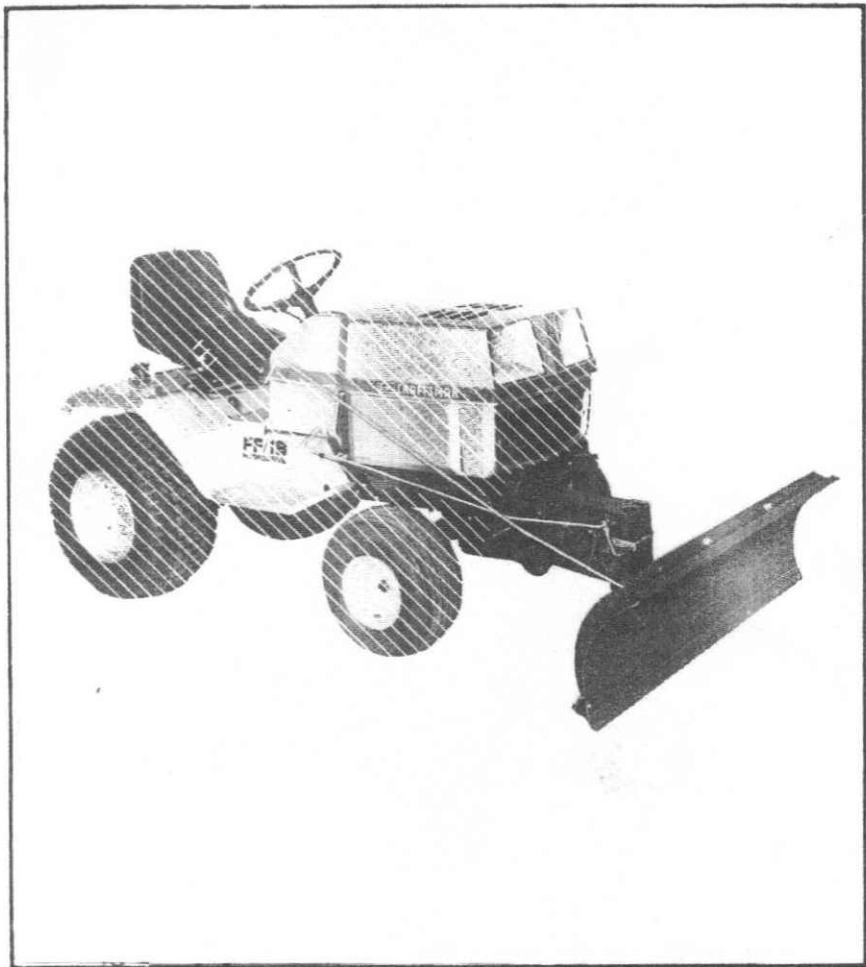


Sears

**OWNERS
MANUAL**

MODEL NO.
917.25410

Caution:
Read Rules for
Safe Operation
and Instructions
Carefully



**54 INCH
DOZER BLADE
FOR SEARS
FULL FEATURE
TRACTORS**

**Assembly
Installation
Operation
Repair Parts**

Sears, Roebuck and Co., Chicago, Ill. 60684, U.S.A.

WARRANTY FULL ONE YEAR WARRANTY

For one year from date of purchase, Sears will repair any defect in material or workmanship in this tractor attachment, at no charge.

If the tractor attachment is used for commercial or rental purposes, this warranty applies for only thirty days from date of purchase.

Warranty service is available at your home, at no charge, by simply contacting your nearest Sears store or Service Center throughout the United States.

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

SEARS ROEBUCK AND CO.

Sears Tower

BSC 41-3

Chicago, Il. 60684

RULES FOR SAFE OPERATION

1. Know the controls and how to stop quickly. **READ THE OWNER'S MANUAL.**
2. Do not allow children to operate the vehicle. Do not allow adults to operate it without proper instruction.
3. Do not carry passengers. Keep children and pets a safe distance away.
4. Always wear substantial footwear. Do not wear loose fitting clothing that could get caught in moving parts.
5. Keep your eyes and mind on your tractor, blade and the area being dozed. Don't let other interests distract you.
6. Do not attempt to operate your tractor when not in drivers seat.
7. Always get on or off your tractor from the operators left hand side.
8. Disengage all attachment clutches and shift into neutral before attempting to start the engine.
9. Disengage power to attachments and stop the engine before leaving the operator's position.
10. Stop the engine and disconnect spark plug wire(s) from spark plug(s) before cleaning, making an adjustment or repairs.
11. Disengage power to attachments when transporting or not in use.
12. Take all possible precautions when leaving the vehicle unattended, such as disengaging the power-take-off, lowering the attachments, shifting into neutral, setting the parking brake, stopping the engine, and removing the key.
13. Do not stop or start suddenly when going uphill or downhill (not greater than 15°); never across the face.
14. Reduce speed on slopes and make turns gradually to prevent tipping or loss of control. Exercise extreme caution when changing direction on slopes.
15. Do not shift gears while going up or down slopes. Choose a gear low enough to negotiate the slope without stopping and shifting gears. To reduce speed, move throttle lever to slow.
16. Stay alert for holes in the terrain and other hidden hazards.
17. Do not drive too close to creeks, ditches and public highways.
18. Exercise special care when dozing around fixed objects in order to prevent the blade from striking them. Never deliberately run tractor or blade into or over any foreign object.
19. Never shift gears until tractor comes to a stop.
20. 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 in this owner's manual.
21. Watch out for traffic when crossing or near roadways.
22. When using any attachments, don't allow anyone near the vehicle while in operation.
23. Handle gasoline with care - it is highly flammable.
 - a. Use approved gasoline containers.
 - b. Never remove the cap of the fuel tank or add gasoline to a running or hot engine, or fill the fuel tank indoors. Wipe up spilled gasoline.
 - c. Open doors if the engine is run in the garage - exhaust fumes are dangerous. Do not run the engine indoors.
24. Keep the vehicle and attachments in good operating condition, and keep safety devices in place.
25. Keep all nuts, bolts and screws tight to be sure the equipment is in safe working condition.
26. Never store the equipment with gasoline in the tank inside a building where fumes may reach an open flame or spark. Allow the engine to cool before storing in any enclosure.
27. To reduce fire hazard, keep the engine free of grass, leaves or excessive grease.
28. Except for adjustment; **DO NOT** operate Engine if air cleaner or cover directly over carburetor air intake is removed. Removal of such part could create a fire hazard.
29. **DO NOT OPERATE WITHOUT A MUFFLER OR TAMPER WITH THE EXHAUST SYSTEM.** Damaged mufflers or spark arresters could create a fire hazard. Inspect periodically and replace if necessary.
30. 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.
31. Do not change the engine governor settings or overspeed the engine.
32. When using the vehicle with dozer, proceed as follows:
 - a. Doze only in daylight or in good artificial light.
 - b. Check the blade mounting bolts for proper tightness at frequent intervals.



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

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ASSEMBLY INSTRUCTIONS1
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ASSEMBLY

To assemble your Dozer you will need:

- 1/2" wrench
- 9/16" wrench
- 3/4" wrench
- 11/16" wrench
- 15/16" wrench
- screwdriver
- hammer

Remove mower or any other attachment you may have mounted to your tractor.

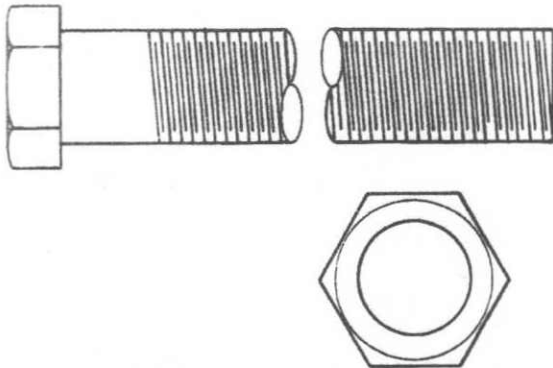
Your shipment consists of one carton containing the Dozer and the Lift Mechanism. Remove contents of carton and cut shipping wires.

YOU SHOULD HAVE TIRE CHAINS AND WHEEL WEIGHTS.

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

INSTRUCTIONS FOR SEARS FF/18, FF/20 AND FF/24 HYDRODRIVE GARDEN TRACTORS.

1. Place (2) 2" blocks of wood under Front Wheels (Fig. 1). Set brake to prevent tractor movement.
2. Insert Lift Tube Assembly (Fig. 1) in opening (left side) of Front Frame Bracket, threaded Lift Rod to front.
3. Assemble Boot Assembly to Blade Mounting Bracket Assembly (Fig. 2) using:



one (4") Hex Bolt and one Hex Nut (shown full size above) found in bag of parts.

- a. Secure Boot Assembly to Blade Mounting Bracket Assembly with Bolt and Hex Nut. Just snug up Nut parts must move freely.
4. Remove Rear Pivot Shafts from Lift Channel Assembly and Channel Assembly by removing Klip Rings and Washers (Fig. 3). Assemble Lift Channel Assembly and Channel Assembly to Mounting Bracket Assembly with Rear Pivot Shafts. Replace Washers and Klip Rings.

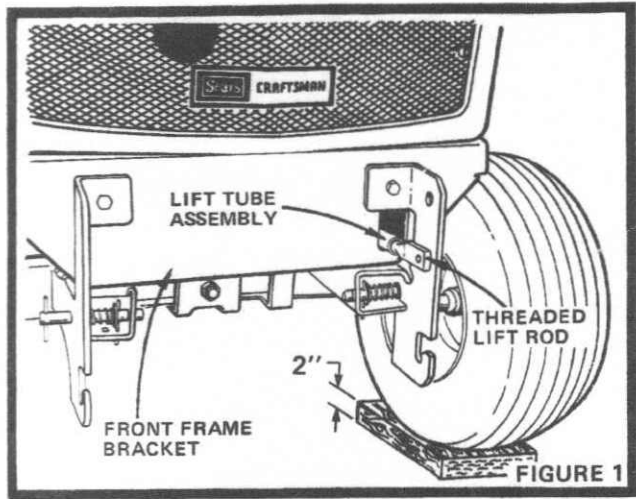


FIGURE 1

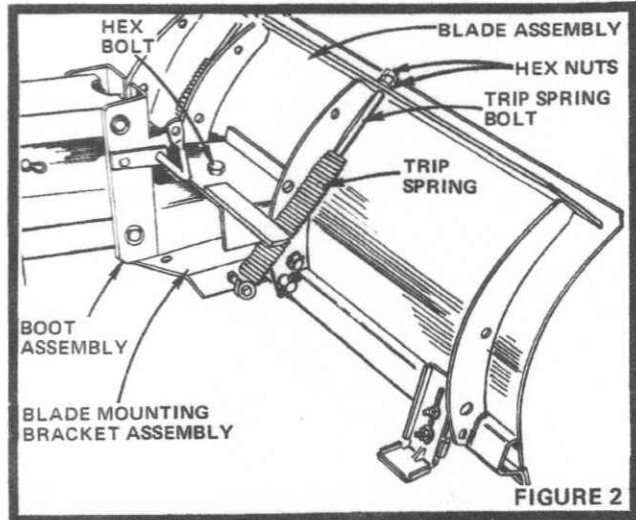
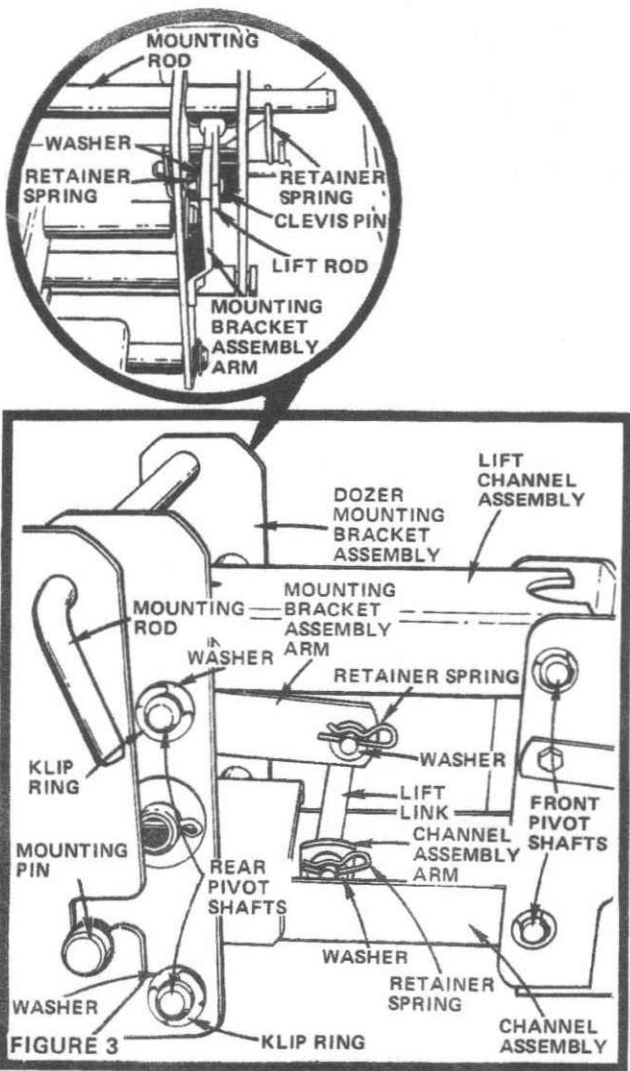
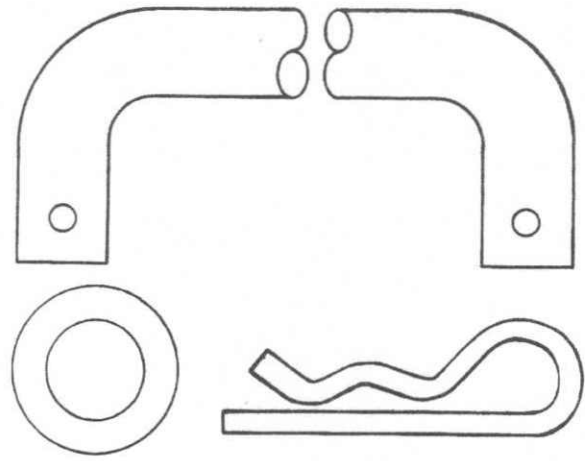


FIGURE 2



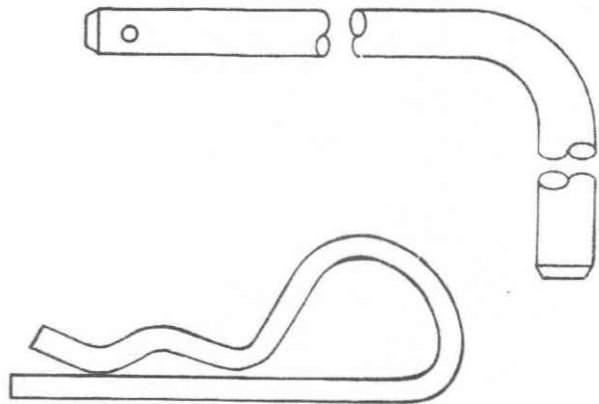
5. Assemble Lift Link to Mounting Bracket Assembly Arm and Lift Channel Assembly Arm (Fig. 3) using:



two Washers, two Retainer Springs (shown full size above) and one Lift Link found in bag of parts.

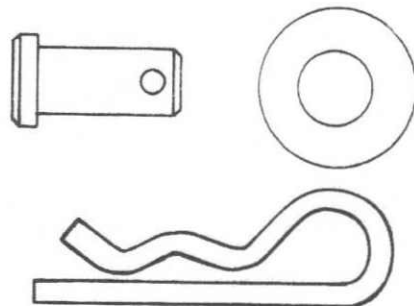
6. Insert Mounting Pins of Dozer Mounting Bracket Assembly into Hitch Slots (Fig. 3).

7. Assemble Dozer Mounting Bracket Assembly to Front Hitch Assemblies (Fig. 3) using:



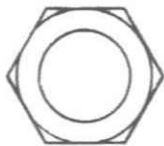
one Retainer Spring (shown full size above and one Mounting Rod found in Tube of Mounting Bracket Assembly).
 a. Insert Mounting Rod thru holes of Front Hitch Assemblies and Dozer Mounting Bracket Assembly. Secure with Retainer Spring (Fig. 3 - Inset).

8. Attach Lift Rod to Mounting Bracket Assembly Arm (Fig. 3 - Inset) using:



one Clevis Pin, one Washer and one Retainer Spring (shown full size above) found in bag of parts.
 a. Place Lift Rod on L.H. side of Mounting Bracket Assembly Arm. Insert Clevis Pin thru Rod and Arm. Place Washer over Pin and secure with Retainer Spring (Fig. 3 - Inset).

9. Assemble a second Hex Nut (shown full size below) found in bag of parts to each Trip Spring Bolt (Fig. 4).



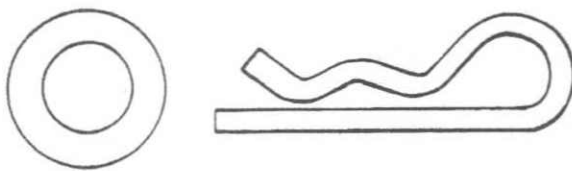
10. Reposition Blade Shoes on Anchor Assembly as shown in Fig. 4. Adjust Anchor Assembly upward in slot against Blade Assembly.

NOTE: BLADE SHOES ASSEMBLED UPSIDE DOWN FOR SHIPPING PURPOSES.

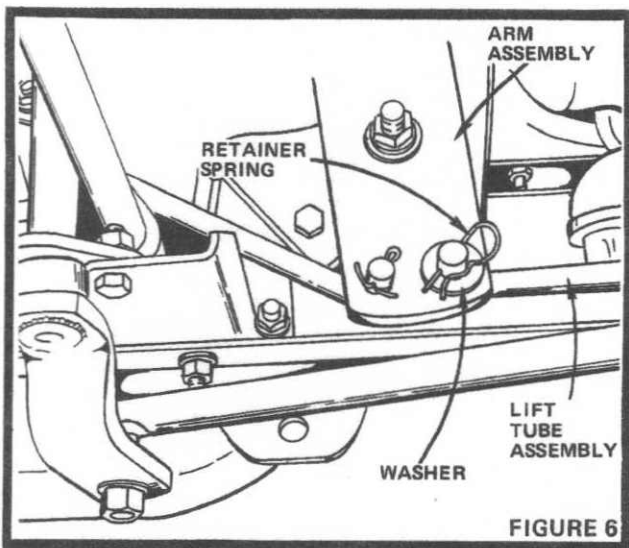
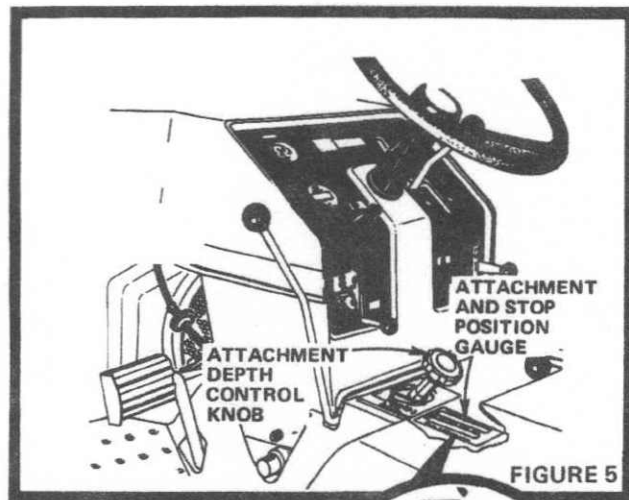
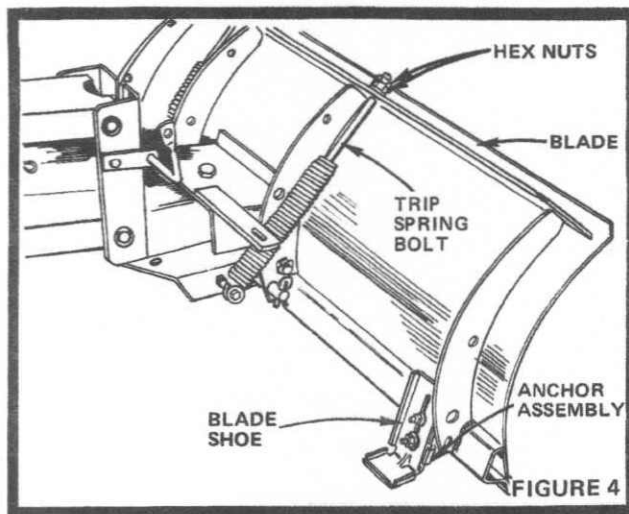
11. Adjust Attachment Depth Control Knob (Fig. 5), turning clockwise as far as possible.

12. Using Lift Control Lever and Attachment Stop Position Gauge, set attachment position (Fig. 5 - Inset) to "DOWN".

13. Secure Lift Tube Assembly to Arm Assembly (Fig. 6) using:



one Washer and one Retainer Spring (shown full size above) found in bag of parts.



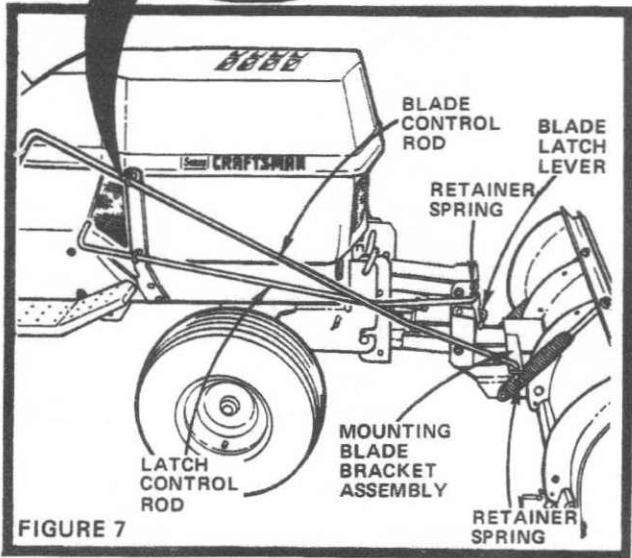
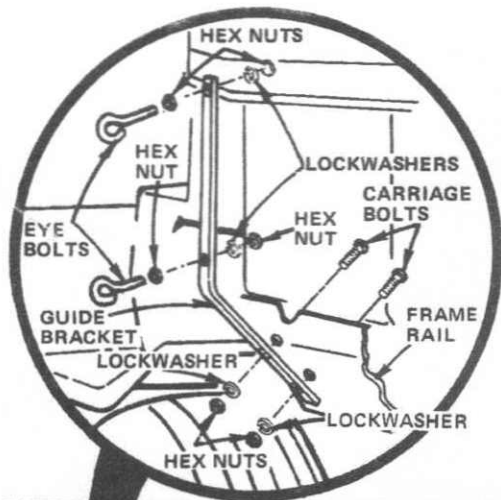
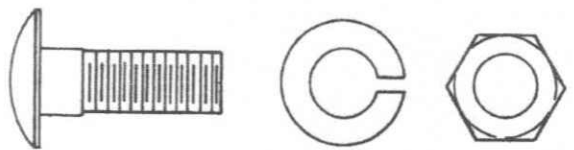


FIGURE 7

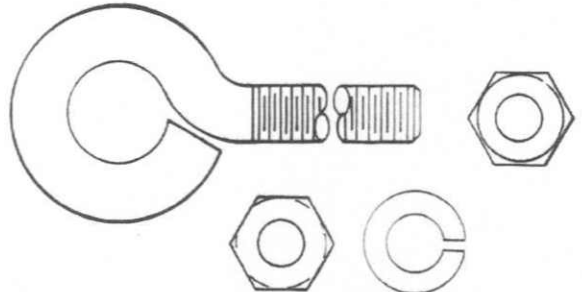
14. Assemble Guide Bracket to R.H. Frame Rail (Fig. 7 - Inset) using:



two Carriage Bolts, two Lockwashers and two Hex Nuts (shown full size above) found in bag of parts.

- a. Insert Carriage Bolts thru 2 holes of Frame Rail from inside.
- b. Place Guide Bracket, Lockwashers and Hex Nuts over Bolts and tighten Nuts securely.

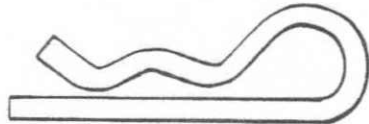
15. Assemble Eye Bolts to Guide Bracket (Fig. 7 - Inset) using:



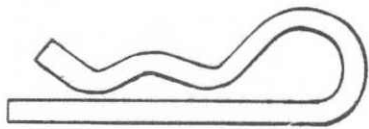
two Eye Bolts, four Hex Nuts and two Lockwashers (shown full size above) found in bag of parts.

- a. Assemble Hex Nut on each Eye Bolt and insert thru Guide Bracket. Place Lockwasher and Hex Nut on each Bolt and tighten securely.

16. Insert Blade Control Rod thru Upper Eye Bolt (Fig. 7). Place opposite end of Blade Control Rod in hole of Mounting Blade Bracket Assembly. Secure with Retainer Spring (shown full size below) found in bag of parts.



17. Insert Latch Control Rod thru Lower Eye Bolt (Fig. 7). Place opposite end of Latch Control Rod in hole of Blade Latch Lever (Fig. 7). Secure with Retainer Spring (shown full size below) found in bag of parts.



ADJUSTMENTS

HEIGHT STOP



ALWAYS LOWER BLADE TO GROUND PRIOR TO ADJUSTING HEIGHT STOP.

1. Remove Retainer Spring and Washer (Fig. 6) from Arm Assembly and Lift Tube Assembly. Remove Lift Tube Assembly from Arm Assembly.
2. Place (2) 2" blocks of wood under Front Wheels with Dozer Blade on ground (Fig. 9), set brake to prevent tractor movement. Adjust Lift Tube Assembly (Fig. 6) counterclockwise until it can be replaced in Arm Assembly. This step will give the proper level for normal terrain.

NOTE: ATTACHMENT POSITION AND STOP POSITION (FIG. 8 - INSET) TO BE DOWN.

3. Reassemble Lift Tube Assembly and Arm Assembly.

LIFT BLADE

Lift Blade from ground before changing blade angle or transporting.

1. Move Lift Control Lever to the extreme rear.
2. Release Lift Control Lever to hold this position.

ANGLE BLADE

There are five blade positions; straight ahead, and two distinct angles to the right or left.

ALWAYS LIFT BLADE FROM GROUND TO CHANGE ANGLE PREVENTING STRAIN ON ANGLE CONTROL LINKAGE.

1. With foot, push forward on Latch Control Rod (Fig. 7).
2. Push or pull Blade Control Rod to desired angle.
3. Remove foot from Latch Control Rod. Blade Assembly will lock in one of the five operating positions.

IMPROVE TRACTION

Wheel weights and tire chains should be used with your Dozer to improve traction. These accessories are available at your nearest Sears retail or catalog store.

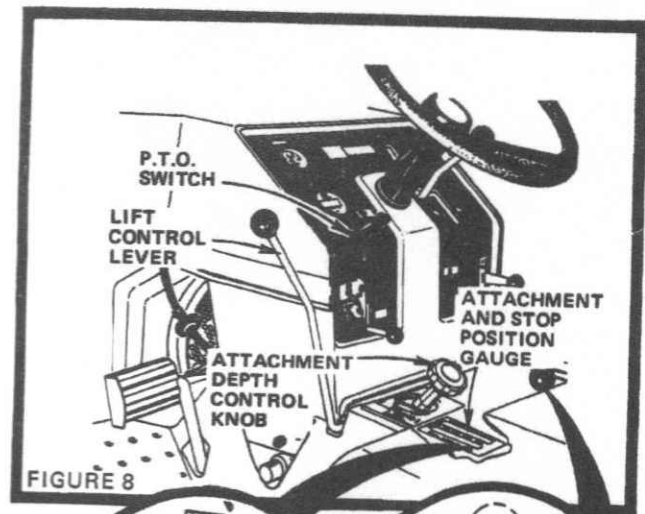


FIGURE 8

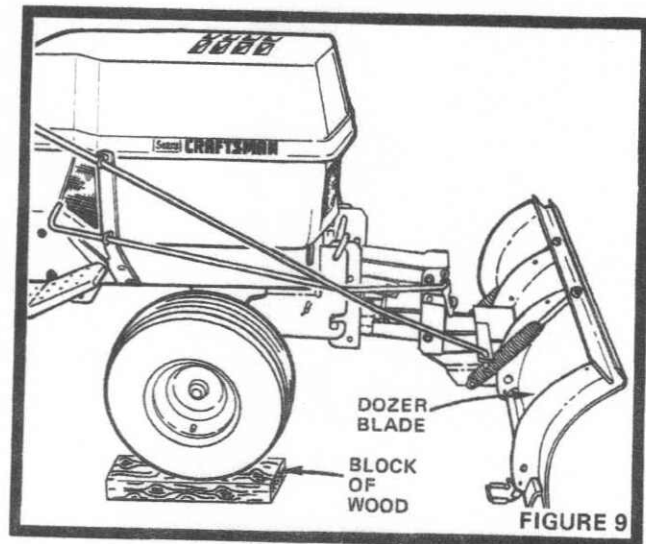
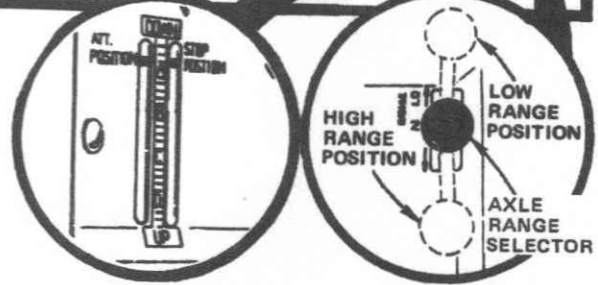


FIGURE 9

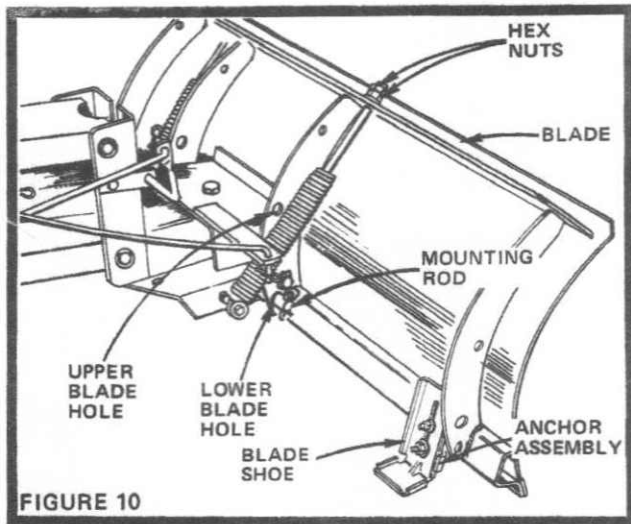


FIGURE 10

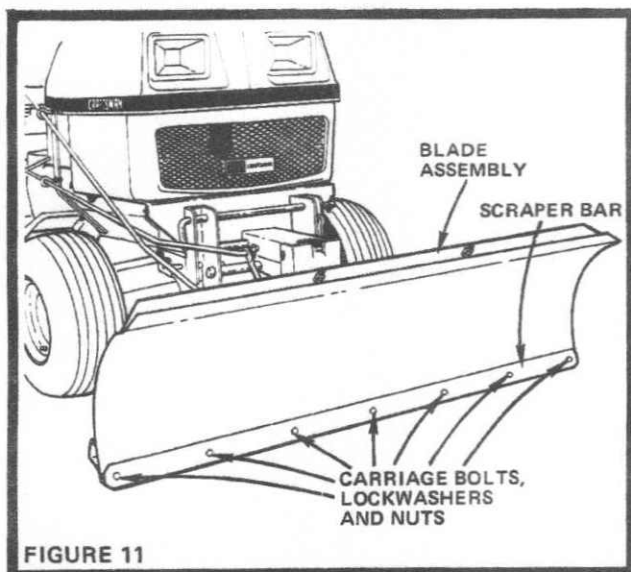


FIGURE 11

ADJUST TRIP SPRING

Trip Springs have been adjusted at the factory to provide only a slight tension which is all that is normally necessary. To change spring tension, adjust the Hex Nuts at the upper end of the Trip Springs (Fig. 10).

ADJUSTMENT TO SMOOTH OR UNEVEN SURFACES

Blade Shoes on ends of Blade (Fig. 10) may be raised for close dozing on smooth surfaces, lowered to raise the Blade to work on rough or uneven areas. Make sure both Shoes and both Anchor Assemblies are set evenly and Nuts are tightened securely.

ADJUST TO SNOW OR SAND/GRAVEL REMOVAL

1. When moving snow or other light material, place the Mounting Rod in the Lower Blade Hole (Fig. 10). This frees the Blade to spring trip and return if a heavy obstacle is encountered. Secure with Retainer Springs.



KNOW THE TERRAIN. AVOID EXCEPTIONALLY SHARP SLOPES OR DROP OFFS WHICH MAY BE HIDDEN BY THE SNOW.

2. When heavier material must be moved, place the Mounting Rod in the Upper Blade Hole (Fig. 10). This places the blade in rigid operating position. Secure with Retainer Springs.



NEVER RUN THE BLADE INTO HEAVY MATERIAL AT HIGH SPEED.

OPERATION



INSPECT THE AREA TO BE WORKED CAREFULLY BEFORE OPERATING THE DOZER BLADE. AVOID PIPES, ROOTS, CURBS OR OTHER HEAVY OBSTRUCTIONS.

1. Start tractor engine and raise the blade to the highest "transport" position. Move blade to desired angle and lower blade to ground.

NOTE: LIFT CONTROL LEVER TO BE IN FORWARD POSITION AS SHOWN IN FIG. 8.

2. Move Axle Range Selector (Fig. 8 - Inset) to desired position.
3. Place tractor Drive Control Lever in "FWD" and ease into the material to be moved. Increase tractor speed gradually to suit working conditions and operations being performed.



ALWAYS LOWER BLADE TO GROUND BEFORE LEAVING TRACTOR.

TO REMOVE DOZER BLADE FROM TRACTOR

1. Lower Blade to ground.
NOTE: LIFT CONTROL LEVER TO BE IN FORWARD POSITION AS SHOWN IN FIG. 8.
2. Remove Retainer Spring, Washer and Clevis Pin from Lift Rod (Fig. 3 - Inset).
3. Remove Retainer Springs from Blade Control Rod and Latch Control Rod (Fig. 7). Remove Rods from Eye Bolts.
4. Remove Retainer Spring in Mounting Rod at L.H. side of tractor (Fig. 3 - Inset). Slide Mounting Rod from Front Hitch Assemblies and Dozer Mounting Bracket.
5. Lift Dozer Mounting Bracket Assembly up so Mounting Pins are free of Front Hitch Assembly Slots (Fig. 3) and remove Dozer from Tractor.
6. Remove Retainer Spring and Washer from rear of Lift Tube Assembly and remove Lift Tube Assembly from tractor.

MAINTENANCE

During the operating season, check all Bolts, Nuts and Retainer Springs to be sure they are secure. For better snow removal performance, coat the blade with automotive type paste wax. This will permit the snow to slide off the blade easier.

LUBRICATION

Oil all Pivot Points so that they will work freely. Apply a light coat of grease to Front and Rear Pivot Shafts (Fig. 3).

SCRAPER BAR

After extensive use, the Scraper Bar may be reversed to utilize the unused edge (Fig. 11).

1. Remove the seven Nuts, Lockwashers and Carriage Bolts in the Scraper Bar and Blade Assembly.
2. Reverse Scraper Bar and secure to Blade Assembly with Bolts, Lockwashers and Nuts previously removed. Head of Carriage Bolts to outside of Blade.

STORAGE

When the Dozer is not being used, remove all dirt and rust and touch up with paint.

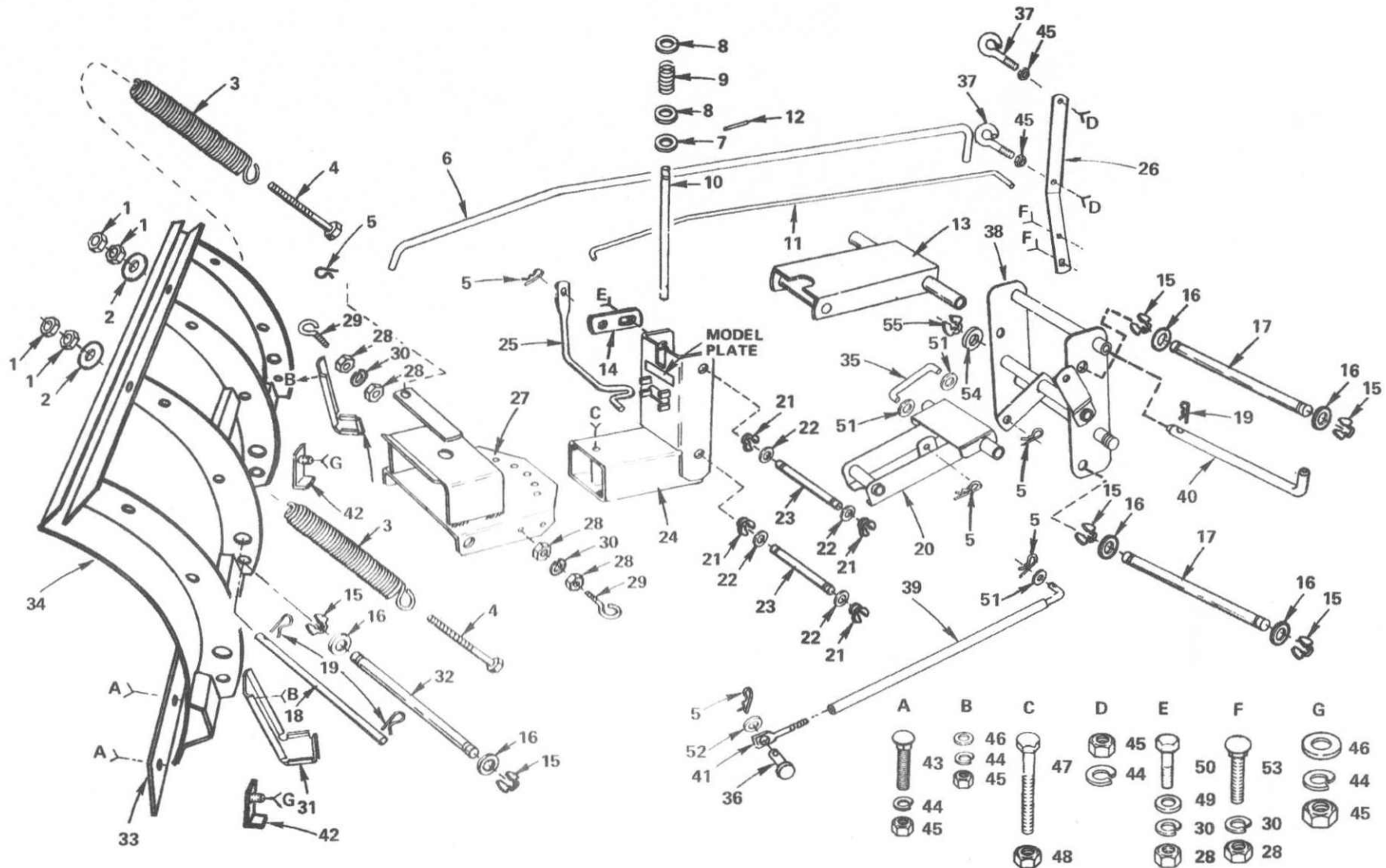
Apply a light coat of grease or rust preventative to the blade and oil Pivot Points.

Store in an area where it is protected from weather.

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 items heretofore manufactured.

REPAIR PARTS

SEARS 54 INCH DOZER--MODEL NUMBER 917.25410



REPAIR PARTS

SEARS 54 INCH DOZER--MODEL NUMBER 917.25410

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	STD541050	*Nut - Hex 1/2 - 13 UNC	31	3132J	Shoe
2	1545P	Washer 17/32 x 1 x 16 Ga.	32	3135J	Shaft - Mounting, Blade
3	9466R	Spring - Trip	33	677H979	Bar - Scraper
4	3411P	Bolt - Hex 1/2 - 13 UNC x 5 - 1/2 (2" Min. Thread)	34	677H978	Blade Assembly
5	4939M	Retainer Spring	35	5437J	Link - Lift
6	678H224	Rod - Control, Blade	36	5438J	Pin - Clevis
7	STD551062	*Washer 21/32 x 1 - 5/16 x 13 Ga.	37	6564H	Bolt - Eye
8	1550P	Washer 21/32 x 1 x 12 Ga.	38	677H975	Bracket Assembly - Mounting
9	9638R	Compression Spring	39	677H980	Tube Assembly - Lift
10	3124J	Pin - Latch	40	5445J	Rod - Mounting
11	678H223	Rod - Control, Latch	41	5450J	Rod - Lift, Threaded
12	7836M	Roll Pin	42	677A666	Anchor Assembly
13	677H983	Channel Assembly	43	77P	Bolt - Carriage 5/16 - 18 UNC x 1 Gr. 5
14	4070J	Clip - Lever, Latch	44	STD551131	*Lockwasher 5/16
15	5027P	Klip Ring	45	STD541031	*Nut - Hex 5/16 - 18 UNC
16	1552P	Washer 25/32 x 1 - 1/4 x 16 Ga.	46	STD551031	*Washer 11/32 x 11/16 x 16 Ga.
17	3116J	Shaft - Pivot, Rear	47	3410P	Bolt - Hex 5/8 - 11 UNC x 4
18	3134J	Rod - Mounting	48	STD541462	*Nut - Hex Center Lock Nylon Patch 5/8 - 11 UNC
19	4940M	Retaining Spring	49	STD551037	*Washer 13/32 x 13/16 x 16 Ga.
20	677H976	Channel Assembly - Lift	50	STD523710	*Bolt - Hex 3/8 - 16 UNC x 1
21	5026P	Klip Ring	51	1523P	Washer 17/32 x 15/16 x 16 Ga.
22	1647P	Washer 21/32 x 1 - 1/4 x 16 Ga.	52	1611P	Washer 13/32 x 7/8 x 16 Ga.
23	3111J	Shaft - Pivot, Front	53	STD533710	*Bolt - Carriage 3/8 - 16 x 1
24	677H984	Boot Assembly	54	1671P	Washer 1 - 1/16 x 1 - 1/2 x 18 Ga.
25	3125J	Lever - Latch, Blade	55	5030P	Klip Ring
26	678H92	Guide Bracket	---	1129J	Warranty Tag
27	677H977	Bracket Assembly - Mounting Blade	---	5436J	Owners Manual
28	STD541037	*Nut - Hex 3/8 - 16 UNC			
29	3133J	Bolt - Eye			
30	STD551137	*Lockwasher 3/8			

*STANDARD HARDWARE--PURCHASE LOCALLY

Sears

**OWNERS
MANUAL**

**MODEL NO.
917.25410**

**HOW TO ORDER
REPAIR PARTS**

54 INCH DOZER BLADE FOR SEARS FULL FEATURE TRACTORS

The Model Number will be found on a plate attached to the Upper Channel of the Boot Assembly. Always mention the Model Number when requesting service or repair parts for your Dozer.

All parts listed herein may be ordered from any SEARS ROEBUCK AND CO., retail or catalog store.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION.

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

If the parts you need are not stocked locally, your order will be electronically transmitted to a Sears Repair Parts Distribution Center for "expedited handling".