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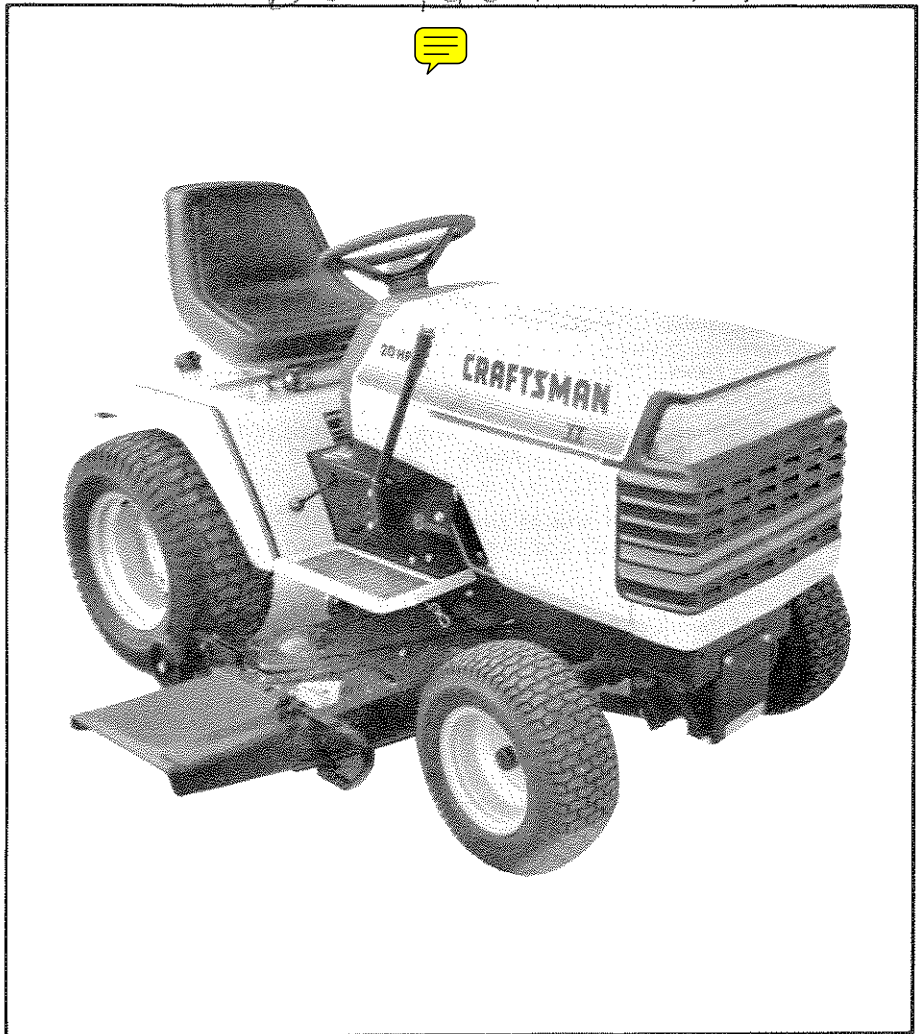


SEARS
OWNERS
MANUAL
FILE COPY

MODEL NO.
917.254490

Caution:
Read and Follow
All Safety Rules
And Instructions
Before Operating
This Equipment

FILE COPY



CRAFTSMAN
GT 20HP TWIN
6 SPEED - 50" MOWER
GARDEN TRACTOR

FILE COPY

Assembly
Operation
Maintenance
Repair and Adjustment
Repair Parts



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

CAUTION: LOOK FOR THIS WORD TO POINT OUT IMPORTANT EQUIPMENT PRECAUTION



RULES FOR SAFE OPERATION

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

In the State of California the above is required by law (Section 4442 of the California Public Resources Code). Other States may have similar laws. Federal laws apply on federal lands.

1. Know the controls and how to stop quickly. READ THIS OPERATOR'S MANUAL and instructions furnished with attachments.
2. Do not allow children to operate the machine. Do not allow adults to operate it without proper instruction.
3. Do not carry passengers. Do not mow when children and others are around.
4. Always wear substantial footwear. Do not wear loose fitting clothing that could get caught in moving parts.
5. Keep your eyes and mind on your tractor, mower, and the area being cut. Do not let other interests distract you.
6. Do not attempt to operate your tractor or mower when not in the drivers seat.
7. Always get on or off your tractor from the operator's left hand side.
8. Clear the work area of objects (wire, rocks, etc.) which might be picked up and thrown.
9. Disengage all attachment clutches 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 repair. Be careful to avoid touching hot muffler or engine components.
12. Disengage power to attachments when transporting or not in use.
13. Take all possible precautions when leaving the vehicle unattended. Disengage the power-take-off, lower the attachments, shift into neutral, set the parking brake, stop the engine, and remove the key.
14. Do not stop or start suddenly when going uphill or downhill. Mow up and down the face of slopes (not greater than 15°); never across the face. Refer to page 37.
15. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
16. While going up or down slopes, place Gear Shift Control Lever in 1st gear position to negotiate the slope without stopping.
17. Never mow in wet or slippery grass, when traction is unsure, or at a speed which could cause a skid.
18. Stay alert for holes in the terrain and other hidden hazards. Keep away from drop-offs.
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 objects.
21. Never shift gears until tractor comes to a stop.
22. Never place hands or feet under the mower, in discharge chute, or near any moving parts while tractor or mower are running. Always keep clear of discharge chute.
23. Use care when pulling loads or using heavy equipment.
 - a. Use only approved drawbar hitch points.
 - b. Limit loads to those you can safely control.
 - c. Do not turn sharply. Use care when backing.
 - d. Use counterweight or wheel weights when suggested owner's manuals.
24. Watch out for traffic when crossing or near roadways.
25. When using any attachments, never direct discharge 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 fuel cap of the fuel tank or add gasoline to a running or hot engine or an engine that has not been allowed to cool for several minutes after running. Never fill tank indoors, always clean up spilled gasoline.
 - c. Open doors if the engine is run in the garage - exhaust fumes are dangerous. Do not run the engine indoors.
27. Keep the vehicle and attachments in good operating condition, and keep safety devices in place and working.
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 building where fumes may reach an open flame or spark. Allow the engine to cool before storing in any enclosure.
30. To reduce fire hazard, keep the engine free of grass, leaves or excessive grease. Do not clean product while engine running.
31. Except for adjustments, DO NOT operate Engine if a cleaner or cover directly over carburetor air intake is removed. Removal of such part could create a fire hazard.
32. Do not operate without a muffler, or tamper with exhaust system. Damaged mufflers or spark arresters could create fire hazard. Inspect periodically and replace if necessary.
33. The vehicle and attachments should be stopped and inspected for damage after striking a foreign object, and the damage should be repaired before restarting and operating the equipment.
34. Do not change the engine governor settings or overspeed the engine; severe damage or injury may result.
35. When using the vehicle with mower, proceed as follows:
 - a. Mow only in daylight or in good artificial light.
 - b. Shut the Engine off when unclogging chute.
 - c. Check the blade mounting bolts for proper tightness at frequent intervals.
36. Do not operate the mower without either the entire grass catcher, on mowers so equipped, or the the deflector shield in place.
37. Disengage power to mower before backing up. Do not mow in reverse unless absolutely necessary and then only after careful observation of the entire area behind the mower.
38. Under normal usage the grass catcher bag material is subject to deterioration and wear. It should be checked frequently for bag replacement. Replacement bags should be checked to ensure compliance with the original manufacturer's recommendations or specifications.

CONGRATULATIONS on your purchase of a Sears GT 20HP Garden Tractor. It has been designed, engineered and manufactured to give you the best possible dependability and performance. Should you experience any problem you cannot easily remedy, please contact your nearest Sears Service Department. We have competent, well-trained technicians and the proper tools to service or repair this unit.

Please read and retain this manual. The instructions will enable you to assemble and maintain your Tractor properly. Always observe the "SAFETY RULES".

MODEL NUMBER	_____
SERIAL NUMBER	_____
DATE OF PURCHASE	_____
THE MODEL AND SERIAL NUMBERS WILL BE FOUND ON THE MODEL PLATE ATTACHED TO THE FENDER.	
YOU SHOULD RECORD BOTH SERIAL NUMBER AND DATE OF PURCHASE AND KEEP IN A SAFE PLACE FOR FUTURE REFERENCE.	

MAINTENANCE AGREEMENT

A Sears Maintenance Agreement is available on this product. Contact your nearest Sears store for details.

YOUR NEW GT 20 HP GARDEN TRACTOR FEATURES...

CRAFTSMAN 20 HP TWIN--CYLINDER ENGINE--cool running performance and long life with plenty of power to take on a variety of yard, gardening or snow removal tasks.

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

CONTROL PANEL--with Throttle, Choke, Light Switch, Hour Meter, Ignition Switch, Indicator Lights, Parking Brake Lever and Clutch Switch--conveniently grouped for ease of use.

ATTACHMENT VERSATILITY--handles a large variety of Sears Yard and Garden Tractor Attachments. See Pages 51 and 52.

CUSTOMER RESPONSIBILITIES

Read and observe the safety rules. Always use care when using your tractor. Keep away from moving parts. **DO NOT** work on your tractor with engine running. Always keep your tractor and mower clean. Follow a regular schedule in maintaining, caring for and using your tractor. A well cared for tractor will run and last longer. Follow the instructions under "Maintenance" and "Storage" sections of this Owner's Manual.

LIMITED TWO YEAR WARRANTY ON ELECTRIC START RIDING EQUIPMENT

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

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

This warranty does not cover:

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

FULL 90-DAY WARRANTY ON BATTERY

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

WARRANTY SERVICE IS AVAILABLE BY CONTACTING THE NEAREST SEARS SERVICE CENTER/DEPARTMENT IN THE UNITED STATES. This warranty applies only while this product is in use in the United States.

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

SEARS, ROEBUCK and CO., D/731CR-W, Sears Tower, Chicago, Il 60684

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ASSEMBLY

Know Your Tractor

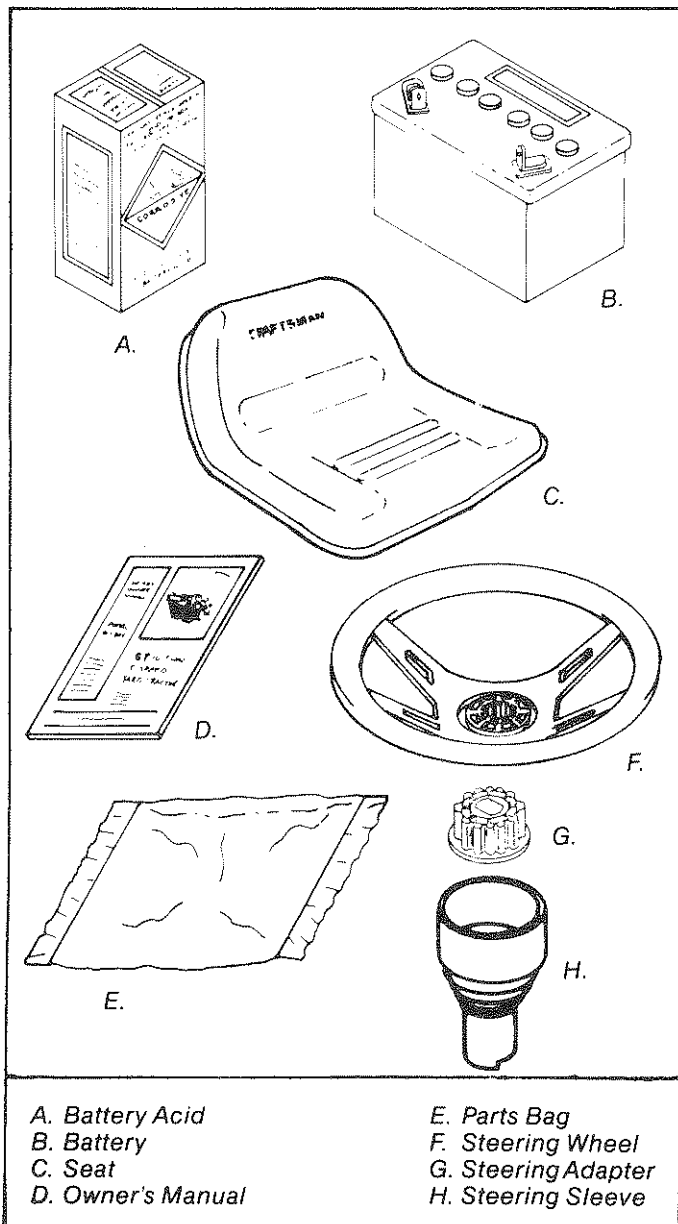
READ THIS OWNER'S MANUAL BEFORE OPERATING YOUR GARDEN TRACTOR. If you understand the machine and its operation, you will achieve efficient and peak performance. While reading the manual, compare the illustrations with your Garden Tractor to familiarize yourself with the location of various controls and adjustments. Study the operating instructions and safety precautions thoroughly to insure proper functioning of your Garden Tractor and to prevent injury to yourself and others. Be sure to pay strict attention to all notes and cautions; they are included for your safety. Save this manual for future reference.

Unpacking Instructions

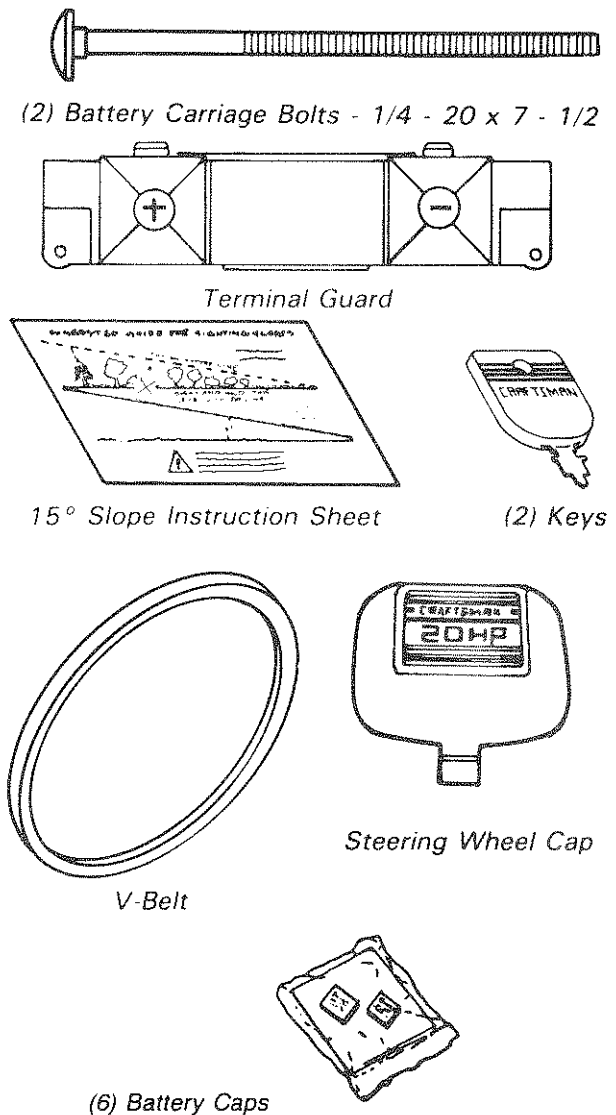
1. Remove items from carton. The box contains the items shown below.
2. Cut down four corners of the carton with a utility knife and fold down sides.
3. Remove banding holding mower deck to skid.
4. Lower mower deck to floor and remove packing.
5. Remove banding holding tractor to skid.
6. Shift unit into neutral and release the parking brake.
7. Carefully guide the tractor backwards off the skid.






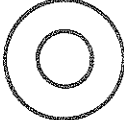

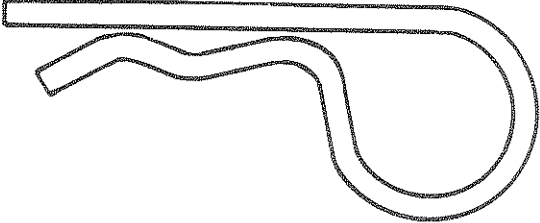
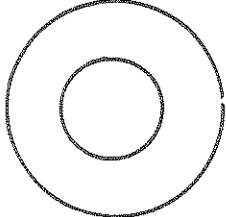
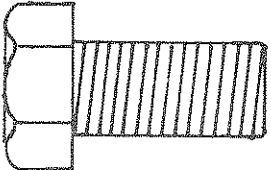
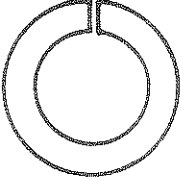
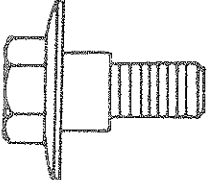
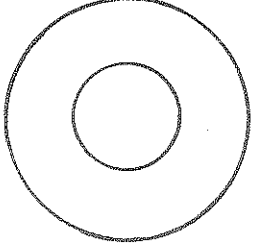
The operation of any tractor can result in foreign objects thrown into the eyes, which can result in severe eye damage. Always wear safety glasses or eye shields before starting your tractor and while mowing. We recommend Wide Vision Safety Mask for over the spectacles or standard safety glasses, available at Sears Retail or Catalog Stores.



Parts Bag Contents Not Shown Full Size:

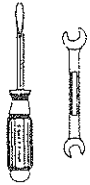


ASSEMBLY

ASSEMBLY LOCATION	PARTS BAG CONTENTS SHOWN FULL SIZE		
BATTERY	 (2) Wing Nut - 1/4 - 20		
BATTERY TERMINALS	 (2) Hex Nut, 1/4 - 20	 (2) Hex Bolt, 1/4 - 20 x 3/4  (2) Washer 9/32 x 5/8 x 16 Ga.	 (2) Lockwasher 1/4
SUSPENSION ARMS	 (4) Spring Retainer  (4) Washer 17/32 x 1 - 1/16 x 13 Ga.		
SEAT	 (1) Hex Bolt 1/2 - 13 x 1 Grade 5	 (1) Lockwasher 1/2  (1) Shoulder bolt 5/16 - 18	 (1) Washer 17/32 x 1-3/16 x 12 Ga.

ASSEMBLY

To assemble and adjust your tractor you will need:



(2) 7/16" wrenches
(1) 3/4" wrench
(1) 9/16" wrench

(2) 1/2" wrenches
Tire Pressure Gauge
Screwdriver
Utility Knife

NOTE: RIGHT HAND (R.H.) AND LEFT HAND (L.H.) ARE DETERMINED FROM OPERATOR'S POSITION WHILE SEATED ON THE TRACTOR.

WEAR EYE AND FACE SHIELD.



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

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

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

1. Prepare Battery



READ INSTRUCTIONS INCLUDED WITH THE BATTERY CAPS FOUND IN BAG OF PARTS. ALWAYS WEAR GLOVES, CLOTHING AND GOGGLES TO PROTECT YOUR HANDS, SKIN AND EYES.

- Fill and charge battery (before installing). NOTE: SEE DETAILED INSTRUCTIONS PACKAGED WITH BATTERY VENT CAPS FOUND IN BAG OF PARTS.
- Fill battery with battery acid to bottoms of tubes in cells (Fig. 1). NOTE: DO NOT OVERFILL. OVERFILLING WILL RESULT IN DAMAGE TO TRACTOR.
- Check level of battery acid after 30 minutes. Add additional battery acid if necessary. NOTE: TIGHTEN VENT CAPS SECURELY.
- Charge battery at the rate of six amperes for one hour.
- Neutralize excess battery acid for disposal by adding it to four inches of water in a five gallon plastic container. Stir with a wooden or plastic paddle while adding baking soda until the addition of more soda causes no more foaming.

2. Install Seat

Seat position should be adjusted forward or backward so that the operator can comfortably reach Clutch/Brake Pedal and safely operate the tractor (Fig. 2).

- Place seat on seat pan. Screw hex head machine screw, lockwasher and flat washer into seat (Fig. 2). Screw shoulder bolt and flat washer into seat (Fig. 2). Machine screw, shoulder bolt and washers found in bag of parts (shown full size on page 6).
- Tighten shoulder bolt and flat washer using a 1/2" wrench.
- Tighten hex bolt (adjustment bolt), lockwasher and flat washer using a 3/4" wrench.
- Place seat in operating position. Sit on the seat and press clutch/brake pedal all the way down. If operating position is not comfortable, adjust seat.
- To adjust: Raise seat. Loosen adjustment bolt. Slide seat to desired position. Tighten adjustment bolt securely.

CUT AWAY VIEW

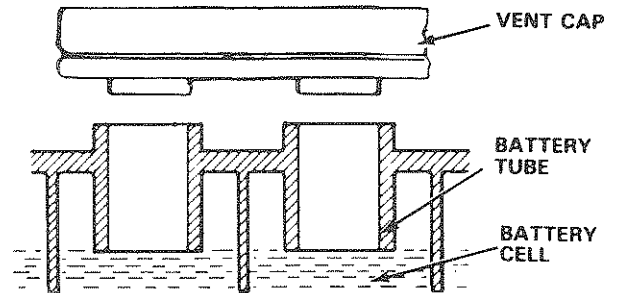


FIGURE 1

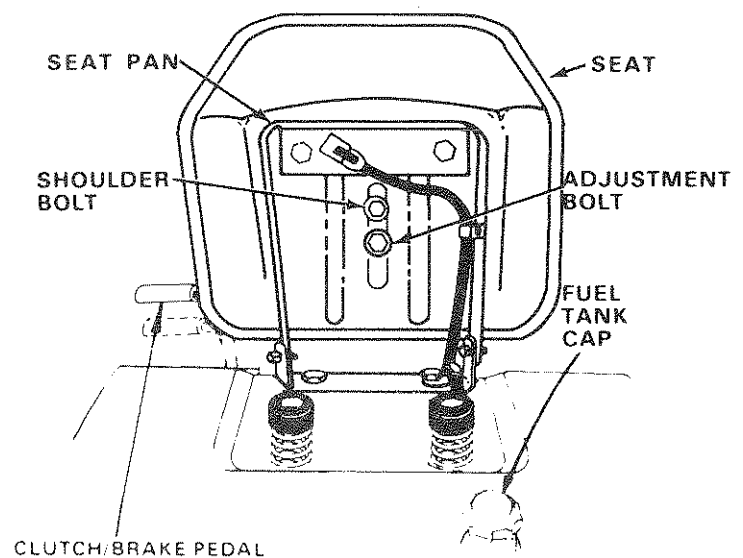


FIGURE 2



THE MACHINE SCREW-LOCKWASHER-FLAT WASHER ASSEMBLY MUST BE TIGHTENED SECURELY TO PREVENT MOVEMENT OF SEAT.

ASSEMBLY

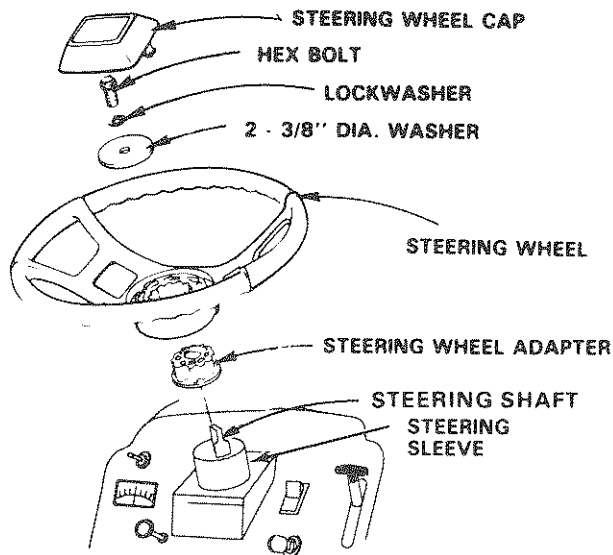


FIGURE 3

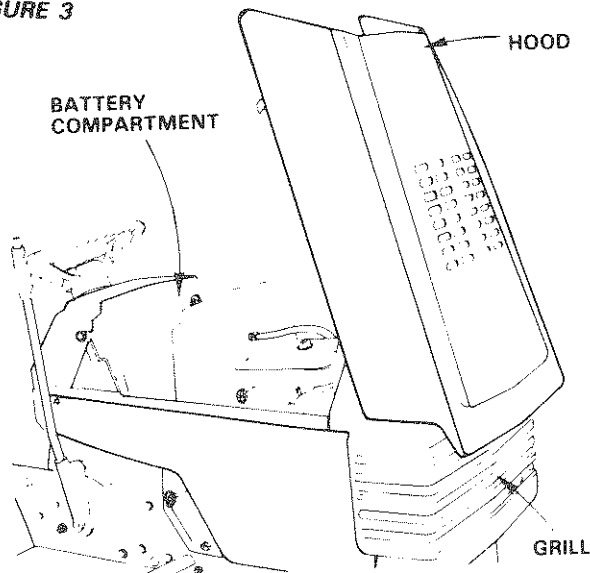


FIGURE 4

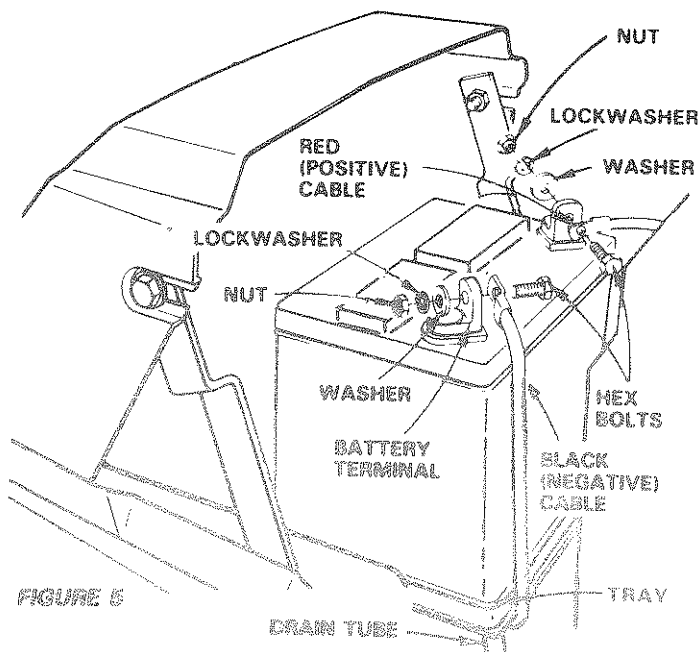
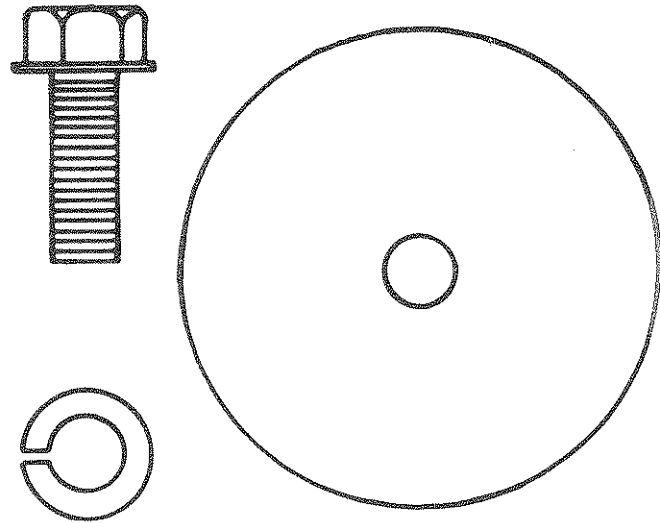


FIGURE 5

3. Install Steering Wheel

NOTE: POSITION FRONT WHEELS FORWARD.

- a. Use a 9/16" wrench to remove hex, bolt lockwasher and 2-3/8" diameter washer (shown full size below) from steering column (Fig. 3).



- b. Position sleeve over steering shaft assembly. Position steering wheel over steering wheel adaptor.
- c. Secure steering wheel to steering shaft using hex bolt, lockwasher and 2-3/8" diameter washer (Fig. 3).
- d. Snap steering wheel cap in place on steering wheel. Steering wheel cap found in bag of parts.

4. Check Tires

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

DO NOT SHORT BATTERY TERMINALS.

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

5. Install Battery

- a. Lift hood from rear sides (Fig. 4).
- b. Remove tape from plastic tray. Make sure drain tube (Fig. 5) is fastened to drain hole in battery tray and battery tray is positioned in hole of battery support.
- c. Place battery in plastic tray (Battery terminals to front of tractor)(Fig. 5).

ASSEMBLY



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

- d. Connect RED battery cable to positive (+) battery terminal with hex bolt, flat washer, lockwasher and hex nut (shown full size on page 6) found in bag of parts (Fig. 5). Tighten securely with two 7/16" wrenches.
- e. Connect BLACK ground cable to negative (-) battery terminal with remaining hex bolt, flat washer, lockwasher and hex nut (shown full size below) found in bag of parts (Fig. 5). Tighten securely.

NOTE: IF YOU HAVE A WEAK BATTERY, SEE "STARTING YOUR TRACTOR WITH A WEAK BATTERY" PAGE 20.

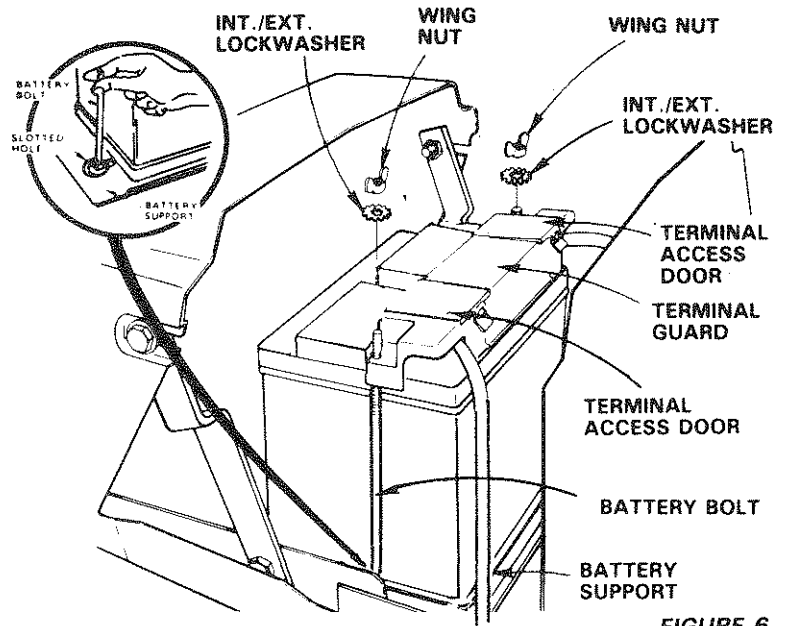
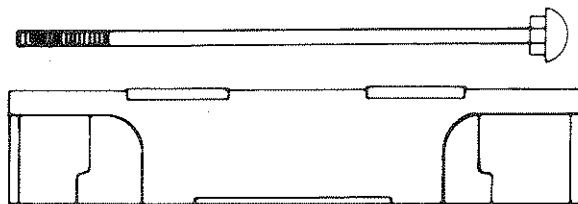


FIGURE 6

- f. Using the slotted hole on one side of the battery support (Fig. 6) insert one battery bolt, head of bolt down. Fasten the battery bolt to the terminal guard using int./ext. lockwasher and wing nut (shown full size on page 6) as shown in Fig. 6.
- g. Assemble the remaining battery bolt to other side of battery support and fasten terminal guard to it with remaining int./ext. lockwasher and wing nut. Tighten wing nuts securely by hand (Fig. 6).



- h. Remove Plastic on tractor hood and close.

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

1. INSPECTION FOR SECURE CONNECTIONS (TIGHTEN HARDWARE)
2. INSPECTION FOR CORROSION
3. TESTING BATTERY
4. JUMPING (IF REQUIRED)
5. CHARGING (IF REQUIRED)



KEEP TERMINAL ACCESS DOORS CLOSED WHEN NOT IN USE.

DO NOT START ENGINE UNTIL MOWER SUSPENSION BRACKET HAS BEEN RELEASED. SEE MOWER DRIVE BELT INSTALLATION, PAGE 10.

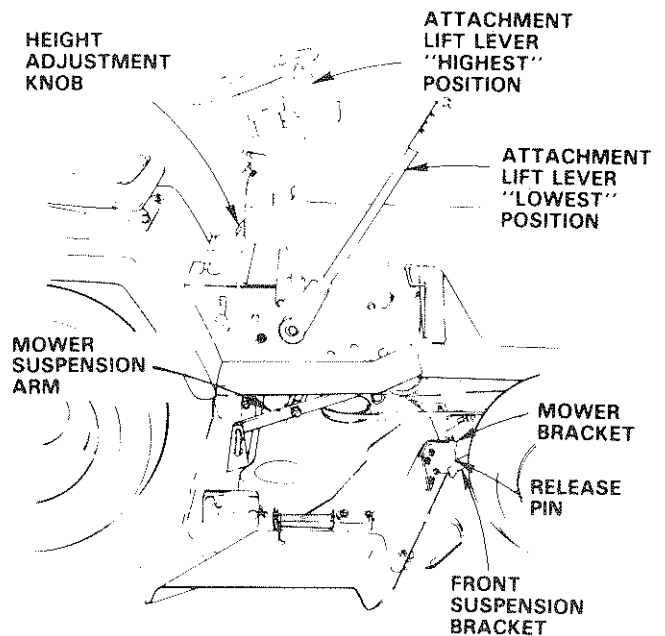


FIGURE 7

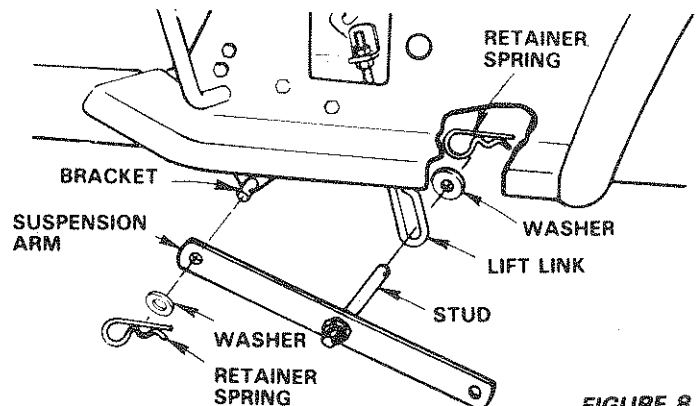


FIGURE 8

ASSEMBLY

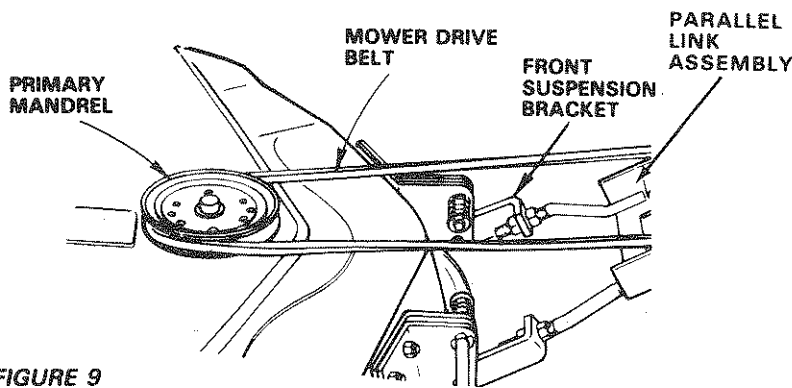


FIGURE 9

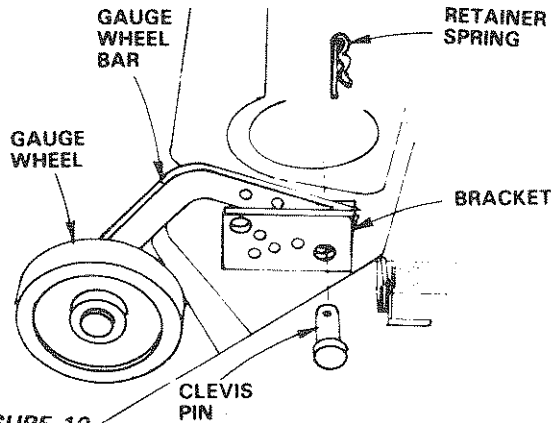


FIGURE 10

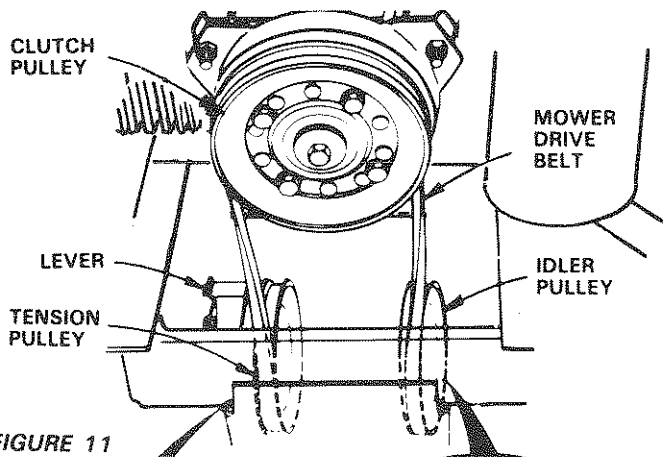
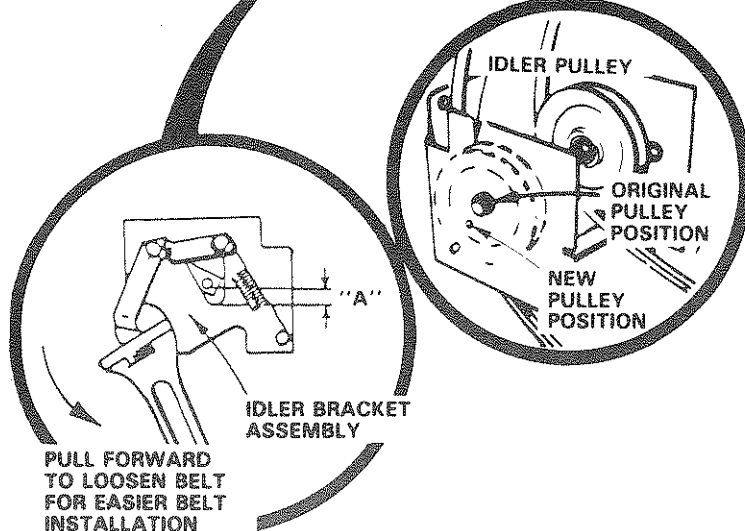


FIGURE 11



6. Mower Installation

- Remove band from mower suspension bracket.
- Remove banding from suspension arms (Fig. 7) and gauge wheels. Set gauge wheels aside for later assembly.
- Slide mower under tractor, deflector to R.H. side.
- Slide front suspension brackets into mower brackets. Retain with release pins (Fig. 7).
- Turn height adjustment knob counterclockwise (↺) until it stops (Fig. 7).
- Move attachment lift lever to lower mower suspension links (page 11).
- Slide studs through lift links on both sides of tractor (Fig 8). Retain with washers and retainer springs (shown full size on page 6) found in bag of parts.
- Place the suspension arms on brackets on both sides of the frame (Fig. 8). Retain with washers and retainer springs found in bag of parts.
- Turn height adjustment knob (Fig. 7) clockwise (↻) to remove slack from mower suspension.
- Roll drive belt over primary mandrel (Fig. 9).
- Insert gauge wheel bar into bracket. Retain with clevis pin and retainer spring found assembled to gauge wheel bracket (Fig. 10). Repeat for other gauge wheel.

7. Mower Drive Belt Installation

- Remove hood and grill (See page 23).
- Place mower drive belt over clutch pulley and under idler pulley and tension pulley (Fig. 11). NOTE: PULL LEVER FORWARD TO SWING TENSION PULLEY FOR BELT CLEARANCE. Make sure narrow "V" side of belt is engaged in each pulley (Fig. 11).
- Pull mower drive belt over front mower suspension bracket (Fig. 7).
- Replace hood and grill.

8. Mower Drive Belt Adjustment

- Lower mower using attachment lift lever.
- If dimension "A" on idler bracket assembly measures 1/4" or less, mower drive belt must be adjusted (Fig. 11-Inset).
- Turn ignition switch off and remove mower drive belt.
- Using two 9/16" wrenches, remove bolt, (2) washers, lockwasher and nut from idler pulley (Fig. 11-Inset) (original position).
- Place v-belt and idler pulley in "NEW" pulley position (Fig. 11-Inset). Replace bolt, (2) washers, lockwasher and nut. Tighten securely.
- Check v-belt for proper installation on all pulley grooves.

9. Check the Cutting Level

The blade housing was set at the factory to cut level. After mowing a short distance, look at the area that was cut. If the blade housing cuts uneven; see the instructions on "Side-to-Side And Front-to-Rear Mower Adjustment" (page 23)".

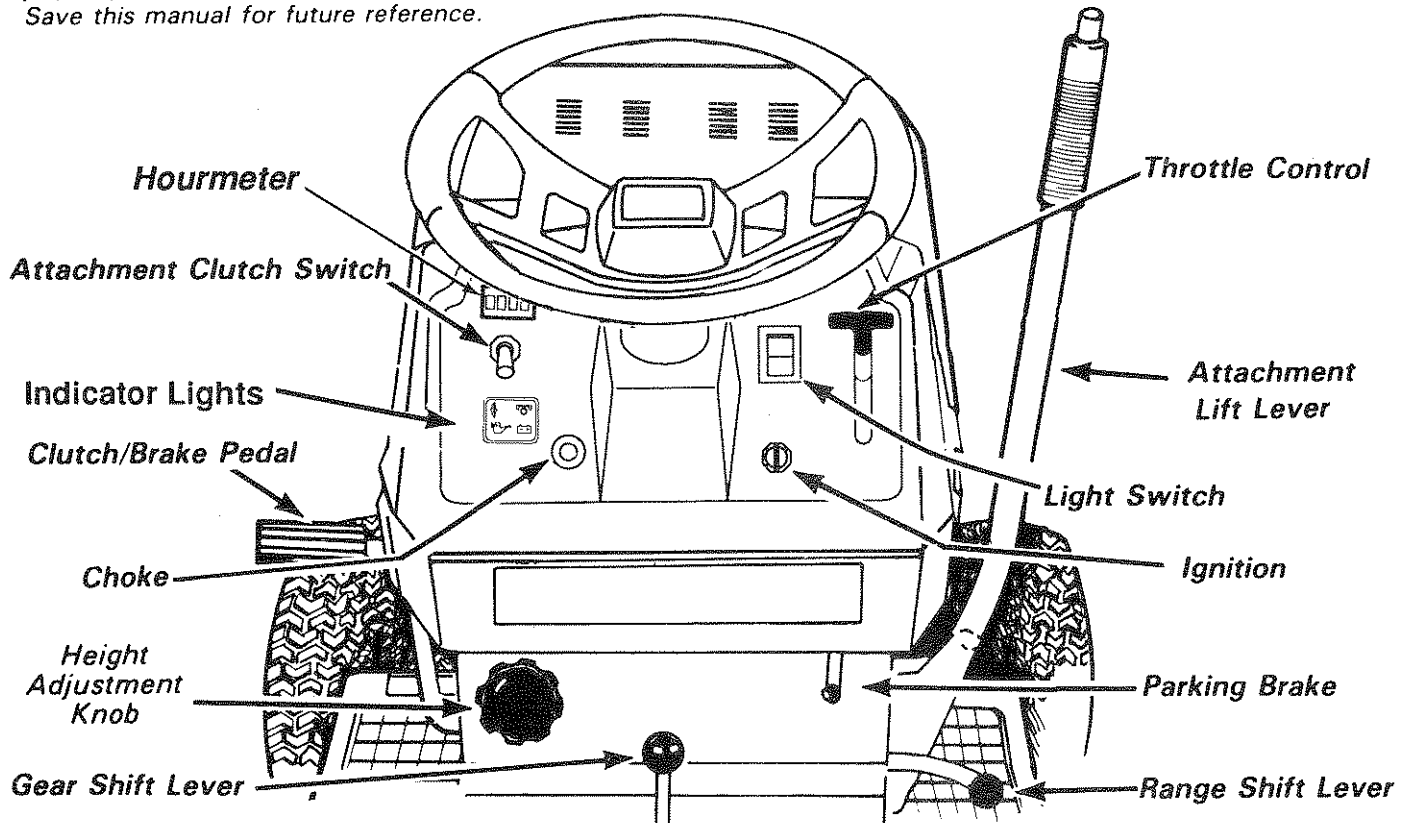
10. Final Assembly

- Make sure all fasteners are tight.
- Read and follow the operation instructions (page 11). Know the location and purpose of all controls.
- Check oil and gasoline (page 12) before starting the tractor.

KNOW YOUR TRACTOR

OPERATION

READ THIS OWNER'S MANUAL BEFORE OPERATING YOUR GARDEN TRACTOR. If you understand the machine and its operation, you will achieve efficient and peak performance. While reading the manual, compare the illustrations with your Garden Tractor to familiarize yourself with the location of various controls and adjustments. Study the operating instructions and safety precautions thoroughly to insure proper functioning of your Garden Tractor and to prevent injury to yourself and others. Be sure to pay strict attention to all notes and cautions; they are included for your safety. Save this manual for future reference.



THROTTLE CONTROL: Use the throttle control to increase or decrease the speed of the engine.

ATTACHMENT CLUTCH SWITCH: Pull switch out and up to engage attachment. There will be an engine hesitation as the clutch engages.

ATTACHMENT LIFT LEVER: Use the attachment lift switch to raise and lower the attachment mounted to your tractor.

LIGHT SWITCH: Turns on and off the headlights.

CHOKER: To start a cold engine, pull choke out to engage.

CLUTCH/BRAKE PEDAL: The pedal has 2 functions: a clutch and a brake. To engage the brake push the pedal down completely.

HEIGHT ADJUSTMENT KNOB: Use the height adjustment knob to adjust the mower height. With attachment lift lever in the full "UP" position, turn clockwise (↻) to raise mower and counterclockwise (↻) to lower mower.

GEARSHIFT: Press the clutch/brake pedal down firmly and move gear shift lever to desired speed.

IGNITION: Place key in ignition and turn to the right to start.

HOURMETER: Indicates the number of hours of operation.

INDICATOR LIGHTS: "DEPRESS FOOT PEDAL" indicates that the clutch/brake pedal must be depressed before engine will start. "DISENGAGE ATTACHMENT" indicates that the attachment must be disengaged before the engine will start. "CHECK OIL" is a low oil pressure warning light. "BATTERY DISCHARGING" indicates there is insufficient battery charging.

PARKING BRAKE LOCK: To set the parking brake, push the clutch/brake pedal completely forward. Place the parking brake lever in "Engaged" position and release pressure from pedal. Clutch/brake pedal will remain in brake position.

RANGE SHIFT LEVER: The Hi-Lo range shift lever gives you the versatility of 6 speed selections: Lo 1, 2, 3, and Hi 1, 2, 3.

IMPORTANT

IF "CHECK OIL" LIGHT COMES ON WHILE ENGINE IS RUNNING, SHUT TRACTOR OFF IMMEDIATELY. RUNNING ENGINE WITH THIS LIGHT ON CAN CAUSE SEVERE ENGINE DAMAGE. REFER TO TROUBLESHOOTING, PAGE 25.

OPERATION

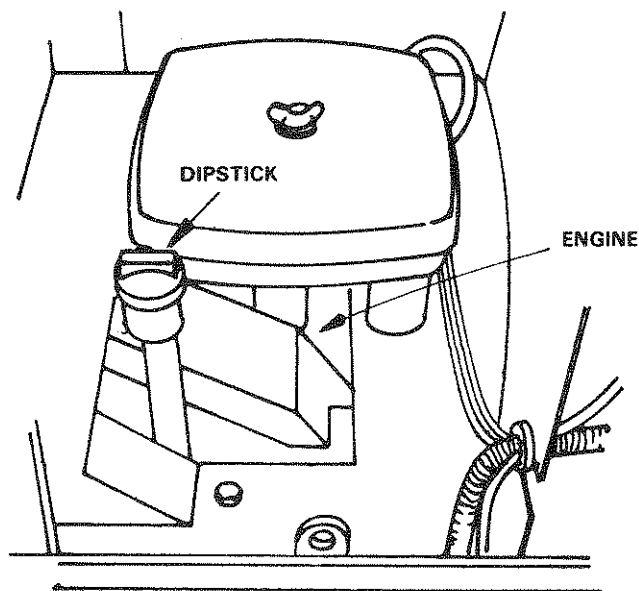


FIGURE 12

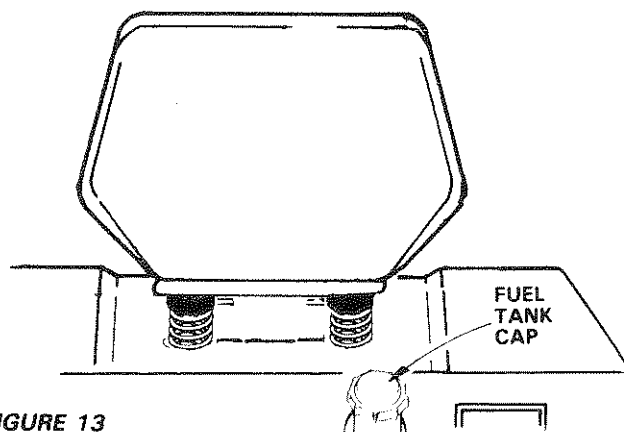


FIGURE 13

1. Stopping Your Tractor

NOTE: REMOVE KEY WHEN LEAVING TRACTOR TO PREVENT UNAUTHORIZED USE.

- Push clutch/brake pedal (page 11) into full "BRAKE" position.
- Place parking brake (page 11) in "ENGAGED" position and release pressure from clutch/brake. Pedal should remain in "BRAKE" position. NOTE: MAKE SURE PARKING BRAKE WILL HOLD TRACTOR IN PLACE.
- Move gear shift lever (page 11) to "NEUTRAL" position.

- Place attachment clutch switch (page 11) in "DIS-ENGAGED" position.
- Move throttle control (page 11) to "S" (slow) position.
- Turn ignition key (page 11) to "OFF" position. Never use choke to stop engine.

2. Starting The Engine



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

NOTE: THIS TRACTOR IS EQUIPPED WITH INTERLOCK SWITCHES TO PREVENT STARTING OF THE TRACTOR ENGINE WHILE THE ATTACHMENT CLUTCH OR THE CLUTCH/BRAKE PEDAL IS ENGAGED.



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

- This engine has been shipped filled with summer weight oil (for cold weather operation see Chart page 16). Check engine oil level with tractor on level ground. Wipe dipstick (Fig. 12) clean, screw it in tight for a few seconds, remove and read oil level. If necessary, add oil until "FULL" mark is reached. See chart page 16.
- Fill fuel tank (Fig. 13). Use fresh, clean, regular unleaded automotive gasoline. (Use of leaded gasoline will increase carbon and lead oxide deposits and reduce valve life). Capacity is 3-1/2 gallons.

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

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

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


- Place attachment clutch switch (page 11) in "DIS-ENGAGED" position.
- Push clutch/brake pedal (page 11) fully into brake position.

OPERATION

- e. Place gear shift lever in "N" neutral (page 11).
- f. Place range shift lever in "N" neutral position (page 11).
- g. Pull choke out (page 11).
- h. Move throttle control to middle position (page 11).
- i. Turn ignition to "START" position until engine starts (page 11). **NOTE: DO NOT RUN STARTER CONTINUOUSLY FOR MORE THAN FIFTEEN SECONDS PER MINUTE.** If engine does not start after several attempts, move throttle control to "F" position, wait a few minutes and try again.
- j. After engine is warm, push choke in.


The first time you start the engine, it will take extra cranking time to move fuel from tank to engine. **NOTE: ALLOW ENGINE TO WARM UP FOR A FEW MINUTES BEFORE ENGAGING CLUTCH/BRAKE PEDAL OR ATTACHMENT CLUTCH SWITCH.**

- k. When restarting a warm engine, move throttle control midway between "S" (slow) and "F" (fast) position. Choke may not have to be used.

 **BEFORE DRIVING THE TRACTOR, INSTALL MOWER OR REMOTE FRONT PARALLEL LINK ASSEMBLY AND RAISE MOWER SUSPENSION ARMS TO HIGHEST POSITION (Fig. 9).**

WARNING

1. Keep all shields in place.
2. Before leaving operator's position:
 - a. Shift transmission to neutral.
 - b. Depress clutch/brake pedal and set parking brake.
 - c. Disengage attachment clutch switch.
 - d. Shut off engine.
 - e. Remove ignition key.
3. Wait for all movement to stop before servicing machine.
4. Keep people and pets a safe distance away from machine.
5. Always wear substantial footwear and avoid loose fitting clothing that could get caught in moving parts.

 **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.

CAUTION: DO NOT ADD ADDITIONAL WEIGHT TO THE TRACTOR OTHER THAN THE OPTIONAL WHEEL WEIGHTS. EXCESSIVE WEIGHT MAY OVERLOAD AND DAMAGE THE TRANSMISSION.

DEPTH
ADJUSTMENT
KNOB

PLUNGER

ATTACHMENT
LIFT LEVER

RETAINER
SPRING

GAUGE WHEEL

CLEVIS PIN

FIGURE 15

3. Operating Your Tractor and Mower

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



READ THE "SAFETY RULES" CAREFULLY BEFORE OPERATING YOUR MOWER.

Use the height adjustment knob (page 11) to adjust mower height. Move the attachment lift switch to the full "UP" position, turn height adjustment knob clockwise (↻) to raise cutting height and counterclockwise (↻) to lower cutting height. Fully lower attachment to check adjustment.

- a. To adjust gauge wheels (Fig 15) lower attachment.
- b. Remove retainer spring and clevis pin from gauge wheels.
- c. Move gauge wheels to the adjustment hole that will provide the desired cut.
- d. Replace retainer spring and clevis pin.
- e. With engine running and warm, place throttle control midway between "S" (slow) and "F" (fast) position (page 11).
- f. Move attachment to its full "UP" position.
- g. To engage mower pull attachment clutch switch (page 11) out and up.
- h. Move range shift lever to "LO" (low) position (page 11).
- i. Move gear shift lever to desired gear (page 11).
- j. Use attachment lift switch to lower mower into cutting position.
- k. Release clutch/brake pedal **SLOWLY** to start movement.
- l. Start mowing at slow and increase ground speed by increasing throttle as conditions will permit.

NOTE: BRING TRACTOR TO COMPLETE STOP BEFORE SHIFTING GEARS.

OPERATION




FUNCTION	GEARSHIFT	THROTTLE
Normal Mowing	2H* or 3L*	
Heavy Mowing	1H or 2L	 FAST
Snow Removal	1L	
Tilling	1L	SLOW
Dozing	1L	
Grading	2L	
Transport	3H	SLOW-FAST

FIGURE 16

* Indicates Range Shift Lever position "H" for High, "L" for low

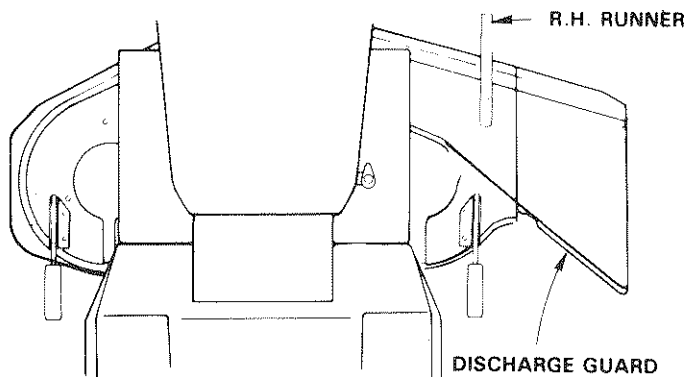


FIGURE 17

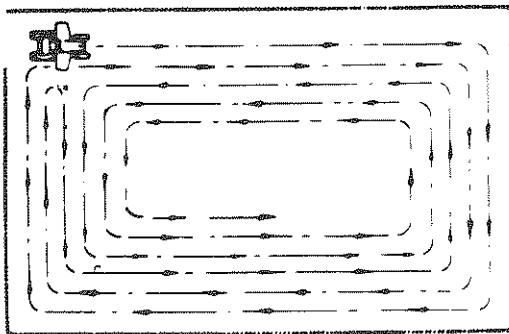


FIGURE 18

4. Mowing Tips

NOTE: TIRE CHAINS CANNOT BE USED WITH THE MOWER HOUSING ATTACHED



READ THE "SAFETY RULES" CAREFULLY BEFORE OPERATING YOUR MOWER. REFER TO PAGE 2.

- Use the runner on the R.H. side as a guide; the blade cuts approximately an inch outside the runner (Fig. 17).
- Drive so that clippings are discharged onto the area that has been cut. Have the cut area to the right of the machine. This will result in a more even distribution of clippings and more uniform cutting.
- When mowing large areas (Fig. 18), start by turning to the right so that the clippings will be discharged away from shrubs, fences, driveways, etc. After two or three rounds, mow in the opposite direction making left hand turns until finished.
- If grass is extremely tall, it should be mowed twice. The first time cut relatively high. The second time to the desired height.
- The left hand side of mower should be used for trimming.
- Always operate engine at full throttle when mowing.

5. Operating The Tractor On Hills

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



DO NOT DRIVE UP OR DOWN HILLS WITH SLOPES GREATER THAN 15° AND DO NOT DRIVE ACROSS ANY SLOPE. REFER TO PAGE 55.

- Avoid stopping or shifting on hills.
- If slowing is necessary, move throttle control lever to middle position.



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

- If stopping is absolutely necessary, push clutch/brake pedal quickly to brake position and engage parking brake.
- To restart your tractor, make sure tractor is in 1st gear and that you have allowed room to roll slightly downhill. Disengage parking brake and release clutch/brake pedal SLOWLY to start tractor forward movement.
- Make all turns slowly.

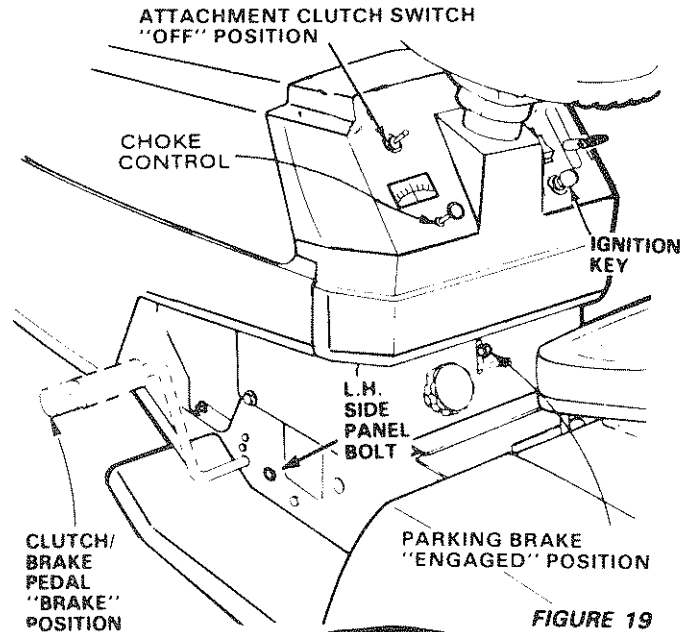
To keep your tractor running better, longer, perform necessary service using the following maintenance schedule:

BEFORE MAKING ANY INSPECTION, ADJUSTMENT OR REPAIR: (FIG. 19):

1. PUSH TRACTOR CLUTCH/BRAKE PEDAL COMPLETELY INTO BRAKE POSITION.
2. MOVE GEAR SHIFT CONTROL LEVER TO NEUTRAL POSITION.
3. PLACE PARKING BRAKE IN "ENGAGED" POSITION. REMOVE FOOT FROM PEDAL.
4. TURN OFF ATTACHMENT CLUTCH SWITCH.
5. SHUT OFF THE ENGINE.
6. MAKE ABSOLUTELY SURE THE BLADES AND ALL MOVING PARTS HAVE COMPLETELY STOPPED.
7. DISCONNECT THE SPARK PLUG WIRES FROM THE SPARK PLUGS AND KEEP WIRES AWAY FROM THE SPARK PLUGS TO PREVENT INJURY FROM ACCIDENTAL STARTING. BE CAREFUL TO AVOID TOUCHING HOT ENGINE OR MUFFLER COMPONENTS.



- # MAINTENANCE
- g. With oil in crankcase, start engine and check for leaks around the filter element. Retighten only as much as necessary to eliminate leaks. Do not overtighten.
 - h. Shut down engine and re-check oil level. Add as necessary to bring up to full mark.



With Every Mowing

1. Make sure all nuts on bolts are tight and cotter pins and retainer springs are secure.
2. Observe all safety precautions.
3. Keep Tractor well lubricated (refer to page 18).

First Two Hours (Two Mowings)

1. CHANGE ENGINE OIL

Changing oil after the first two hours (or two mowings) will help eliminate break-in residue which might be damaging to your engine.

NOTE: BE CAREFUL NOT TO ALLOW DIRT TO ENTER THE ENGINE WHEN CHANGING OIL.

- a. Drain oil with engine warm.
- b. Remove hood and grill (see page 23).
- c. Loosen oil drain wing nut (Fig. 20). Catch oil in a suitable container and discard.
- d. Tighten oil drain wing nut after all oil has been removed from engine.
- e. Refill engine oil. Refill capacity is 3 pints without oil filter change. **NOTE: DO NOT OVERFILL.**
- f. Replace dipstick.

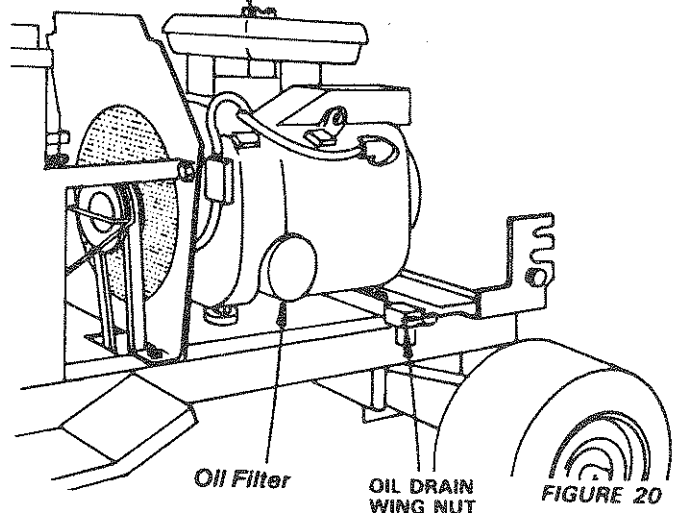
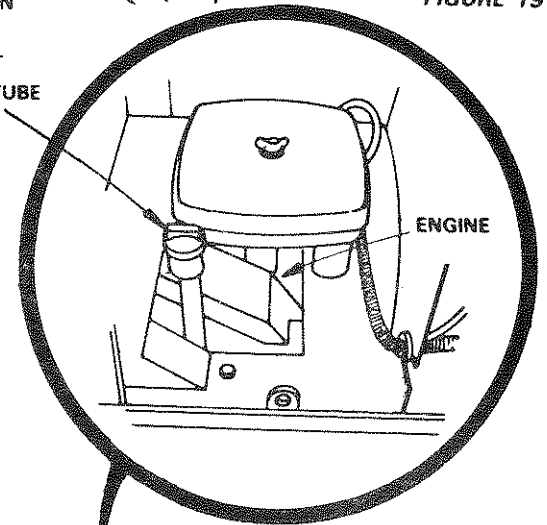
FIRST 25 HOURS

1. CHANGE ENGINE OIL AND OIL FILTER (INITIAL BREAK-IN CHECK).

Refer to Service Record, Page 19 for oil filter change interval. If operating in extremely dusty conditions, change oil filter more often.

- a. Drain oil and discard.
- b. Spin off oil filter element and discard.
- c. Thoroughly clean filter mounting surface and make sure new gasket is inserted in the element.
- d. Apply a thin film of oil to the gasket.
- e. Spin element down by hand until gasket just touches mounting pad. Then turn down an additional 1/4-1/2 turn. Do not overtighten.
- f. Refill engine oil. Refill capacity is 3 1/2 pints with oil filter change.

ENGINE OIL
DIPSTICK
AND FILL TUBE



MAINTENANCE

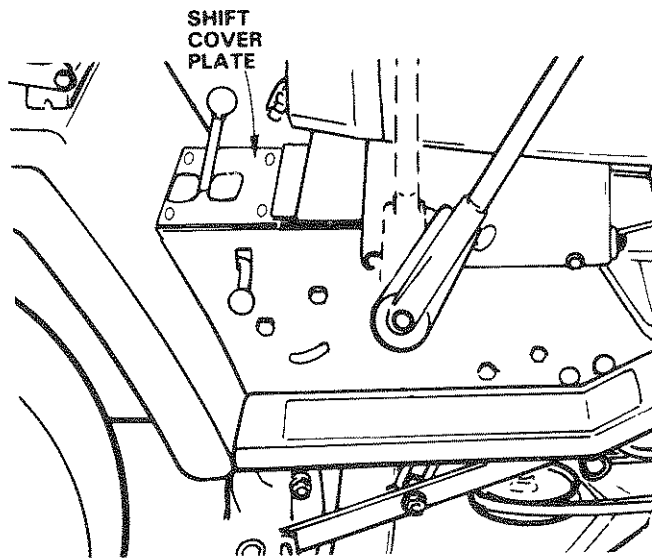


FIGURE 21

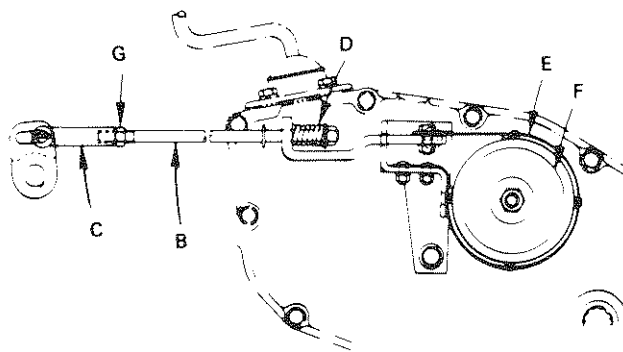


FIGURE 22

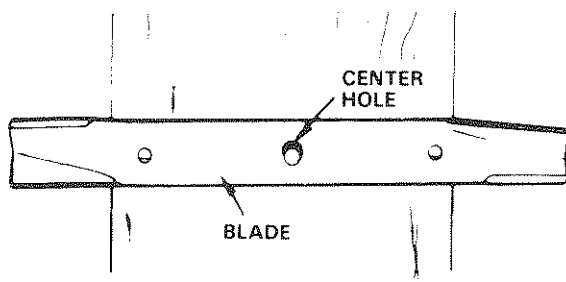
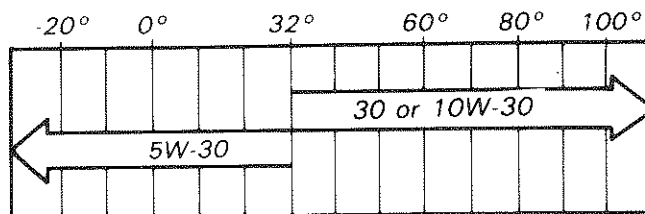


FIGURE 23

Recommended SAE Viscosity Grades

Determine temperature expected before next oil change. All oil must meet A.P.I. service classification SD, SE or SF.



NOTE: DO NOT OVERFILL. Dipstick assembly must be securely tightened into tube at all times when engine is operating.

CAUTION: TO AVOID DAMAGE TO THE STARTING SYSTEM, USE SAE 5W30 OIL WHEN THE TEMPERATURE FALLS BELOW 32°.

f. Replace dipstick.

Every 5 Hours (Five Mowings)

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. 20) clean, screw it down tight for a few seconds, remove and read oil level. If necessary, add oil until "FULL" mark is reached. NOTE: DO NOT OVERFILL.

Every 25 Hours (Twice a Mowing Season)

(Operating in dusty conditions may require more frequent servicing.)

1. Brake Adjustment



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

- Remove (4) hex washer head tapping screws from shift cover plate (Fig. 21), located on top of tractor frame. Remove the cover plate.
- Loosen jam nut (G) on brake rod (B) at clevis (C) (Fig. 22). If you find it difficult to loosen jam nut (G), remove cover plate in L.H. frame rail.
- Rotate brake rod (B) counterclockwise (↺) turning brake rod out of clevis (C) four to six turns.
- Start tractor with transmission in "N" (neutral) position.
- Depress clutch/brake pedal to the point where belt stops moving.

MAINTENANCE

f. Engage parking brake to hold clutch/brake pedal in position. If belt begins to move after engaging parking brake, depress clutch/brake pedal to next notch on parking brake.

g. Shut engine off. Rotate brake rod (B) clockwise (↻) by hand, turning brake rod into clevis (C), until tight. Tighten jam nut (G) on brake rod. (B) at clevis (C) (Fig. 22).

h. Reinstall shift cover plate and four (4) mounting screws. Replace cover plate if removed in step (b).

2. Tire Care

Maintain tire pressure in front at 14 PSI and rear tires at 10 PSI.

3. Blade Care

For best results mower blades must be kept sharp. The blades can be sharpened with a few strokes of a file or on a grinding wheel. We suggest they be sharpened after every 25 hours of mowing. Do not attempt to sharpen while on mower.

- When grinding, care should be taken to maintain blade balance and the blade should be checked for proper balance before reinstallation on mower.
- Unbalanced or bent blade will cause excessive vibration when running and eventual damage to mower or engine. Replace bent or damaged blades.

To check blade balance, drive a nail into a beam or wall. Leave about one inch of the straight nail exposed. Place center hole of clean blade over the head of the nail (Fig. 23). NOTE: CENTER HOLE OF BLADE ON NAIL. IF BLADE IS PROPERLY BALANCED, BLADE SHOULD REMAIN IN POSITION SHOWN IN FIG. 23. IF EITHER END OF THE BLADE MOVES DOWNWARD, BLADE IS NOT BALANCED, SHARPEN THE HEAVY END UNTIL THE BLADE IS BALANCED.

Every 50 Hours (Once a Mowing Season)

(Operating in dusty conditions may require more frequent servicing)

1. Check Battery

- Battery Acid level in each battery cell should be even with bottoms of tubes in cells (Fig. 24). Add only distilled water if necessary. NOTE: DO NOT OVERFILL. DO NOT ADD ACID.
- Keep battery and terminals clean. Refer to page 18.
- Keep battery bolts tight.
- Keep vent caps tight and small vent holes in caps open.
- Recharge at 6 amperes for 1 hour if necessary.

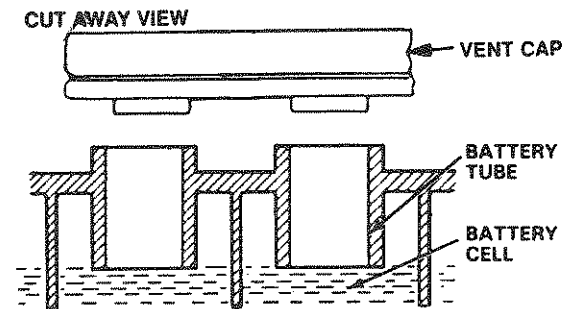


FIGURE 24

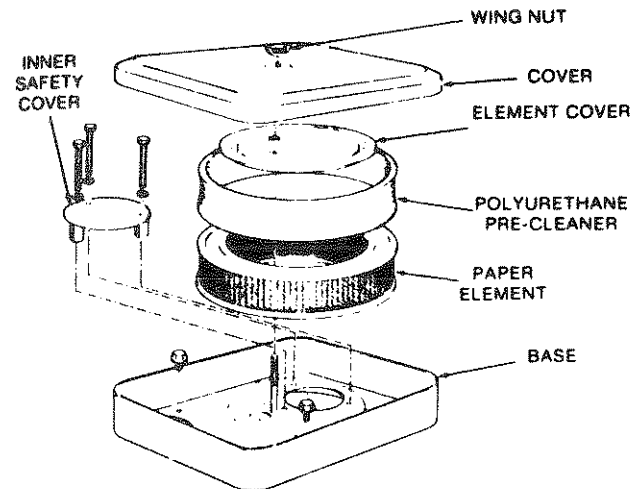


FIGURE 25



FIGURE 25A

2. Clean Air Filter

- Unscrew knob (Fig. 25) to remove cover.
- Remove polyurethane pre-cleaner.
- Wash foam pre-cleaner in detergent and water.
- Rinse, squeeze (rather than twist) allow to dry thoroughly. (Fig. 25A).
- Coat with three tablespoons of S.A.E. 30 engine oil squeeze to distribute evenly and squeeze out excess.
- Check paper cartridge. Replace if excessively dirty.
- Reassemble paper cartridge and re-position on tractor. NOTE: NEVER RUN ENGINE WITH AIR FILTER REMOVED AS DIRT (DUST) WILL DAMAGE THE ENGINE.

MAINTENANCE

3. 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 terminal guard.
- b. Remove the battery from the tractor and wash with baking soda and water. **NOTE: BE CAREFUL NOT TO GET THE SODA SOLUTION INTO THE CELLS.**
- c. Clean terminals and cable ends with a wire brush until bright.
- d. Rinse the battery with plain water, dry and reinstall on tractor.
- e. Replace cables and terminal guard. Refer to page 8.

4. Change Engine Oil

The best time to drain engine oil is at the end of a day's operation when all dirt and foreign materials are suspended in the hot oil. Refer to page 15.

5. Change Oil Filter

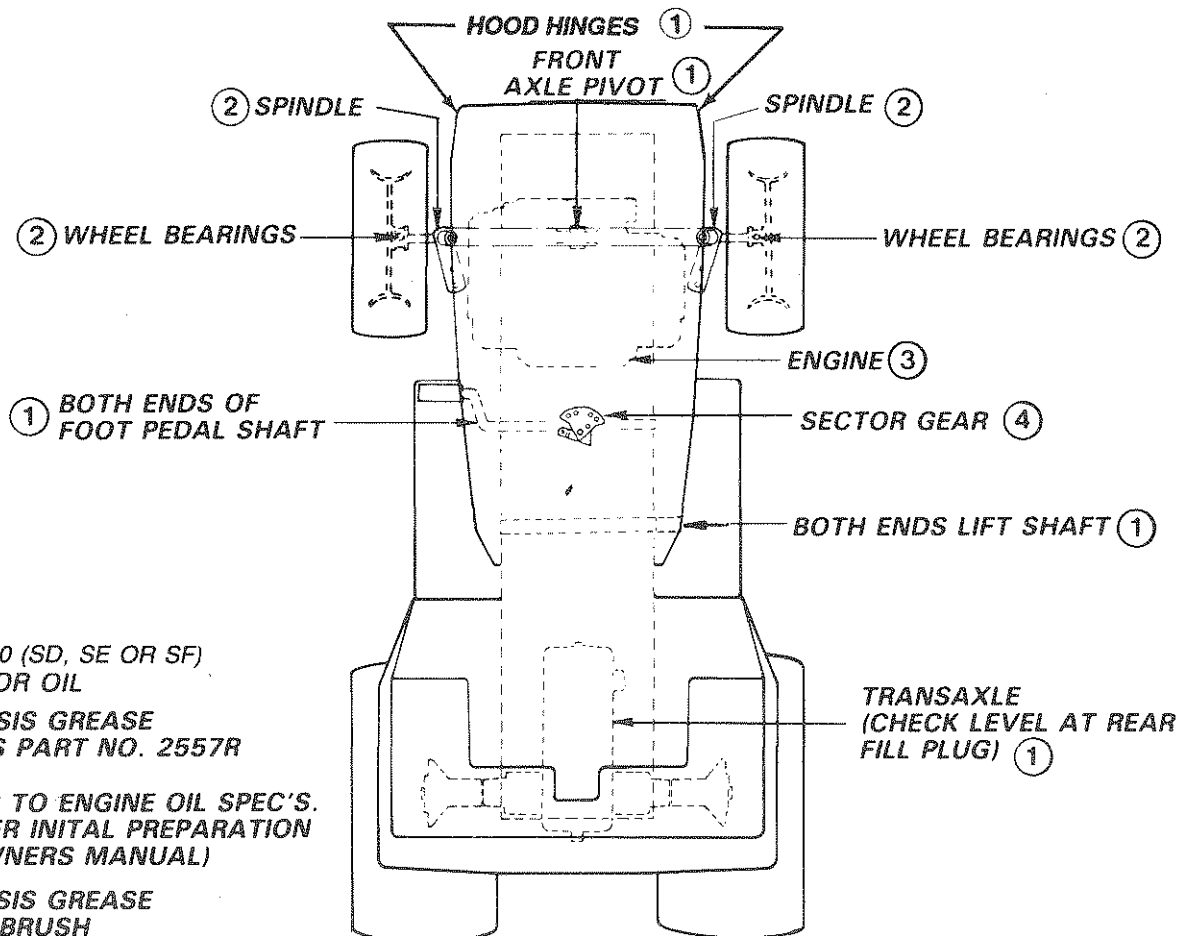
If operating in extremely dusty conditions, change oil filter more often. Refer to Page 15.

6. Lubricate Pivot Points

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

- a. Front Axle Pivot
- b. Hood Hinges
- c. Foot Pedal Shaft (both ends)
- d. Lift Shaft (both ends)
- e. Steering Plate

Lubrication Chart



MAINTENANCE

7. Clean Air Screen

Air screen (Fig. 26) must allow free-flow of air to prevent engine damage from overheating. Clean with a wire brush or compressed air to remove dirt, stubborn dried gum and fibers.

8. Clean Front Grill

Brush debris from front grill to allow free-flow of air, preventing engine damage from overheating.

9. Lubricate Steering and Front Wheels

There are four grease fittings on your tractor (Fig. 27). Using a grease gun, give each grease fitting two shots of chassis grease (available through your Sears Service Center). Sears Part No. 2557R.

10. Check Muffler

Inspect and replace corroded muffler as it could create a fire hazard and/or engine damage.

EVERY 100 HOURS (Every Two Years)



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

1. Replace Spark Plugs

Replace spark plugs at the beginning of each season or every 100 hours, whichever comes first. (Replacement information found on page 47) Gap should be set at .025 inch (Fig. 28).

EVERY 200 HOURS (Every 4 Years)

1. Replace Air Filter Paper Cartridge

Refer to page 17.

2. Replace Fuel Filter

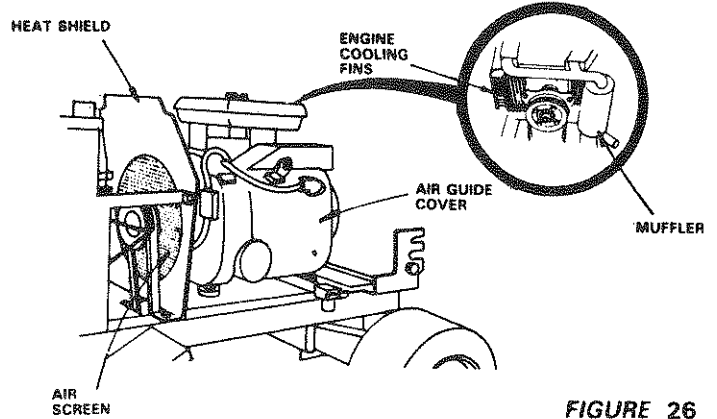


FIGURE 26

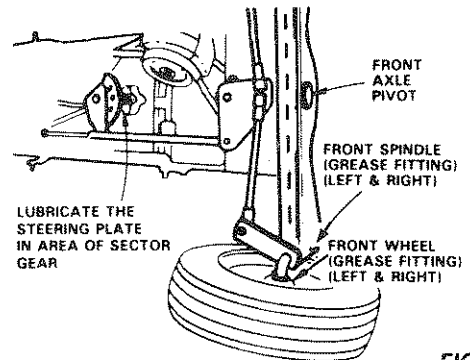


FIGURE 27

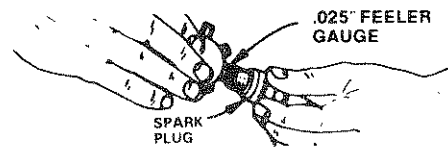


FIGURE 28

SERVICE RECORD

SERVICE RECORD	SCHEDULE						
	FIRST 2 HOURS	FIRST 25 HOURS	EVERY 5 HOURS	EVERY 25 HOURS	EVERY 50 HOURS	EVERY 100 HOURS	EVERY 200 HOURS
Blades				X			
Brake Adjustment				X			
Check Battery					X		
Change Engine Oil	X				X		
Check Engine Oil Level			X				
Clean Air Cleaner Element				X			
Check Muffler					X		
Clean Air Screen					X		
Clean Front Grill					X		
Lubricate Tractor					X		
Replace Spark Plugs						X	
Replace Air Cleaner Element And Fuel Filter							X
Check tire inflation pressure				X			
Change Engine Oil Filter And Engine Oil		X				X	


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

REPAIR AND ADJUSTMENT

1. Starting Your Tractor with a Weak 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 BATTERY.**

- Connect each end of the RED cable to the POSITIVE (+) terminals of each battery (taking care not to short against chassis). (Fig. 29).
- Connect one end of the BLACK cable to the NEGATIVE (-) terminal of fully charged battery.
- Connect the other end of the cable to L.H. side panel bolt (Fig. 19). NOTE: KEEP AWAY FROM GAS TANK AND BATTERY.
- Disconnect cables in reverse order:
 - L.H. Side Panel Bolt (Fig. 19).
 - Negative Terminal of fully charged Battery
 - Positive Terminals

IMPORTANT: DO NOT USE YOUR BATTERY TO START OTHER VEHICLES.

2. Carburetor

All carburetors have a fixed main jet. An optional main jet is available for altitude compensation above 5,000 feet.

The carburetor idle mixture was set for maximum efficiency at the factory and should normally not be disturbed. If adjustments seem necessary, first be sure the ignition system is working properly and governor sensitivity is properly adjusted.

The carburetor has a limited adjustment range between stops of $\pm\frac{1}{8}$ turn. The screw should only be adjusted within these limits; in to lean the mixture, out to richen.

When replacing idle mixture screw, turn in until lightly seated, then turn screw back out $1\frac{1}{4}$ turns. Replace limiter cap with the plastic stop approximately centered.

3. Throttle Control Cable and Carburetor Adjustment

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

REFER TO "STARTING THE ENGINE", PAGE 12.

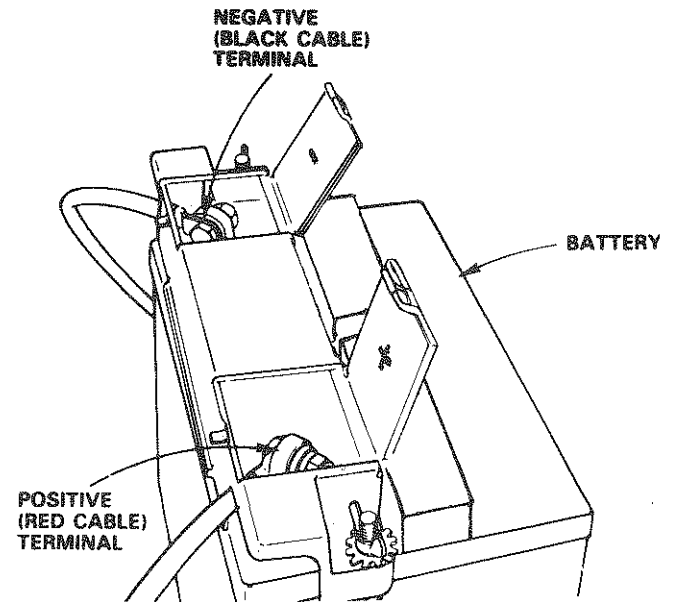


FIGURE 29

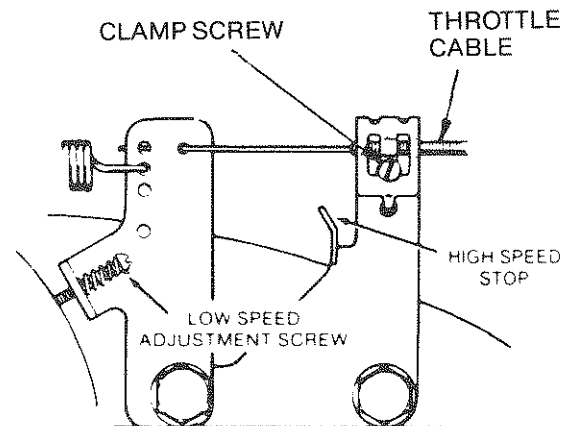


FIGURE 30

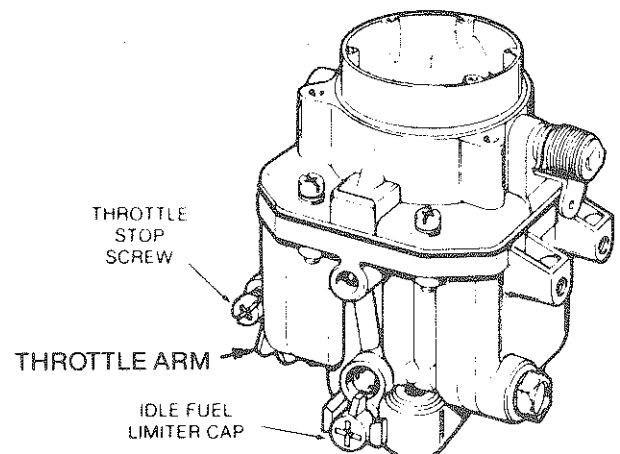


FIGURE 31

REPAIR & ADJUSTMENT

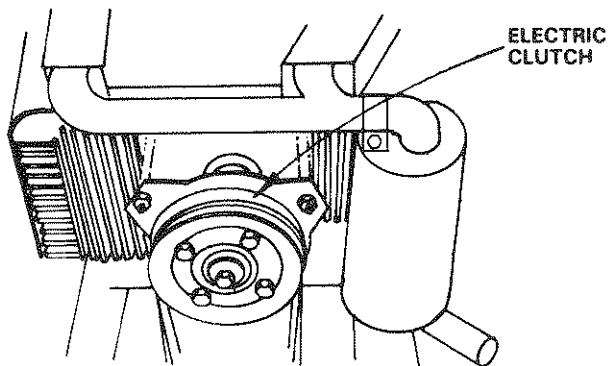


FIGURE 32

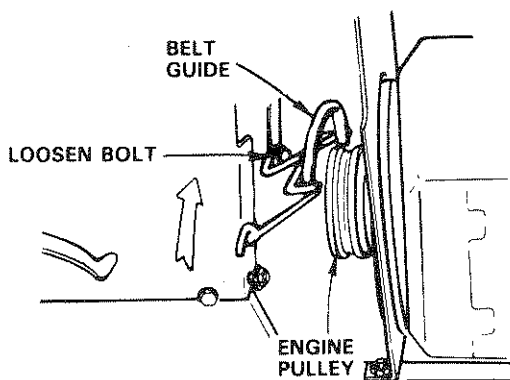


FIGURE 33

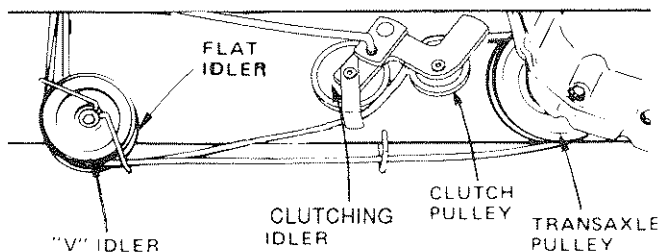


FIGURE 34

- Start the engine and allow it to warm up thoroughly (at least 10 minutes.)
- Loosen clamp screw so throttle cable is free to move (Fig. 30).
- Move throttle (on dashboard) to "slow" position.
- Hold throttle arm against stop screw and adjust throttle stop screw to 1000-1100 RPM (Fig. 31).
- Adjust the governor low speed adjustment screw for 1400 RPM idle (Fig. 30).
- Tighten clamp screw to secure throttle cable

4. Electric Clutch Adjustment

The electric clutch (Fig. 32) should provide years of service. The clutch incorporates a built-in brake that stops the pulley almost immediately. Eventually, the internal brake will wear so the mower blades will not stop as recommended. Adjustment must be made by a Sears Service Technician.

5. Motion Drive Belt Removal

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

- Raise hood and disconnect negative ground battery cable.
- Set parking brake (to get belt slack).
- Loosen (do not remove) two engine pulley belt guide bolts and swivel R.H. side of belt guide up. Tighten L.H. bolt to hold belt guide in position (Fig. 33).
- Roll belt off engine pulley.
- Roll belt off "V" idler, flat idler and adjustable idler pulleys (Fig. 34).
- Pull belt off clutch pulley - between pulley and frame.

6. Motion Drive Belt Replacement

NOTE: THERE IS A BELT INSTALLATION DECAL UNDER L.H. FOOTREST.

- Push belt down from engine pulley area. Place back (flat) side of belt on flat idler. (Flat idler is next to frame).
- Place belt on adjustable idler and over clutch pulley. "V" (narrow) part of belt should engage clutch pulley.

REPAIR AND ADJUSTMENT

- c. Place belt around transaxle pulley. "V" part of belt should engage transaxle pulley.
- d. Make sure "V" part of belt engages "V" idler.
- e. Roll belt over engine pulley.
- f. Loosen L.H. engine pulley belt guide bolt and swivel belt guide bolt and swivel belt guide onto R.H. bolt. Tighten L.H. and R.H. bolts securely (Fig. 35).
- g. Release parking brake. NOTE: WHEN A NEW BELT HAS BEEN INSTALLED, YOU MUST CHECK V-BELT ADJUSTMENT AND BRAKE ADJUSTMENT.

Idler Bracket Removal

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

- a. Pull belt up through idler bracket and out of tractor. Use lever to swing tension pulley for belt removal.
- b. Remove lockwashers and nuts from idler bracket (Fig. 36).

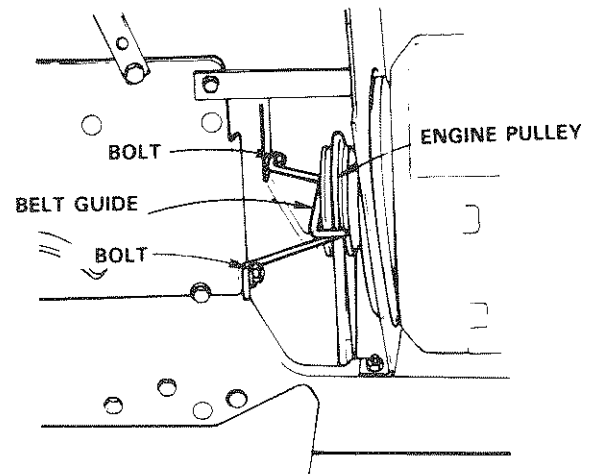


FIGURE 35

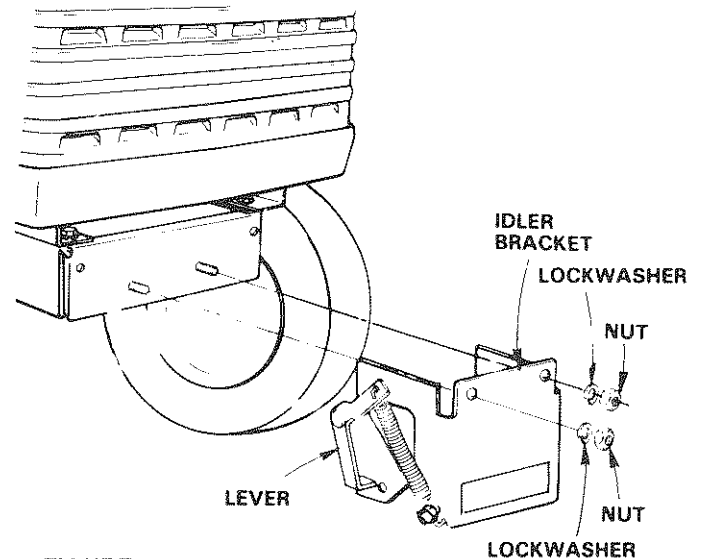


FIGURE 36

REPAIR AND ADJUSTMENT

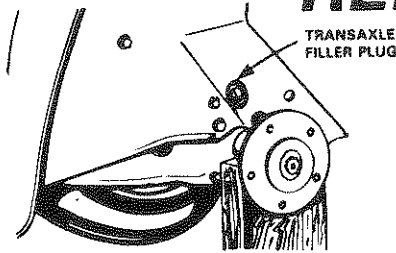


FIGURE 37

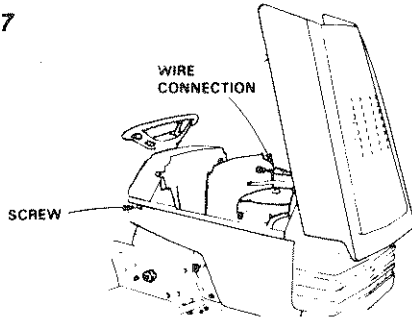


FIGURE 38

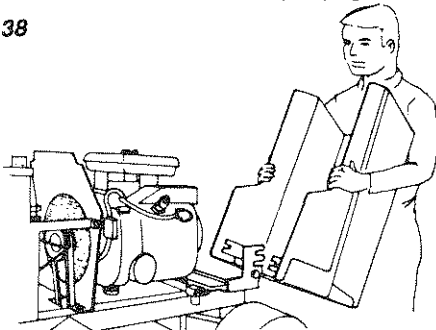


FIGURE 39

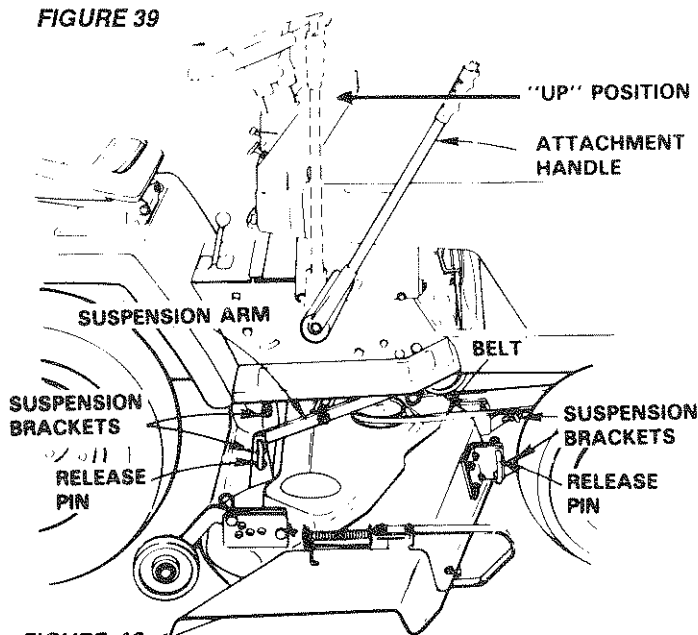


FIGURE 40

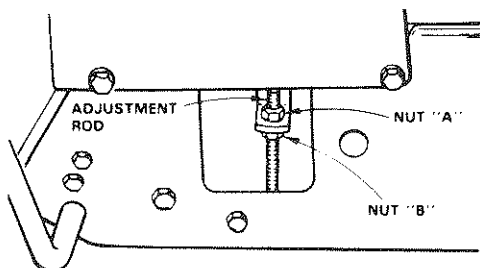


FIGURE 41

9. Fuse Replacement

Replace with 30 amp automotive - type, plug-in fuse. Fuses can be purchased at all Sears Service Centers and most retail stores.

10. Check Transaxle Oil Level

- Block up rear axle (Fig. 37) securely or use a tractor jack.
- Remove left rear wheel by removing hub bolts.
- Remove filler plug (Fig. 37) from transaxle. Oil level must be even with plug threads. See your Sears Service Center if additional oil is required. Replace filler plug.
- Reposition wheel. Secure with hub bolts.

11. Hood Removal

- Lift hood. Disconnect headlight wiring connection (Fig. 38).
- Unscrew one screw at rear of each side panel (Fig. 38).
- Pivot hood and side panel forward and lift off tractor (Fig. 39).
- To replace, reverse the above procedure.

12. Mower Removal

- Lower mower.
- Pull the four (4) release pins out of suspension brackets (Fig. 40).
- Move the attachment to the full "UP" position. The suspension arms will lift out of the suspension brackets.
- Slide mower forward and remove belt from primary mandrel.
- Slide mower out from under tractor.

NOTE: IF AN ATTACHMENT OTHER THAN THE MOWER DECK IS TO BE MOUNTED ON THE TRACTOR, REMOVE THE FRONT PARALLEL LINK ASSEMBLY (Fig. 42).

13. Level Mower Housing

Adjust the mower while tractor is parked on level ground or driveway. Make sure tire pressures are 14 PSI in front; 10 PSI in rear.

Side to Side Mower Adjustment

- Move attachment to full "UP" position.
- Use a ruler to make sure bottom of curl at rear of mower deck are the same height from the ground on each side (Fig. 43).
- If adjustment is required, snap out access cover on L.H. side of tractor above footrest (Fig. 41).
- To raise left side of mower, loosen nut "B" and screw nut "A" down on adjustment rod.
- Adjust until both rear mower flanges are the same height above the ground. Tighten nuts "A" and "B" securely.
- Snap access cover in place.

REPAIR AND ADJUSTMENT

Front to Rear Mower Adjustment

Move attachment to full "UP" position. After leveling side to side, measure bottom of curl at FRONT AND REAR OF MOWER. The bottom of curl at the R.H. front flanges should measure 3/4" lower than at the R.H. REAR flange (Fig. 43). If adjustment is required follow the procedure below.

- To raise front of mower loosen nuts "D". Screw nuts "C" up onto suspension arms (Fig. 42). NOTE: SCREW NUTS "C" ON BOTH SUSPENSION ARMS THE SAME NUMBER OF TURNS SO MOWER WILL REMAIN LEVEL. Tighten nuts "D" securely.
- To lower front of mower loosen nuts "C". Screw nuts "D" down suspension arms. NOTE: SCREW NUTS "D" THE SAME NUMBER OF TURNS SO MOWER WILL REMAIN LEVEL. Tighten nuts "C" securely.
- Use depth adjustment knob to set mower at the approximate cutting height you need.
- With mower deck at desired height, set gauge wheels (Fig. 44) to lowest position without touching the ground.
- Use clevis pin (Fig. 44) to set gauge wheels at lowest point without touching the ground.

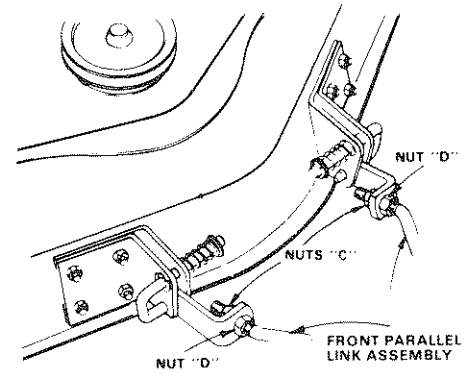


FIGURE 42

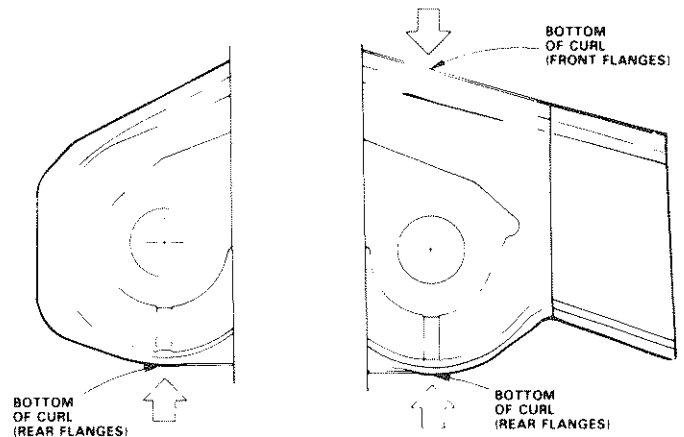


FIGURE 43

14. Blade Drive Belt Removal and Replacement

BELT ROUTING DECAL UNDER MOWER DECK COVER.

- Remove mower from tractor (see page 23).
- Remove top cover self tapping screws, lockwashers and nuts from idler arm bolt.
- Roll belt over the top of the R.H. mandrel.
- Pull belt off all other mandrels.
- Remove any dirt and grass which may have accumulated around mandrels and idler arm.
- Check deck idler arm assembly and flat idler to see that they rotate freely (Fig. 45).
- Be sure spring is hooked in deck idler arm assembly and on bolt in mower housing (Fig. 45).
- Install new belt in groove of L.H. mandrel sheave and through belt retainer, in lower groove of center mandrel sheave and around flat idler as shown (Fig. 45).
- From a position at discharge end of mower, roll belt into groove of R.H. mandrel sheave (Fig. 45).
- Rotate center mandrel sheave by hand to make sure belt is in grooves properly.

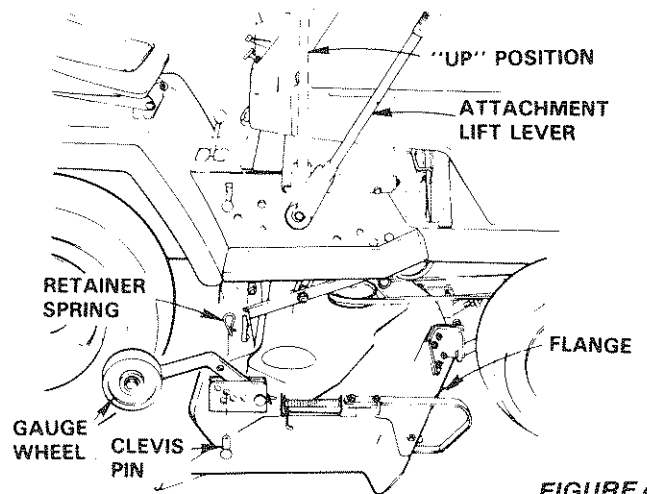


FIGURE 44



BLADES WILL ROTATE WITH CENTER MANDREL SHEAVES.

- Reassemble top cover to deck. Tighten all screws securely.
- Install mower to tractor (see page 10).

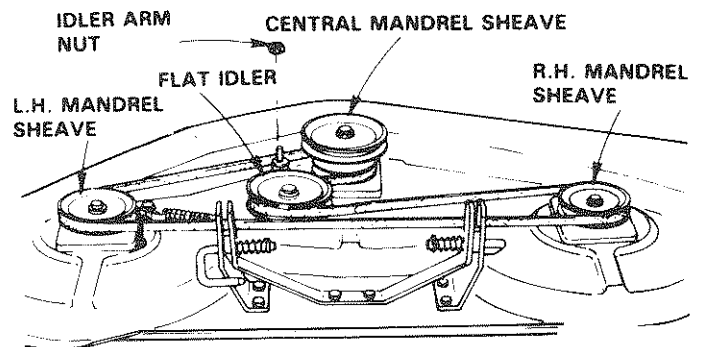


FIGURE 45

REPAIR AND ADJUSTMENT

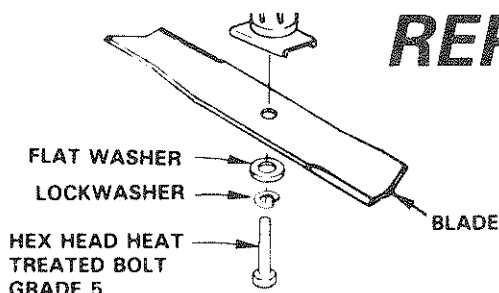


FIGURE 46

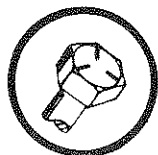
16. Blade Replacement

It is not necessary to remove mower from tractor for blade replacement. Moving adjustment lift lever to up (Rear) position will permit access to blades.

- Remove the hex head bolt, lockwasher and flat washer (Fig. 46).
- Remove and discard old blade.
- Clean top and bottom of mower housing.
- Install new blade with SHARP EDGE DOWN and secure with flat washer, lockwasher and hex head bolt. TIGHTEN SECURELY.



ALWAYS USE GRADE 5 HEAT TREATED BOLTS TO ATTACH BLADES. CHECK BOLTS IN BLADES OCCASIONALLY TO MAKE SURE BOLTS ARE TIGHT. TORQUE BOLTS 30 - 35 FT. LBS.



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

17. Storage

Remove mower from tractor for winter storage. When mower is to be stored for a period of time, clean it thoroughly, remove all dirt, grease, leaves, etc. Store in a clean dry area.

A. Fuel System

IT IS IMPORTANT TO PREVENT GUM DEPOSITS FROM FORMING IN ESSENTIAL FUEL SYSTEM PARTS SUCH AS THE CARBURETOR, FUEL FILTER, FUEL HOSE, OR TANK DURING STORAGE. ALSO, EXPERIENCE INDICATES THAT ALCOHOL BLENDED FUELS (CALLED GASOHOL OR USING ETHANOL OR METHANOL) CAN ATTRACT MOISTURE WHICH LEADS TO SEPERATION AND FORMATION OF ACIDS DURING STORAGE. ACIDIC GAS CAN DAMAGE THE FUEL SYSTEM OF AN ENGINE WHILE IN STORAGE. TO AVOID ENGINE PROBLEMS, THE FUEL SYSTEM SHOULD BE EMPTIED BEFORE STORAGE FOR 30 DAYS OR LONGER.

B. Engine Oil

Drain (with engine warm) and replace with clean engine oil, (See chart page 16).

C. Cylinders

- Remove spark plugs.
- Pour one ounce of oil through spark plug holes into cylinders.
- Turn ignition key to "START" position for a few seconds to distribute oil.
- Replace with new spark plugs. (Replacement information located on page 47)

D. Battery

- Prior to storage, clean terminals and top of battery.
- After a period of time in storage, battery may require recharging.

E. General Cleaning

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

F. Store in a Clean Dry Area

TROUBLESHOOTING

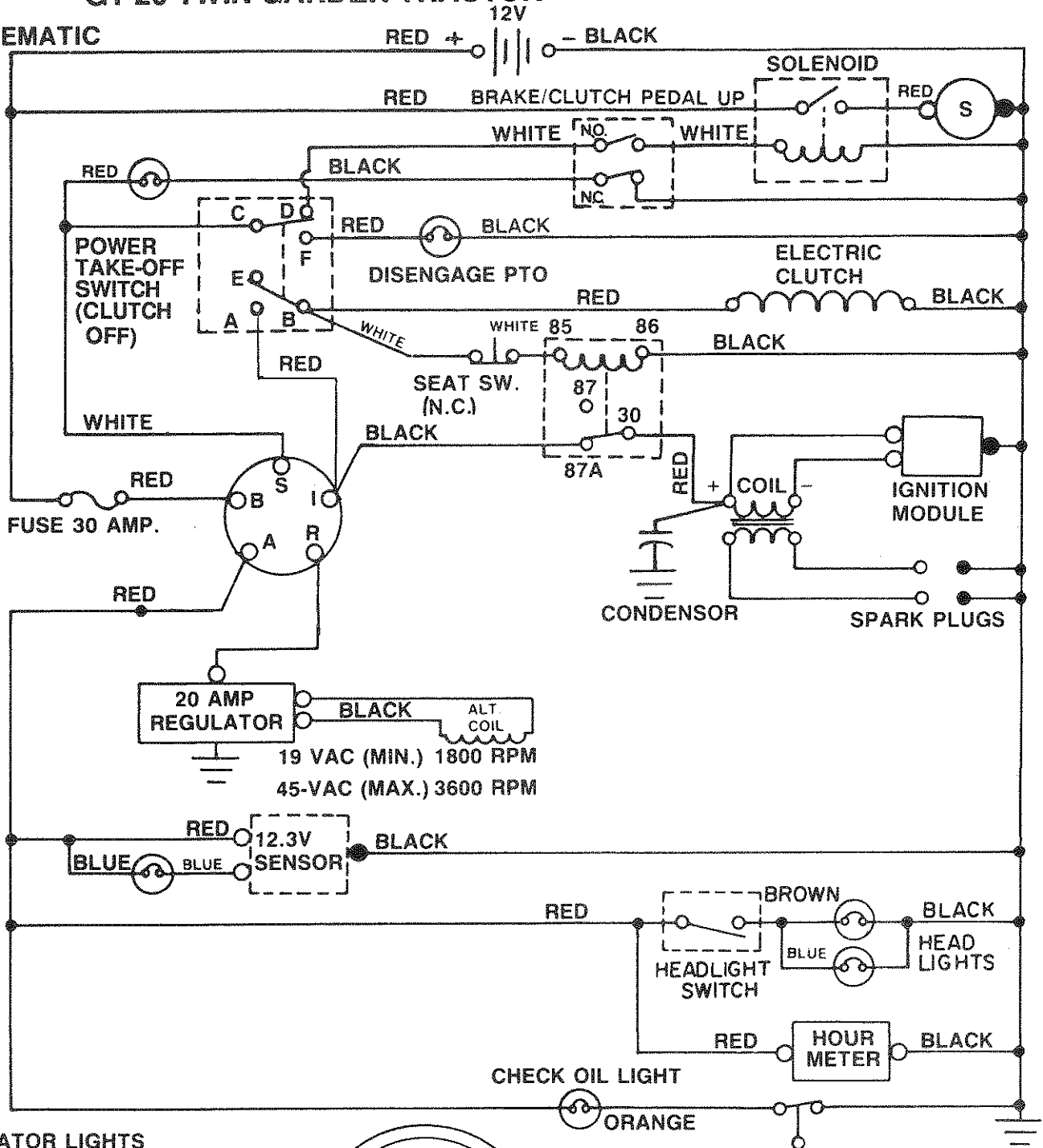
PROBLEM	CAUSE/ REMEDY (SEE INDEX)
WILL NOT TURN OVER	Push Clutch/Brake Pedal into Brake Position. Move Attachment Clutch Switch to "Disengaged Position" Charge Battery Replace Ignition Switch Engage Interlock Switch Replace Interlock Switch Replace Solenoid Replace Fuse Check All Wire Connections
WILL NOT START	Fill Tank with Gasoline. Check Fuel Line and Carburetor (clean if necessary) Replace Fuel Filter Check fuse for fault and replace Recharge or replace Battery Check Wiring Replace Spark Plugs and adjust gap
ENGINE CLICKS BUT WON'T START	Charge or Replace Battery Check or Replace Starter
HARD TO START	Place Throttle Control in "FAST" position and run starter several times to clear out gas Remove and clean Fuel Tank and lines. Replace Fuel Filter Remove Air Filter and clean Replace Spark Plugs and adjust gap Replace Battery Check the wiring and Spark Plugs Drain Fuel Tank and Carburetor, use fresh fuel and replace Spark Plugs Make necessary adjustments to Carburetor Major Engine Overhaul Check Valve Lash

TROUBLESHOOTING

PROBLEM	CAUSE/ REMEDY (SEE INDEX)
ENGINE MISSES OR LACKS POWER	Shift to a lower gear or reduce load Remove and clean Tank; replace Fuel Filter Remove and clean Air Cleaner Make necessary carburetor adjustments Clean Air Screen Replace Spark Plugs Add or change oil Check Spark Plugs and check for any loose wires Check Valve Lash or Major Engine overhaul Drain Gas Tank and Carburetor and refill
ENGINE OVERHEATS	Clean Air Screen Add or change oil Clean Engine Cooling Fins Remove and clean Muffler or replace Remove and clean Air Filter Use fresh fuel and adjust Carburetor
NO LIGHTS	Check Fuse, Switch and Wire Connections. Replace Headlight Bulbs
INDICATOR LIGHTS LIT	"Check Oil": Check Oil Level Check Oil Pump. Oil could be too light or diluted. "Battery Discharging": Move throttle control to fast position. "Depress Foot Pedal": Push clutch/brake pedal into brake position. "Disengage Attachment": Move attachment clutch switch to "Disengaged" position
UNSATISFACTORY MOWER PERFORMANCE UNEVEN DISTRIBUTION OF CLIPPINGS	Check air pressure in tires Check front to rear and side to side mower adjustment Use a slower ground speed Replace mower blades Reinstall mower blades with top of blades up Re-adjust mower drive belt Clean underside of mower deck Sharpen blades
MOWER BLADES WILL NOT ROTATE	Install new Mower Drive Belt Reinstall Mower Drive Belt Replace Attachment Clutch Switch Replace Frozen Mandrel Replace Frozen Pulley
EXCESSIVE MOWER VIBRATION	Replace Bent or Unbalanced Blade Replace Mandrel, Straighten Deck or replace
WIND ROWING STRIPPING OR DROPPING OF GRASS CLIPPINGS	Let grass dry out Clean underside of Mower Deck Level Mower Replace Blades
UNEVEN CUT OR SCALPING	Level Mower Adjust Gauge Wheels Replace Blades
WON'T CHARGE	Check for Fuse fault and replace Replace Battery Replace Regulator Replace Alternator
OPERATOR PRESENCE SYSTEM WILL NOT SHUT DOWN ENGINE WHEN OPERATOR LEAVES SEAT NOTE: THIS TRACTOR IS EQUIPPED WITH AN OPERATOR PRESENCE SENSING SYSTEM. ANY ATTEMPT BY THE OPERATOR TO LEAVE THE SEAT WITH THE ENGINE RUNNING AND THE ATTACHMENT CLUTCH ENGAGED WILL SHUT DOWN THE ENGINE.	Engage Attachment Clutch Check All Wire Connections Check Seat Switch Check Operator Presence Relay Check PTO Switch

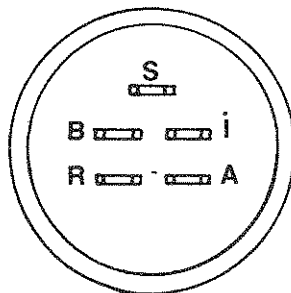
GT 20 TWIN GARDEN TRACTOR -- MODEL NUMBER 917.254490

SCHEMATIC



INDICATOR LIGHTS

- 1 DEPRESS FOOT PEDAL
- 2 DISENGAGE ATTACHMENT
- 3 CHECK OIL
- 4 BATTERY DISCHARGING



IGNITION SWITCH

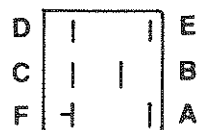
POSITION	CIRCUIT
OFF	
ON	B + I + R + A
START	B + I + R + S

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

8 PSI LOW-PRESSURE SWITCH (N.C.)

PTO SWITCH

POSITION	CIRCUIT MAKE:
OFF	B&E, C&D
ON	B&A, C&F



REPAIR PARTS

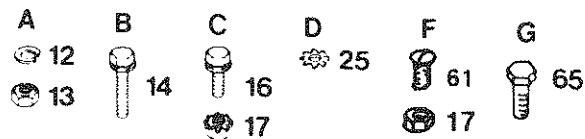
GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

ELECTRICAL

29

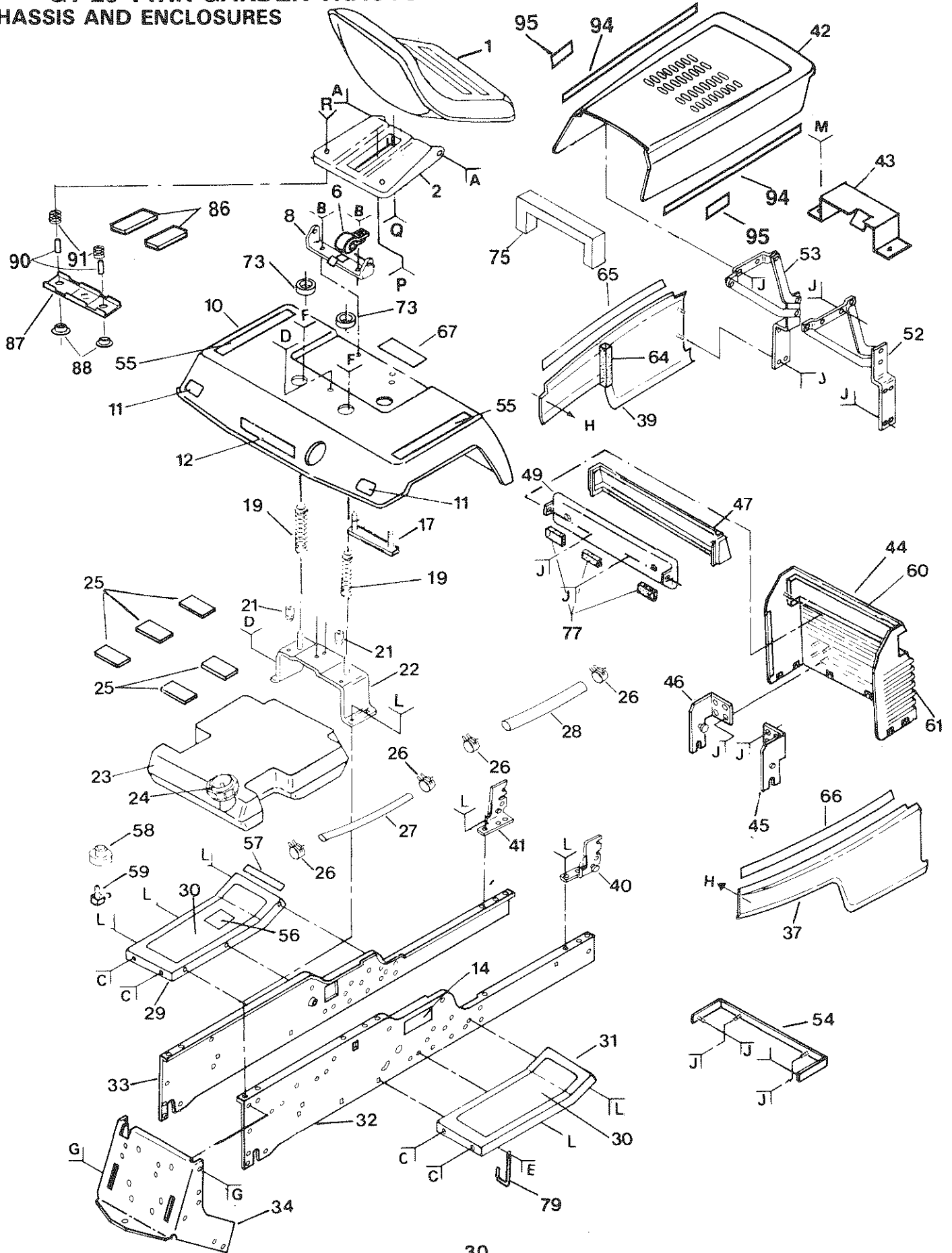
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	109310X	Key	36	STD551137	*Washer - Lock 3/8
2	2683R	Switch - Ignition	37	72240460	Bolt - Carriage 1/4 - 20 x 7-1/2
3	109787X	Bezel - Ignition	39	STD541625	*Nut - Wing 1/4 - 20
4	109788X	Nut - Ignition	40	102476X	Guard - Terminal
5	109555X	Indicator Lights	41	STD522507	*Bolt - Hex 1/4 - 20 x 3/4
6	121433X	Switch - Light <i>121445X</i>	42	STD551025	*Washer 9/32 x 5/8 x 16 Ga.
7	121537X	Battery	43	STD541025	*Nut - Hex 1/4 - 20
8	7603J	Tray - Battery	44	STD551125	*Washer - Lock 1/4
9	100541K	Tube - Drain	<i>15</i> 45	110859X	Harness - Wire
10	109596X	Clamp - Hose	46	121305X	Switch - Seat
11	109081X	Solenoid	47	4171R	Clip-insulated
12	10090400	Washer - Lock 1/4	48	109748X	Relay - Operator Presence
13	STD541225	*Nut - Hex Jam 1/4 - 20	49	120168X	Key, Electric Clutch
14	17190408	Screw - Hex Washer Thread Cutting 1/4 - 20 x 1/2	50	120445X	Counterbalance - Engine
15	109553X	Switch - Interlock	60	110143X	Bulb, Light
16	71031008	Screw - Hex Washer No. 10 - 32 x 1/2	61	74641008	Screw, Pan Hd - #10 - 32 x 1/2
17	73951000	Nut - Keps No. 10 - 32	63	121264X	Battery Caps
18	109554X	Sensor, Low Voltage	65	17011008	Screw Hex Thd. 10 - 24 x 1/2
<i>45</i> 19	121475X	Harness - Ignition	66	120960X	Decal, Battery
20	4152J	Bulb - Headlight	---	101539X	Sheet - Instruction, Tractor 15° Slope
21	108824X	Fuse - 30 Amp	---	123613X	Manual - Owners
22	74610648	Bolt - Hex 3/8 - 24 x 3			
23	STD523707	*Bolt - Hex 3/8 - 16 x 3/4			
24	120606X	Cable - Ground			
25	11050600	Washer - Lock - Ext. Tooth 3/8			
26	109626X	Switch - P.T.O.			
27	4022J	Nut - Hex			
28	120605X	Cable - Battery			
29	719J	Cover - Terminal			
30	110940X	Hourmeter			
31	120604X	Cable - Starter			
32	110880X	Clutch - Electric			
33	110944X	Spacer - Clutch			
34	110881X	Stop - Clutch			
35	19132203	Washer			

* STANDARD HARDWARE - PURCHASE LOCALLY



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490
CHASSIS AND ENCLOSURES

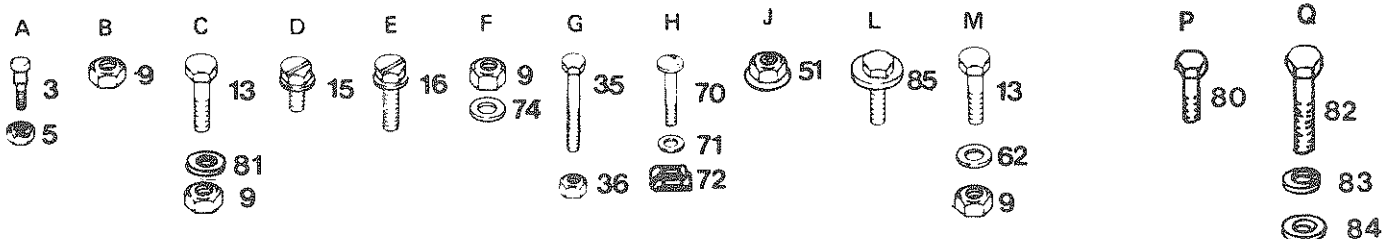


REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

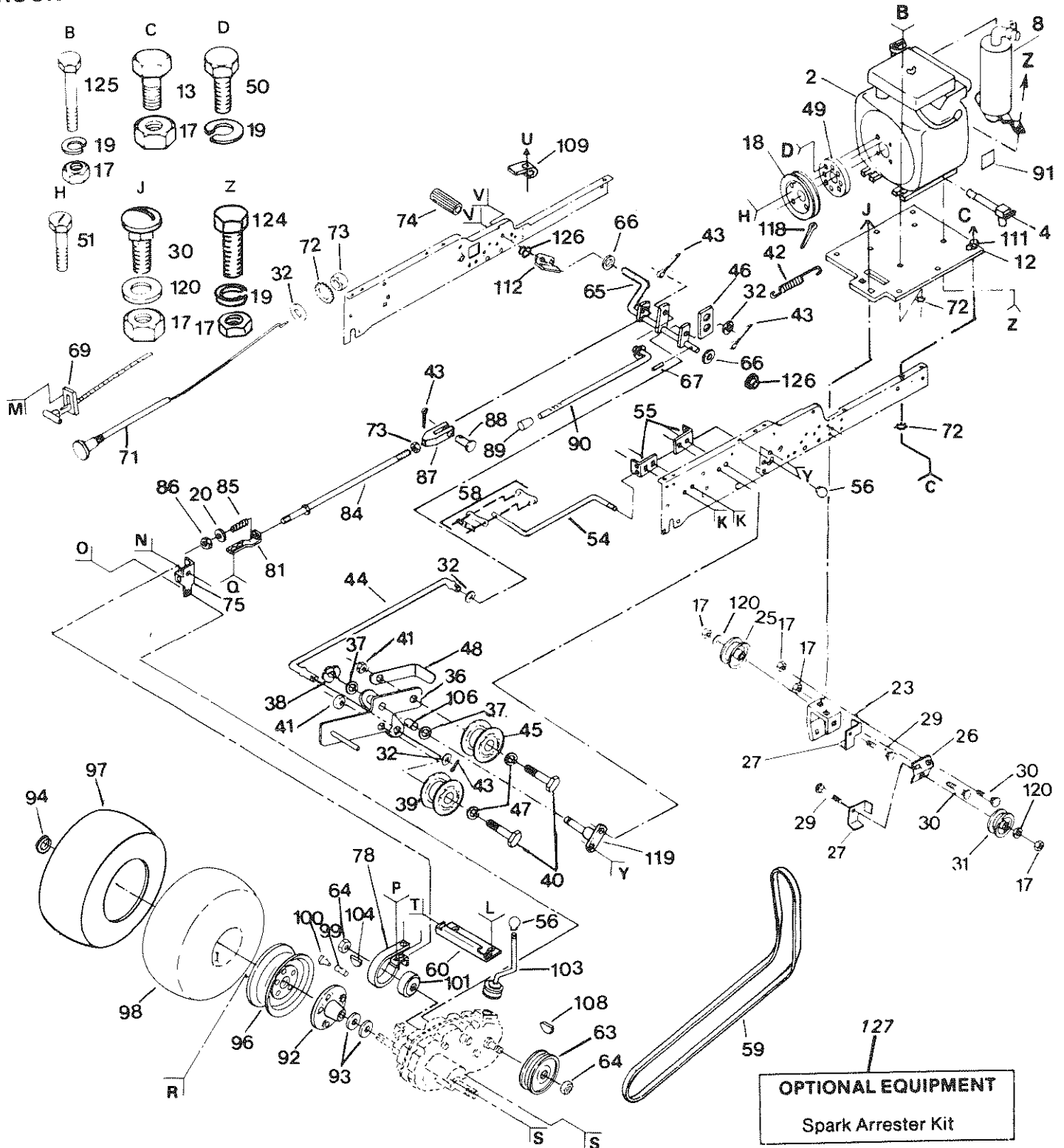
CHASSIS AND ENCLOSURES

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	110900X	Seat	46	108513X	Bracket - Pivot, Grill, L.H.
2	121247X	Pan - Seat	47	110898X	Lens
3	105529X	Bolt - Shoulder	49	110897X	Bezel
5	73680500	Nut - Lock 5/16 - 18	51	108067X	Nut - Pal
6	2751R	Clip	52	106091X	Hinge - R.H.
7	109641X	Grommet	53	106090X	Hinge - L.H.
8	105513X	Bracket - Pivot, Seat	54	110350X361	Strap - Grill
9	73680600	Nut - Lock 3/8 - 16	55	109139X	Decal - Fender
10	121642X	Fender	56	106868X	Decal - Drive Belt Schematic
11	106202X	Reflector - Taillight	57	4900J	Decal - Clutch/Brake
12	105801X	Decal	58	3645J	Bushing
13	STD523707	*Bolt - Hex 3/8 - 16 x 3/4	59	8710J	Stem - Fuel Tank
14	121985X	Decal - Chassis	60	105806X	Decal - Grill
15	17490608	Screw - Hex Washer Thread Rolling 3/8 - 16 x 1/2	61	105568X	Decal - Grill (Stripe)
16	17490616	Screw - Hex Washer Thread Rolling 3/8 - 16 x 1	62	19131416	Washer 13/32 x 7/8 x 16 Ga.
17	105511X	Strap - Fender	64	106088X	Strip - Foam
19	121067X	Spring - Compression, R.H.	65	106813X	Decal - Stripe, Side Panel, L.H.
21	105531X	Nut - Push	66	106814X	Decal - Stripe, Side Panel, R.H.
22	105509X	Bracket - Fender	67	106974X	Decal - Caution
23	106020X	Tank - Fuel	70	106909X	Screw - Special
24	121221X	Cap - Fuel	71	106910X	Washer
25	106082X	Pad - Spacer	72	108402X	U-Clip
26	6999R	Clamp - Hose	73	121093X	Cap, Spring
27	7834R	Line - Fuel	74	19131614	Washer, 13/32 x 1 x 14 Ga.
28	7833R	Line - Fuel	75	106086X	Foam Strip
29	105465X	Footrest - L.H.	77	105036X	Foam Strip
30	105466X	Pad - Footrest	79	105500X	Retainer, Belt, Lower
31	105464X	Footrest - R.H.	80	121144X	Shoulder Bolt, 5/16 - 18 UNC
32	110892X	Rail - Frame - R.H.	81	19131312	Washer 13/32 x 13/16 x 12 Ga.
33	110893X	Rail - Frame L.H.	82	74780816	Screw, Hex., 1/2 - 13 r. 5
34	7982J	Drawbar	83	10040800	Lockwasher, 1/2
35	74760716	Bolt - Hex 7/16 - 14 x 1	84	19171912	Washer, 17/32 x 1 3/16 x 12 Ga.
36	73680700	Nut - Lock 7/16 - 14	85	17490512	Screw Wsh. Thd. Roll 3/8-16 x x3/4
37	108403X	Panel - Side, R.H.	86	121251X	Foam Strip
39	108410X	Panel - Side, L.H.	87	121246X	Switch- Brkt.
40	121054X	Bracket - Pivot, Frame, R.H.	88	121248X	Snap Bushing
41	121055X	Bracket - Pivot, Frame, L.H.	89	72170410	Bolt - Carr. 1/4 - 20 x 11/2
42	106013X017	Hood	90	121249X	Spacer Split
43	110874X	Shield - Heat, Front	91	121250X	Spring
44	120153X	Grill	94	108743X	Decal, Stripe - Hood
45	108512X	Bracket - Pivot, Grill, R.H.	95	110907X	Decal 20 H.P.



REPAIR PARTS
GT 20 TWIN GARDEN TRACTOR -- MODEL NUMBER 917.254490

GROUND DRIVE



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REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

GROUND DRIVE

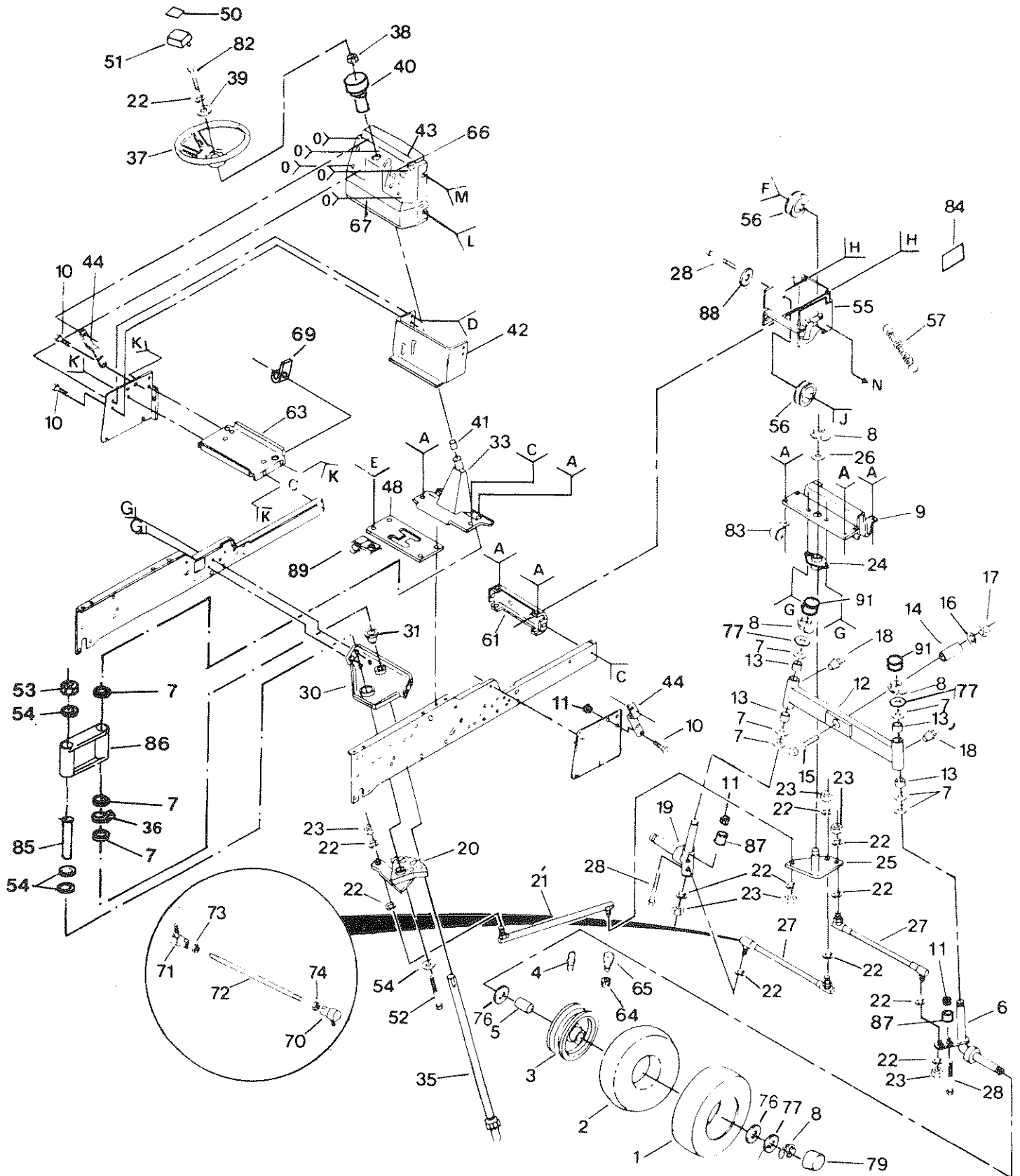
KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
2	121385X	Engine, Model No.739.10896B	67	STD571812	*Pin, Roll, 3/16 x 1 - 1/4
4	110902X	Valve, Oil Drain	69	122759X	Control, Throttle
8	110886X	Muffler	70	17720408	Screw, Hex, Thd. Cut, 1/4-20 x 1/2
12	110866X	Base, Engine	71	121388X	Control, Choke
13	STD523707	*Bolt, Hex, 3/8 - 16 x 3/4	72	11050600	Washer, Lock, Ext. Tooth, 3/8
17	73680600	Nut, Lock, 3/8 - 16	73	STD541137	*Nut, 3/8-24
18	121355X	Pulley, Ground Drive	74	8883R	Cover, Pedal
19	STD551137	*Washer, Lock, 3/8	75	677A637	Bracket, Brake
20	19131614	Washer, 13/32 x 1 x 14 Ga.	76	74370612	Screw, Mach., Unct. Fl. Hd., 3/8 - 16 x 3/4
23	121063X	Bracket, V-Pulley, Drive, Mule	77	74760614	Bolt, Hex, 3/8 - 16 x 7/8
25	101344L	Pulley, Idler	78	7920J	Band, Brake
26	122825X	Bracket, Idler, Flat	79	72140405	Bolt, Carr., 1/4 - 20 x 5/8
27	122824X	Guard, Belt, Mule Drive, Flat Idler	80	STD541025	*Nut, Hex, 1/4 - 20
29	72110614	Bolt Carr., 3/8 - 16 x 1 - 3/4	81	7229J	Guide, Rod, Brake
30	STD533707	*Bolt, Carr., 3/8 - 16 x 3/4	82	1685H	Nut, Lock, 5/16 - 18
31	102403X	Idler, Flat	83	STD533110	*Bolt, Carr., 5/16 - 18 x 3/4
32	STD551037	*Washer, 13/32 x 13/16 x 16 Ga.	84	5308J	Rod, Brake
36	121356X	Bracket, Clutch	85	7241J	Spring, Compression
37	207J	Washer, Hardened	86	73530600	Nut, Lock, 3/8 - 24
38	12000039	Klip Ring	87	100604K	Yoke
39	121361X	Idler, Grooved	88	5102J	Pin, Clevis
40	STD523715	*Bolt, Hex, 3/8 - 16 x 1 - 3/4	89	71673	Cap, Plunger
41	73930600	Nut, Lock, 3/8 - 16	90	109767X	Rod, Parking Brake
42	101355X	Spring, Extension	91	110921X	Decal, Engine
43	STD570907	*Pin, Cotter 3/32 x 3/4	92	634A692	Bushing and Wheel Hub
44	101356L	Rod, Clutch	93	7563R	Washer, Thrust, Axle
45	104360X	Idler, Flat	94	12000034	Klip Ring
46	121358X	Retainer Spring	95	1304H	Bolt, Hub
47	19131413	Washer, 13/32 x 7/8 x 13 Ga.	96	106277X361	Wheel, Rear
48	121360X	Retainer, Belt	97	105588X	Tire, Rear
49	110943X	Adapter	98	7154J	Tube, Tire (Not furnished)
50	STD523710	*Bolt, Hex, 3/8 - 16 x 1 Gr. 5	99	65139	Valve, Tire
51	17190516	Screw, Hex, 5/16 - 18 x 1	100	59192	Cap, Valve
54	122253X	Rod, Shift, Hi-Lo	101	214J	Drum, Brake
55	105598X	Bracket, Rod, Shift	102	STD541410	*Nut - Lock No. 10 - 24
56	100196K	Knob	103	633A109	Gear Shift Lever Assembly
57	73680500	Nut, Lock, 5/16 - 18	104	2228M	Key, Woodruff
58	122268X	Connecting Link	105	74760724	Bolt, Hex 7/16 - 14 x 1 - 1/2
59	110883X	V-Belt	106	105706X	Bearing - Idler
60	120404X	Bracket, Support, Transaxle	108	9858M1	Key - Woodruff
61	74760716	Bolt, Hex, 7/16 - 14 x 1	109	5304J	Actuator - Switch, Interlock
62	STD551143	*Washer, Lock 7/16	110	74321016	Screw - Fin 10 - 24 x 1
63	120332X	Pulley, Transaxle	111	2751R	Clip
64	9204H	Nut, Lock, 1/2 - 20	112	104601X	Bracket - Interlock
65	104375X	Shaft, Foot Pedal	113	STD522507	*Bolt - Hex 1/4 - 20 x 3/4
66	121749X	Washer, 25/32 x 1 - 1/4 x 16 Ga.	114	73680400	Nut - Crownlock 1/4 - 20
			116	73680700	Nut - Crownlock 7/16 - 14
			118	76020816	Pin - Cotter 1/4 x 1
			119	101358K	Bracket - Assembly Clutch
			120	19131612	Washer 13/32 x 1 x 12 Ga.
			122	72140506	Bolt - Carriage 5/16 - 18 x 3/4
			124	74760624	Bolt - 3/8 - 16 x 1 - 1/2
			125	74760620	Bolt - Hex, 3/8 - 16 x 1 - 1/4
			126	110895X	Nyliner
			127	120615X	Spark Arrester Kit

***STANDARD HARDWARE - PURCHASE LOCALLY**

REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

STEERING



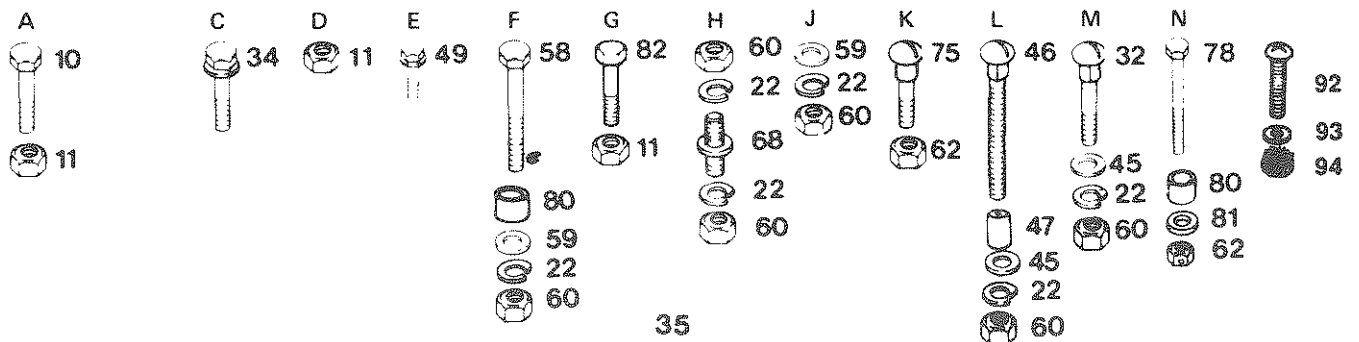
REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

STEERING

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	106230X	Tire, 16 x 6.50	48	106042X012	Cover, Gate, Shift
2	8134H	Tube, Front (not furnished with tractor)	49	17720408	Screw, Hex Washer Thd. Cutting 1/4 - 20 x 1/2
3	106228X	Front Wheel (Inc. Key No. 3 and of Key No. 4)	50	110906X	Decal, Insert
4	278H	Fitting, Grease	51	100710L	Cap, Steering Wheel
5	9040H	Bearing	52	74780880	*Bolt - Hex 1/2 - 13 x 2
6	106045X	Spindle, R.H.	53	73680800	Nut, Lock 1/2 - 13
7	6266H	Bearing, Thrust	54	19172610	Washer 17/32 x 1 - 5/8 x 10 Ga.
8	12000029	Klip Ring	55	120542X	Bracket, Idler
9	5284J	Bracket, Axle	56	677A451	Pulley, Idler
10	STD523707	*Bolt - Hex 3/8 - 16 x 3/4	57	7190J	Spring
11	73680600	Nut, Lock, 3/8 - 16	58	STD523720	*Bolt, Hex 3/8 - 16 x 2 - 1/4
12	674A244	Axle, Front, (Inc. Key No. 13)	59	19131413	Washer 13/32 x 7/8 x 13 Ga.
13	1309H	Bearing	60	STD541037	*Nut - Hex 3/8 - 16
14	5298J	Tube, Pivot, Axle	61	5213J	Bracket, Frame Front
15	74781044	Bolt, Hex 5/8-11 x 2-3/4 Gr. 5	62	73680500	Nut, Lock 5/16 - 18
16	STD551162	*Washer, Lock 5/8	63	7985J	Support, Battery
17	STD541062	*Nut, Hex 5/8 - 11	64	65139	Stem, Valve
18	6855M	Fitting, Grease	65	59192	Cap, Valve
19	106046X	Spindle, L.H.	66	121375X011	Dashplate
20	120424X	Sector Assembly	67	108456X	Decal, Instruction
21	110497X	Link, Drag	68	106615X	Pin, Mounting, Idler Bracket
22	STD551137	*Washer, Lock 3/8	69	2751J	Clip
23	STD541137	*Nut, Hex 3/8 - 24	70	109850X	Joint - Tie Rod - R.H. Thread
24	5292J	Bushing, Bellcrank	71	109851X	Joint - Tie Rod - L.H. Thread
25	108137X	Bellcrank	72	7919J	Rod - Tie
26	19292016	Washer 29/32 x 1 - 1/4 x 16 Ga.	73	73700600	Nut - Hex Jam 3/8 - 24 L.H.
27	109849X	Rod, Tie	74	STD541337	*Nut - Hex Jam 3/8 - 24
28	STD523720	*Bolt, Hex 3/8 - 16 x 2 Gr. 5	75	STD533107	*Bolt - Carriage 5/16 - 18 x 3/4
29	102933X	Spacer, Split	76	121749X	Washer 13/32 x 1 - 1/4 x 7 Ga.
30	102439X	Bracket, Support, Steering	77	121748X	Washer 25/32 x 1 - 5/8 x 16 Ga.
31	104239X	Bearing, Flanged	78	74930516	Bolt, Hex 5/16 - 18 x 1
32	72110608	Bolt, Carr. 3/8 - 16 x 1 Gr. 5	79	104757X	Cap - Hub, Front
33	101274N	Support, Steering	80	100644K	Bushing - Handle
34	17490612	Screw, Hex Washer Thd. Rolling 3/8 - 16 x 3/4	81	19111416	Washer 11/32 x 7/8 x 16 Ga.
35	102458X	Shaft, Steering	82	STD523710	*Bolt - Hex 3/8 - 16 x 1 Gr. 5
36	12000034	Klip Ring	83	100207K	Clip - 3/8
37	121021X	Wheel, Steering	84	108367X	Decal - Adjustment
38	100711L	Adapter, Steering	85	120199X	Tube
39	19133808	Washer	86	121177X	Collar
40	121050X	Sleeve, Steering	87	110946X	Spindle Stop
41	9038R	Bearing	88	19133807	Washer 13/32 x 11/4 x 7 Ga.
42	105519X	Dash, Lower	89	4171R	Clip
43	120028X	Dash	91	121232X	Cap, Spindle
44	105525X	Bracket, Support, Dash	92	74180412	Screw, Mach. Cr. 1/4 - 20 x 3/4
45	19171416	Washer 17/32 x 7/8 x 16 Ga.	93	19091216	Washer 9/32 x 3/4 x 16 Ga.
46	72110622	Bolt - Carr. 3/8 - 16 x 2 - 3/4	94	73510400	Nut Keps 1/4 - 20 UNC
47	121235X	Spacer			

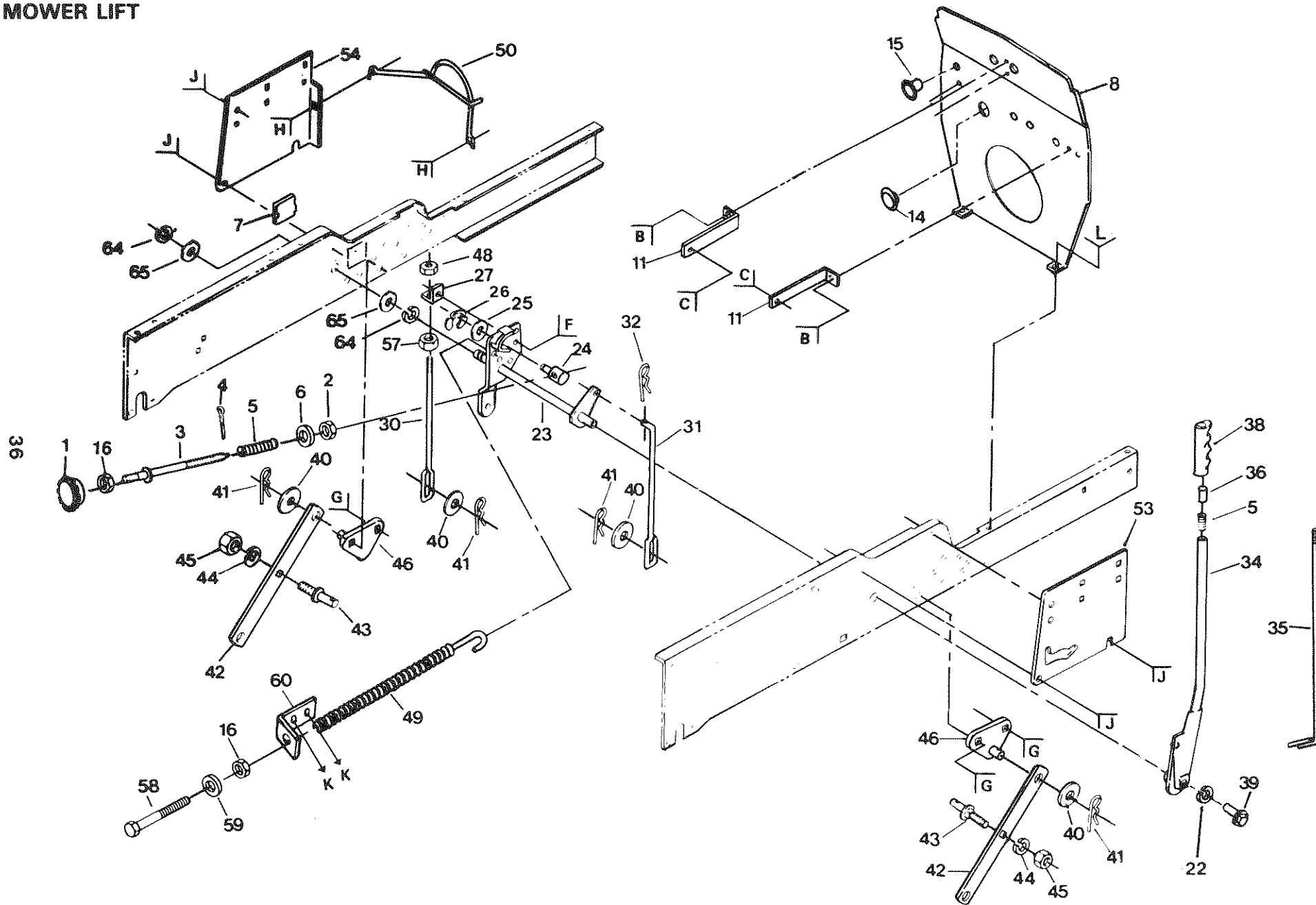
* STANDARD HARDWARE - PURCHASE LOCALLY



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

MOWER LIFT



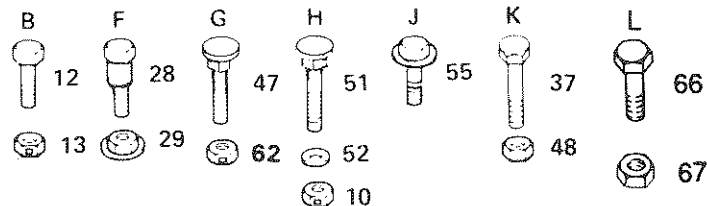
REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

MOWER LIFT

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	100734K	Handle, Adjust, Lift	39	74760624	Bolt, Hex, 3/8 - 16 x 1 1/2
2	110807X	*Nut, Special	40	STD551050	*Washer 17/32 x 1-1/16 x 13 Ga.
3	110811X	Rod, Adjust, Lift	41	9135R	Retainer Spring
4	STD570907	*Pin, Cotter, 3/32 x 3/4	42	105429X	Arm, Suspension
5	2876H	Spring	43	105413X	Stud, Pivot Center
6	19131016	Washer 13/32 x 5/8 x 16 Ga.	44	STD551150	*Washer, Lock, 1/2
7	121794X	Cover, Access	45	STD541050	*Nut, Hex, 1/2 - 13
8	110870X	Shield, Heat, Rear	46	105501X	Bracket, Suspension, Mower
10	73680500	Nut, Lock, 5/16 - 18	47	STD533707	*Bolt, Carriage, 3/8 - 16 x 3/4
11	110904X	Brace, Heat Shield	48	73680600	Nut, Lock, 3/8 - 16
12	STD522505	*Bolt, Hex, 1/4 - 20 x 1/2 Gr. 5	49	674A247	Spring - Ass'y. - Assist, Lift
13	73680400	Nut, Lock, 1/4 - 20	50	110908X	Guard, Belt, Engine
14	106351X	Plug	51	STD533110	*Bolt, Carriage, 5/16 - 18 x 1
15	110436X	Bushing, Snap	52	19111610	Washer 11/32 x 1 x 10 Ga.
16	73350600	Nut, Hex Jam 3/8 - 16 UNC	53	121045X	Panel, Side, R.H.
22	STD551137	Lockwasher, 3/8	54	121046X	Panel, Side, L.H.
23	120137X	Shaft, Lift	55	17490608	Bolt, Hex Washer Thd. Rolling 3/8 - 16 x 1/2
24	110810X	Trunnion, Stop Depth	57	STD541037	*Nut, Hex 3/8 - 16
25	19151216	Washer 15/32 x 3/4 x 16 Ga.	58	5328J	Bolt - Adjust, Spring
26	12000037	Klip Ring	59	STD551037	*Washer 13/32 x 13/16 x 16 Ga.
27	7594J	Bracket, Lift, L.H.	60	5329J	Bracket, Spring - Assist
28	7901J	Bolt, Shoulder	62	73930600	Nut - Centerlock 3/8 - 16
29	73900400	Nut, Hex Flange 1/4 - 20	64	12000034	Klip Ring
30	7596J	Link, Lift, L.H.	65	19292016	Washer, 29/32 x 1-1/4 x 16 Ga.
31	105503X	Link, Lift, R.H.	66	STD523107	*Bolt - Hex. 5/16 - 18 x 3/4
32	4939M	Retainer, Spring	67	73680500	Nut Lock, 5116 - 18
34	121002X	Lever Lift			
35	121006X	Rod, Lift			
36	105723X	Plunger, Lever			
37	STD523707	Bolt, Hex 3/8 - 16 x 3/4			
38	109413X	Grip Handle			

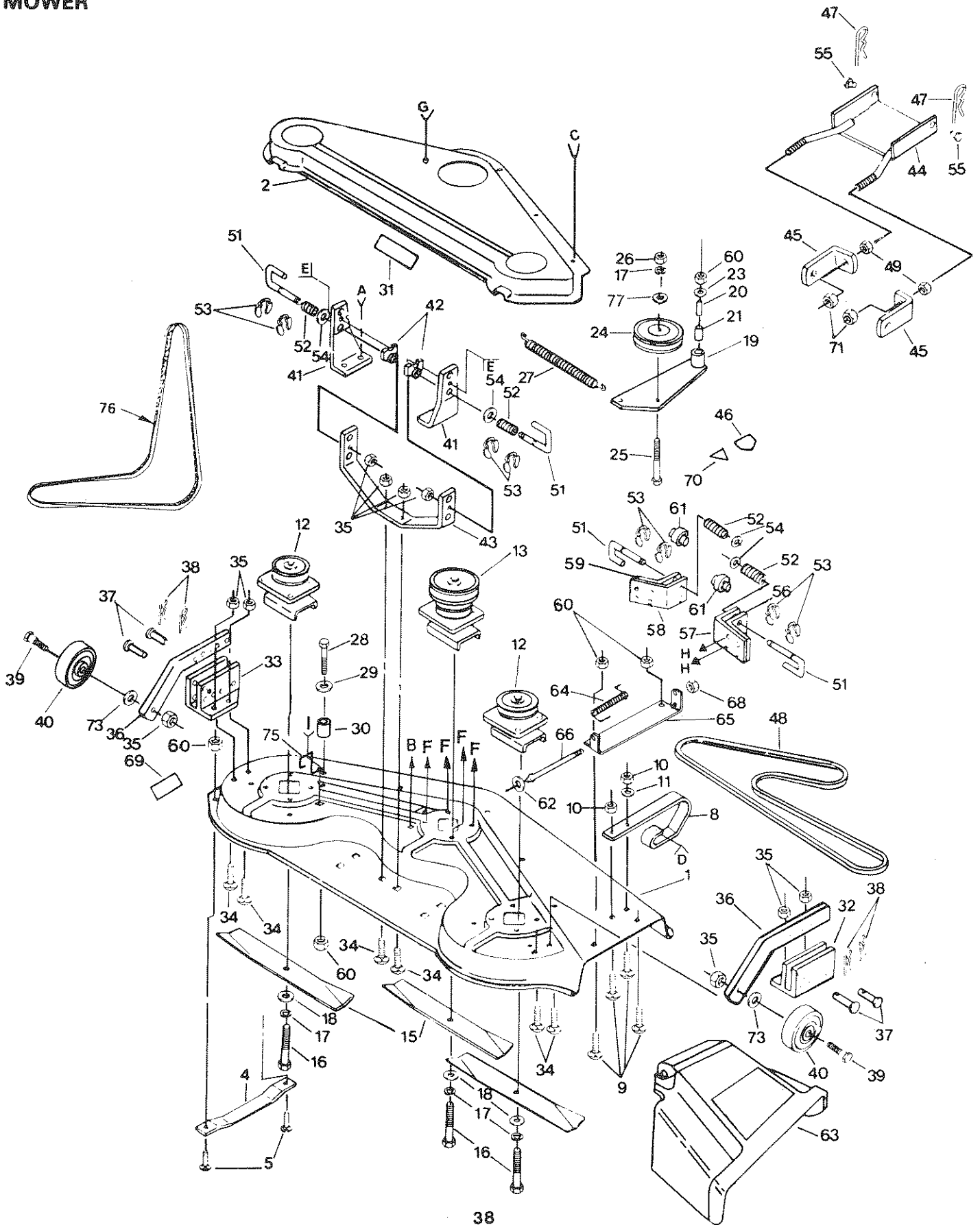
*STANDARD HARDWARE - PURCHASE LOCALLY



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

MOWER



REPAIR PARTS

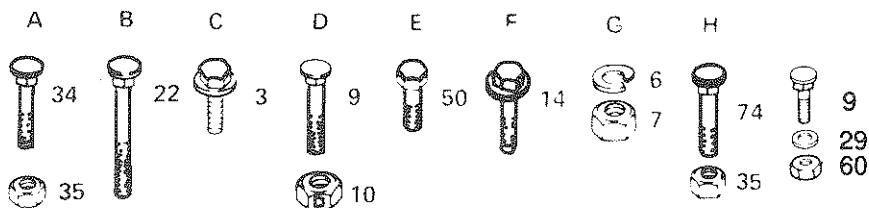
GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

MOWER

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	121664X	Housing, Mower	36	105453X	Bar, Ga. Wheel
2	121811X	Cover - Drive, Deck	37	5565J	Pin, Clevis
3	17490508	Screw - Hex Washer Thd. Roll 5/16 - 18 x 1/2	38	4939M	Retainer, Spring
4	7631J	Runner, L.H.	39	4898H	Bolt, Shoulder
5	72110505	Bolt, Carr. 5/16 - 18 x 5/8	40	105455X	Wheel, Gauge
6	STD551131	*Washer - Lock, 5/16	41	105433X	Brkt., Suspension
7	STD541031	*Nut - Hex 5/16 - 18	42	110237X	Spacer
8	120449X	Runner, R.H.	43	105434X	Brace, Suspension
9	72140506	Bolt, Carr. 5/16 - 18 x 3/4	44	105436X	Parallel Link
10	1685H	Nut, Lock 5/16 - 18	45	105441X	Brkt., Suspension
11	STD551031	*Washer 11/32 x 11/16 x 16 Ga.	46	121343X	Decal - Warning
12	121658X	Mandrel - Secondary	47	3146R	Retainer - Spring
13	121657X	Mandrel - Primary	48	3703J	V-Belt
14	17490612	Screw - Hex Washer Thd. Roll 3/8 - 16 x 3/4	49	STD541050	*Nut, 1/2 - 13
15	121798X	Blade	50	74760622	Bolt, Hex 3/8 - 16 x 1 - 3/8
16	STD623715	*Bolt - Hex, 3/8-24 x 1-1/2 Gr.5	51	105435X	Pin, Release
17	STD551137	*Washer - Lock, 3/8	52	3720R	Spring
18	19132012	Washer 13/32 x 1 - 1/4 x 12 Ga.	53	12000039	Ring, Klip
19	674A213	Arm Assembly, Idler	54	19171612	Washer 17/32 x 1 x 12 Ga.
20	7834J	Liner, Bearing	55	105440X	Pin, Clevis
21	7835J	Bearing	56	105458X	Brkt., Outer, R.H.
22	72110522	Bolt, Carriage 5/16 - 18 x 2 - 3/4	57	105460X	Brkt., Inner, R.H.
23	19111610	Washer 11/32 x 1 x 10 Ga.	58	110998X	Brkt., Inner, L.H.
24	102403X	Pulley, Idler	59	120000X	Brkt., Outer, L.H.
25	STD523715	*Bolt - Hex 3/8 - 16 x 1 - 1/2	60	73680500	Locknut 5/16 - 18
26	STD541037	*Nut - Hex 3/8 - 16	61	120135X	Spacer
27	104361X	Spring	62	19111016	Washer 11/32 x 5/8 x 16 Ga.
28	STD523112	*Bolt - Hex 5/16-18 x 1-1/4 Gr. 5	63	110509X	Shield, Deflector
29	19111216	Washer 11/32 x 3/4 x 16 Ga.	64	106734X	Spring, Deflector
30	8438J	Spacer	65	109743X	Bracket, Deflector
31	106224X	Decal - V-Belt, Dr., Schematic, Mower	66	106735X	Pad, Hinge
32	105448X	Bracket, Ga. Wheel, R.H.	68	110452X	Push Nut
33	105449X	Bracket, Ga. Wheel, L.H.	69	3713J	Instruction - Caution Decal
34	STD533707	*Bolt, Carriage 3/8 - 16 x 3/4	70	--	**Decal - Safety Standard
35	73680600	Nut, Crownlock 3/8 - 16	71	73680800	Nut - Hex 1/2 - 13
			73	19171512	Washer 17/32 x 15/16 x 12 Ga.
			74	72240608	Bolt, Carriage 3/8 - 16 x 1
			75	121352X	Belt, Retainer
			76	110885X	V-Belt
			77	19131614	Washer 13/32 x 1 x 14 Ga.

*STANDARD HARDWARE--PURCHASE LOCALLY

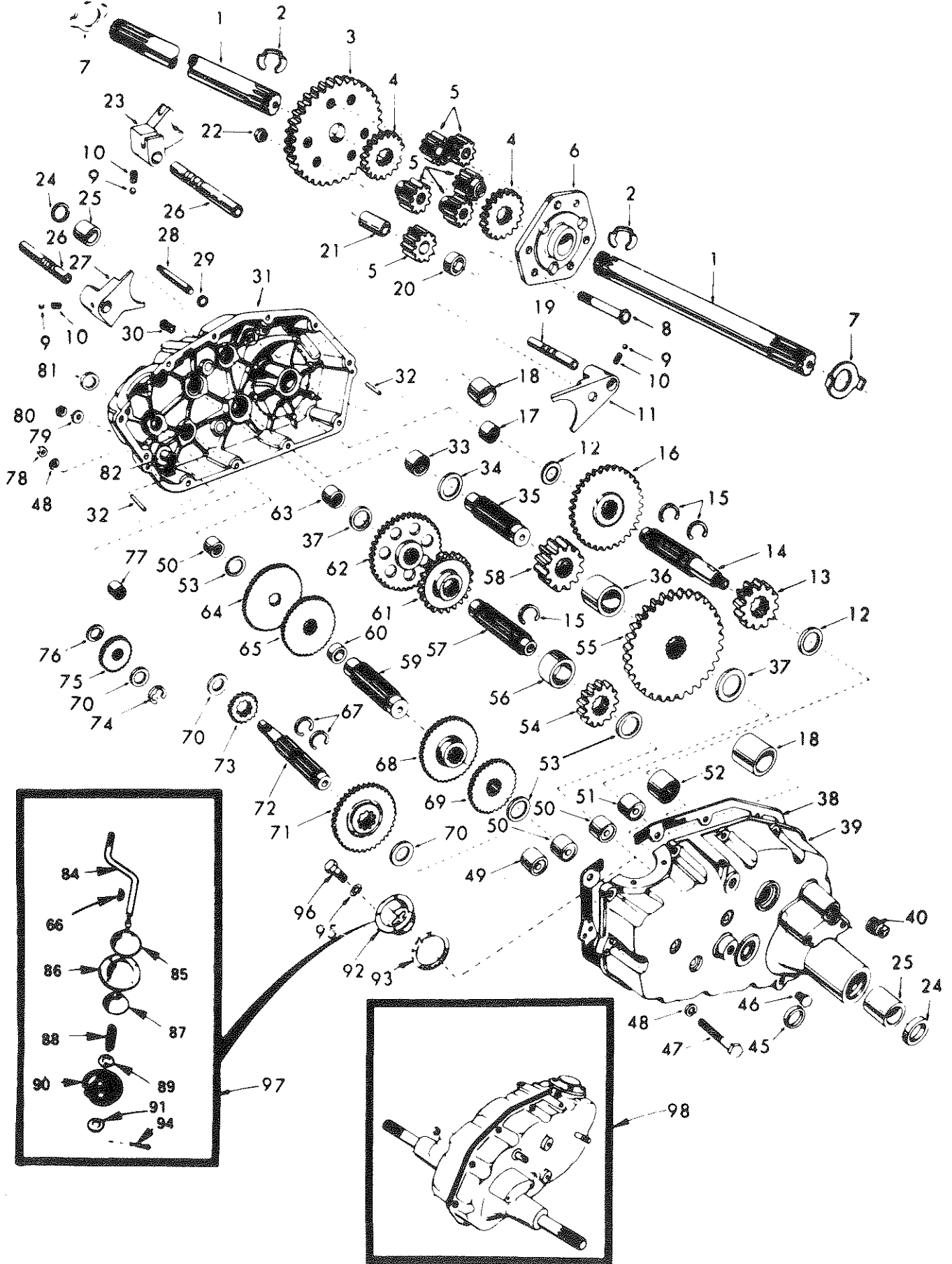
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REPAIR PARTS

TRANSAXLE

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

TRANSAXLE

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	4197R	Axle Shaft	49	4895H	Needle Bearing
2	5845R	Retaining Ring	50	4222R	Needle Bearing
3	4199R	Final Drive Gear	51	1529R	Needle Bearing
4	4216R	Differential Gear	52	8119M	Needle Bearing
5	4215R	Differential Pinion	53	4220R	Thrust Bearing Race
6	4217R	Differential Carrier	54	4209R	3rd Reduction Pinion - Low
7	6256H	Axle Thrust Washer	55	4213R	4th Reduction Gear
8	74020652	Hex Bolt 3/8 - 24 x 3 - 1/4 (1" Thread Length)	56	4442R	3rd Reduction Pinion Spacer
9	7392M	Steel Ball	57	4195R	2nd Reduction Gear Shaft
10	6272H	Spring Shift Fork Detent	58	4214R	Final Drive Pinion
11	4985R	Shift Fork, High - Low Range	59	4194R	1st Reduction Gear Shaft
12	6266H	Thrust Bearing Race	60	7528R	1st Reduction Shaft Spacer
13	4212R	4th Reduction Pinion	61	4208R	3rd Reduction Pinion - High
14	4196R	3rd Reduction Gear Shaft	62	4207R	2nd Reduction Gear
15	6276H	Snap Ring - Crescent Type	63	7398H	Needle Bearing
16	633A63	High - Low Range Gears	64	4203R	Low Speed Gear and 2nd Reduction Pinion Cluster
17	8118M	Needle Bearing	65	4204R	Reverse Gear
18	8740H1	Sintered Iron Bearing	66	2898J	Key - Hi - Pro 1/8 x 17/32
19	122238X	Shift Fork Shaft, High - Low Range	67	4926H	Snap Ring - Crescent Type
20	4218R	Differential Pinion Spacer	68	4205R	Intermediate Speed Gear
21	6252H1	Differential Pinion Bushing	69	4206R	High Speed Gear
22	7810H	Gripco Centerlock Nut 3/8 - 24	70	1370H	Thrust Bearing Race
23	4986R	Shift Fork - L.H.	71	633A69	Intermediate and High Speed Cluster Pinions
24	7393R	Oil Seal	72	208J	Input Shaft
25	992R1	Sintered Iron Bearing	73	4201R	Low Speed Pinion
26	6216H	Shift Fork Shaft	74	12000002	E-Ring
27	6262H	Shift Fork - R.H.	75	1153R	Reverse Idler Gear
28	101416X	Shift Shaft, High - Low Range	76	7392H	Reverse Idler Thrust Washer
29	6269H	Oil Seal	77	3990H	Needle Bearing
30	5855H	Pressure Relief Valve	78	STD541031	*Hex Nut 5/16 - 18
31	122162X	Gearcase, Reverse Idler Shaft and Bearings - R.H. (Inc. Key No's. 17, 18, 25, 33, 50, 63, 76, 77 and 82)	79	1167R	Sealing Washer
32	6277H	Dowel Pin	80	73360700	Hex Jam Nut 7/16 - 20
33	4225R	Needle Bearing	81	6270H	Oil Seal
34	7396H	Thrust Bearing Race	82	7384H	Reverse Idler Shaft
35	4198R	4th Reduction Gear Shaft	84	5384J	Gear Shift Lever - Bent
36	4200R	4th Reduction Gear Spacer	85	2978J	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	122162X	Gearcase and Bearings - L.H. (Inc. Key No's. 18, 25, 49, 50 (2), 51 and 52)	88	4924H	Spring
40	13320400	Pipe Plug 1/2 - 14 N.P.T.	89	19151516	Washer 15/32 x 15/16 x 16 Ga.
45	6271H	Oil Seal	90	8105R	Shift Mechanism Seal
46	13020200	Pipe Plug 1/4 - 18 N.P.T.	91	19181511	Washer 9/16 x 15/16 x 12 Ga.
47	STD523115	*Hex Bolt 5/16 - 18 x 1 - 1/2 Grade 5	92	75J	Gear Shift Gate and Reinforcement
48	10140500	Lockwasher 5/16 Extra Heavy	93	6274H	Shift Ball Cover Gasket
			94	76020412	Cotter 1/8 x 3/4
			95	STD551131	*Lockwasher 5/16
			96	STD523108	*Hex Bolt 5/16 - 18 UNC x 7/8
			97	633A109	Gear Shift Lever Ass'y.
			98	122286X	Transaxle Assembly Less Brake Drum & Shift Lever

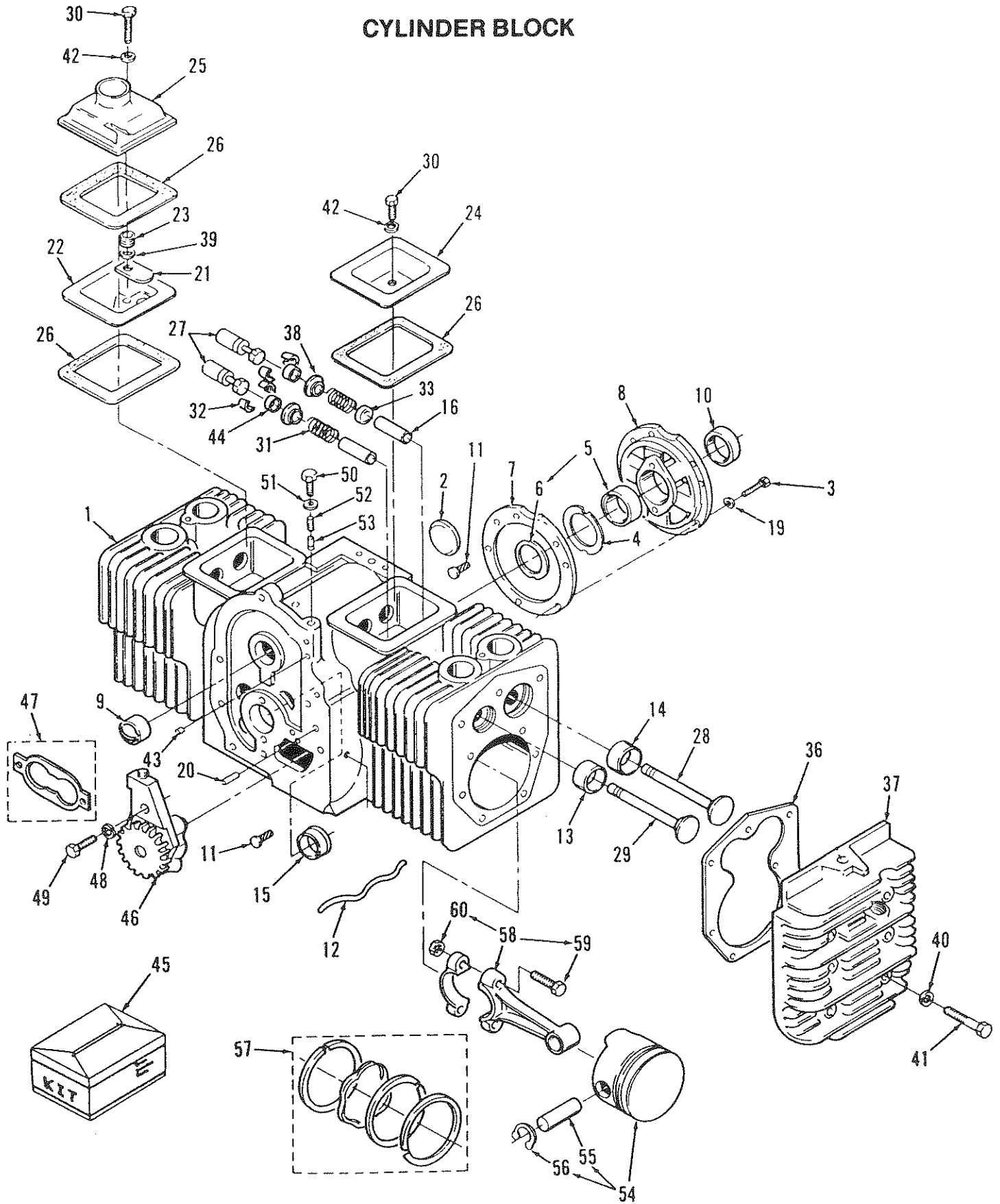
*STANDARD HARDWARE--PURCHASE LOCALLY

REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

ENGINE MODEL NUMBER 739.10896B

CYLINDER BLOCK



**GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490
ENGINE MODEL NUMBER 739.10896B**

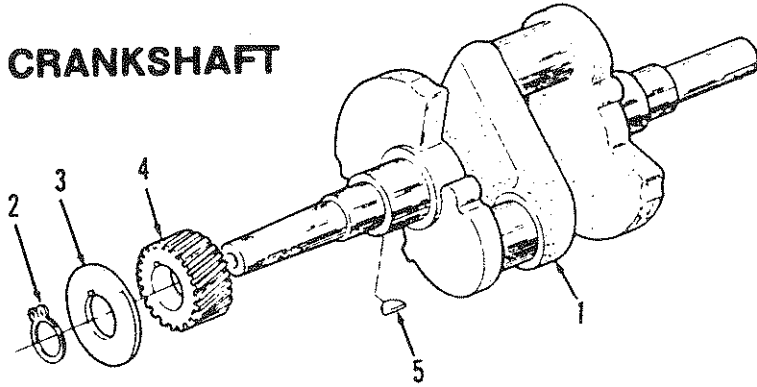
CYLINDER BLOCK

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	110-3420-02	Short Block, Cylinder (Includes Parts Marked*)	29	110-3515	Valve, Exhaust
			30	800-0010	Screw, Cap - Hex Head (14-20x1-34")
2	517-0048	*Plug, Welch - Camshaft Opening (1-5/8") - Non-Chromed	31	110-3485	Spring, Valve
4	800-0051	*Screw, Cap - Hex Head (3/8 - 16 x 1-1/4")	32	110-3511	Lock, Valve Spring
5	104-0776	*Shim, Crankshaft End Play (.005")	33	509-0210	Seal, Valve - Intake
4		Bearing, Crankshaft - Rear (Includes Thrust Washer)	36	110-3181	Gasket, Cylinder Head
			37		Head, Cylinder
	101-0450	*Standard		110-3509	Right Side
	101-0450-02	.002" Undersize		110-3508	Left Side
	101-0450-10	.010" Undersize	38	110-3487	Washer, Valve Spring-Retg.
	101-0450-20	.020" Undersize	39	526-0018	Washer, Flat (1/4" Screw)
	101-0450-30	.030" Undersize	40	526-0122	Washer, Flat (5/16" Screw)
6	104-0575	*Washer, Thrust	41	800-0571	Screw, Cap - Hex Head (Special) 2" Long
7	101-0415	*Gasket, Bearing Plate	42	526-0063	Washer, Flat - Copper (1/4" Screw)
8	101-0439	*Plate, Bearing - Rear - Standard - Code 11AH	43	517-0067	*Plug, Core Hole
			44	110-3510	Cap, Valve
9	101-0405	*Bearing, Camshaft	45		Kit, Gasket
10	509-0041	*Seal, Oil - Crankshaft Rear		168-0182	Engine, Complete
11	516-0072	*Pin, Drive - Bearing Stop		168-0183	Valve Grind/Carbon Removal
12	120-0735	*Tube, Oil - Cylinder Block	46	120-0491	Pump, Oil (Components Not Sold Separately)
13		Insert, Valve Seat - Exhaust			Gasket Kit, Oil Pump
	110-1824	*Standard	47	120-0161	Washer, Lock - Spring (1/4")
	110-1824-02	.002" Oversize	48	850-0040	Screw, Cap - Hex Head (1/4 - 20 x 1")
	110-1824-05	.005" Oversize	49	800-0007	Screw, Cap - Hex Head (3/8 - 24 x 7/8")
	110-1824-10	.010" Oversize	50	801-0049	Washer, Flat - Copper (3/8" Screw)
	110-1824-25	.025" Oversize			Spring, Bypass Valve
14		Insert, Valve Seat - Intake	51	526-0066	Plunger, Bypass Valve
	110-0197	*Standard	52	120-0140	Piston (Includes Pin And Retaining Rings)
	110-0197-02	.002" Oversize	53	120-0398	Standard
	110-0197-05	.005" Oversize			.005" Oversize
	110-0197-10	.010" Oversize			.010" Oversize
	110-0197-25	.025" Oversize			.020" Oversize
15		Bearing, Crankshaft - Front (Flanged)		112-0186	.030" Oversize
	101-0432	*Standard		112-0186-05	.040" Oversize
	101-0432-02	.002" Undersize		112-0186-10	Pin, Piston
	101-0432-10	.010" Undersize		112-0186-20	Ring, Retaining
	101-0432-20	.020" Undersize		112-0186-30	Ring Set, Piston
	101-0432-30	.030" Undersize		112-0186-40	Standard
16		Guide, Valve	55	112-0229	.005" Oversize
	110-3527	*Exhaust	56	518-0311	.010" Oversize
	110-3526	*Intake	57		.020" Oversize
19	850-0050	*Washer, Lock - Spring (3/8")		113-0189	.030" Oversize
20	516-0141	*Pin, Alignment - Gear Cover		113-0189-05	.040" Oversize
21	123-1175	Reed, Breather Valve		113-0189-10	Rod, Connecting (Includes Bolt And Nut) 20 Horsepower
22	123-1173	Baffle, Breather Valve		113-0189-20	Standard
23	123-1174	Spring, Breather Valve		113-0189-30	.005" Oversize
24	110-1879	Cover, Valve - RH - Non-Chromed		113-0189-40	.010" Oversize
25	110-2274	Cover, Valve - LH - Non-Chromed	58		.020" Oversize
26	110-1921	Gasket, Valve Cover			.030" Oversize
27		Tappet, Valve		114-0257	.040" Oversize
	115-0006	Standard		114-0257-10	Standard
	115-0006-02	.002" Oversize		114-0257-20	.010" Undersize
	115-0006-05	.005" Oversize		114-0257-30	.020" Undersize
28	110-3479	Valve, Intake	59	114-0240	.030" Undersize
			60	870-0302	Bolt, Connecting Rod (Special)
					Nut, Hex - Crown Lock

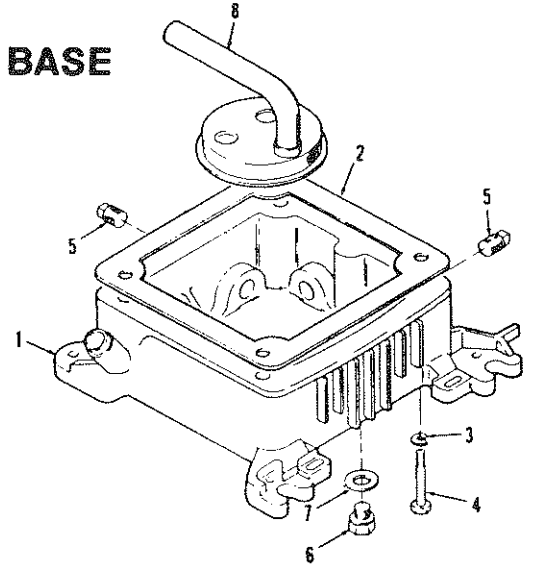
*-Parts Included in Cylinder Block.

**REPAIR PARTS
GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490
ENGINE MODEL NUMBER 739.10896B**

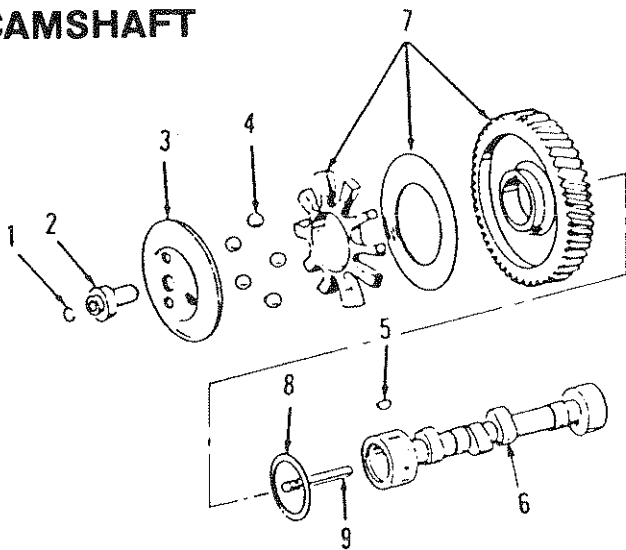
CRANKSHAFT



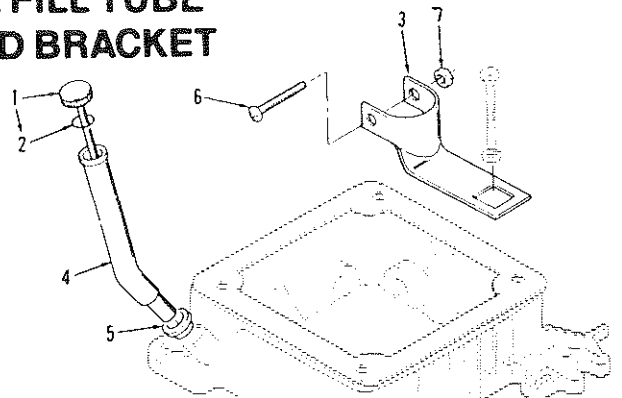
OIL BASE



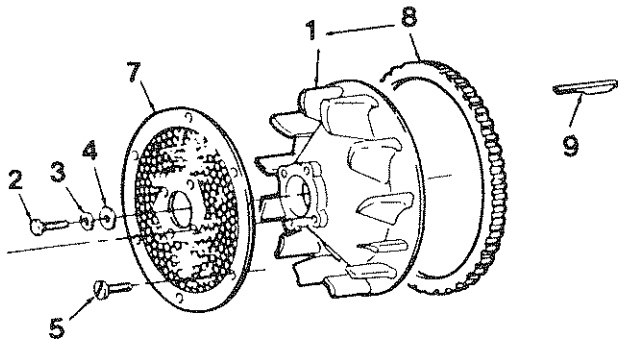
CAMSHAFT



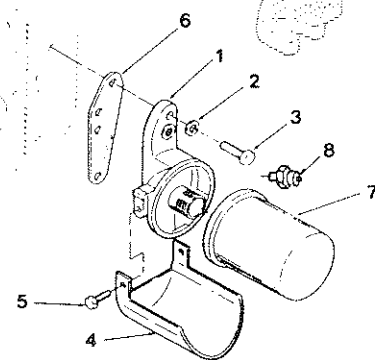
OIL FILL TUBE AND BRACKET



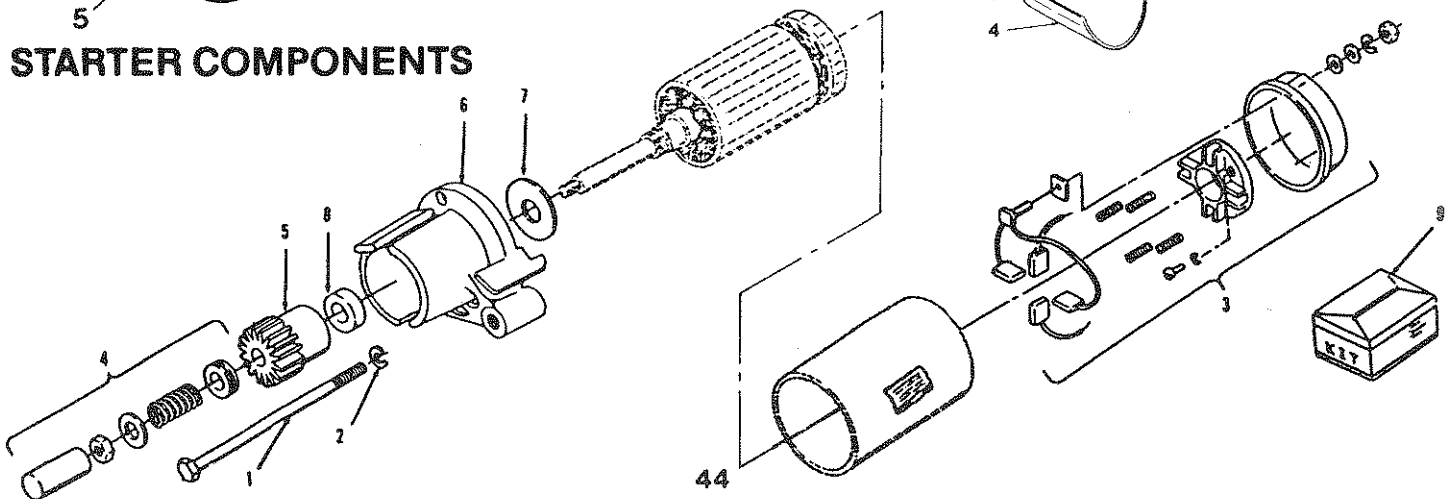
BLOWER WHEEL WITH SCREEN



OIL FILTER



STARTER COMPONENTS



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

ENGINE MODEL NUMBER 739.10896B

CRANKSHAFT

KEY NO.	PART NO.	DESCRIPTION
1	104-1360	Crankshaft (includes Key, item 5)
2	518-0014	Ring, Retaining
3	104-0043	Washer, Gear Retaining - Special
4	104-0032	Gear, Crankshaft
5	515-0001	Key, Crankshaft Gear

OIL BASE

KEY NO.	PART NO.	DESCRIPTION
1	102-1325	Base, Oil (Includes All Plugs and Plug Gasket) - Code 17BW
2	102-1200	Gasket, Oil Base
3	850-0050	Washer, Lock - Spring (3/8")
4	800-0061	Screw, Cap - Hex Head (3/8-16 x 3-3/4") - Code 17BW
5	505-0110	Plug, Square Head (3/8") - Code 17BW
6	102-0938	Plug, Hex Head - Special
7	102-0743	Gasket, Hex Head Plug
8	102-0713	Cup, Intake - Oil Pump - Code 17BW

CAMSHAFT

KEY NO.	PART NO.	DESCRIPTION
1	150-0078	Ring, Retaining
2	150-1519	Hub, Governor Cup
3	150-1520	Cup, Governor
4	510-0015	Ball, Governor
5	515-0001	Key, Woodruff - Camshaft Gear
6	105-0639	Camshaft (includes Center Pin, item 9)
7	105-0332	Gear, Camshaft (Includes Gear, Spacer And Plate)
8	105-0541	Washer, Thrust - Special
9	150-0075	Pin, Center

OIL FILL TUBE AND BRACKET

KEY NO.	PART NO.	DESCRIPTION
1	123-1637	Cap And Indicator, Oil Fill (Includes O-Ring)
2	509-0142	O-Ring, Oil Fill Cap
3	123-1742	Bracket, Fill Tube - Non-Chromed - Code 17BY
4	123-1685	Tube, Oil Fill - 15.75" Long - Non-Chromed - Code 17BY
5	509-0209	Seal, Oil Fill Tube
6	815-0576	Screw, Pan Head (#10 x 1-1/4")
7	870-0410	Nut, Speed (Type U)

BLOWER WHEEL WITH SCREEN

KEY NO.	PART NO.	DESCRIPTION
1	134-4633	Flywheel (Includes Ring Gear)
2	104-0170	Screw, Cap - Hex Head (Special)
3	526-0356	Washer, Flat (7/16" Screw)
4	526-0017	Washer, Flat (7/16" Screw)
5	815-0687	Screw, Lock Head - Flange (#10-24 x 3/8")
7	134-4553	Screen, Air Inlet - Unpainted
8	104-0779	Gear, Ring
9	515-0284	Key, Flywheel

OIL FILTER

KEY NO.	PART NO.	DESCRIPTION
1	122-0320	Adapter, Oil Filter
2	526-0065	Washer, Flat - Copper (5/16" Screw)
3	800-0028	Screw, Cap - Hex Head (5/16-18 x 1")
4	122-0360	Drain, Oil Filter - Unpainted
5	815-0194	Screw, Cap - Hex Head W/ET (#10-32 x 3/8")
6	122-0375	Gasket, Oil Filter Adapter
7	122-0645	Filter, Oil
8	309-0546	Switch, Low Oil Pressure

STARTER COMPONENTS

KEY NO.	PART NO.	DESCRIPTION
1	191-1048	Bolt, Hex Head
2	870-0438	Retainer, Bolt
3	191-1532	Cap Assembly, End (Includes Cap, Brushholder, Springs, Brushes, Terminal Hardware)
4	191-1359	Cover Assembly (Includes Dust Cover, Spring, Spacer, Nut and Washer)

KEY NO.	PART NO.	DESCRIPTION
5	191-1156	Gear, Drive
6	191-1671	Cap Plate, End - Front
7	191-1038	Washer, Thrust
8	191-1534	Seal, Dust
9	191-1841	Kit, Repair (Includes Brush with Stud, Springs and Brushes)

NOTE: Part Number Stamped on the Starter Nameplate for Identification.

NOTE: Phantom Items Not For Sale, For Replacement Order Complete Starter.

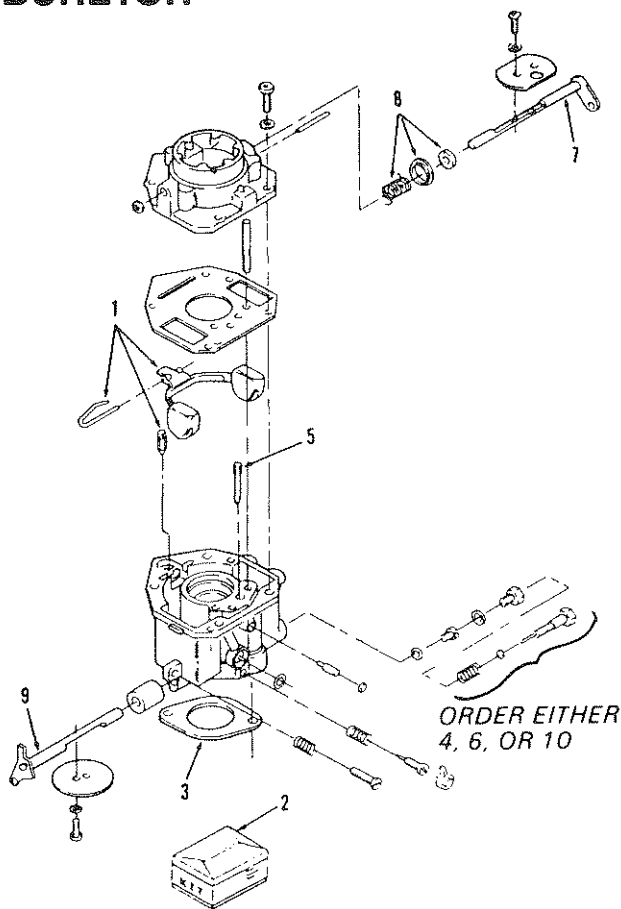
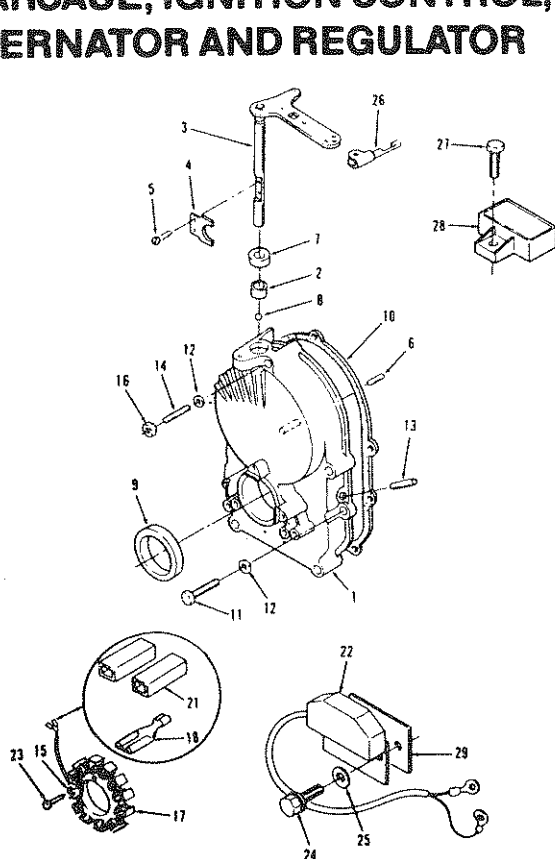
REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR -- MODEL NUMBER 917.254490

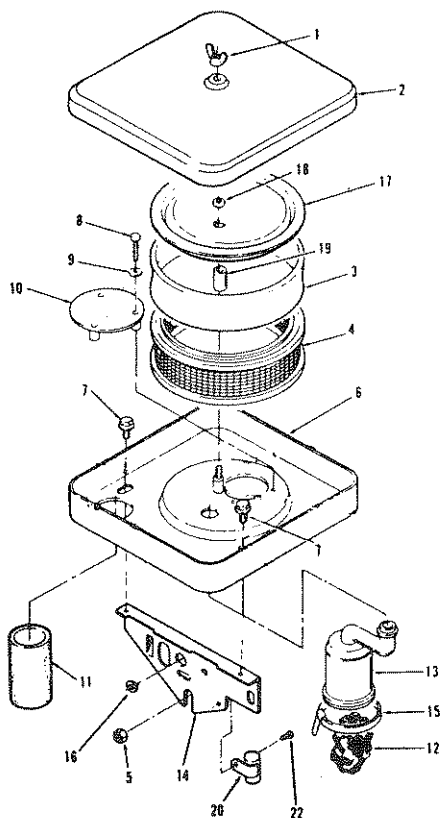
ENGINE MODEL NUMBER 739.10896B

GEARCASE, IGNITION CONTROL, ALTERNATOR AND REGULATOR

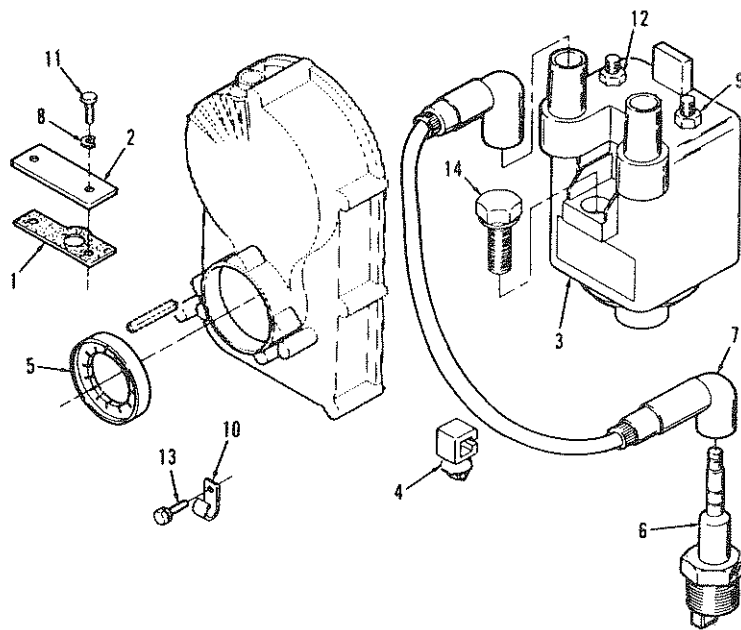
CARBURETOR



AIR CLEANER



IGNITION



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490 ENGINE MODEL NUMBER 739.10896B

GEARCASE, IGNITION CONTROL, ALTERNATOR AND REGULATOR

KEY NO.	PART NO.	DESCRIPTION
1	103-0791	Gearcase (Kit) (Includes Parts Marked*)
2	510-0105	*Bearing, Governor Shaft
3	150-1470	*Shaft And Arm, Governor - Non-Chromed
4	150-1187	*Yoke, Governor Shaft
5	815-0046	*Screw, Machine - Pan Head (8-32 x 3/8")
6	516-0130	*Pin, Dowel - Governor Cup Stop
7	509-0008	*Seal, Oil - Governor Shaft
8	510-0014	*Ball, Bearing - Governor Shaft
9	509-0040	*Seal, Oil - Crankshaft
10	103-0408	Gasket, Gearcase Mounting
11	800-0032	Screw, Cap - Hex Head (5/16-18 x 1-3/4")
12	526-0065	Washer, Flat - Copper (5/16" Screw)
13	149-1299	*Tube, Vacuum Port
14	520-0933	Stud, Gear Cover
15	850-0030	Washer, Lock (#10) - Code 31AZ
16	862-0015	Nut, Hex (5/16-18)
17	191-1256	Stator (Includes Terminals)
18	332-2423	Terminal, Stator Leads Code 31AZ
21	323-1257	Body, Terminal Connector Kit (Includes Terminals) Code 31AZ
22	166-0763	Control, Ignition
23	815-0172	Screw, Machine - Hex Head Self-Lock (#10-32 x 1") Code 31AZ
24	815-0340	Screw, Hex Washer Head (10-32 x 3/8")
25	854-0010	Washer, Lock - IT (#10)
26	518-0406	Clip, Retaining - Control Rod To Governor Shaft
27	821-0008	Screw, Cap - Hex Washer Head (1/4-20 x 5/16")
28	191-1748	Regulator, Voltage - 20 Ampere - Code 31AZ
29	166-0786	Insulator, Ignition Module

*-Parts Included In 103-0791 Gearcase.

KEY NO.	PART NO.	DESCRIPTION
19	301-0458	Spacer, Air Cleaner Stud
20	312-0256	Capacitor
22	815-0178	Screw, Hex Washer Head - Thread Form (10-32 x 5/8")

CARBURETOR

KEY NO.	PART NO.	DESCRIPTION
	146-0430	Carburetor, Complete - 20 Horsepower (Includes Mounting Gasket)
1	146-0437	Float Kit (Includes Float, Pin And Valve)
2	146-0432	Kit, Repair (Includes Screw And Plug Package, Gasket Package, Float Valve, Idle Adjust Needle And Spring, Mounting Gaskets, Idle Limit Cap)
3	154-0733	Gasket, Carburetor Mounting
4	146-0327	Variable Jet Kit - Optional (High Altitude Application) (Includes Power Jet And Gasket, Retainer, Power Needle Spring, Power Needle And Power Plug Gasket)
5	146-0425	Jet, Idle
6	145-0391	Jet, Power
7	146-0433	Shaft, Choke - Kit (Includes Choke Valve, Valve Set Screw And Air Filter)
8	146-0435	Lever, Choke - Kit (Includes Choke Lever Ring, Choke Spring And Choke Collar)
9	146-0324	Shaft, Throttle - Kit (Includes Valve Set Screw, Air Filter And Throttle Valve)
10	146-0347	Jet, Fixed - High Altitude Kit

AIR CLEANER

KEY NO.	PART NO.	DESCRIPTION
1	865-0020	Nut, Wing (1/4-20)
2	140-2005	Cover, Air Cleaner - Non-Chromed
3	140-1496	Wrapper, Air Cleaner Element Code 19AS
4	140-1228	Element, Air Cleaner Code 19AS
5	870-0399	Nut, Hex Washer Head Flanged (5/16-18)
6	140-2004	Housing, Air Cleaner - Unpainted - Code 19AS
7	815-0575	Screw - Tapping - Hex Washer Head (1/4-20 x 3/8") Gasoline
8	815-0470	Screw, Machine - Hex Head (#10-32 x 1-1/2")
9	526-0234	Washer, Flat (#10 Screw)
10	145-0521	Plate, Air Deflector
11	140-2025	Tube, Air Intake
12	123-1417	Filter, Breather Tube
13	123-1429	Tube, Crankcase Breather
14	140-2017	Support, Air Cleaner - Unpainted - Code 19AS
15	503-1138	Clamp, Breather Tube
16	508-0021	Grommet, Rubber (3/4" Hole)
17	140-1692	Cover, Element
18	870-0365	Nut, Hex (1/4-20)

IGNITION

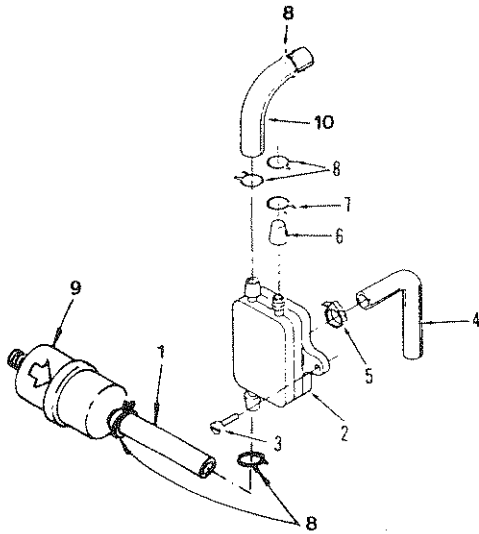
KEY NO.	PART NO.	DESCRIPTION
1	160-1150	Gasket, Plate
2	160-1345	Plate, Ignition Plunger Cover - Non-Chromed
3	166-0761	Coil, Battery Ignition (Includes Nuts)
4	332-2904	Clip, Wire (Attach To #1 Spark Plug Wire)
5	166-0767	Rotor, Ignition
6	167-0263	Plug, Spark
7		Cable, Spark Plug
	167-1615-01	9" Long
	167-1615-04	18.5" Long
8	850-0040	Washer, Lock (1/4")
9	166-0770	Nut, Hex Flange (M4 Positive Terminal)
10	518-0515	Clip, Wire
11	800-0004	Screw, Cap Hex Head (1/4-20 x 5/8")
12	166-0771	Nut, Hex Flange (M5 Negative Terminal)
13	815-0389	Screw, Hex Washer Head (1/4-20 x 1")
14	815-0650	Screw, Hex Washer Head (1/4-20 x 1")

REPAIR PARTS

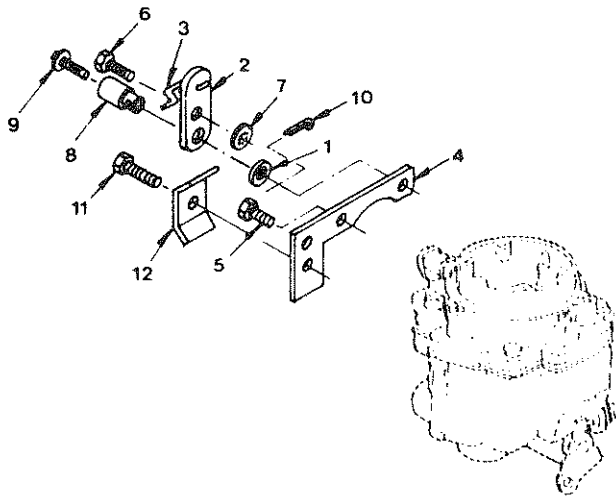
GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

ENGINE MODEL NUMBER 739.10896B

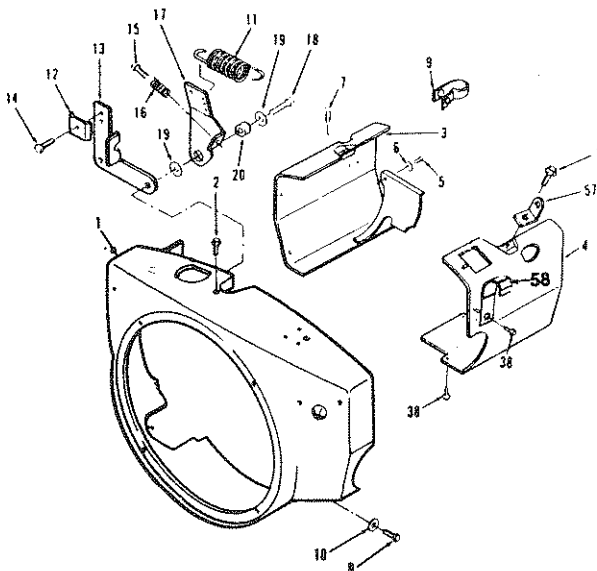
FUEL PUMP AND FILTER



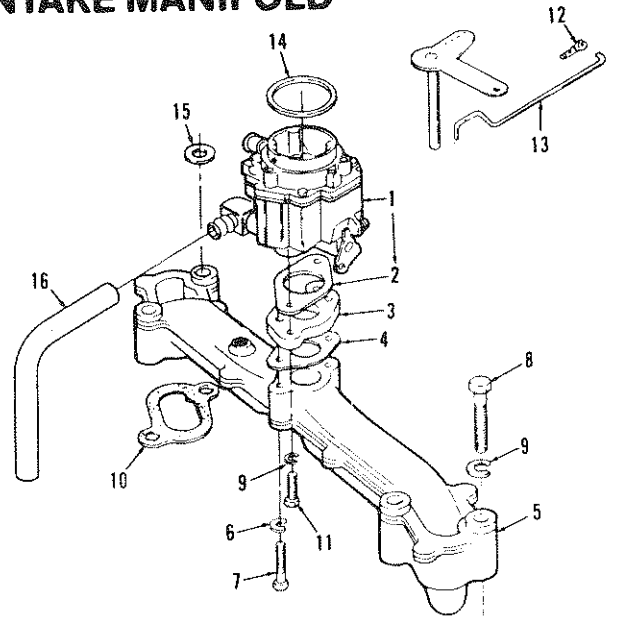
CHOKE CONTROL (FRONT PULL)



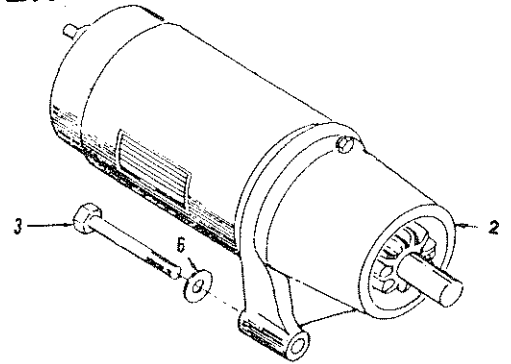
BLOWER HOUSING AND GOVERNOR



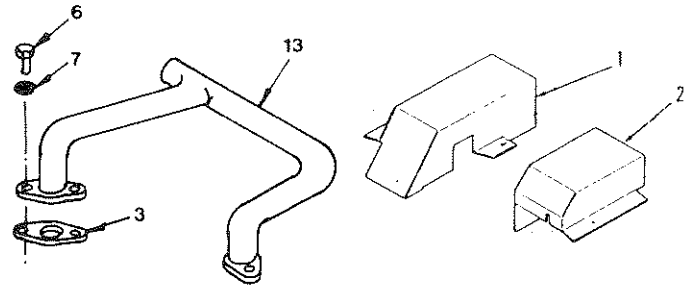
INTAKE MANIFOLD



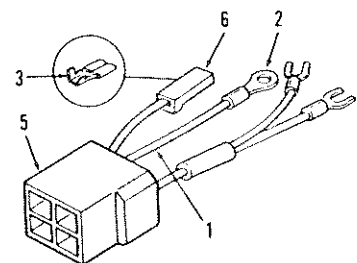
STARTER



EXHAUST SYSTEM



WIRING HARNESS (4 LEADS)



REPAIR PARTS

GT 20 TWIN GARDEN TRACTOR - - MODEL NUMBER 917.254490

ENGINE MODEL NUMBER 739.10896B

FUEL PUMP AND FILTER

KEY NO.	PART NO.	DESCRIPTION
1	503-0707	Hose - 12"(Cut To Appropriate Length)
2	149-1982	Pump, Fuel - Vacuum
3	815-0555	Screw, Tapping - Pan Head (10-24 x 5/8")
4	503-0707	Line, Pulse (Cut To 7" Long)
5	503-0731	Clamp, Hose (1/2")
6	149-1321	Cap, Fuel Fitting
7	503-0301	Clamp, Hose
8	503-0731	Clamp, Hose (1/2")
9	149-2005	Filter, Fuel

CHOKE CONTROL (FRONT PULL)

KEY NO.	PART NO.	DESCRIPTION
1	526-0140	Washer, Flat (#10 Screw)
2	153-0523	Lever, Choke
3	153-0500	Link, Choke
4	153-0524	Bracket, Choke Cable
5	821-0004	Screw, Cap - Hex Washer Head (#10-32 x 1/4")
6	815-0480	Screw, Shoulder (#10-32 x .34")
7	854-0010	Washer, Lock - IT (#10)
8	152-0155	Swivel, Choke Lever
9	815-0693	Screw, Machine - Hex Head (#8-32 x .375")
10	516-0059	Pin, Cotter
11	815-0359	Screw, Tapping - Slotted Hex Washer Head (#10-32 x 7/8")
12	153-0514	Clip, Choke Cable

BLOWER HOUSING AND GOVERNOR

KEY NO.	PART NO.	DESCRIPTION
1	134-4654	Housing, Blower - Unpainted - Code 13BJ
2	815-0261	Screw, Tapping - Hex Washer Head (1/4-20 x 7/16")
3	134-4615	Housing, Cylinder Air - LH Unpainted
4	134-4614	Housing, Cylinder Air - RH Unpainted
5	815-0290	Screw, Tapping - Hex Washer Head (1/4-20 x 5/8")
6	526-0021	Washer, Flat (1/4" Screw)
7	821-0016	Screw, Cap - Hex Washer Head (5/16-18 x 3/4")
8	815-0290	Screw, Tapping - Hex Washer Head (1/4-20 x 5/8")
9	332-2319	Clamp, Wire - Alternator Leads
10	526-0018	Washer, Flat (1/4" Screw)
11	150-1214	Spring, Governor - 5 Ball - Code 13BJ
12	153-0514	Clamp, Cable - Code 13BJ
13	150-1725	Bracket, Cable - Code 13BJ
14	815-0359	Screw, Tapping - Hex Head (#10-32 x 1/2") - Code 13BJ
15	815-0510	Screw, Tapping - Hex Head (#6-32 x 5/8") - Code 13BJ
16	150-1398	Spring, Idle Setting - Code 13BJ
17	150-1576	Arm, Governor Control (Without Swivel) - Code 13BJ
18	815-0436	Screw, Cap - Hex Washer Head (1/4-20 x 1/2") - Code 13BJ
19	526-0021	Washer, Flat (1/4" Screw) - Code 13BJ
20	150-1269	Bushing, Control Arm - Code 13BJ
36	821-0008	Screw, Cap - Hex Washer Head (1/4-20 x 5/16")
57	403-1523	Bracket Lifting - Non-chromed
58		Insulated Clip

INTAKE MANIFOLD

KEY NO.	PART NO.	DESCRIPTION
1	146-0430	Carburetor, Complete - 20 Horsepower (Includes Mounting Gasket, Elbow And O-Ring)(See Separate Page for Components)
2	154-0733	Gasket, Carburetor To Adapter
3	154-1977	Adapter, Carburetor - Non-Chromed
4	145-0438	Gasket, Adapter To Manifold
5	154-2666	Manifold, Intake - With Un-tapped Boss
6	850-0040	Washer, Lock - Spring (1/4")
7	800-0023	Screw, Cap - Hex Head (1/4-20 x 1-3/8")
8	800-0033	Screw, Cap - Hex Head (5/16-18 x 2")
9	850-0045	Washer, Lock - Spring (5/16")
10	154-1446	Gasket, Manifold To Block
11	800-0028	Screw, Cap - Hex Head (5/16-18 x 1")
12	518-0004	Clip, Retaining - Control Rod To Carburetor
13	150-1924	Rod, Governor Control
14	509-0145	O-Ring
15	526-0113	Washer, Flat (5/16" Screw)
16	503-1577	Hose, Fuel - 30" Long

STARTER

KEY NO.	PART NO.	DESCRIPTION
2	191-1828	Starter - Inertia (Bendix) Type (See Separate Page For Components)
3	800-0039	Screw, Cap Hex Head (5/16"-18 x 3-1/2")
6	526-0122	Washer, Flat (5/16" Screw) - Inside Mounting Bolt - Code 33AV

EXHAUST SYSTEM

KEY NO.	PART NO.	DESCRIPTION
1	134-4254	Cover, Exhaust - LH Code 21BH
2	134-4655	Cover, Exhaust - RH - Code 21BH
3	154-1725	Gasket, Exhaust Adapter
6	800-0026	Screw, Cap Hex Head (5/16-18 x 3/4")
7	850-0045	Washer, Lock - Spring (5/16")
13	154-2732	Manifold, Exhaust

WIRING HARNESS (4 LEADS)

KEY NO.	PART NO.	DESCRIPTION
1	338-2075	Harness, Wiring - Engine Code 35BB
2	332-0806	Terminal, Ring (#8)
3	332-2715	Terminal, Receptacle (.250)
5	323-1382	Housing, Tab - 4 Way
6	332-0819	Housing, Receptacle

SERVICE NOTES

Attachments That Add to the Usefulness of Your Craftsman Garden Tractor

Sears offers a wide variety of attachments that fit your tractor. Many of these are listed below with brief explanations of how they can help you. This list was current at the time of publication; however, it may change in future years — more attachments may be added, changes (including changes in the stock number) may be made in these attachments, or some may no longer be available.

Most of these attachments do not require additional hitches or conversion kits (those that do are indicated) and are designed for easy attaching and detaching. You may order these attachments at most Sears retail stores, catalog sales offices, and through the catalog.

LAWN SWEEPERS let you collect grass clippings and leaves.

Stock No.	Path	Capacity
71-24030	30-in.	9.0 cu. ft.
71-24032	32-in.	10.0 cu. ft.
71-24033 High-Performance	32 in.	11.5 cu. ft.
71-24038	38-in.	12.5 cu. ft.

LAWN VACS for powerful collections of heavy grass clippings and leaves. All acceptWand attachment to pick up debris in hard-to-reach places.

Stock No.	Engine	Capacity	Also Required
71-2455	3HP	8 bu.	71-26471 chute
71-2452	3HP	12 bu.	71-26471 chute
71-2447	5HP	25bu.	71-24474 chute 10 cu. ft. cart

CARTS make hauling easy.

Stock No.	Size	Capacity	
71-24353	4 cu. ft.	400 lb.	Dump cart
71-24354	10 cu. ft.	1,000 lb.	Hauling cart
71-24355	10 cu. ft.	1,000 lb.	Dump cart
71-24356	14 cu. ft.	1,250 lb.	Dump cart
71-24357	17 cu. ft.	1,500 lb.	Dump cart

ROLLER for smoother lawn surface. 36-inch wide, 18 inch diameter water-tight drum holds up to 390 lb. of weight. Rounded edges prevent harm to turf. Adjustable scraper automatically cleans drum. Stock number 71-24084.

SPREADER/SEEDERS make seeding, fertilizing, and weed killing easy. Broadcast spreaders are also useful for granular de-icers and sand.

71-24194	Drop type, 36 inch. 12 in. semi-pneumatic wheels. 100 lb. capacity steel hopper.
71-24394	Broadcasts over a 5 to 8 foot swath. 70 lb. capacity steel hopper. Noncorrosive spreading spinner, nylon gear box, stainless steel shaft.
71-24395	Broadcasts 8 to 10 foot swath. 160 lb. capacity. (covers 40,000sq. ft.) No-rust polypropylene hopper and impeller. Vinyl hopper cover.
71-2416	Broadcasts 6 to 8 foot swath. 50 lb. capacity. Corrosion-resistant construction. Polyethylene hopper.

CORING AERATOR takes small plugs out of soil to allow moisture and nutrients to reach grass roots. 36-inch swath. 24 hardened steel coring tips. 150 lb. capacity weight tray. Stock number 71-24351

AERATOR promotes deep root growth for a healthy lawn. Tapered 2.5" steel spikes mounted on 10-in. diameter discs puncture holes in soil at close intervals to let moisture soak it. Steel weight tray for increased penetration. Stock number 71-2435.

DETHATCHER loosens and flips thatch and matted leaves to lawn surface for easy pick up. Twenty spring tine teeth. Useful to prepare bare areas for reseeding. 40 inch rear mount: Stock number 71-24313. 38 inch front mount: Stock number 71-24301.

SPRAYERS use 12-volt DC electric motor that connects to the tractor battery or other 12-volt source. Includes booms for automatic spraying when pulling, and hand held wand for spot spraying. Wand has adjustable spray pattern. For applying herbicides, insecticides, fungicides, and liquid fertilizers.

71-2458	50 psi maximum pressure with 25 foot wand length. Sprays up to 25 feet with wand.
71-24398	25 psi maximum pressure with 18 foot wand length. Sprays up to 18 feet with wand.

DOZER BLADE removes snow; grades dirt, sand and gravel. 48 inches wide, 17 inches high, clears 44 inch path when angled. Master lift control lever for operator ease. Spring trip for snow removal on uneven pavement; built - in float for blade to follow ground contour. Reversible, replaceable scraper bar. (Use with tire chains, wheel weights or rear drawbar weight). Stock No. 71-24402

SNOWTHROWER has 42-inch swath. Drum-type auger handles powdery and wet/heavy snow. Mounts easily with simple pin arrangement. Discharge chute adjusts to 240 degree arc from tractor seat. 6-inch diameter spout discharges snow 10 to 50 ft. Lift controlled at tractor seat. (Use with tire chains, wheel weights, or rear drawbar weight). Stock No. 71-24074

TIRE CHAINS are heavy duty; closely spaced extra-large cross links give smooth ride, outstanding traction. Stock No. 71-26946.

WHEEL WEIGHTS provide stability, reduce tearing of turf when moving on hills, stopping, turning, starting. Provides extra weight for traction to pull low-loads, lawn vac. Required for snow removal. For plowing: one in front frame, one in right rear tire, two on left rear tire. For snow blower or dozer blade: one on right rear tire, one on left rear tire. 55 pounds. Stock No. 71-26234. (Front or rear mounting frame bracket Stock No. 71-26235.)

CHEVRON TIRES for extra traction. Pair of rear tires mounted on wheels. Stock No. 71-24167.

TRACTOR CAB has heavy duty vinyl fabric over tubular steel frame, fiberglass top; clear plastic windshield offers 360 degree visibility. Hinged metal frame doors with catch. Keeps operator warm and dry. Remove vinyl and windshield for use as sun protector in summer. Stock No. 71-24173.

Optional accessories for tractor cab: tinted/tempered solid safety glass wind shield with hand operated wiper (Stock No. 71-26168); 12-volt amber caution light for mounting on cab top (Stock No. 71-26169).

TRACTOR COVER protects tractor from weather. Made of Evolution 3 fabric (water-repellent, extremely breathable, light weight, soft, non-abrasive, pliable in all temperatures, durable, stain-tear-puncture resistant, will not shrink or stretch). Stock No. 71-24602.

***TILLER** has 8hp engine to prepare seed beds, cultivate and compost garden residue. Chain-drive transmission. Six 11 inch dia., one piece heat-treated steel tines. Tills 30 inch path. (Requires sleeve hitch Stock No. 71-25231.) Stock No. 71-25249.

***PLOW** turns soil 6 inches deep, cuts 10 inch furrow. Crank adjustment controls depth, 3-position yoke sets width. Heavy steel landslide for straight forrowing. Stock No. 71-24233.

***DISC HARROW** has 2 gangs of 4 steel blades that angle from 10 to 20 degrees 40 inches wide. Can hook 2 units in tandem. Stock No. 71-24234.

***REAR GRADER/LEVELER BLADE** is 42-inches wide operated from driver's seat. Reversible steel blade can be angled at 30 degrees for grading. Reverses for snow plowing. Stock No. 71-24239.

***SLEEVE CULTIVATOR** is 43 inches wide. Prepares ground for seeding, helps weed control. Steel frame holds 5 adjustable sweeps. Adjusts vertically, horizontally, Stock No. 71-25304. Optional accessory for cultivator: steel furrow opener for wider for wide openings for potatoes, corn, and other deep seeded crops (Stock No. 71-25305).

ELECTRICAL ASSIST KIT mounts to master lift. Raises and lowers front, mid ,and rear mount attachments with flip of switch. Stock No. 71-25242.

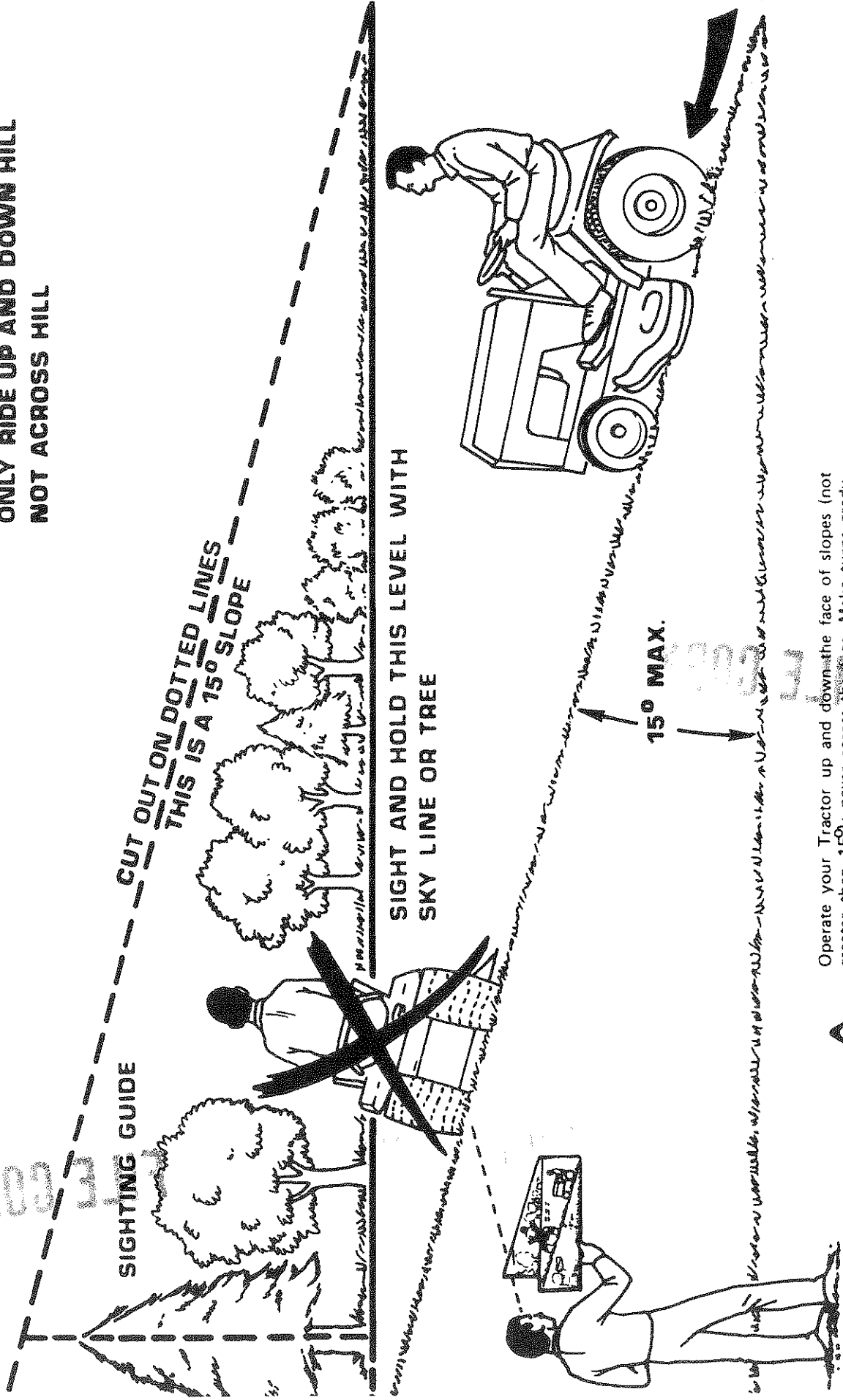
*Asterisked attachments require sleeve hitch (Stock No. 71-25231) for use with master lift system. Single pin couples/uncouples.

SERVICE NOTES

SERVICE NOTES

SUGGESTED GUIDE FOR SIGHTING SLOPES FOR SAFE OPERATION

ONLY RIDE UP AND DOWN HILL
NOT ACROSS HILL



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



SEARS

**OWNERS
MANUAL**

**MODEL NO.
917.254490**

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**HOW TO ORDER
REPAIR PARTS**

**CRAFTSMAN
GT 20HP TWIN
6 SPEED - 50" MOWER
GARDEN TRACTOR**

The Model Number will be found on the Model Plate located under the seat. Always provide the Model Number when requesting service or repair parts for your Garden Tractor.

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

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

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

Your Sears merchandise has added value when you consider Sears has service units nationwide staffed with Sears trained technicians having the parts, tools and the equipment to insure that we meet our pledge to you, "We Service What We Sell".

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