

Operation Number	Detail Code	Description	XR 50R	XR 65R	XR 105R	XR 200R	XR 250R	XR 250R	XR 500R
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)	2.0	3.1	3.1	6.4	6.4	6.4	6.1
110130		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
110150		CRANKSHAFT OIL SEAL	0.4	0.6	0.6	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	1.6	1.6	2.8	2.8	2.8	3.6
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		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	—	—	—	—	—	—
111153		CAM CHAIN TENSIONER ARM	1.3	—	—	—	—	—	—

Motorcycle Repair Labor Guide

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1. Understanding the eBook Motorcycle Repair Labor Guide
 - The Rise of Digital Reading Motorcycle Repair Labor Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Motorcycle Repair Labor Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Motorcycle Repair Labor Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Motorcycle Repair Labor Guide
 - Personalized Recommendations
 - Motorcycle Repair Labor Guide User Reviews and Ratings
 - Motorcycle Repair Labor Guide and Bestseller Lists
5. Accessing Motorcycle Repair Labor Guide Free and Paid eBooks
 - Motorcycle Repair Labor Guide Public Domain eBooks
 - Motorcycle Repair Labor Guide eBook Subscription Services
 - Motorcycle Repair Labor Guide Budget-Friendly Options
6. Navigating Motorcycle Repair Labor Guide eBook Formats

- ePub, PDF, MOBI, and More
- Motorcycle Repair Labor Guide Compatibility with Devices
- Motorcycle Repair Labor Guide Enhanced eBook Features

7. Enhancing Your Reading Experience

- Adjustable Fonts and Text Sizes of Motorcycle Repair Labor Guide
- Highlighting and Note-Taking Motorcycle Repair Labor Guide
- Interactive Elements Motorcycle Repair Labor Guide

8. Staying Engaged with Motorcycle Repair Labor Guide

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Motorcycle Repair Labor Guide

9. Balancing eBooks and Physical Books Motorcycle Repair Labor Guide

- Benefits of a Digital Library
- Creating a Diverse Reading Collection Motorcycle Repair Labor Guide

10. Overcoming Reading Challenges

- Dealing with Digital Eye Strain
- Minimizing Distractions
- Managing Screen Time

11. Cultivating a Reading Routine Motorcycle Repair Labor Guide

- Setting Reading Goals Motorcycle Repair Labor Guide
- Carving Out Dedicated Reading Time

12. Sourcing Reliable Information of Motorcycle Repair Labor Guide

- Fact-Checking eBook Content of Motorcycle Repair Labor Guide
- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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