4
53	106023X			Nut, Lock 5/16 - 18
54	101345M	122	1685H	Screw, Hex 1/4 - 20 x 1/2
55	76020616	123	17720408	Bolt, Hex 3/8 - 16 x 7/8
56	73930600	124	74760614	Cap - Hub, Rear
57	19131413	125	104758X	* Bolt - Carriage 5/16 - 18 x 3/4
58	104360X	126	72140506	Decal - Engine
59	101347L	127	110848X	Nyloner
60	105897X	128	110895X	Stud
61	74780632	129	120235X	* Nut - 5/16-18
62	101358K	130	73520500	* Lockwasher 5/16
63	74760624	131	10173500	Spacer
64	110484X	132	120236X	Spark Arrestor Kit
		133	120689X	

*STANDARD HARDWARE—PURCHASE LOCALLY

REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

STEERING



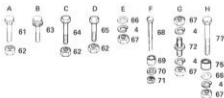
REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

STEERING

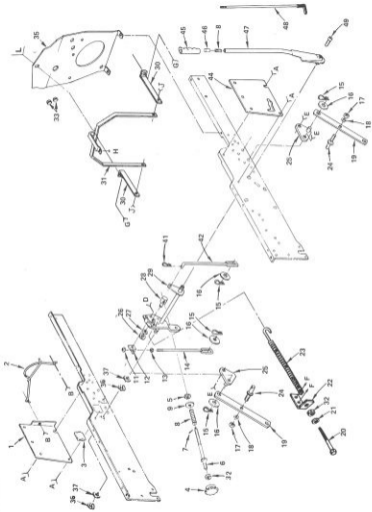
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	104580X	Decal - Steering Wheel	41	6855M	Fitting, Grease
2	100710L	Insert - Steering Wheel	42	73221000	* Nut, Hex 5/8 - 11
3	74780616	Bolt - Hex 3/8 - 16 x 1 Gr. 5	43	10041000	* Washer, Lock 5/8
4	10040600	* Washer - Lock 3/8	44	5298J	Tube, Pivot, Axle
5	1913380B	Washer 13/32 x 2-3/8 x 8 Ga.	45	6744243	Axle Assembly, Front
6	100713N	Wheel, Steering	46	5292J	Bushing, Bellcrank
7	100711L	Adapter, Steering	48	5284J	Bracket, Axle
8	106943X	Spacer - Shaft Steering	49	18292016	Washer 29/32 x 1 - 1/4 x 16 Ga.
9	108940X	Tube, Shaft	50	677A451	Washer 13/32 x 2-3/8 x 8 Ga.
10	9038R	Bearing	51	1913380B	Washer 13/32 x 2-3/8 x 8 Ga.
11	101274N	Support Assembly, Steering	52	110946X	Spindle, Stop
12	73680800	Nut, Lock 1/2 - 13	53	120542X	Bracket, Idler
13	19172610	Washer 17/32 x 1 - 5/8 x 10 Ga.	54	7190J	Spring
14	104239X	Bearing, Flanged	55	108367X	Decal, Adjustment
15	12000034	Klip Ring	56	8522R	Joint - Tie Rod - L.H. Thread
16	6266H	Bearing, Thrust	57	73700800	Nut - Hex Jam 3/8 - 24 L.H.
17	5212J	Bracket, Frame Front	58	7919J	Rod - Tie
18	102439X	Bracket, Support, Steering	59	73360600	Nut - Hex Jam 3/8 - 24
19	73610600	* Nut, Hex 3/8 - 24	60	8921R	Joint - Tie Rod - R.H. Thread
20	120424X	Sector Assembly	61	74750612	Bolt - Hex 3/8 - 16 x 3/4
21	74780880	Nut, Lock 1/2 - 13 x 5 Gr. 5	62	73680600	Nut - Lock 3/8 - 16
22	104591X	Shaft, Steering	63	17490612	Screw - Hex Washer Thd, Rolling 3/8 - 16 x 3/4
23	110457X	Link, Drag	64	74780616	Bolt - Hex 3/8 - 16 x 1 Gr. 5
24	106946X	Spindle, L.H.	65	74780616	* Bolt - Hex 3/8 - 16 x 1
25	74520632	Bolt, Hex 3/8 - 16 x 2	66	19131413	Washer 13/32 x 7/8 x 13 Ga.
26	109949X	Rod, Tie	67	73220600	* Nut - Hex 3/8 - 16
27	9040H	Bearing	68	74800516	Bolt - Hex 5/16 - 18 x 1
28	106228X	Rim Assembly - 8" Front	69	100644K	Bushing - Handle, Clutch
29	3838R	Tire	70	19111416	Washer 11/32 x 7/8 x 16 Ga.
29A	8134H	Tube (not furnished with tractor)	71	73680500	Nut, Lock 5/16 - 18
30	12000029	Klip Ring	72	106615X	Pin - Mounting, Idler Bracket
31	104757X	Cap, Hub, Front	73	19252616	Washer 25/32 x 1-5/8 x 16 Ga.
32	19252016	Washer, 25/32 x 1-1/4 x 16 Ga.	74	74780632	Bolt, Hex 3/8 - 16 x 2
33	59192	Cap, Valve	75	102933X	Spacer
34	65139	Stem, Valve	76	120195X	Collar Weld Ass'y.
35	278H	Fitting, Grease	77	74780636	Bolt - Hex 3/8-16 x 2-1/4
36	106045X	Spindle, R.H.	78	120200X	Nyliner
38	108137X	Bellcrank Assembly	79	120199X	Tube
39	74781044	Bolt - Hex 5/8 - 11 x 2 - 3/4 Gr. 5	80	120800X	Clamp Hose
40	1306H	Bearing			

*STANDARD HARDWARE—PURCHASE LOCALLY



ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

MOWER LIFT



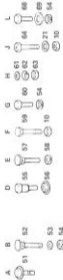
REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

MOWER LIFT

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	121044X	Panel, Side, L.H.	28	110810X	Trumion, Stop Depth	60	74350512	Bolt - Hex 5/16 - 18 x 3/4
2	110900X	Guard Assembly - Belt, Engine	29	120137X	Sheet, Lift	61	18091216	Washer, 9/32 x 3/4 x 16 Ga.
3	105000X	Cover, Access	30	109603X	Bracket - Shield, Heat, Side	62	10090400	Washer, Lock 1/4
4	107344K	Handle, Adjust, Lift	31	106927Z	Support Assembly - Dersh	63	73220400	Nut, Hex 1/4 - 20
5	119807X	Nut	32	73300000	Nut - Hex Jam 3/8-160 NC	64	74790812	Bolt - Hex 3/8 - 16 x 3/4
6	119811X	*Nut, Adjust, Lift	33	110430X	Grommet	68	74760512	*Bolt - Hex 5/16 - 18 x 3/4
7	76020008	*Pin, Cotter	35	110572X	Base - Shield, Heat	69	1911216	Washer, 11/32 x 3/4 x 16 Ga.
8	2876H	Spring	36	12000222	Klip - Ring			
9	19131016	Washer 13/32 x 5/8 x 16 Ga.	37	19290116	Washer 29/32 x 1-1/4 x 16 Ga.			
10	73680600	Nut, Lock, 3/8 - 16	41	4839M	Retainer, Spring			
11	73800600	Nut, Lock, Hex w/ Washer, 3/8 - 16	42	105503X	Link, Lift, R.H.			
12	7994J	Bracket, Lift, L.H.	44	121043X	Panel, Side, R.H.			
13	73220600	*Nut, Hex 3/8 - 16	45	109413X	Grip, Handle			
14	7596J	Link, Lift, L.H.	46	105723X	Plunger - Lever, Lift			
15	8135R	Retainer Spring	47	121002X	Lever Assembly - Lift			
16	19171713	*Washer 17/32 x 1 - 1/16 x 13 Ga.	48	121006X	Rod Assembly - Lever			
17	73220800	*Nut, Hex, 1/2 - 13	49	74780624	Bolt - Hex 3/8 - 16 x 1-1/2			
18	10040800	*Washer, Lock, 1/2						
19	105429X	Arm, Suspension	51	12490008	Screw, Hex Washer Thrd, 3/8 - 16 x 1/2			
20	532B	Bolt - Adjust, Spring, Assist	52	72140508	*Bolt - Carriage, 9/16 - 18 x 1			
21	19131316	*Washer 13/32 x 13/16 x 16 Ga.	53	1911810	Washer 11/32 x 1 x 10 Ga.			
22	5329J	Bracket, Spring - Assist	54	73680500	Nut, Lock, 5/16 - 18			
23	8744A247	Spring Assembly - Assist, Lift	55	7901J	Bolt, Shoulder			
24	105413X	Stud, Pivot Center	56	73900400	Nut, Hex Flange 1/4 - 20			
25	1055011X	Bracket, Suspension	57	72140606	*Nut, Carriage, 3/8 - 16 x 3/4			
26	13000037	Klip Ring	58	73900600	Nut - Crimperlock 3/8 - 16			
27	19151216	Washer 15/32 x 3/4 x 16 Ga.	59	74790816	*Bolt - Hex 3/8 - 16 x 1			

*STANDARD HARDWARE - PURCHASE LOCALLY

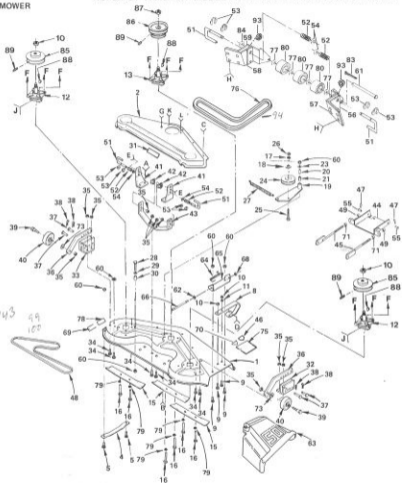


REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

MOWER

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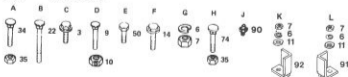


REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

MOWER

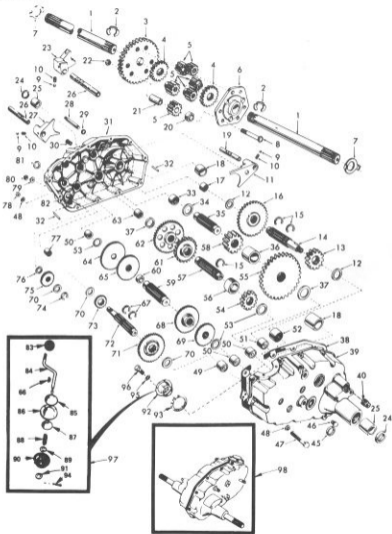
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	110545X	Housing, Mower	48	3703J	V-Belt
2	110543X	Cover - Drive Deck	49	73680600	*Nut, Crownlock 1/2 - 13
3	1748050B	Screw - Hex Washer Thd. Roll 5/16 - 18 x 1/2	50	74760822	Bolt, Hex 3/8 - 16 x 1 - 3/8
4	7631J	Runner, L.H.	51	105435X	Pin, Release
5	7211090B	*Bolt, Carr, 5/16 - 18 x 5/8	52	3720R	Spring
6	10040500	*Washer - Lock, 5/16	53	12000039	Ring, Klip
7	73220500	*Nut - Hex 5/16 - 18	54	19171612	Washer 17/32 x 1 x 12 Ga.
8	120449X	Runner, R.H.	55	105440X	Pin, Clevis
9	72140506	*Bolt, Carr, 5/16 - 18 x 3/4	56	105458X	Brkt., Outer, R.H.
10	1685H	Nut, Lock 5/16 - 18	57	109773X	Brkt., Inner, R.H.
11	19111116	*Washer 11/32 x 11/16 x 16 Ga.	58	110997X	Brkt., Inner, L.H.
12	677A344	Mandrel - Secondary	59	120000X	Brkt., Outer, L.H.
13	674A225	Mandrel - Primary	60	73680600	Locknut 5/16 - 18
14	17490612	Screw - Hex Washer Thd. Roll 3/8 - 16 x 3/4	61	109776X	Pin, Pivot
15	3695J	Blade	62	19111016	Washer 11/32 x 5/8 x 16 Ga.
16	74780712	*Bolt - Hex, 7/16 - 14 x 3/4 Gr. 5	63	110509X	Shield, Deflector
17	10040600	*Washer - Lock, 3/8	64	106734X	Spring, Deflector
18	19131614	Washer, 13/32 x 1 x 14 Ga.	65	109743X	Bracket, Deflector
19	674A213	Arm Assembly, Idler	66	106735X	Rod, Hinge
20	7834J	Liner - Bearing	68	110452X	Push Nut
21	7835J	Bearing	69	3713J	Decal - Instruction, Caution
22	72110522	Bolt, Carriage 5/16 - 18 x 2 - 3/4	70	-----	Decal, Caution - Not Serviced
23	19111610	Washer 11/32 x 1 x 10 Ga.	71	73220800	Nut - Hex 1/2 - 13
24	102403X	Pulley, Idler	73	19171512	Washer 17/32 x 15/16 x 12 Ga.
25	74780624	*Bolt - Hex 3/8 - 16 x 1 - 1/2	74	72240608	Bolt, Carriage 3/8 - 16 x 1
26	73220600	*Nut - Hex 3/8 - 16	75	109819X	Decal - Warning
27	104361X	Spring	76	110885X	V-Belt
28	74780520	*Bolt - Hex 5/16 - 18 x 1 - 1/4 Gr. 5	77	19151610	Washer 15/32 x 1 x 10 Ga.
29	19111216	Washer 11/32 x 3/4 x 16 Ga.	78	105185X	Decal - Instruction - Decal (GTK181AT only)
30	8438J	Spacer Split	79	10040700	Lockwasher 7/16
31	106224X	Decal - V-Bolt, Dr. Schematic, Mower	80	109729X	Nosebar
32	105448X	Bracket, Ga. Wheel, R.H.	83	79520412	Cotterpin
33	105449X	Bracket, Ga. Wheel, L.H.	84	19151818	Washer 15/32 x 1 x 16 Ga.
34	72240606	*Bolt, Carriage 3/8 - 16 x 3/4	85	3681J	Pulley
35	73680600	Nut, Crownlock 3/8 - 16	86	7710J	Pulley
36	105453X	Bar, Ga. Wheel	87	73611200	Nut - Hex
37	5565J	Pin, Clevis	88	8330H	Key
38	4939M	Retainer, Spring	89	23180608	Scr - Hex Fgd Socket 3/8 x 16 x 1/2
39	4898H	Bolt, Shoulder	90	6855M	Grease Fitting
40	105455X	Wheel, Gauge	91	3700J	Brkl. Guard, R.H.
41	105433X	Brkt., Suspension	92	3701J	Brkl. Guard, L.H.
42	110237X	Spacer	93	120135X	Spacer
43	105434X	Brace, Suspension			* STANDARD HARDWARE—PURCHASE LOCALLY
44	109778X	Plate Assy., Mower Suspension			
45	109771X	Brkt., Suspension			
46	78850	Decal - Warning (GTK181AR only)			
47	107339X	Decal - Warning (GTK181AT only)			
48	3146R	Retainer - Spring			



REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT
TRANSAXLE

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REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT

TRANSAXLE

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	4197R	Axle Shaft	49	4895H	Needle Bearing
2	5845R	Retaining Ring	50	4222R	Needle Bearing
3	4199R	Final Drive Gear	51	1529R	Needle Bearing
4	4216R	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	6256H	Axle Thrust Washer	55	4213R	4th Reduction Gear
8	74020652	Hex Bolt 3/8 - 24 x 3 - 1/4 (1" 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	4196R	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	8118M	Needle Bearing	66	4204R	Reverse Gear
18	8740H1	Sintered Iron Bearing	66	2896J	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			
25	392 R1	Sintered Iron Bearing	72	208J	Input Shaft
26	6216H	Shift Fork Shaft	73	4201R	Low Speed Pinion
27	6262H	Shift Fork - R.H.	74	12000002	E-Ring
28	101416X	Shift Shaft, High - Low Range	75	1153R	Reverse Idler Gear
29	6269H	Oil Seal	76	7392H	Reverse Idler Thrust Washer
30	5855H	Pressure Relief Valve	77	3990H	Needle Bearing
31	105406X	Grease, Reverse Idler Shaft and Bearings - R.H. (Inc. Key No's. 17, 18, 25, 33, 50, 63, 76, 77 and 82)	78	73220500	*Hex Nut 5/16 - 18
			79	1167R	Sealing Washer
			80	73360700	Hex Jam Nut 7/16 - 20
32	6277H	Dowel Pin	81	6270H	Oil Seal
33	4225R	Needle Bearing	82	7384H	Reverse Idler Shaft
34	7396H	Thrust Bearing Race	83	106106K	Control Knob
35	4198R	4th Reduction Gear Shaft	84	5384J	Gear Shift Lever - Best
36	4200R	4th Reduction Gear Spacer	85	2975J	Gear Shift Cap
37	7395H	Thrust Bearing Race	86	633A85	Gear Shift Ball Cover and Pin
38	6275H	Grease Gasket	87	8739H1	Shift Lever Guide Ball - Keyed
39	105402X	Grease and Bearings - L.H. (Inc. Key No's. 18, 25, 49, 50 (2), 51 and 52)	88	4924H	Spring
			89	19151516	Washer 15/32 x 15/16 x 16 Ga.
40	13060400	Pipe Plug 1/2 - 14 N.P.T.	90	110542X	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	74780524	*Hex Bolt 5/16 - 18 x 1 - 1/2 Grade 5	93	6274H	Shift Ball Cover Gasket
			94	76020412	Cotter 1/8 x 3/4
			95	10040500	*Lockwasher 5/16
48	10140500	Lockwasher 5/16 Extra Heavy	96	74760514	*Hex Bolt 5/16 - 18 UNC x 7/8
			97	633A109	Gear Shift Lever Ass'y.
			98	105474X	Transaxle Assembly Less Brake Drum & Shift Lever

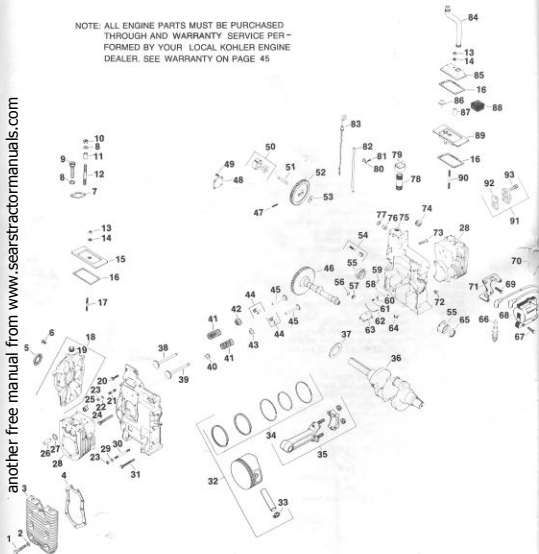
*STANDARD HARDWARE - PURCHASE LOCALLY

REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT
ENGINE -- KOHLER MODEL M18S SPEC. 24573

NOTE: ALL ENGINE PARTS MUST BE PURCHASED THROUGH AND WARRANTY SERVICE PERFORMED BY YOUR LOCAL KOHLER ENGINE DEALER. SEE WARRANTY ON PAGE 45

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REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT ENGINE -- KOHLER MODEL M18S SPEC. 24573

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	41-086-02	Screw 5/16 - 18 x 1-1/2 (16)	42	52-413-01	Rotator, exhaust valve (2)
2	220534	Washer 5/16 (18)	43	230011	Retainer, valve spring (2)
3	52-015-08	Head, cylinder (2)	44	41-755-10	Kit, retainer (4)
4	52-041-18	Gasket, head (2)	45	52-019-03	Tappet (4)
5	X-583-5	Seal, rear oil	46	52-012-07	Carnishalt
6	X-802-9	Screw, hex. wash. hd. 5/16 - 18 x 1 (9)	47	X-280-15	Pin, roll
7	52-041-14	Gasket, exhaust (2)	48	52-096-03	Cover, oil pump
8	X-21-1	Washer, lock 5/16 (4)	49	X-67-64	Screw, hex. wash. hd. 10-32 x 7/16 (4)
9	X-55-6	Screw, Hex. sock. hd. 5/16 - 18 x 3/4 (2)	50	52-393-09	Rotor set
10	X-82-2	Nut, hex. 5/16 - 18 (2)	51	52-144-05	Shaft, oil pump
11	52-112-08	Spacer 2 - 1/4" long	52	52-043-05	Gear, oil pump
12	52-072-13	Stud 5/16 - 18 x 4 (2)	53	52-422-01	Spacer (A.R. max. 2)
13	X-81-1	Nut, hex. 1/4 - 20 (2)	54	52-755-50	Kit, oil relief
14	X-25-12	Washer, plain 1/4 (2)	55	52-030-10	Bearing, sleeve (2)
15	52-096-18	Cover, #2 cylinder valve	52-030-11	Bearing, sleeve (.010) (2)	
16	52-055-01	Gasket, cover (3)	52-030-12	Bearing, sleeve (.020) (2)	
17	X-352-39	Stud, #2 cyl. valve 1/4 - 20 x 2-1/4	56	52-141-02	O-Ring
18	52-755-55	Kit, closure plate (Includes 19)	57	52-139-08	Plug 3/4" O.D.
19	X-75-23	Plug, hex. ctsk. 1/8 N.P.T.F.	58	52-123-10	Tube, oil pickup
20	25-086-10	Screw, hex. flange 5/16 - 18 x 1-1/2 (3)	59	X-702-15	Plug, Cup 5/16
21	52-072-12	Steo stud 5/16 - 18 x 3/4", 3/8 - 16 x 5/8", 2" long	60	52-237-05	Clamp, tube
22	52-468-12	Washer, flat 5/16 (12)	61	X-67-64	Screw, hex. wash. hd. 10-32 x 7/16
23	X-82-2	Nut, hex. 5/16 - 18 (16)	62	52-237-02	Clip, spring
24	25-086-13	Screw, hex. flange 3/16 - 16 x 3-5/8 (2)	63	52-095-03	Housing, oil pickup
25	52-158-04	Bushing, locating (2)	64	X-75-32	Plug, hex. ctsk. 3/8 N.P.T.F. (2)
26	52-316-06	Guide, valve (4)	65	52-032-10	Seal, front oil
27	230265	Insert, valve seat (4)	66	51-132-02	Spark plug (2)
28	52-755-81	Kit, cylinder barrel (Includes 25-27)	67	25-086-15	Screw, hex. wash. hd. 1/4 - 20 x 1 (2)
29	41-468-01	Washer, plain 5/16 (4)	68	52-584-02	Module, ignition
30	X-352-33	Stud, 5/16 - 18 x 4-1/8 (2)	69	25-086-16	Screw, hex. wash. hd. 1/4 - 20 x 7/8 (2)
31	25-086-11	Screw, hex. flange 5/16 - 18 x 3-1/2 (6)	70	52-313-02	Grommet
32	58-874-11	Piston w/Ring Set (Std.) (2)	71	52-126-08	Bracket, module
	52-874-12	Piston w/Ring Set (.003) (2)	72	X-75-10	Plug, solid sq. hd. 3/8 N.P.T.F.
	52-874-13	Piston w/Ring Set (.010) (2)	73	25-086-12	Screw, hex. flange 5/16 - 18 x 2 (2)
	52-874-14	Piston w/Ring Set (.020) (2)	74	X-75-23	Plug, hex. ctsk. 1/8 N.P.T.F.
	52-874-15	Piston w/Ring Set (.030) (2)	75		Crankcase (Service with Short Block 82-522-11)
33	230004	Retainer, piston pin (4)	76	52-078-05	Shaft, governor
34	52-108-09	Ring set (Std. & .003) (2)	77	X-269-43	Ring, retaining
	52-108-10	Ring set (.010) (2)	78	46-136-02	Pipe nipple 3/4 I.P. x 2-1/2
	52-108-11	Ring set (.020) (2)	79	52-173-01	Pipe Cap
	52-108-12	Ring set (.030) (2)	80	52-154-01	Clip, tube
35	52-067-67	Connecting Rod (Std.) (2)	81	X-67-64	Screw 10-32 x 7/16
	52-067-68	Connecting Rod (.010) (2)	82	52-123-09	Tube, dipstick
36	52-014-64	Crankshaft (3-9/16" x 1" tapped P.T.O.)	83	52-038-04	Dipstick
37	52-468-03	Washer, thrust .119/.121 (A.R.)	84	52-326-05	Hose, breather
	52-468-04	Washer, thrust .128/.131	85	52-096-08	Cover, #1 upper cylinder valve
	52-468-05	Washer, thrust .137/.140 (A.R.)	86	52-462-01	Valve, umbrells
38	52-016-02	Valve, exhaust (2)	87	52-032-04	Seal, breather
39	52-017-08	Valve, intake (2)	88	231419	Filter, breather
40	52-032-13	Seal, intake valve stem (2)	89	52-096-22	Cover, #1 lower cylinder valve
41	Spring, valve (4)		90	275220	Stud, #1 cyl. valve 1/4 - 20 x 3-1/4
			91	52-755-66	Kit, filter cover (Includes 92 & 93)
			92	52-041-16	Gasket, filter cover
			93	X-55-15	Screw, hex. sock. hd. 5/16 - 18 x 1-1/4 (2)
				52-518-22	NOT ILLUSTRATED
					Lead, Black module to connector (12-1/2" - 18 gauge — insulated push on tab — uninsulated push on tab terminals)

REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT
ENGINE -- KOHLER MODEL M18S SPEC. 24573

NOTE: ALL ENGINE PARTS MUST BE PURCHASED THROUGH AND WARRANTY SERVICE PERFORMED BY YOUR LOCAL KOHLER ENGINE DEALER. SEE WARRANTY ON PAGE 45

another free manual from www.seartractormanuals.com



REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT ENGINE -- KOHLER MODEL M18S SPEC. 24573

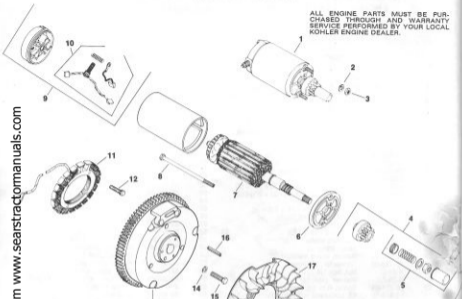
AIR CLEANER — CARBURETOR GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	X-276-7	Wing nut 1/4 - 20	39	52-531-02	Stop, high speed
2	52-096-36	Cover, air cleaner	40	52-144-15	Shaft, throttle w/seal
3	231032	Seal, element cover	41	25-146-02	Plate, throttle
4	52-082-04	Cover, air cleaner element	42	25-086-27	Screw, throttle & choke plate (4)
5	45-063-01	Precleaner	43	25-368-01	Needle, idle
6	45-063-02	Element, air cleaner	44	25-089-02	Spring, idle
7	237423	Seal, air cleaner cover	45	25-086-26	Screw, throttle
8	X-67-98	Screw, hex. wash. hd. 10 - 32 x 9/16 (4)	46	25-089-04	Spring, throttle
9	52-201-06	Base, air cleaner	47	52-090-12	Shaft, choke
10	277093	Gasket, air cleaner base	48	52-337-06	Jet, main (.055)
11	52-754-01	Kit, elbow (Includes 12 & 13)	49	25-041-04	Gasket, bowl
12	52-086-11	Screw, self tap 1/4 - 20 x 5/8	50	25-757-09	Kit, float
13	25-041-06	Gasket, air intake elbow	51	25-104-01	Bowl, fuel
14	X-22-9	Washer, lock #10 (2)	52	25-041-03	Gasket, bowl retainer screw
15	X-50-57	Screw, sltd. pan hd. 10 - 32 x 1-1/2 (2)	53	25-100-05	Screw, bowl retainer
16	X-50-37	Screw, sltd. pan hd. 10 - 32 x 2-1/4 (2)	54	25-146-03	Plate, choke
17	X-25-79	Washer, plain #10	55	25-194-01	Ball, choke friction
18	X-6-8	Screw, H.C. 5/16 - 18 x 2-3/4 (4)	56	25-089-03	Spring, choke friction
19	X-21-1	Washer, lock 5/16 (4)	57	231355	Pin, governor stop
20	X-77-2	Nut 5/16 (2)	58	X-25-12	Washer, plain 1/4
21	X-352-37	Stud 5/16 - 18 x 1 (2)	59	X-25-63	Washer, plain 1/4
22	52-184-10	Manifold, intake	60	X-288-28	Retainer, governor
23	52-445-02	Strap, lifting (2)	61	X-25-102	Washer, plain 1/4 (2)
24	52-041-09	Gasket, intake manifold (2)	62	A-235743-5	Kit, governor gear
25	25-155-02	Connector, 90° hose	63	52-078-04	Shaft, governor cross
26	X-81-1	Nut, hex 1/4 - 20	64	52-353-04	Line, fuel 1/4" I.D. x 6-3/4" long
27	X-25-72	Washer, plain 1/4	65	X-426-9	Clamp, hose (4)
28	52-211-04	Screw, R.H. sq. neck 1/4 - 20 x 1	66	25-155-02	Connector, 90° hose
29	52-853-10	Kit, carburetor w/linkage (Includes 13, 30-33, 40-56)	67	52-559-01	Pump, fuel assembly (Includes 68 & 69)
30	25-158-07	Bushing, linkage (2)	68	52-041-17	Gasket, fuel pump
31	52-079-08	Linkage, governor	69	X-25-63	Washer, plain 1/4 (2)
32	52-186-06	Arm, governor	70	47-086-08	Screw, pozidriv T.H. 1/4 - 20 x 5/8 (2)
33	271030	Gasket, carburetor	71	25-353-15	Line, fuel 1/4" I.D. x 7" long
34	52-091-04	Spring, governor	72	25-050-01	Filter, fuel
35	235778	Clamp, cable (2)			NOT ILLUSTRATED
36	X-67-97	Screw, H.C. 10 - 24 x 7/16 (2)		25-113-07	Decal, air cleaner
37	52-119-01	Lever, speed control		25-757-06	Kit, carburetor repair
38	234614	Stop, governor		52-755-98	Kit, high altitude jet

REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT
ENGINE -- KOHLER MODEL M18S SPEC. 24573

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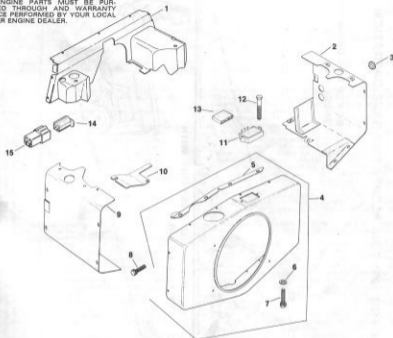
STARTER MOTOR GROUP

KEY NO.	PART NO.	DESCRIPTION
1	52-098-03	Starter assembly (includes 4-10)
2	X-20-1	Washer, lock 1/4 (2)
3	X-81-1	Nut, hex. 1/4 - 20 (2)
4	52-755-05	KR, drive (includes 5)
5	52-755-08	KR, drive parts
6	52-227-01	Cap, drive end
7	52-170-02	Armature
8	52-211-01	Bolt, thru 1/4 - 20 x 5-7/8 (2)
9	48-227-04	Cap, commutator end (Includes 10)
10	48-755-15	Kit, brush
11	237878	Kit, stator
12	X-57-51	Screw, hex. wash. hd. 10 - 24 x 3/4 (4)
13	52-025-36	Flywheel
14	52-114-02	Washer, plain 3/8" I.D. x 1-3/8" O.D.
15	25-086-24	Screw, hex. mach. 3/8 - 24 x 1-1/4
16	X-286-17	Key, square 3/16 x 7/8
17	25-175-01	Fan
18	25-112-04	Spacer 1/8"
19	25-086-21	Screw, hex. wash hd. 1/4 - 20 x 5/8 (4)
20	237373	Adapter, Front Drive
21	X-159-2	Screw, H.C. 3/8 - 16 x 1 (4)
22	25-162-02	Screen, grass 3-1/2" dia. hole
		NOT ILLUSTRATED
	25-450-03	Tag, caution

REPAIR PARTS

ROPER GT TRACTOR—MODEL NUMBERS GTK181AR AND GTK181AT ENGINE -- KOHLER MODEL M18S SPEC. 24573

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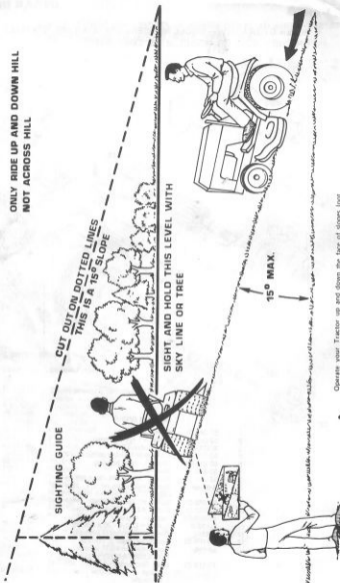


HOUSING GROUP

1	52-282-01	Cover, air duct
2	52-063-24	Baffle, #1 cylinder head
3	X-301-8	Plug, button (2)
4	52-755-70	Kit, blower housing (includes 5-7)
5	52-217-01	Support, upper housing
6	52-488-18	Washer, plain (2)
7	52-088-11	Screw, self tap 1/4 - 20 x 5/8 (2)
8	X-67-83	Screw, hex. wash. hd. 1/4 - 20 x 7/28 (32)
9	52-063-21	Baffle, #2 cylinder head
10	52-063-01	Baffle, #2 cylinder top
11	41-403-09	Rectifier, regulator
12	X-132-5	Screw, H.C. 1/4 - 20 x 5/8 (2)
13	238602	Connector, female (3 contact)
14	41-155-03	Connector, male (2 contact)
15	52-155-04	Connector, female (2 contact)
	25-518-21	NOT ILLUSTRATED Lead, Red rectifier-regulator (5" — 14 gauge — uninsulated push on tab terminals)

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.

