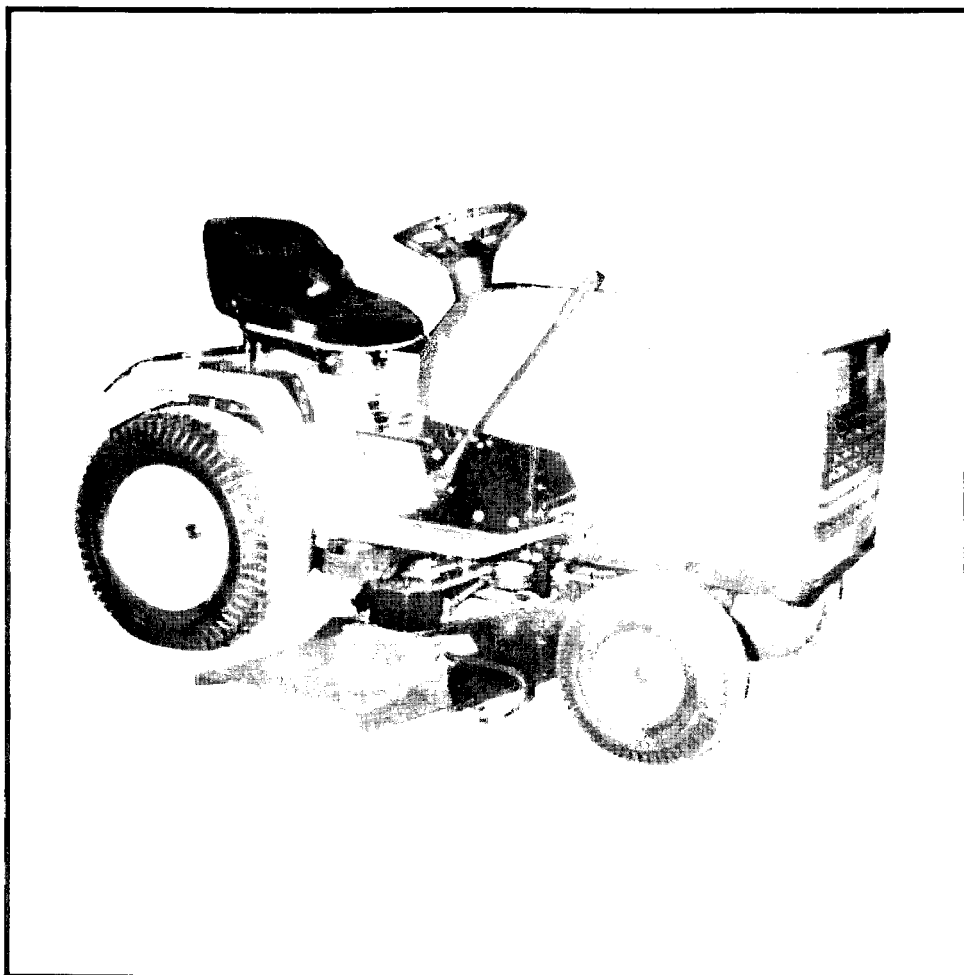


SEARS
OWNER'S
MANUAL

MODEL NO.
917.254450
AND
917.250020
WITHOUT
MOWER DECK

Caution:
Read and follow
all Safety Rules
and Instructions
Before Operating
This Equipment



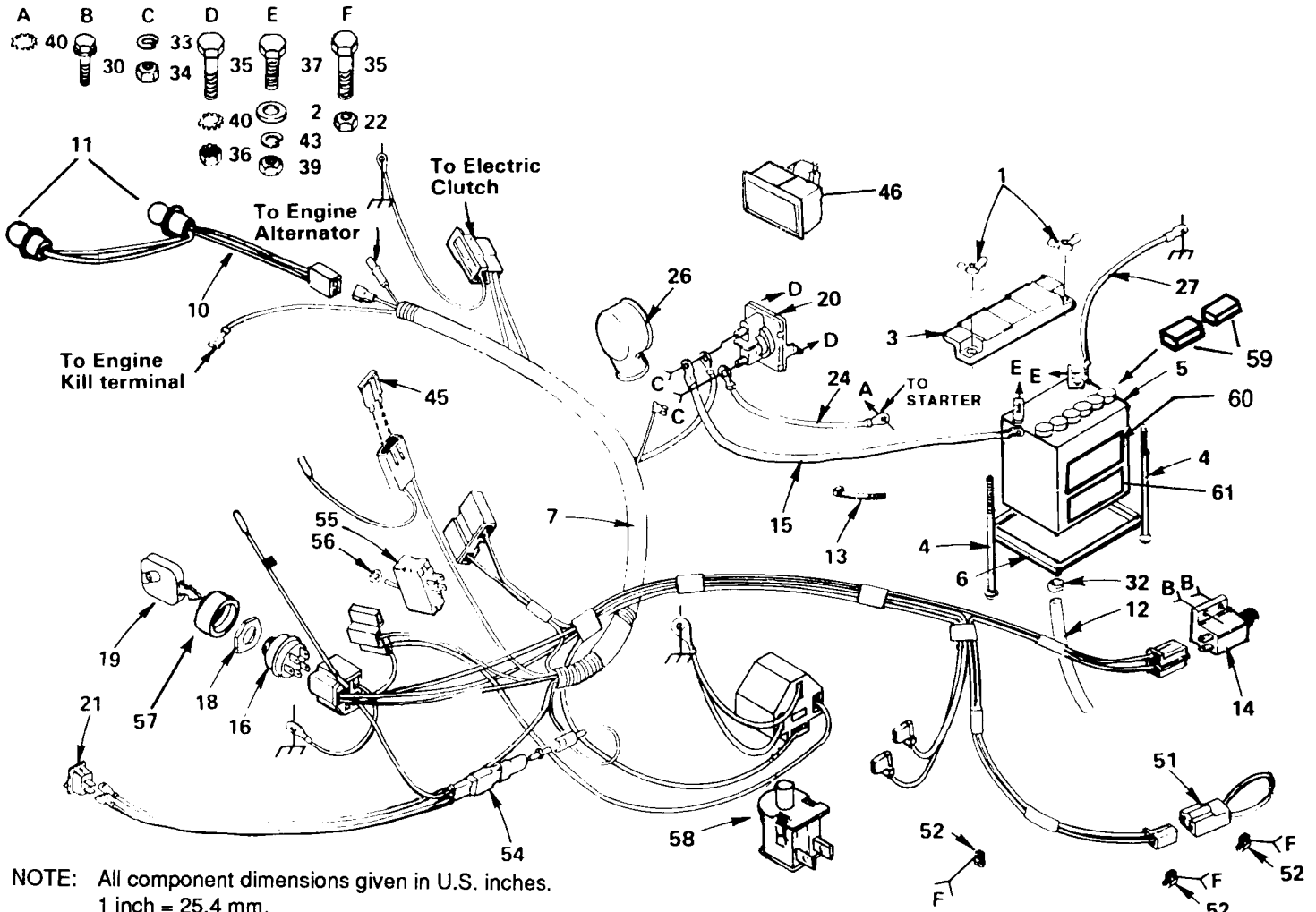
CRAFTSMAN®
18.0 HP TWIN IC
ELECTRIC START
44" MOWER DECK
6 SPEED TRANSAXLE
GARDEN TRACTOR

- Assembly
- Operation
- Maintenance
- Service and Adjustment
- Repair Parts

REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020

ELECTRICAL



NOTE: All component dimensions given in U.S. inches.
1 inch = 25.4 mm.

KEY PART NO.	NO.	DESCRIPTION	KEY PART NO.	NO.	DESCRIPTION
1	123198X	Wing Nut 1/4 - 20	30	STD601005 *	Screw - Tap. Hex Hd. No. 10 - 24 UNC x 1/2 Type T
2	STD551025 *	Washer 9/32 x 5/8 x 16 Ga.	32	109596X	Clamp - Hose
3	102476X	Guard - Terminal	33	STD551125 *	Lockwasher 1/4
4	STD532575 *	Bolt, Carriage 1/4- 20 x 7- 1/2	34	73350400 *	Nut - Hex Jam 1/4 - 20
5	121537X	Battery	35	74780408	Bolt-Hex 1/4 - 20 x 1/2 Gr. 5
6	7603J	Battery Tray	36	STD541425 *	Nut-Keps, Hex 1/4 - 20
7	124561X	Harness - Ignition	37	74760412	Bolt-Hex 1/4 - 20 x 3/4
10	110859X	Harness - Light Socket	39	STD541025 *	Nut-Hex 1/4 - 20
11	4152J	Bulb - Light	40	STD551125	Washer - Lock 1/4 Ext. Tooth
12	100541K	Tube - Battery Tray	43	STD551125 *	Lockwasher 1/4
13	7192J	Cable Tie	45	108824X	Fuse - 30 Amp.
14	104445X	Switch - Interlock - Clutch	46	121433X	Ammeter
15	4206J	Cable - Battery (Battery to Solenoid)	51	102501X	Loop - Wire
16	4406R	Ignition Switch	52	235R	Clip - Insulated
18	109788X	Nut - Ignition	54	106315X	Diode Assembly
19	109310X	Key	55	4021J	Switch PTO
20	109081X	Solenoid	56	4022J	Nut-Hex
21	110712X	Switch - Light	57	109787X	Bezel, Ignition
22	73680400	Nut - Hex 1/4 - 20	58	121305X	Switch Seat
24	4799J	Cable - Battery (Solenoid to Starter)	59	121264X	Cap Battery
26	719J	Terminal Cover (For Solenoid)	60	121549X	Decal Battery
27	4207J	Cable - Battery (Battery to Ground)	61	120960X	Decal, Battery
			---	124555X	Owner's Manual (English)
			---	101539X	Sheet, Instruction - Tractor 15° Slope (English)

REPAIR PARTS

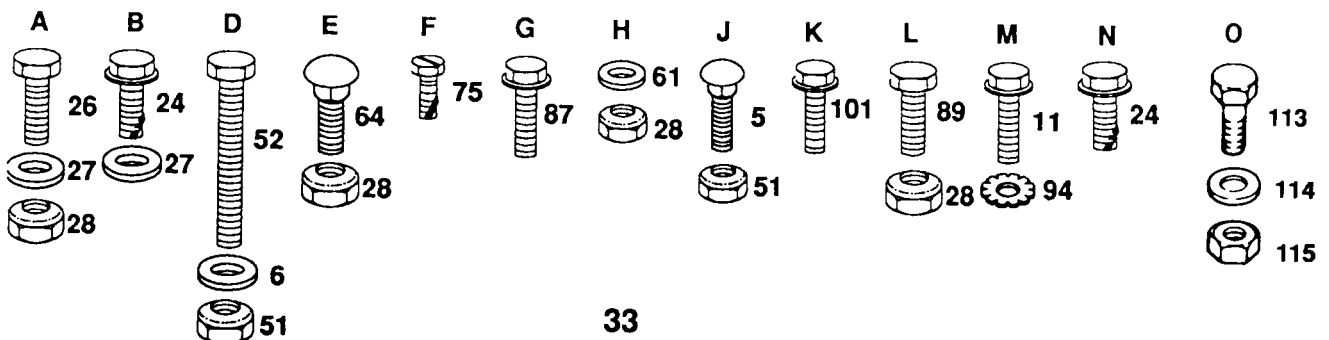
18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020

DRIVE

KEY PART NO. NO.	DESCRIPTION	KEY PART NO. NO.	DESCRIPTION
1	121327X	65	123766X
2	12000004	66	123789X
3	2228M	67	123205X
4	123797X	68	STD523715
5	STD533107	69	110812X
6	19111214	70	12000039
7	71208	71	105709X
8	125860X	72	105710X
9	126197X	73	73530400
10	100229L	74	124559X
11	17490628	75	17720410
12	STD541437	76	59192
14	108373X	77	65139
17	123796X	78	126609X
19	106933X	79	7154J
20	123781X	80	124074X
21	105701X	81	108097X
22	19171216	82	108236X
23	STD561210	83	12000053
24	17490612	84	104757X
25	105730X	85	9396E
26	STD523710	86	121218X
27	19131312	87	17490624
28	STD541437	88	19212016
29	8883R	89	STD523707
30	122424X	90	105706X
31	1572H	91	12000008
32	STD551062	92	123772X
34	123792X	93	123782X
35	126112X	94	STD551237
36	123788X	97	STD541437
37	109070X	98	109169X
38	4470J	101	17490512
39	123674X	102	2751R
40	STD523727	103	123793X
41	123795X	104	100091X
42	STD551143	105	110422X
43	71130764	106	4497H
44	123791X	107	105953X
46	123776X	108	13280336
47	120183X	109	STD522507
48	71040412	110	STD551125
49	STD551025	111	8545J
51	STD541431	112	13200300
52	74780544	113	74760516
53	123787X	114	19111212
54	123780X	115	STD541431
55	123794X	116	STD601005
56	STD561210		
57	125637X		
58	123786X		
59	124236X		
60	126909X		
61	STD551037		
62	123800X		
63	123102X		
64	STD533707		

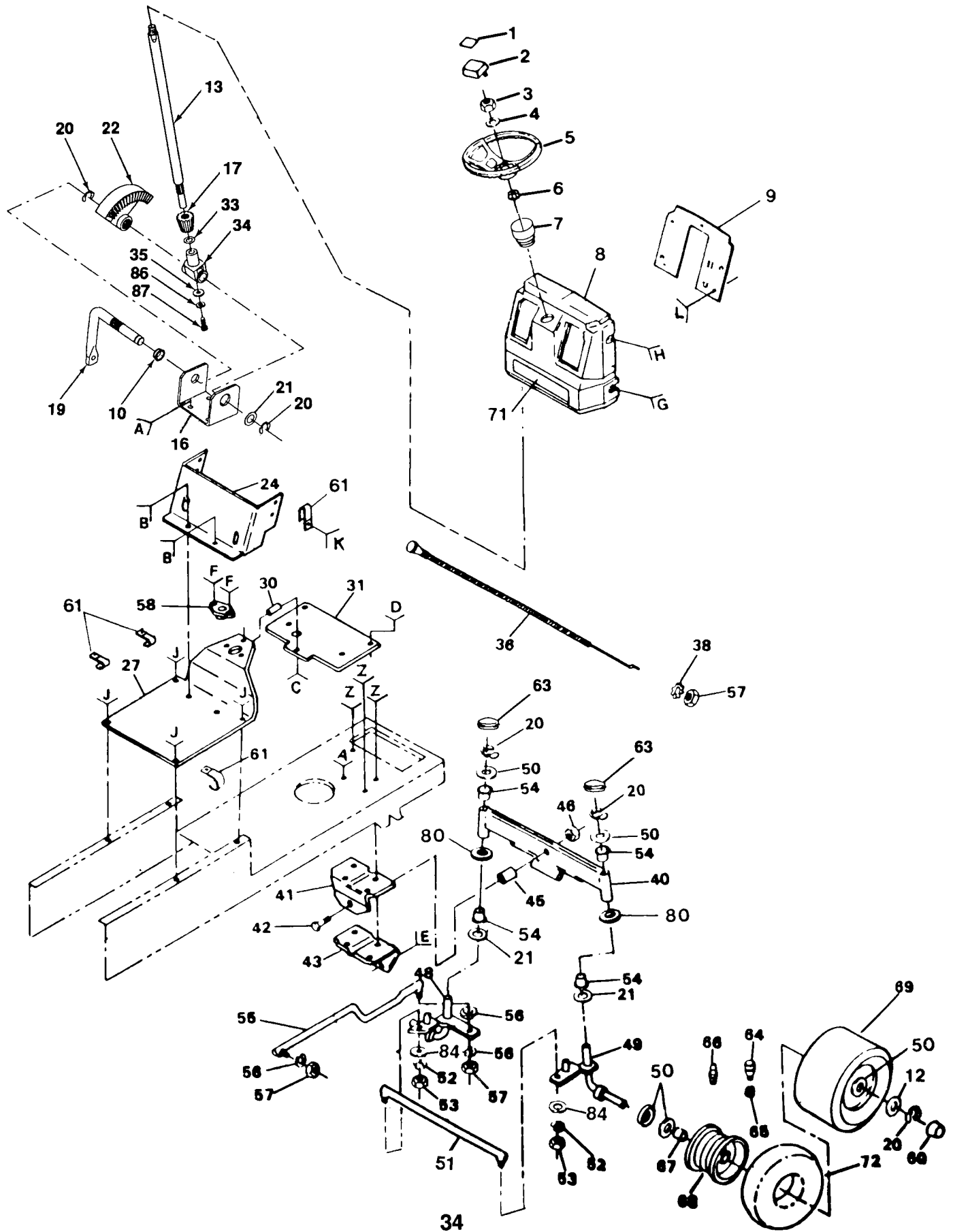
* STANDARD HARDWARE—PURCHASE LOCALLY

NOTE: All component dimensions given in U.S. inches -
1 inch = 25.4 mm



REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020
STEERING ASSEMBLY



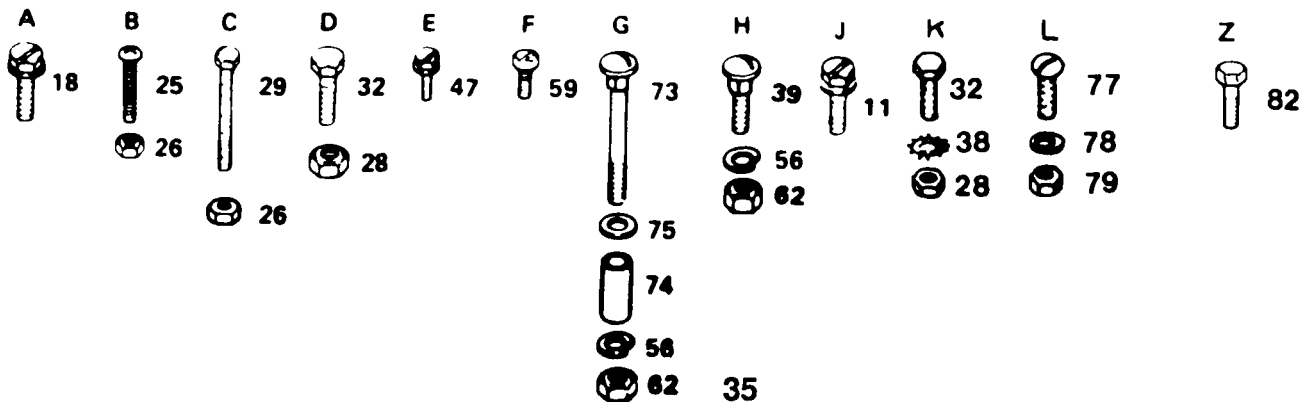
REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020 STEERING ASSEMBLY

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	105810X	Decal - Cap, Steering Wheel	46	73901000	Nut, Lock, Flange 5/8-11
2	100710L	Insert, Steering Wheel	47	17490508	Screw, Hex Washer Thd. Rolling 5/16-18 x 1/2
3	73940800	*Nut, Top Lock 1/2 - 20UNF	48	105656X	Spindle, L.H.
4	100712K	Washer	49	105654X	Spindle, R.H.
5	100713N	Wheel, Steering	50	121749X	Washer 25/32 x 1-1/4 x 16 Ga.
6	100711L	*Adapter - Steering Wheel	51	121334X	Rod, Tie
7	110709X	Column - Steering	52	STD551131	*Washer, Lock 5/16
8	120028X	Dash	53	STD541131	*Nut, Hex 5/16-24
9	124557X 011	Dash Plate	54	3366R	Bearing
10	109816X	Nyliner, Snap-In	55	124032X	Link, Drag
11	17490608	Screw, Hex Washer Thd. Rolling 3/8-16 x 1/2	56	STD551137	*Washer, Lock 3/8
12	121748X	Washer 25/32 x 1-5/8 x 16 Ga.	57	STD541137	*Nut, Hex 3/8-24
13	124041X	Shaft, Steering	58	1554J	Bushing, Steering
16	124036X	Bracket, Steering	59	17431008	Screw, Hex No. 10-16 x 1/2
17	124037X	Gear, Pinion	60	104757X	Cap, Hub, Front
18	17490612	Screw, Hex Washer Thd. Rolling 3/8-16 x 3/4	61	2751R	Clip, Fuel Line
19	124033X	Shaft, Pitman	62	STD541037	*Nut, Hex 3/8-16
20	12000029	Klip Ring	63	121232X	Spindle, Cap
21	6266H	Bearing, Thrust	64	59192	Cap, Valve
22	124034X	Gear, Sector	65	65139	Stem, Valve
24	105518X	Dash, Lower	66	6855M	Fitting, Grease
25	74180512	Screw, Crown Truss Hd. 5/16-18 x 3/4	67	9040H	Bearing
26	STD541431	Nut, Lock 5/16-18	68	106732X	Rim, 6" Front
27	123783X 012	Saddle	69	106222X	Tire, Front
28	STD541437	Nut, Lock 3/8-16	71	108456X	Decal, Instructions, Operating
29	STD523120	*Bolt, Hex 5/16-18 x 2	72	59904	Tube, Tire, Front
30	121236X	Spacer	73	72110622	Bolt, Carriage Hex 3/8-16 x 2-3/4
31	106001X	Support Plate, Battery	74	121235X	Spacer
32	STD523707	*Bolt, Hex 3/8-16 x 3/4	75	19131416	Washer 13/32 x 7/8 x 16 Ga.
33	57079	Washer	77	STD512507	*Screw, Pan Head 1/4-20 x 3/4
34	124035X	Shaft, Support	78	19091216	Washer 13/32 x 3/4 x 16 Ga.
35	126684X	Washer 5/8 x 1/4 x 16 Ga.	79	73510400	Nut, Keps 1/4 NC
36	121525X	Control, Choke	80	19272016	Washer 27/32 x 1-1/4 x 16 Ga.
38	STD551237	Washer, Lock, Int./Ext. Tooth 3/8	82	122819X	Screw, Special 3/8 - 16 x 3/4
39	72110608	Bolt, Carriage	84	19111216	Washer 11/32 x 3/4 x 16 Ga.
40	108075X	Axle, Front	86	STD551125	Lockwasher 1/4
41	105663X	Support, Saddle, Rear	87	71070410	Screw, Socket Hex 1/4 x 20 x 5/8
42	74761060	Bolt, Hex 5/8-11 x 3-3/4			
43	105664X	Support, Saddle, Front			
45	110438X	Spacer Bearing, Front Axle			

*STANDARD HARDWARE--PURCHASE LOCALLY

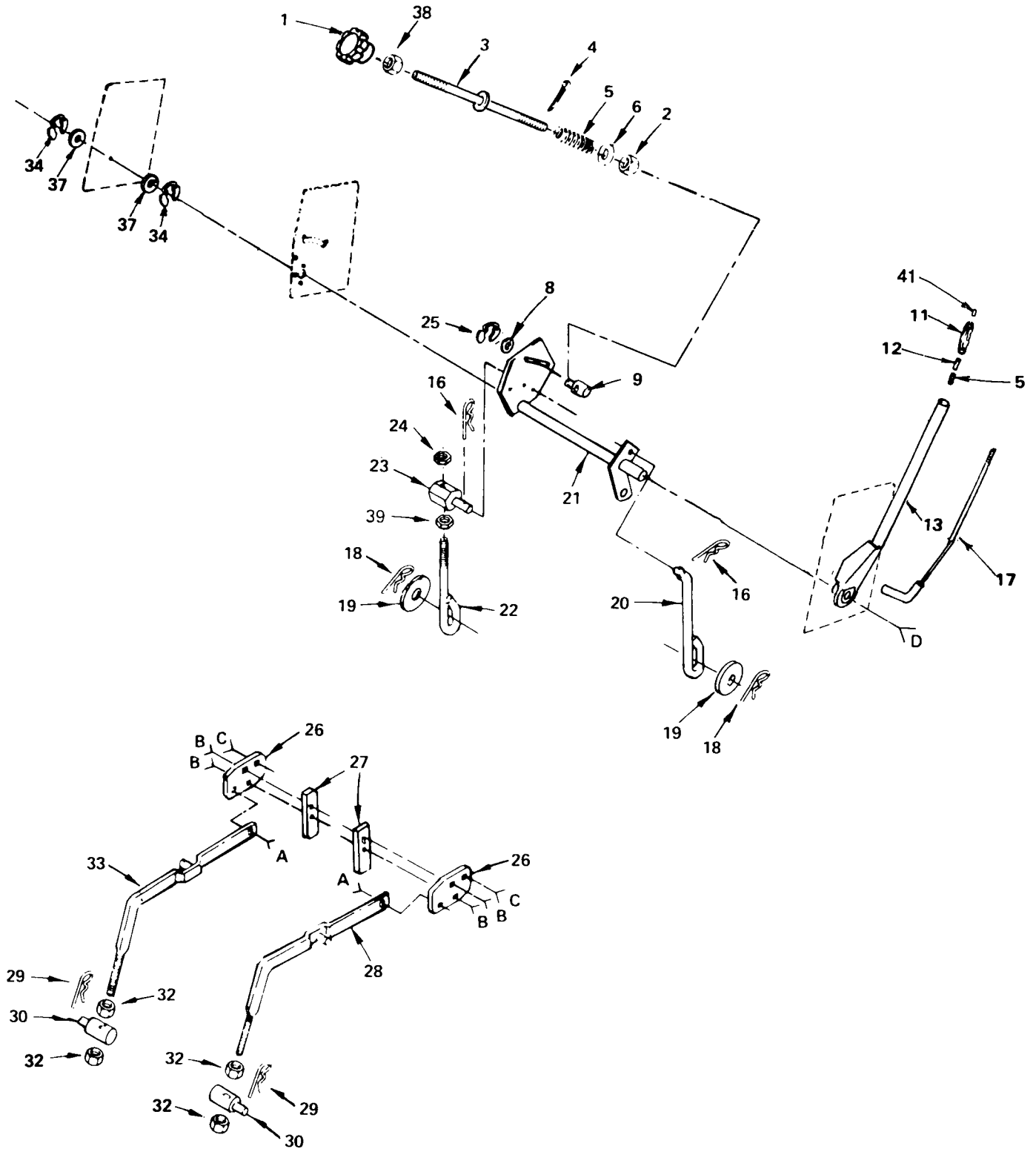
NOTE: All component dimensions given in U.S. inches -
1 inch = 25.4 mm



REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020

LIFT ADJUSTMENT



REPAIR PARTS

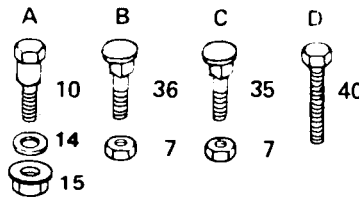
18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020

LIFT ADJUSTMENT

KEY PART NO. NO.	DESCRIPTION	KEY PART NO. NO.	DESCRIPTION
1	121891X Knob, Depth Adjustment	21	124516X Shaft - Lift
2	110807X Nut Hex Special	22	110448X Link - Lift, Adjust
3	110729X Rod - Adjust - Lift	23	110447X Trunnion - Lift
4	STD560907 * Pin - Cotter 3/32 x 1/2	24	73710700 Nut Lock 7/16 - 20 UNF
5	2876H Spring	25	12000037 Klip Ring
6	19131016 Washer 13/32 x 5/8 x 16 Ga.	26	105864X Bracket - Suspension
7	STD541437 * Nut - Lock 3/8 - 16	27	121252X Upstop Mower
8	19151216 Washer 15/32 x 3/4 x 16 Ga.	28	121598X Arm - Suspension - R.H.
9	110810X Trunnion	29	9135R Retainer Spring
10	105848X Bolt, Shoulder 3/8 - 16	30	106308X Trunnion - Lift - Lower
11	125631X Grip- Handle	32	STD541050 * Nut- Hex Fin. 1/2 - 13
12	122364X Plunger - Lever	33	121599X Arm - Suspension - L.H.
13	121004X Lever - Lift (Includes Key No. 17)	34	12000022 E-Ring
14	110739X Spring Washer	35	STD533710 * Bolt - Carriage 3/8 - 16 x 1
15	73980600 Center Lock Flangenut 3/8 x 16	36	STD533707 * Bolt Carriage 3/8 - 16 x 3/4
16	4939M Retainer - Spring	37	19292016 Washer 29/32 x 1 - 1/4 x 16 Ga.
17	121006X Rod - Lever	38	STD541237 * Nut., Hex Jam 3/8 - 16
18	4921H Retainer - Spring	39	STD541343 * Nut - Hex Jam 7/16-20
19	19171516 Washer 17/32 x 15/16 x 16 Ga.	40	74780624 Bolt - Hex 3/8 - 16 x 1 - 1/2
20	110029X Link - Lift	41	122365X Button - Plunger

*STANDARD HARDWARE—PURCHASE LOCALLY

NOTE: All component dimensions given in U.S. inches -
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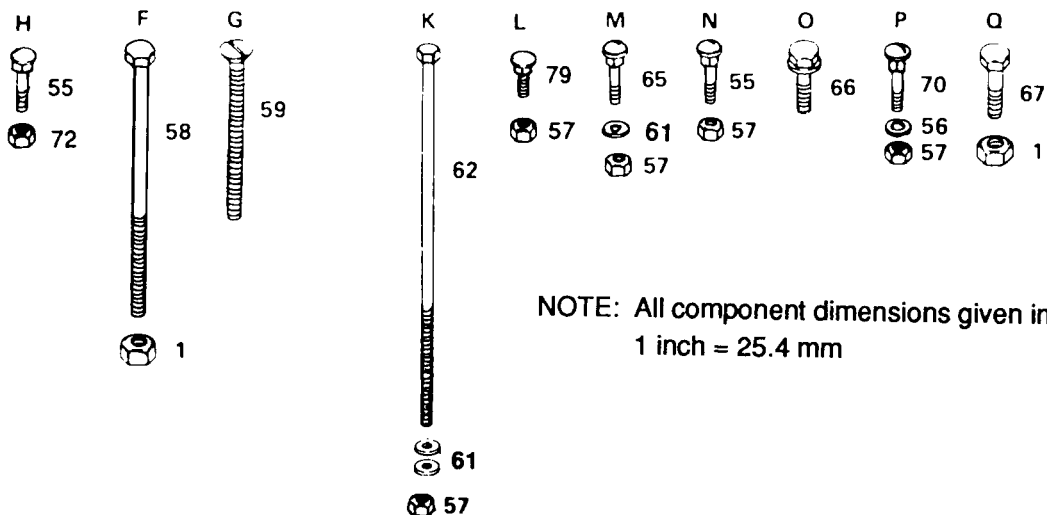
REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450

MOWER

KEY PART NO. NO.	DESCRIPTION	KEY PART NO. NO.	DESCRIPTION
1	STD541437 * Nut - Lock 3/8 - 16	40	19111016 Washer 11/32 x 5/8 x 16 Ga.
2	19131614 Washer 13/32 x 1 x 14 Ga.	41	Decal OPEI (not serviced)
3	121316X Pulley Idler	42	106735X Rod Hinge
4	102403X Pulley, Idler	43	106635X Blade
5	106902X Spacer	44	STD623715 * Bolt- Hex 3/8 - 24 x 1- 1/2 Gr. 5
6	677A451 Pulley Idler	45	19132012 Washer 13/32 x 1-1/4 x 12 Ga.
7	106513X Washer - Wear	46	7631J Runner - L.H.
8	121425X Arm - Idler	47	123807X Bracket Suspension, Rear-R.H.
9	109776X Pin - Pivot	48	123808X Bracket - Suspension, Rear-L.H.
10	106523X Bar Support - Idler	49	106223X Decal- V-Belt - Schematic
11	106522X Brace - Idler - Deck	50	105185X Instruction - Caution Decal
12	121236X Spacer	51	STD533717 * Bolt - Carriage 3/8 - 16 x 1 - 3/4
13	STD551037 * Washer, 13/32 X 13/16 X 16 Ga.	52	STD533710 * Bolt - Carriage 3/8 - 16 x 1
14	121658X Mandrel - Secondary	53	STD533715 * Bolt - Carriage 3/8 16 x 1-1/2
15	106214X Guard	54	STD523712 * Bolt - Hex 3/8 - 16 x 1 - 1/4
16	106085X V Belt	55	STD533107 * Bolt - Carriage 5/16- 18 x 3,4
17	STD541037 * Nut, Hex 3/8 - 16	56	STD551031 * Washer 11/32 x 11/16x 16 Ga.
18	STD551137 * Washer - Lock 3/8	57	STD541431 * Nut - Lock 5/16- 18
19	102932X Idler - Flat	58	STD523730 * Bolt - Hex 3/8 - 16 x 3
20	106526X Arm - Idler - Deck	59	74110632 Screw - Flat Head 3/8 - 16 x 2
21	7644J Spring- Extension	61	19111216 Washer 11/32 x 3/4x 16 Ga.
22	121705X Mandrel - Primary	62	STD523150 * Bolt - Hex 5/16 18 x 5
24	106511X Bracket Lift L.H.	65	STD533107 * Bolt - Carriage 5/16 - 18 x 5/8 UNC x 3/4
25	105662X Link Parallel	66	17490612 Screw - Hex Washer Thread Rolling 3/8 16 x 3/4
26	4921H Retainer - Spring	67	STD533707 * Bolt - Carriage 3/8 - 16 x 3/4
27	105744X Pin, Front Hinge	68	102727X Spring - Extension
28	109835X Pin, Rear Hinge	69	STD541437 * Nut - Centerlock 3/8 - 16
29	106512X Bracket Lift - R.H.	70	STD533107 * Bolt - Carriage 5/16 - 18 x 3/4
30	108119X Guard Belt - R.H.	72	1685H Nut - Lock 5/16 - 18
31	STD551137 Washer, Lock Hvy. Hel. Spring	75	72140620 Bolt, Carriage 3/8 - 16 X 2 1/2
32	8418J Runner - R. H.	76	19131210 Washer 13/32 x 3/4 x 10 Ga.
33	121423X Housing - Mower	77	STD533106 Washer, 13/32 X 7/8 X 10 Ga.
34	105304X Cap Sleeve	78	121352X Keeper - L.H. Mandrel
35	106734X Spring	79	72110505 * Bolt - Carriage 5/16 - 18 X 5/8
36	110452X Nut . Push	80	125728X Mower Deck, Complete
37	109743X Bracket - Deflector		
38	109785X Guard - Discharge		
39	121349X Decal - Warning		

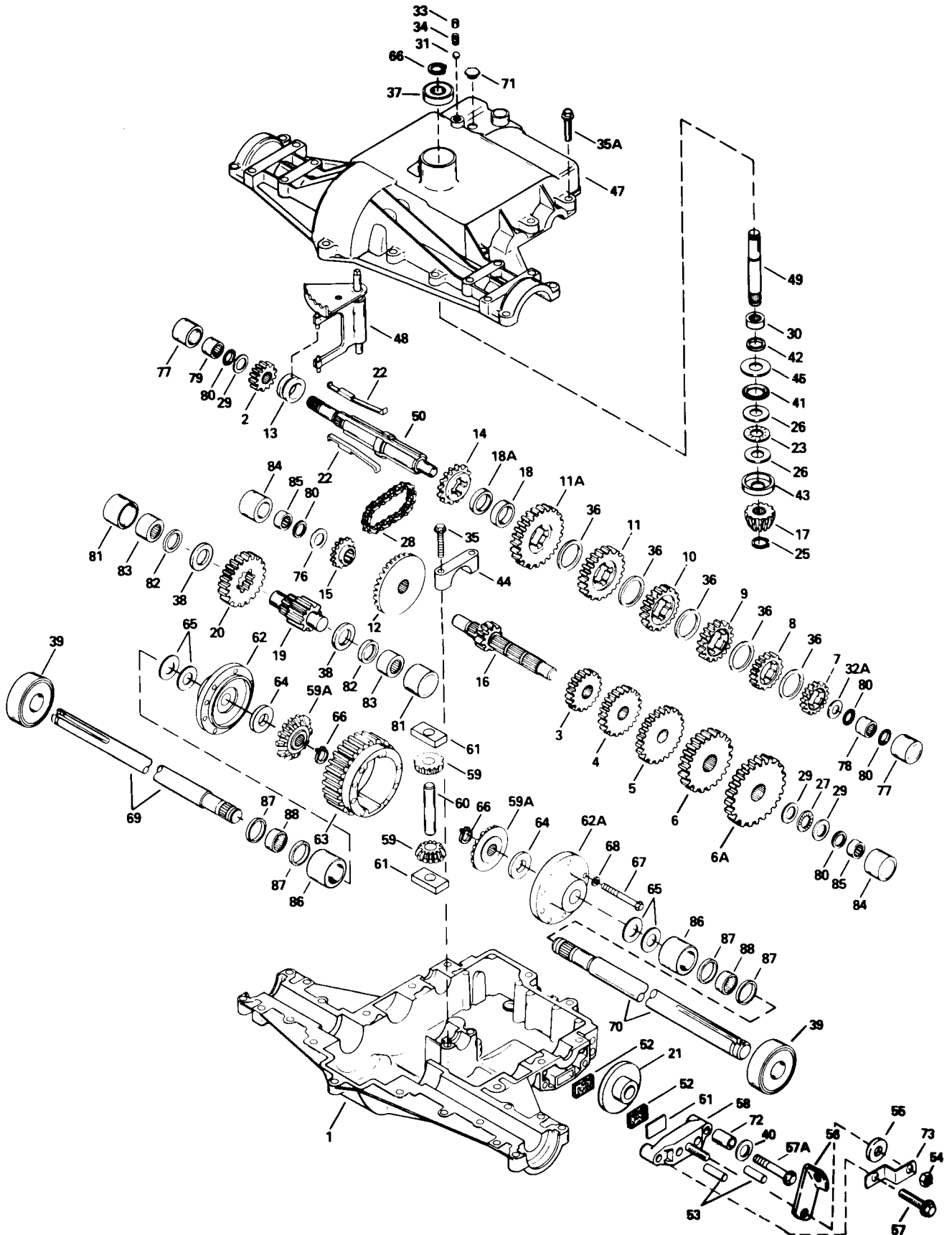
* STANDARD HARDWARE--PURCHASE LOCALLY



NOTE: All component dimensions given in U.S. inches - 1 inch = 25.4 mm

REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020
TRANSAXLE PEERLESS - - MODEL NUMBER 143-820-016



REPAIR PARTS

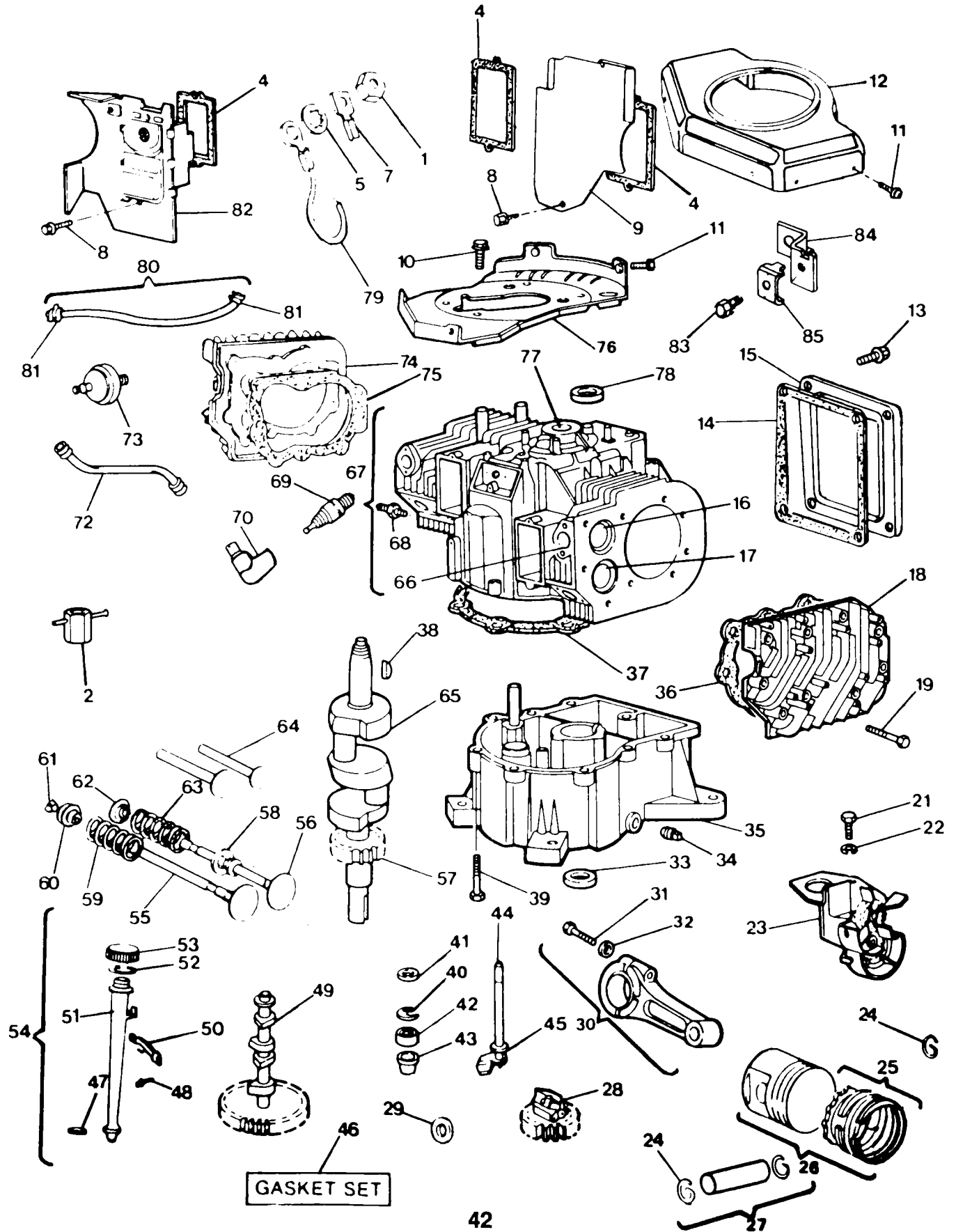
18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020 TRANSAXLE PEERLESS - - MODEL NUMBER 143-820-016

Ref. No.	Part No.	Part Name	Ref. No.	Part No.	Part Name
1	770088	Case, Transaxle	44	786131	Cap, Bearing
2	778253	Gear, Spur (15 teeth)	45	780165	Washer, Flat
3	778211	Gear, Spur (12 teeth)	47	772098	Cover, Transaxle
4	778240	Gear, Spur (18 teeth)	48	784342	Rod & Fork Assy., Shift
5	778201	Gear, Spur (25 teeth)	49	776274	Shaft, Input
6	778202	Gear, Spur (28 teeth)	50	776313	Shaft, Brake (4 Keyed)
6A	778208	Gear, Spur (31 teeth)	51	790007	Plate, Brake pad
7	778209	Gear, Spur (19 teeth)	52	790006	Pad, Brake
8	778203	Gear, Spur (22 teeth)	53	786026	Pin, Dowel
9	778204	Gear, Spur (25 teeth)	54	792075	Locknut, 5/16-24
10	778239	Gear, Spur (32 teeth)	55	792076	Washer, Flat
11	778207	Gear, Spur (37 teeth)	56	790047	Lever, Brake
11A	778216	Gear, Spur (41 teeth)	57	792073	Screw, Flanged hex hd. thread-forming, 1/4-20 x 1-1/4
12	778246	Gear, Bevel (33 teeth)	57A	792085	Screw, Flanged hex hd. thread-forming, 1/4-20 x 2-1/4
13	784216	Collar, Shift	58	790025	Holder, Brake pad
14	786123	Sprocket (18 teeth)	59	778197	Pinion, Differential bevel
15	786082	Sprocket (9 teeth)	59A	778198	Gear, Bevel
16	776291	Shaft, Counter (w/9 tooth gear)	60	786019	Pin, Drive
17	778245	Bevel Pinion, Input (13 teeth)	61	786027	Block, Drive
18	786121	Spacer, Natural (.350/.340 thick)	62	774833	Carrier, Differential (Threaded holes)
18A	786122	Spacer, Natural (.276/.268 thick)	62A	774834	Carrier, Differential
19	776275	Shaft, Output (9 teeth)	63	778248	Gear, Ring (31 teeth)
20	778247	Gear, Output (35 teeth)	64	780107	Washer
21	790043	Disk, Brake	65	780042	Washer, Thrust
22	792138	Key	66	792018	Ring, Snap
23	780084	Bearing, Thrust	67	792020	Screw, Hex hd., 1/4-20 x 2-1/4
25	788040	Ring, Retaining	68	792006	Lockwasher, 1/4"
26	780051	Washer, Thrust	69	774832	Axle (12-5/16" long)
27	780071	Bearing, Thrust	70	774831	Axle (16-3/16" long)
28	786081	Chain, Roller (No. 41 chain, 24 links)	71	792074	Plug, Hex hd., 9/16-18 thread
29	780072	Washer, Thrust	72	786067	Spacer
30	780155	Bearing, Needle	73	786086	Bracket, Brake lever
31	792077	Ball, Steel	76	780153	Washer
32A	780139	Washer, Thrust	77	786144	Sleeve (stepped)
33	792078	Screw, Set, 3/8-16 x 3/8	78	780150	Bearing, Needle
34	792079	Spring	79	780152	Bearing, Needle (capped)
35	792073	Screw, Flanged hex hd. thread-forming, 1/4-20 x 1-1/4	80	792001	"O" Ring
35A	792129	Screw, Hex hd. threadforming, 5/16-18 x 1-1/4	81	786142	Sleeve (stepped)
36	780108	Washer, Thrust	82	788071	Ring, Square cut
37	780119	Bearing, Ball	83	780049	Bearing, Needle (capped)
38	780128	Washer, Thrust	84	786143	Sleeve (stepped)
39	780050	Bearing, Ball	85	780151	Bearing, Needle (capped)
40	792128	Washer, Flat	86	786145	Sleeve (stepped)
41	788077	"O" Ring	87	788070	Ring, Square cut
42	788042	Seal, Oil	88	780031	Bearing, Needle
43	780166	Washer, Cupped			

NOTE: All component dimensions given in U.S. inches.
1 inch = 25.4 mm.

REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020
ENGINE BRIGGS AND STRATTON - MODEL NUMBER 422707, TYPE NUMBER 1228-01
CYLINDER, CRANKSHAFT AND ENGINE BASE GROUP



REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020 ENGINE BRIGGS AND STRATTON - MODEL NUMBER 422707, TYPE NUMBER 1228-01 CYLINDER, CRANKSHAFT AND ENGINE BASE GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	90576	Nut - Hex 8 - 32	38	222698	Key - Flywheel
2	89838	Wrench, Spark Plug	39	93585	Screw - Hex Hd. Sem
4	27803	*Gasket - Valve Cover	40	94296	Retainer - E-Ring
5	92791	Washer - Lock, Shakeproof	41	491287	Foam Seal - Governor Shaft
6	222892	Cover - Breather Cylinder No. 2	42	262331	Upper Bushing - Governor
7	93722	Terminal - Spade	43	262332	Lower Bushing - Governor
8	94382	Screw - Sem	44	491530	Crank - Governor
9	224362	Baffle - Air	45	223882	Washer - Governor Crank (Inside)
10	93777	Screw - Hex Head (Back Plate to Cylinder)	46	394501	Gasket Set
11	93559	Screw - Sem	47	271157	Seal - Filler Tube
12	492656	Housing - Blower	48	94166	Screw - Hex Head
13	90887	Screw - Crankcase Cover Mtg. Sem NOTE: USES 92228 LOCKWASHER	49	212337	Gear - Cam
14	270981	*Gasket - Crankcase	50	222875	Clamp - Oil Filler
15	212455	Cover Plate - Crankcase	51	280224	Tube - Oil Filler
16	261463	+Seat - Intake Valve (Standard)	52	271170	Seal - Oil Filler Cap
17	213316	+Seat - Exhaust Valve (Standard)	53	394020	Cap and Dipstick - Oil Filler
18	493458	Head - Cylinder No. 2	54	394394	Dipstick and Tube Assembly (Inc. Key Nos. 47, 48, 50, 51, 52 & 53)
19	94565	Screw - Cylinder Head	55	390420	Valve - Exhaust
21	93686	Screw - Hex Head (10 - 32 x 5/8)	56	261528	Valve - Intake
22	92290	Washer - Lock (No. 10 x 1/16 x 3/64)	57	231445	Gear - Timing
23	393415	Oil Slinger Assembly	58	393606	Seal Assembly and Retainer
24	260924	Lock - Piston Pin	59	26828	Spring - Exhaust Valve
25	394959	Ring Set - Piston (Standard)	60	292260	Rotocoil - Exhaust Valve
25	394960	Ring Set - Piston (.010" O.S.)	61	93630	Retainer - Exhaust Valve Rotocoil
25	394961	Ring Set - Piston (.020" O.S.)	62	221596	Retainer - Intake Valve
25	394962	Ring Set - Piston (.030" O.S.)	63	65906	Spring - Intake Valve
26	394955	Piston Assembly (Standard) (Inc. Key Nos. 24 & 25)	64	261368	Tappet - Valve
26	394956	Piston Assembly (.010" O.S.)	65	394028	Crankshaft NOTE: ORDER NO. 94196 FOR TIMING GEAR RETAINING DEVICE
26	394957	Piston Assembly (.020" O.S.)	66	261961	+Guide - Exhaust Valve NOTE: 231218 GUIDE INTAKE (BRASS)
26	394958	Piston Assembly (.030" O.S.)			
27	299691	Pin Assembly - Piston (Standard) (Inc. Key No. 24)	67	491730	Cylinder Assembly (Inc. Key No. 68)
27	391286	Pin Assembly - Piston (.005" O.S.)	68	230318	Connector - Impulse Pump
28	394348	Gear - Governor	69	802592	Plug - Spark (Resistor)Champion RJ-12 or equivalent
29	222773	Washer - Thrust			
30	394306	Rod Assembly - Connecting (Inc. Key Nos. 31 & 32) NOTE: FOR CONNECTING ROD WITH .020" UNDERSIZE CRANKPIN BORE, ORDER NO. 397158	70	66538	Elbow - Spark Plug
			72	280225	Tube Breather
			73	394358	Filter - Fuel (In Fuel Line to Tank)
			74	493457	Head - Cylinder No. 1
			75	271867	*Gasket - Cylinder
31	92909	Screw - Connecting Rod	76	491304	Back Plate Assembly
32	220863	Washer	77	399265	+Bearing - Cylinder
33	291675	Seal - Oil	78	391086	Seal - Oil
34	91084	Plug - Oil Drain	79	391115	Wire - Ground
35	393552	Base Assembly - Crankcase	80	299146	Line - Fuel (28" cut to required length) (Inc. Key No. 81)
36	271868	*Gasket - Cylinder Head No. 2			
37	271142	*Gasket - Crankcase Cover (1/64" thick)	81	93053	Clamp - Fuel Line
37	271188	*Gasket - Crankcase Cover (.005" thick)	82	393370	Breather Assembly No. 1
37	271189	*Gasket - Crankcase Cover (.009" thick)	83	93496	Screw - Hex Head
			84	223890	Bracket - Choke Cable
			85	221535	Clamp - Casing

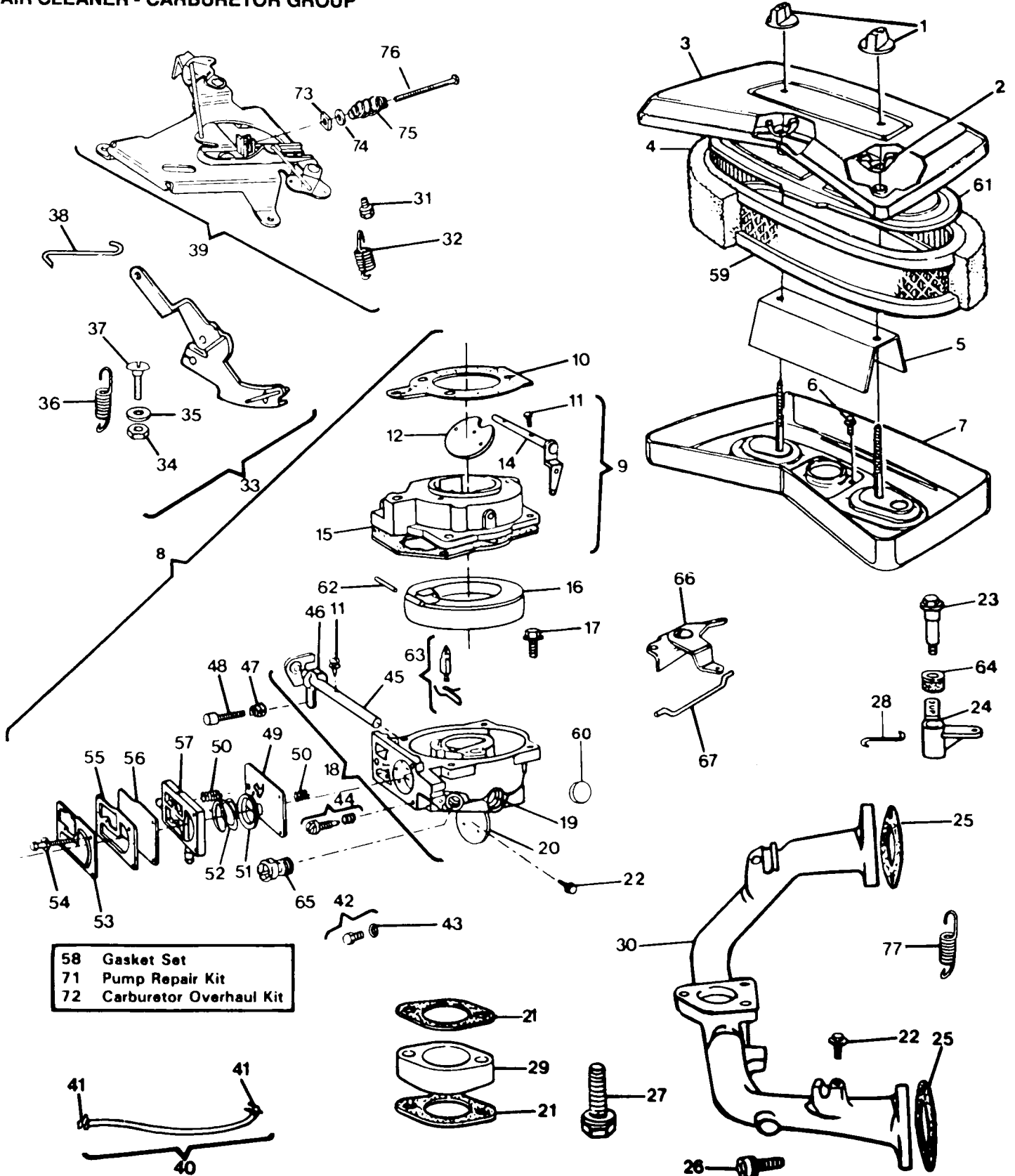
NOTE: All component dimensions given in U.S. inches.
1 inch = 25.4 mm.

*INCLUDED IN GASKET SET 394501
+SPECIAL TOOLS REQUIRED TO INSTALL

REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020
 ENGINE BRIGGS AND STRATTON - MODEL NUMBER 422707, TYPE NUMBER 1228-01

AIR CLEANER - CARBURETOR GROUP



- | | |
|----|-------------------------|
| 58 | Gasket Set |
| 71 | Pump Repair Kit |
| 72 | Carburetor Overhaul Kit |

REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020 ENGINE BRIGGS AND STRATTON - MODEL NUMBER 422707, TYPE NUMBER 1228-01

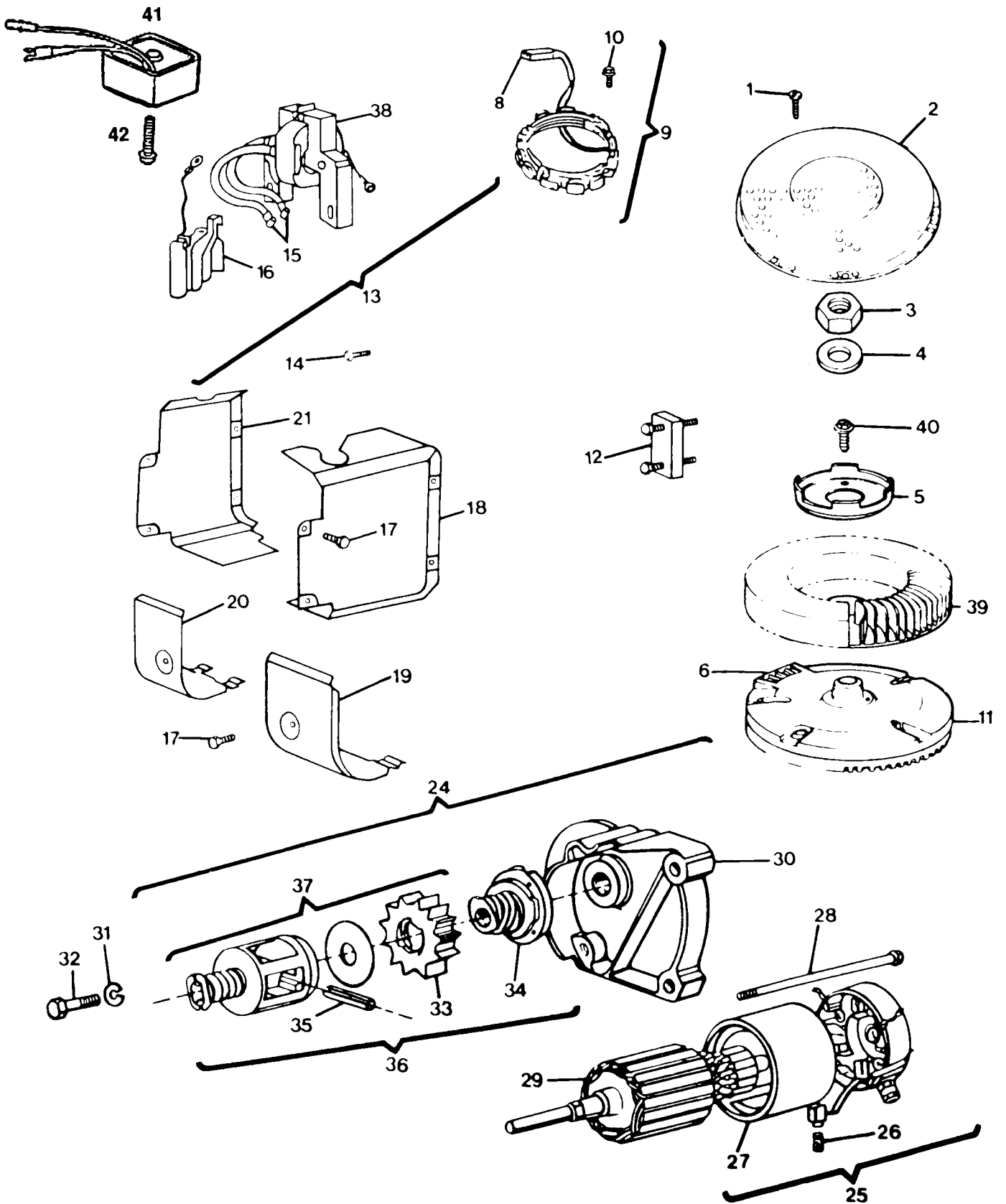
AIR CLEANER - CARBURETOR GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	212706	Knob - Air Cleaner	38	262683	Link - Governor
2	94289	Nut - Hex	39	491282	Plate Assembly - Governor Control
3	223579	Cover - Air Cleaner	40	393815	Impulse Line and Clamp Assembly (Inc. Key No. 41)
4	271271	Element - Air Cleaner	41	93053	Clamp - Fuel Line
5	224039	Mounting Strap Assembly - Air Cleaner	42	397882	Plug and Seal, Solenoid
6	94166	Screw - Hex Head	43	280474	O-Ring Seal
7	398826	Body - Air Cleaner	44	491538	+ Valve Assembly - Carburetor Idle
8	491429	Carburetor Assembly (Inc. Key Nos. 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 62 & 63)	45	392672	Shaft and Lever - Throttle
9	491541	Body Assembly - Upper Carburetor	46	271013	+ Washer - Choke Shaft
10	271411	Gasket - Air Cleaner	47	26157	Spring - Throttle Adjustment
11	93499	Screw - Throttle and Choke	48	91920	Screw - Machine Fill. Hd. (8 - 32 x 5/8)
12	223534	Valve - Choke	49	270988	x Diaphragm
14	392673	Shaft and Lever - Choke	50	261358	x Spring
15	271607	+ Gasket - Carburetor Body	51	221377	x Cap - Spring
16	298514	Float - Carburetor	52	261395	x Spring - Pump
17	94152	Screw - Hex Head Sem (10 - 32 x 3/4)	53	223688	Cover - Diaphragm
18	491543	Body - Lower Carburetor (Inc. Key Nos. 11, 19, 20, 45 & 46)	54	93829	Screw - Diaphragm - Damping
19	231209	Bushing - Throttle Shaft	55	271025	x Gasket - Carburetor Pump
20	221939	Valve - Throttle	56	270989	x Diaphragm - Damping
21	271412	+ * Gasket - Carburetor and Intake Elbow	57	280197	Body - Pump
22	93897	Screw - Sem	58	394501	Gasket Set
23	93971	Screw - Hex Head	59	394019	Cartridge - Air Cleaner
24	280997	Crank - Bell	60	223472	Plug - Welch
25	270884	* Gasket - Intake Manifold Mounting	61	223714	Cartridge Plate - Air Cleaner
26	93208	Screw - Intake Manifold Mounting	62	230896	+ Pin - Float Hinge
27	93970	Screw - Hex Head	63	394683	+ Valve - Fuel Inlet
28	262684	Link - Throttle	64	271013	Washer
29	280319	Spacer - Carburetor	65	231338	° Jet - Needle Valve (Fixed)
30	213290	Manifold Assembly - Intake	66	490207	Crank - Bell
31	93949	Screw - Sem	67	262375	Link
32	262351	Spring - Governor	71	393397	Repair Kit - Pump
33	491297	Lever Assembly - Governor (Inc. Key Nos. 34, 35 & 37)	72	491539	Overhaul Kit - Carburetor
34	92278	Nut - Hex (10 - 24)	73	94298	Nut - Square
35	222289	Washer	74	223882	Washer
36	261563	Spring - Governor Idle	75	262337	Spring - Compression
37	93853	Bolt - Governor Lever	76	94297	Screw - Pan Head
			77	262539	Spring, Gov. Control
					*INCLUDED IN GASKET SET 394501
					+INCLUDED IN CARBURETOR OVERHAUL KIT 491539
					xINCLUDED IN CARBURETOR OVERHAUL KIT 491539 AND PUMP REPAIR KIT 393397
					°HIGH ALTITUDE — JET NEEDLE VALVE — PART NO. 231333

NOTE: All component dimensions given in U.S. inches.
1 inch = 25.4 mm.

REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020
ENGINE BRIGGS AND STRATTON - MODEL NUMBER 422707, TYPE NUMBER 1228-01
ALTERNATOR AND STARTER MOTOR GROUP



REPAIR PARTS

18 HP GARDEN TRACTOR - - MODEL NUMBER 917.254450 & 917.250020 ENGINE BRIGGS AND STRATTON - MODEL NUMBER 422707, TYPE NUMBER 1228-01 ALTERNATOR AND STARTER MOTOR GROUP

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	94326	Screw - Sem	21	222848	Cover - Air Guide
2	222673	Screen - Flush Rotating	24	394808	Motor - Starting (Inc. Key Nos. 25, 26, 27, 28, 29, 30, 33, 34, 35, 36 & 37)
3	230674	Nut - Hex	25	395537	Commutator End Cap Assembly Starter (Inc. Key No. 26)
4	222511	Washer - Spring	26	395538	Brush Set
5	223726	Retainer - Fan	27	393825	Housing Assembly
6	491179	Flywheel and Ring Gear Assembly - Magneto	28	94003	Thru Bolt
8	393537	Diode and Connector Assembly	29	390837	Armature Assembly (Motor)
9	392595	Stator - Alternator (Dual Circuit) (Inc. Key No. 8)	30	394860	Drive End Cap Assembly - Starter
10	93621	Screw - Sem	31	90366	Lockwasher
11	391362	Gear - Flywheel Ring (Includes Mounting Parts)	32	91162	Screw - Hex Head (5/16 - 18 x 1-1/2)
12	19203	Puller - Flywheel (Optional Accessory)	33	280104	Gear - Starter
13	394891	Armature Group (Inc. Key Nos. 15, 16 & 38)	34	398003	Clutch Assembly - Starter
14	93381	Screw - Armature Mounting Sem	35	94288	Roll Pin
15	221798	Terminal - Ignition Cable	36	490421	Pinion Spring Kit (Inc. Key Nos. 33 & 35)
16	394970	Trigger Coil Assembly Magnatron Ignition	37	490467	Starter Drive Group (Inc. Key Nos. 33, 34, 35 & 36)
17	93163	Screw - Sem	38	394988	Armature Assembly
18	222849	Cover - Air Guide	39	280815	Fan - Flywheel
19	222734	Shield - Cylinder	40	93535	Screw - Sem
20	222846	Shield - Cylinder	41	491546	Regulator, Alternator
			42	94137	Screw, Regulator

NOTE: All component dimensions given in U.S. inches.
1 inch = 25.4 mm.

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 accept Wand 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

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. 71-244010