

Operation Number	Detail Code	Description	Z 50R	XR 85R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
110100		ENGINE REMOVE AND REPLACE	0.9	0.9	0.9	2.1	2.1	2.1	2.2
110105		CRANKCASE SET	—	—	—	—	—	6.7	7.0
110110		CRANKCASE GASKET	2.6	2.7	2.7	5.5	5.5	5.5	5.8
110115		LEFT CRANKCASE	2.9	3.6	3.6	6.5	6.5	6.5	6.5
110120		RIGHT CRANKCASE	2.8	3.0	3.0	5.7	5.7	5.7	6.1
110125		CRANKSHAFT, MAIN BEARING, MAIN BEARING HOLDERS (INCLUDES TIMING SPROCKET)	2.6	3.1	3.1	6.4	6.4	6.4	6.1
110135		BALANCER ASSEMBLY, BEARING, SHAFT, CHAIN OR GUIDE	—	—	—	5.8	5.8	5.8	6.0
110140		CAM CHAIN	1.3	2.7	2.7	2.7	2.7	2.7	4.2
110130		CRANKSHAFT OIL SEAL	0.4	0.5	0.5	0.7	0.7	0.7	0.8
110155		LEFT CRANKCASE COVER OR GASKET	0.1	0.1	0.1	0.8	0.8	0.7	0.7
110160		RIGHT CRANKCASE COVER OR GASKET	0.5	0.7	0.7	0.8	0.8	0.8	0.8
111100		CYLINDER, CYLINDER BASE GASKET	1.0	1.4	1.4	2.7	2.7	2.7	3.4
111103		PISTON, RINGS, PIN OR BEARING (ONE)	1.1	1.5	1.5	2.8	2.8	2.8	3.5
111106		CYLINDER HEAD	1.2	1.5	1.5	2.7	2.7	2.7	3.7
111109	G	INTAKE OR EXHAUST VALVE GUIDE (ONE) EACH ADDITIONAL	1.3 0.4	1.6 0.4	1.6 0.4	2.6 0.4	2.6 0.4	2.6 0.4	3.6 0.4
111112	G	VALVE, VALVE SPRING OR SEAL (ONE) EACH ADDITIONAL	1.0 0.1	1.3 0.1	1.3 0.1	2.3 0.1	2.3 0.1	2.3 0.1	3.4 0.1
111115		CYLINDER HEAD GASKET	0.9	1.2	1.2	2.2	2.2	2.2	3.2
111118		CAM SHAFT(S)	0.6	0.7	0.7	1.7	1.7	1.7	2.9
111121		CAM SHAFT SPROCKET, BEARING, BUSHING OR HOLDER	—	0.9	0.9	1.8	1.8	1.9	2.9
111130		CAM CHAIN TENSIONER	—	1.6	1.6	3.2	3.2	2.8	3.9
111133		CAM CHAIN TENSIONER LIFTER, ADJUSTER OR BRACKET ASSEMBLY/PUSHROD ASSEMBLY	0.2	—	—	—	—	2.2	3.4
111136		CAM CHAIN TENSIONER SPRING	0.2	1.6	1.6	3.2	3.2	2.2	3.4
111139		CAM CHAIN TENSIONER GUIDE	—	1.4	1.4	2.2	2.2	2.2	3.2
111148		CAM CHAIN TENSIONER ROLLER(S)	1.0	—	—	—	—	—	—
111151		CAM CHAIN TENSIONER ARM	1.3	—	—	—	—	—	—

# Mechanics Time Guide

**Sabine Zange**



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