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OWNER'S MANUAL

18T GARDEN TRACTOR

MODEL NUMBER T8328BR

ONAN ENGINE ~~30~~ 405670-
7015ORDAN 185.
DIXIE EQUIPMENT TERRY PK
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DIVISION OF ROPER CORPORATION

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CONGRATULATIONS . . .

On your purchase of a Roper 18T Twin-Garden Tractor, It has been designed, engineered and manufactured to give you dependability and performance. Should you experience any problem you cannot easily remedy, please contact your nearest authorized Roper dealer. He has competent, 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 Twin-Garden Tractor.

LIMITED WARRANTY ROPER OUTDOOR POWER PRODUCTS

Roper Corporation warrants to the original consumer purchaser that this product is free from defects in materials and workmanship. For a period of one (1) year from date of purchase, we will repair or replace, at our option, without charge, any part except for the engine which we find to be defective due to materials or workmanship. This warranty is subject to the following limitations:

1. Engine Warranty: All engine powered Roper products have a separate Engine Warranty extended by the individual Engine Manufacturer. The Engine Warranty must be referred to in the event of an engine problem.
2. Battery Warranty: On products equipped with a battery, Roper will replace, without charge to you, any battery which we find to be defective during your first ninety (90) days of ownership. After ninety (90) days, we will exchange the battery charging you 1/12 of the price for a new battery for each full month from the date of the original sale.
3. The warranty period for any products used for rental or commercial purposes is limited to 45 days from the date of original purchase.
4. This warranty applies only to products which have been properly assembled, adjusted and operated in accordance with instructions found in the Product Literature for your product. This warranty does not apply to any product which has been subjected to alteration, misuse, abuse, improper assembly or installation or delivery damage.
5. In the event you have a claim (other than an engine claim) under this warranty, you must return the product to an authorized Roper Outdoor Power Products service dealer.

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

Roper Outdoor Power Products
Division of Roper Corporation
Service Department
1905 West Court Street
Kankakee, Illinois 60901

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 any 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 limitations 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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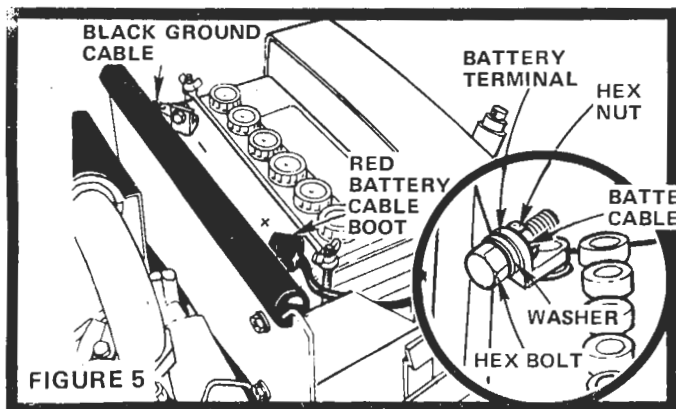
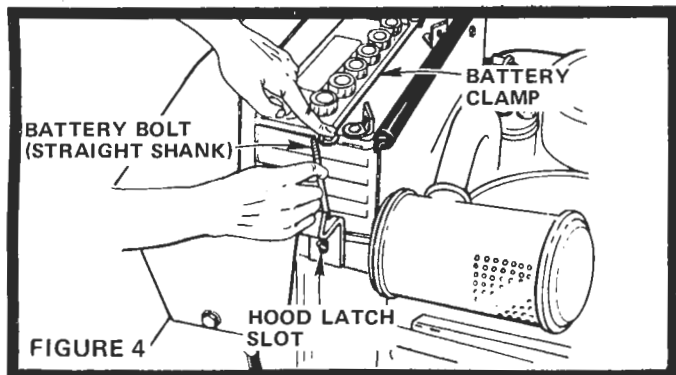
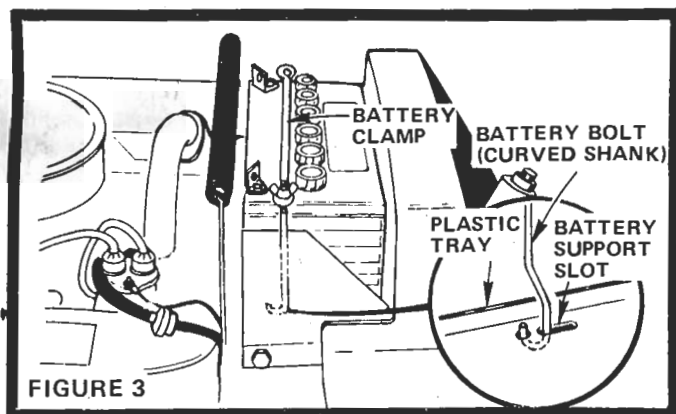
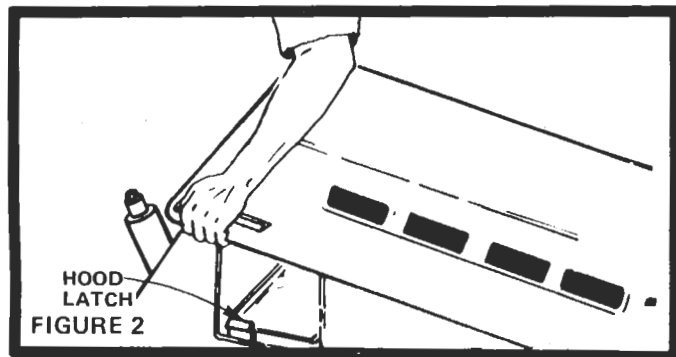
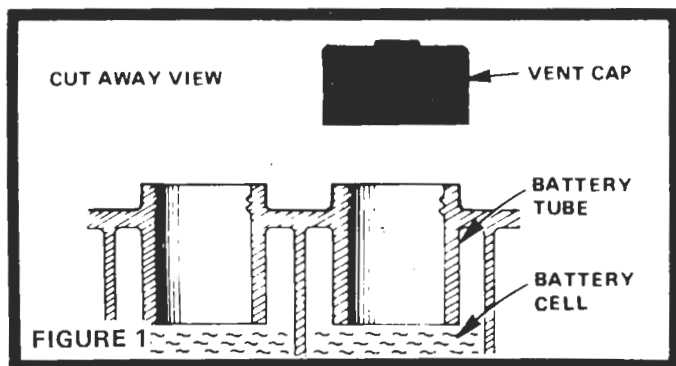
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RULES FOR SAFE OPERATION

1. Know the controls and how to stop quickly. READ THE OWNER'S MANUAL.
2. Do not allow children to operate the vehicle. Do not allow adults to operate it without proper instruction.
3. Do not carry passengers. Keep children and pets a safe distance away.
4. Always wear substantial footwear. Do not wear loose fitting clothing that could get caught in moving parts.
5. Keep your eyes and mind on your tractor, mower and the area being cut. Don't let other interests distract you.
6. Do not attempt to operate your Tractor or mower when not in operator's seat.
7. Always get on or off your tractor from the operator's left hand side.
8. Clear the work area of objects which might be picked up and thrown.
9. Disengage all attachment clutches and shift into neutral before attempting to start the engine.
10. Disengage power to attachments and stop the engine before leaving the operator's position.
11. Disengage power to mower, stop the engine and disconnect spark plug wire(s) from spark plug (s) before cleaning, making an adjustment or repairs.
12. Disengage power to attachments when transporting or not in use.
13. Take all possible precautions when leaving the vehicle unattended, such as disengaging the power-take-off, lowering the attachments, shifting into neutral, setting the parking brake, stopping the engine, and removing the key.
14. Do not stop or start suddenly when going uphill or downhill. Mow up and down the face of slopes (not greater than 15°); never across the face.
15. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
16. Do not shift gears while going up or down slopes. Choose a gear low enough to negotiate the slope without stopping and shifting gears. To reduce speed, move throttle lever to slow.
17. Never mow in wet or slippery grass, when traction is unsure or at a speed which could cause a skid.
18. Stay alert for holes in the terrain and other hidden hazards.
19. Do not drive too close to creeks, ditches and public highways.
20. Exercise special care when mowing around fixed objects in order to prevent the blades from striking them. Never deliberately run tractor or mower into or over any foreign object.
21. Never shift gears until tractor comes to a stop.
22. Never place hands or feet under the mower, in the deflector (discharge chute) or near any moving parts while tractor or mower are running. Always keep clear of discharge chute.
23. Use care when pulling loads or using heavy equipment.
 - a. Use only approved drawbar hitch points.
 - b. Limit loads to those you can safely control.
 - c. Do not turn sharply. Use care when backing.
 - d. Use counterweights or wheel weights when suggested in this owner's manual.
24. Watch out for traffic when crossing or near roadways.
25. When using any attachments, never direct discharge of material toward bystanders nor allow anyone near the vehicle while in operation.
26. Handle gasoline with care - it is highly flammable.
 - a. Use approved gasoline containers.
 - b. Never remove the cap of the fuel tank or add gasoline to a running or hot engine, or fill the fuel tank indoors. Wipe up spilled gasoline.
 - c. Open doors if the engine is run in the garage - exhaust fumes are dangerous. Do not run the engine indoors.
27. Keep the vehicle and attachments in good operating condition, and keep safety devices in place.
28. Keep all nuts, bolts and screws tight to be sure the equipment is in safe working condition.
29. Never store the equipment with gasoline in the tank inside a building where fumes may reach an open flame or spark. Allow the engine to cool before storing in any enclosure.
30. To reduce fire hazard, keep the engine free of grass, leaves or excessive grease.
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.
33. When using the vehicle with mower, proceed as follows:
 - a. Mow only in daylight or in good artificial light.
 - b. Never make a cutting height adjustment while the engine is running if the operator must dismount to do so.
 - c. Shut the engine off when removing the grass catcher or unclogging chute.
 - d. Check the blade mounting bolts for proper tightness at frequent intervals.
34. Check the grass catcher bags frequently for wear or deterioration. Replace with new bags for safety protection.
35. Do not operate the Mower without either the entire grass catcher, on mowers so equipped, or the deflector shield in place.



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



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

NOTE: Right Hand (R.H.) and Left Hand (L.H.) are determined from operator's position.

ASSEMBLY

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



WEAR EYE AND FACE SHIELD.

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



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

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



DO NOT SMOKE. FUMES FROM CHARGED ELECTROLYTE ARE EXPLOSIVE.

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

3. Install Battery using:



Battery Clamp, two Wing Nuts, two Battery Bolts,



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

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



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

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

4. Install Steering Wheel using:



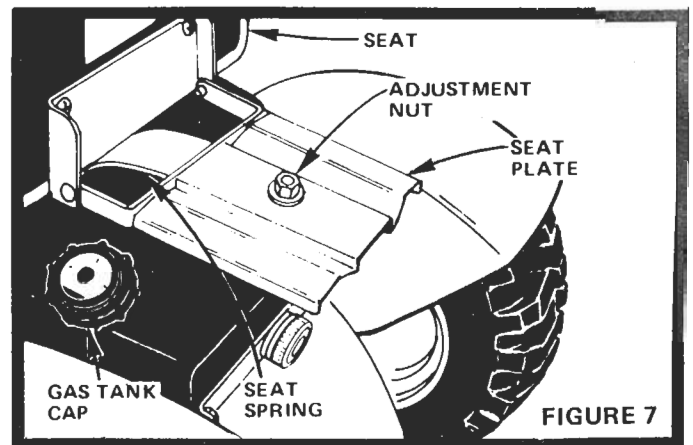
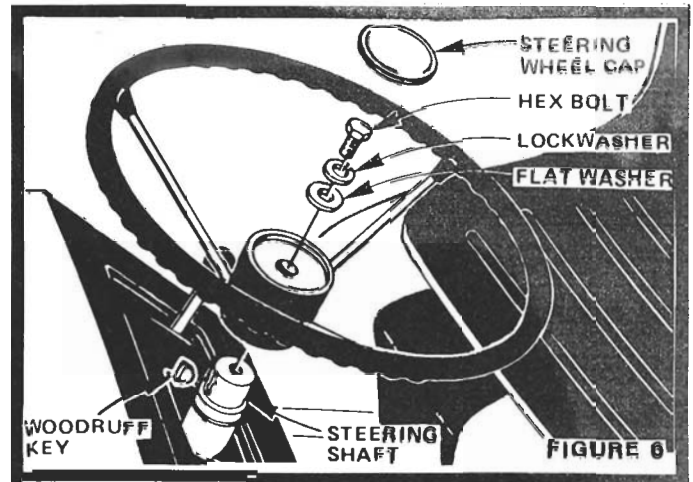
Flat Washer, Lockwasher, and Hex Bolt assembled on end of Steering Shaft.



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

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

NOTE: A SPARK ARRESTOR MUFFLER (PAGE 13) IS AVAILABLE AS AN ACCESSORY PART FOR YOUR TRACTOR. CHECK LEGAL REQUIREMENTS IN YOUR AREA.



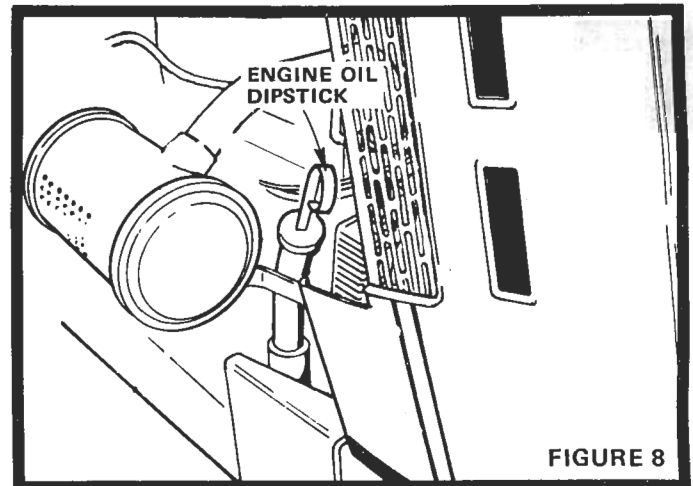
INITIAL ADJUSTMENTS

- Reduce Tire pressure to 12 pounds in front and rear Tires. (Tires were overinflated for shipping purposes).
- Seat position may be adjusted forward or backward by loosening Nut in Seat Plate (Fig. 7). NOTE WHEN RE-TIGHTENING NUT AFTER ADJUSTMENT, MAKE SURE SEAT PLATE HAS NOT TWISTED OUT OF ALIGNMENT WITH SEAT SPRING.

INITIAL SERVICE

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

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



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

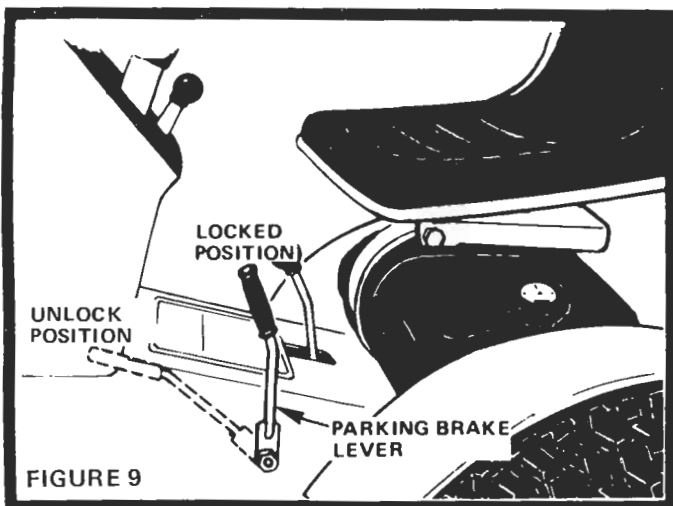


FIGURE 9

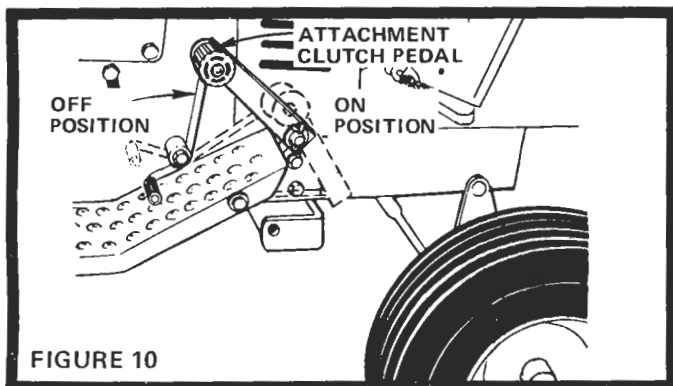


FIGURE 10

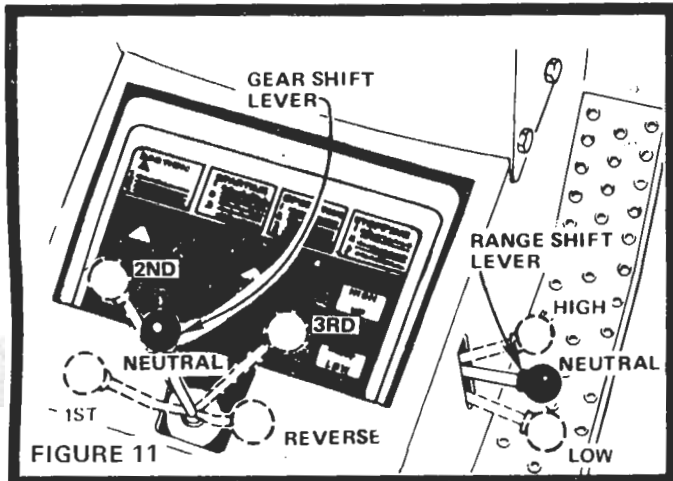


FIGURE 11

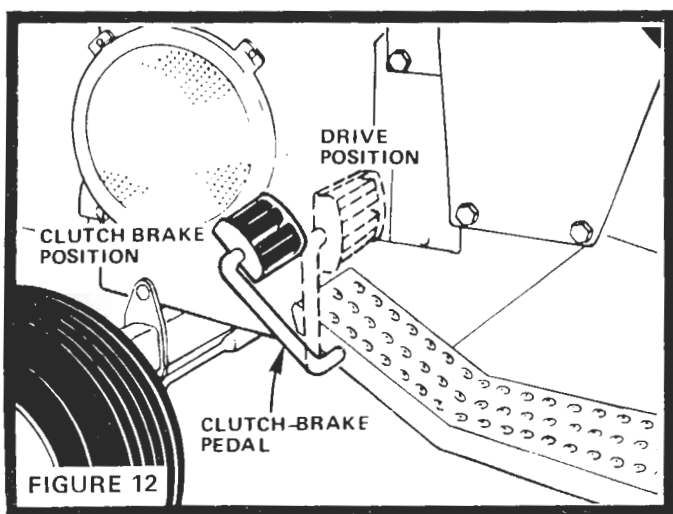


FIGURE 12

OPERATION



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.

STARTING THE ENGINE

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

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

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

WARMING UP THE ENGINE

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

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

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



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

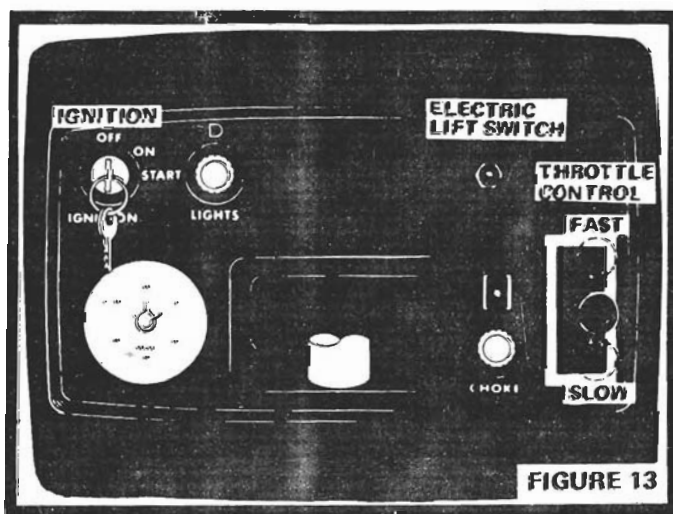


FIGURE 13

TRACTOR OPERATION

1. With engine running and warm, place Throttle Control Lever in middle position.
2. Push Clutch-Brake Pedal down firmly to unlock Parking Brake and hold it in Brake position (Fig. 12).
3. Move Gear Shift Lever to "2ND" and Range Shift Lever to "LOW" (Fig. 11).
4. Release Clutch-Brake Pedal SLOWLY to start forward movement.
5. If ground travel is too slow move Throttle Lever to fast position or press Clutch-Brake Pedal to stop and shift to a different gear. NOTE: ALWAYS SELECT A GROUND TRAVEL SPEED THAT WILL SUIT THE TERRAIN AND THE ATTACHMENT BEING USED.



BRING TRACTOR TO COMPLETE STOP BEFORE SHIFTING GEARS.



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



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

NOTE: ALWAYS OPERATE ENGINE AT FULL ENGINE RPM WHEN MOWING TO ASSURE BETTER MOWING PERFORMANCE, LONG ENGINE LIFE AND PROPER DISCHARGE OF CUT MATERIAL.

STOPPING YOUR TRACTOR

1. Push Clutch-Brake Pedal completely into "BRAKE" position.
2. Move Gear Shift Lever to "NEUTRAL" position.
3. Place Parking Brake in "LOCK" position.



CLUTCH-BRAKE PEDAL SHOULD REMAIN COMPLETELY DEPRESSED WHEN FOOT PRESSURE IS RELEASED.

4. Place Attachment Clutch Pedal in "OFF" position and lower attachment to the ground.
5. Move Throttle Control Lever to "S", slow position.
6. Turn Ignition Key to "OFF" position.



REMOVE KEY WHEN LEAVING TRACTOR TO PREVENT UNAUTHORIZED USE.



MAKE SURE PARKING BRAKE WILL HOLD TRACTOR SECURE.

TRANSPORTING YOUR TRACTOR

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

TRACTOR OPERATION ON HILLS

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



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

2. AVOID STOPPING OR SHIFTING ON HILLS.

a. If slowing is necessary, move Throttle Control to slower 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 the lowest speed range and that you have allowed room to roll slightly downhill. Unlock Parking Brake and release Clutch-Brake Pedal SLOWLY to start tractor movement.

3. Make all turns gradually.



THIS TRACTOR IS EQUIPPED WITH SAFETY SWITCHES TO PREVENT STARTING OF THE TRACTOR ENGINE WHILE THE ATTACHMENT CLUTCH PEDAL IS IN THE "ON" POSITION (FIG. 10) AND THE CLUTCH BRAKE PEDAL IS IN DRIVE POSITION (FIG. 12).



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

STARTING YOUR TRACTOR WITH A LOW BATTERY

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



LEAD-ACID BATTERIES GENERATE EXPLOSIVE GASES. KEEP SPARKS, FLAME, AND SMOKING MATERIALS AWAY FROM BATTERIES. ALWAYS WEAR EYE PROTECTION AROUND BATTERIES.

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



DO NOT USE YOUR TRACTOR BATTERY TO START OTHER VEHICLES.

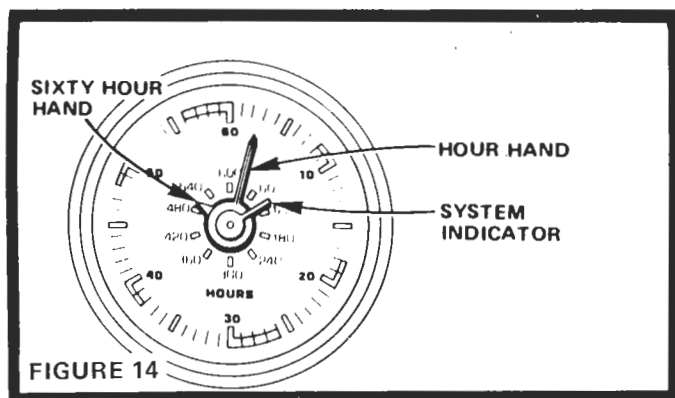


FIGURE 14

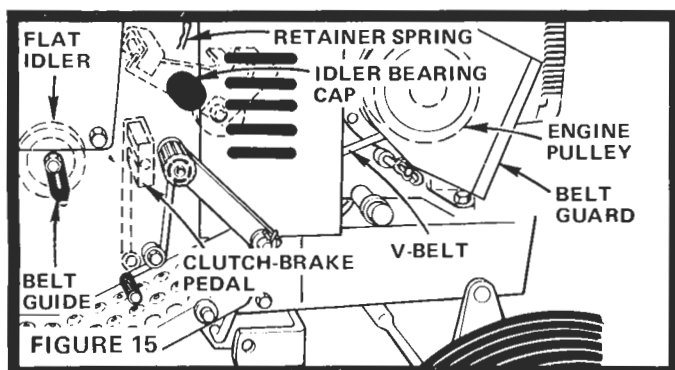


FIGURE 15

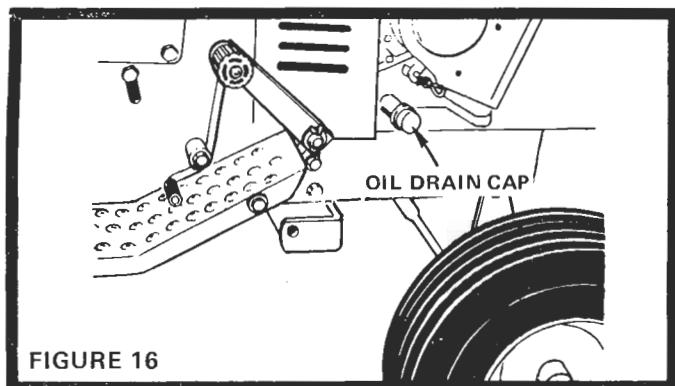


FIGURE 16

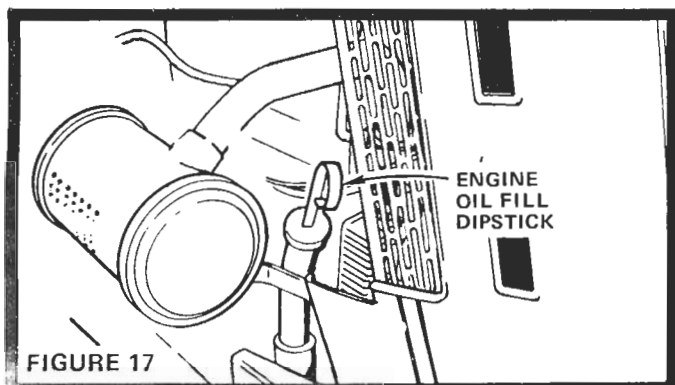


FIGURE 17

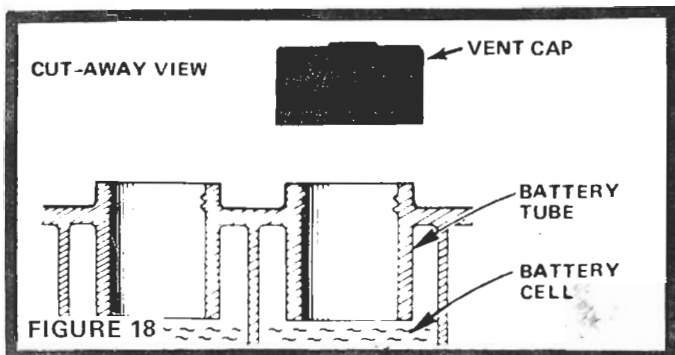


FIGURE 18

MAINTENANCE

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



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

FIRST 2 HOURS:

1. CHECK V-BELT TENSION

A new V-Belt may stretch after the first few hours of operation. If Clutch-Brake Pedal, in drive position (Fig. 15), is considerably to the front or rear of the vertical position, the V-Belt is out of adjustment and must be re-tensioned.

- Secure Clutch-Brake pedal in brake position (relaxing V-Belt tension) by tying to front axle.
- Hold Nut on inside of Flat Idler and loosen Flat Idler Bolt.
- Move Flat Idler in frame slot 1/4 inch down (to tighten), up (to loosen) V-Belt tension. Tighten Bolt.
- Release Clutch-Brake Pedal. It should return to approximately vertical position.



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

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

2. CHANGE ENGINE OIL

Changing Oil after the first two hours will help eliminate break-in residue which might be damaging to your Engine.

Note: Be careful not to allow dirt to enter the Engine when changing oil.

- Drain Oil with Engine warm. Unscrew Oil Drain Cap (Fig. 16) and catch Oil in a suitable container. Replace Cap.
- Refill Engine Oil (Fig. 17). In summer use S.A.E. 30 (SC, SD or SE) Oil. In winter (below 32°F.) use S.A.E. 10W30 (SC, SD or SE) or 10W40 (SC, SD or SE). In extreme cold (below 0°F.) use S.A.E. 5W20 (SC, SD or SE). Capacity is 3 - 1/2 pints. NOTE: DO NOT OVER-FILL.

FREQUENTLY:

1. CHECK BATTERY

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

2. CHECK TIRE PRESSURE

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

3. CLEAN AIR SCREEN

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

EVERY 5 HOURS:

1. CHECK ENGINE OIL LEVEL



DO NOT CHECK ENGINE OIL LEVEL WITH ENGINE RUNNING.

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

2. LUBRICATE STEERING AND FRONT WHEELS

There are six Grease Fittings on your Tractor (Fig. 19). Using a Grease Gun, give each Grease Fitting two shots of Extreme Pressure Lubricating Grease Amdex No. 1 (Available through your Roper Dealer).

3. OIL PIVOT POINTS

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

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

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

1. CLEAN AIR FILTER & FOAM PRE-CLEANER

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

2. CLEAN AIR SCREEN

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

3. CHANGE ENGINE OIL

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

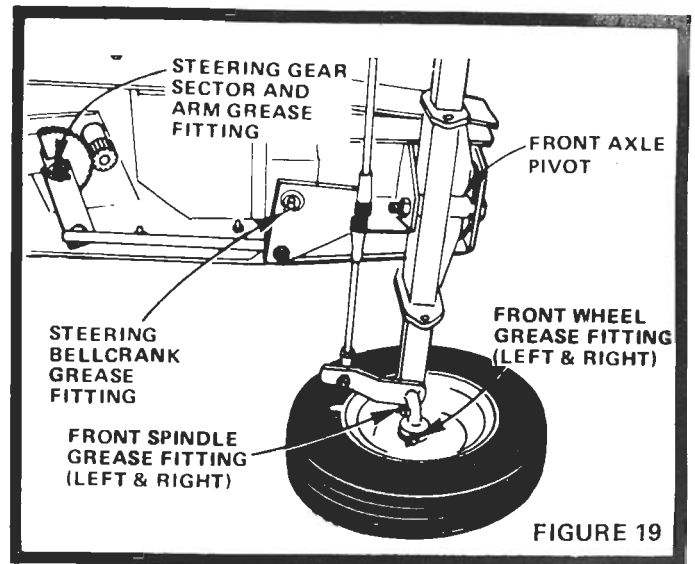


FIGURE 19

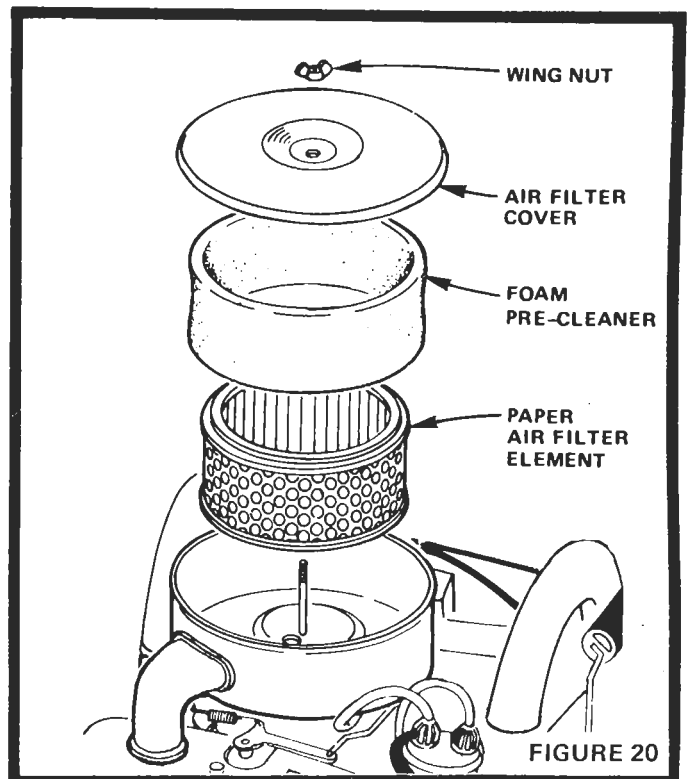


FIGURE 20

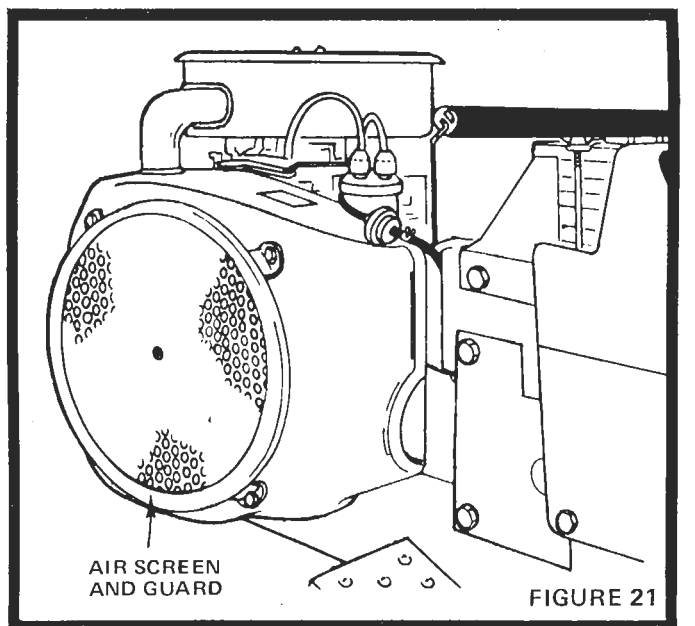


FIGURE 21

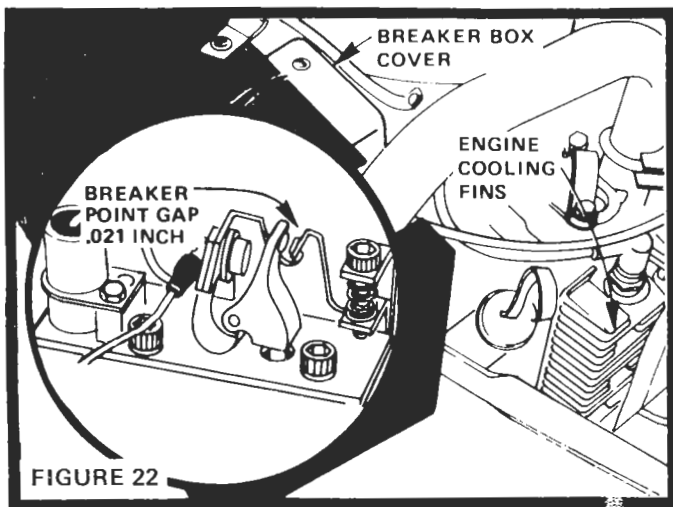


FIGURE 22

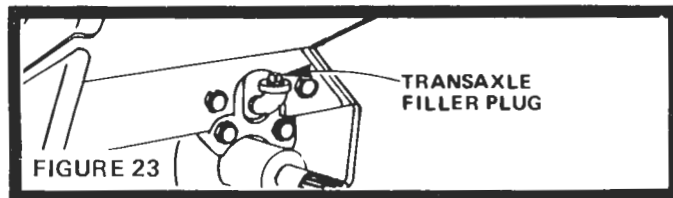


FIGURE 23

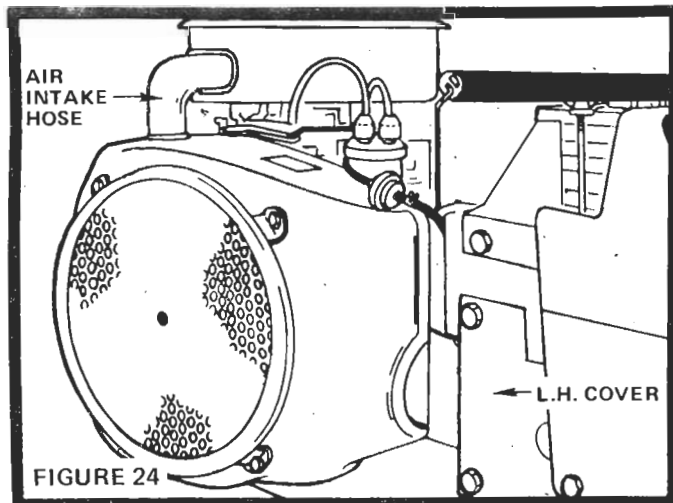


FIGURE 24

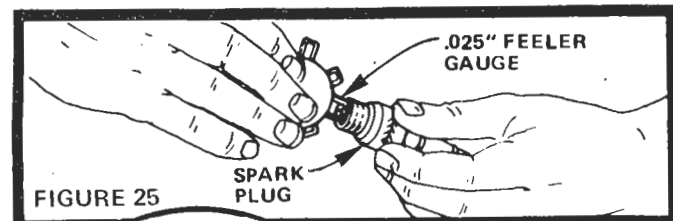


FIGURE 25

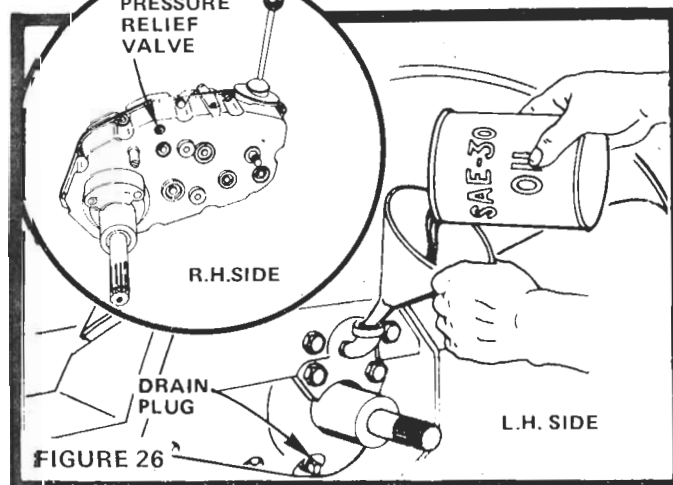


FIGURE 26

EVERY 50 HOURS:

1. CLEAN ENGINE COOLING FINS

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

2. CHECK TRANSAXLE OIL LEVEL

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

EVERY 100 HOURS:

1. CLEAN SPARK PLUGS AND RESET GAP

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

2. CHECK BREAKER POINTS

Replace Points if they are pitted or burned.

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

3. LUBRICATE BALL JOINTS

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

EVERY 200 HOURS:

1. REPLACE PAPER AIR FILTER ELEMENT

Refer to page 7.

2. REPLACE BREAKER POINTS

Refer to step 2, above.

EVERY 480 HOURS:

CHANGE TRANSAXLE OIL

- Block up Rear Axle securely or use a Tractor Jack. Remove Left Rear Wheel by removing E-Ring.
- Drain Transaxle Oil by removing Drain Plug (Fig. 26) and catching Oil in suitable container. Replace Drain Plug.
- Refill Transaxle with S.A.E. 30 (SC, SD or SE) Motor Oil. Capacity is 5 quarts. Pressure Relief Valve (R.H. side of Transaxle, Fig. 26, Inset) may be held open to allow Transaxle to fill more quickly.
- Check Pressure Relief Valve. It should spring completely closed when pulled out by hand and released.
- Reposition wheel. Secure with E-Ring.

AS NEEDED :

1. REPLACE IN-LINE FUEL FILTER

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

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



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

2. TOE-IN ADJUSTMENT

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

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

3. BRAKE ADJUSTMENT

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

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

4. PARKING BRAKE ADJUSTMENT

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

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

5. CARBURETOR ADJUSTMENT

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

- Main Fuel (High Speed) Screw (Fig. 30) should not require adjustment. If resetting is necessary, turn clockwise, closing finger tight ONLY, then turn counterclockwise 1 - 1/8 to 1 - 3/8 turns.
- Turn Idle Adjusting Needle (Fig. 30) clockwise, closing finger tight ONLY, and then turn counterclockwise 7/8 to 1 - 1/8 turns.



REFER TO "STARTING THE ENGINE" PAGE 4.

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

6. RE-TENSION V-BELT

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



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

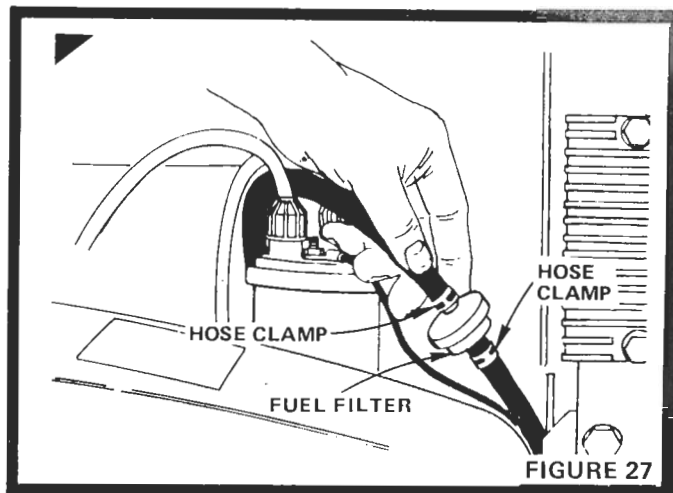


FIGURE 27

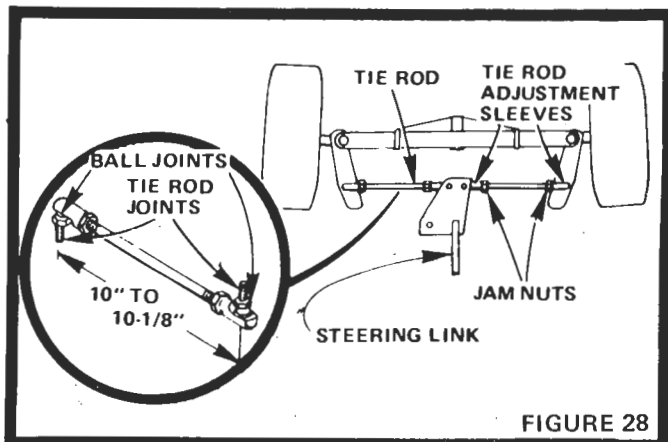


FIGURE 28

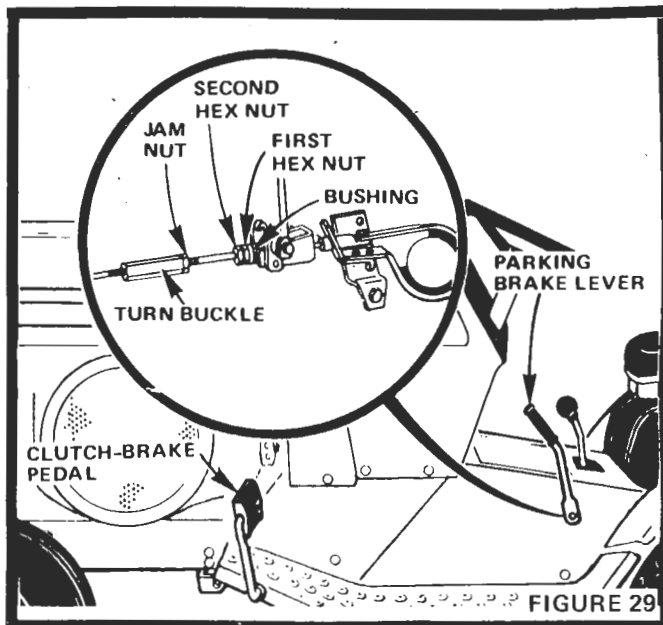


FIGURE 29

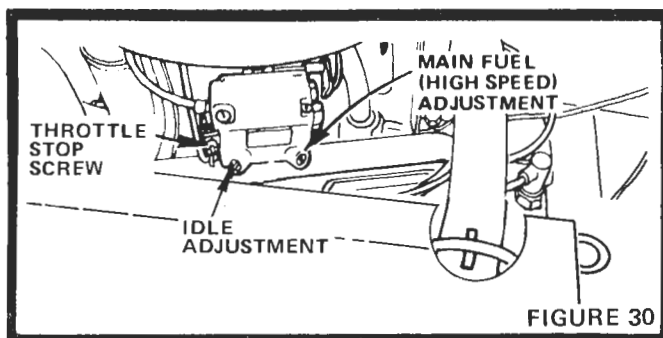


FIGURE 30

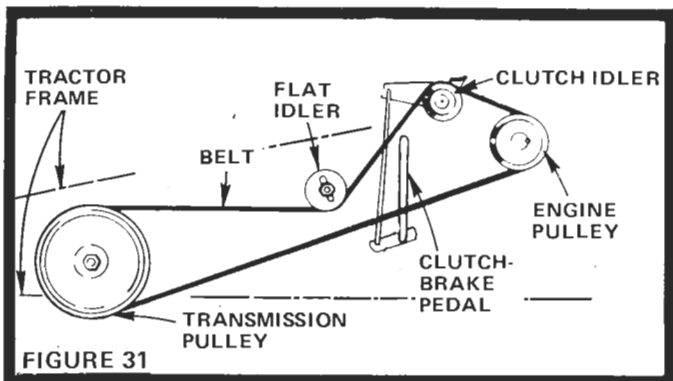


FIGURE 31

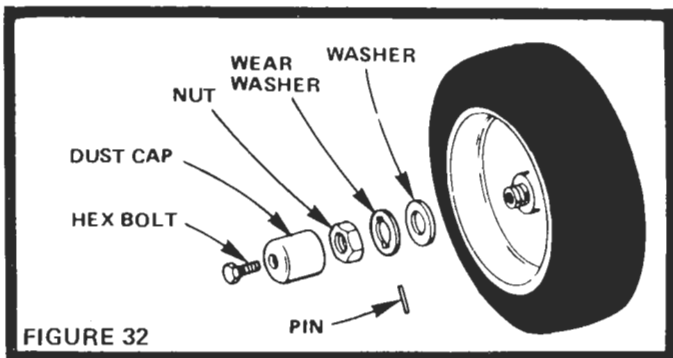


FIGURE 32

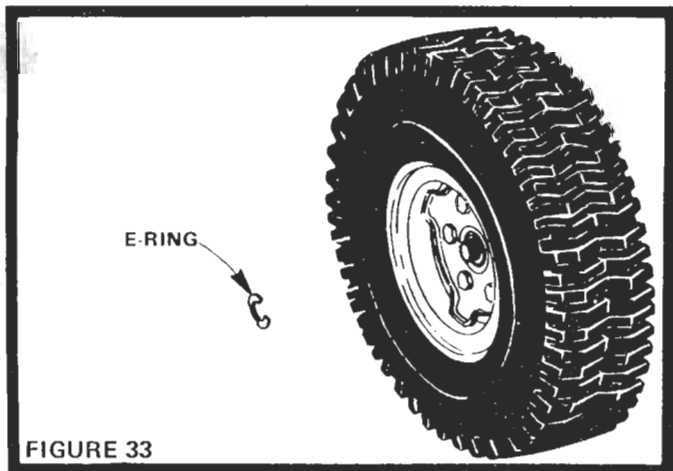


FIGURE 33

7. V-BELT REPLACEMENT

- a. Remove Belt from Clutch Idler by depressing Clutch-Brake Pedal (Fig. 31).
- b. Remove Belt Guide from Engine Pulley.
- c. Remove Rear Belt Guide Assembly from Transmission Pulley.
- d. Loosen Flat Idler Assembly on R.H. side of Tractor Frame.
- e. Remove Belt from Engine Pulley, between Belt Guide Finger (note position of Belt) and Flat Idler, and Transmission Pulley.
- f. Place new Belt around Transmission Pulley. Then place Belt between Belt Guide Finger and Flat Idler and then around Engine Pulley.
- g. Depress Clutch-Brake Pedal and slip Belt over the top of the Clutch Idler.
- h. Replace Engine Pulley Belt Guide and Transmission Pulley Belt Guide. Tighten Flat Idler Assembly. NOTE: Make sure Belt Guide Finger on Flat Idler is parallel with slot in Tractor Frame.
- i. Check Belt tension, page 6.

8. CLEAN BATTERY AND TERMINALS

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

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

9. TIRE CARE

- a. Maintain tire pressure in front and rear tires of 12 pounds.
- b. Keep tires free of gasoline, oil, or insect control chemicals which can destroy rubber.
- c. Avoid stumps, stones, deep ruts and other hazards that may cause tire damage.
- d. Removing front wheel for tire repair (Fig. 32).
 - Block up front axle securely or use a Tractor Jack.
 - Remove Hex Bolt and Dust Cap.
 - Remove Nut, Wear Washer, Pin and Washer to allow wheel removal.
 - Repair tire and reassemble.
- e. Removing rear wheel for tire repair (Fig. 33).
 - Block up rear axle securely or use a Tractor Jack.
 - Remove E-Ring to allow wheel removal.
 - Repair tire and reassemble. Snap E-Ring securely in axle groove.

10. FINISH

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

TROUBLE SHOOTING

POSSIBLE CAUSE

POSSIBLE REMEDY

WILL NOT START

Clutch-Brake Pedal in drive position
Attachment Clutch Pedal in "ON" position
No gasoline in Fuel Tank, clogged Fuel Filter
or Fuel Line
Blown Fuse
Dead Battery

Press Pedal into brake position
Move Pedal to "OFF" position
Fill Tank with Gasoline. Check Fuel Line, Fuel Filter
and Carburetor (clean if necessary)
Check for fault and replace Fuse
Recharge or replace Battery

HARD TO START

Choked improperly, flooded Engine

Clogged Fuel Filter
Clogged Fuel Tank
Dirty Air Cleaner
Spark Plugs dirty or improper gap
Defective Battery
Defective Ignition or loose wiring
Water in gasoline or old fuel

Improper Carburetor adjustment

Push Choke in, place Throttle Control in middle position and run starter several times to clear out gas
Remove and replace
Remove and clean
Remove and clean
Clean, adjust gap or replace
Recharge or replace
Check the wiring and Spark Plugs
Drain Fuel Tank and Carburetor, use fresh fuel and clean Spark Plugs
Make necessary adjustments

ENGINE MISSES OR LACKS POWER

Engine overload
Clogged Fuel Filter
Clogged Fuel Tank
Partially plugged Air Cleaner
Improper Carburetor adjustment
Dirty Air Screen
Low oil level or dirty oil
Spark Plugs dirty, improper gap or wrong type
Faulty ignition
Poor compression
Oil in gasoline

Shift to a lower gear or reduce load
Remove and replace
Remove and clean
Remove and clean
Make necessary adjustments
Clean Air Screen and Cylinder Fins
Add or change oil
Clean, reset gap or replace
Check Spark Plugs and for loose wires
Major Engine overhaul
Drain and refill Gas Tank and Carburetor

ENGINE OVERHEATS

Dirty Air Screen
Low oil level or dirty oil
Dirty Engine
Partially plugged Mufflers
Partially plugged Air Cleaner
Stale fuel or improper Carburetor adjustment

Clean Air Screen
Add or change oil
Clean Cylinder Fins
Remove and clean Mufflers
Remove and clean
Use fresh fuel and adjust Carburetor

NO LIGHTS

No Headlights or Taillight with Light Switch Knob pulled out

Check Light Fuse under dash, replace Taillight Bulb or Sealed Beam Headlights

WON'T CHARGE

Blown Fuse
Defective Battery

Check for fault and replace
Replace

STORAGE

1. ENGINE OIL

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

2. FUEL SYSTEM

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

3. CYLINDER

- Remove Spark Plugs.
- Pour one ounce of oil through spark plug hole into cylinder.
- Turn ignition key to "START" position for a few seconds to distribute oil.
- Replace Spark Plugs.

4. BATTERY

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

5. GENERAL CLEANING

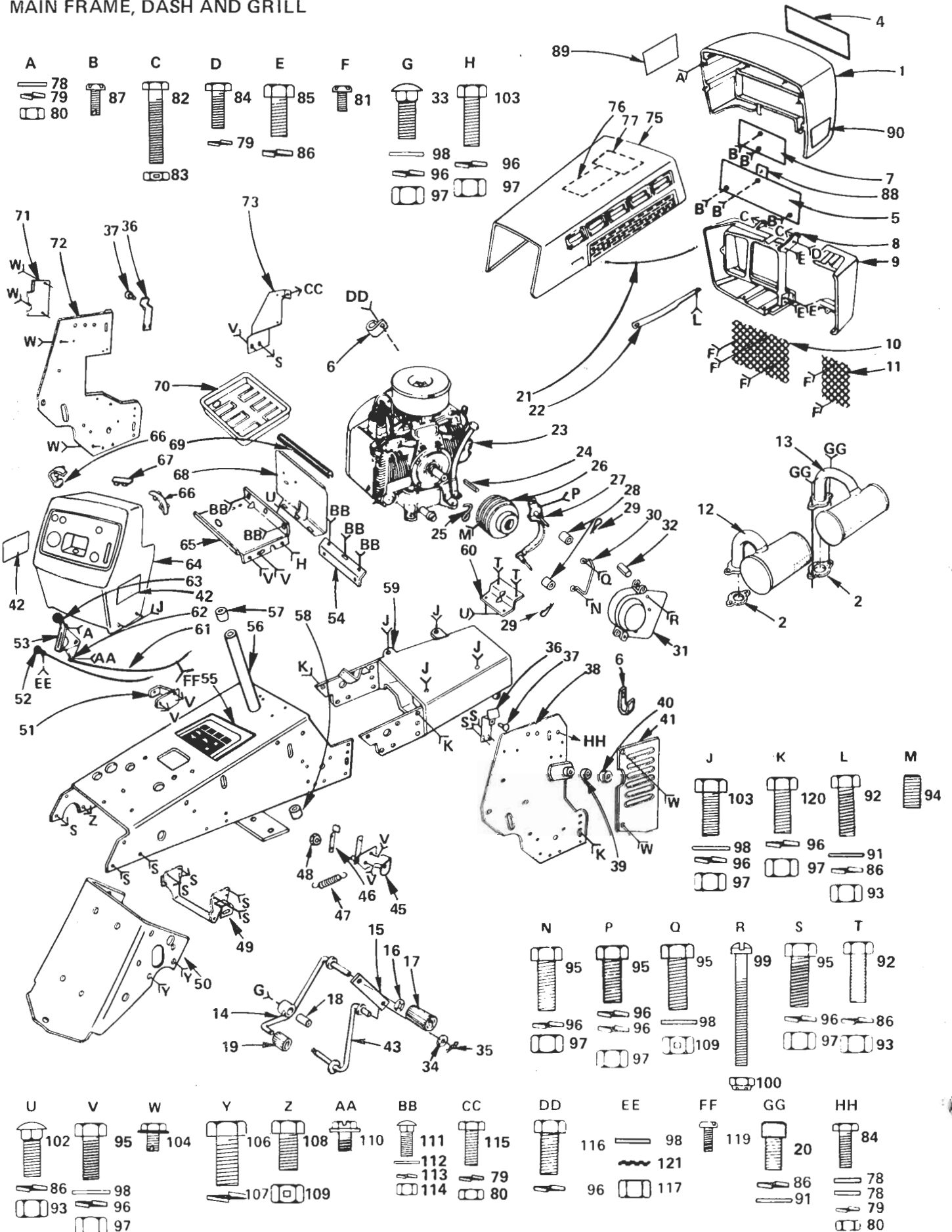
Clean engine, battery, finish, etc. of all foreign matter.

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.

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

MAIN FRAME, DASH AND GRILL



another free manual from www.searstractormanuals.com

REPAIR PARTS

Rectifier 7753R

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

MAIN FRAME, DASH AND GRILL

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	911J	Grill - Upper	68	107J	Battery Heat Shield
2	878J	Gasket - Exhaust Manifold	69	7874R	Hood Seal
4	245J	Decal - Grill	70	8855R	Battery Tray
5	291J	Grill - Panel - Lower	71	86J	Cover - L.H.
6	2751R	Wire Clip	72	113J	Bracket - Battery Support - L.H.
7	290J	Grill Panel - Upper	73	1181J	Bracket - Rectifier
8	7937R	Grill - Lower	75	634A907	Hood Ass'y.
9	7938R	Grill Side	76	8028R	Decal - Instruction
10	2674R	Grill Screen - L.H.	77	9880R	Decal - Wiring
11	2673R	Grill Screen - R.H.	78	1506P	*Washer 9/32 x 5/8 x 16 Ga.
12	105J	Muffler - Rear	79	1002P	*Lockwasher 1/4
13	104J	Muffler - Front	80	503P	*Hex Nut 1/4 - 20 UNC
14	634A901	Pedal Weldment	81	5501P	Phillips Pan Hd. Thd. Self Tap. 10 - 24 x 3/8 Type T
15	89J	Link	82	3267P	*Hex Bolt 1/4 - 20 x 1 - 1/2 Grade 5
16	92J	Push-On Nut	83	1605H	Locknut 1/4 - 20 UNC
17	93J	Rubber Pedal	84	3003P	*Hex Bolt 1/4 - 20 x 3/4
18	91J	Pivot Spacer	85	3010P	*Hex Bolt 5/16 - 18 x 3/4
19	267J	Foot Pedal	86	1003P	*Lockwasher 5/16
20	3366P	Soc. Hd. Cap Screw 5/16 - 18 x 3/4	87	5554P	*Phillips Pan Hd. Thd. Self Tap 10 - 16 Hi-Lo Thd. x 1/2 Blunt Point
21	8058R	Grill Cable	88	8768H	Mounting Clip
22	875J	Grill Brace	89	1590J	Decal - Grill - L.H.
23	B48M- GA018/3560A	Engine, Onan 18 H.P.	90	1591J	Decal - Grill - R.H.
24	9396E	Sq. Key 1/4 x 2	91	1537P	*Washer 11/32 x 11/16 x 16 Ga.
25	8245R	Belt Retainer Finger	92	3011P	*Hex Bolt 5/16 - 18 x 1
26	634A104	Engine Pulley w/Set Screws	93	504P	*Hex Nut 5/16 - 18 UNC
27	634A527	Belt Guide Weldment	94	4546P	Hex Forged Socket Hdless. Set Screw CP 5/16 - 18 x 1/2 - Nylok
28	8704H1	Spacer	95	3023P	*Hex Bolt 3/8 - 16 x 1
29	4939M	Retainer Spring	96	1004P	*Lockwasher 3/8
30	9011H	Belt Retainer	97	501P	*Hex Nut 3/8 - 16 UNC
31	634A659	Belt Guard Weldment	98	1557P	Washer 13/32 x 13/16 x 11 Ga.
32	8238H	Split Spacer	99	3154P	Stt. Fil. Hd. Machine Screw 1/4 - 20 x 2 - 1/4
33	50P	Sq. Neck Carriage Bolt 3/8 - 16 x 2 - 1/4	100	347H	Huglock Nut 1/4 - 20 UNC
34	1545P	Washer 17/32 x 1 x 16 Ga.	102	5P	*Carriage Bolt 5/16 - 18 x 3/4
35	2506P	*Cotter Pin 1/8 x 1	103	3025P	*Hex Bolt 3/8 - 16 x 1 - 1/4
36	634A900	Hood Latch	104	5557P	Hex Washer Hd. Thd. Cutting Screw 1/4 - 20 x 1/2 Type 1
37	8457R	Support Bumper	105	61P	Sq. Neck Carriage Bolt - Short Shoulder 3/8 - 16 x 1 Gr. 5
38	634A903	Battery Support Bracket (Inc. Key 39)	106	3035P	Hex Bolt 7/16 - 14 x 1 - 1/4
39	7756R	Bearing	107	1001P	*Lockwasher 7/16
40	8006R	Cap	108	3021P	*Hex Bolt 3/8 - 16 x 3/4
41	7729R	Cover - R.H.	109	5394H	Locknut 3/8 - 16 UNC
42	287J	Model Decal - Side of Dash	110	6055P	Hex Stt. Hd. Machine Screw w/Sems Int. Tooth Lockwasher 10 - 32 x 1/4
43	634A902	Lever Weldment	111	53P	Sq. Neck Carriage Bolt 10 - 24 x 1/2
45	634A785	Hanger Weldment R.H. - Front	112	1535P	Washer 7/32 x 7/16 x 18 Ga.
46	7944R	Belt Tightener Arm	113	1006P	*Lockwasher No. 10
47	7948R	Return Spring	114	505P	*Hex Nut 10 - 24 UNC
48	7810H	Locknut 3/8 - 24 UNF	115	3114P	*Hex Bolt 1/4 - 20 x 1/2
49	634A814	Hanger Weldment - Rear	116	3022P	*Hex Bolt 3/8 - 16 x 7/8
50	634A787	Drawbar and Weldnuts	117	515P	*Hex Nut 3/8 - 24 UNF
51	634A355	Hanger Weldment - L.H. - Front	119	5592P	*Slotted Pan Hd. Self Tap. Screw No. 8 x 3/4 Type AB
52	7931R	Choke Control	120	3025P	*Hex Bolt 3/8 - 16 x 1 - 1/4 Gr. 5
53	1518J	Throttle Control (Inc. Key 61, 62 & 63)	121	1402P	Ext. Tooth Lockwasher - 3/8
54	97J	Adaptor Bar			
55	1596J	Decal (Shift Pattern)			
56	634A888	Chassis Ass'y. (Inc. Key 57 & 58)			
57	6468H	Bearing			
58	4766H	Bearing			
59	634A908	Engine Mount Ass'y.			
60	96J	Grill Spacer			
61	9903R	Throttle Wire & Casing			
62	8204R	Clamp			
63	1550J	Throttle Control Lever			
64	634A893	Dashboard (Inc. Key No's. 66 and 67)			
65	106J	Battery Support			
66	1998R	Clip - Dashboard			
67	8571R	Clip - Dashboard, Center			

*STANDARD HARDWARE--PURCHASE LOCALLY

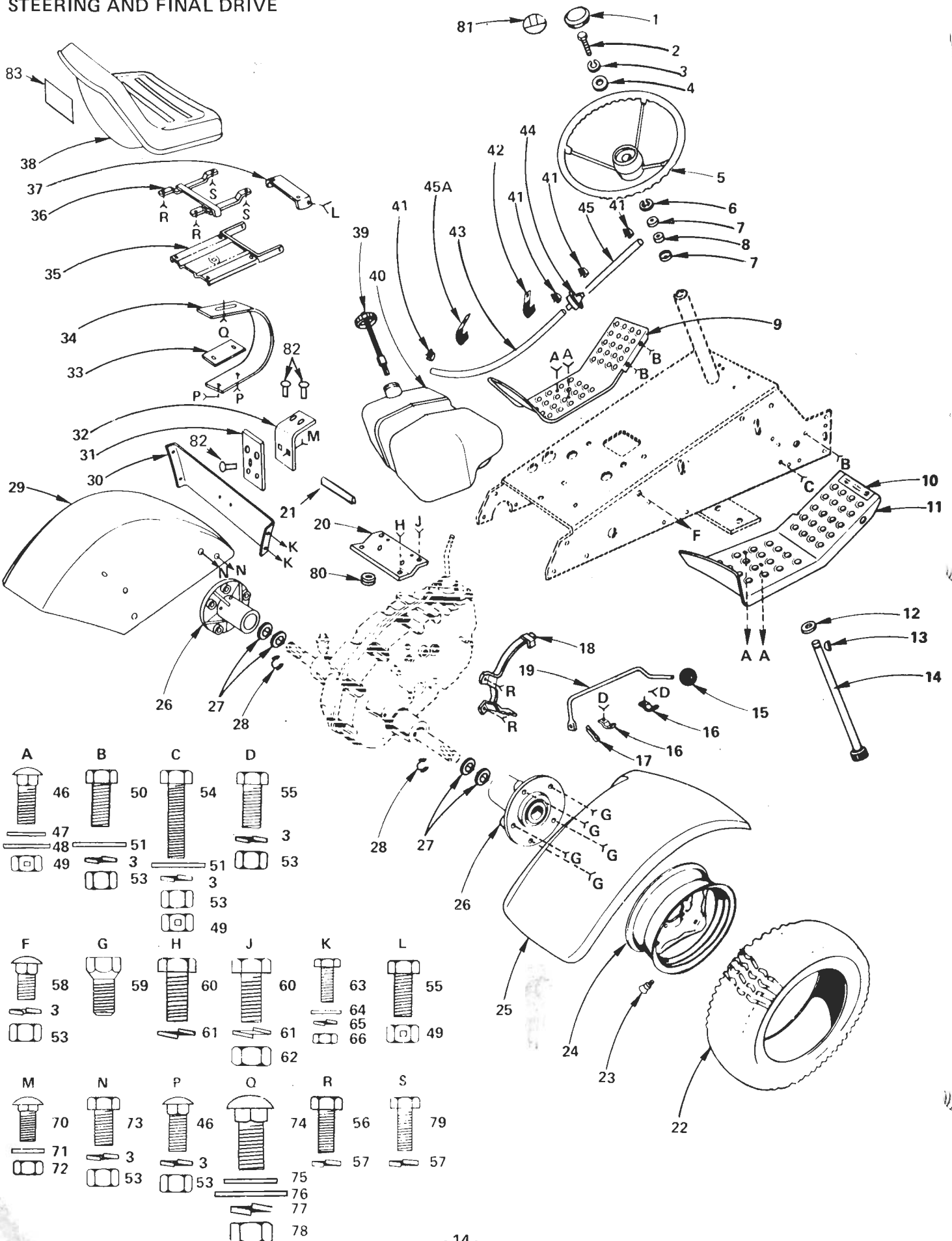
OPTIONAL EQUIPMENT

Spark Arrestor Muffler LA259AR

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

STEERING AND FINAL DRIVE



another free manual from www.searstractormanuals.com

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

STEERING, AND FINAL DRIVE

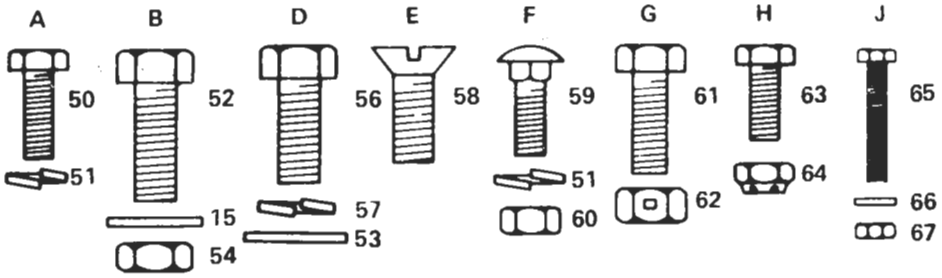
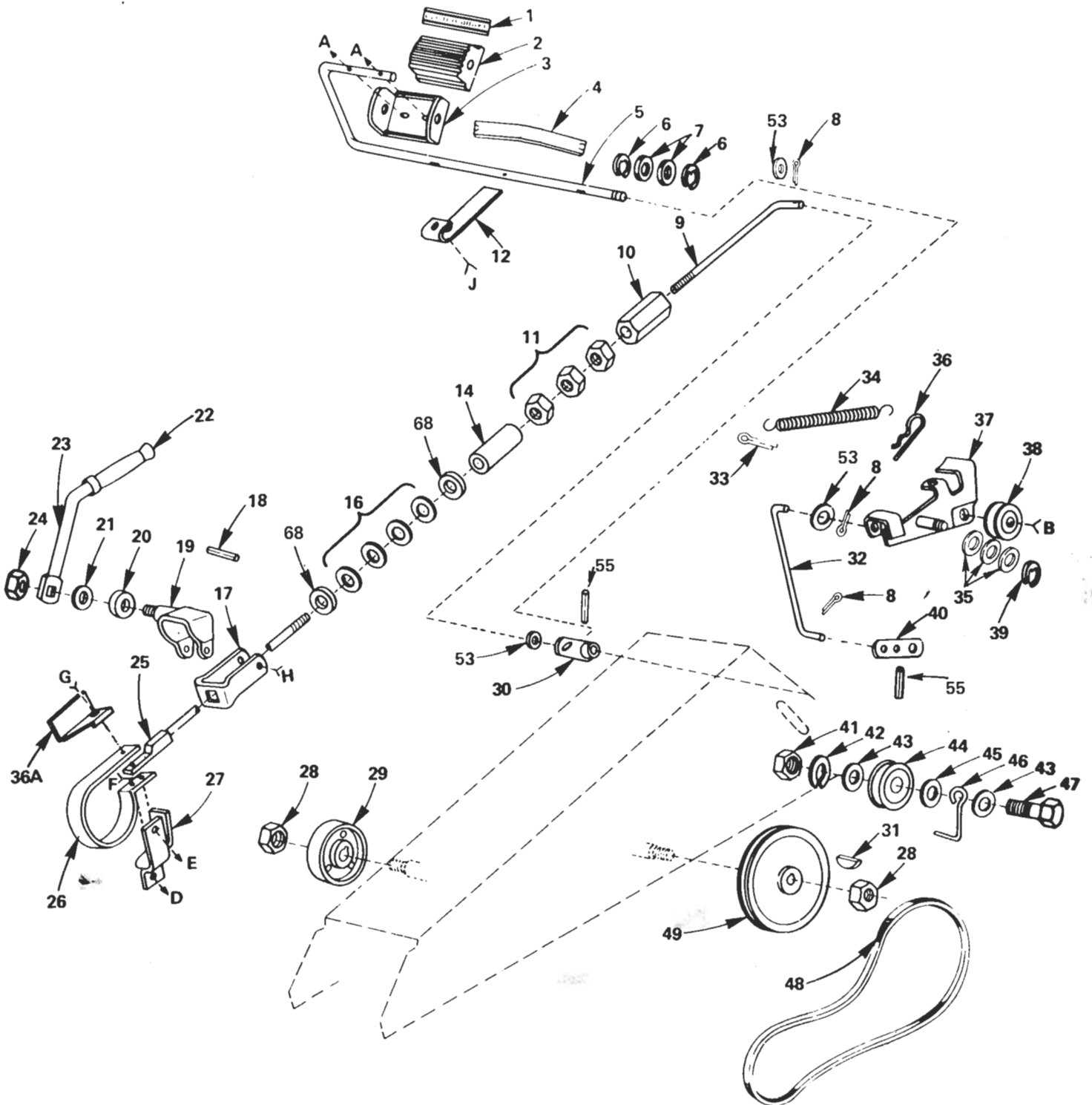
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	9719R	Steering Wheel Insert	46	61P	Sq. Nk. Sht. Shld. Carr. Bolt 3/8 16 x 1 Gr. 5
2	3023P	*Hex Bolt 3/8 - 16 x 1	47	1513P	*Washer 13/32 x 13/16 x 16 Ga.
3	1004P	*Lockwasher 3/8	48	1519P	Washer 15/32 x 1 x 12 Ga.
4	1559P	Washer 7/16 x 1 x 10 Ga.	49	5394H	Locknut 3/8 UNC
5	3644R	Steering Wheel	50	3025P	*Hex Bolt 3/8 - 16 x 1 - 1/4
6	5003P	E-Ring	51	1557P	Washer 13/32 x 13/16 x 11 Ga.
7	9007H	Cap			
8	5949H	Rubber Bushing	53	501P	*Hex Nut 3/8 - 16 UNC
9	7903R	Foot Rest - L.H.	54	3027P	*Hex Bolt 3/8 - 16 x 1 - 1/2
10	8900R	Decal (Attach. Clutch)	55	3022P	Hex Bolt 3/8 - 16 x 7/8
11	7904R	Foot Rest - R.H.	56	3010P	*Hex Bolt 5/16 - 18 x 3/4
12	1553P	Washer 57/64 x 1 - 1/4 x 16 Ga.	57	1003P	*Lockwasher 5/16
13	9858M1	Woodruff Key 3/16 x 5/8	58	19P	*Sq. Neck Carriage Bolt 3/8 - 16 x 3/4
14	634A626	Steering Shaft and Pinion	59	1304H	Hub Bolt
15	6364H	Control Knob	60	3034P	Hex Bolt 7/16 - 14 x 1
16	6442H	Shift Rod Bracket	61	1001P	*Lockwasher 7/16
17	2511P	Cotter Pin 3/16 x 1	62	500P	*Hex Nut 7/16 - 14 UNC
18	634A22A	Belt Guide	63	3003P	*Hex Bolt 1/4 - 20 x 3/4
19	6477H	Range Shift Rod	64	1506P	*Washer 9/32 x 5/8 x 16 Ga.
20	9594R	Transmission Bracket	65	1002P	*Lockwasher 1/4
21	8674R	Seat Stop	66	503P	*Hex Nut 1/4 - 20 UNC
22	4607R	Rear Tire 23 x 10.50 - 12	70	5P	*Short Shoulder Sq. Neck Carriage Bolt 5/16 - 18 x 3/4
23	795R	Tire Valve	71	1537P	*Washer 11/32 x 11/16 x 16 Ga.
24	3635R	Rear Wheel 12 x 7 JA	72	1685H	Lock Nut 5/16 - 18 UNC
25	9428R	Fender - R.H.	73	3021P	*Hex Bolt 3/8 - 16 x 3/4
26	634A692	Wheel Hub - Rear	74	52P	Carriage Bolt 1/2 - 13 x 1 - 1/4 Gr. 5
27	7563R	Axle Thrust Washer	75	1578P	Washer 3/4 x 1 - 1/8 x 11 Ga.
28	5845R	Retaining Ring	76	1560P	Washer 17/32 x 1 - 1/2 x 11 Ga.
29	9427R	Fender - L.H.	77	1000P	*Lockwasher 1/2
30	2656R	Bracket - Tail Light	78	502P	*Hex Nut 1/2 - 13 UNC
31	125J	Seat Stop Bracket	79	3159P	*Hex Bolt 5/16 - 18 x 7/8
32	126J	Fuel Tank Retainer	80	9547R	Rubber Grommet
33	8141H	Seat Spring Reinforcement	81	235J	Steering Wheel Decal
34	7898R	Seat Spring	82	124J	Rubber Bumper
35	634A776	Seat Plate Weldment	83	245J	Decal
36	634A532	Seat Bracket Weldment	---	1623J	Warranty Fact Tag
37	7897R	Bracket, Seat Pivot	---	1614J	Owners Manual
38	9744R	Seat			
39	2329J	Fuel Gauge			
40	7885R	Fuel Tank			
41	6999R	Fuel Line Clamp			
42	2751R	Clip - Fuel Line			
43	7834R	Fuel Line (Long)			
44	266J	In-Line Filter			
45	7833R	Fuel Line (Short)			
45A	9297R	Clip - Fuel Line			

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

BRAKE AND CLUTCH



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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

BRAKE AND CLUTCH

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	8899R	Insert Clutch-Brake	37	634A754	Idler Bracket Weldment
2	8882R	Foot Pedal	38	6636H	Idler
3	8765H	Foot Pedal Bracket	39	5U02P	E-Ring
4	9008H	Spring	40	634A898	Steering Arm Assembly
5	111J	Foot Pedal Shaft	41	500P	*Hex Nut 7/16 - 14 UNC
6	5001P	E-Ring	42	1001P	*Lockwasher 7/16
7	1527P	Washer 21/32 x 7/8 x 16 Ga.	43	1544P	*Washer 15/32 x 15/16 x 16 Ga.
8	2505P	Cotter Pin 1/8 x 3/4	44	6635H	Flat Idler
9	2202R	Brake Rod - Front	45	1520P	Washer .469 I.D. x 1 - 1/8 x 11 Ga.
10	6417H	Turnbuckle	46	6479H1	Belt Finger
11	501P	*Hex Nut 3/8 - 16 UNC	47	3262P	Hex Bolt 7/16 - 14 x 2 - 1/2
12	7823R	Safety Start Actuator	48	2692R	V-Belt
14	2201R	Bushing	49	6461H2	Pulley, Transmission
15	1557P	Washer 13/32 x 13/16 x 11 Ga.	50	3003P	*Hex Bolt 1/4 - 20 x 3/4
16	2263R	Spring Washer	51	1002P	*Lockwasher 1/4
17	9686R	Parking Brake Yoke	52	3052P	*Fin. Hex Bolt 3/8 - 24 x 1
18	175H	Roll Pin	53	1513P	*Washer 13/32 x 13/16 x 16 Ga.
19	634A887	Lock Bracket Assembly	54	548P	*Hex Jam Nut 3/8 - 24 UNF
20	2221R	Parking Brake Spacer	55	5142H	Roll Pin
21	5999H	Spring Washer	56	3022P	Hex Bolt 3/8 - 16 x 7/8
22	4379H	Handle Grip	57	1004P	*Lockwasher 3/8
23	626A341	Parking Lock Handle Assembly	58	3164P	Flat Hd. Machine Screw - Undercut 3/8 - 16 x 3/4
24	7810H	Gripco Centerlock Nut 3/8 - 24 UNF	59	11P	Sq. Neck Carriage Bolt 1/4 - 20 x 5/8
25	626A365	Brake Rod Assembly	60	503P	*Hex Nut 1/4 - 20 UNC
26	634A167	Brake Band and Lining	61	3159P	*Hex Bolt 5/16 - 18 x 7/8
27	634A168	Brake Bracket Assembly	62	1685H	Locknut 5/16 - 18 UNC
28	9204H	Lock Nut 1/2 - 20 UNF	63	3244P	Hex Bolt 1/4 - 28 x 5/8 Gr. 5
29	214J	Brake Drum	64	9071H	Huglock Nut 1/4 - 28 UNF
30	634A899	Brake Arm Assembly	65	3326P	Hex Hd. Mach. Screw 6 - 32 x 1
31	9858M1	Woodruff Key	66	1567P	Washer 5/32 x 3/8 x 20 Ga.
32	9288R	Clutch Rod	67	562P	Centerlock Nut 6 - 32 UNC
33	2514P	Cotter Pin 1/4 x 1	68	1602P	Washer 13/32 x 5/8 x 11 Ga.
34	6486H	Spring			
35	1587P	*Washer 17/32 x 1 - 1/16 x 21 Ga.			
36	4939M	Retainer Spring			
36A	544J	Hose Shield			

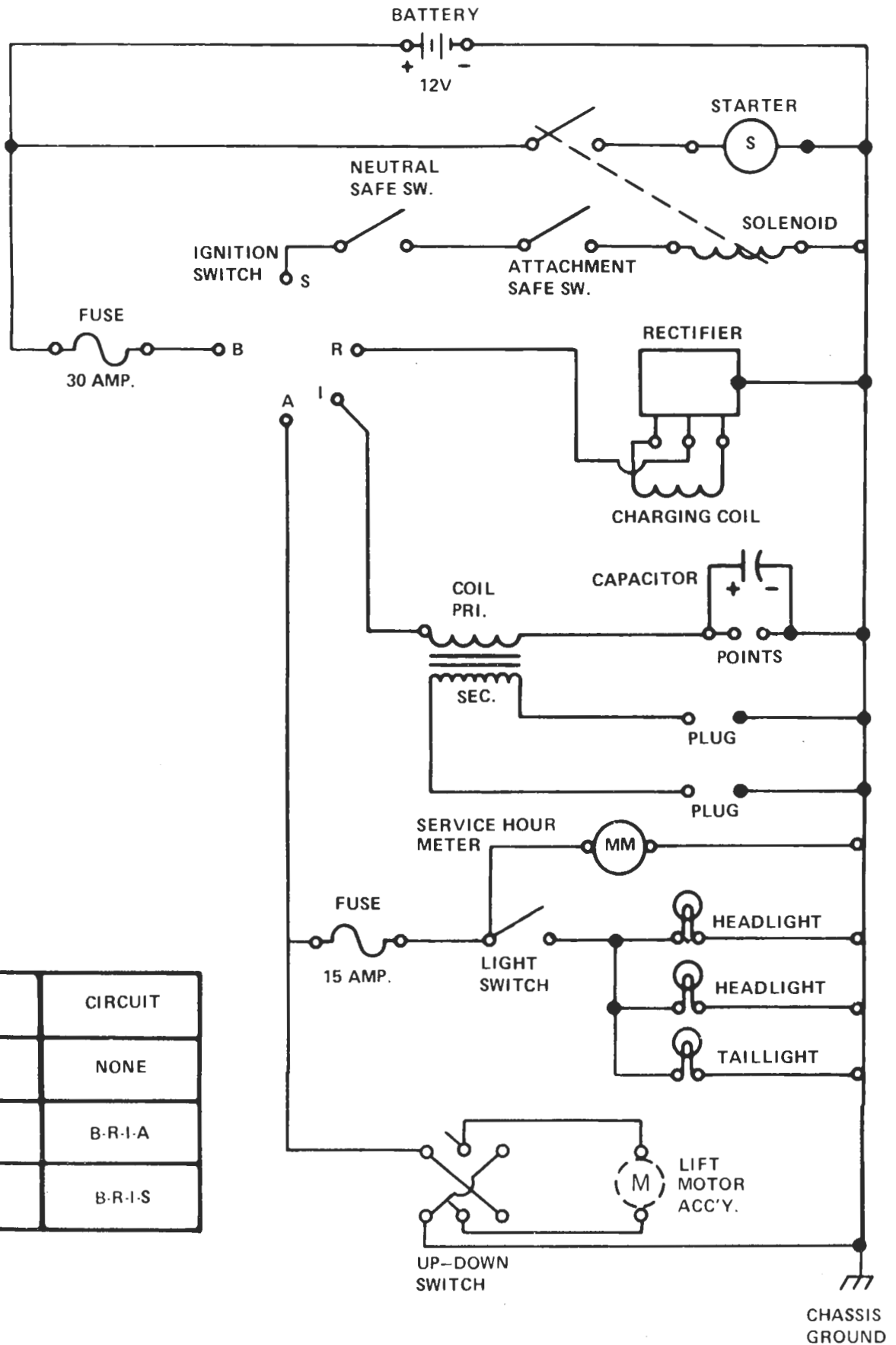
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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

SCHEMATIC DIAGRAM

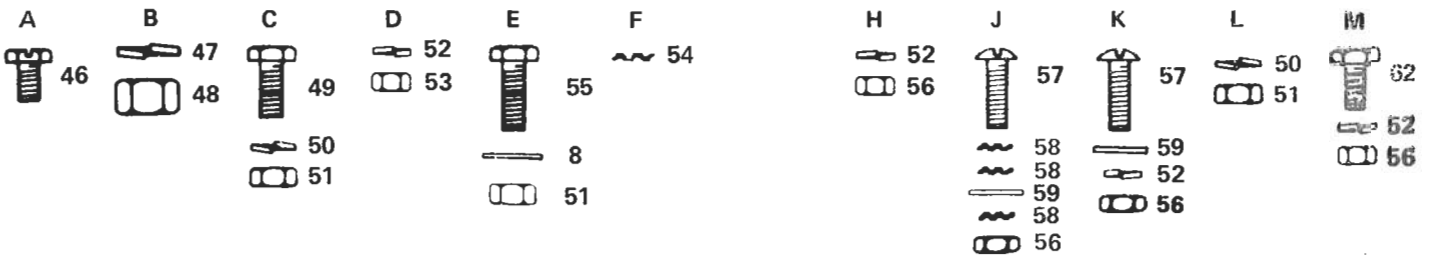
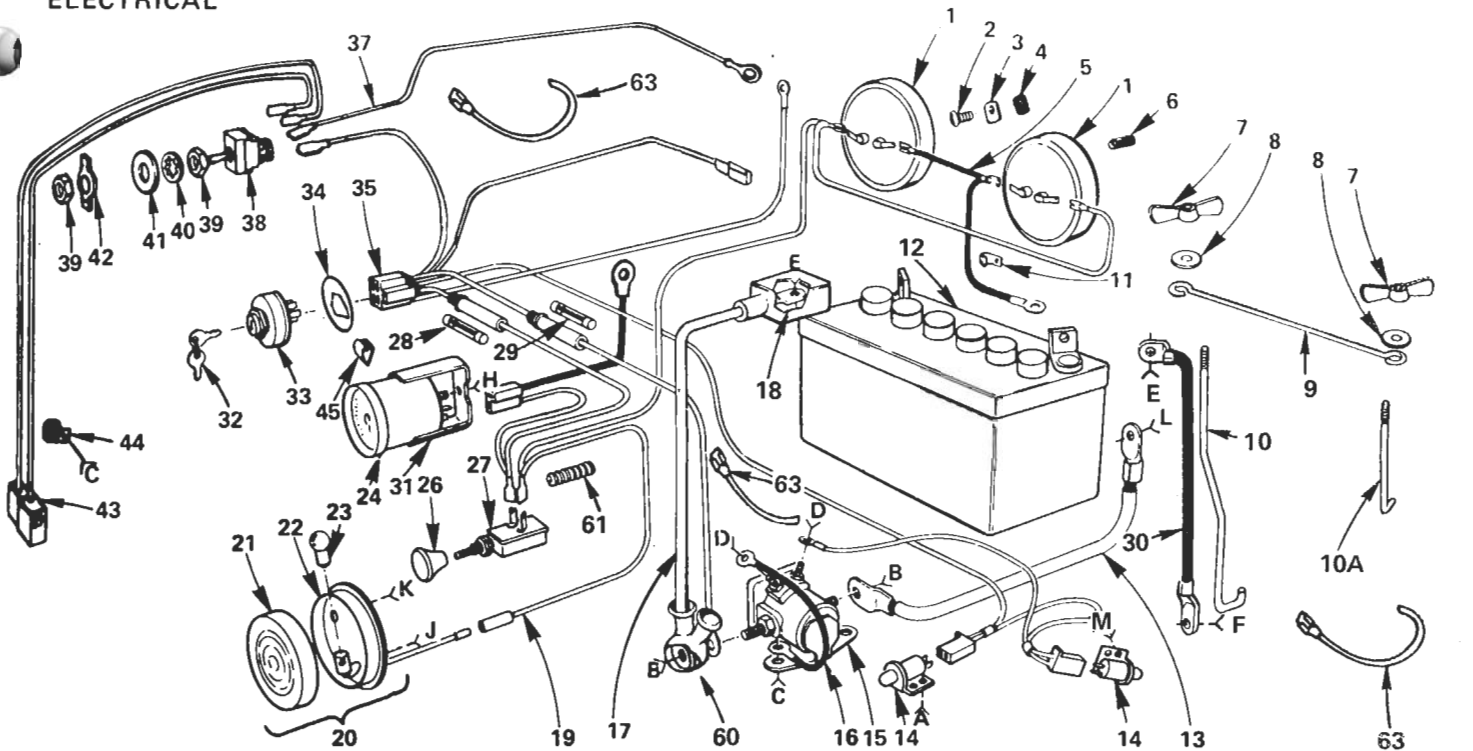


POSITION	CIRCUIT
OFF	NONE
RUN	B-R-I-A
START	B-R-I-S

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

ELECTRICAL



KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	6452R	Headlight	34	8656R	Terminal Identifier
2	5554P	Phillips Pan Hd. Thd. Cutting Screw	35	1492J	Wire Harness - Main
3	8768H	Mounting Clip	37	9698R	Wire, Ground Lift Switch
4	8784H1	Ruber Spacer	38	8984R	Switch Elec. Lift
5	8031R	Headlight Ground Wire	39	566P	Hex Nut, Steel 7/16 - 32 NS - 2A
6	9197H	Hose	40	7319R	Lockwasher, Internal Tooth
7	3748M	Wing Nut 1/4 - 20 UNC	41	1518P	Washer 15/32 x 11/16 x 16 Ga.
8	1506P	Washer 9/32 x 5/8 x 16 Ga.	42	9349R	Switch Plate
9	7955R	Battery Clamp	43	8985R	Lift Motor Harness
10	2685R	Battery Bolt	44	5320R	Clip, Wire
10A	88J	Battery Bolt	45	8615R	Clip
11	4171R	Insulated Clip	46	5534P	Slotted Hex Indented Hd. Self Tapping Screw No. 10 - 24 x 3/8 Type 1
12	226J	Battery	47	1003P	* Lockwasher 5/16
13	2235R	Cable - Solenoid to Starter	48	538P	* Hex Jam Nut 5/16 - 24 UNF
14	7755R	Safety Switch	49	3115P	* Hex Bolt 1/4 - 20 x 5/8
15	7754R	Solenoid	50	1002P	* Lockwasher 1/4
16	8027R	Wire - Ground to Solenoid	51	503P	* Hex Nut 1/4 - 20 UNC
17	116J	Battery Cable	52	1006P	* Lockwasher No. 10
18	225J	Terminal Cover	53	543P	* Hex Nut No. 10 - 32 UNF
19	8030R	Light Harness	54	1402P	Ext. Tooth Lockwasher 3/8
20	8089H	Taillight (Inc. Key No. 21, 22 & 23)	55	3003P	* Hex Bolt 1/4 - 20 x 3/4
21	8292H	Lens - Taillight	56	505P	* Hex Nut No. 10 - 24 UNC
22	8293H	Housing - Taillight	57	3074P	* Std. Truss Hd. Mach. Screw 10 - 24 x 3/4
23	8291H	Bulb No. 1895 2 Candle Power	58	1404P	Ext. Tooth Lockwasher No. 10
24	7763R	Maintenance Meter	59	1504P	* Washer 7/32 x 1/2 x 18 Ga.
26	7794R	Light Switch Knob	60	51J	Solenoid Terminal Cover
27	7793R	Light Switch	61	302J	Wire Guard
28	2212R	Fuse - 15 Amp.	62	3218P	Hex Hd. Mach. Screw No 10 - 24 x 1/2
29	6347R	Fuse - 30 Amp.	63	6106R	Cable Tie
30	2753R	Battery Cable - Ground			*STANDARD HARDWARE--PURCHASE LOCALLY
31	8066R	Maintenance Meter Bracket			
32	7552H	Key Set			
33	2683R	Ignition Switch			

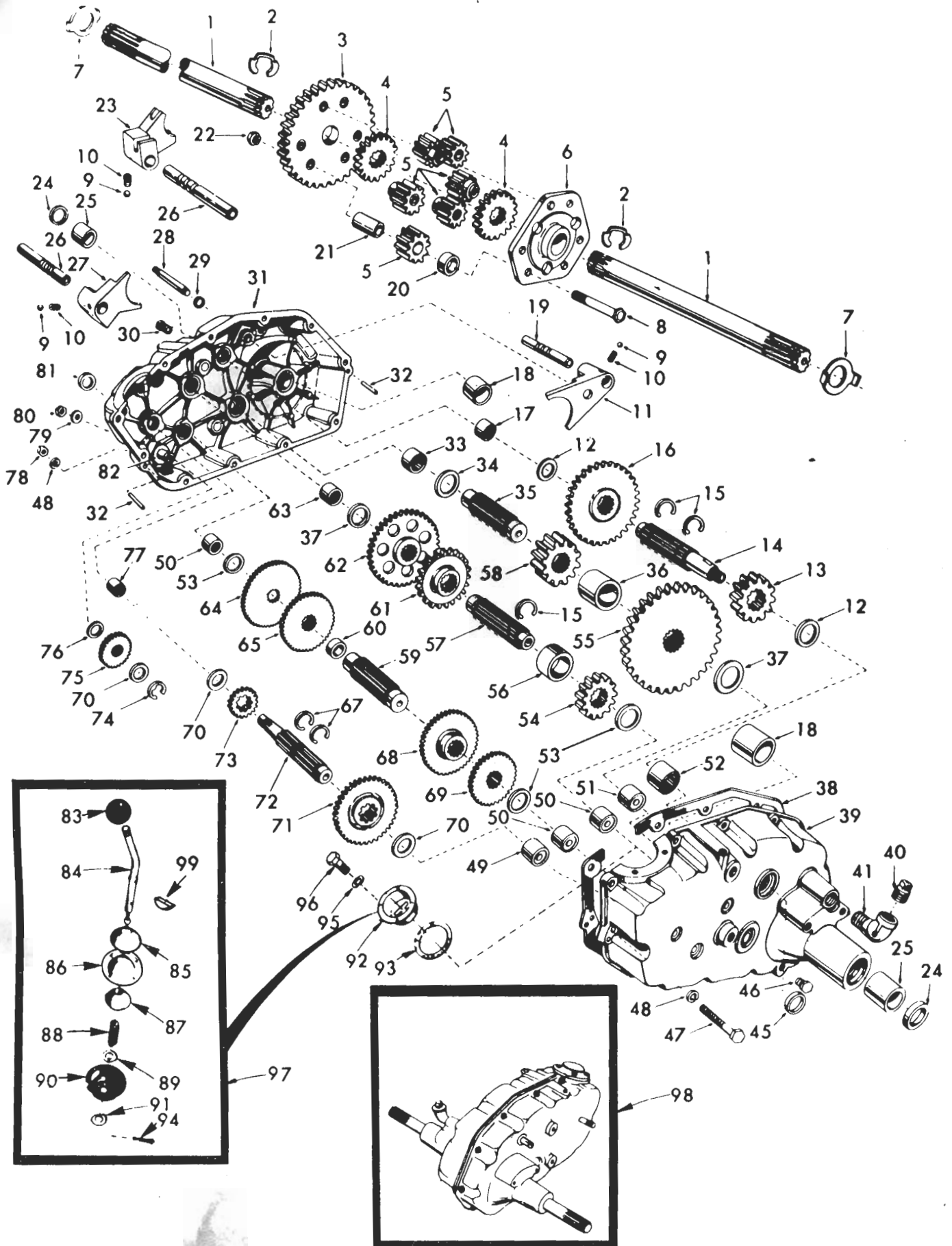
7753R Rectifier

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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

TRANSAXLE



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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

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	3056P	Hex Bolt 3/8 - 24 UNF 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	65	4204R	Reverse Gear
18	8740H1	Sintered Iron Bearing	67	4926H	Snap Ring - Crescent Type
19	6217H	Shift Fork Shaft, High - Low Range	68	4205R	Intermediate Speed Gear
20	4218R	Differential Pinion Spacer	69	4206R	High Speed Gear
21	6252H1	Differential Pinion Bushing	70	1370H	Thrust Bearing Race
22	7810H	Gripco Centerlock Nut 3/8 - 24 UNF	71	633A69	Intermediate and High Speed Cluster Pinions
23	4986R	Shift Fork - L.H.	72	4193R	Input Shaft
24	7393R	Oil Seal	73	4201R	Low Speed Pinion
25	992R1	Sintered Iron Bearing	74	5001P	E-Ring
26	6216H	Shift Fork Shaft	75	1153R	Reverse Idler Gear
27	6262H	Shift Fork - R.H.	76	7392H	Reverse Idler Thrust Washer
28	6215H	Shift Shaft, High - Low Range	77	5529H	Needle Bearing
29	6269H	Oil Seal	78	504P	*Hex Nut 5/16 - 18 UNC
30	5855H	Pressure Relief Valve	79	1167R	Sealing Washer
31	633A65	Gearcase, Reverse Idler Shaft and Bearings - R.H. (Inc. Key No's. 17, 18, 25, 33, 50, 63, 76, 77 and 82)	80	541P	Hex Jam Nut 7/16 - 20 UNF
32	6277H	Dowel Pin	81	6270H	Oil Seal
33	4225R	Needle Bearing	82	7384H	Reverse Idler Shaft
34	7396H	Thrust Bearing Race	83	6364H	Control Knob
35	4198R	4th Reduction Gear Shaft	84	9635R	Gear Shift Lever - Bent
36	4200R	4th Reduction Gear Spacer	85	9013R	Gear Shift Cap
37	7395H	Thrust Bearing Race	86	633A85	Gear Shift Ball Cover and Pin
38	6275H	Gearcase Gasket	87	8739H1	Shift Lever Guide Ball - Keyed
39	633A64	Gearcase and Bearings - L.H. (Inc. Key No's. 18, 25, 49, 50 (2), 51 and 52)	88	4924H	Spring
40	4002P	Pipe Plug 1/2 - 14 N.P.T.	89	1593P	Washer 15/32 x 59/64 x 16 Ga.
41	4003P	Street Elbow 90°, 1/2 - 1/4 N.P.T.	90	8105R	Shift Mechanism Seal
45	6271H	Oil Seal	91	1569P	Washer 9/16 x 15/16 x 11 Ga.
46	4001P	Pipe Plug 1/4 - 18 N.P.T.	92	75J	Gear Shift Gate
47	3087P	*Hex Bolt 5/16 - 18 x 1 - 1/2 Grade 5	93	6274H	Shift Ball Cover Gasket
48	1007P	Lockwasher 5/16 Extra Heavy	94	2505P	Cotter 1/8 x 3/4
			95	1003P	Lockwasher 5/16
			96	3159P	Hex Bolt 5/16 - 18 UNC x 7/8
			97	633A82	Gear Shift Lever Ass'y.
			98	633A78	Transaxle Assembly Less Brake Drum & Shift Lever
			99	7635M	Woodruff Key 1/8 x 1/2

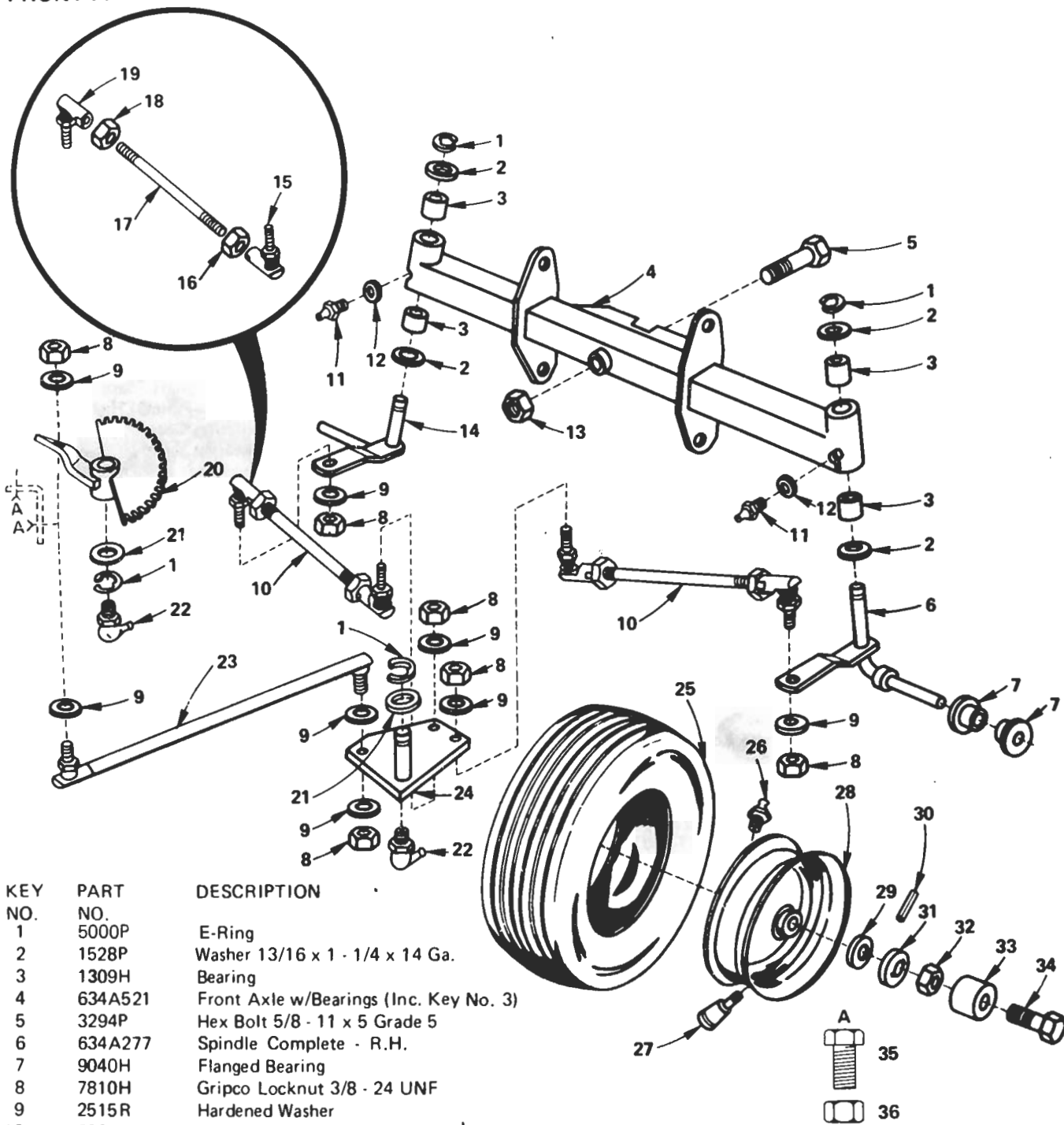
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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR

FRONT AXLE



KEY NO.	PART NO.	DESCRIPTION
1	5000P	E-Ring
2	1528P	Washer 13/16 x 1 - 1/4 x 14 Ga.
3	1309H	Bearing
4	634A521	Front Axle w/Bearings (Inc. Key No. 3)
5	3294P	Hex Bolt 5/8 - 11 x 5 Grade 5
6	634A277	Spindle Complete - R.H.
7	9040H	Flanged Bearing
8	7810H	Gripco Locknut 3/8 - 24 UNF
9	2515R	Hardened Washer
10	7838R	Tie Rod and Joints (Inc. Key No's. 15, 16, 17, 18 & 19)
11	6855M	Grease Fitting
12	1505P	Washer 9/32 x 1/2 x 14 Ga.
13	4764H	Huglock Nut 5/8 x 11 UNC
14	634A278	Spindle Complete L.H.
15	8515R	Tie Rod Joint (R.H. Thread)
16	558P	*Hex Jam Nut 1/2 - 20 (R.H. Thread)
17	634A819	Tie Rod and Nuts (Inc. Key No's. 16 & 18)
18	559P	Hex Jam Nut 1/2 - 20 (L.H. Thread)
19	8514R	Tie Rod Joint (L.H. Thread)
20	634A813	Steering Gear Sector and Arm
21	1552P	Washer 49/64 x 1 - 1/4 x 16 Ga.
22	6842M	Grease Fitting
23	7837R	Drag Link and Joints
24	634A98	Steering Bell Crank Weldment
25	3938R	Front Tire 16 x 6.50 - 8 T.S.

KEY NO.	PART NO.	DESCRIPTION
26	6856M	Grease Fitting 1/4 - 28 Taper Thrd.
27	795R	Tire Valve
28	3636R	Front Wheel and Bearings
29	1562P	Washer 25/32 x 1 - 1/2 x 16 Ga.
30	8798H	Roll Pin 5/32 x 1
31	8785H	Wear Washer
32	4831H	Elastic Nut 3/4 - 16 UNF
33	8763H	Dust Cap-Outer
34	3008P	Hex Bolt 5/16 - 18 x 1/2
35	3052P	*Hex Bolt 3/8 - 24 x 1
36	546P	*Hex Jam Nut 3/8 - 24 UNF

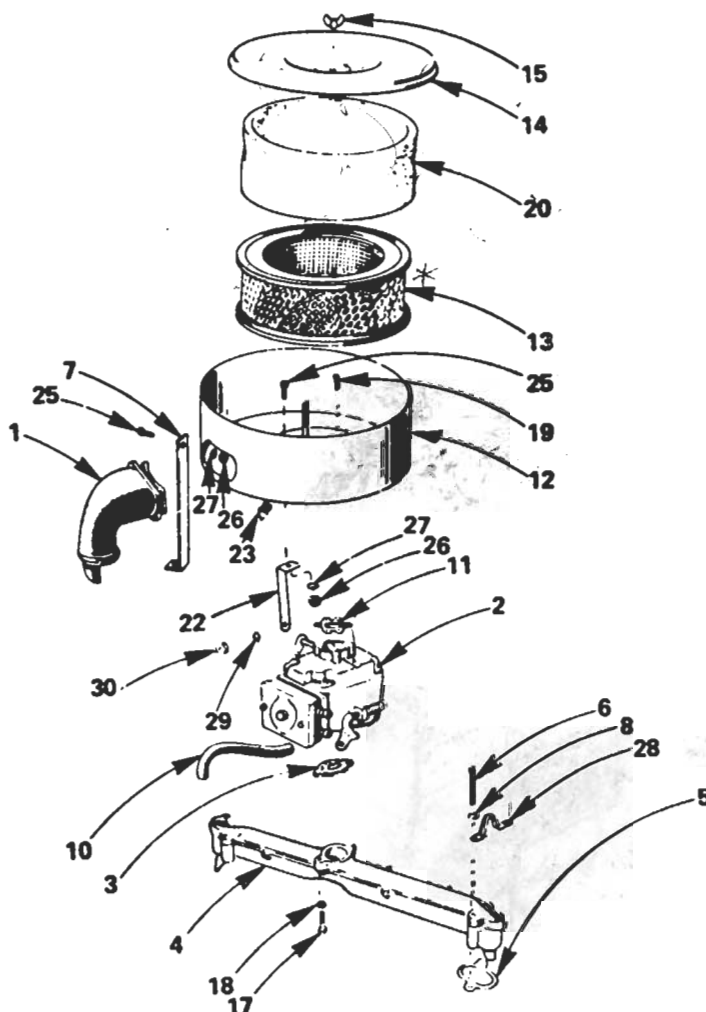
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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

FUEL SYSTEM GROUP

ALL PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.



KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	140-1169	Tube, Air Intake (Air Cleaner to Blower Housing)	15	865-0020	Nut, Wing - Air Cleaner (1/4 - 20)
2	142-0568	†Carburetor, Gasoline (with Integral Fuel Pump)	17	800-0023	Screw, Hex Head Cap (1/4 - 20 x 1 - 3/8")
3	145-0438	*Gasket, Carburetor Mounting	18	850-0040	Washer, Spring Lock (1/4")
4	154-1468	Manifold, Intake	19	815-0463	Screw, Round Head with Nylon Seal (No. 10 - 32 x 5/8")
5	154-1446	*Gasket, Intake - Manifold	20	140-1259	Wrapper, Air Cleaner Element
6	800-0033	Screw, Hex Head Cap 5/16 - 18 x 2	22	140-1313	Bracket, Air Cleaner Support
	800-0034	Screw, Hex Head Cap 5/16 - 18 x 2 - 1/4	23	518-0328	Clip, Bracket, Cable
7	140-1198	Support, Air Cleaner	25	800-0003	Screw, Hex Head Cap (1/4 - 20 x 1/2")
8	850-0045	Washer, Spring Lock (5/16")	26	862-0001	Nut, Hex - Steel (1/4 - 20)
10	503-0740	Hose, Fuel Pump Vacuum	27	853-0013	Washer, Lock - ET (1/4")
11	140-1215	*Gasket, Air Cleaner Mtg.	28	403-1490	Bracket, Lifting
12	140-1213	Housing, Air Cleaner	29	854-0017	Washer, Lock - IT (5/16")
13	140-1216	Element, Air Cleaner	30	870-0275	Nut, Hex (7/16 - 14)
14	140-1168	Cover, Air Cleaner			

† - See separate group for components.
* - Included in Gasket Kit, page 29.

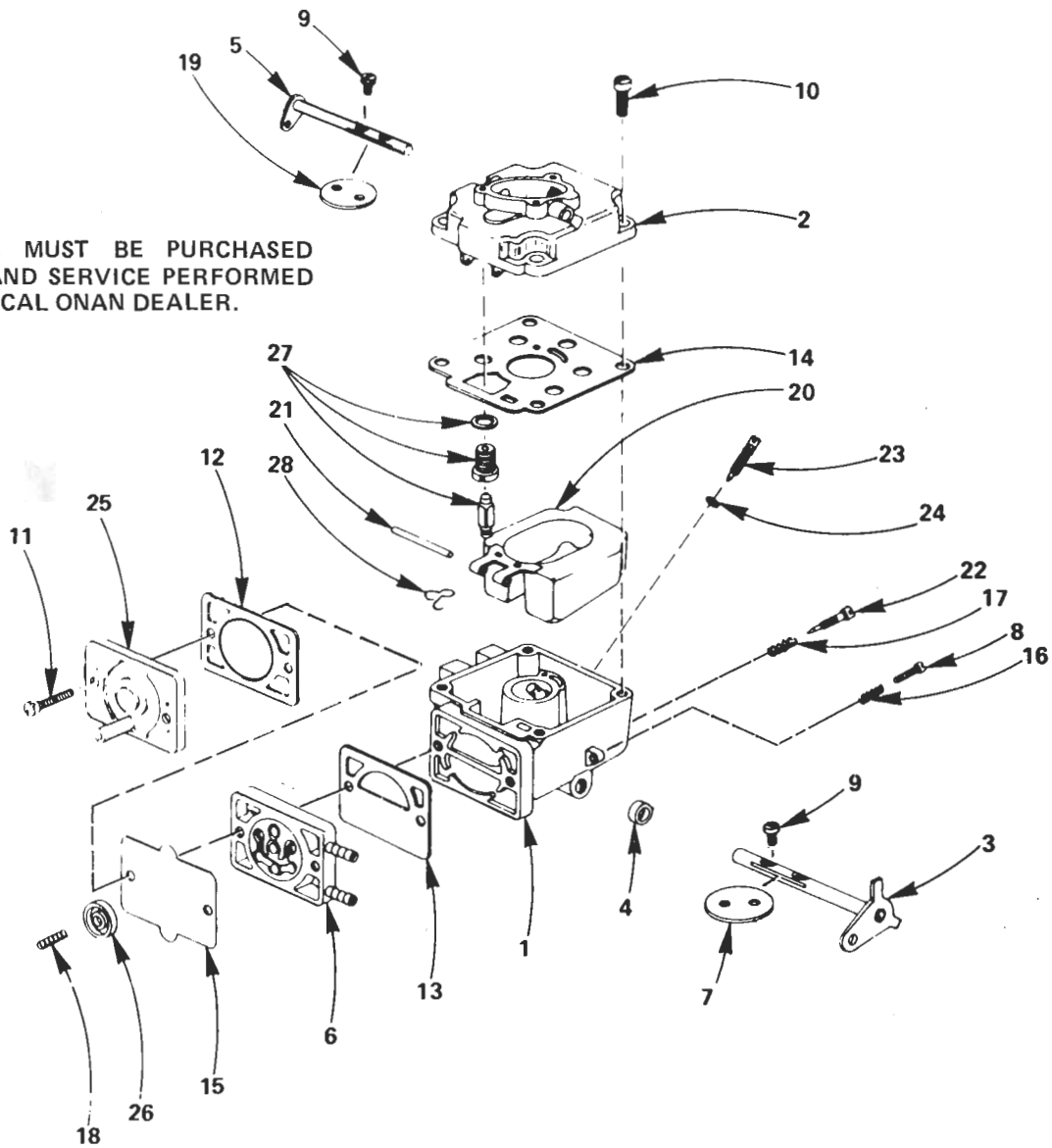
Form only used
14-7215 Assembly 202

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

CARBURETOR PARTS GROUP

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

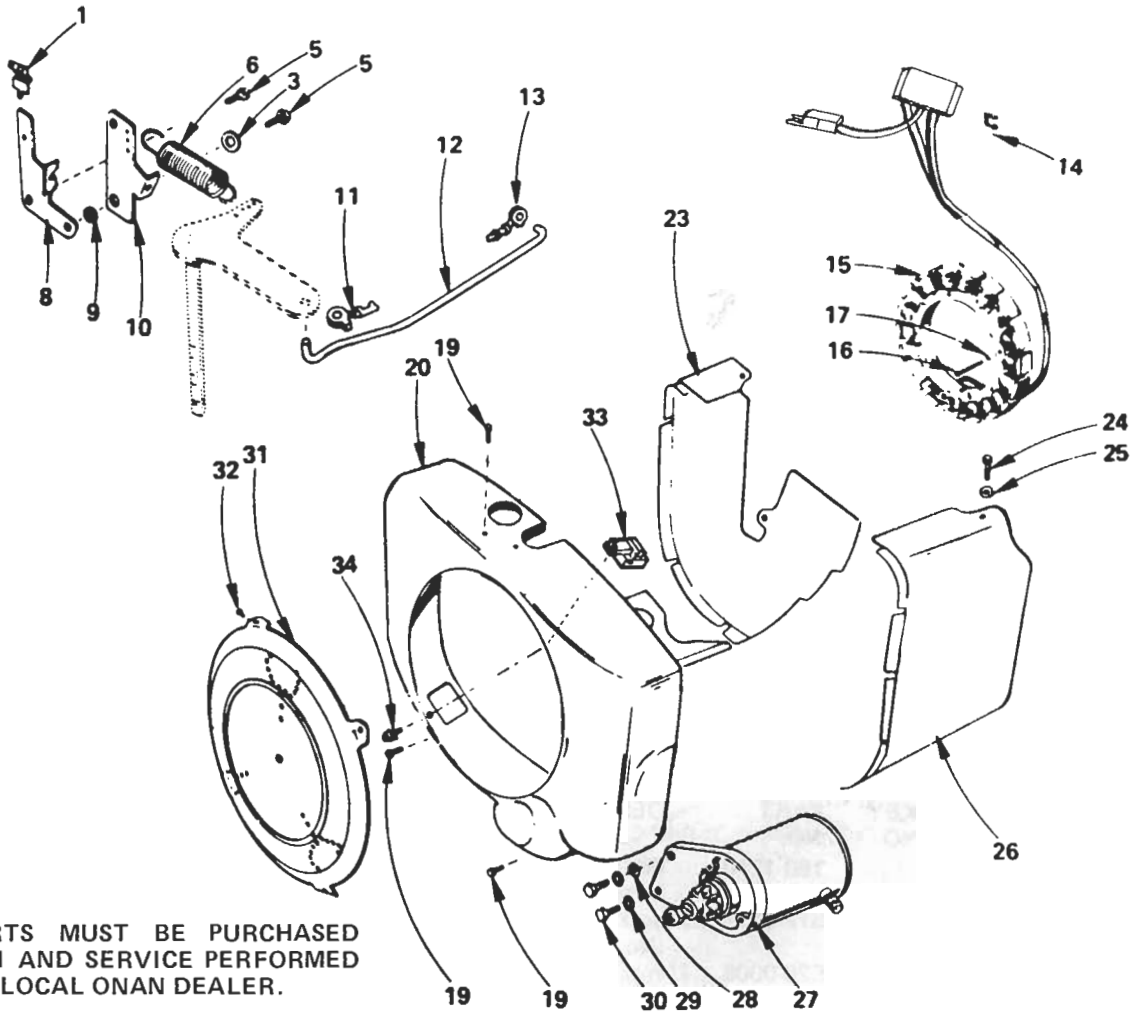
† Included in 142-0571 Gasket Set.
* Included in 142-0570 Repair Kit.

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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

GOVERNOR, STARTER, CHARGING ALTERNATOR AND BLOWER HOUSING GROUP



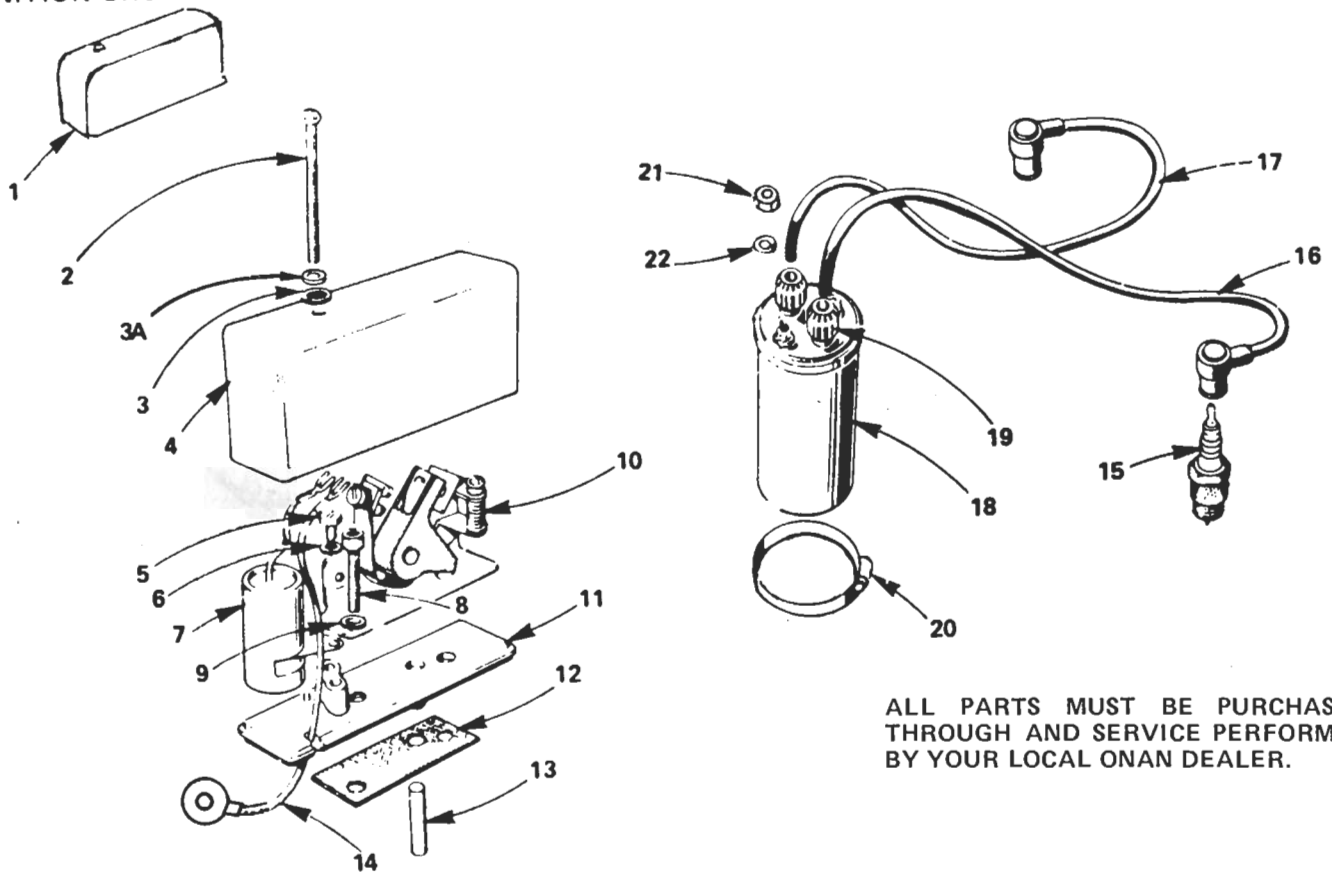
ALL PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	153-0514	Clip, Throttle Cable	19	815-0261	Screw, Hex Head Cap (1/4 - 20 x 7/16")
3	526-0214	Flat Washer 17/64 I.D. x 1/2 x 1/16	20	134-3749	Housing, Blower
5	815-0436	Screw, Hex Cap - Flange Locking (1/4 - 20 x 1/2)	23	134-2989	Housing, Cylinder Air - Left
6	150-1214	Spring, Governor	24	815-0290	Screw, Hex Head Cap (1/4 - 20 x 5/8")
8	150-1725	Bracket, Governor Mounting	25	526-0021	Washer, Flat - Steel (17/64" I.D. x 3/4" O.D. x 1/16" Thick)
9	150-1269	Bushing Governor Control	26	134-3400	Housing, Cylinder Air - Right
10	150-1576	Arm, Governor Control	27	191-0933	Starter, 12 Volt (For Components see separate group)
11	870-0278	Clip, Governor Control Rod to Governor Arm	28	526-0113	Washer, Flat - Steel (11/32" I.D. x 1" O.D. x 3/32" Thick)
12	150-1350	Rod, Governor Control	29	850-0045	Washer, Spring Lock (5/16")
13	518-0004	Clip, Governor Control Rod to Carburetor	30	800-0028	Screw, Hex Head Cap (5/16 - 18 x 1")
14	167-0188	Clip, Alternator Lead Support	31	134-3213	Guard, Blower Housing
15	191-1216	Stator, Charging Alternator	32	815-0378	Screw, Ind. Hex Head w/ET (No. 14 x 1/2")
16	813-0143	Screw Round Head - Steel No. 10 - 32 x 1 - 3/8"	33	191-1206	Regulator, Alternator (15 Amp)
17	850-0030	Washer, Lock (No. 10)	34	821-0010	Screw, Hex Hd. Cap (1/4 - 20 x 1/2)

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

IGNITION GROUP



ALL PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.

KEY NO.	PART NO.	DESCRIPTION
1	160-1210	Box Assembly, Breaker (Includes Parts Marked *)
2	812-0108	†*Screw, Machine - Round Head (No. 10 - 14 x 1 - 1/2")
3	526-0008	†*Washer, Flat (13/64" I.D. x 7/16" O.D. x 1/32" thick)
3A	509-0065	†*Retainer, "O" Ring
4	160-1232	*Cover, Breaker Box (Includes parts marked †)
5	815-0358	*Screw, Tapping - Hex Head (No. 8 - 32 x 5/16")
6	850-0025	*Washer, Lock - Spring (No. 8)
7	312-0196	*Condenser, Ignition
8	802-0034	*Screw, Cap - Socket Head (1/4 - 20 x 3/4")
9	850-0038	*Washer, Lock - Spring - High Collar (1/4")
10	160-1183	*Point Assembly, Breaker
11	160-1219	*Base, Breaker Box
12	160-1150	+*Gasket, Breaker Box
13	160-1151	Plunger, Breaker Point Assembly
14	336-2378	Lead, Breaker Points to Coil
15	167-0298	Plug, Spark
16	167-1595	Cable, Spark Plug (17")
17	167-1596	Cable, Spark Plug (15")
18	166-0535	Coil, Ignition
19	166-0604	Nut, Coil Cable (Part of 166-0535 Coil)
20	503-0311	Clamp, Coil Mounting
21	166-0554	Nut, Hex
22	850-2005	Washer, Lock

*PARTS INCLUDED IN 160-1210 BREAKER BOX ASSEMBLY.

+INCLUDED IN GASKET KIT 168-0130.

†INCLUDED IN 160-1232 COVER

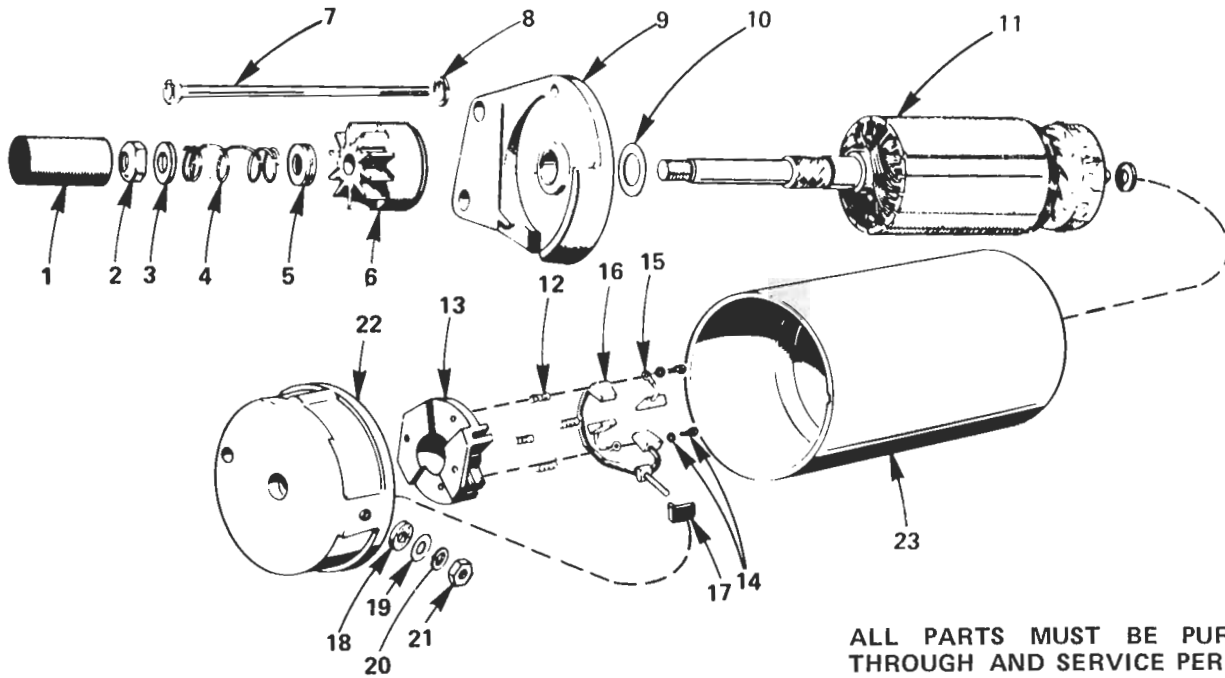
replaced by 312-0246

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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

STARTER PARTS GROUP



ALL PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.

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

† - Included in the 191-1040 Cap Assembly.

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

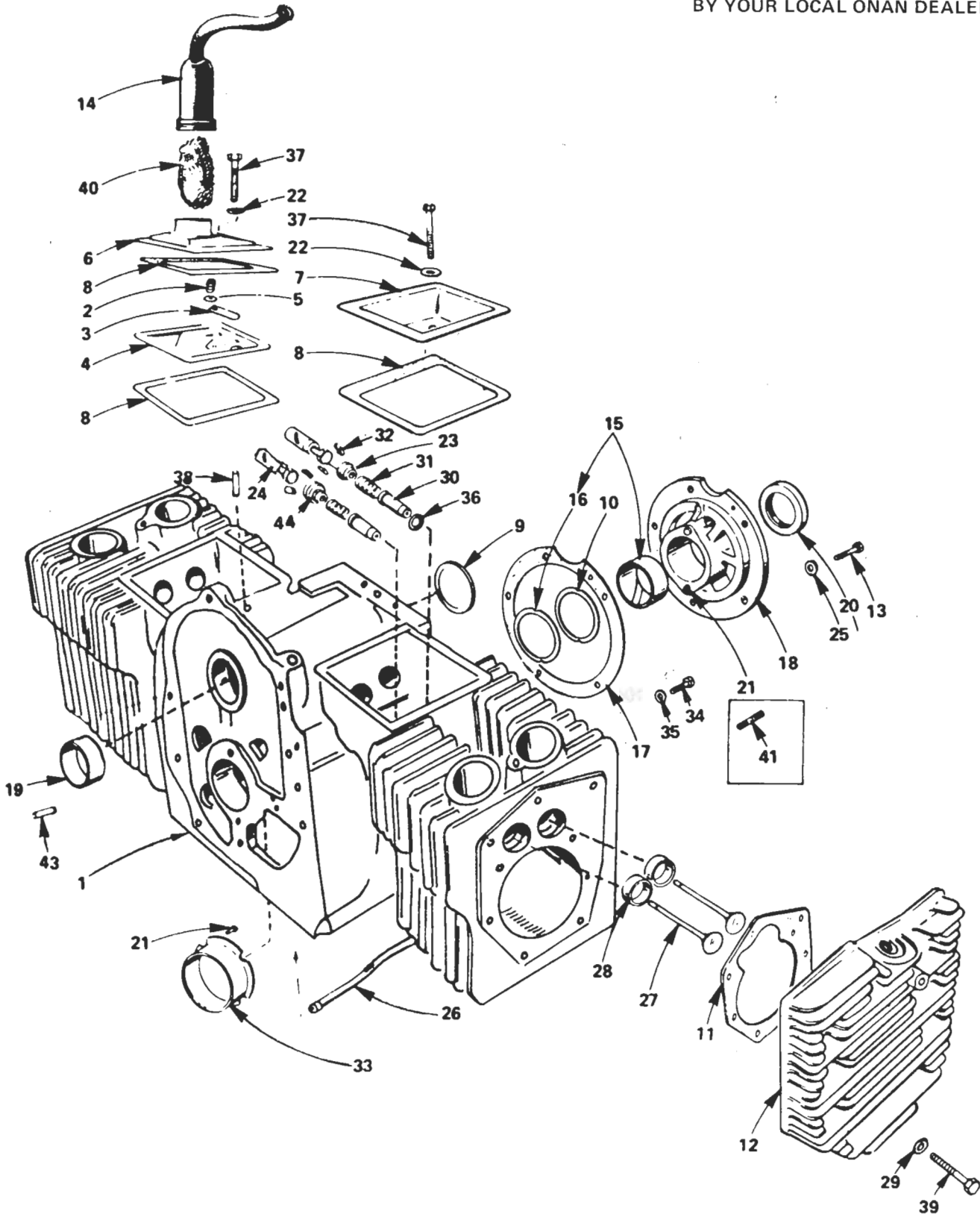
▲ - Not Sold Separately

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

CYLINDER BLOCK GROUP

ALL PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.



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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

CYLINDER BLOCK GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	110-2590	Block Assembly, Cylinder (Includes Parts Marked †)	28		INSERT, VALVE SEAT EXHAUST
2	123-1174	Spring, Breather Valve	110-1824		†Standard
3	123-1175	Valve, Breather	110-1824-02		.002" Oversize
4	123-1173	Baffle, Breather	110-1824-05		.005" Oversize
5	526-0018	Washer, Flat - Steel (17/64" I.D. x 5/8" O.D. x 1/16" Thick)	110-1824-10		.010" Oversize
6	110-2274	Cover, Valve Compartment (L.H.)	110-1824-25		.025" Oversize
7	110-1879	Cover, Valve Compartment (R.H.)			INTAKE
8	110-1921	xGasket, Valve Cover	110-0197		†Standard
9	517-0048	†Plug, Extension - Camshaft	110-0197-02		.002" Oversize
10	104-0776	†Shim, Rear Bearing Plate (.005")	110-0197-05		.005" Oversize
11	110-0892	xGasket, Cylinder Head	110-0197-10		.010" Oversize
12		HEAD, CYLINDER	110-0197-25		.025" Oversize
	110-2564	Right Side (No. 2 Cylinder)	29	526-0122	Washer, Flat - Steel (11/32" I.D. x 23/32" O.D. x 10 Gauge)
	800-2563	Left Side (No.1 Cylinder)	30	110-1807	†Guide, Valve
13	800-0051	†Screw, Hex Head Cap - Steel (3/8 - 16 x 1 - 1/4")	31	110-0539	Spring, Valve
14	123-1277	Tube, Breather	32	110-0639	Lock, Valve and Spring Retainer
15		BEARING, CRANKSHAFT - REAR (INCLUDES THRUST WASHER)	33		*BEARING, CRANKSHAFT - FRONT (FLANGED)
	101-0450	†Standard	101-0432		†Standard
	101-0450-02	.002" Undersize	101-0432-02		.002" Undersize
	101-0450-10	.010" Undersize	101-0432-10		.010" Undersize
	101-0450-20	.020" Undersize	101-0432-20		.020" Undersize
	101-0450-30	.030" Undersize	101-0432-30		.030" Undersize
16	104-0575	†*Washer, Crankshaft Bearing Thrust	34	800-0046	Screw, Hex Head Cap (3/8 - 16 x 3/4") - Cylinder Block Wet Hole
17	101-0415	x†Gasket, Bearing Plate	35	526-0066	Washer, Flat - Copper (25/64" I.D. x 9/16" O.D. x 1/16" O.D.)
18	101-0439	†Plate, Bearing (Excludes Bearings)	36	110-0068	x†Gasket, Valve Guide (Intake)
19	101-0405	†Bearing, Camshaft (Precision)	37	800-0010	Screw, Hex Head Cap (1/4 - 20 x 1 - 3/4")
20	509-0041	x†Seal, Bearing Plate	38	149-1299	†Tube, Fuel Pump Vacuum
21	516-0072	†Pin, Main Bearing Stop	39		SCREW, HEX HEAD CAP
22	526-0063	Washer, Flat - Copper (17/64" I.D. x 7/16" O.D. x 1/32" Thick)		800-0540	5/16 - 18 x 1 - 5/8"
23	110-0893	Retainer, Valve - INTAKE		800-0541	5/16 - 18 x 2"
24		TAPPET, VALVE	40	123-0865	Filter, Breather Tube
	115-0006	Standard	41	520-0820	Stud, Cylinder Block Wet Hole (Lower)
	115-0006-02	.002" Oversize	43	516-0141	†Pin, Dowel (Gear Cover Aligner)
	115-0006-05	.005" Oversize	44	110-0904	Rotocap - Exhaust Valve
25	850-0050	†Washer, Lock (3/8")			
26	120-0735	†Tube, Crankcase Oil			
27		VALVE			
	110-1808	Intake			
	110-1809	Exhaust			

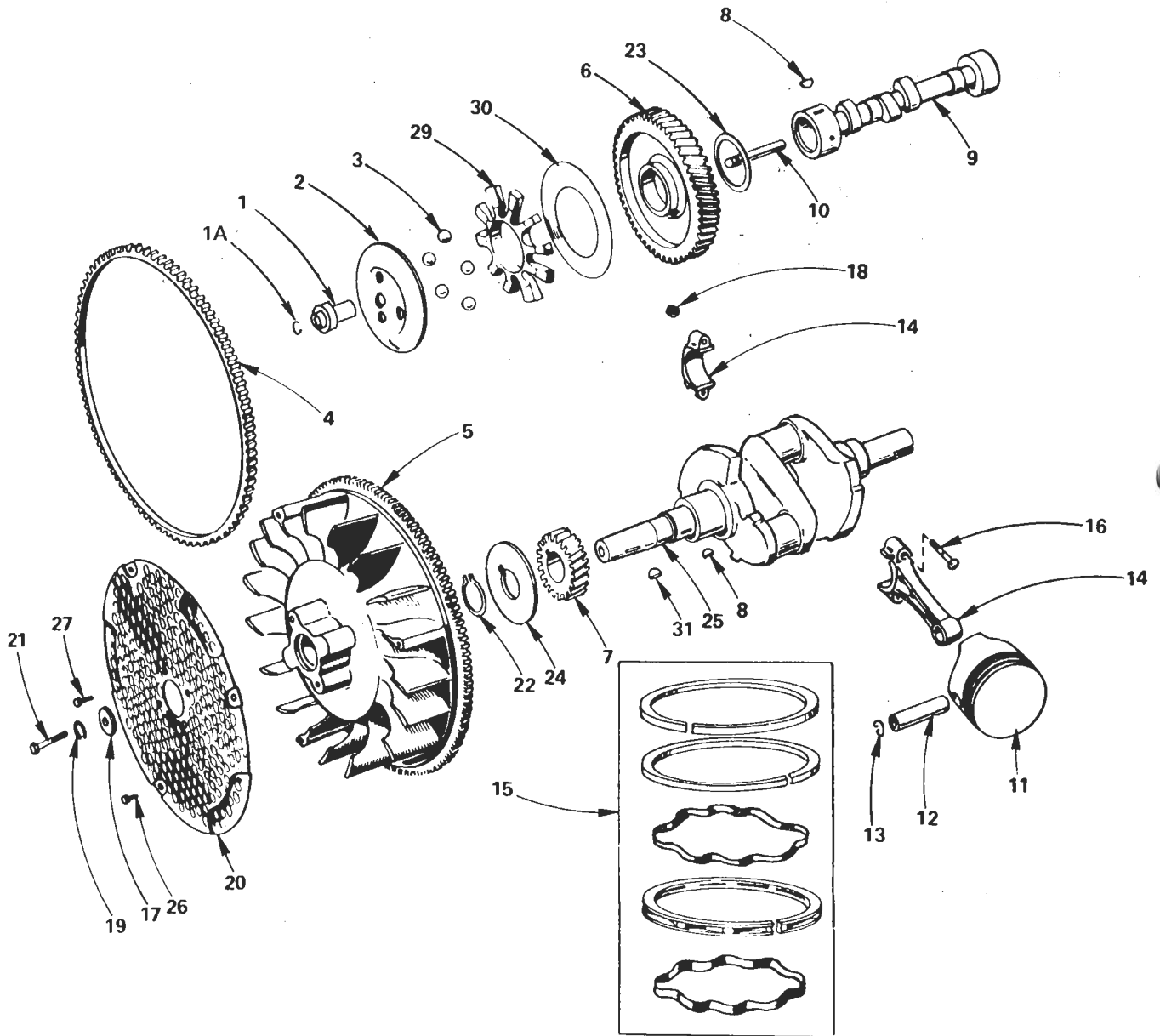
† - Included in 110-2590 Cylinder Block Assembly.
* - Replacement Front Flange Bearing replaces unflanged bearing and thrust washer.
x - Included in Gasket Kit 168-0130

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE -MODEL NO. B48M-GA018/3560A

CRANKSHAFT, FLYWHEEL, CAMSHAFT
AND PISTON GROUP

ALL PARTS MUST BE PURCHASED
THROUGH AND SERVICE PERFORMED
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REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

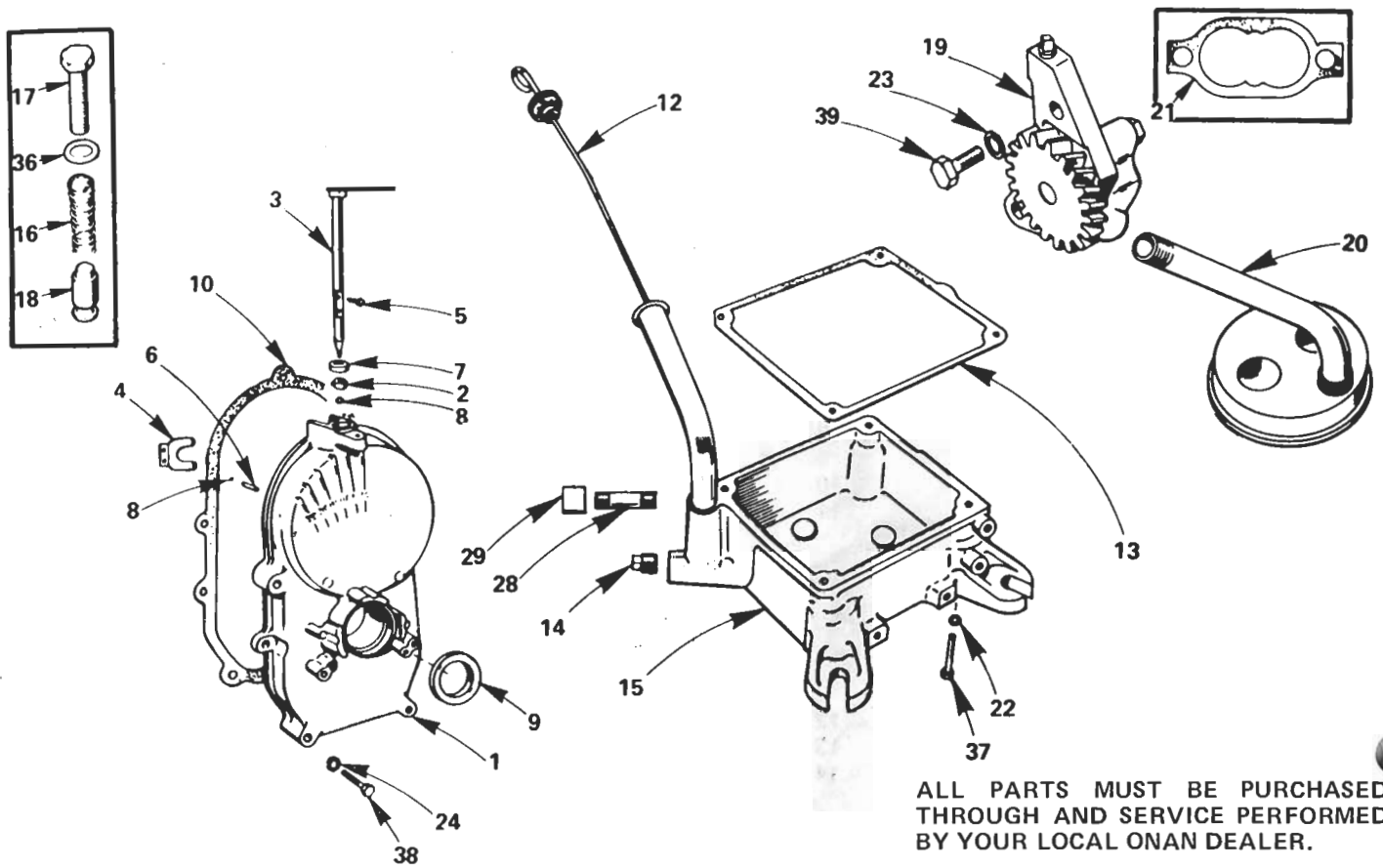
CRANKSHAFT, FLYWHEEL, CAMSHAFT AND PISTON GROUP

KEY NO.	PART NO.	DESCRIPTION
1	150-1519	Hub
1A	150-0078	Ring, Camshaft Center Pin
2	150-1520	Cup, Governor
3	510-0015	Ball, Fly - Governor
4	104-0779	Gear, Ring - Flywheel
5	134-3494	Flywheel (Includes Ring Gear and Magnet Ring)
6	105-0332	Gear, Camshaft (Includes Flyball Spacer and Plate)
7	104-0032	Gear, Crankshaft
8	515-0001	Key (1/2" Diameter x 1/8")
9	105-0402	Camshaft (Includes Center Pin)
10	150-0075	Pin, Camshaft Center
11		PISTON AND PIN (INCLUDES RETAINING RINGS)
	112-0151	Standard
	112-0151-05	.005" Oversize
	112-0151-10	.010" Oversize
	112-0151-20	.020" Oversize
	112-0151-30	.030" Oversize
	112-0151-40	.040" Oversize
12	112-0122	Pin, Piston
13	518-0311	Ring, Piston Pin Retaining
14		ROD ASSEMBLY, CONNECTING
	114-0257	Standard
	114-0257-10	.010" Oversize
	114-0257-20	.020" Oversize
	114-0257-30	.030" Oversize
15		RING SET, PISTON
	113-0189	Standard
	113-0189-05	.005" Oversize
	113-0189-10	.010" Oversize
	113-0189-20	.020" Oversize
	113-0189-30	.030" Oversize
	113-0189-40	.040" Oversize
16	114-0240	Bolt, Special - Connecting Rod
17	526-0017	Washer, Flat Steel
	(15/32" I.D. x 1 - 1/4" O.D. x 1/4" Thick)	
18	870-0302	Nut, Locking (5/16 - 24)
19	850-0055	Washer, Spring Lock (7/16")
20	134-3508	Guard, Flywheel
21	104-0170	Screw, Hex Head Cap (7/16 - 14 x 4")
22	518-0014	Ring, Retaining - Crankshaft Gear Washer
23	105-0004	Washer, Camshaft Gear Thrust
24	104-0043	Washer, Crankshaft Gear Retainer
25	104-0996	Crankshaft
26	815-0400	Machine Screw Truss Head
27	821-0014	Screw, Hex Head Cap - Locking Flange (5/16 - 18 x 1/2")
29	150-1257	Spacer, Governor Flywheel
30	150-0077	Plate, Governor Flyball
31	515-0227	Key Kit

REPAIR PARTS

ROPER 18T TWIN-GARDEN TRACTOR--MODEL NO. T8328BR
ONAN ENGINE--MODEL NO. B48M-GA018/3560A

GEAR COVER, OIL BASE AND OIL PUMP GROUP



ALL PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.

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

* - Included in Gear Cover Assembly.

+ - Included in Gasket Kit, page 29.

SERVICE NOTES

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ONAN MANUFACTURER'S LIMITED WARRANTY

Onan extends to the original purchaser of goods for use, the following warranty covering goods manufactured or supplied by Onan, subject to the qualifications indicated.

THERE IS NO OTHER EXPRESS WARRANTY.

IMPLIED WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO PERIODS OF WARRANTY SET FORTH BELOW AND TO THE EXTENT PERMITTED BY LAW, ANY AND ALL IMPLIED WARRANTIES ARE EXCLUDED.

IN NO EVENT IS ONAN LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.

NOTE: Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply in every instance.

1. Onan warrants to original purchaser for the periods set forth below that goods manufactured or supplied by it will be free from defects in workmanship and material, provided such goods are installed, operated, and maintained in accordance with Onan's written instructions, and further provided, that installation inspection and initial start-up on commercial-industrial generator set or power system installations are conducted by an Onan Authorized Distributor or its designated service representatives.

PRODUCT APPLICATION

- Goods used in personal, family and household applications.
- Goods used in commercial-industrial applications.
- Commercial-industrial stationary generator sets.
- Commercial-industrial, standby power systems with nominal operating speeds of 1800 rpms or less which are installed in the U.S. or Canada (must include Onan supplied generator sets, automatic transfer switch, exerciser and running time meter).
- Commercial-industrial, standby power systems with nominal operating speeds of 1800 rpms or less which are installed outside the U.S. or Canada (must include Onan supplied generator set, automatic transfer switch, exerciser and running time meter).
- Repair or replacement parts.

PERIOD OF WARRANTY

One (1) year from date of purchase.

One (1) year from date of purchase.

One (1) year from date of initial start-up.

*Five (5) years or 1500 hours, whichever occurs first from the date of initial start-up. Labor allowance for the first two (2) years or 1500 hours, whichever occurs first from the date of initial start-up.

*Two (2) years or 1500 hours, whichever occurs first from the date of initial start-up.

Ninety (90) days from date of purchase, excludes labor.

*MUST BE REGISTERED ON FORM NO. 23C065, TO BE PROVIDED AND COMPLETED BY SELLER.

2. Onan's sole liability and Purchaser's sole remedy for a failure of goods under this warranty and for any and all other claims arising out of the purchase and use of the goods, including negligence on the part of the manufacturer, shall be limited to the repair of the product by the repair or replacement, at Onan's option, of parts that do not conform to this warranty, provided that the product or parts are returned to Onan's factory at 1400 73rd Avenue N.E. Minneapolis, Minnesota 55432, or to an Onan Authorized Distributor or its designated service representative, transportation prepaid:

Except as indicated below, this warranty does not include travel time, mileage, or labor for removal of Onan product from its application and reinstallation.

a. Removal and Reinstallation.

Onan will pay the following stated labor at straight time only for warranty work requiring removal and reinstallation of Onan Products in the following applications, provided, such warranty labor is performed by an Onan Authorized Distributor or its designated service representatives.

- i. Garden Tractor Applications – Up to a maximum of two (2) hours for Onan Industrial Engine installations.
- ii. On-Highway Recreational and Commercial Vehicle Applications – Up to a maximum of one (1) hour for Onan engineered Power Drawer or slide-out type generator set installations.
– Up to a maximum of two (2) hours for all other permanent type generator set installations.
- iii. Marine Product Installations – Up to a maximum of four (4) hours for all single and two cylinder engine powered Marine Generator Sets installed below-deck.
– Up to a maximum of eight (8) hours for all four and six cylinder engine powered Marine Generator Sets installed below-deck.

b. Travel Time and Mileage

- i. Marine Generator Set Installations – Onan will, for six (6) months after date of purchase, pay travel time up to four (4) hours and mileage costs up to one hundred fifty (150) miles related to warranty repairs, provided, such travel and repairs are performed by an Onan Authorized Distributor or its designated service representative.
- ii. Commercial-industrial Standby Generator Set and System Installations – Provided the generator set or system is permanently wired in a stationary installation, Onan will, for six (6) months after initial start-up, pay travel time up to four (4) hours and mileage costs up to one hundred fifty (150) miles for warranty repairs performed by an Onan Authorized Distributor or its designated service representative.

3. All claims must be brought to the attention of Onan or an Authorized Distributor or its designated service representative within thirty (30) days after discovery that goods or parts fail to meet this warranty.

4. THIS WARRANTY SHALL NOT APPLY TO:

- a. Cost of maintenance, adjustments, installation and start-up.
- b. Failures due to normal wear, accident, misuse, abuse, negligence or improper installation.
- c. Products which are altered or modified in manner not authorized by manufacturer in writing.
- d. Failure of goods caused by defects in the system or application in which the goods are installed.
- e. Telephone, telegraph, teletype or other communication expenses.
- f. Living and travel expenses of persons performing service, except as specifically included in Section 2.
- g. Rental equipment used while warranty repairs are being performed.
- h. Overtime labor requested by purchaser.
- i. Starting batteries.

No person is authorized to give any other warranties or to assume any other liabilities on Onan's behalf, unless made or assumed in writing by an officer of Onan, and no person is authorized to give any warranties or assume any other liability on behalf of Seller unless made or assumed in writing by Seller.

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