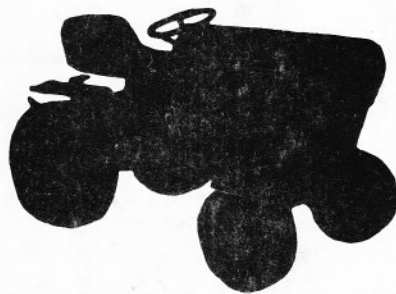


OWNER'S MANUAL

18 H.P. TWIN HYDRO
GARDEN TRACTOR
MODEL NUMBER T8338AR



LAWN AND GARDEN
POWER EQUIPMENT

ROPER

OUTDOOR POWER PRODUCTS

DIVISION OF ROPER CORPORATION

CONGRATULATIONS . . .

on your purchase of a Roper 18 Twin-Hydro 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 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 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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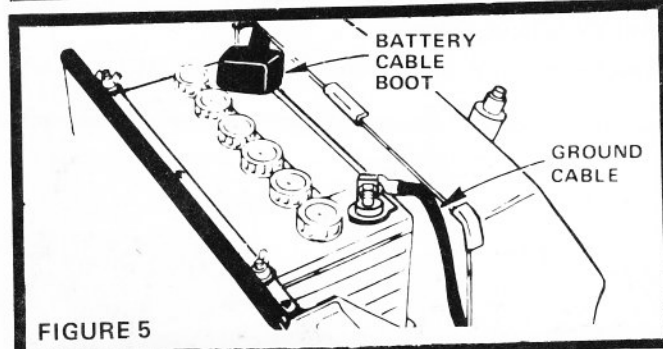
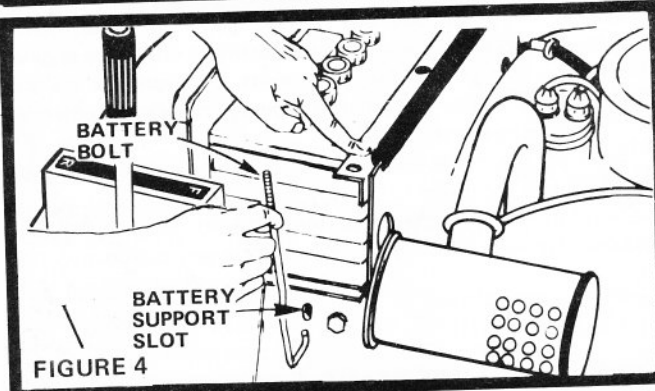
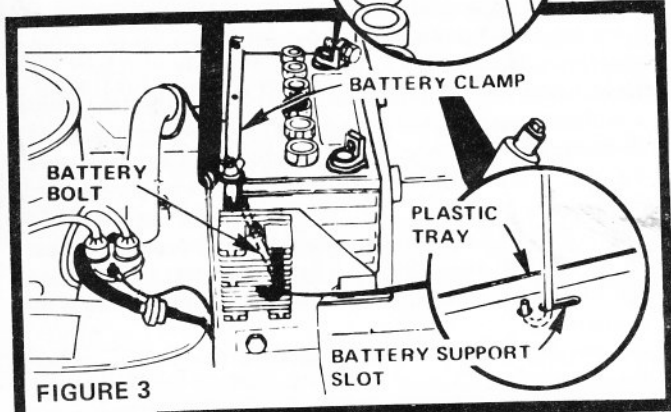
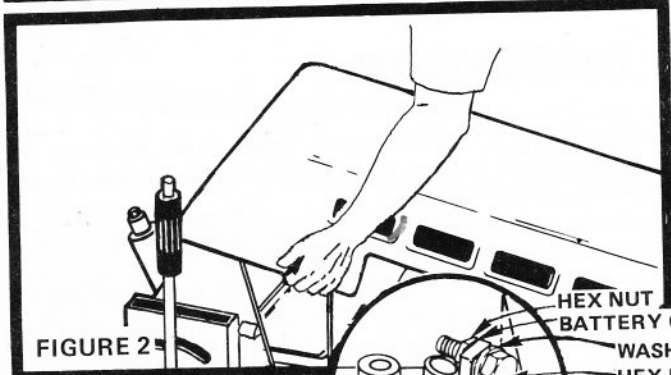
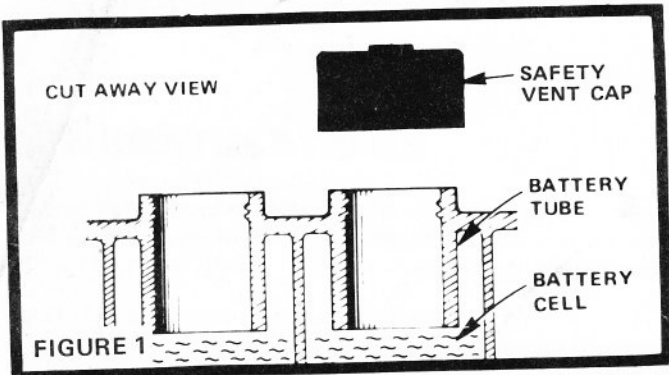
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RULES FOR SAFE OPERATION

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. Clear the work area of objects which might be picked up and thrown.
5. Disengage all attachment clutches and shift into neutral before attempting to start the engine.
6. Disengage power to attachments and stop the engine before leaving the operator's position.
7. Disengage power to attachments and stop the engine before making any repairs or adjustments.
8. Disengage power to attachments when transporting or not in use.
9. Take all possible precautions when leaving the vehicle unattended, such as disengaging the power-take-off, lowering the attachments, shifting into neutral, setting the parking brake, stopping the engine, and removing the key.
10. Do not stop or start suddenly when going uphill or downhill. Mow up and down the face of slopes (not greater than 15°); never across the face.
11. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
12. Stay alert for holes in the terrain and other hidden hazards.
13. Use care when pulling loads or using heavy equipment.
 - a. Use only approved drawbar hitch points.
 - b. Limit loads to those you can safely control.
 - c. Do not turn sharply. Use care when backing.
 - d. Use counterweights or wheel weights when suggested in this owner's manual.
14. Watch out for traffic when crossing or near roadways.
15. When using any attachments, never direct discharge of material toward bystanders nor allow anyone near the vehicle while in operation.
16. Handle gasoline with care - it is highly flammable.
 - a. Use approved gasoline container.
 - b. Never remove the cap of the fuel tank or add gasoline to a running or hot engine, or fill the fuel tank indoors. Wipe up spilled gasoline.
 - c. Open doors if the engine is run in the garage - exhaust fumes are dangerous. Do not run the engine indoors.
17. Keep the vehicle and attachments in good operating condition, and keep safety devices in place.
18. Keep all nuts, bolts and screws tight to be sure the equipment is in safe working condition.
19. Never store the equipment with gasoline in the tank inside a building where fumes may reach an open flame or spark. Allow the engine to cool before storing in any enclosure.
20. To reduce fire hazard, keep the engine free of grass, leaves, or excessive grease.
21. The vehicle and attachments should be stopped and inspected for damage after striking a foreign object, and the damage should be repaired before restarting and operating the equipment.
22. Do not change the engine governor settings or overspeed the engine.
23. When using the vehicle with mower, proceed as follows:
 - (1)Mow only in daylight or in good artificial light.
 - (2)Never make a cutting height adjustment while the engine is running if the operator must dismount to do so.
 - (3)Shut the engine off when removing the grass catcher or unclogging chute.
 - (4)Check the blade mounting bolts for proper tightness at frequent intervals.
24. Check the grass catcher bags frequently for wear or deterioration. Replace with new bags for safety protection.



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



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

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: Press Safety Vent Caps down securely in place.

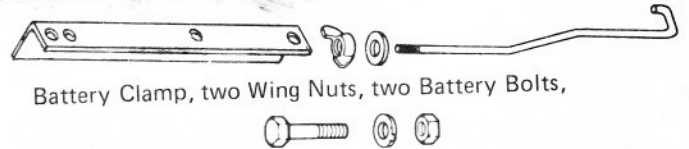
c. Charge Battery at a rate not exceeding three amperes for about two and one half hours.



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:



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

a. Grasp each side of Hood at rear and pull outward and upward (Fig. 2).

b. Remove tape from Plastic Tray. Position Plastic Tray so that drain hole in Tray is over round hole of Battery Support.

c. Place Battery in Plastic Tray (Battery Terminals to rear of Tractor) (Fig. 3).

d. Hook one Battery Bolt into slot on the left side of Battery Support (Fig. 3). Fasten Battery Clamp (inner slot) to Battery Bolt with a Flat Washer and Wing Nut.

e. Hook remaining Battery Bolt to right side of Battery Support and fasten Battery Clamp to it with a Flat Washer and Wing Nut (Fig. 4). Tighten Wing Nuts securely.

f. Place a Flat Washer over the end of a Hex Bolt. Secure RED Battery Cable to Positive (+) Battery Terminal with a Hex Bolt (Washer attached) and Hex Nut (Fig. 5). Tighten Nut securely. Place Boot over Terminal.



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

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

4. Install Steering Wheel using: Flat Washer, Lockwasher, and Hex Bolt assembled on end of Steering Shaft; Woodruff Key, and Steering Wheel Insert found in Bag of Parts.
 - a. Remove Hex Bolt, Lockwasher and Flat Washer from Steering Shaft (Fig. 6).
 - b. 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.
 - c. Fasten with Flat Washer, Lockwasher and Hex Bolt (Fig. 6). Tighten securely.
 - d. Press Steering Wheel Insert in place.

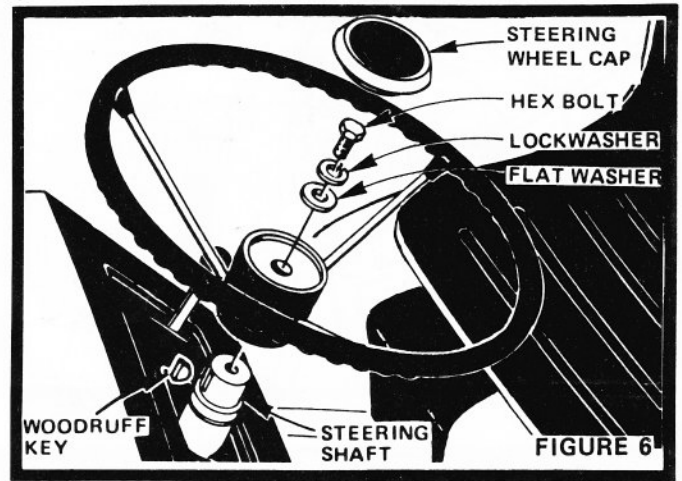


FIGURE 6

INITIAL ADJUSTMENTS

1. Reduce Tire pressure to 12 pounds in front and rear Tires. (Tires were overinflated for shipping purposes).
2. 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.
3. The By-Pass Valve Handle (Fig. 8) slides in and out, and rotates so that Handle will engage the notch in Rotating Plate. Moving the Handle up or down with Handle engaging notch will open or close By-Pass Valve.

The By-Pass Valve must be in closed position (rotate down tight) for tractor to operate with engine running. Index handle up at least four notches if it becomes necessary to push tractor with engine stopped.

NOTE: Do not force Valve.

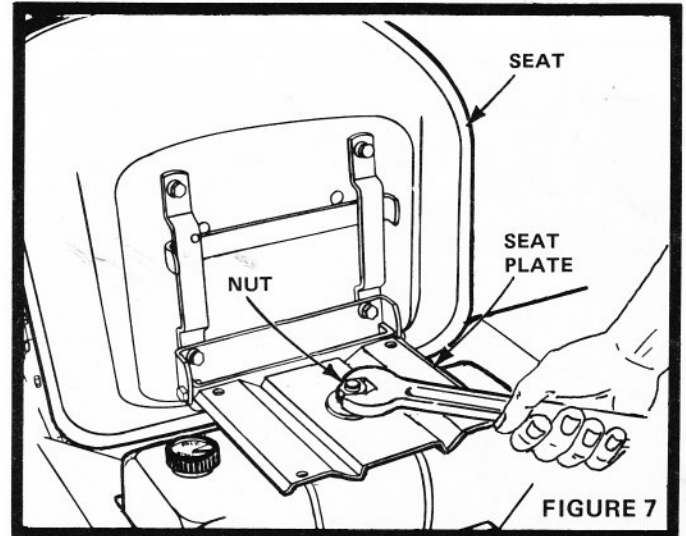


FIGURE 7



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. 11) AND THE DRIVE CONTROL LEVER IS IN "F" FORWARD OR "R" REVERSE POSITIONS (FIG. 12).



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

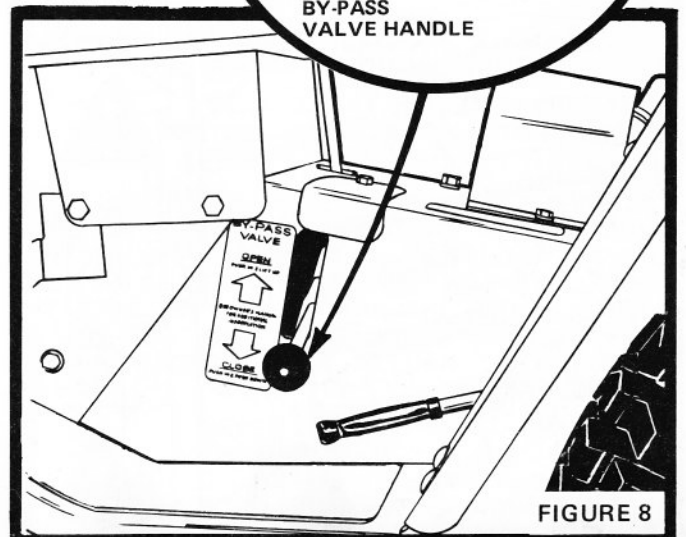
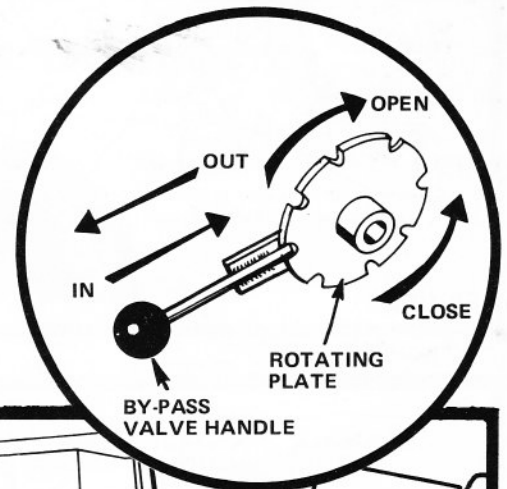


FIGURE 8

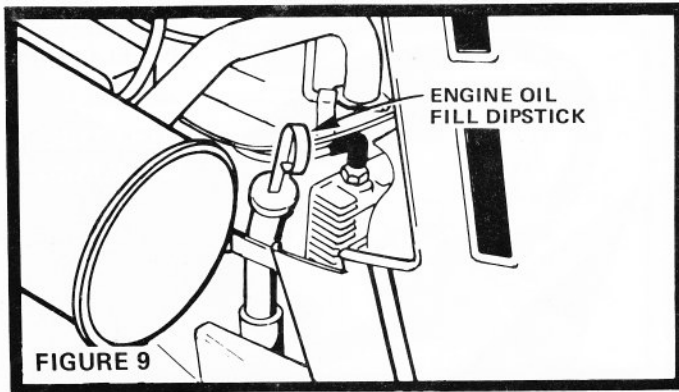


FIGURE 9

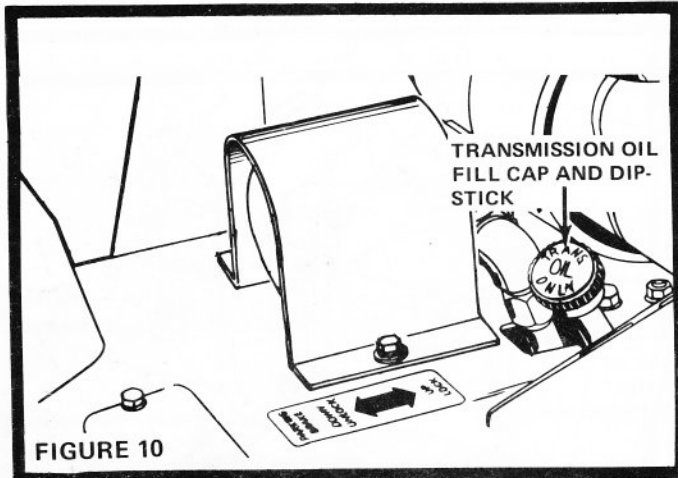


FIGURE 10

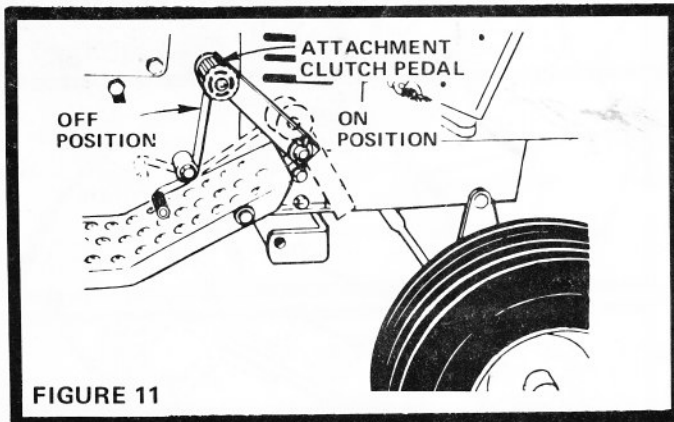


FIGURE 11

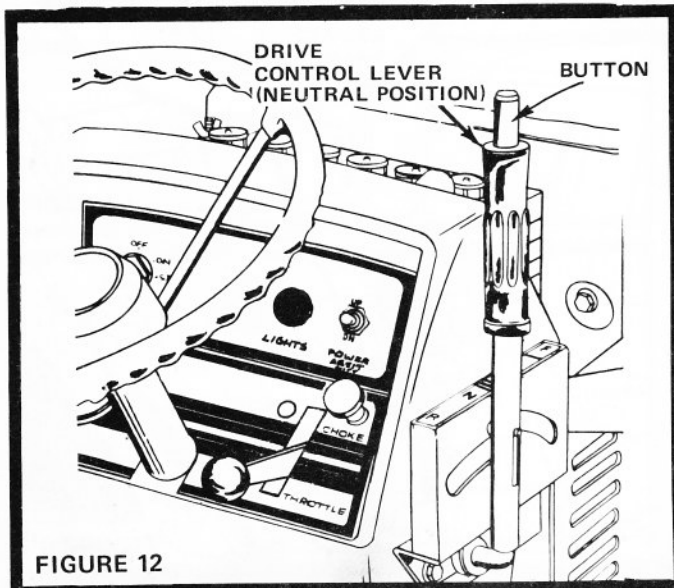


FIGURE 12

INITIAL SERVICE

NOTE: BE EXTREMELY CAREFUL NOT TO ALLOW DIRT OR FOREIGN PARTICLES TO ENTER THE HYDRAULIC SYSTEM OR ENGINE WHEN CHECKING OR ADDING OIL, HYDRAULIC FLUID OR FUEL.

1. Check Engine Oil Level with Tractor on level ground. Wipe dipstick (Fig. 9) 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.
2. Check Hydrostatic Transmission Fluid Level (Fig. 10) with engine running (See Starting Engine Section) and Drive Control Lever (Fig. 12) in neutral position. Add fluid if necessary to bring level up to "SAFE" mark on dipstick. NOTE: Cap and Dipstick must be screwed in tight to check fluid level. Do not fill above "SAFE" mark on dipstick. Use automatic transmission fluid "TYPE F" only.
3. Fill Fuel Tank (Fig. 13) with fresh regular grade lead-free or leaded gasoline. Capacity is 2 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.

OPERATION



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



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 Attachment Clutch Pedal in "OFF" position (Fig. 11).
2. Move Drive Control Lever to "N" neutral position (Fig. 12).
3. Move By-Pass Valve Handle to "CLOSE" position (Fig. 13).
4. Pull up on Parking Brake Handle to "LOCK" position (Fig. 13).

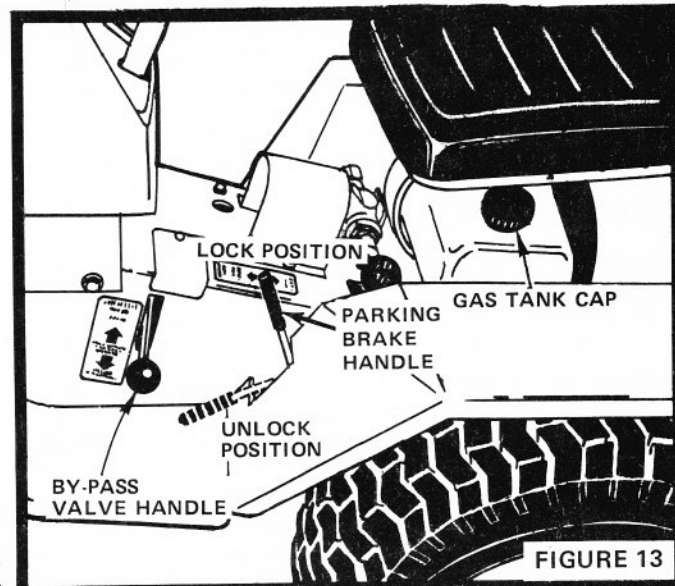


FIGURE 13

5. Push Clutch-Brake Pedal into "BRAKE" position (Fig. 14).
6. Move Throttle Control Lever to middle position (Fig. 15).
7. Pull Choke out (Fig. 15).
8. Turn Ignition Key to "START" position until Engine starts (Fig. 15). 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 "F" fast position, wait a few minutes, and try again.

NOTE: The Power Assist Lift Switch (Fig. 15) raises or lowers an attachment when used with an Electric Three Point Hitch (optional equipment).

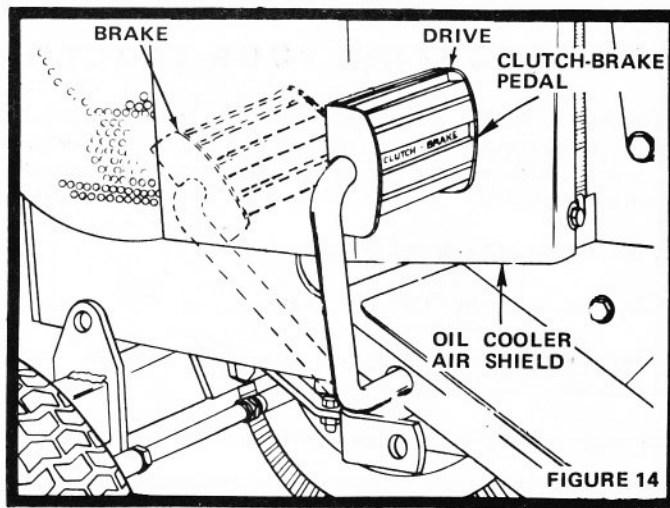


FIGURE 14

WARMING UP THE ENGINE

Move Throttle Control Lever to "S" 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 in 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.

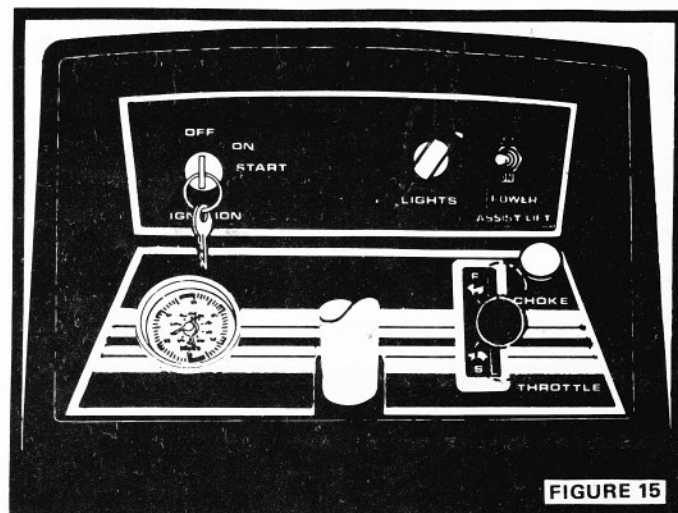


FIGURE 15

TRACTOR OPERATION

1. With engine running and warm, move Throttle Control Lever to middle position.
2. Push down on Parking Brake Handle to "UNLOCK" position.
3. Press Button (Fig. 12) on Drive Control Lever and slowly move Lever forward and tractor will begin to move.



THE DRIVE CONTROL LEVER IS SENSITIVE TO THE SLIGHTEST MOVEMENT. MOVE DRIVE CONTROL LEVER SLOWLY.

4. Adjust Throttle Control Lever to desired engine speed so that engine is not overloaded.
NOTE: Always operate power-driven equipment such as Rotary Mower, Snow Thrower, etc. at full Throttle speed unless otherwise specified in the attachment Owners Manual. Always select a safe ground travel speed that will suit the terrain and the attachment being used.
5. To back-up, return Drive Control Lever to "N" neutral position and tractor will stop. Reduce Throttle Control Lever to "SLOW" position, pull Drive Control Lever back slowly.



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

STOPPING YOUR TRACTOR

1. Return Drive Control Lever to "N" neutral position.
2. Reduce Throttle Control Lever to "S" slow position.
3. Place Attachment Clutch Pedal in "OFF" position.
4. Place Parking Brake in "LOCK" position.



MAKE SURE PARKING BRAKE WILL HOLD TRACTOR SECURE.

5. Turn Ignition Key to "OFF" position.



REMOVE KEY WHEN LEAVING TRACTOR TO PREVENT UNAUTHORIZED USE.

NOTE: USE CLUTCH-BRAKE PEDAL FOR EMERGENCY STOPS ONLY. FOR NORMAL STOPS, RETURN DRIVE CONTROL LEVER TO NEUTRAL BY HAND DEPRESSING THE CLUTCH-BRAKE PEDAL HALF-WAY DECLUTCHES THE TRACTOR AS LONG AS THE PEDAL IS HELD IN THIS POSITION. WHEN FOOT IS REMOVED FROM PEDAL, TRACTOR WILL RETURN TO TRAVELING SPEED.



NEVER USE FOOT PEDAL AS A CLUTCH TO SLOW TRACTOR. ALWAYS PUSH CLUTCH-BRAKE PEDAL ALL THE WAY FORWARD SO THAT DRIVE CONTROL LEVER RETURNS TO NEUTRAL.

TRANSPORTING YOUR TRACTOR

TOWING IS NOT RECOMMENDED. As with any hydraulic power transmission, internal damage can result when vehicle is towed. Push tractor by hand only short distances with controls as follows:

1. Drive Control Lever in "N" neutral.
2. By-Pass Valve in "OPEN" position.
3. Parking Brake Handle pushed down to "UNLOCK" position.

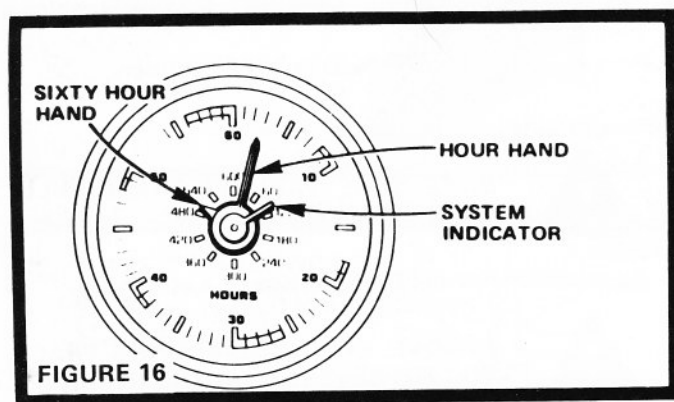
Use trailer to transport tractor for long distances.

TRACTOR OPERATION ON HILLS



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

1. Avoid stopping on hills.
 - a. If slowing is necessary, pull Drive Control Lever back slowly.
 - b. If stopping is necessary, pull Drive Control Lever to neutral.
 - c. Engage Parking Brake.
 - d. To resume travel push Drive Control Lever slowly forward.
 - e. Release Parking Brake as forward movement begins.
2. Make all turns gradually.



STARTING YOUR TRACTOR WITH A LOW BATTERY

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



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

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



DO NOT USE YOUR TRACTOR BATTERY TO START OTHER VEHICLES.

MAINTENANCE

1. SERVICE HOUR METER

To keep your tractor running better, longer; perform necessary service using the following Maintenance Schedule and the Service Hour Meter (Fig. 16) on the tractor dash.

The Service Hour Meter records the number of hours of tractor operation. Read the Hour (Red Hand) on the outer dial; each mark indicating one hour of operation. Read the Sixty Hour (Yellow Hand) on the inner dial; each mark indicating sixty hours of operation. The System Indicator (White Hand) moves visibly when the Ignition Key is in the "ON" position, indicating the system operational. It is normal for this hand to continue to turn for a short period of time after the Ignition Key is turned to the "OFF" position.



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. 14) 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 (Fig. 17).
- 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.

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. 17) and catch Oil in a suitable container. Replace Cap.
- Refill Engine Oil (Fig. 18). 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.

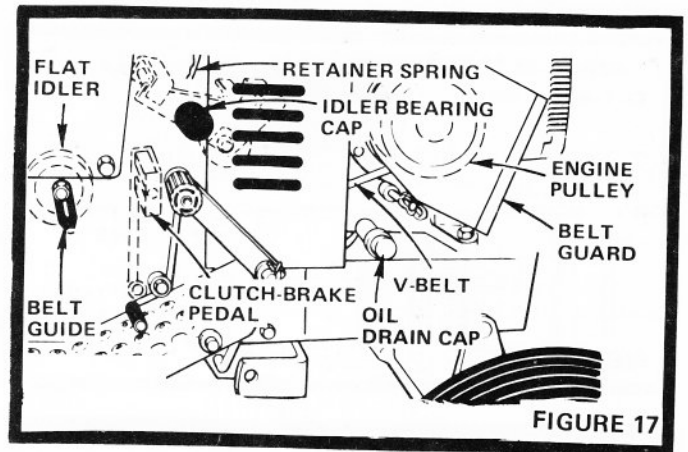


FIGURE 17

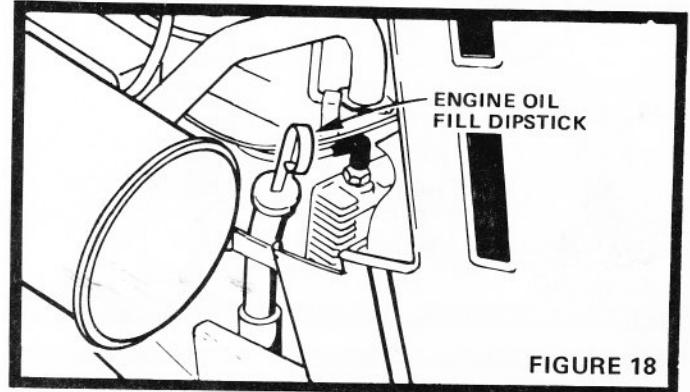


FIGURE 18

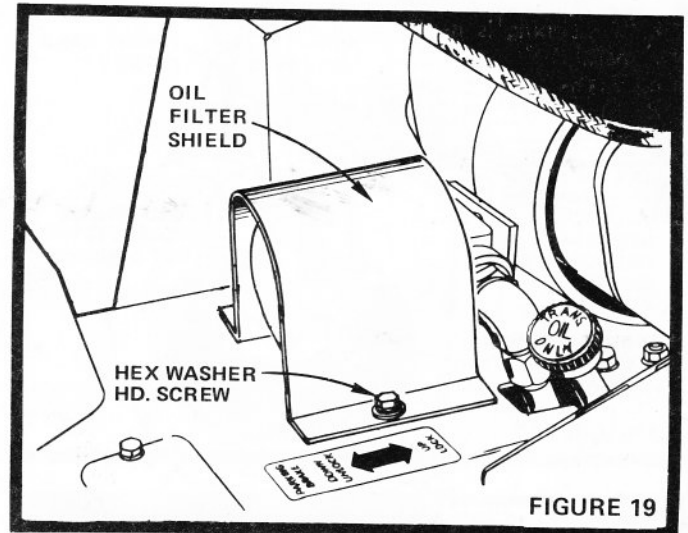


FIGURE 19

FIRST 10 HOURS

1. REPLACE HYDROSTATIC TRANSMISSION FLUID FILTER. Filter is available from Roper (Part No. 5276R).

- Remove Screw from each side of Oil Filter Shield (Fig. 19). Place rag under Filter to absorb oil leakage.
- Turn Filter (Fig. 20) counterclockwise to remove. Apply a light film of oil to seal surface and threads of new Filter. Hand tighten Filter securely. Turn Clockwise to tighten.
- Replace Oil Filter Shield and Screws. Check oil level and replace oil as required.
- After operating Tractor, check Filter for Fluid leaks. If leakage occurs, tighten Filter.

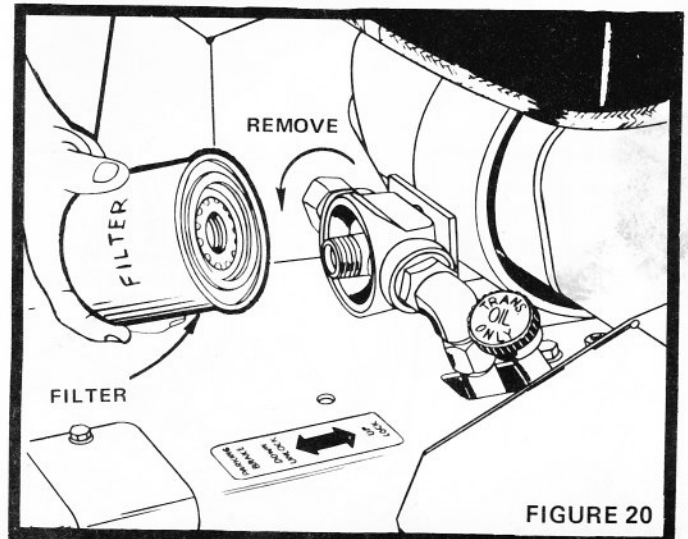


FIGURE 20

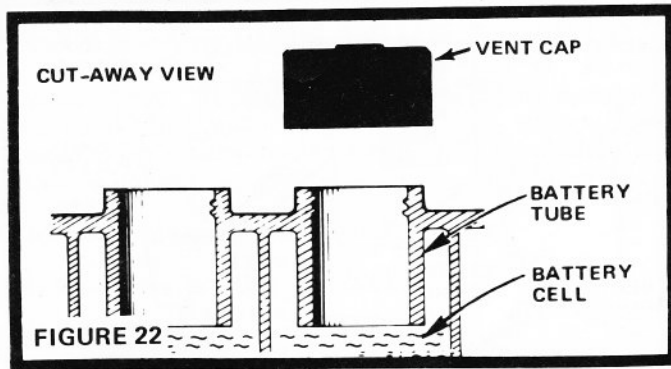


FIGURE 22

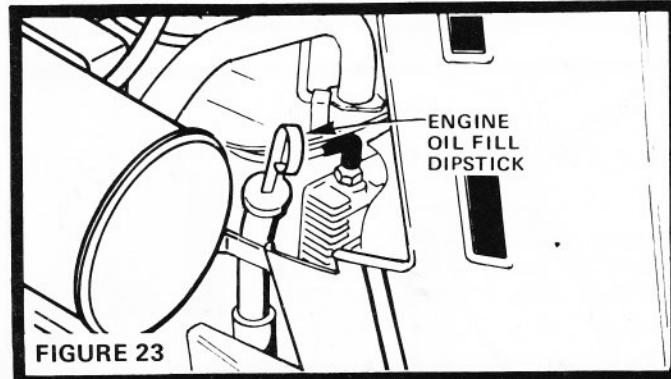


FIGURE 23

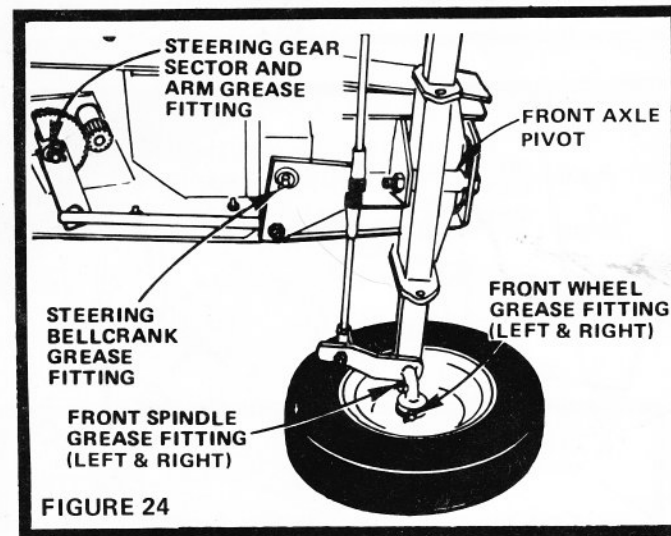


FIGURE 24

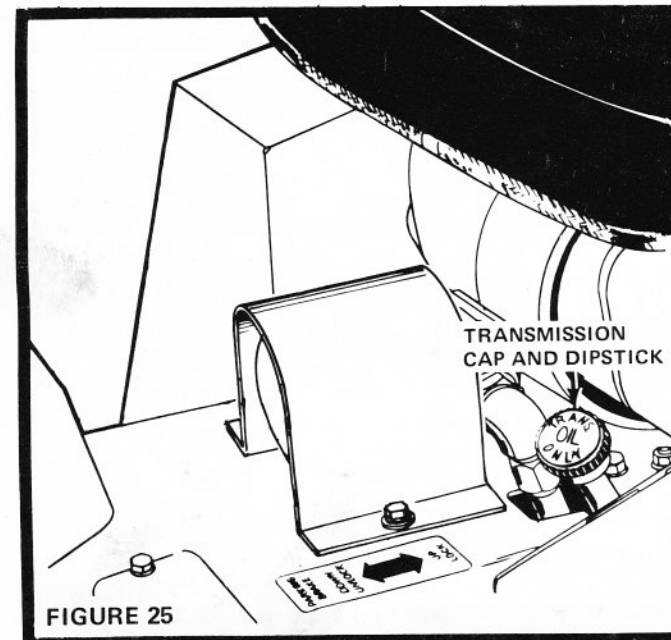


FIGURE 25

FREQUENTLY

1. CHECK BATTERY

- Electrolyte solution level in each Battery Cell should be even with bottoms of tubes in cells (Fig. 22). Add distilled water if necessary. NOTE: DO NOT OVERFILL.
- Keep Battery and Terminals clean. Refer to page 12.
- 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 GUARDS

Blower Housing Guard and Flywheel Guard (Fig. 27) must allow free-flow of air to prevent Engine damage from overheating. Remove Oil Cooler Air Shield (Fig. 14) and Blower Housing Guard. Clean Blower Housing Guard and Flywheel Guard with a wire brush to remove dirt and chaff and stubborn dried gum and fibers.

4. CLEAN OIL COOLER

- It will be necessary to remove the Oil Cooler Air Shield (Fig. 14) to clean Oil Cooler.
- Air is circulated from the back of the Oil Cooler therefore, it is especially necessary that this area be kept clean. Use a small brush, air pressure or water pressure.

NOTE: REPLACE GUARD AND SHIELD AFTER CLEANING.

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. 23) 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. 24). Using a Grease Gun, give each Grease Fitting two shots of Extreme Pressure Lubricating Grease Amdex No. 1 or until grease appears. This grease may be obtained by ordering Part No. 2557R 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:

- Idler Bearings (Fig. 17).
 - Remove Idler Bearing 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.
- Front Axle Pivot (Fig. 24).

EVERY 10 HOURS

1. CHECK HYDROSTATIC TRANSMISSION FLUID LEVEL

NOTE: Be careful not to allow dirt to enter the Hydraulic System when checking Fluid Level.

- Engine must be running and Drive Control Lever in neutral position with Tractor on level ground.
- Unscrew Cap and Dipstick (Fig. 25) remove and wipe clean.
- Screw Cap and Dipstick in tight. Remove and read Fluid Level.
- If necessary, add Fluid to bring level to "SAFE" mark on Dipstick. Use Automatic Transmission fluid "TYPE F" only. Do not overfill. Capacity is 4 - 1/2 quarts. Replace Cap and Dipstick.

When Oil Filters are replaced every 50 hours there will be no need to drain Hydrostatic Transmission.

EVERY 25 HOURS

(EVERY 15 HOURS IF OPERATING IN VERY DUSTY CONDITIONS)

1. CLEAN AIR FILTER & FOAM PRE-CLEANER

- Unscrew Wing Nut (Fig. 26) to remove Air Filter Cover, Paper Air Filter Element and Foam Pre-Cleaner.
 - Clean dust from Paper Air Filter Element by gently tapping Element on a flat surface.
 - Wash Foam Pre-Cleaner in detergent and warm water.
 - Rinse, squeeze (rather than twist) and allow to dry thoroughly.
 - Coat with three tablespoons of S.A.E. 30 Engine Oil, knead to distribute evenly, and squeeze out excess.
 - Check Paper Air Filter Element. Replace if excessively dirty.
 - Re-Assemble Air Filter and re-position on Tractor.
- NOTE: NEVER RUN ENGINE WITH AIR CLEANER REMOVED.

2. CLEAN AIR SCREEN GUARDS

Blower Housing Guard and Flywheel Guard (Fig. 27) must allow free-flow of air to prevent Engine damage from overheating. Remove Oil Cooler Air Shield (Fig. 14) and remove Blower Housing Guard and Flywheel Guard with a wire brush to remove dirt and chaff and stubborn dried gum and fibers.

NOTE: REPLACE GUARD AND SHIELD AFTER CLEANING.

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 7.

EVERY 50 HOURS

1. CLEAN COOLING SYSTEM

Remove any dust, dirt, chaff or oil from Engine Cooling Fins, Blower Housing Guard, Flywheel Guard (located under Blower Housing Guard) and Oil Cooler Cooling Fins to prevent Engine from overheating (Fig. 27).

- It will be necessary to remove the Oil Cooler Air Shield (Fig. 14) to clean Oil Cooler.
- Air is circulated from the back of the Oil Cooler therefore, it is especially necessary that this area be kept clean. Use a small brush, air pressure or water pressure.

NOTE: BE SURE TO REPLACE GUARD AND SHIELD AFTER CLEANING.

2. REPLACE HYDROSTATIC TRANSMISSION FLUID FILTER. Refer to page 7.

3. REPLACE OIL FILTER (FIG. 27).

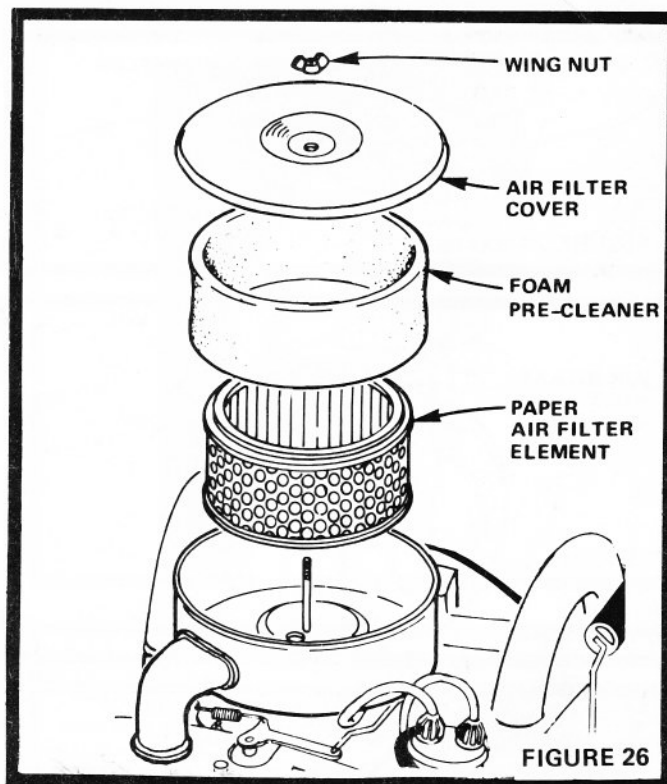


FIGURE 26

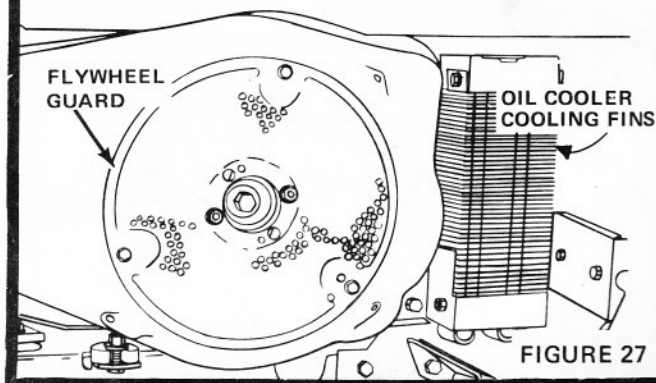
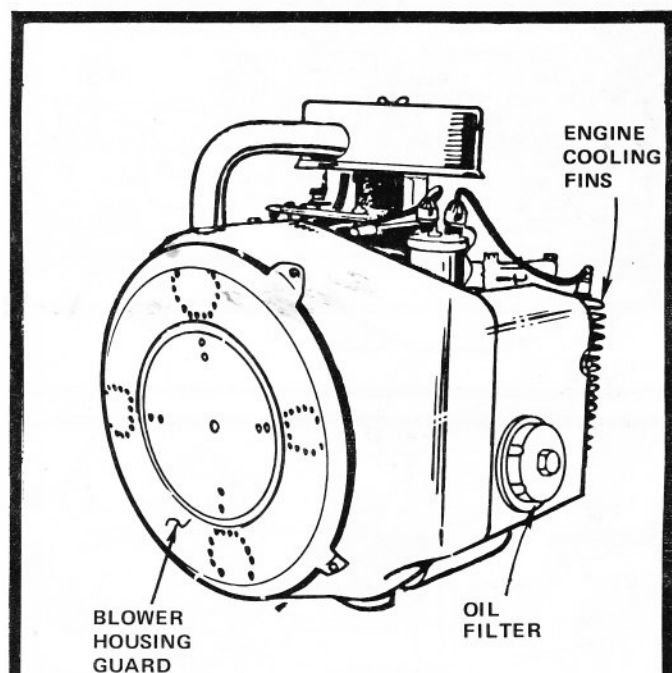


FIGURE 27

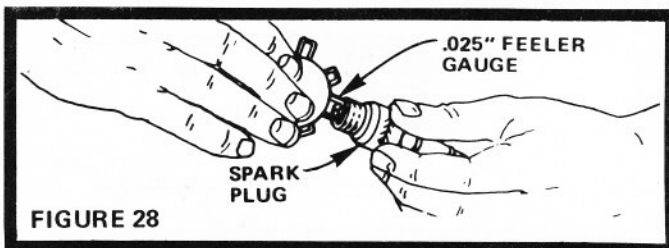


FIGURE 28

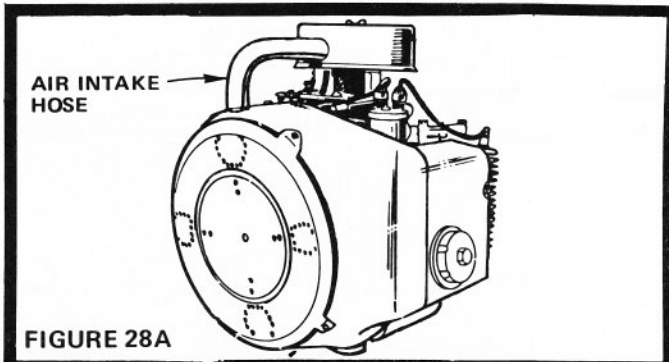


FIGURE 28A

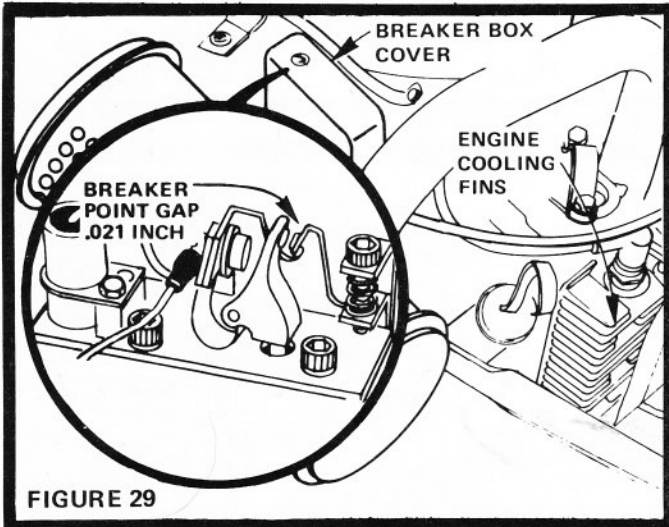


FIGURE 29

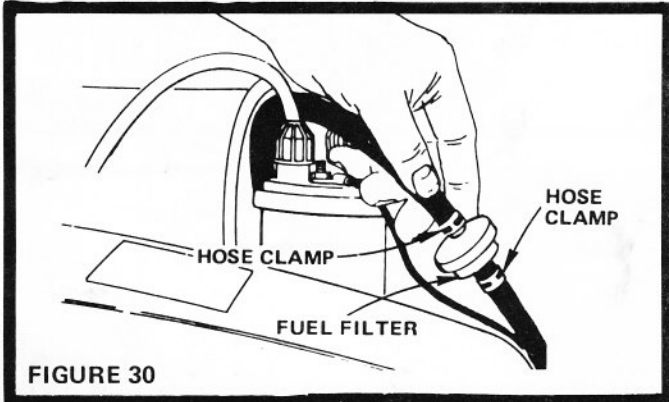


FIGURE 30

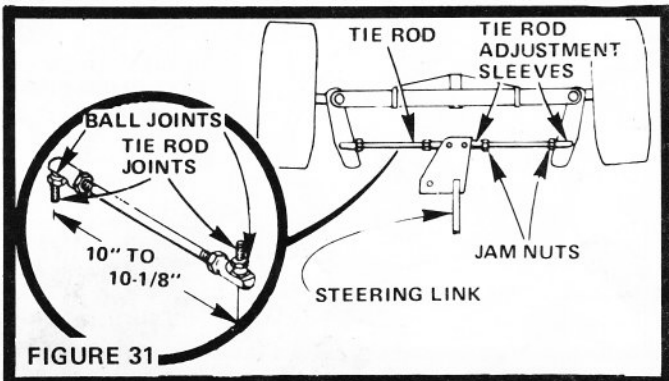


FIGURE 31

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. 28). 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. 28A). This provides an access to view Timing Mark.
- Remove Spark Plugs and Belt Guard and turn Engine Pulley (Fig. 17) 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. 29) by loosening Screw and lift off to remove.
- Replace Points, if necessary.
- Using an Allen Head Wrench, adjust Set Screw for .021 inch between Points. Measure Point Gap with a Flat Feeler Gauge. NOTE: MAKE SURE FEELER GAUGE IS CLEAN AND FREE OF GREASE, OIL, OR DIRT. No other adjustment or alignment is necessary. Setting point gap accurately adjusts Engine Timing.
- Replace Breaker Box Cover, Spark Plugs and Cables and Air Intake Hose.

3. LUBRICATE BALL JOINTS

- Move Rubber Boots to expose Ball Joints on Tie Rods and Steering Link (Fig. 31).
- Coat Ball Joints with Silicone Spray Lubricant.
- Reposition Rubber Boots.

EVERY 200 HOURS

1. REPLACE PAPER AIR FILTER ELEMENT

Refer to page 9.

2. REPLACE BREAKER POINTS

Refer to step 2, above.

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. 30).
- 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. 31) 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. RETENSION V-BELT

It may be occasionally necessary to re-tension V-belt page 7.

4. PARK BRAKE ADJUSTMENT

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

- Remove Cotter Pin and Clevis Pin from Yoke (Fig. 32).
- Turn Yoke one full turn clockwise on Parking Brake Rod. Replace Yoke on Brake Arm and secure with Clevis Pin.
- Place by-pass valve handle (Fig. 34A) in the "OPEN" position.
- With parking brake handle in "LOCK" position (Fig. 34A) L.H. rear tire should slide when tractor is pushed. If tire does not slide, repeat steps a and b.
- Replace Cotter Pin in Clevis Pin.
- Rotate by-pass handle (Fig. 34A) to "CLOSE" position.
- If tractor is to be operated, push down on parking brake handle to "UNLOCK" brake.

5. CARBURETOR ADJUSTMENT

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

- Main Fuel (High Speed) Screw (Fig. 33) should not require adjustment. If resetting is necessary, turn clockwise, closing finger tight ONLY, then turn counterclockwise 1- 1/4 turn.
- Turn Idle Adjusting Needle (Fig. 33) clockwise, closing finger tight ONLY, and then turn counterclockwise one turn.
- Start Engine and allow to warm for five minutes.
- Make final adjustments with Engine running and Drive Control Lever in Neutral position.
 - Turn Idle Adjusting Needle counterclockwise until Engine runs "rough" then clockwise until Engine begins to miss. Return Needle to a point midway between these extremes.
 - Throttle Stop Screw (Fig. 33) should not require adjustment. If resetting is necessary, set to obtain the slowest engine speed that will allow smooth acceleration.

6. BELT REPLACEMENT

- Remove Belt from Clutch Idler by depressing Clutch-Brake Pedal (Fig. 34).
- Remove Belt Guide from Engine Pulley.
- Remove Belt Guide Weldment from Pump Pulley.
- Loosen Flat Idler Assembly on R.H. side of Tractor Frame.
- Remove Belt from Engine Pulley, between Belt Guide Finger (note position of Belt) and Flat Idler, and Pump Pulley.
- Place new Belt around Pump Pulley. Then place Belt between Belt Guide Finger and Flat Idler and then around Engine Pulley.
- Depress Clutch-Brake Pedal and slip Belt over the top of the Clutch Idler.
- Replace Engine Pulley Belt Guide and Pump Pulley Belt Guide Weldment. Tighten Flat Idler Assembly. NOTE: Make sure Belt Guide Finger on Flat Idler is parallel with slot in Tractor Frame.
- Check Belt Tension, page 7.

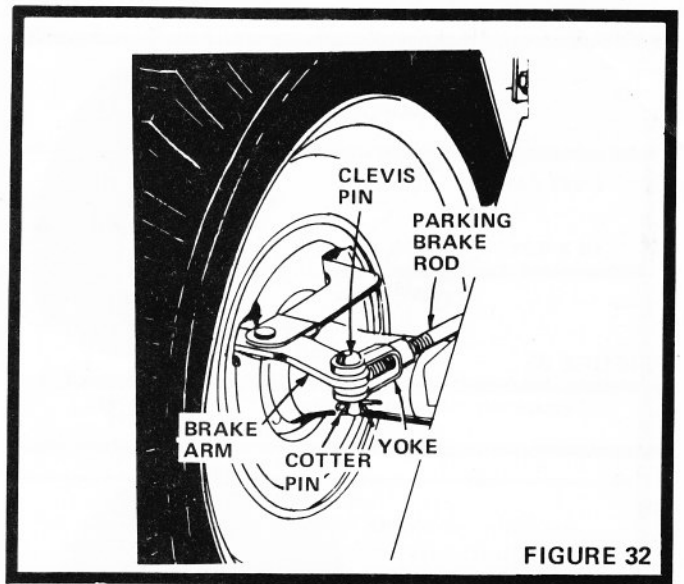


FIGURE 32

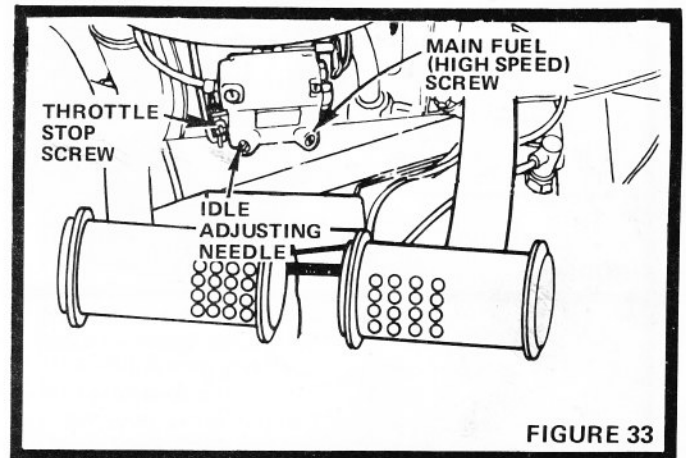


FIGURE 33

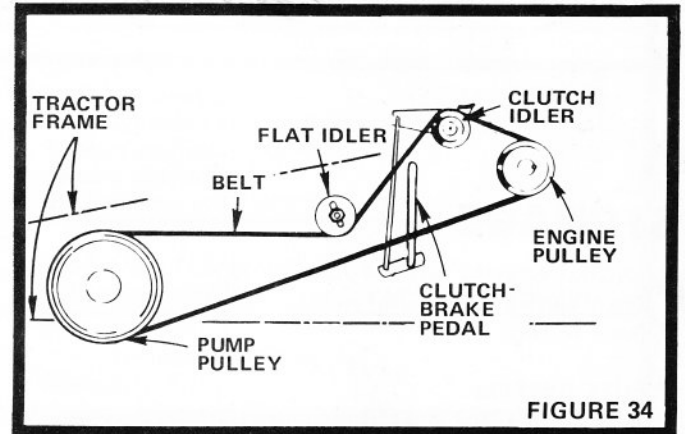


FIGURE 34

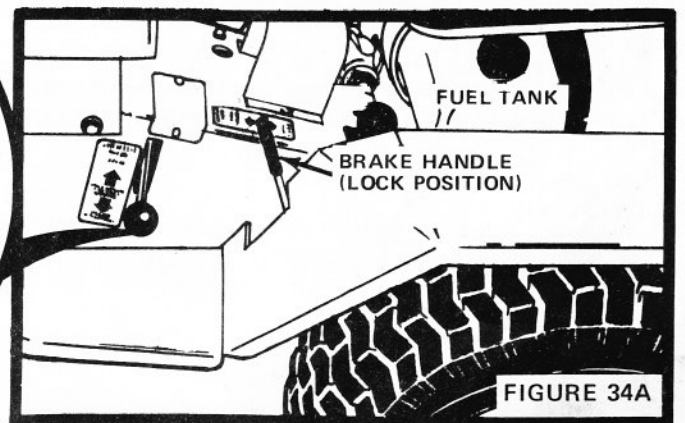
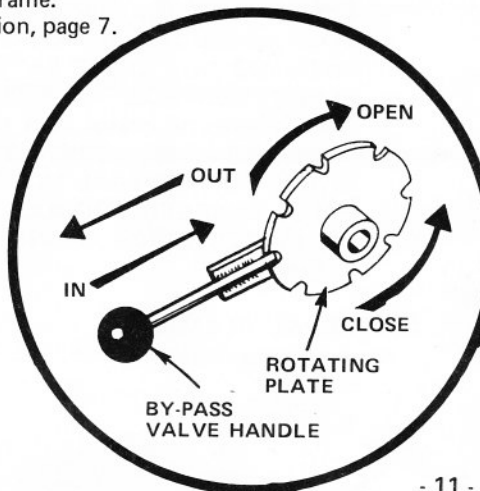


FIGURE 34A

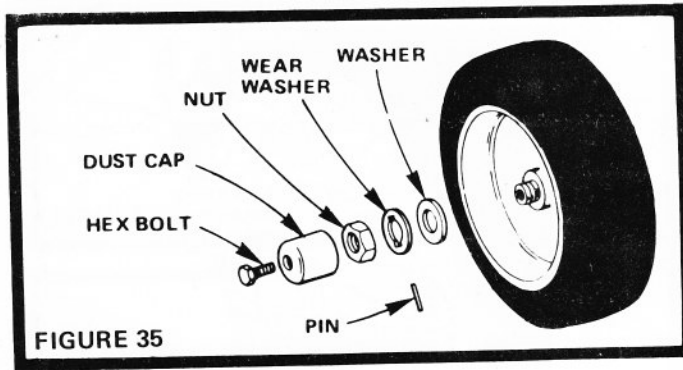


FIGURE 35

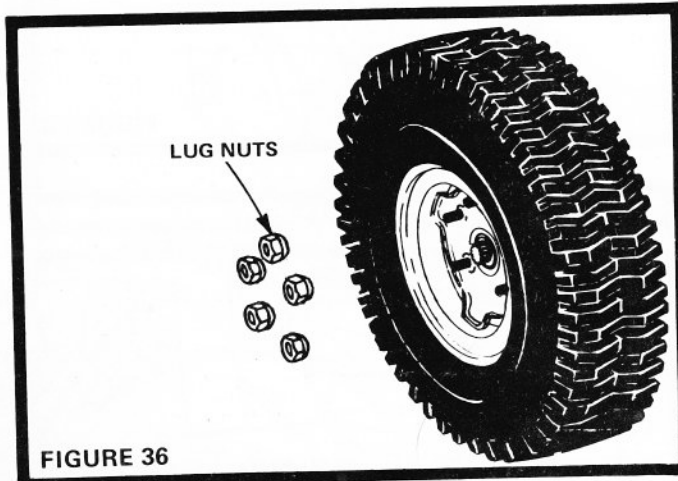


FIGURE 36

7. CLEAN BATTERY AND TERMINALS

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

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

8. TIRE CARE

- a. Maintain tire pressure in front and rear tires of 12 pounds.
- b. Keep tires free of gasoline, oil, or insect control chemicals which can destroy rubber.
- c. Avoid stumps, stones, deep ruts and other hazards that may cause tire damage.
- d. Removing front wheel for tire repair (Fig. 35).
 - Block up front axle securely or use a Roper Tractor Jack. Rear wheels should also be blocked to prevent roll.
 - 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. 36):
 - Block up rear axle securely or use a Roper Tractor Jack. Front wheels should also be blocked to prevent roll.
 - Remove the five Lug Nuts.
 - Repair tire and reassemble. Tighten Lug Nuts securely.

9. FINISH

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

STORAGE

1. ENGINE OIL

Drain (with engine warm) and replace with clean engine oil. Refer to page 7.

2. FUEL SYSTEM

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

3. CYLINDER

- a. Remove Spark Plugs.
- b. Pour one ounce of oil through spark plug holes into cylinders.

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

4. BATTERY

- a. Remove battery if tractor is not used regularly during winter months. Store in cool, dry place (above 50°F). NOTE: DO NOT STORE BATTERY DIRECTLY ON CEMENT SURFACE.
- b. 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.

TROUBLE SHOOTING

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POSSIBLE CAUSE	POSSIBLE REMEDY
WILL NOT START Drive Control Lever in "F" or "R" position Attachment Clutch Pedal in "ON" position No gasoline in Fuel Tank, clogged Fuel Line Filter or Fuel Line Blown Fuse Dead Battery	Move Lever to "N" position Move Pedal to "OFF" position. Fill Tank with Gasoline. Check Fuel Line, Fuel Line 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 Line 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 Line 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	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 behind dash and wire connections. Replace Taillight Bulb or Sealed Beam Headlights
WON'T CHARGE Blown Fuse Defective Battery	Check for fault and replace Replace
WILL NOT MOVE By-Pass Valve open Hydrostatic Transmission Fluid very low	Close valve. Refer to page 3. Add fluid, refer to bottom of page 8.

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 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

MAIN FRAME, DASHBOARD AND GRILL

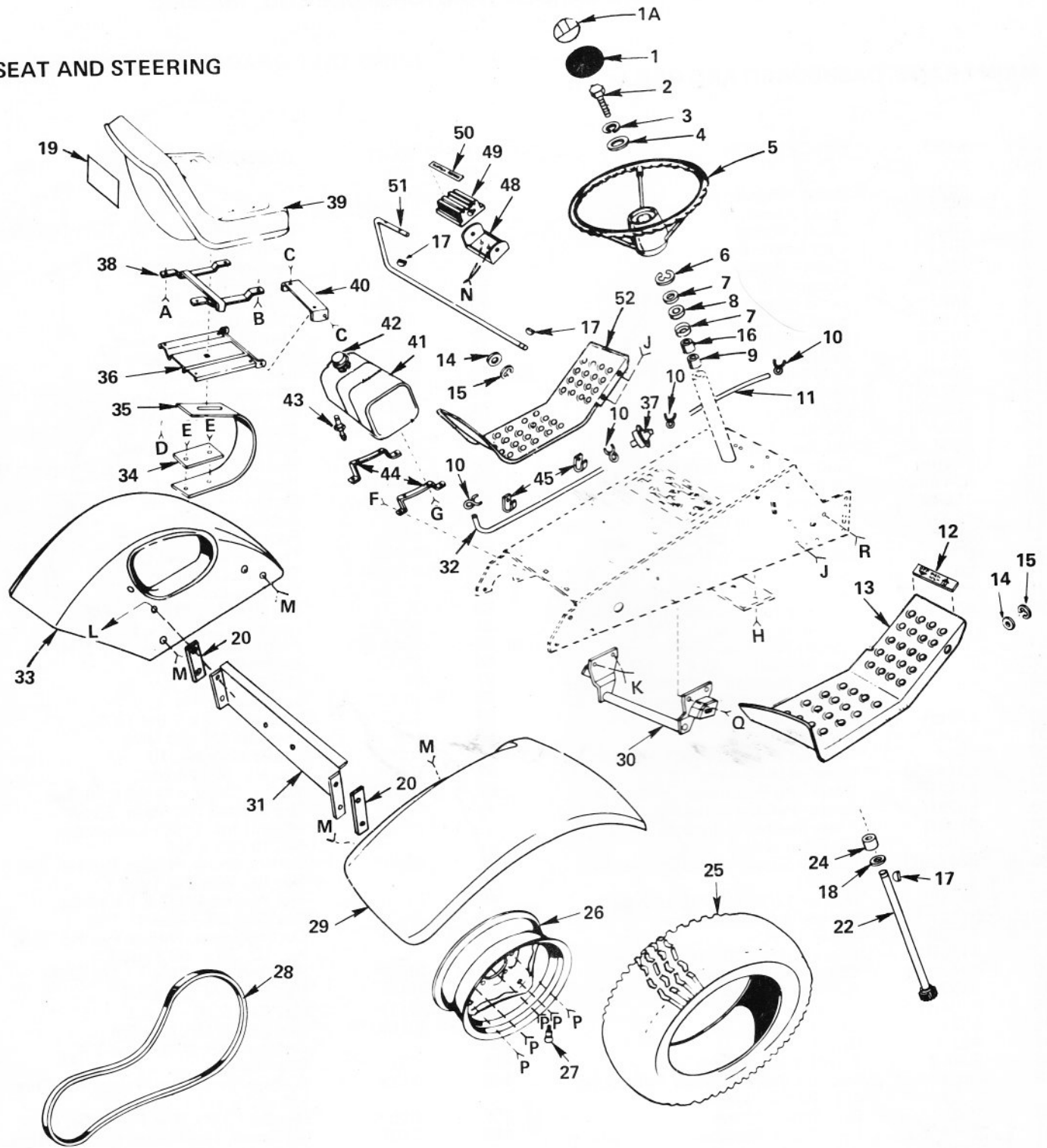
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
3	8028R	Decal - Maintenance	61	B48M-GA018/	
4	634A907	Hood Assembly	62	3475A	Engine, Onan 18 H.P. Twin Cylinder
5	9880R	Decal - Wiring	63	106J	Battery Support
6	291J	Grill Panel - Lower	64	906J	Battery Support Bracket - L.H.
7	245J	Decal - Roper	65	8855R	Battery Tray
8	911J	Upper Grill	66	9860R	Decal - Lower Dash
9	246J	Decal - Roper	67	2754R	Choke Control
10	1181J	Rectifier Bracket	68	1520J	Throttle Control Lever
11	7937R	Lower Grill	69	9776H	Choke Control Clip
12	7938R	Grill Side	70	9859R	Decal - Upper Dash
13	2674R	Grill Screen - L.H.	71	5123R	Dashboard
14	2673R	Grill Screen - R.H.	72	634A901	Pedal Weldment P.T.O.
15	8058R	Grill Cable	73	634A930	Lever Weldment
16	104J	Muffler - Front	74	503P	*Hex Nut 1/4 - 20 UNC
17	105J	Muffler - Rear	75	91J	Pivot Spacer
18	7810H	Gripco Centerlock Nut 3/8 - 24 UNF	76	7874R	Hood Seal
19	634A494	Hanger Weldment - R.H., Front	77	9687R	Battery Heat Shield
20	1689E	Bushing	78	93J	Rubber Pedal
21	1003P	*Lockwasher 5/16	79	267J	Foot Pedal
22	504P	*Hex Nut 5/16 - 18 UNC	80	1515J	Throttle Wire and Casing
23	878J	Gasket - Exhaust Manifold	81	8204R	Throttle Clamp
24	89J	Link	82	1516J	Throttle Control
25	634A492	Switch Bracket Assembly	83	3027P	*Hex Bolt 3/8 - 16 x 1 - 1/2
26	634A491	Belt Tightener Arm and Idler Shaft Assembly	84	3023P	*Hex Bolt 3/8 - 16 x 1
27	92J	Speed - Nut/Push-on	85	634A355	Front Hanger Weldment - L.H.
28	3013P	*Hex Bolt 5/16 - 18 x 1 - 1/2	86	2506P	Cotter Pin 1/8 x 1
29	634A934	Chassis Assembly with Bearings (Inc. Key No. s. 9 and 24, page 16)	87	86J	Cover - L.H.
30	5080R	U-Bolt - Axle Clamp	88	1002P	*Lockwasher 1/4
31	1004P	*Lockwasher 3/8	89	1506P	*Washer 9/32 x 5/8 x 16 Ga.
32	501P	*Hex Nut 3/8 - 16 UNC	90	1605H	Locknut 1/4 - 20 UNC
33	634A638	Drawbar Weldment	91	1006P	*Lockwasher No. 10
34	6143R	Decal - By-Pass Valve	92	505P	*Nut No. 10 - 24 UNC
35	5628R	Decal - Parking Brake	93	1537P	*Washer 11/32 x 11/16 x 16 Ga.
36	5109R	Filter Mounting Bracket	94	6055P	Hex Slotted Hd. Mach. Screw w/Sems Int. Tooth Lockwasher No. 10 - 32 x 1/4
37	6204R	Oil Filter Shield	95	5564P	*Cutting Screw, Phillips Pan Hd. Thd. No. 10 - 24 x 1/2 Type T
38	634A903	Battery Support Bracket (Inc. Key No. 59)	96	1545P	Flat Washer 17/32 x 1 x 16 Ga.
39	1513P	*Washer 13/32 x 13/16 x 16 Ga.	97	3025P	*Hex Bolt 3/8 - 16 x 1 - 1/4
40	811J	Neutral Adjustment Cover	98	5501P	*Cutting Screw, Phillips Pan Hd. Thd. No. 10 - 24 x 3/8 Type T
41	7729R	Cover - R.H.	99	3267P	*Hex Bolt 1/4 - 20 x 1 - 1/2 Gr. 5
42	8115R	Retainer Nut 3/8 - 16 UNC	100	3114P	*Hex Bolt 1/4 - 20 x 1/2
43	634A884	Engine Mount Assembly	102	3011P	*Hex Bolt 5/16 - 18 x 1
44	4939M	Retainer Spring	103	3010P	*Hex Bolt 5/16 - 18 x 3/4
45	8704H1	Spacer	104	5P	*Carriage Bolt 5/16 - 18 x 3/4
46	5621R	Belt Retainer	105	879J	Clip - Cable
47	96J	Grill Spacer	106	5557P	Cutting Screw, Hex Washer Hd. Thrd. 1/4 - 20 x 1/2 Type 1
48	8245R	Belt Retainer Finger	107	3025P	*Hex Bolt 3/8 - 16 x 1 - 1/4 Gr. 5
49	3154P	Machine Screw, Slotted Fillister Hd. 1/4 - 20 x 2 - 1/4	108	4540P	Set Screw, Hex Forged Socket Hdless. 5/16 - 18 x 1/2
50	290J	Grill Panel - Upper	109	50P	Carriage Bolt 3/8 - 16 x 2 - 1/4
51	634A663	Belt Guard Weldment	110	53P	Carriage Bolt No. 10 - 24 x 1/2
52	8238H	Split Spacer	111	5394H	Locknut 3/8 - 16 UNC
53	347H	Huglock Nut 1/4 - 20 UNC	112	1535P	Washer 7/32 x 7/16 x 18 Ga.
54	634A662	Belt Guide Weldment	113	3003P	*Hex Bolt 1/4 - 20 x 3/4
55	634A665	Engine Pulley (Inc. Key No. 108)	114	5592P	Sl. Pan Hd. Tap Screw No. 8 x 3/4
56	9396E	Square Key 1/4 x 2	115	1557P	Washer 13/32 x 13/16 x 11 Ga.
57	875J	Grill Brace	116	3159P	*Hex Bolt 5/16 - 18 x 7/8
58	302J	Wire Guard	117	7948R	Return Spring
59	7756R	Idler Bearing	118	3366P	Socket Hd. Cap Screw 5/16 - 18 x 3/4
60	8006R	Idler Shaft Cap			
60A	1308J	Decal			

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

SEAT AND STEERING



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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

SEAT AND STEERING

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	9719R	Steering Wheel Insert	41	2693R	Fuel Tank
1A	235J	Decal - Roper	42	7293R	Fuel Gauge
2	3023P	*Hex Bolt 3/8 - 16 x 1	43	815R	Fuel Line Fitting
3	1004P	*Lockwasher 3/8	44	2650R	Bracket - Fuel Tank
4	1559P	Washer 7/16 x 1 x 10 Ga.	45	2751R	Clip - Fuel Line
5	3644R	Steering Wheel	48	8765H	Foot Pedal Bracket
6	5003P	E-Ring	49	8882R	Foot Pedal
7	9007H	Cap	50	8899R	Insert-Clutch-Brake
8	5949H	Rubber Bushing	51	940J	Foot Pedal Shaft
9	6468H	Bearing	52	8178R	Foot Rest - L.H.
10	6999R	Clamp - Fuel Line	53	1003P	*Lockwasher 5/16
11	7833R	Fuel Line (Short)	54	5394H	*Locknut 3/8 - 16 UNC
12	8900R	Decal (Attach. Clutch)	55	1578P	Washer 3/4 x 1 - 1/8 x 11 Ga.
13	7904R	Foot Rest - R.H.	56	1560P	Washer 17/32 x 1 - 1/2 x 11 Ga.
14	1527P	Washer 21/32 x 7/8 x 16 Ga.	57	1000P	*Lockwasher 1/2
15	5001P	E-Ring	58	502P	*Hex Nut 1/2 - 13 UNC
16	7895R	Steering Shaft Spacer	59	501P	*Hex Nut 3/8 - 16 UNC
17	9858M1	Woodruff Key 3/16 x 5/8	60	504P	*Hex Nut 5/16 - 18 UNC
18	1553P	Washer 57/64 x 1 - 1/4 x 16 Ga.	61	1002P	*Lockwasher 1/4
19	245J	Decal - Roper	62	1513P	*Washer 13/32 x 13/16 x 16 Ga.
20	1165J	Spacer - Taillight Bracket	63	1506P	*Washer 9/32 x 5/8 x 16 Ga.
21	1557P	Washer 13/32 x 13/16 x 11 Ga.	64	503P	*Hex Nut 1/4 - 20 UNC
22	634A775	Steering Shaft & Pinion	66	3003P	*Hex Bolt 1/4 - 20 x 3/4
23	1519P	Washer 15/32 x 1 x 12 Ga.	67	3010P	*Hex Bolt 5/16 - 18 x 3/4
24	4766H	Bearing	68	3159P	*Hex Bolt 5/16 - 18 x 7/8
25	4607R	Rear Tire - Tubeless 23 x 10.00 - 12	69	3022P	Hex Bolt 3/8 - 16 x 7/8 Gr. 5
26	3635R	Rear Wheel	70	52P	Carriage Bolt 1/2 - 13 x 1 - 1/4 Gr. 5
27	795R	Tire Valve	71	61P	Sq. Nk. Carriage Bolt 3/8 - 16 x 1 Gr. 5
*28	5125R	V-Belt (Ground Drive)	72	17P	*Carriage Bolt 5/16 - 18 x 1
29	9428R	Fender - R.H.	75	3025P	*Hex Bolt 3/8 - 16 x 1 - 1/4
30	634A814	Hanger Weldment - Rear	76	3023P	*Hex Bolt 3/8 - 16 x 1
31	2656R	Bracket - Taillight	77	3004P	*Hex Bolt 1/4 - 20 x 1
32	8545R	Fuel Line (Long)	78	3021P	*Hex Bolt 3/8 - 16 x 3/4
33	8177R	Fender - L.H.	79	5137R	Lug Nut
34	8141H	Seat Spring Reinforcement	80	3027P	*Hex Bolt 3/8 - 16 x 1-1/2
35	5404R	Seat Spring	81	1537P	*Washer 11/32 x 11/16 x 16 Ga.
36	634A533	Seat Plate Weldment	----	2557R	Grease Cartridge Amdex No. 1 E.P. (Not furnished with your Tractor)
37	266J	Fuel Line Filter	----	1198J	Warranty Tag
38	634A532	Seat Bracket Weldment	----	1197J	Owners Manual
39	9744R	Seat			
40	2663R	Bracket Seat Pivot			

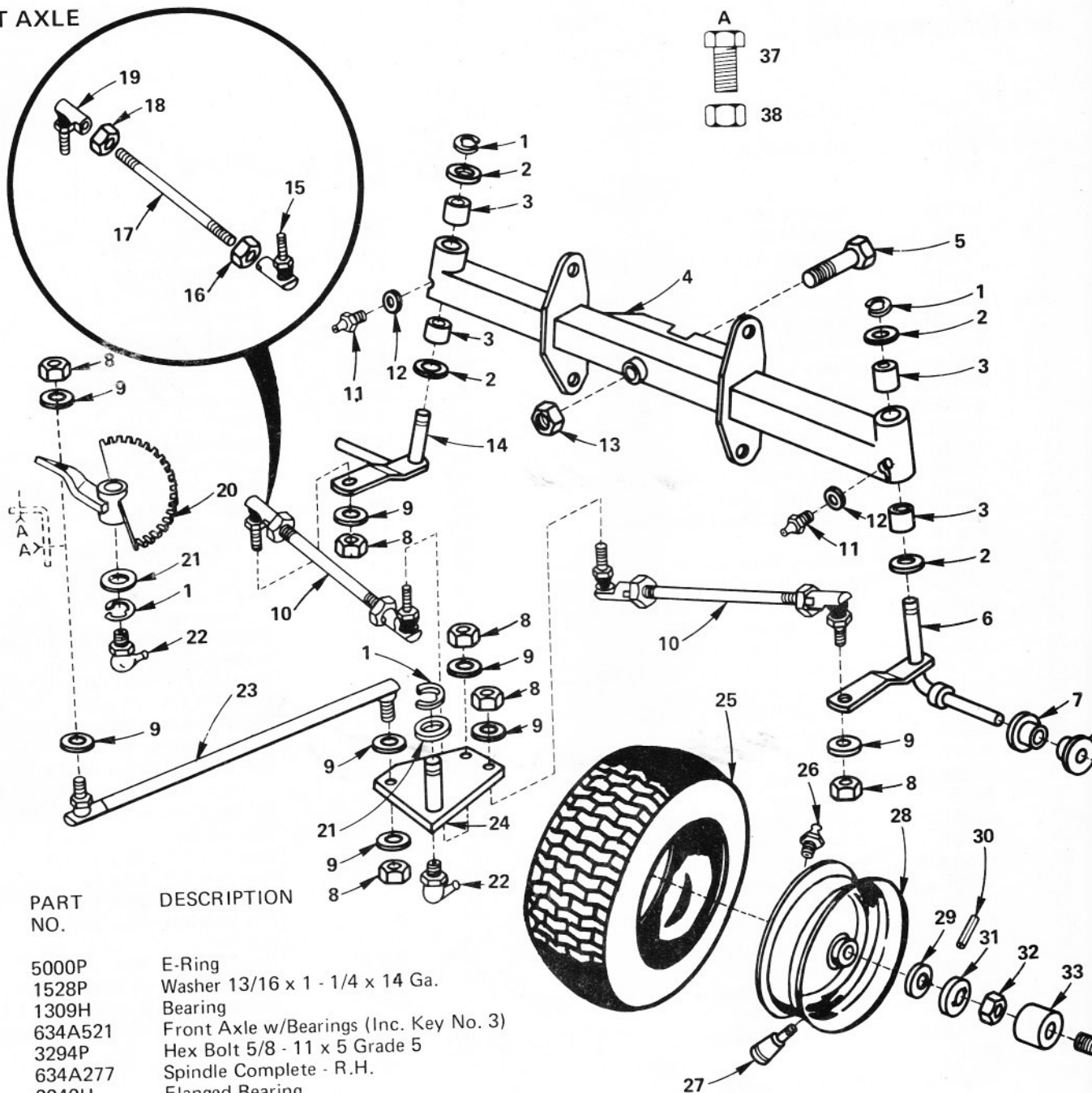
*STANDARD HARDWARE--PURCHASE LOCALLY

* DAYCO BELT # L468
1/2" X 68"

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

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 UNF
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 - Tubeless 16 x 6.50 - 8

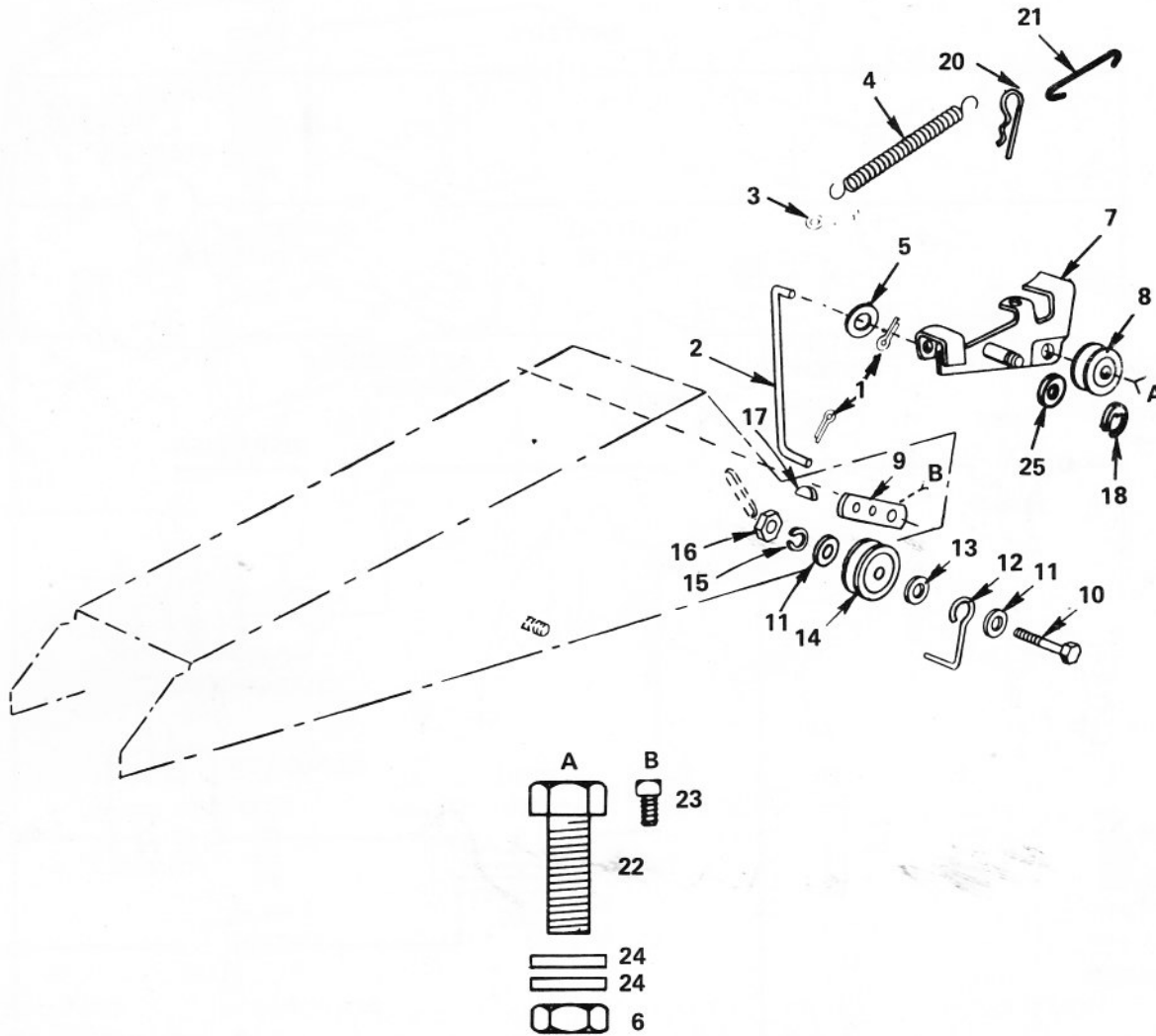
KEY NO.	PART NO.	DESCRIPTION
26	6856M	Grease Fitting 1/4 - 28 Taper Thrd.
27	795R	Tire Valve
28	3636R	Front Wheel (Inc. Key No's. 7 & 26)
29	1562P	Washer 25/32 x 1 - 1/2 x 16 Ga.
30	8798H	Roll Pin 5/32 x 1
31	8785H	Wear Washer
32	4831H	Elastic Nut 3/4 - 16 UNF
33	8763H	Dust Cap - Outer
34	3008P	*Hex Bolt 5/16 - 18 x 1/2
37	3052P	*Hex Bolt 3/8 - 24 x 1
38	548P	*Hex Jam 3/8 - 24 UNF Locknut

*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

CLUTCH



KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	2505P	Cotter Pin 1/8 x 3/4	13	1520P	Washer .469 I.D. x 1 - 1/8 x 11 Ga.
2	9288R	Clutch Rod	14	5616R	Flat Idler
3	2514P	Cotter Pin 1/4 x 1	15	1001P	*Lockwasher 7/16
4	6486H	Spring	16	500P	*Hex Nut 7/16 - 14 UNC
5	1513P	*Washer 13/32 x 13/16 x 16 Ga.	17	9858M1	Woodruff Key 3/16 x 5/8
6	7810H	Locknut 3/8 - 24 UNF	18	5002P	E-Ring
7	634A754	Idler Bracket Weldment	20	4939M	Retainer Spring
8	6636H	Idler	21	8254R	Retainer Spring
9	626A31A	Steering Arm Assembly	22	3052P	*Hex Bolt 3/8 - 24 x 1
10	3262P	Hex Bolt 7/16 - 14 x 2 - 1/2	23	4501P	Sq. Hd. Set Screw C.P. 5/16 - 18 x 1/2
11	1518P	Washer 15/32 x 11/16 x 16 Ga.	24	1545P	Washer 17/32 x 1 x 16 Ga.
12	5892R	Belt Guide Finger	25	1587P	Washer 17/32 x 1 - 1/16 x 21 Ga.

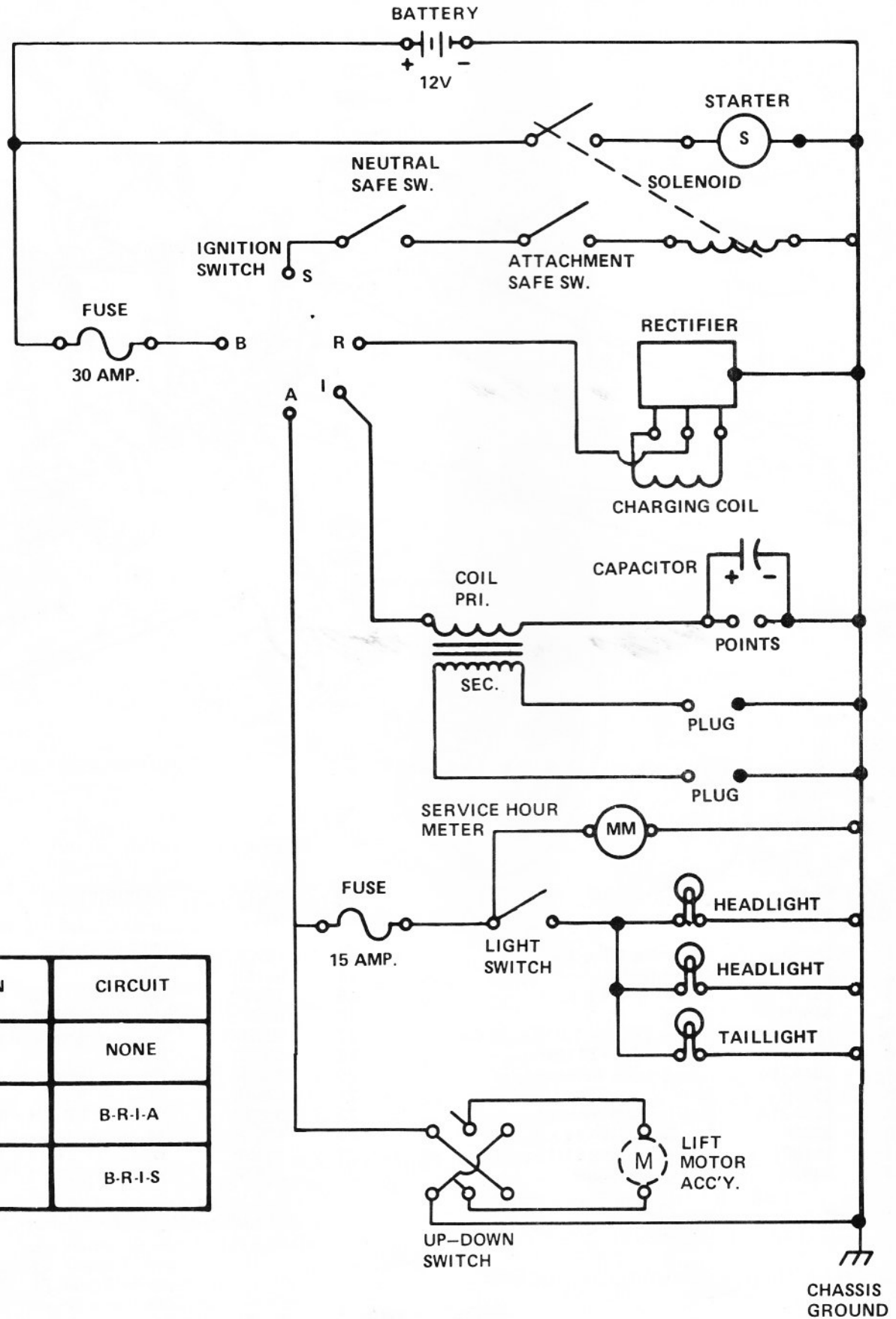
*STANDARD HARDWARE--PURCHASE LOCALLY

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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

SCHEMATIC DIAGRAM

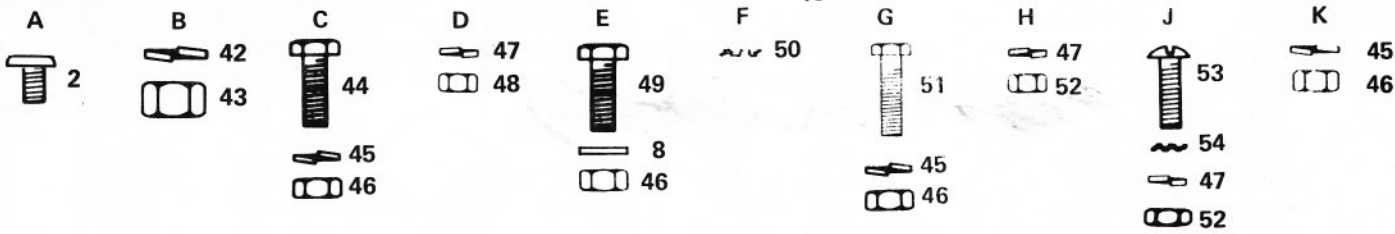
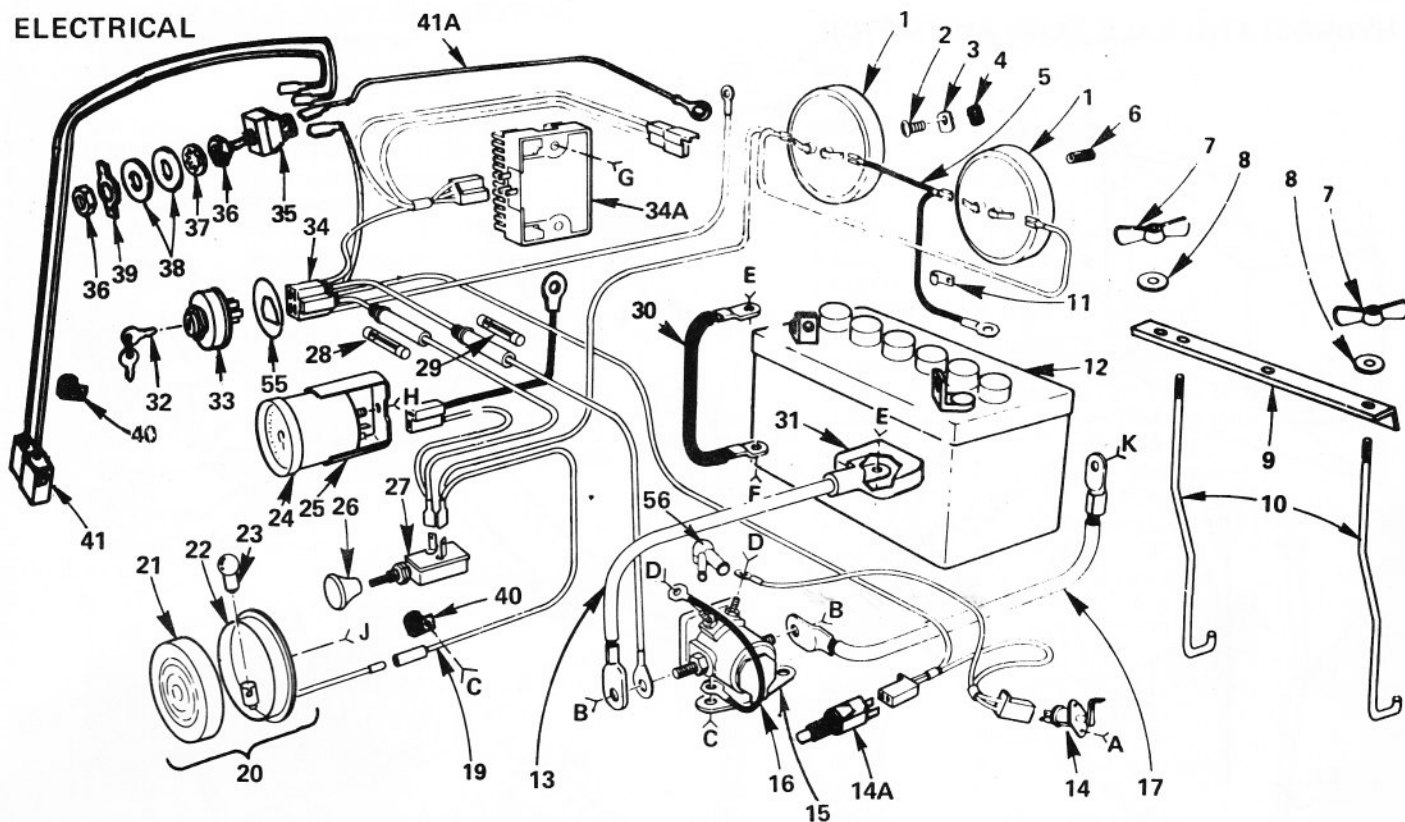


POSITION	CIRCUIT
OFF	NONE
RUN	B-R-I-A
START	B-R-I-S

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

ELECTRICAL



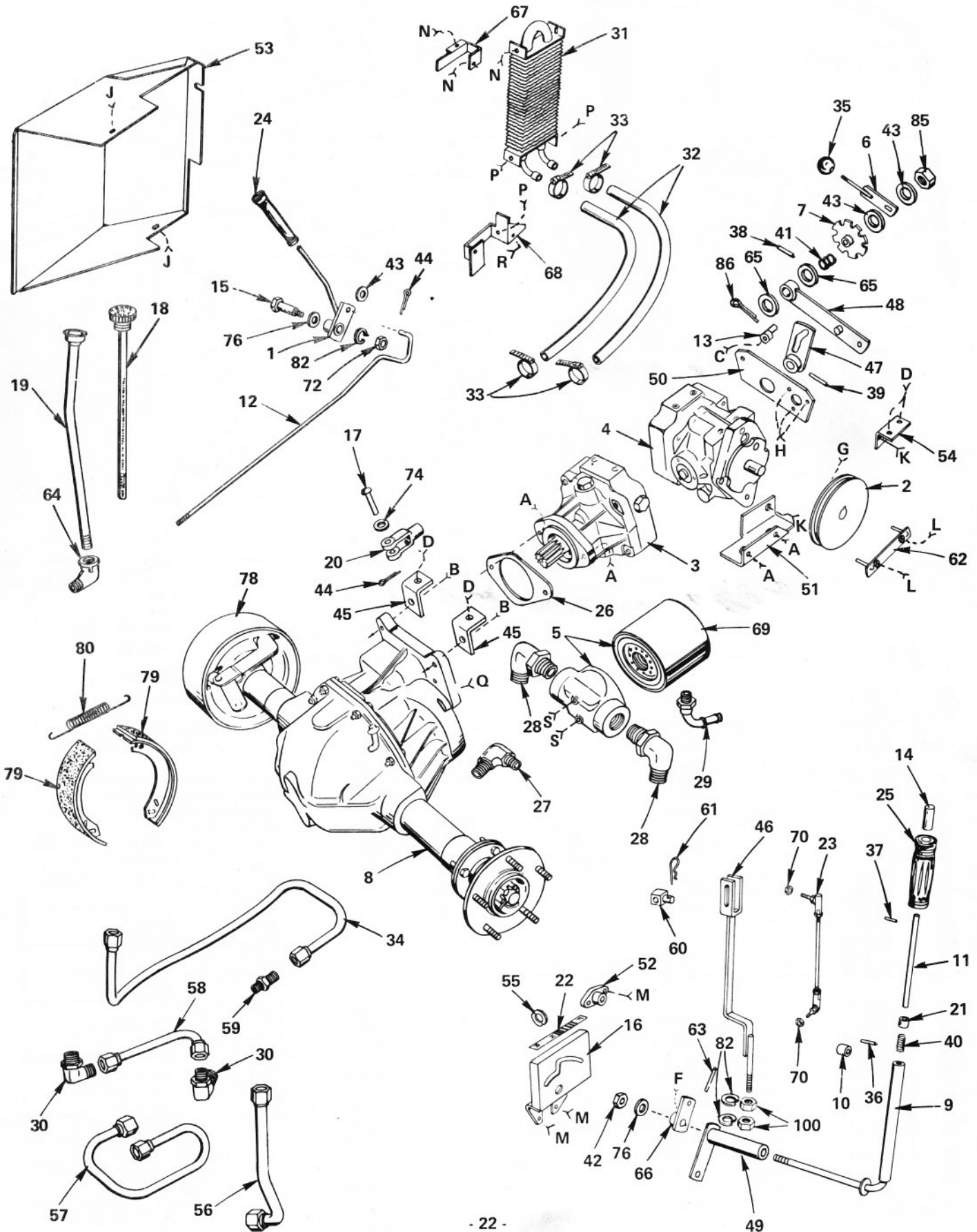
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	6452R	Headlight	30	2753R	Battery Cable - Ground
2	5501P	*Phillips Pan Hd. Thd. Cutting Screw 10 - 24 x 3/8 Type T	31	225J	Terminal Cover - Battery
3	8768H	Mounting Clip	32	7552H	Key Set
4	8784H1	Rubber Spacer	33	2683R	Ignition Switch (Inc. Key No. 32)
5	8031R	Headlight Ground Wire	34	9854R	Main Harness - Ignition
6	9197H	Hose	34A	7753R	Regulator - Rectifier
7	3748M	Wing Nut 1/4 - 20	35	8984R	Switch, Elec. Lift
8	1506P	*Washer 9/32 x 5/8 x 16 Ga.	36	566P	Hex Nut, Steel 7/16 - 32 NS - 2A
9	9400R	Battery Clamp	37	7319R	Lockwasher, Internal Tooth
10	2685R	Battery Bolt	38	1518P	Washer 15/32 x 11/16 x 16 Ga.
11	4171R	Clip - Insulated	39	9349R	Switch Plate
12	226J	Battery	40	5320R	Clip, Wire
13	2235R	Cable - Battery	41	8985R	Lift Motor Harness
14	2249R	Safety Switch (Attachment Clutch)	41A	9698R	Wire, Ground Lift Switch
14A	3249R	Safety Switch (Hydro Drive Control Lever)	42	1003P	*Lockwasher 5/16
15	7754R	Solenoid	43	538P	*Hex Jam Nut 5/16 - 24 UNF
16	8027R	Wire - Ground to Solenoid	44	3115P	*Hex Bolt 1/4 - 20 x 5/8
17	2226R	Cable-Solenoid to Starter	45	1002P	*Lockwasher 1/4
19	8030R	Light Harness	46	503P	*Hex Nut 1/4 - 20 UNC
20	8089H	Taillight (Inc. Key No. 21, 22, 23)	47	1006P	*Lockwasher No. 10
21	8292H	Lens - Taillight	48	543P	*Hex Nut No. 10 - 32 UNF
22	8293H	Housing - Taillight	49	3003P	*Hex Bolt 1/4 - 20 x 3/4
23	8291H	Bulb No. 1895 2 Candle Power	50	1402P	Ext. Tooth Lockwasher 3/8
24	7763R	Service Hour Meter	51	3295P	*Hex Bolt 1/4 - 20 x 7/8
25	8066R	Service Hour Meter Bracket	52	505P	*Hex Nut No. 10 - 24 UNC
26	7794R	Light Switch Knob	53	3357P	*Slotted Truss Hd. Machine Screw 10 - 24 x 1/2
27	7793R	Light Switch	54	1404P	Ext. Tooth Lockwasher No. 10
28	2212R	Fuse - 15 Amp.	55	8656R	Terminal Tag
29	6347R	Fuse - 30 Amp.	56	51J	Terminal Cover - Solenoid
					*STANDARD HARDWARE--PURCHASE LOCALLY

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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

HYDROSTATIC AXLE, PUMP AND MOTOR



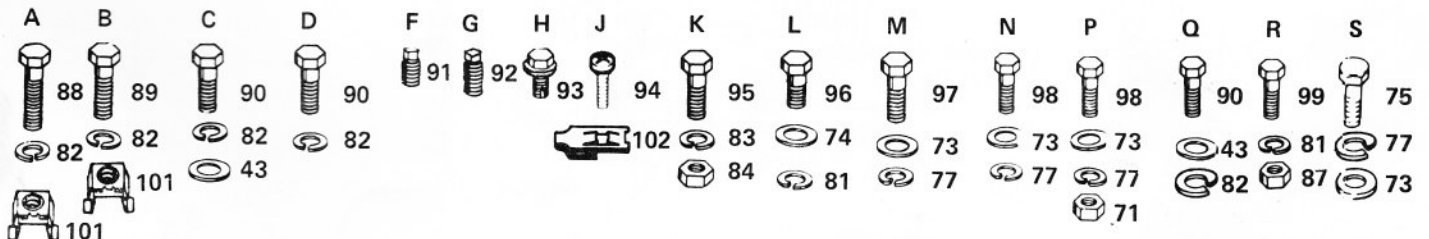
REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

* NAPA COLD 1551 HYDR. FILT.

HYDROSTATIC AXLE, PUMP AND MOTOR

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	634A640	Parking Brake Handle Weldment	55	5999H	Spring Washer
2	634A652	Pump Pulley with Set Screw	56	5133R	Suction Line
3	634A655	Hydrostatic Motor	57	5130R	Pressure Line No. 1
4	634A656	Hydrostatic Pump	58	5131R	Pressure Line No. 2
5	634A657	Filter Assembly (Inc. Key No. 69)	59	5128R	Straight Connector "O" Ring to Flare
6	634A668	By-Pass Valve Handle Weldment	60	9420H	Leveling Pin
7	634A669	Rotating Plate Weldment	61	4940M	Retainer Spring
8	668A12	Axle Assembly (Inc. Key No. 78)	62	634A646	Belt Guide Weldment
9	634A678	Control Lever Weldment	63	8120H	Coil Spring Pin
10	5868R	Quadrant Bushing	64	4012P	Street Elbow 90°
11	5864R	Lever Plunger	65	1527P	Washer 21/32 x 7/8 x 16 Ga.
12	5082R	Brake Rod	66	634A677	Control Arm (Ret. to Neut.) Weldment
13	5863R	Pivot Pin Cam Follower	67	634A671	Filter Top Weldment
14	5265R	Plunger Button	68	634A672	Filter Bottom Weldment
15	5093R	Parking Brake Pivot Pin	*69	5276R	Cartridge for Filter Assembly
16	634A679	Quadrant Weldment	70	5886R	Center Locknut 5/16 - 24 UNF
17	5120R	Clevis Pin	71	503P	*Hex Nut 1/4 - 20 UNC
18	5136R	Transmission Cap and Dipstick Ass'y.	72	7810H	Locknut 3/8 - 24 UNF
19	5135R	Transmission Oil Filler Tube Ass'y.	73	1506P	*Washer 9/32 x 5/8 x 16 Ga.
20	5122R	Yoke	74	1537P	*Washer 11/32 x 11/16 x 16 Ga.
21	5266R	Lever Plunger Guide	75	3003P	*Hex Bolt 1/4 - 20 UNC x 3/4
22	5329R	Decal - Quadrant	76	1545P	Washer 17/32 x 1 x 16 Ga.
23	5879R	Connector Link and Joints	77	1002P	*Lockwasher 1/4
24	4379H	Handle Grip	78	7303R	Brake Assembly
25	781J	Handle Grip	79	7304R	Brake Shoe and Lining
26	5273R	Gasket	80	7305R	Spring
27	5275R	Male 90° Elbow NPT to Flare	81	1003P	*Lockwasher 5/16
28	5274R	90° Elbow "O" Ring to Flare	82	1004P	*Lockwasher 3/8
29	5764R	"O" Ring to Hose Elbow	83	1000P	*Lockwasher 1/2
30	5127R	90° Elbow "O" Ring to Flare	84	502P	*Hex Nut 1/2 - 13 UNC
31	5760R	Oil Cooler	85	552P	*Locknut 3/8 - 16 UNC
32	5765R	Hydro Hose	86	2506P	*Cotter Pin 1/8 x 1
33	5766R	Hose Clamp	87	504P	*Hex Nut 5/16 - 18 UNC
34	5134R	Suction Line	88	3025P	*Hex Bolt 3/8 - 16 UNC x 1 - 1/4
35	7987R	Control Knob	89	3023P	*Hex Bolt 3/8 - 16 UNC x 1
36	5142H	Roll Pin	90	3022P	Hex Bolt 3/8 - 16 UNC x 7/8
37	1364H	Roll Pin	91	4501P	Set Screw, Sq. Hd. - C.P. 5/16 - 18 UNC x 1/2
38	175H	Roll Pin	92	4503P	Set Screw, Square Head C.P. 5/16 - 18 UNC x 5/8
39	6207R	Groove Pin	93	5584P	Cutting Screw, Hex Washer Hd. Thrd. 1/4 - 20 UNC x 3/4 Type T
40	2876H	Spring	94	3253P	Mach. Screw, Pan Hd. Phillips 1/4 - 20 UNC x 1/2
41	5280R	Spring	95	3000P	*Hex Bolt 1/2 - 13 UNC x 1 - 1/2
42	9204H	Locknut 1/2 - 20 UNF	96	3010P	*Hex Bolt 5/16 - 18 UNC x 3/4
43	1513P	*Washer 13/32 x 13/16 x 16 Ga.	97	3116P	*Hex Bolt 1/4 - 20 UNC x 7/8 Gr. 5
44	2505P	Cotter Pin 1/8 x 3/4	98	3115P	*Hex Bolt 1/4 - 20 UNC x 5/8
45	8103R	Mounting Tab (Axle)	99	3012P	*Hex Bolt 5/16 - 18 UNC x 1 - 1/4
46	634A674	Conn. Rod (Ret. to Neut.) Weldment	100	501P	*Hex Nut 3/8 - 16 UNC
47	634A675	Cam Weldment	101	8115R	Nut Retainer
48	634A676	Cam Follower Weldment	102	3531R	"J" Clip
49	634A673	Directional Arm Weldment			*STANDARD HARDWARE--PURCHASE LOCALLY
50	5878R	Cam Follower Support			
51	8102R	Bottom Pump Bracket			
52	5272R	Lever Support			
53	634A972	Oil Cooler Air Shield Assembly			
54	634A647	Top Pump Bracket Weldment			

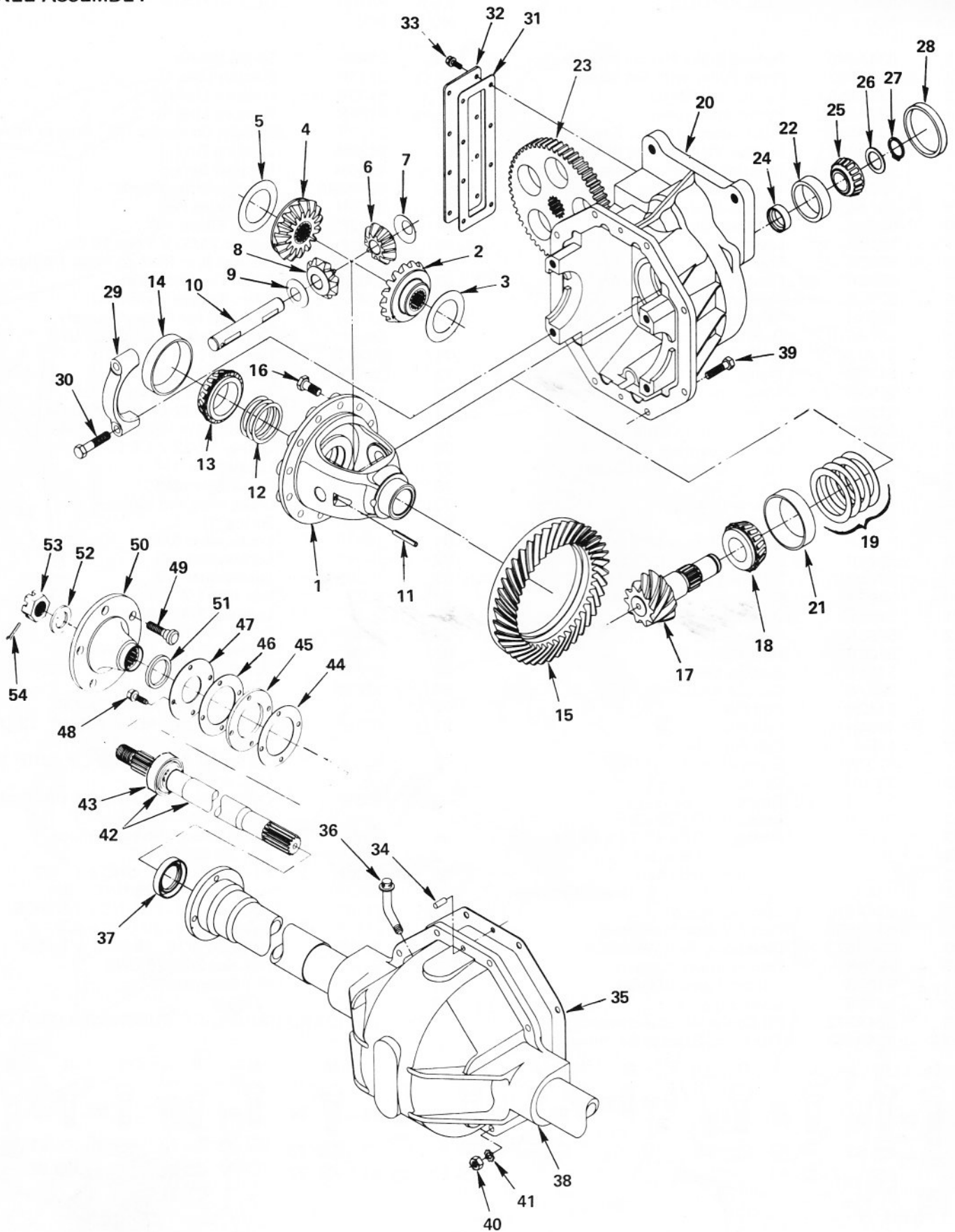


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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

AXLE ASSEMBLY



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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

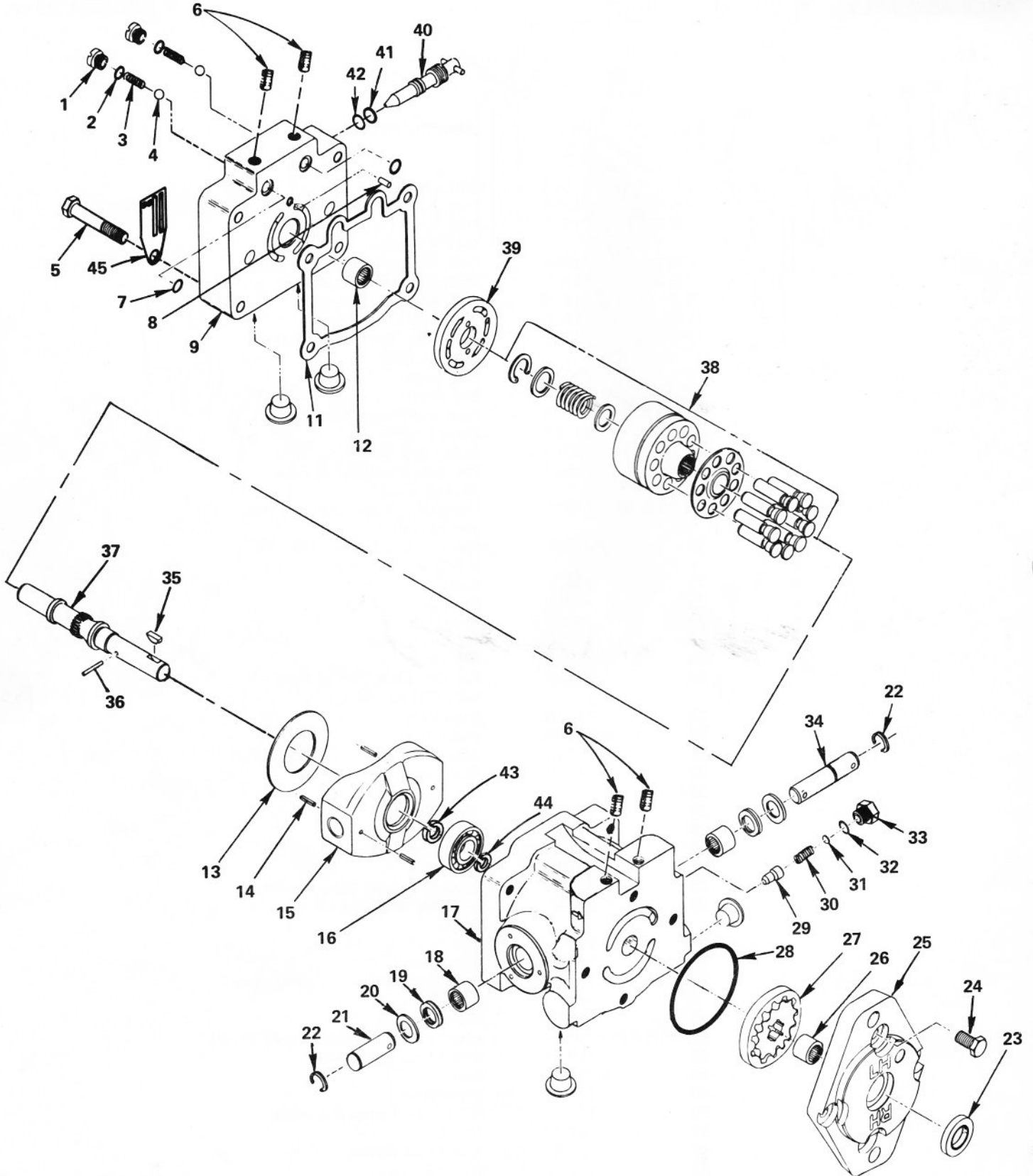
AXLE ASSEMBLY

KEY NO.	PART NO.	DESCRIPTION
1	7164R	Diff. Case
2 & 4	7165R	Diff. Gear (Set of Two)
3 & 5	7169R	Diff. Gear Thrust Washer (Set of Two)
6 & 8	7166R	Diff. Pinion Mate (Set of Two)
7 & 9	7170R	Diff. Pinion Thrust Washer
10	7167R	Diff. Shaft (Pin. Mate)
11	7168R	Diff. Shaft Lock Pin
12	7202R	Diff. Adj. Shim (Set of Four .003 to .030)
13	7207R	Brg. Cone
14	7206R	Brg. Cup
15 & 17	7171R	Gear and Pinion Assembly
16	7172R	Drive Screw
18	7201R	Roller Brg. Cone
19	7196R	Pin. Brg. Shim (Set of Four .003 to .030)
20, 29 & 30	7173R	Upper Hsg. Sub. Assembly (Inc. Key No. 30)
30	3299P	Hex Hd. Cap Screw 7/16 - 14 N.F.C. x 2 Grade 5
21	7200R	Roller Brg. Cup
22	7194R	Brg. Cup
23	7208R	Spur Gear
24	7195R	Pin Brg. Spacer
25	7193R	Brg. Cone
26	7179R	Pin. Brg. Shim (Set of Four - teen .031 to .057)
27	7178R	Snap Ring
28	7177R	Welch Plug
31	7174R	Gear Cover Gasket
32	7175R	Gear Cover
33	7176R	Hex Tap Screw
34	7217R	Dowel Pin
35	7210R	Housing Gasket
36	7214R	Vent Tube Assembly
37	7219R	Oil Seal
38	7215R	Lower Hsg. and Tube Assembly
39	3303P	Hex Bolt 5/16 - 24 NF x 1 - 1/4 Grade 5
40	519P	Hex Nut 5/16 - 24 NF
41	1003P	Lockwasher 5/16
42 & 43	7209R	Axle Shaft and Bearing (Inc. Key No. 43)
43	7211R	Wheel Bearing
44, 46 & 47	7180R	Wheel Bearing Gasket (Set of Three)
45	7181R	Wheel Bearing Retainer
48	7213R	Bolt
49	7216R	Wheel Bolt
50	7212R	Axle Shaft Flange Assembly
51	7218R	Felt Seal
52	7220R	Wheel End Washer
53	7221R	Wheel End Nut
54	7222R	Wheel End Cotter Pin

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

HYDROSTATIC PUMP ASSEMBLY--MODEL NO'S. 15-2023 AND 15-2084



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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

HYDROSTATIC PUMP ASSEMBLY--MODEL NO'S. 15-2023 AND 15-2084

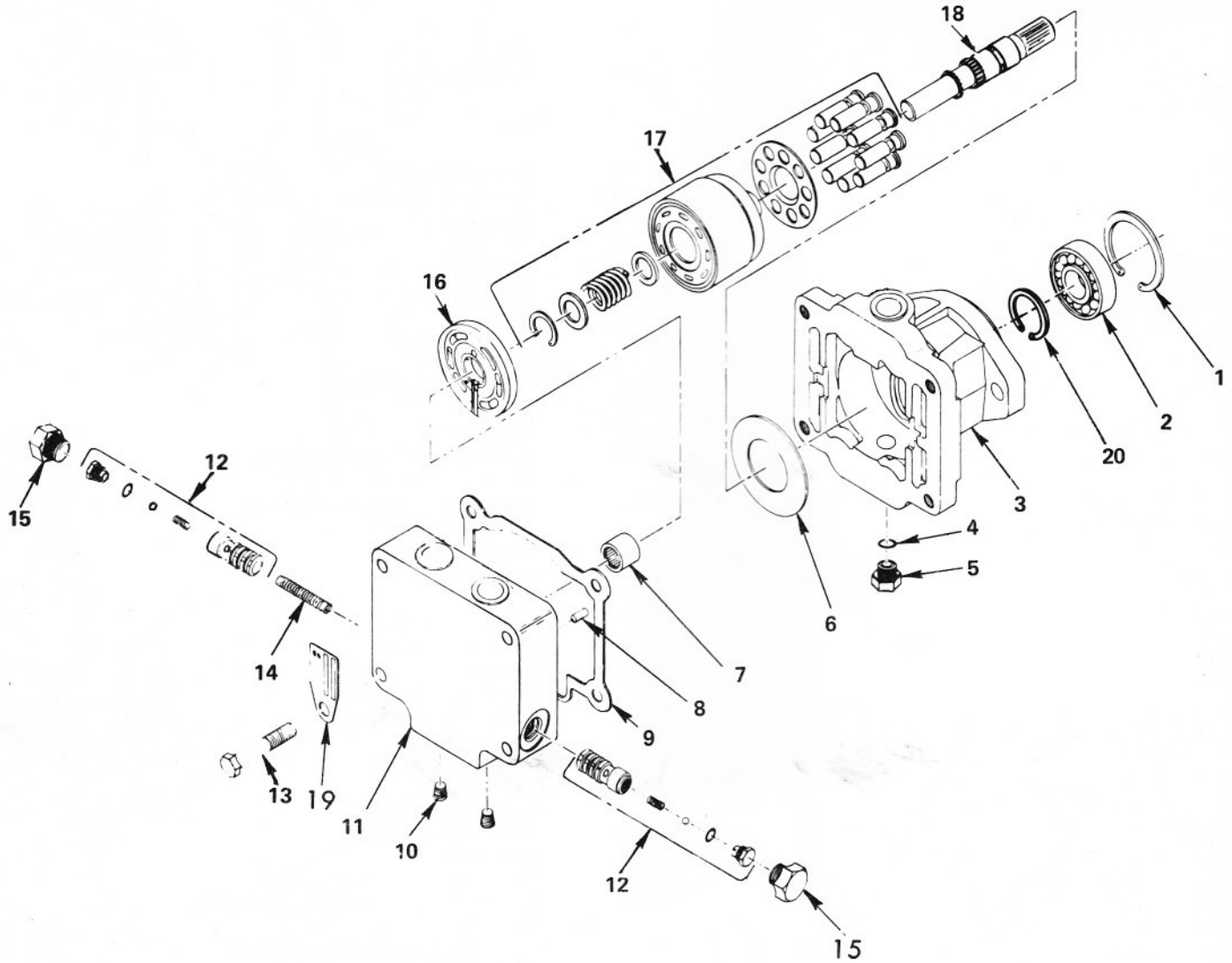
KEY NO.	PART NO.	DESCRIPTION
1,2,3 AND4	7223R	Check Valve Kit
5	7224R	Hex Head Cap Screw
6	7273R	Pipe Plug
7	7226R	"O" Ring
8	7227R	Headless Str. Pin
9	7228R	End Cap
11	7229R	Gasket
12	7230R	Needle Bearing
13	7231R	Thrust Plate
14	7232R	Coiled Spring Pin
15	7233R	Swashplate
16	7234R	Ball Bearing
17	1601J	Housing (For Pump Model No. 15 - 2084 ONLY)
17	7235R	Housing (For Pump Model No. 15 - 2023 ONLY)
18	7236R	Needle Bearing
19	7237R	Lip Seal
20	7238R	Washer
21	7239R	Trunnion Shaft
22	7240R	Retaining Ring
23	7241R	Lip Seal
24	7242R	Hex Head Cap Screw
25	7243R	Charge Pump Housing
26	7244R	Needle Bearing
27	7245R	Gerotor Assembly
28	7246R	"O" Ring
29	7247R	Relief Valve Cone
30	7248R	Relief Valve Spring
31	7249R	Shim Pack
32	7250R	"O" Ring
33	1603J	Hex Head Plug (For Pump Model No. 15 - 2084 ONLY)
33	7251R	Hex Head Plug (For Pump Model No. 15 - 2023 ONLY)
34	7252R	Control Shaft
35	7253R	Woodruff Key
36	7254R	Head Str. Pin
37	1602J	Shaft (For Pump Model No. 15 - 2084 ONLY)
37	7255R	Shaft (For Pump Model No. 15 - 2023 ONLY)
38	7256R	Cyl. Block Kit
39	7257R	Valve Plate
40	7258R	By-Pass Valve
41	7259R	Back-Up Ring
42	7260R	"O" Ring
43	1604J	Retaining Ring (For Pump Model No. 15 - 2084 ONLY)
44	1605J	Retaining Ring (For Pump Model No. 15 - 2084 ONLY)
45	-----	Model Plate
----	634A656	Complete Pump Assembly

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REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR

HYDROSTATIC MOTOR ASSEMBLY



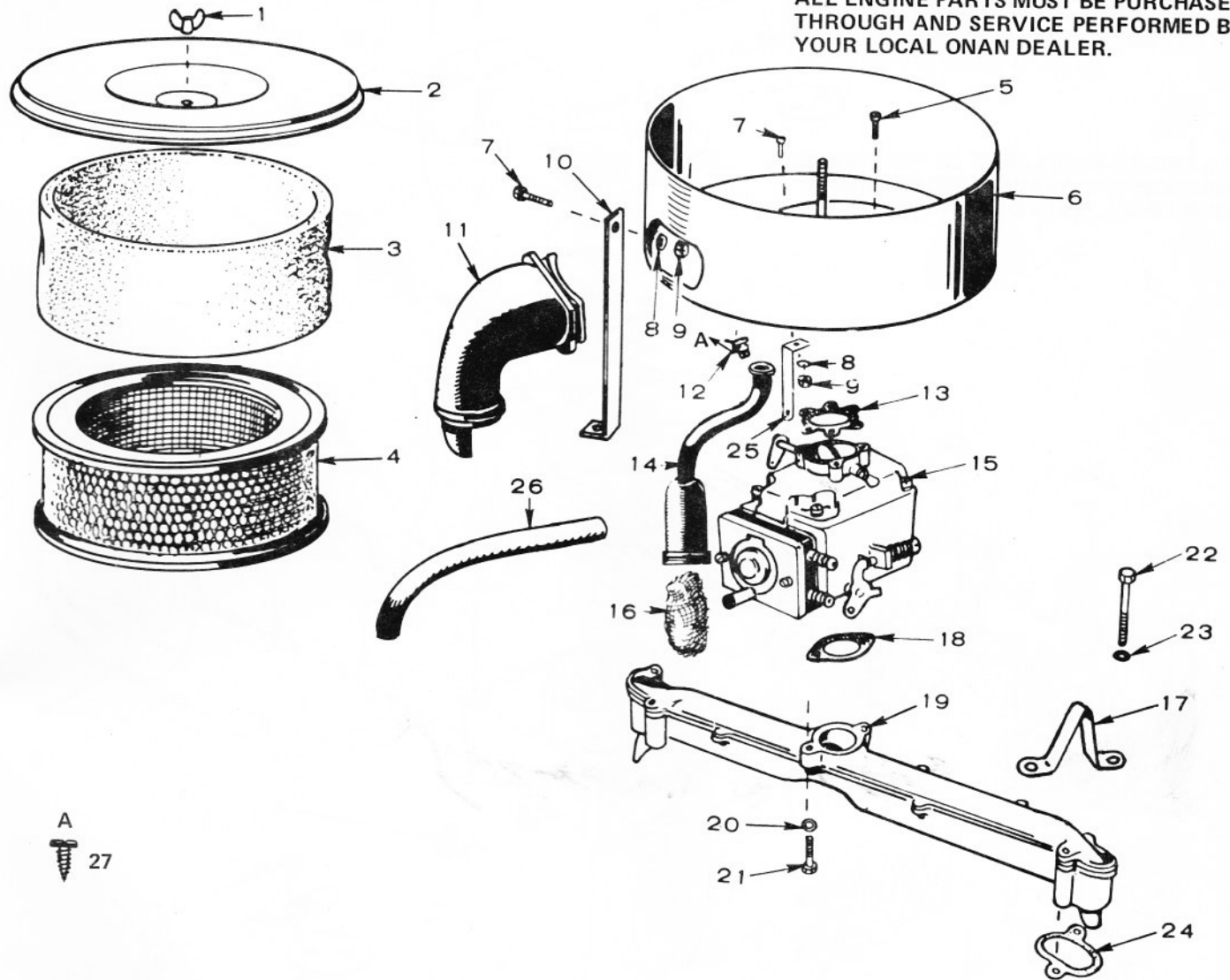
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	7262R	Retaining Ring	11	7272R	End Cap
2	7263R	Ball Bearing	12	7271R	Accelerator Valve Assembly
3	7264R	Motor Case	13	7279R	Hex Head Cap Screw
4 & 5	7265R	Hex Hd. Plug	14	7275R	Accelerator Spring
6	7231R	Thrust Plate	15	7270R	Hex Head Plug
7	7230R	Roller Bearing	16	7276R	Valve Plate
8	7227R	Hdless. Str. Pin	17	7256R	Cyl. Block Kit
9	7229R	Gasket	18	7278R	Motor Shaft
10	7273R	Pipe Plug	19	----	Model Plate
			20	224J	Retaining Ring
			---	634A655	Complete Motor Assembly

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

FUEL SYSTEM GROUP

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



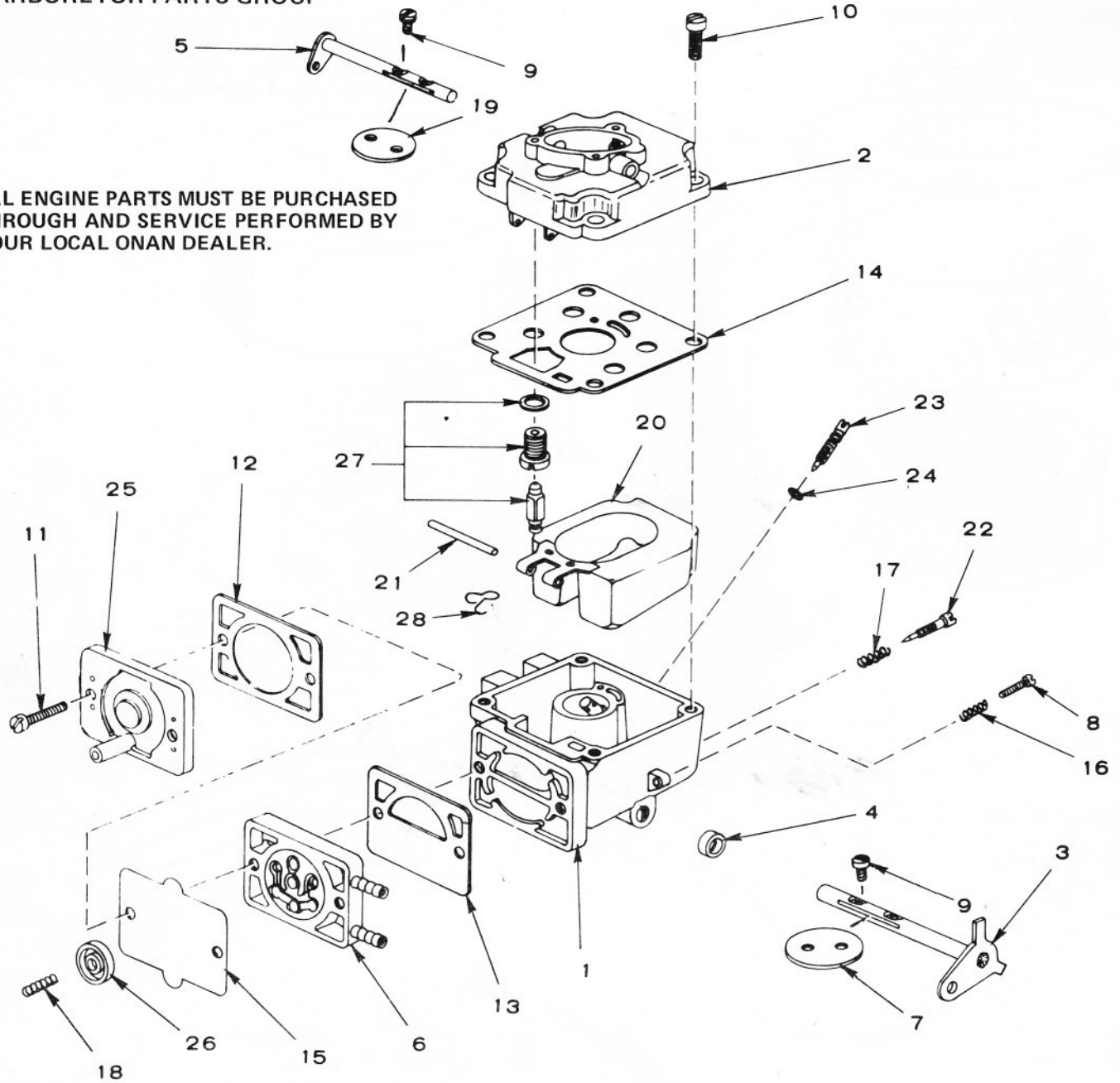
KEY NO.	PART NO.	DESCRIPTION
1	865-0020	Wing Nut (1/4 - 20)
2	140-1168	Air Cleaner Cover
3	140-1259	Air Cleaner Wrapper
4	140-1216	Air Cleaner Element
5	815-0463	Machine Screw, Slotted Head (No. 10 - 32 x 5/8")
6	140-1213	Air Cleaner Housing
7	800-0003	Cap Screw (1/4 - 20 x 1/2")
8	853-0013	Lockwasher (1/4")
9	862-0001	Hex Nut (1/4 - 20)
10	140-1198	Support
11	140-1169	Air Intake Tube
12	518-0328	Cable Clip
13	140-1215	Gasket
14	123-1277	Breather Tube

KEY NO.	PART NO.	DESCRIPTION
15	142-0568	Carburetor
16	123-0865	Filter
17	403-1021	Lifting Bracket
18	145-0438	Gasket
19	154-1468	Intake Manifold
20	850-0040	Lockwasher (1/4")
21	800-0023	Cap Screw (1/4 - 20 x 1 - 3/8")
22	CAP SCREW	5/16 - 18 x 2"
		5/16 - 18 x 2 - 1/4"
23	850-0045	Lockwasher (5/16")
24	154-1744	Gasket
25	140-1313	Support
26	503-0740	Fuel Hose
27	5592P	Tap Screw Sl. Pan Hd. No. 8 x 3/4 Type AB

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

CARBURETOR PARTS GROUP



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

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	142-0574	Body	17	142-0282	*Spring
2	142-0573	Body	18	142-0545	*Spring
3	142-0534	*Throttle Shaft	19	142-0546	Fly
4	142-0535	+Seal	20	142-0547	Float
5	142-0536	Choke Shaft	21	142-0548	*Shaft
6	142-0537	*Valve Assembly	22	142-0016	Idle Needle
7	142-0538	Fly	23	142-0549	High Speed Screw
8	142-0064	Stop Screw	24	142-0550	+Seal
9	142-0334	*Screw	25	142-0551	Cover
10	142-0539	Screw	26	142-0552	*Plate
11	142-0540	Screw	27	142-0553	*Valve Assembly
12	142-0541	+Gasket	28	142-0554	Retaining Clip
13	142-0542	+Gasket	---	142-0571	Gasket Kit (Inc. Parts Marked +)
14	142-0572	+Gasket	---	142-0570	Repair Kit (Inc. Parts Marked *)
15	142-0555	+Diaphragm			
16	142-0544	Spring			

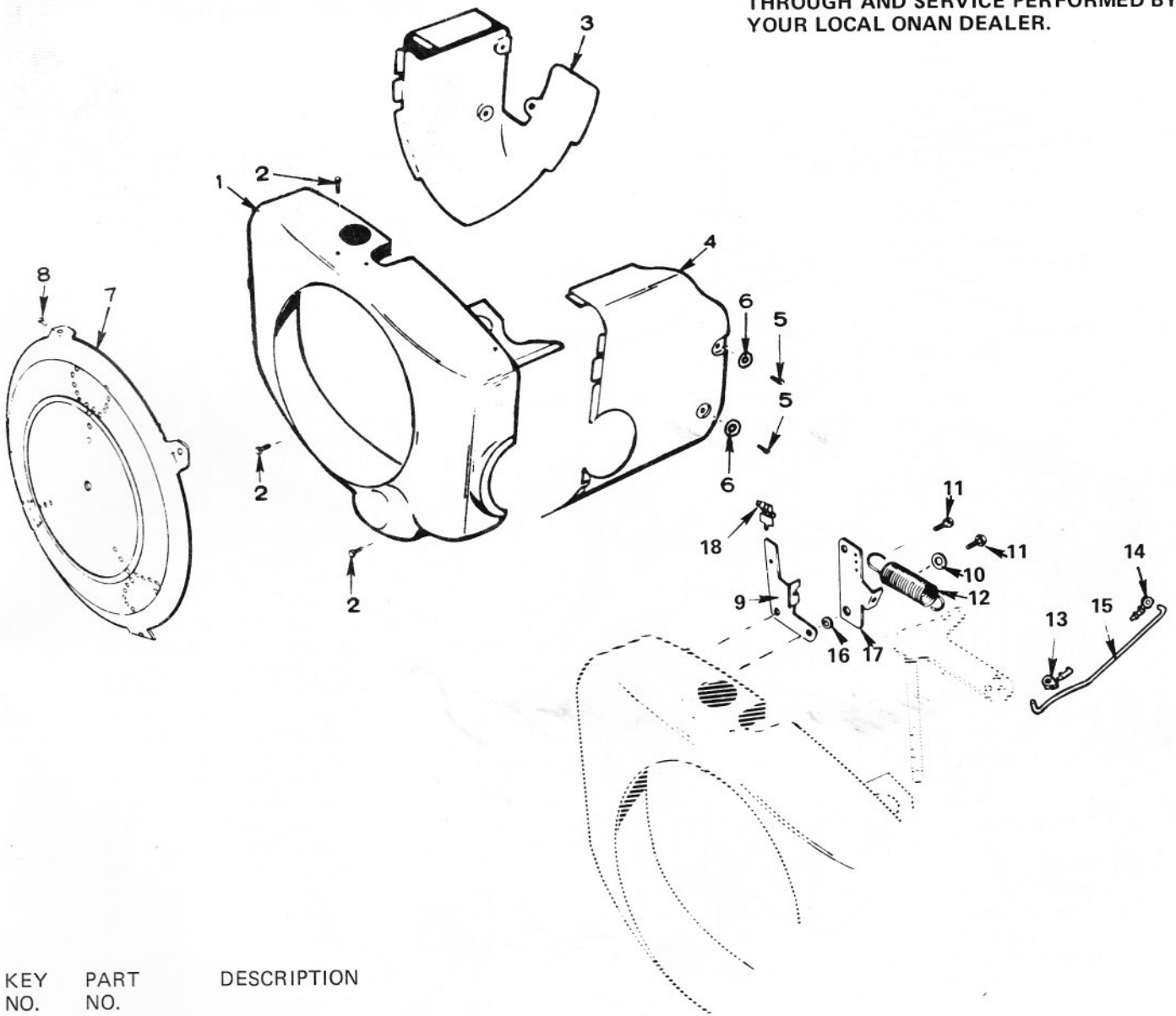
+Parts included in 142-0571 Gasket Kit.
*Parts included in 142-0570 Repair Kit.

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

BLOWER HOUSING AND GOVERNOR GROUP

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



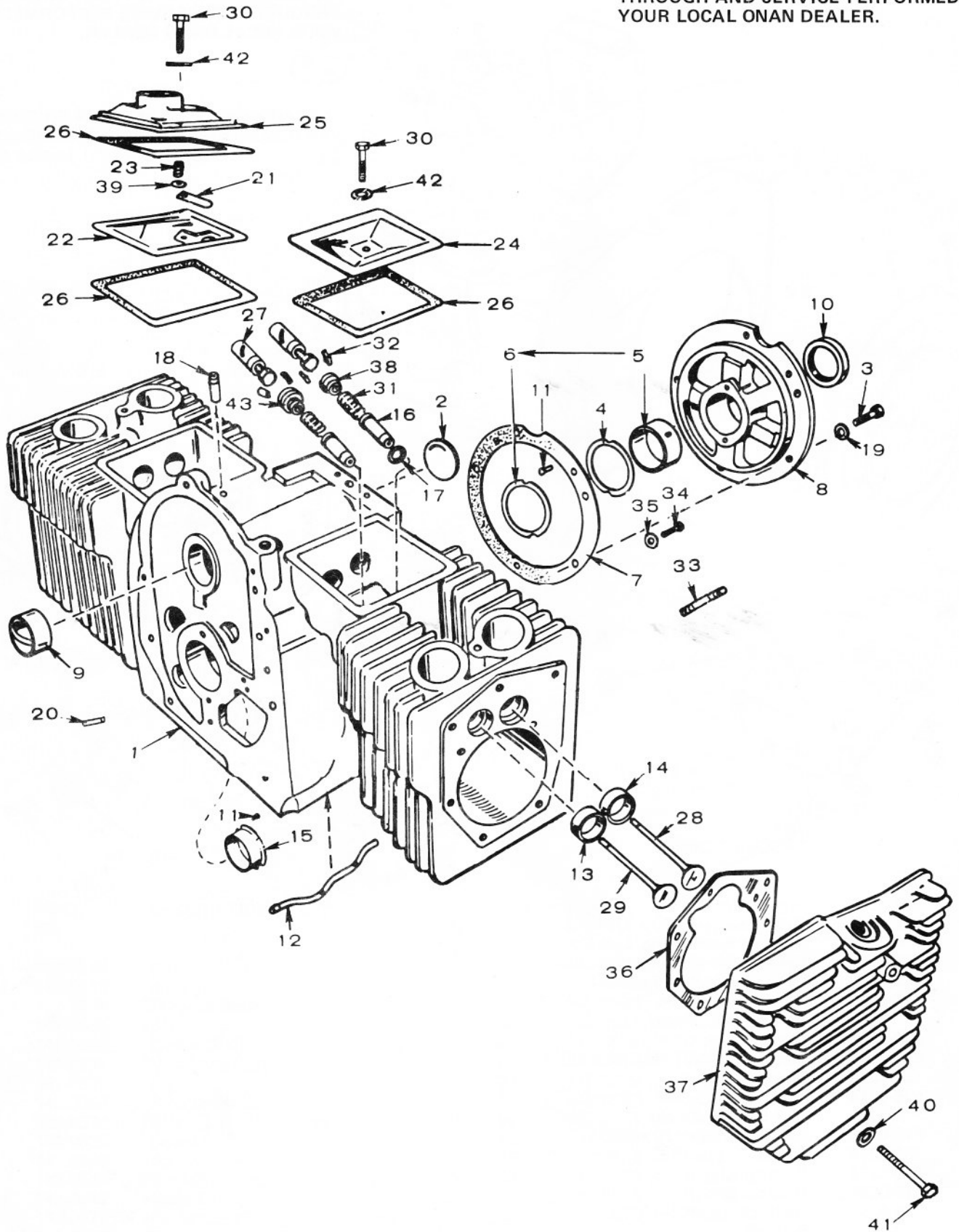
KEY NO.	PART NO.	DESCRIPTION
1	134-3567	Blower Housing
2	815-0261	Cap Screw (1/4 - 20 x 7/16")
3	134-2989	Cylinder Air Housing, Left Side
4	134-3518	Cylinder Air Housing, Right Side
5	815-0290	Cap Screw (1/4 - 20 x 5/8")
6	526-0021	Flat Washer (17/64" I.D. x 3/4" O.D. x 1/16" Thick)
7	134-3213	Guard
8	815-0378	Cap Screw, W/ET (No. 14 x 1/2")
9	150-1343	Bracket
10	526-0214	Flat Washer (17/64" I.D. x 1/2" O.D. x 1/16" Thick)
11	815-0436	Cap Screw (1/4 - 20 x 1/2")
12	150-1214	Spring
13	870-0278	Retainer Clip
14	518-0004	Retainer Clip
15	150-1350	Rod
16	150-1269	Bushing
17	150-1576	Arm
18	518-0176	Clip

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

CYLINDER BLOCK GROUP

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



another free manual from www.searstractormanuals.com

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

CYLINDER BLOCK GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	110-2590	Cylinder Block Assembly	21	123-1175	Reed
2	517-0048	*Plug	22	123-1173	Baffle
3	800-0051	*Cap Screw (3/8 - 16 x 1 - 1/4")	23	123-1174	Spring
4	104-0776	*Shim (.005" Thick)	24	110-1879	Valve Cover
5	CRANKSHAFT BEARING, REAR		25	110-2274	Valve Cover
	101-0450	*Standard	26	110-1921	Gasket
	101-0450-02	.002" Undersize	27	VALVE TAPPET	
	101-0450-10	.010" Undersize		115-0006	*Standard
	101-0450-20	.020" Undersize		115-0006-01	.001" Oversize
	101-0450-30	.030" Undersize		115-0006-02	.002" Oversize
6	104-0575	*Thrust Washer		115-0006-05	.005" Oversize
7	101-0415	*Gasket	28	110-1808	Intake Valve
8	101-0439	*Bearing Plate, Rear	29	110-1809	Exhaust Valve
9	101-0405	*Camshaft Bearing	30	800-0010	Cap Screw (1/4 - 20 x 3/4")
10	509-0041	*Seal	31	110-0539	Valve Spring
11	516-0072	*Drive Pin	32	110-0639	Valve Spring Lock
12	120-0735	*Tube	33	520-0820	Stud
13	VALVE SEAT INSERT, EXHAUST		34	800-0046	Cap Screw (3/8 - 16 x 1/2")
	110-1824	*Standard	35	526-0066	Flat Washer, Copper (25/64" I.D. x 9/16" O.D. x 1/16" Thick)
	110-1824-02	.002" Oversize	36	110-2287	Head Gasket
	110-1824-05	.005" Oversize	37	CYLINDER HEAD	
	110-1824-10	.010" Oversize		110-2564	Right Side
	110-1824-25	.025" Oversize		110-2563	Left Side
14	VALVE SEAT INSERT, INTAKE		38	110-0904	Roto-Cap - Exhaust Valves
	110-0197	*Standard	39	526-0018	Flat Washer (17/64" I.D. x 5/8" O.D. x 1/16" Thick)
	110-0197-02	.002" Oversize	40	526-0122	Flat Washer 11/32" I.D. x 23/32" O.D. x 10 Ga.)
	110-0197-05	.005" Oversize	41	CAP SCREW - SPECIAL	
	110-0197-10	.010" Oversize		800-0540	5/16 - 18 x 1 - 5/8"
	110-0197-25	.025" Oversize		800-0541	5/16 - 18 x 2"
15	CRANKSHAFT BEARING, FRONT		42	526-0063	Flat Washer, Copper 17/64" I.D. x 7/16" O.D. x 1/32" Thick)
	101-0432	*Standard	43	110-0893	Retainers - Intake Valves
	101-0432-02	.002" Undersize		160-1213	Ignition Tune-up Kit
	101-0432-10	.010" Undersize		168-0140	Carbon Removal Gasket Kit
	101-0432-20	.020" Undersize		168-0141	Engine Gasket Kit
	101-0432-30	.030" Undersize			
16	110-1807	*Valve Guide			
17	110-0068	*Gasket			
18	149-1299	*Vacuum Tube			
19	850-0050	*Lockwasher (3/8")			
20	516-0141	*Alignment Pin			

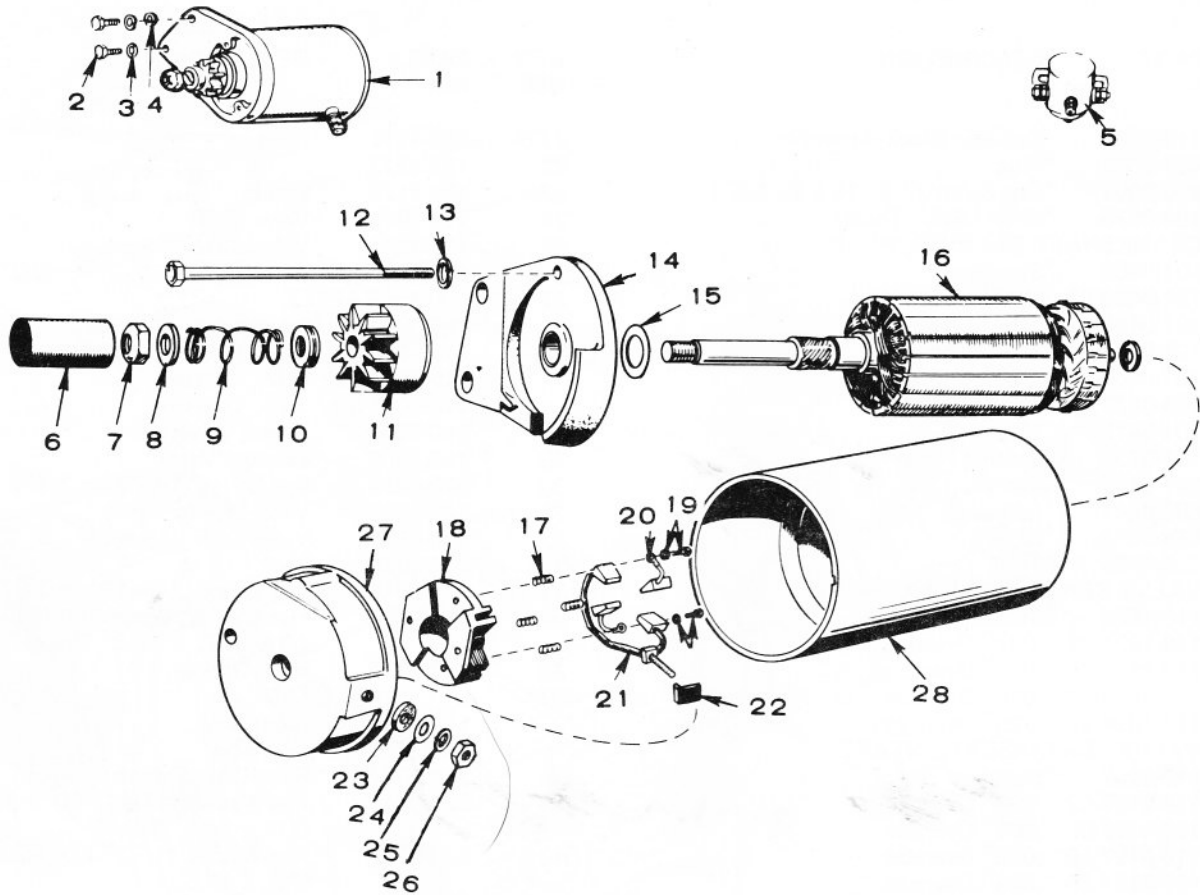
*Parts Included in Cylinder Block Assembly

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

STARTER GROUP

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



KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	191-0933	Starting Motor, Complete	15	191-1038	Washer
2	800-0028	Cap Screw (5/16 - 18 x 1")	16	191-1039	Armature
3	850-0045	Lockwasher (5/16")	17	&	*+Spring
4	526-0113	Flat Washer (11/32" I.D. x 1" O.D. x 3/32" Thick)	18	&	+Brush
5	307-1031	Starting Solenoid	19	&	+Screw and Lockwasher
6	191-1034	Dust Cover	20	&	*+Brush
7	191-1045	Stop Nut	21	&	*+Stud and Brush Assembly
8	191-1046	Washer	22	&	+Bushing
9	191-1035	Spring	23	&	+Insulation Washer
10	191-1047	Spacer	24	&	+Flat Washer
11	191-1036	Drive Assembly	25	&	+Lockwasher
12	191-1048	Cap Screw	26	&	+Nut
13	850-0040	Lockwasher (1/4")	27	191-1040	Cap Assembly (Inc. Parts Marked +)
14	191-1037	Cap Assembly	28	&	Housing
				191-1041	Repair Package (Inc. Parts Marked *)

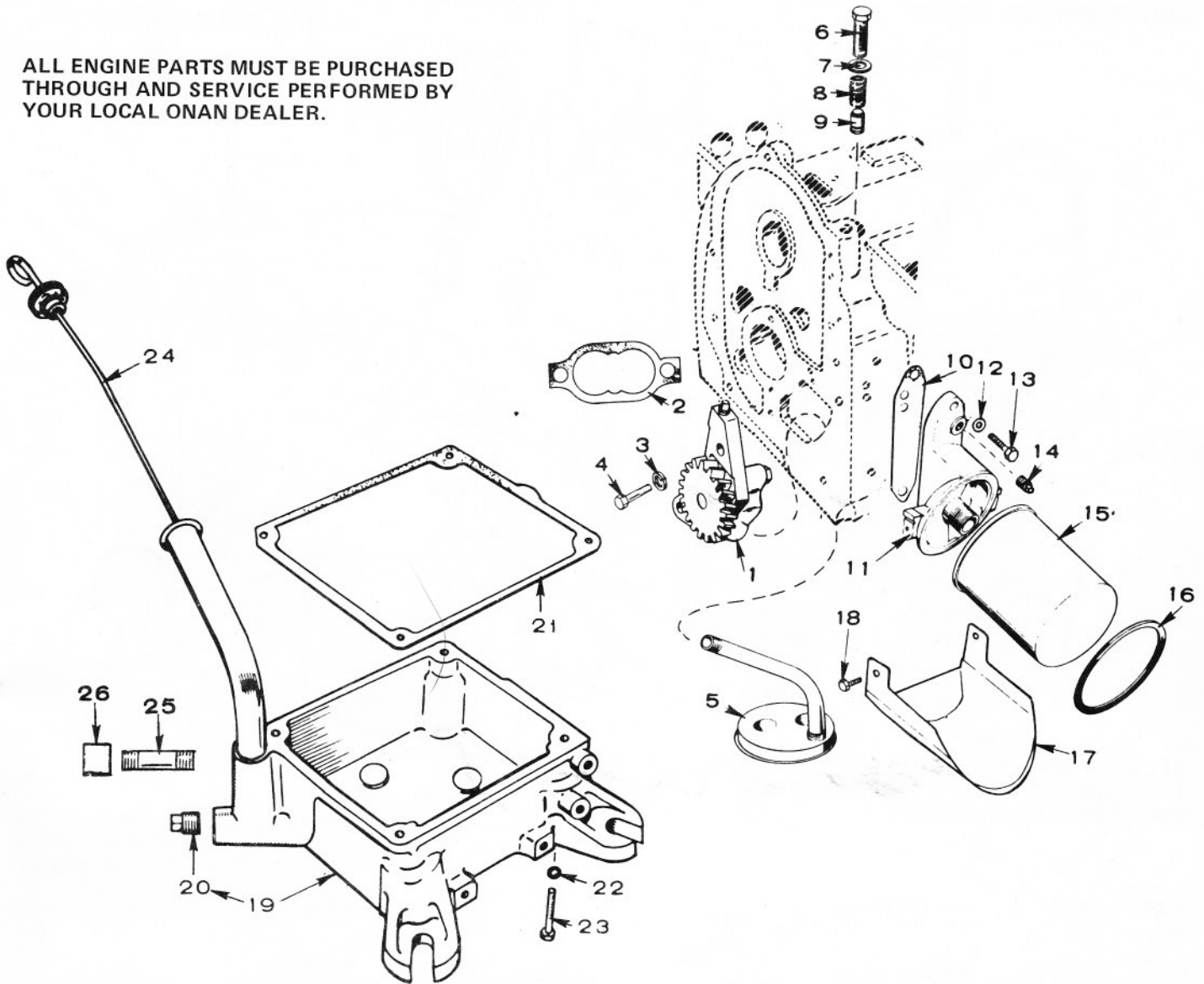
+Parts included in 191-1040 Cap Assembly
*Parts included in 191-1041 Repair Package
&Not Sold Separately

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

OIL SYSTEM GROUP

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

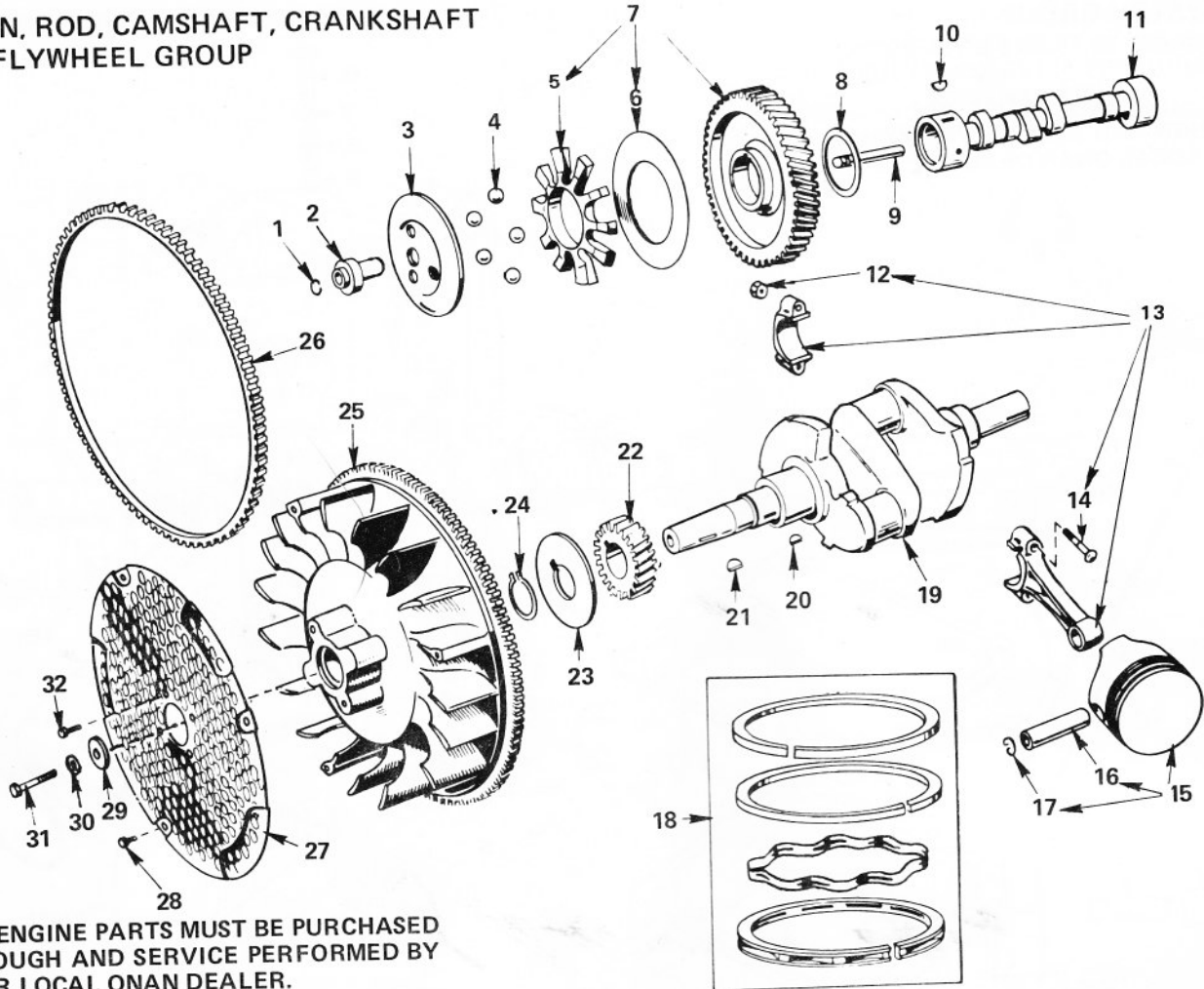


KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	120-0491	Oil Pump (Components Not Sold Separately)	13	800-0028	Cap Screw (5/16 - 18 x 1)
2	120-0161	Oil Pump Gasket Kit	14	505-0057	Pipe Plug
3	850-0040	Lockwasher (1/4")	15	122-0338	Oil Filter
4	800-0007	Cap Screw (1/4 - 20 x 1")	16	122-0347	Air Seal, Filter to Housing
5	120-0713	Intake Cup	17	122-0360	Oil Drain
6	801-0050	Cap Screw (3/8 - 24 x 1")	18	815-0194	Cap Screw W/ET (No. 10 - 32 x 3/8")
7	526-0066	Flat Washer, Copper (25/64" I.D. x 9/16" O.D. x 1/16" Thick)	19	102-0741	Oil Base
8	120-0140	Spring	20	505-0056	Plug
9	120-0398	Plunger	21	102-0693	Gasket
10	122-0321	Gasket	22	850-0050	Lockwasher (3/8")
11	122-0320	Adapter	23	800-0056	Cap Screw (3/8 - 16 x 2 - 1/2")
12	526-0065	Flat Washer, Copper (21/64" I.D. x 9/16" O.D. x 1/16" Thick)	24	123-1292	Cap and Indicator
			25	505-0176	Pipe Nipple (1/2 x 3 - 1/2")
			26	505-0158	Pipe Cap (1/2")

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

PISTON, ROD, CAMSHAFT, CRANKSHAFT AND FLYWHEEL GROUP



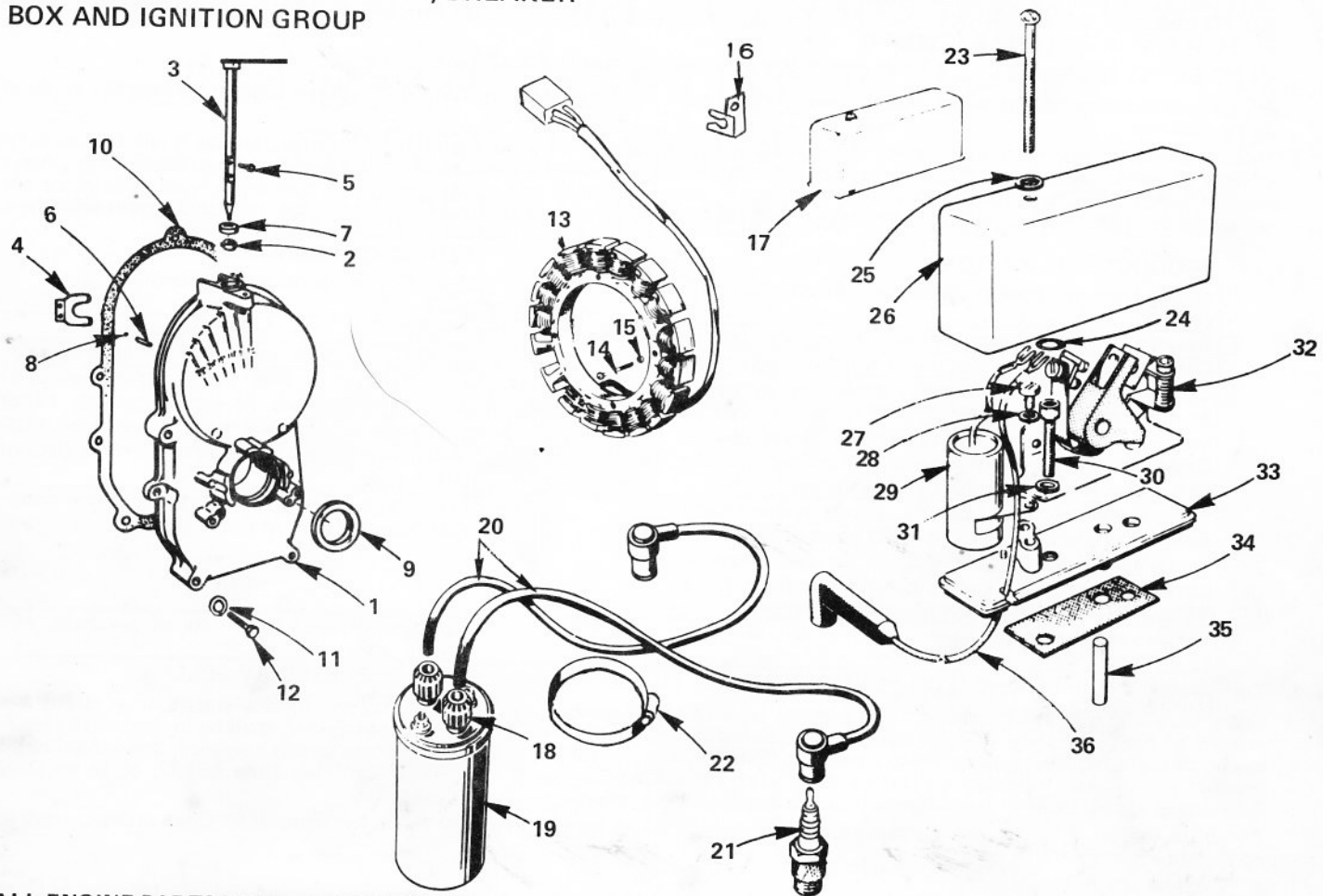
ALL ENGINE PARTS MUST BE PURCHASED THROUGH AND SERVICE PERFORMED BY YOUR LOCAL ONAN DEALER.

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	150-0078	Retaining Ring	16	112-0122	Piston Pin
2	150-1519	Hub	17	518-0311	Retaining Ring
3	150-1520	Cup	18	RING SET, PISTON	
4	510-0015	Flyball		113-0189	Standard
5	150-1257	Spacer		113-0189-05	.005" Oversize
6	150-0077	Plate		113-0189-10	.010" Oversize
7	105-0332	Gear (Includes Spacer and Plate)		113-0189-20	.020" Oversize
8	105-0004	Thrust Washer		113-0189-30	.030" Oversize
9	150-0075	Center Pin		113-0189-40	.040" Oversize
10	515-0001	Camshaft Gear Key	19	104-0996	Crankshaft
11	105-0402	Camshaft (Includes Center Pin)	20	515-0001	Key, Crankshaft Gear
12	870-0302	Hex Nut, Locking (5/16 - 24)	21	515-0227	Key, Flywheel
13	CONNECTING ROD (Inc. Key No's. 12 and 14)		22	104-0032	Gear
	114-0257	Standard	23	104-0043	Gear Retaining Washer
	114-0257-10	.010" Undersize	24	518-0014	Retaining Ring
	114-0257-20	.020" Undersize	25	134-3506	Flywheel (Inc. Ring Gear and Stator)
	114-0257-30	.030" Undersize	26	104-0779	Ring Gear
14	114-0240	Bolt (Special)	27	134-3508	Guard
15	PISTON AND PIN (Inc. Key No's 16 and 17)		28	815-0400	Machine Screen, Truss Head
	112-0151	Standard	29	526-0017	Flat Washer (15/32" I.D. x 1 - 1/4" O.D. x 1/4" Thick)
	112-0151-05	.005" Oversize	30	850-0055	Lockwasher (7/16")
	112-0151-10	.010" Oversize	31	104-0170	Cap Screw (7/16 - 14 x 4")
	112-0151-20	.020" Oversize			
	112-0151-30	.030" Oversize			
	112-0151-40	.040" Oversize			

REPAIR PARTS

ROPER 18 TWIN HYDRO GARDEN TRACTOR--MODEL NO. T8338AR
ONAN ENGINE--MODEL NO. B48M-GA018/3475A

GEARCASE, CHARGING STATOR, BREAKER BOX AND IGNITION GROUP



ALL ENGINE 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	Gearcase Assembly (Inc. Parts Marked X)	22	503-0311	Coil Clamp
2	510-0105	x Bearing	23	812-0108	+* Machine Screw, Round Head (No. 10 - 24 x 1 - 1/2")
3	150-1470	x Shaft and Arm	24	509-0065	+* Retainer, "O" Ring
4	150-1187	x Yoke	25	526-0008	+* Flat Washer (13/64" I.D. x 7/16" O.D. x 1/32" Thick)
5	815-0046	x Pan Head Screw (8 - 32 x 3/8")	26	160-1232	* Cover (Inc. Parts Marked +)
6	516-0130	x Dowel Pin	27	815-0358	* Cap Screw (No. 8 - 32 x 5/16") - Slotted
7	509-0008	x Seal	28	850-0025	* Lockwasher (No. 8)
8	510-0014	x Ball	29	312-0196	* Condenser
9	509-0040	x Seal	30	802-0034	* Cap Screw (1/4 - 20 x 3/4") - Socket Head
10	103-0408	Gasket	31	850-0038	* Lockwasher (1/4")
11	CAP SCREW		32	160-1183	* Point Set
	800-0032	5/16 - 18 x 1 - 3/4"	33	160-1219	* Base
	800-0545	5/16 - 18 x 2 - 3/4" - Special	34	160-1150	* Gasket
12	526-0065	Flat Washer, Copper (21/64" I.D. x 9/16" O.D. x 1/16" Thick)	35	160-1151	Plunger
13	191-1102	Stator	36	336-2132	Lead
14	813-0108	Round Head Screw (No. 10 - 32 x 1 - 1/2")	---	160-1213	Tune up Kit (Include points and condenser)
15	850-0030	Lockwasher (No. 10)			
16	167-0188	Bracket Alternator Lead			
17	160-1210	Breaker Box (Inc. Parts Marked *)			
18	166-0604	Terminal Cap (Part of Coil)			
19	166-0535	Ignition Coil			
20	SPARK PLUG CABLE				
	167-1595	17"			
	167-1596	15"			
21	167-0237	Spark Plug			

*Parts included in 160-1210 Breaker Box
+Parts included in 160-1232 Cover
xIncluded in 103-0498 Gearcase Assembly

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.

- 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

PERIOD OF WARRANTY

<input type="checkbox"/> Goods used in personal, family and household applications.	One (1) year from date of purchase.
<input type="checkbox"/> Goods used in commercial-industrial applications.	One (1) year from date of purchase.
<input type="checkbox"/> Commercial-industrial stationary generator sets.	One (1) year from date of initial start-up.
<input type="checkbox"/> 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).	*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.
<input type="checkbox"/> 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).	*Two (2) years or 1500 hours, whichever occurs first from the date of initial start-up.
<input type="checkbox"/> Repair or replacement parts.	Ninety (90) days from date of purchase, excludes labor.

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

- 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.

- Garden Tractor Applications – Up to a maximum of two (2) hours for Onan Industrial Engine installations.
- 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.
- 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

- 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.
- 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.

- 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:

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

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