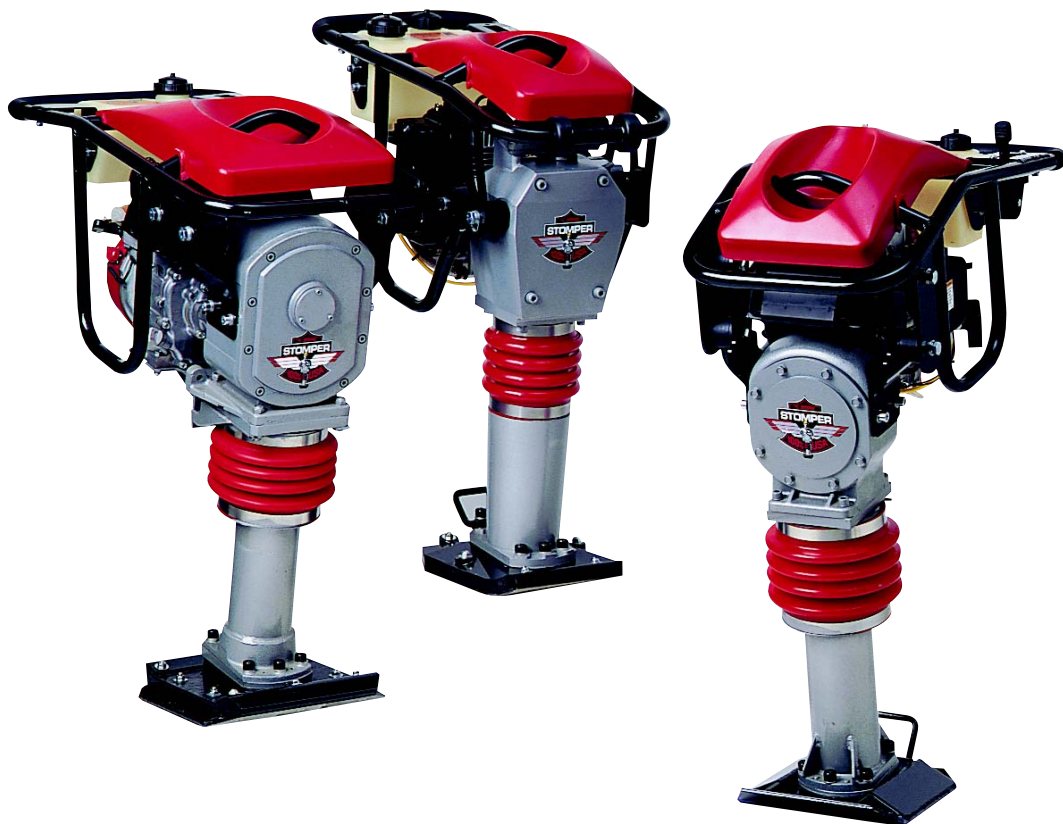




# OPERATOR/SERVICE MANUAL

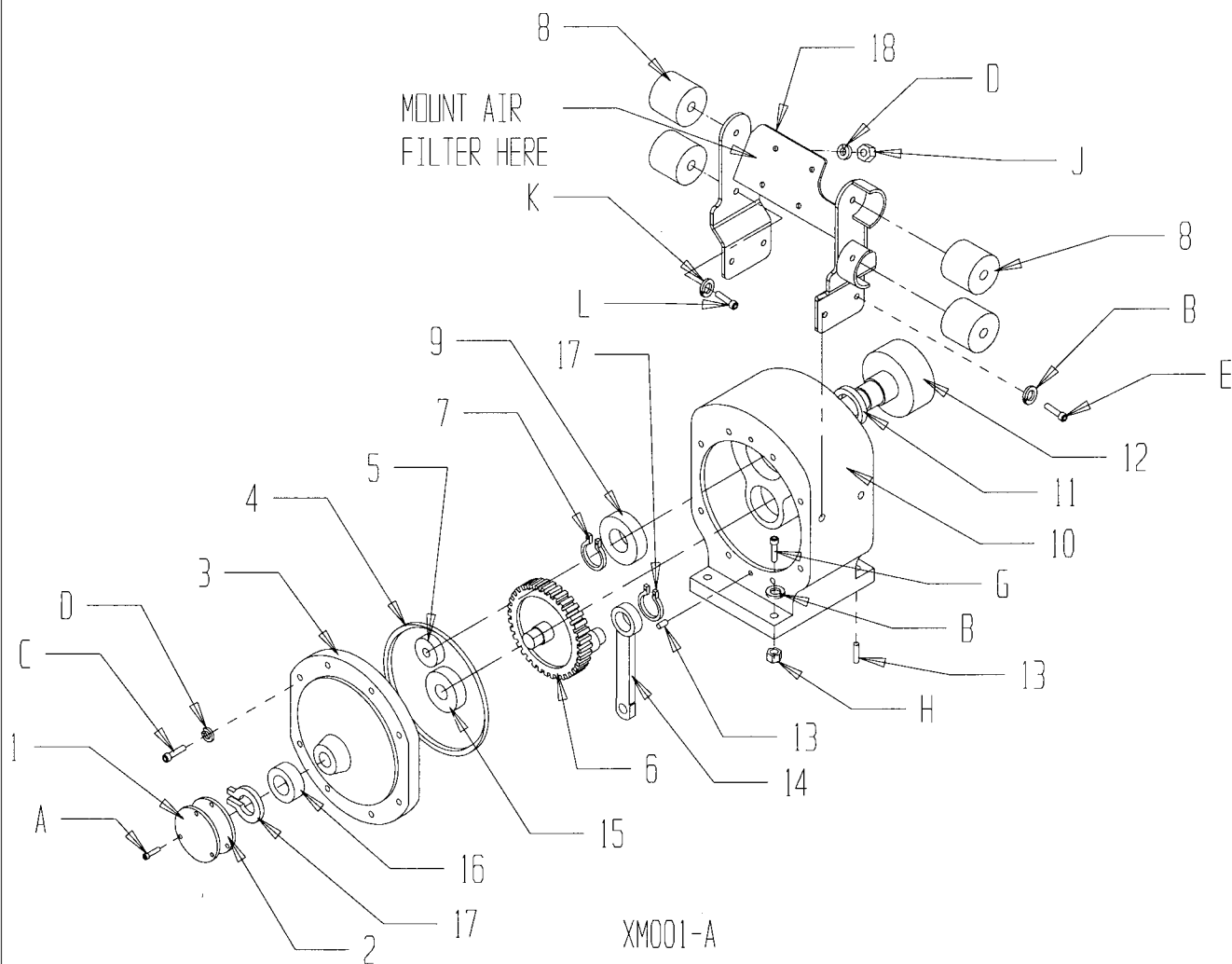
MODEL: XN650R, XN650ROI, XT728R,  
XT728ROI, XM832R, XM832ROI,  
XJ834HG, XD836Y



STOMPER® - 2 Cycle Oil Injected and Pre-Mix,  
4 Cycle and Diesel

A 100% employee-owned American manufacturer

## 8.4 Gearcase - XM Oil Injected and Pre-Mix



## 8.4 Gearcase - XM Oil Injected and Pre-Mix

Item	Part No.	Description	Qty.
1	65029-2	Cap Speed Cover	1
2	30189	Gasket	1
3**	22991	Gearcase Cover Assy	1
4	32216	O-Ring 81D	1
5	32023	Bearing - 204	1
6	42638	Gear 70 TH XM	1
7	30192	Retaining Ring	1
8	65004	Shock Mount	4
9	32213	Bearing - 206	1
10	65023-2	Case Machined	1
11#	30193	Seal	1
12	28672	Pinion Assy 10T XM	1
13	80002	1/4 Dowel Pin	3
14	28658	Connecting Rod Assy	1
15	32214	Bearing - 307	1
16	32212	Bearing - 205	1
17	30191	Retaining Ring	2
18	44233-2	Weld Handle Bracket	1

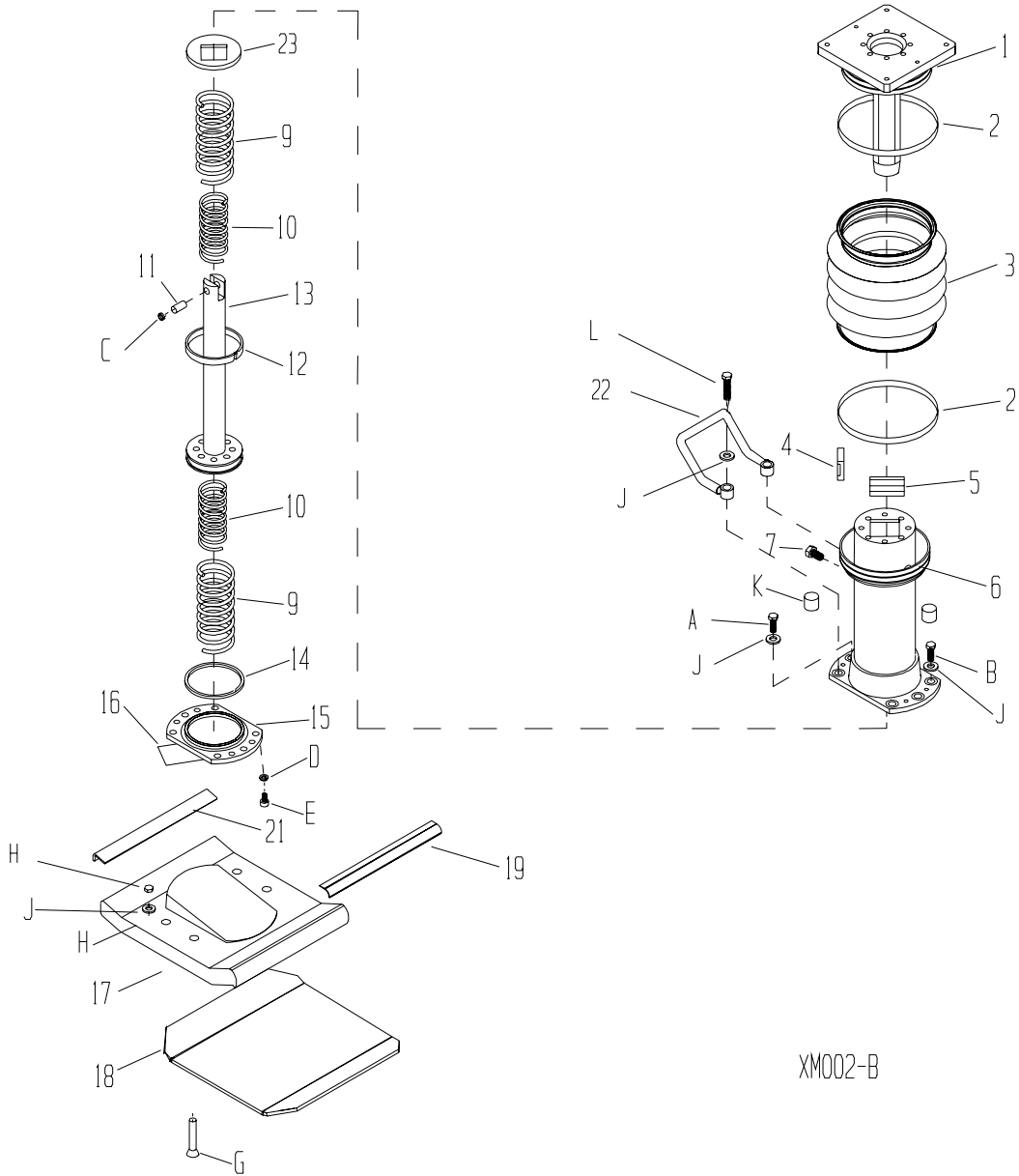
Item	Part No.	Description	Qty.	DIN
A*	80821	SHCS M5 .8 x 16mm 8.8 ZN	3	912
B	80804	WSHRL M10 Split ZN XM	8	127B
C*	80810	SHCS M8 1.25 x 20mm 8.8 ZN	8	912
D	80812	WSHRL M8 Split ZN	12	127B
E*	80803	SHCS M10 1.5 x 25mm 8.8 ZN	4	912
G*	80801	SHCS M10 1.5 x 35mm 12.9 BLK XM	4	912
H	80833	NUTNY M10 1.5 ZN SW	4	985
J	80817	NUTNY M8 - 1.25	4	985
K	80805	WSHRL M12 Split ZN	4	127B
L	80808	HHCS M12 - 1.75 x 20mm 8.8 ZN	4	933

# Lube seal with grease when replacing

\*\* Gearcase Kit PN 23021 includes 1,3,5,16 & 17

\* Loctite Required

## 8.9 Lower Unit for XM Oil Injected and Pre-Mix



XM002-B



**THE SPRING RETAINING BASE PLATE RETAINS HEAVY SPRINGS UNDER COMPRESSION. FOLLOW THE INSTRUCTIONS (BASE PLATE REMOVAL LOCATED ON PAGE 53 OF THIS MANUAL) CAREFULLY OR SEVERE PERSONAL INJURY MAY OCCUR.**

## 8.9 Lower Unit for XM Oil Injected and Pre-Mix

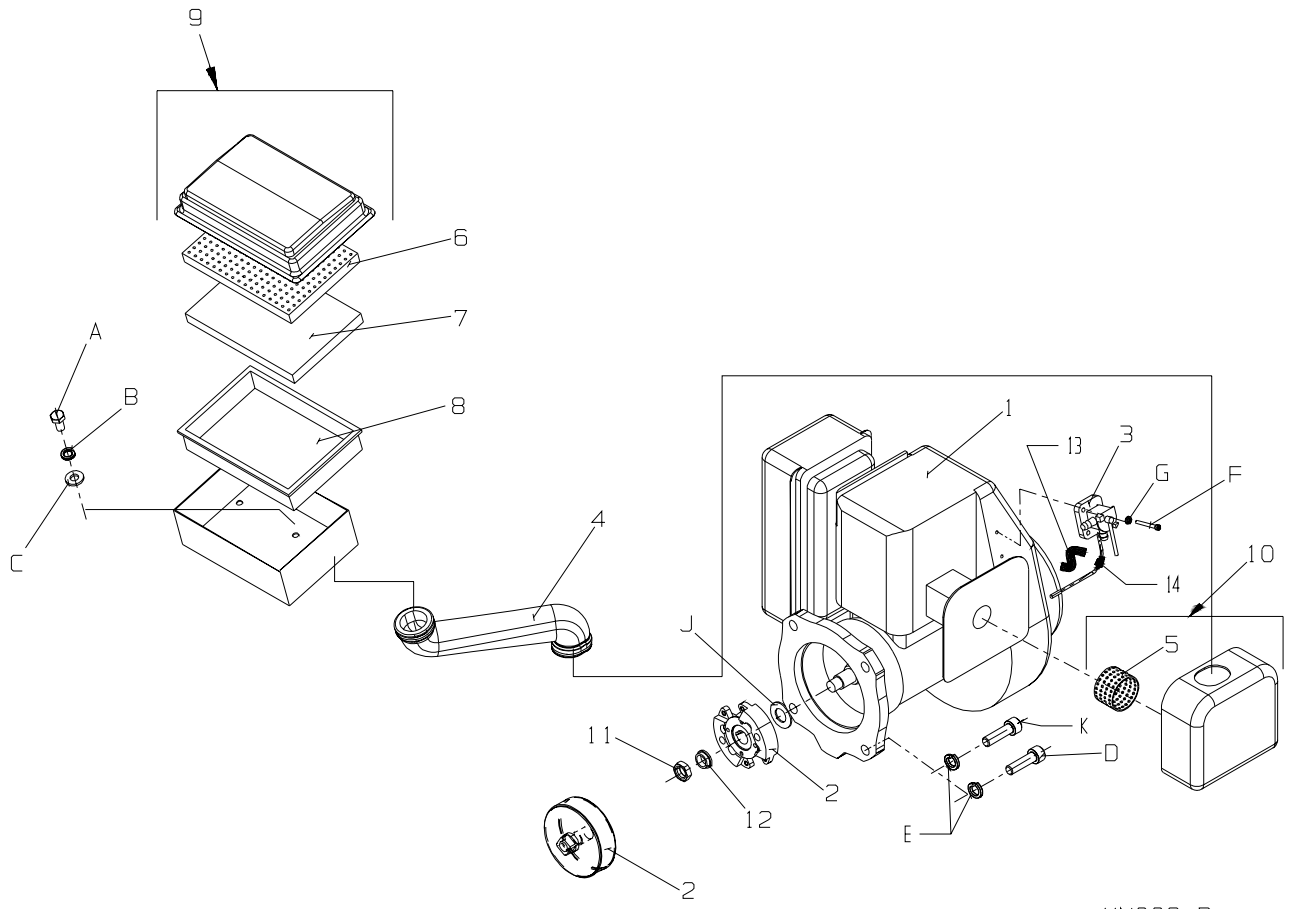
Item	Part No.	Description	Qty.
1	65032-2	Guide Tube	1
2	44106	Boot Clamp	2
3	47361	Boot	1
4	27938	Bushing Short	2
5	27939	Bushing Long	2
6	65051-2	Spring Housing	1
7*	34096	Oil Sight Gauge	1
8	42318	Spacer, Bearing to Spring	1
9	42661	Spring Outer	2
10	42662	Spring Inner	2
11	80423	Rod Pin	1
12	28694	Piston Ring	1
13	28701	Piston Rod Assembly	1
14	32033	O-Ring	1
15	65026-2	Base Plate	1
16	55026	Spring Housing Safety Decal	1
17	47302	Shoe	1
17a	65028	Insert	6
18	65024-2	Shoe Plate	1
19	29215-2	Shoe Edge Guard	1
21	42353-2	Stiffener Rear Shoe	1
21a#	22988	Shoe Kit (includes 17,18,19,21 and hardware)	1
22	39480	Lifting Grip Weldment Assy.	1
23	42318	Spring Spacer	1

Item	Part No.	Description	Qty.	DIN
A	80824	SHCS M12 - 1.75 x 80 8.8 ZN	3	912
B	80822	SHCS M12 - 1.75 x 50mm 8.8 ZN	3	912
C	80519	Internal Retaining Ring	1	-
D	80812	WSHRL M8 Split ZN	10	127B
E	80720	SHCS M8 - 1.25 x 25mm 8.8 ZN	4	912
F#	80813	WSHR M8 x 24 OD ZN	10	9021B
G	80823	FHSCS M8 - 1.25 x 50mm 10.9 ZN	10	7991
H	80814	NUTNY M8 1.25 ZN	10	985
J	80805	WSHRL M12 Split ZN	6	127B
K	80765	Cap Plastic Blk	6	-
L	80943	SHCS M12 - 1.75 x 100 8.8 ZN	2	912

\* Use of a socket wrench is recommended to avoid damage to the sight gauge.

# Not Shown

## 8.11 Engine - XN, XT & XM Oil Injected and Pre-Mix



XN002-B

## 8.11 Engine - XN, XT & XM Oil Injected and Pre-Mix

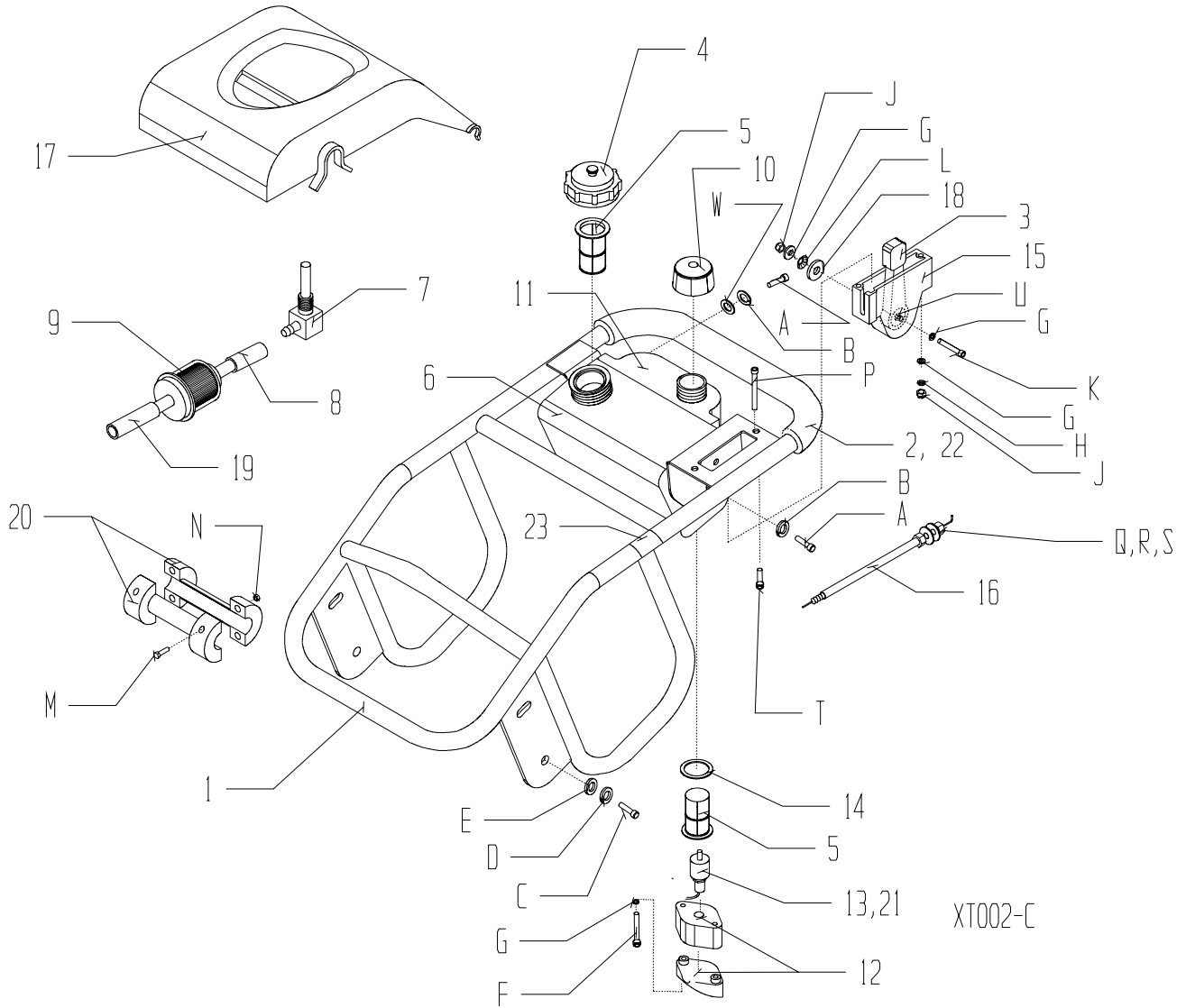
Item	Part No.	Description	Qty.
1**	23208	Kit EC12 O/I Engine XN	1
1a	23209	Kit EC12 O/I Engine XT	1
1b	23210	Kit EC12 Pre-Mix Engine XN	1
1c	23211	Kit EC12 Pre-Mix Engine XT	1
1d	23212	Kit EC12 O/I Engine XM	1
1e	23213	Kit EC12 Pre-Mix Engine XM	1
2	30356	Clutch Robin Honda (XM, XJ)	1
2a	30308	Clutch (XN & XT)	1
3	23148	Kit Valve/Kill Switch	1
4	39396	Hose Air Filter (XN)	1
4a	39397	Hose Air Filter (XT, XM)	1
5	35995	Filter/Precleaner Lower EC10/EC12	1
6	39329	Air Filter Coarse 1st Stage	1
7	39330	Air Filter Fine 1st Stage	1
8	39332	Frame Air Filter 1st Stage	1
9	23144	Air Filter Assy 1st Stage	1
10	23142	Air Filter Assy Primary	1
11	35060	Nut M12 - 1.25 (XN & XT)	1
12	27242	Spacer (XN & XT)	1
13	39489	Fuel Line 3/16 ID x 2 3/4	1
14	39502	Clamp Cable .083	1
15	39478	Fuel Line 3/16 ID x 23" LG	1

Item	Part No.	Description	Qty.	DIN
A*	80406	HHCS M8 - 1.25 x 20mm 8.8 ZN	4	933
B	80812	WSHRL M8 Split ZN	4	127B
C	80813	WSHR M8 Flat 24 OD ZN	4	9021B
D*	80815	HHCS M10 - 1.5 x 30mm 8.8 ZN	4	912
E	80804	WSHRL M10 Split ZN	4	7980
F	80926	CHSMS M4 x 16mm	2	7981
G	80929	WSHRL M4 Split ZN	2	127B
J	80426	WSHR 9/16 Type B ZN	1	-
K	80872	SHCS M10-1.5 x 30 8.8 ZN (XM)	2	912

\* Loctite Required

\*\* Kit to include all parts shown fully assembled.

# 8.15 Handle and Fuel Tank XT/XM Oil Injected and Pre-Mix





## 8.15 Handle and Fuel Tank XT/XM Oil Injected and Pre-Mix

Item	Part No.	Description	Qty.
1	44215-2	Handle Weld Assembly	1
2	39483	Handle Grip Cushion	1
3	39387	Throttle Lever	1
4	35701	Cap Gas	1
5	47219	Strainer (Oil Injected)	2
5a	47219	Strainer (Pre-Mix)	1
6	39350	Tank Gas (Oil Injected)	1
6a	65081	Tank Gas (Pre-Mix)	1
7	23022	Tank Fitting	1
8	39488	Fuel Line 3/16 ID x 15" LG	1
9	35486	Filter Gas	1
10	39346	Cap Oil (Oil Injected)	1
11	39349	Tank Oil (Oil Injected)	1
12	23065	Tank Guard Set (Oil Injected)	1
13	39316	Sensor Oil (Oil Injected)	1
14	32314	Gasket, Oil Tank (Oil Injected)	1
15	39386	Throttle HSG	1
16 <sup>^+</sup>	39485	Throttle Control	1
17	39426	Cover - Plastic	1
18	39402	Washer Clutch	1
19	39477	Fuel Line 3/16 ID x 6 1/4" LG	1
20**	23138	Kit Wheel -Handle (optional)	1
21	39476	O-Ring (Oil Injected)	1
22	42819	Tube Grip	1
23+	34091	Clamp Cable	1
24a#	39150	Hose, Guard (Oil Injected)	1
24b#	48413	Wiring Harness (Oil Injected)	1
24c#	39308	Ferrule (Oil Injected)	2

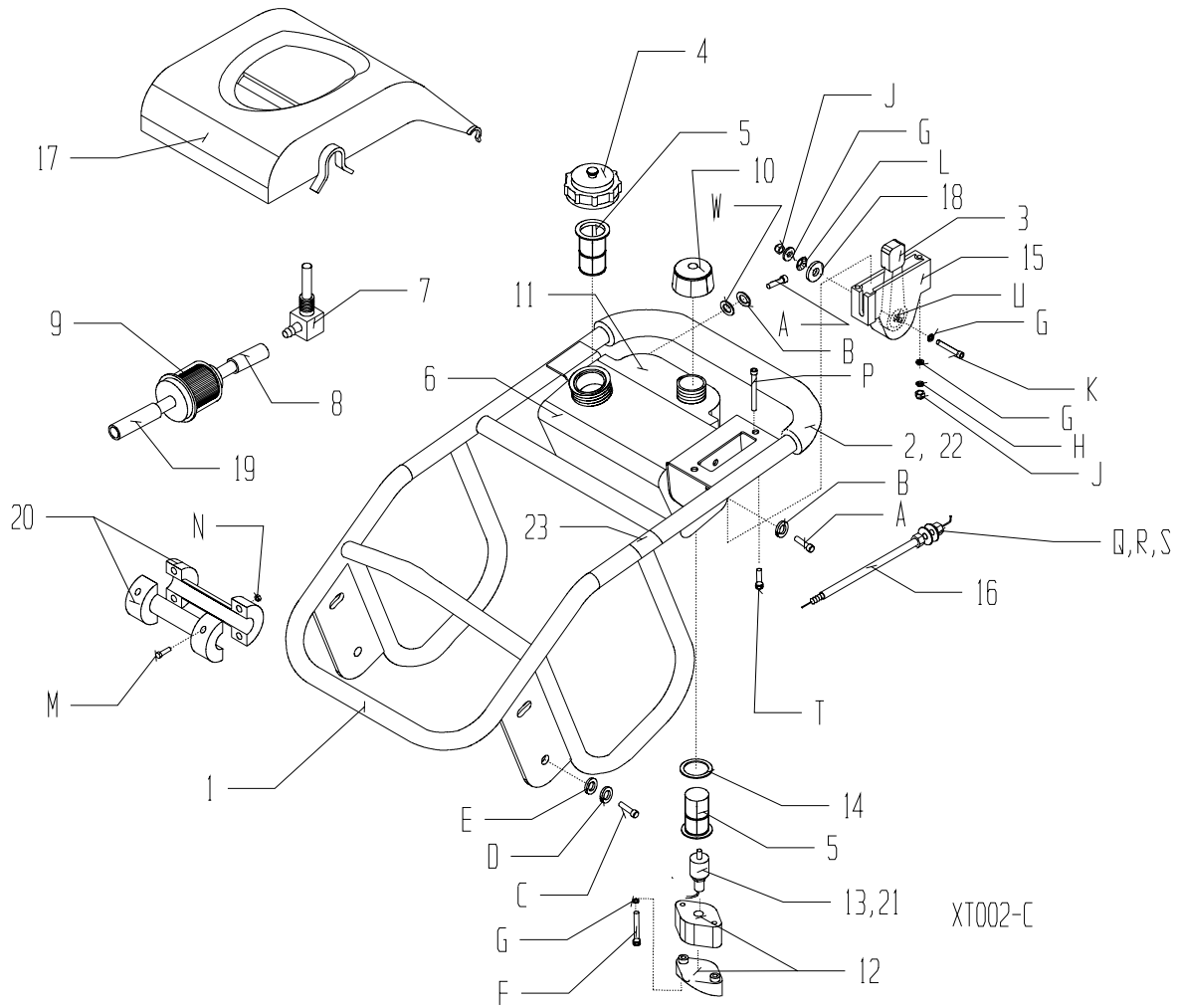
<sup>^</sup> Lubricate Throttle Wire

# Not Shown

+ Included in P/N 23427

\*\* Includes 20, M & N

# 8.15 Handle and Fuel Tank XT/XM Oil Injected and Pre-Mix



## 8.15 Handle and Fuel Tank XT/XM Oil Injected and Pre-Mix



Item	Part No.	Description	Qty.	DIN
A*	80894	SHCS M8 - 1.25 x 16mm 8.8 ZN (Oil Inj.)	10	912
A1	80894	SHCS M8 - 1.25 x 16mm 8.8 ZN (Pre-Mix)	6	
B	80812	WSHRL M8 Split ZN (Oil Inj.)	10	127B
B1	80812	WSHRL M8 Split ZN (Pre-Mix)	4	
C*	80887	HHCS M12 - 1.75 x 25mm 8.8 ZN (XT)	4	933
D	80805	WSHRL M12 Split ZN (SM)	4	127B
E	80807	WSHR M12 x 24 OD ZN (ST)	4	125A
F	80912	SHCS M6 x 50 BLK BN2 (Oil Inj.)	4	-
G	80856	WSHR M6 Flat 12 OD ZN (Oil Inj.)	6	125A
G1	80856	WSHR M6 Flat 12 OD ZN (Pre-Mix)	4	
H	80860	WSHRL M6 ZN	2	127B
J	80851	NUTNY M6 - 1.0	3	985
K	80947	HHCS M6 - 1 x 40 8.8 ZN	1	931
L	80939	WSHR Belleville 1/4 ID	1	-
M	80821	SHCS M5 - .8 x 16 8.8 ZN (optional)	4	933
N	80850	NUTNY M5 - .8 ZN (optional)	4	985
P	80940	SHCS M6 - 1 x 60 8.8 ZN	2	-
Q	80247	NUTFX 5/16 - 24 ZN	2	-
R	80086	WSHRL 5/16 Split ZN	1	-
S	80495	WSHR 5/15 Plain ZN	1	-
T	80586	HWHST 5/16 - 18 x .50 ZN	2	-
U	80347	WSHR 1/4 WROT ZN	1	-
V#	39509	Clamp 3/8	1	-
W	80813	WSHR M8 Flat (Oil Inj.)	4	-
X#	23427	Kit Cable Control	1	-
Y	81154	PINSP 1/8 x 1-3/4 SST	1	-

\* Loctite Required

# Not Shown

# 8.19 Decal Identification

1

<b>⚠ CAUTION</b>	<b>OPERATING INSTRUCTIONS</b>
 <p>Hearing protection required when operating this machine.</p>  <p>Read owners manual before operating or servicing this machine.</p>	<p>Before starting, check oil level in oil tank. Fill with a quality grade two cycle oil.</p> <p>With engine off, fill fuel tank with regular grade gasoline.</p> <p>To start engine: Turn ignition/fuel switch to "ON"; open air vent in fuel tank cap; close choke and pull starter rope.</p> <p>To stop: Turn ignition/fuel switch to "OFF" and close fuel cap vent.</p> <p>See owners manual for additional instructions.</p>
55336	

2

◀ **STOP**

◀ **IDLE**

◀ **START**  
**RUN**

55378  
Diesel

3

**IDLE**



**START**




**RUN**

55379  
Robin

4

**OFF**



**ON**

55322

5

**AIR FILTER MAINTENANCE**

Daily clean filter located on top and the side of the engine.

- Wash foam elements with detergent and water.
- Dry the elements by squeezing between towels.
- Relubricate with engine oil. Squeeze out excess oil and reinstall.

P/N 55337

6

**⚠ WARNING**

After servicing or repairing unit, make sure oil line is full or engine failure will occur.

55345

## 8.19 Decal Identification

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<b>Item</b>	<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>
1	55336	Decal Caution Instruction	1
2	55378	Decal Throttle	1
3	55379	Decal Throttle Stompers	1
4	55322	Decal On/Off	1
5	55337	Decal Air Filter Maintenance	1
6	55345	Decal Oil Line Warning	1

# 8.19 Decal Identification

7

**CAUTION**

**FUEL OIL**

- USE DIESEL FUEL.
- CLEAN FILTER EVERY 500hrs.

**LUBE OIL**

- SAE 10W30 GRADE CC
- CHANGE LUBE OIL EVERY 100hrs.
- CLEAN FILTER EVERY 100hrs.

**STARTING**

- CHECK LUBE OIL LEVEL AND FUEL.
- FOR EAGY STARTING IN COLD WEATHER. ADD 2cc LUBE OIL TO ROCKER ARM COVER.
- WARM UP WITHOUT LOAD.

**STOPPING**

- CLOSE FUEL COCK AFTER STOPPING ENGINE.

PN 55325

8

**HOW TO START**

① Open the fuel cock

② Put the Lever in the "START" position.

③ Pull the starting handle slowly.

④ Pull until you feel resistance. Then return it slowly.

⑤ Push the decompression lever down and release.

⑥ Pull the rope hard and fast.

If the engine doesn't start, try again from ③

PN 55324

9

**NOTICE**

CONTACT THE MANUFACTURER IMMEDIATELY AT 1-800-888-9926 IF SAFETY OR HAZARD DECALS OR OWNER'S MANUAL ARE MISSING FROM THIS EQUIPMENT.

PN 55156

12



• Springs Under Compression  
• May Cause Injury  
• Consult Manual or Manufacturer Before Removing Plate.  
1-800-888-9926  
55026

10

**CHECK OIL DAILY**

USE 30 WT. MOTOR OIL

**OIL LEVEL**

**DO NOT OVERFILL**



PN 55053

11

**ON**



**OFF**

PN 55377

## 8.19 Decal Identification

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<b>Item</b>	<b>Part No.</b>	<b>Description</b>	<b>Qty.</b>
7	55325	Decal Caution Fuel Yanmar	1
8	55324	Decal How To Start Yanmar	1
9	55156	Decal Notice	1
10	55053	Decal Check Oil Daily	1
11	55377	Decal On/Off Choke	1
12	55026	Decal Warning Spring	1