



RD350 '85
350F

57V-SE1

SERVICE INFORMATION

FOREWORD

This Supplementary Service Manual has been prepared to introduce new service and new data for the RD350/350F. For complete information on service procedures, it is necessary to use this Supplementary Service Manual together with following manual:

RD250LC/350LC Service Manual 31L-28197-80
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NOTICE

This manual was written by the Yamaha Motor Company primarily for use by Yamaha dealers and their qualified mechanics. It is not possible to put an entire mechanic's education into one manual, so it is assumed that persons using this book to perform maintenance and repairs on Yamaha motorcycles have a basic understanding of the mechanical concepts and procedures inherent in motorcycle repair technology. Without such knowledge, attempted repairs or service to this model may render it unfit to use and/or unsafe.

Yamaha Motor Company, Ltd. is continually striving to improve all models manufactured by Yamaha. Modifications and significant changes in specifications or procedures will be forwarded to all Authorized Yamaha dealers and will, where applicable, appear in future editions of this manual.

**TECHNICAL PUBLICATIONS
SERVICE DIVISION
MOTORCYCLE OPERATIONS
YAMAHA MOTOR CO., LTD.**

HOW TO USE THIS MANUAL

PARTICULARLY IMPORTANT INFORMATION

This material is distinguished by the following notation.

NOTE: **A NOTE** provides key information to make procedures easier or clearer.

CAUTION: **A CAUTION** indicates special procedures that must be followed to avoid damage to the motorcycle.

WARNING: **A WARNING** indicates special procedures that must be followed to avoid injury to a motorcycle operator or person inspecting or repairing the motorcycle.

MANUAL FORMAT

All of the procedures in this manual are organized in a sequential, step-by-step format. The information has been compiled to provide the mechanic with an easy to read, handy reference that contains comprehensive explanations of all disassembly, repair, assembly, and inspection operations.

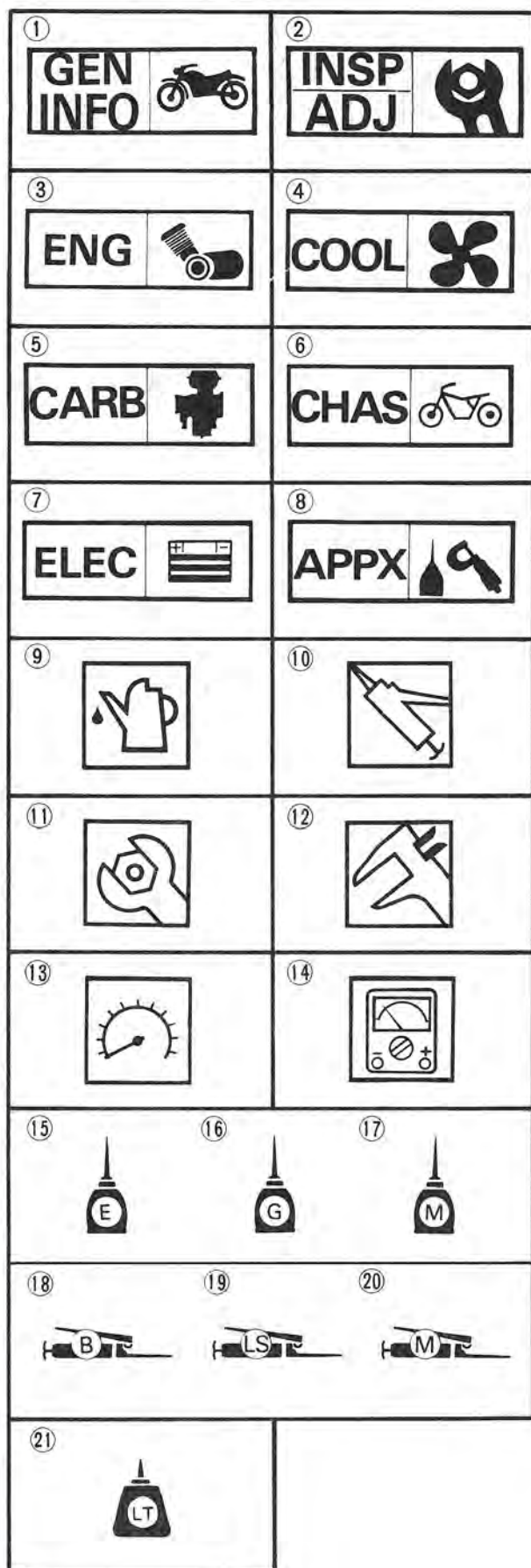
In this revised format, the condition of a faulty component will precede an arrow symbol and the course of action required will follow the symbol, e.g.,

- Bearings

Pitting/Damage → Replace.

EXPLODED DIAGRAM

Each chapter provides exploded diagrams before each disassembly section for ease in identifying correct disassembly and assembly procedures.



ILLUSTRATED SYMBOLS (Refer to the illustration)

Illustrated symbols ① to ⑧ are designed as thumb tabs to indicate the chapter's number and content.

- ① General information
- ② Periodic inspection and adjustment
- ③ Engine
- ④ Cooling system
- ⑤ Carburetion
- ⑥ Chassis
- ⑦ Electrical
- ⑧ Appendices

Illustrated symbols ⑨ to ⑭ are used to identify the specifications appearing in the text.

- ⑨ Filling fluid
- ⑩ Lubricant
- ⑪ Tightening
- ⑫ Wear limit, clearance
- ⑬ Engine speed
- ⑭ Ω , V, A

Illustrated symbols ⑮ to ㉑ in the exploded diagram indicate grade of lubricant and location of lubrication point.

- ⑮ Apply engine oil
- ⑯ Apply gear oil
- ⑰ Apply molybdenum disulfide oil
- ⑱ Apply wheel bearing grease
- ⑲ Apply lightweight lithium-soap base grease
- ⑳ Apply molybdenum disulfide grease
- ㉑ Apply locking agent (LOCTITE®)

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MOTORCYCLE IDENTIFICATION



GENERAL INFORMATION

MOTORCYCLE IDENTIFICATION

FRAME SERIAL NUMBER

The frame serial number ① is stamped into the right side of the steering head pipe.

ENGINE SERIAL NUMBER

The engine serial number ① is stamped into the elevated part of the left rear section of the engine.

NOTE:

The first three digits of these numbers are for model identifications; the remaining digits are the unit production number.

Starting Serial Number:

RD350	1JF	31K-077101
	1JG	31K-085101
RD350F	57V	31K-053101
	1AF	31K-072101

NOTE:

Designs and specifications are subject to change without notice.



INTRODUCTION/MAINTENANCE INTERVALS CHARTS



PERIODIC INSPECTIONS AND ADJUSTMENTS

INTRODUCTION

This chapter includes all information necessary to perform recommended inspections and adjustments. These preventive maintenance procedures, if followed, will ensure more reliable vehicle operation and a longer service life. The need for costly overhaul work will be greatly reduced. This information applies to vehicles already in service as well as new vehicles that are being prepared for sale. All service technicians should be familiar with this entire chapter.

PERIODIC MAINTENANCE/LUBRICATION INTERVALS

Unit: km (mi)

ITEM	REMARKS	BREAK-IN 1,000 (600)	EVERY	
			6,000 (4,000) or 6 Months	12,000 (8,000) or 12 Months
Spark plug(s)	Check condition. Clean or replace if necessary.	○	○	○
Air filter	Clean. Replace if necessary.		○	○
Carburetor*	Check idle speed (/synchronization)/ starter operation. Adjust if necessary.	○	○	○
Fuel line*	Check fuel hose (and vacuum pipe) for cracks or damage. Replace if necessary.		○	○
Transmission oil*	Check oil level/oil leakage. Correct if necessary. Replace every 24,000 (16,000) or 24 months. (Warm engine before draining.)	REPLACE	○	○
Autolube pump*	Check operation. Correct if necessary. Air bleeding.	○	○	○
Brake*	Check operation/fluid leakage/See NOTE. Correct if necessary.		○	○
Clutch	Check operation. Adjust if necessary.		○	○
Rear arm pivot*	Check rear arm assembly for looseness. Correct if necessary. Moderately repack every 24,000 (16,000) or 24 months.			○
Rear suspension link pivots*	Check operation. Apply grease lightly every 24,000 (16,000) or 24 months.			○
Wheels*	Check balance/damage/runout. Repair if necessary.		○	○
Wheel bearings*	Check bearings assembly for looseness/ damage. Replace if damaged.		○	○
Steering bearing*	Check bearings assembly for looseness. Correct if necessary. Moderately repack every 24,000 (16,000) or 24 months. **	○		○
Front forks*	Check operation/oil leakage. Repair if necessary.		○	○
Rear shock absorber*	Check operation./oil leakage. Repair if necessary.		○	○



MAINTENANCE INTERVALS CHARTS

Unit: km (mi)

ITEM	REMARKS	BREAK-IN 1,000 (600)	EVERY	
			6,000 (4,000) or 6 Months	12,000 (8,000) or 12 Months
Cooling system	Check coolant leakage. Repair if necessary. Replace coolant every 24,000 (16,000) or 24 months.		○	○
Drive chain	Check chain slack/alignment. Adjust if necessary. Clean and lube.	EVERY 500 (300)		
Fittings/Fasteners*	Check all chassis fittings and fasteners. Correct if necessary.	○	○	○
Center and sidestand*	Check operation. Repair if necessary.	○	○	○
Battery*	Check specific gravity. Check breather pipe for proper operation. Correct if necessary.		○	○

*: It is recommended that these items be serviced by a Yamaha dealer.

**: Medium weight wheel bearing grease.

***: Lithium soap base grease.

NOTE: _____

Brake fluid replacement:

1. When disassembling the master cylinder or caliper cylinder, replace the brake fluid.
Normally check the brake fluid level and add the fluid as required.
2. On the inner parts of the master cylinder and caliper cylinder, replace the oil seals every two years.
3. Replace the brake hoses every four years, or if cracked or damaged.

CYLINDER HEAD/CYLINDER/YPVS

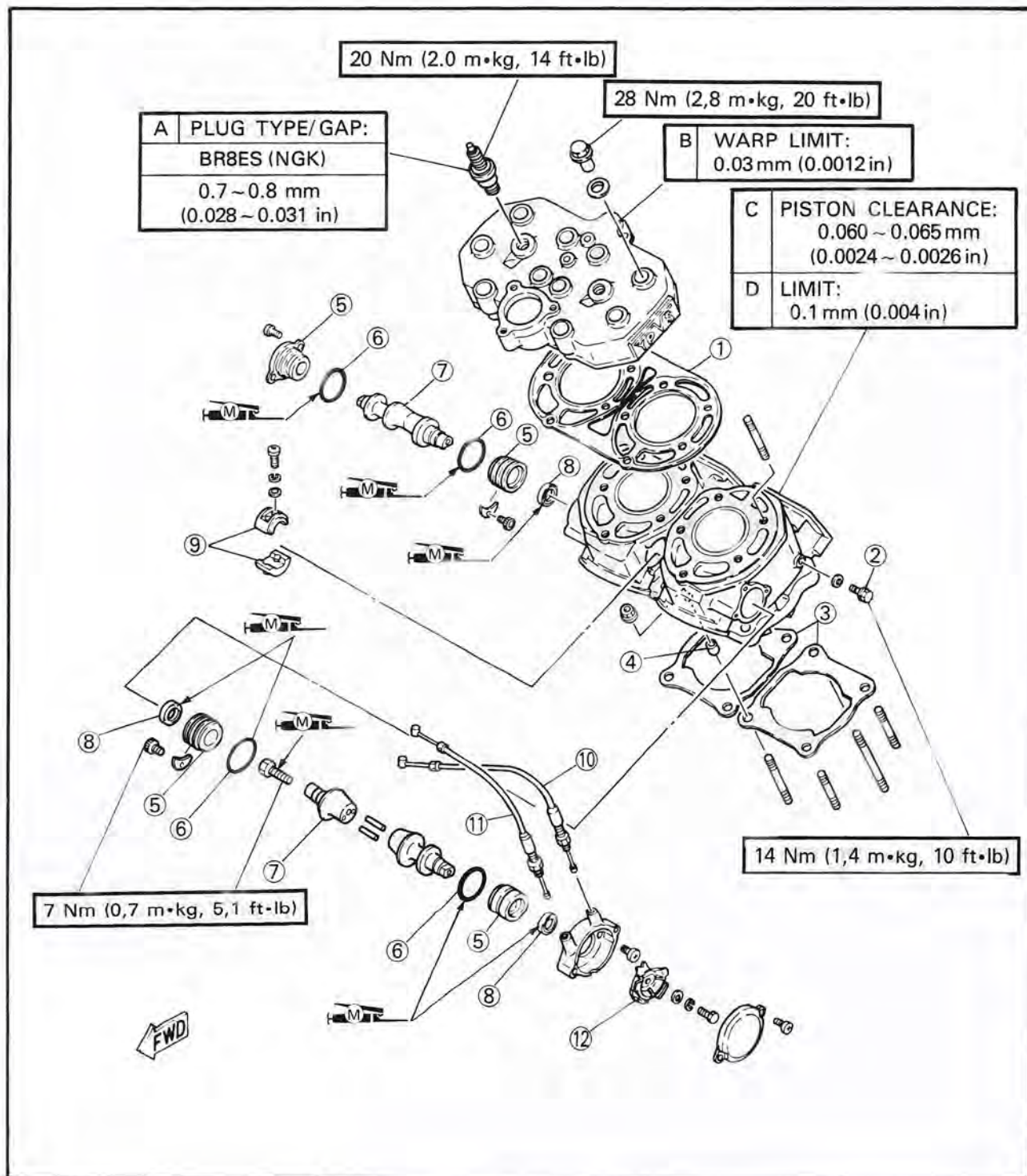
ENG



EXPLODED DIAGRAMS

CYLINDER HEAD/CYLINDER/YPVS

- | | |
|------------------------|----------------|
| ① Cylinder head gasket | ⑦ Power valve |
| ② Drain bolt | ⑧ Oil seal |
| ③ Cylinder gasket | ⑨ YPVS joint |
| ④ Dowel pin | ⑩ YPVS cable 2 |
| ⑤ Holder | ⑪ YPVS cable 1 |
| ⑥ O-ring | ⑫ Pulley |



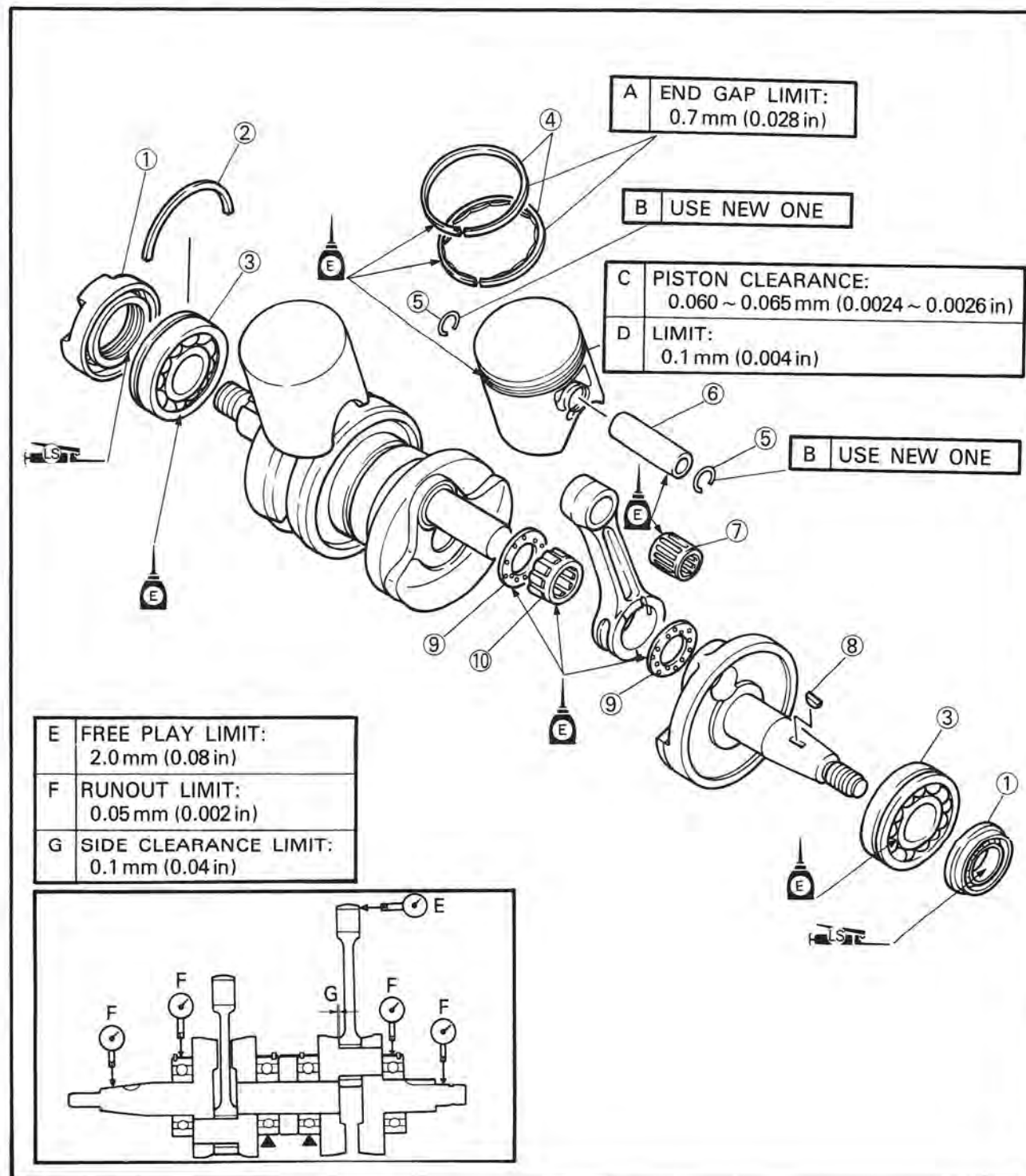
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PISTON/CRANKSHAFT

PISTON/CRANKSHAFT

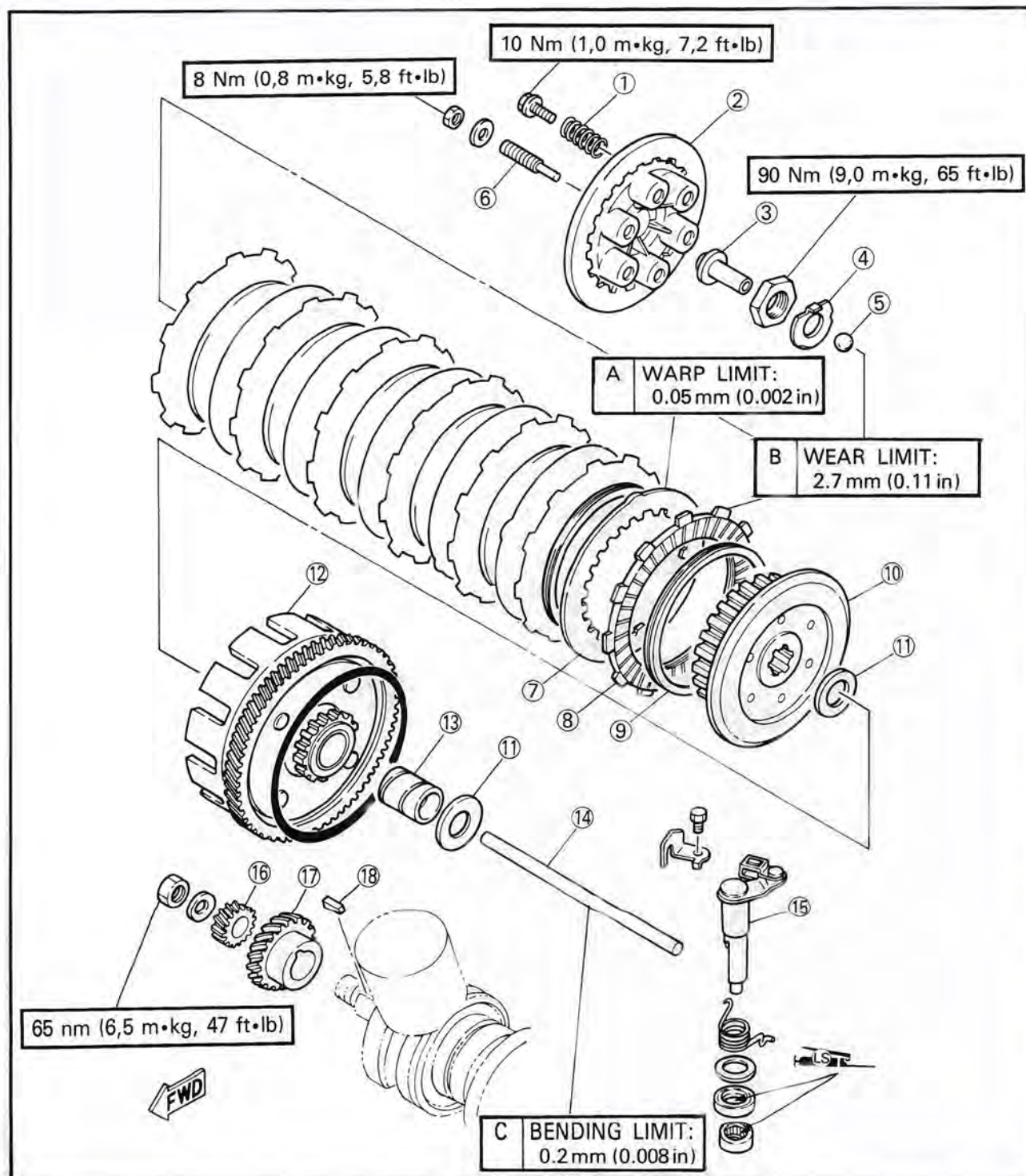
- ① Oil seal
- ② Circlip
- ③ Bearing
- ④ Piston ring
- ⑤ Piston pin clip
- ⑥ Piston pin
- ⑦ Small end bearing
- ⑧ Woodruff key
- ⑨ Washer
- ⑩ Big end bearing





CLUTCH

- | | |
|--------------------|---------------------------|
| ① Clutch spring | ⑩ Clutch boss |
| ② Pressure plate | ⑪ Thrust washer |
| ③ Push rod (No. 1) | ⑫ Clutch hosing |
| ④ Lock washer | ⑬ Spacer |
| ⑤ Ball | ⑭ Push rod (No. 2) |
| ⑥ Adjuster | ⑮ Push lever |
| ⑦ Clutch plate | ⑯ Drive gear (Water pump) |
| ⑧ Friction plate | ⑰ Primary drive gear |
| ⑨ Cushion ring | ⑱ Key |



ENG



CRANKCASE

CRANKCASE

- ① Primary gear
- ② Pin
- ③ Stopper
- ④ Drive gear axle
- ⑤ Drive gear
- ⑥ Gasket
- ⑦ Tachmoeter gear housing
- ⑧ O-ring
- ⑨ Drive gear
- ⑩ Oil buffer
- ⑪ Dowel pin

CRANKCASE TIGHTENING SEQUENCE

1st

9→16 5 Nm (0.5 m•kg, 3.6 ft•lb)

2nd

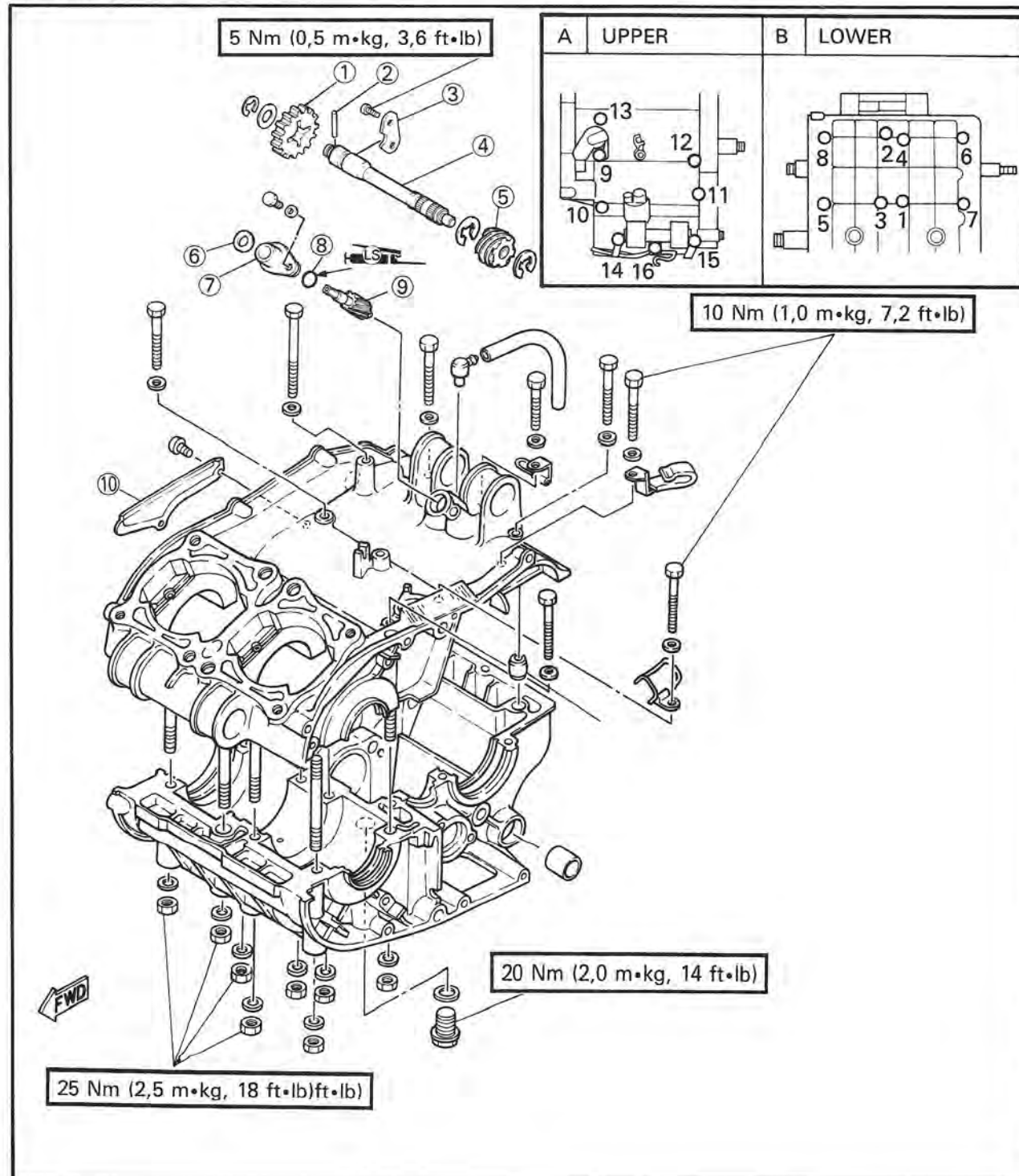
1→8 10 Nm (1.0 m•kg, 7.2 ft•lb)

3rd

1→8 25 Nm (2.5 m•kg, 18 ft•lb)

4th

9→16 10 Nm (1.0 m•kg, 7.2 ft•lb)



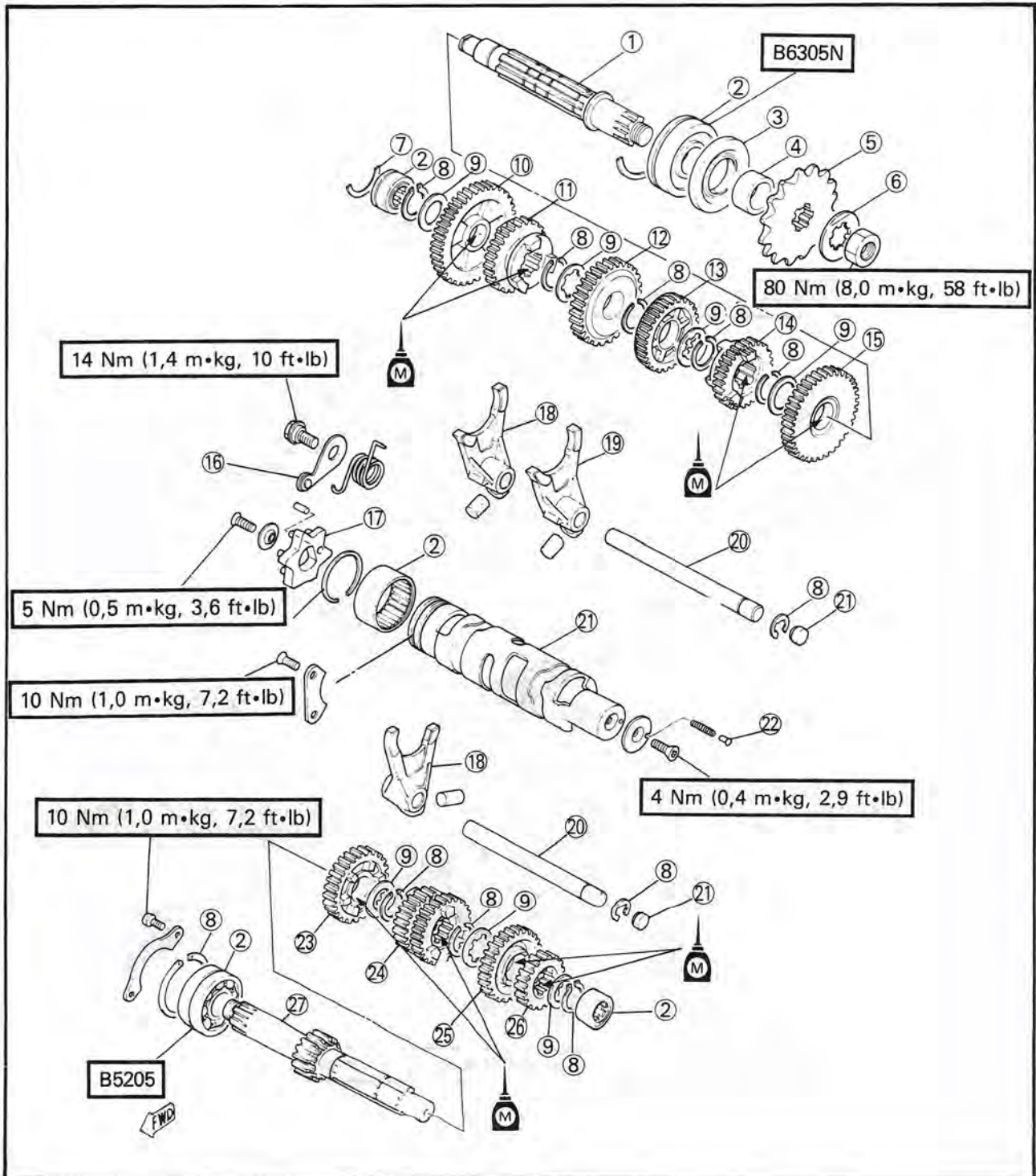
TRANSMISSION/SHIFT CAM

ENG



TRANSMISSION/SHIFT CAM

- | | | |
|------------------|------------------------|---------------------------------|
| ① Drive axle | ⑩ 1st wheel gear (36T) | ⑲ Shift fork 2 |
| ② Bearing | ⑪ 5th wheel gear (25T) | ⑳ Shift fork guide bar |
| ③ Oil seal | ⑫ 3rd wheel gear (29T) | ㉑ Plug |
| ④ Collar | ⑬ 4th wheel gear (26T) | ㉒ Neutral point |
| ⑤ Drive sprocket | ⑭ 6th wheel gear (24T) | ㉓ 5th pinion gear (26T) |
| ⑥ Lock washer | ⑮ 2nd wheel gear (32T) | ㉔ 3rd/4th pinion gear (22T/24T) |
| ⑦ Circlip | ⑯ Stopper lever | ㉕ 6th pinion gear (27T) |
| ⑧ Circlip | ⑰ Segment | ㉖ 2nd pinion gear (18T) |
| ⑨ Washer | ⑱ Shift fork 1 | ㉗ Main axle (14T) |



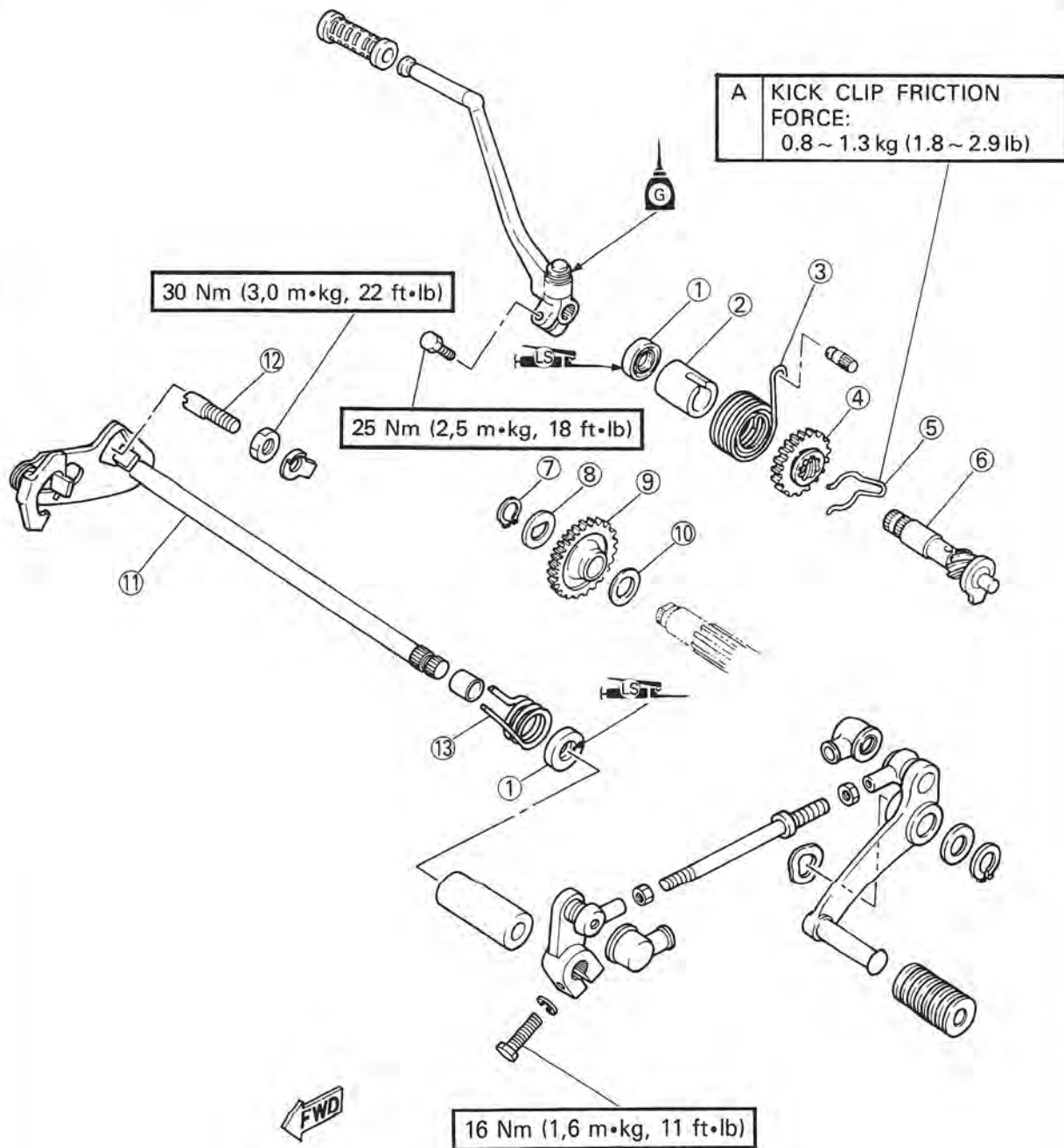
ENG



KICK STARTER/SHIFTER

KICK STARTER/SHIFTER

- | | |
|-----------------|-------------------------------|
| ① Oil seal | ⑧ Claw washer |
| ② Spacer | ⑨ Kick idel gear |
| ③ Return spring | ⑩ Washer |
| ④ Kick gear | ⑪ Shift shaft |
| ⑤ Kick clip | ⑫ Shift shaft adjusting screw |
| ⑥ Kick axle | ⑬ Shift return spring |
| ⑦ Circlip | |



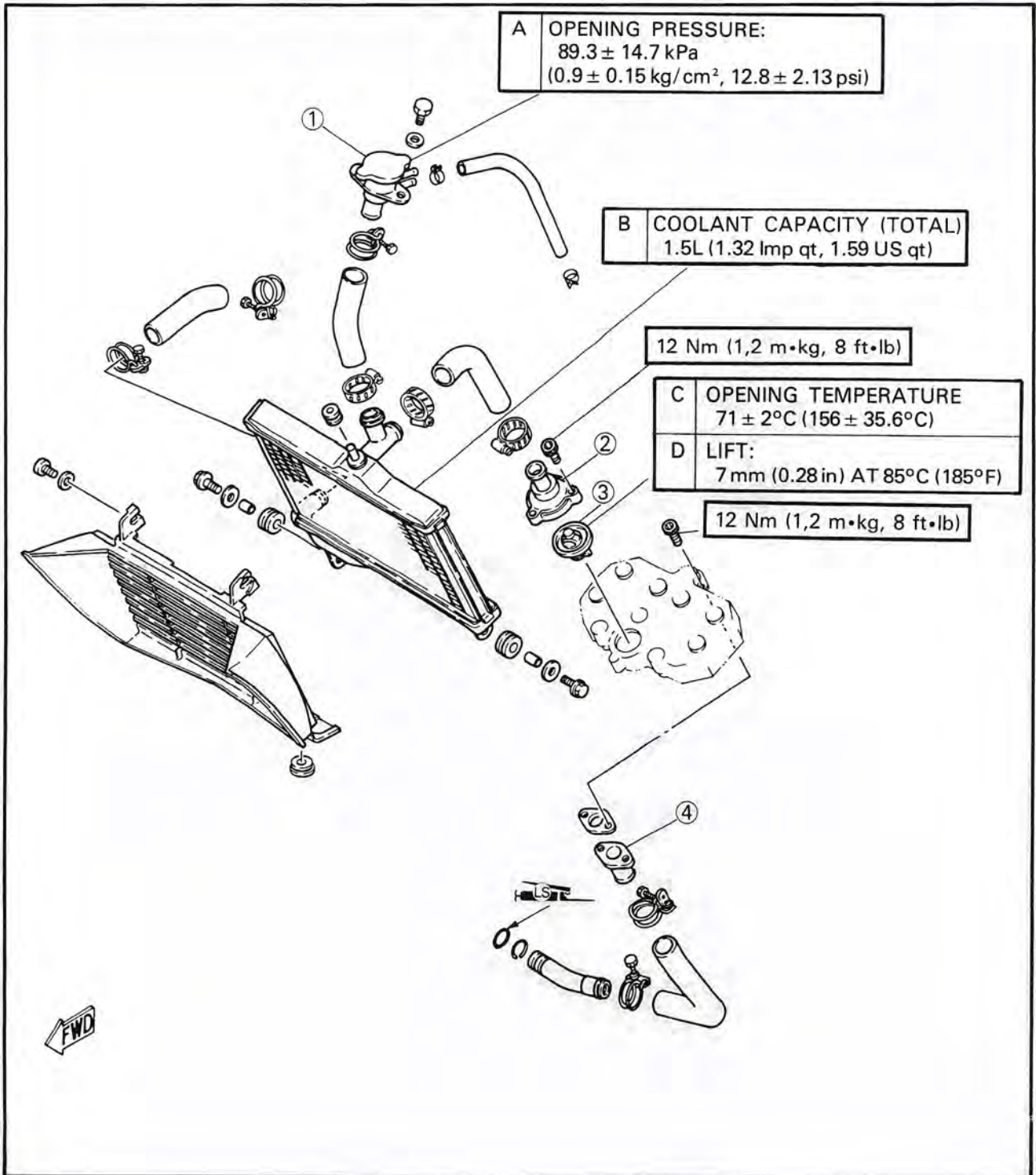
RADIATOR

CARB



RADIATOR

- ① Radiator cap
- ② Joint (Thermostatic valve cover)
- ③ Thermostatic valve
- ④ Joint





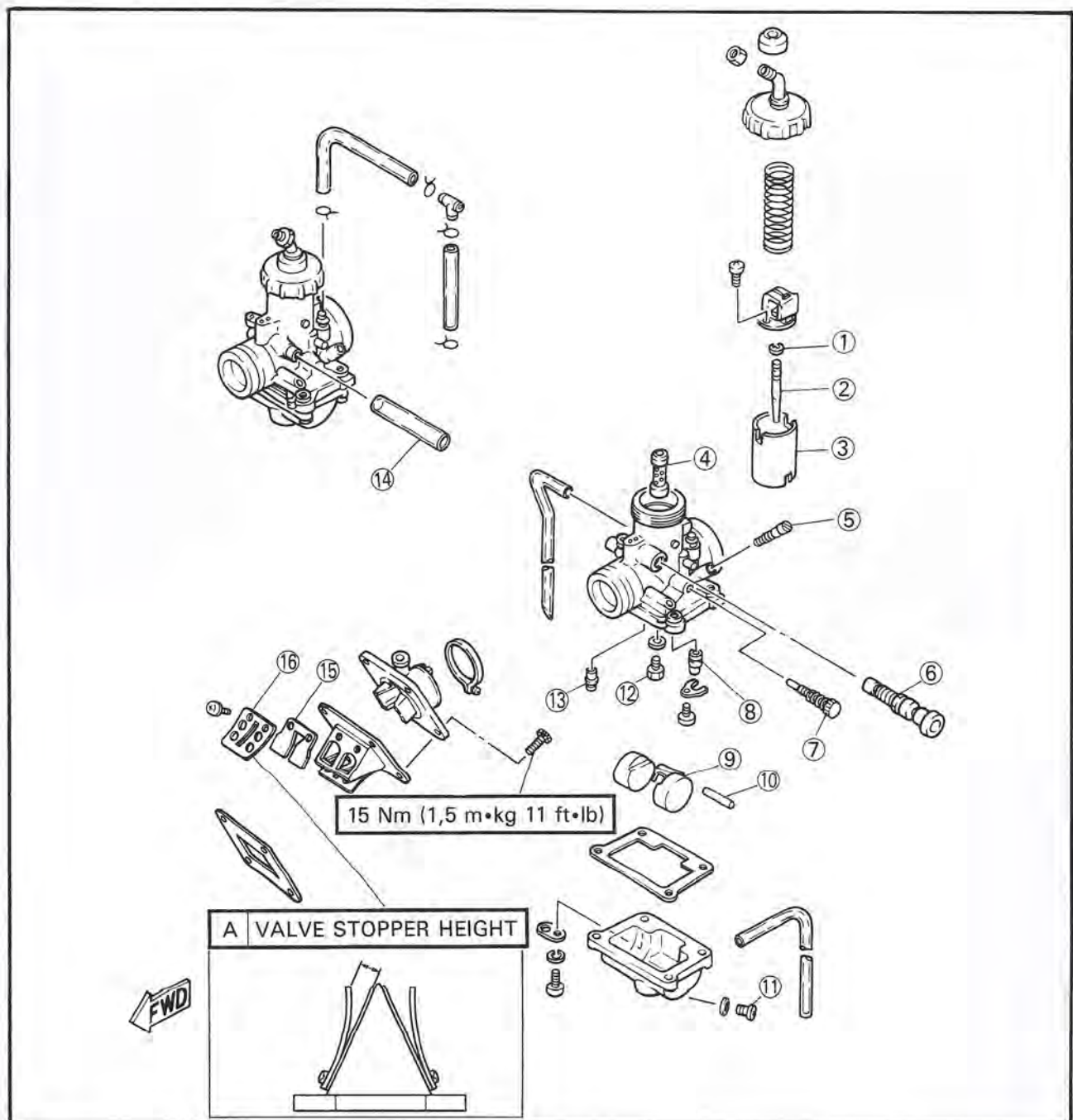
CARBURETOR

CARBURETOR

- | | |
|-----------------------|------------------------|
| ① Clip | ⑬ Pilot jet |
| ② Jet needle | ⑭ Hose (Starter joint) |
| ③ Throttle valve | ⑮ Reed valve |
| ④ Needle jet | ⑯ Valve stopper |
| ⑤ Pilot air screw | |
| ⑥ Starter plunger | |
| ⑦ Throttle stop screw | |
| ⑧ Valve seat | |
| ⑨ Float | |
| ⑩ Float pin | |
| ⑪ Drain screw | |
| ⑫ Main jet | |

SPECIFICATIONS

MAIN JET	#240
MAIN AIR JET	ø0.7
JET NEEDLE	5K1-4
NEEDLE JET	P-0
PILOT JET	#22.5
PILOT AIR SCREW	1 and 1/4
FUEL LEVEL	1.5 ± 0.5 mm (0.06 ± 0.04 in)
FLOAT HEIGHT	21.0 ± 1.0 mm (0.83 ± 0.04 in)
ENGINE IDLE SPEED	1,200 ± 50 r/min



FRONT WHEEL

CHAS

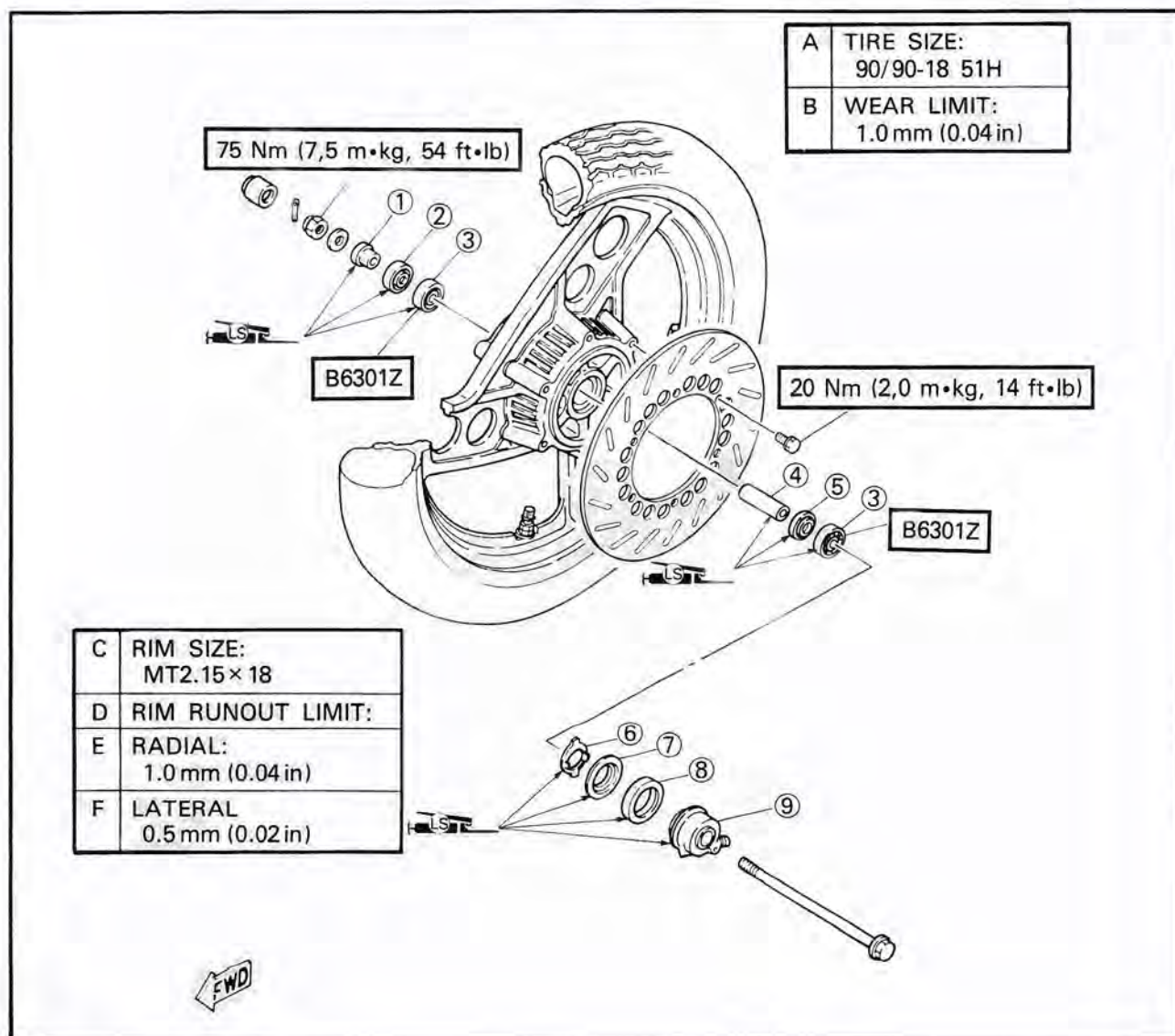


FRONT WHEEL

- ① Collar
- ② Dust cover
- ③ Bearing
- ④ Spacer
- ⑤ Spacer flange
- ⑥ Meter clutch
- ⑦ Clutch retainer
- ⑧ Oil seal
- ⑨ Gear unit

BASIC WEIGHT: WITH OIL AND FULL FUEL TANK	RD350: 161 kg (355 lb) RD350F: 165 kg (364 lb)
MAXIMUM LOAD*	RD350: 214 kg (472 lb) RD350F: 210 kg (463 lb)
COLD TIRE PRESSURE	FRONT REAR
UP TO 90 kg (198 lb) LOAD*	177 kPa 196 kPa (1.8 kg/cm ² , (2.0 kg/cm ² , 26 psi) 28 psi)
90 kg (198 lb) ~ MAXIMUM LOAD*	226 kPa 275 kPa (2.3 kg/cm ² , (2.8 kg/cm ² , 32 psi) 40 psi)
HIGH SPEED RIDING	196 kPa 226 kPa (2.0 kg/cm ² , (2.3 kg/cm ² , 28 psi) 32 psi)

*LOAD IS THE TOTAL WEIGHT OF CARGO, RIDER, PASSENGER, AND ACCESSORIES.





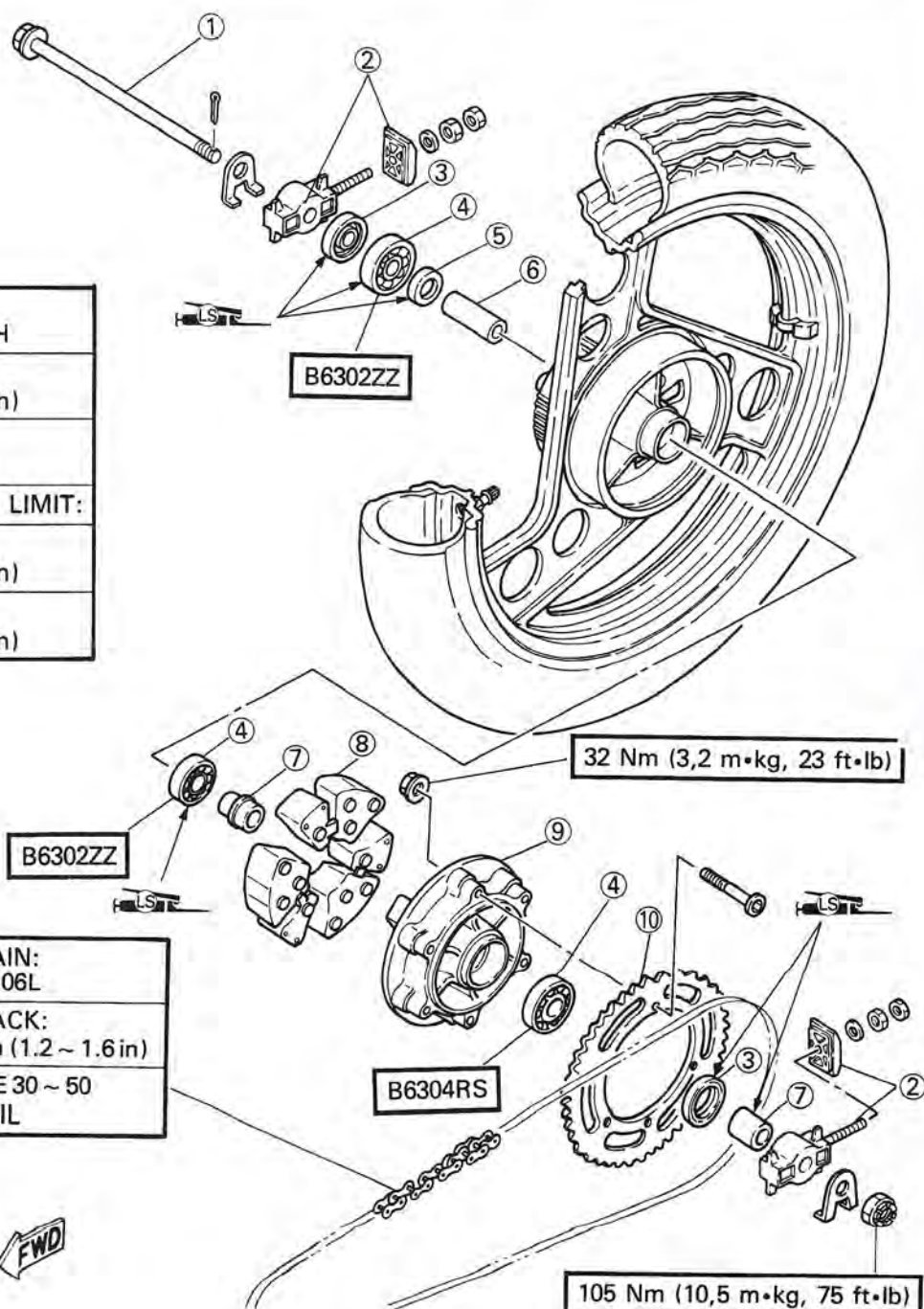
REAR WHEEL

REAR WHEEL

- ① Rear axle
- ② Drive chain puller
- ③ Oil seal
- ④ Bearing
- ⑤ Spacer flange
- ⑥ Spacer
- ⑦ Collar
- ⑧ Damper
- ⑨ Clutch hub
- ⑩ Driven sprocket (39T)

A	TIRE SIZE: 110/80-18 58H
B	WEAR LIMIT: 1.0 mm (0.04 in)
C	RIM SIZE: MT2.50 × 18
D	RIM RUNOUT LIMIT:
E	RADIAL: 1.0 mm (0.04 in)
F	LATERAL: 0.5 mm (0.02 in)

G	DRIVE CHAIN: 520V-SR/ 106L
H	CHAIN SLACK: 30 ~ 40 mm (1.2 ~ 1.6 in)
I	APPLY SAE 30 ~ 50 MOTOR OIL



FRONT AND REAR BRAKE CALIPER



FRONT AND REAR BRAKE CALIPER

- ① Rubber cap
- ② Bleed screw
- ③ Retaining bolt
- ④ Pad spring
- ⑤ Pad
- ⑥ Shim
- ⑦ Dust seal
- ⑧ Piston seal
- ⑨ Piston

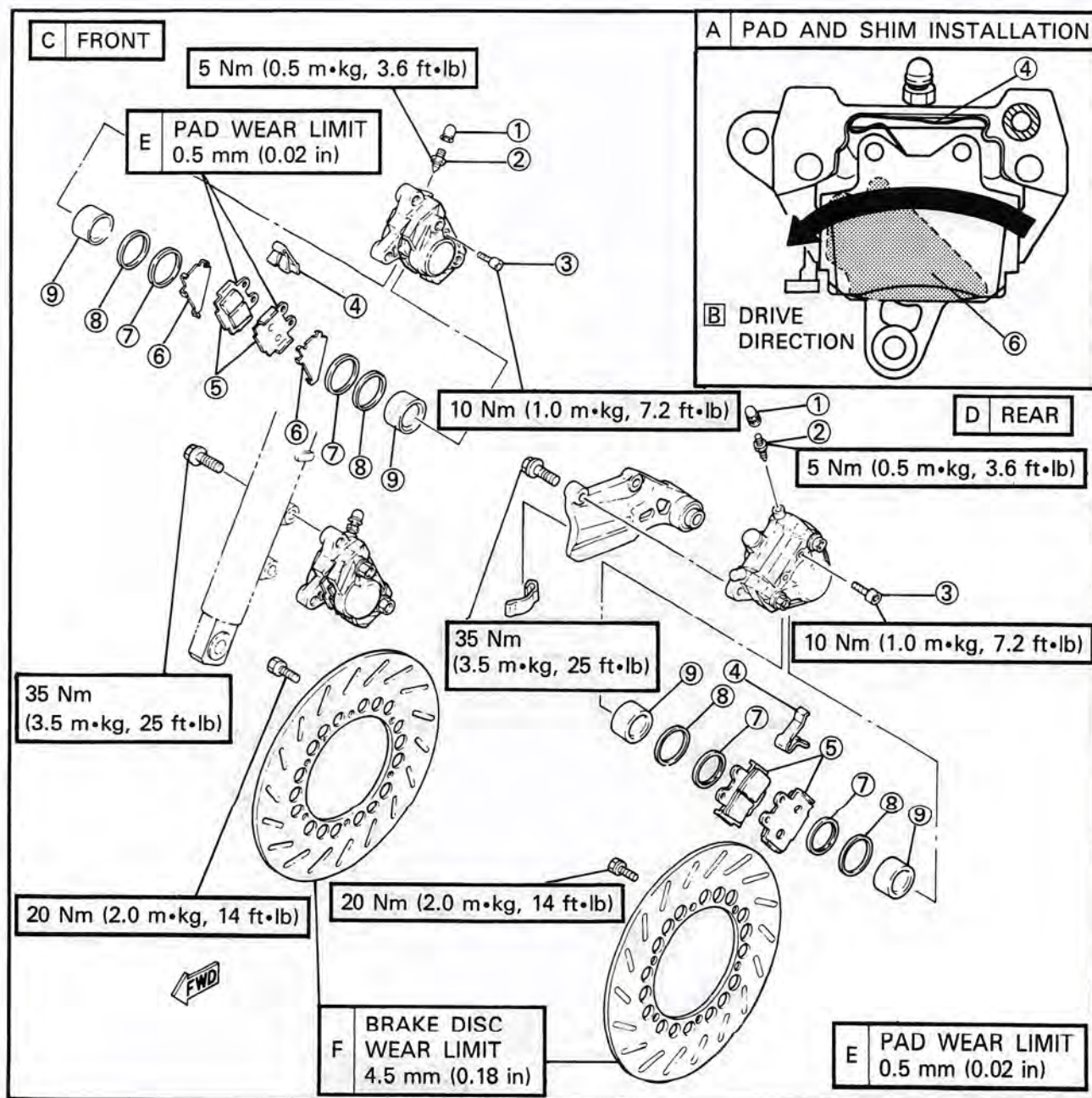
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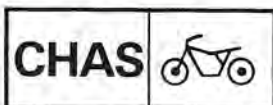
FRONT BRAKE:

Install the pad spring with its longer tangs * facing towards the disk rotation direction.

FRONT AND REAR BRAKE:

Be sure to position the shim so that its arrow mark points in the direction of the disk plate rotation.

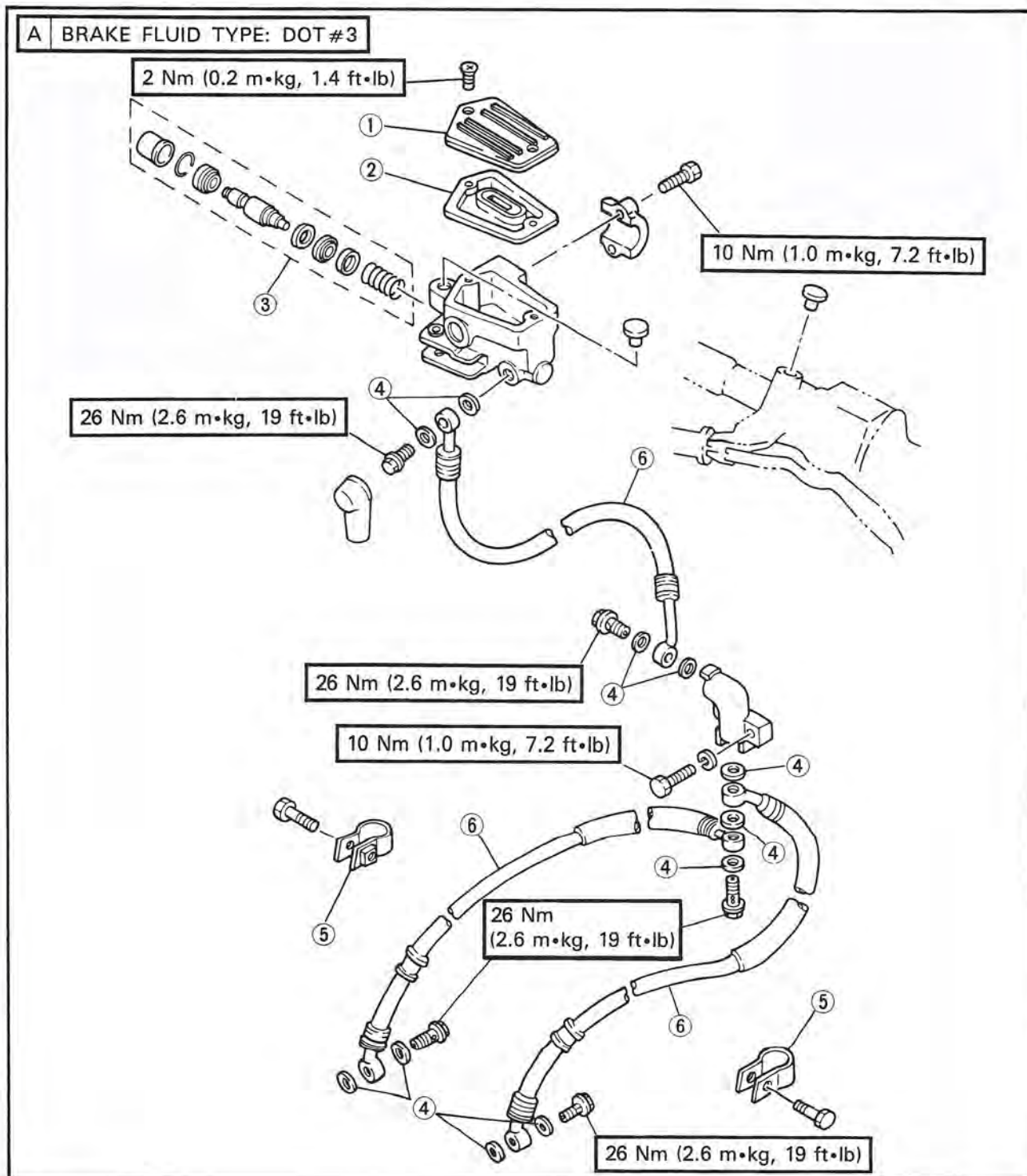




BRAKE MASTER CYLINDER

BRAKE MASTER CYLINDER (FRONT)

- ① Master cylinder cap
- ② Rubber seal
- ③ Master cylinder kit
- ④ Copper washer
- ⑤ Brake hose holder
- ⑥ Brake hose





FRONT FORK

FRONT FORK

- ① Air valve
- ② Cap bolt
- ③ O-ring
- ④ Dust seal
- ⑤ Spacer
- ⑥ Spring seat
- ⑦ Fork spring
- ⑧ Piston ring
- ⑨ Damper rod
- ⑩ Rebound spring

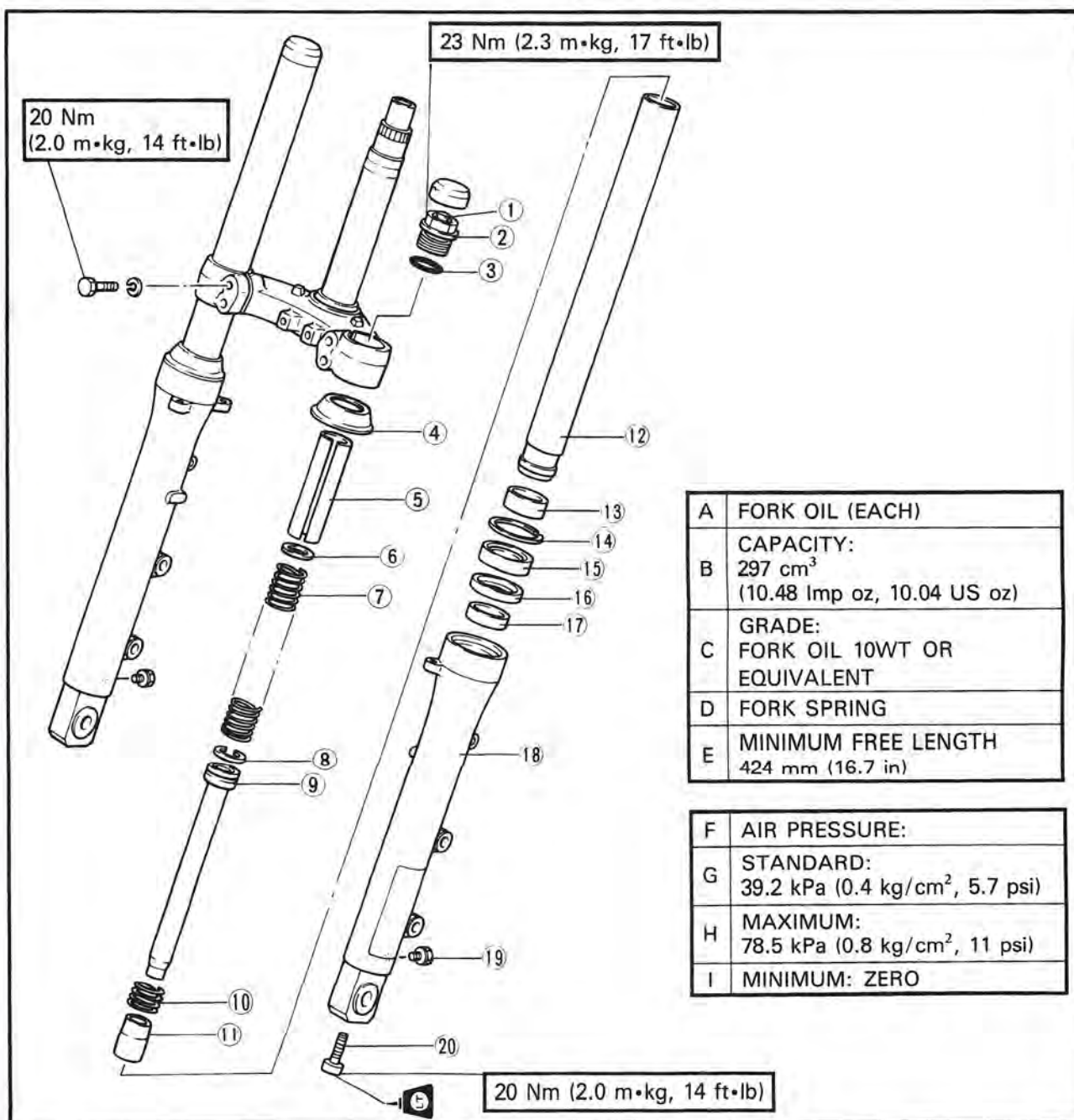
- ⑪ Oil lock piece
- ⑫ Inner fork tube
- ⑬ Slide metal
- ⑭ Retaining clip
- ⑮ Oil seal
- ⑯ Plain washer
- ⑰ Slide metal
- ⑱ Outer fork tube
- ⑲ Drain screw
- ⑳ Cylinder securing bolt

T-HANDLE:

P/N. 90890-01326

DAMPER ROD HOLDER:

P/N. 90890-01294



A	FORK OIL (EACH)
B	CAPACITY: 297 cm ³ (10.48 Imp oz, 10.04 US oz)
C	GRADE: FORK OIL 10WT OR EQUIVALENT
D	FORK SPRING
E	MINIMUM FREE LENGTH 424 mm (16.7 in)

F	AIR PRESSURE:
G	STANDARD: 39.2 kPa (0.4 kg/cm ² , 5.7 psi)
H	MAXIMUM: 78.5 kPa (0.8 kg/cm ² , 11 psi)
I	MINIMUM: ZERO

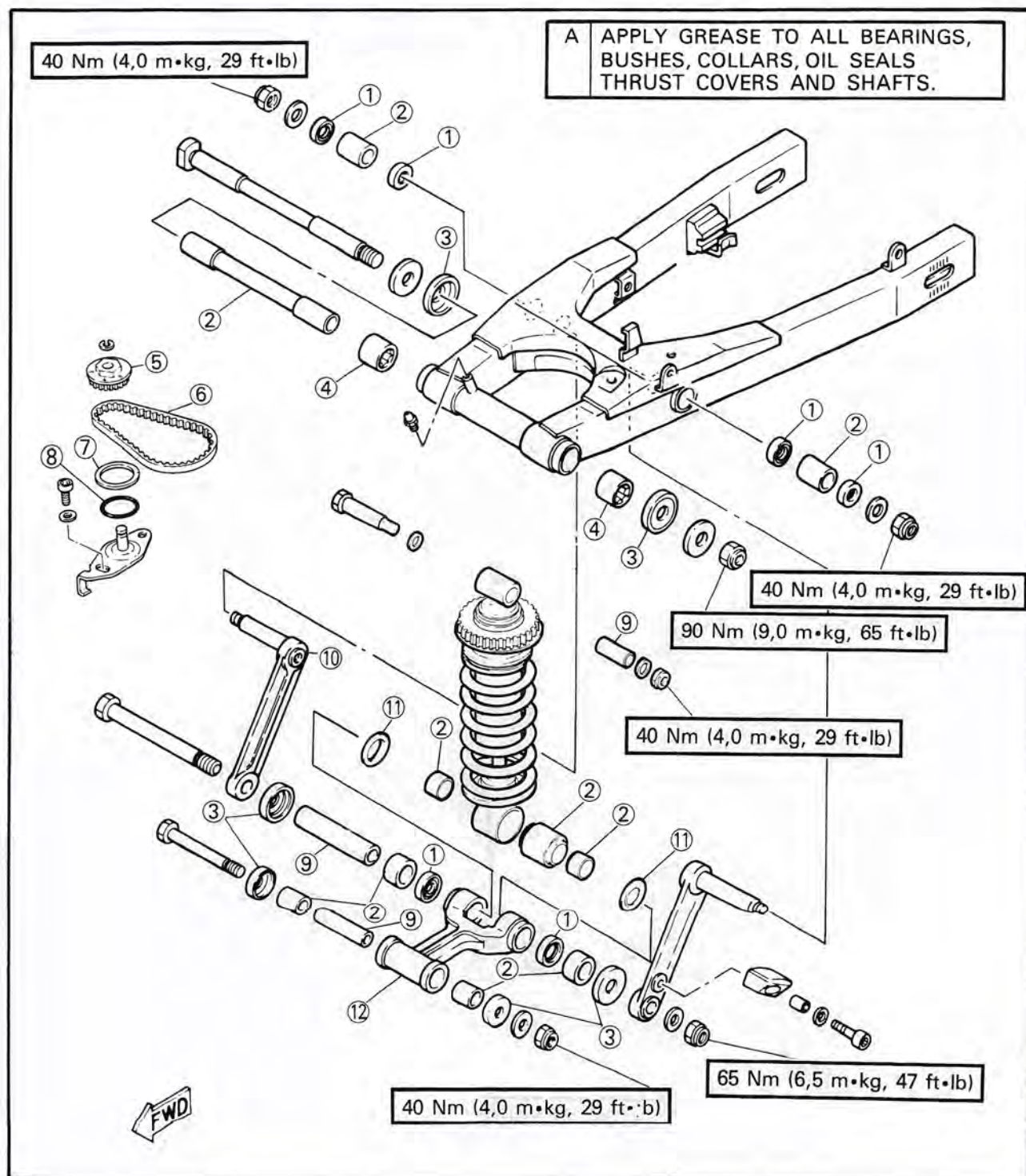
REAR SHOCK ABSORBER/SWINGARM

CHAS



REAR SHOCK ABSORBER/ SWINGARM

- | | |
|----------------|--------------|
| ① Oil seal | ⑨ Collar |
| ② Bash | ⑩ Arm |
| ③ Thrust cover | ⑪ Dust cover |
| ④ Bearing | ⑫ Relay arm |
| ⑤ Pulley | |
| ⑥ Timing belt | |
| ⑦ Washer | |
| ⑧ O-ring | |



ELEC



ELECTRICAL COMPONENTS

ELECTRICAL COMPONENTS (1)

- ① Oil level switch
- ② Battery
- ③ Brake switch (Rear)
- ④ Stator assembly
- ⑤ Flasher relay
- ⑥ Rectifier/Regulator
- ⑦ CDI unit

BATTERY:

CAPACITY: 12V, 5.5A

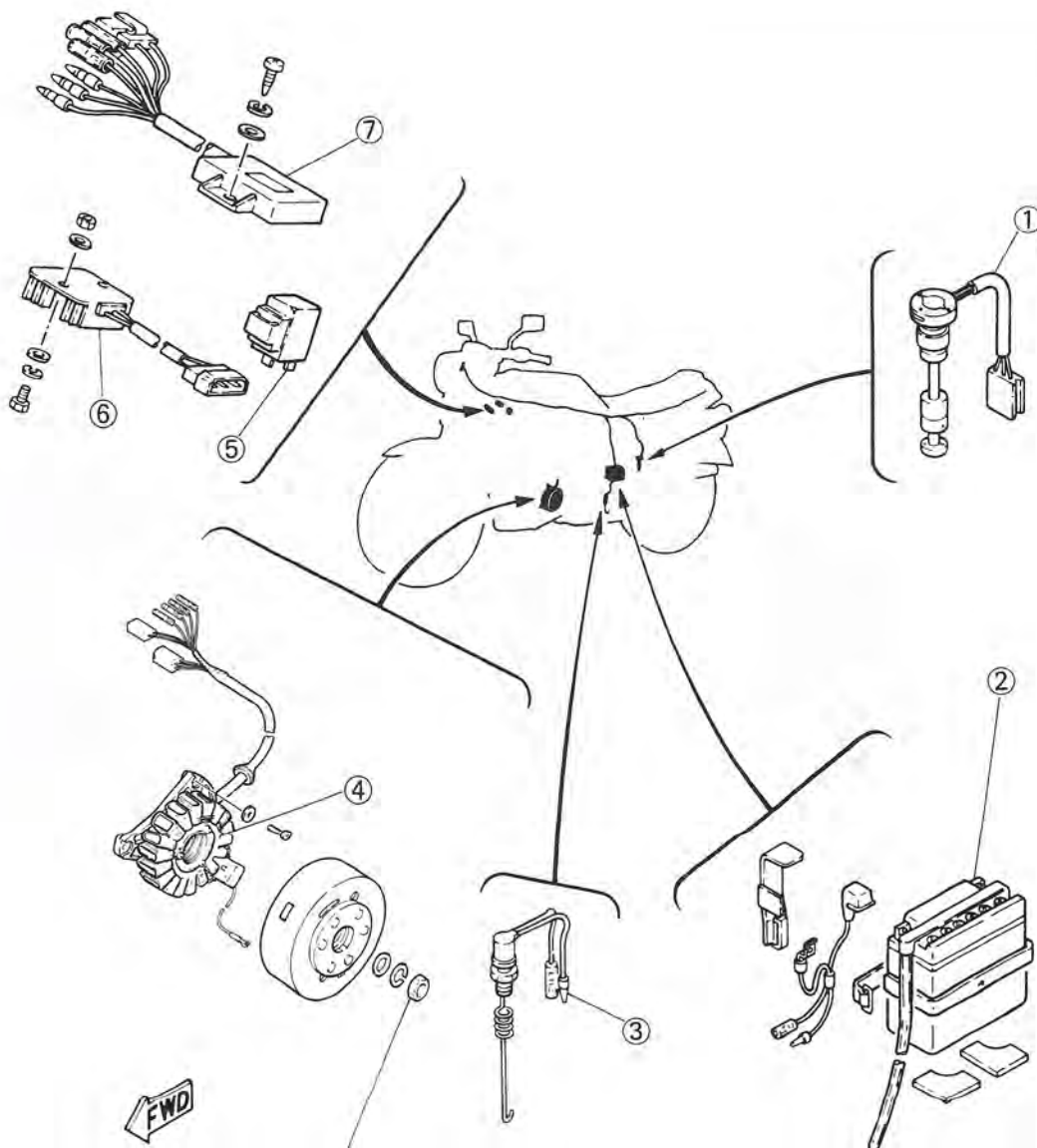
SPECIFIC GRAVITY: 1,280

PICKUP COIL RESISTANCE/ COLOR:

117Ω ± 20% AT 20°C (68°F)
(WHITE/ GREEN — WHITE/ RED)

SOURCE COIL RESISTANCE:

133Ω ± 20% AT 20°C (68°F)
(GREEN — BROWN)
4.1Ω ± 20% AT 20°C (68°F)
(BROWN — RED)



85 Nm (8.5 m•kg, 61 ft•lb)

ELECTRICAL COMPONENTS

ELEC



ELECTRICAL COMPONENTS (2)

- ① Main switch
- ② Servomotor
- ③ Ignition coil
- ④ Control unit (YPVS)
- ⑤ Neutral switch
- ⑥ Thermo unit
- ⑦ Horn

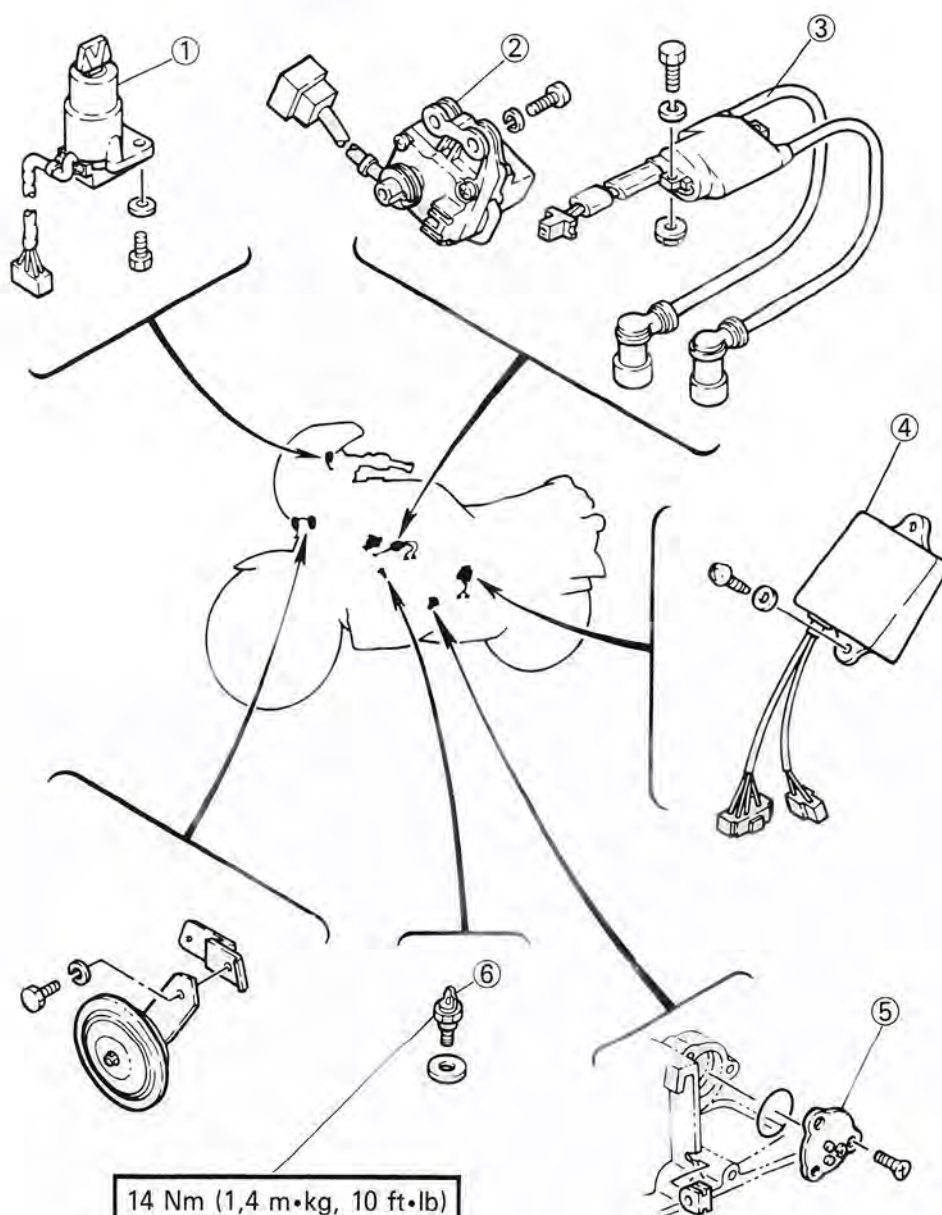
IGNITION COIL:

PRIMARY WINDING RESISTANCE:
 $0.33\Omega \pm 10\%$ AT 20°C (68°F)

SECONDARY WINDING RESISTANCE:
 $3.5k\Omega \pm 100\%$ AT 20°C (68°F)

SERVOMOTOR:

POTENTIOMETER RESISTANCE:
 $7.5k\Omega \pm 30\%$ AT 20°C (68°F)
 (YELLOW/BLUE — WHITE/BLACK)



APPX

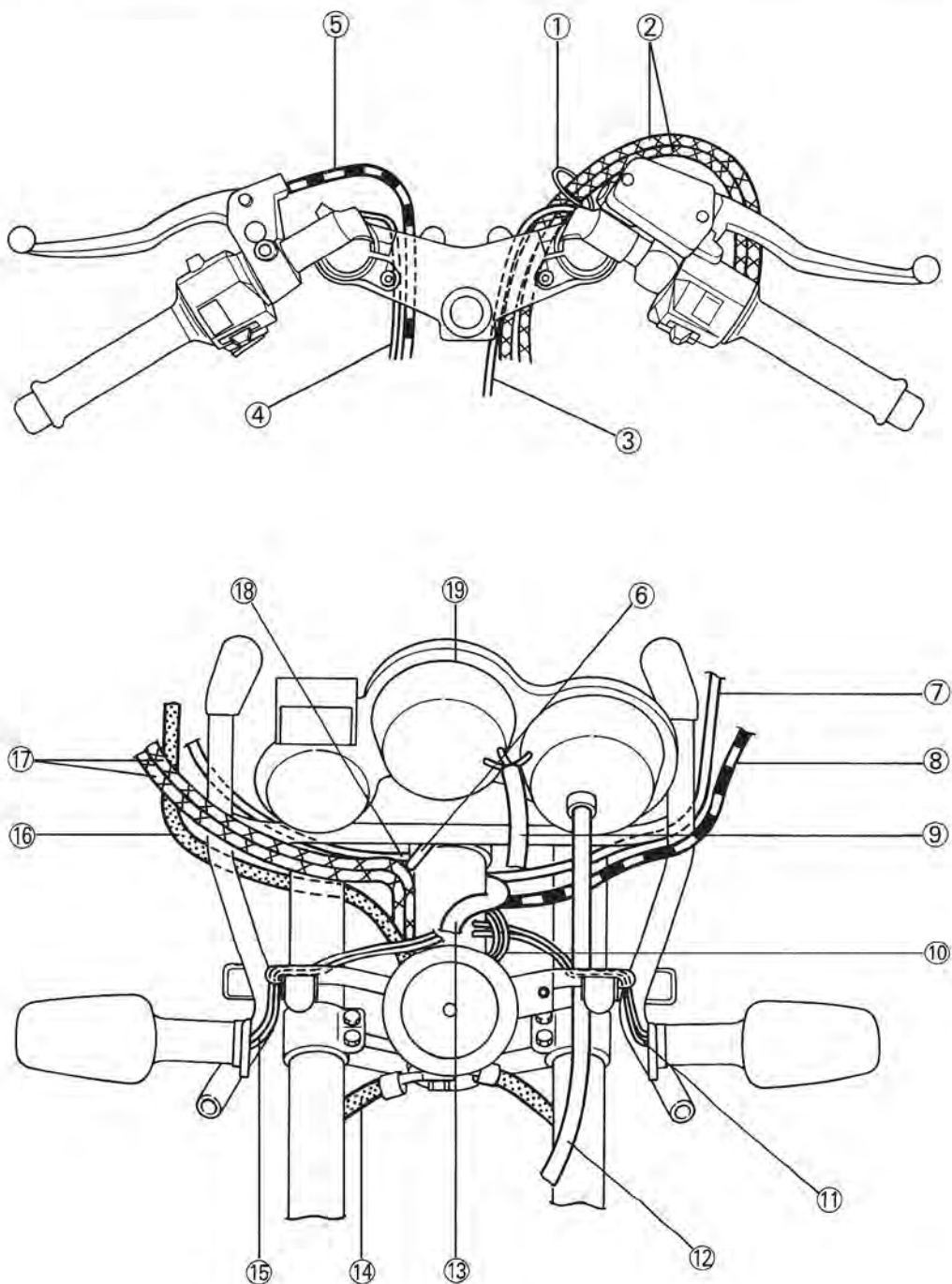


CABLE ROUTING

CABLE ROUTING

- ① Cable holder
- ② Throttle cable 1, 2
- ③ Handlebar switch lead (Right)
- ④ Handlebar switch lead (Left)
- ⑤ Clutch cable
- ⑥ Main switch lead
- ⑦ Handlebar switch lead (Right)
- ⑧ Clutch cable
- ⑨ Meter lead
- ⑩ Horn lead (Left)

- ⑪ Front flasher light lead (Left)
- ⑫ Speedometer cable
- ⑬ Wire harness
- ⑭ Brake hose 2
- ⑮ Front flasher light lead (Right)
- ⑯ Brake hose 1
- ⑰ Throttle cable 1, 2
- ⑱ Handlebar switch lead (Right)
- ⑲ Meter ass'y



CABLE ROUTING

APPX

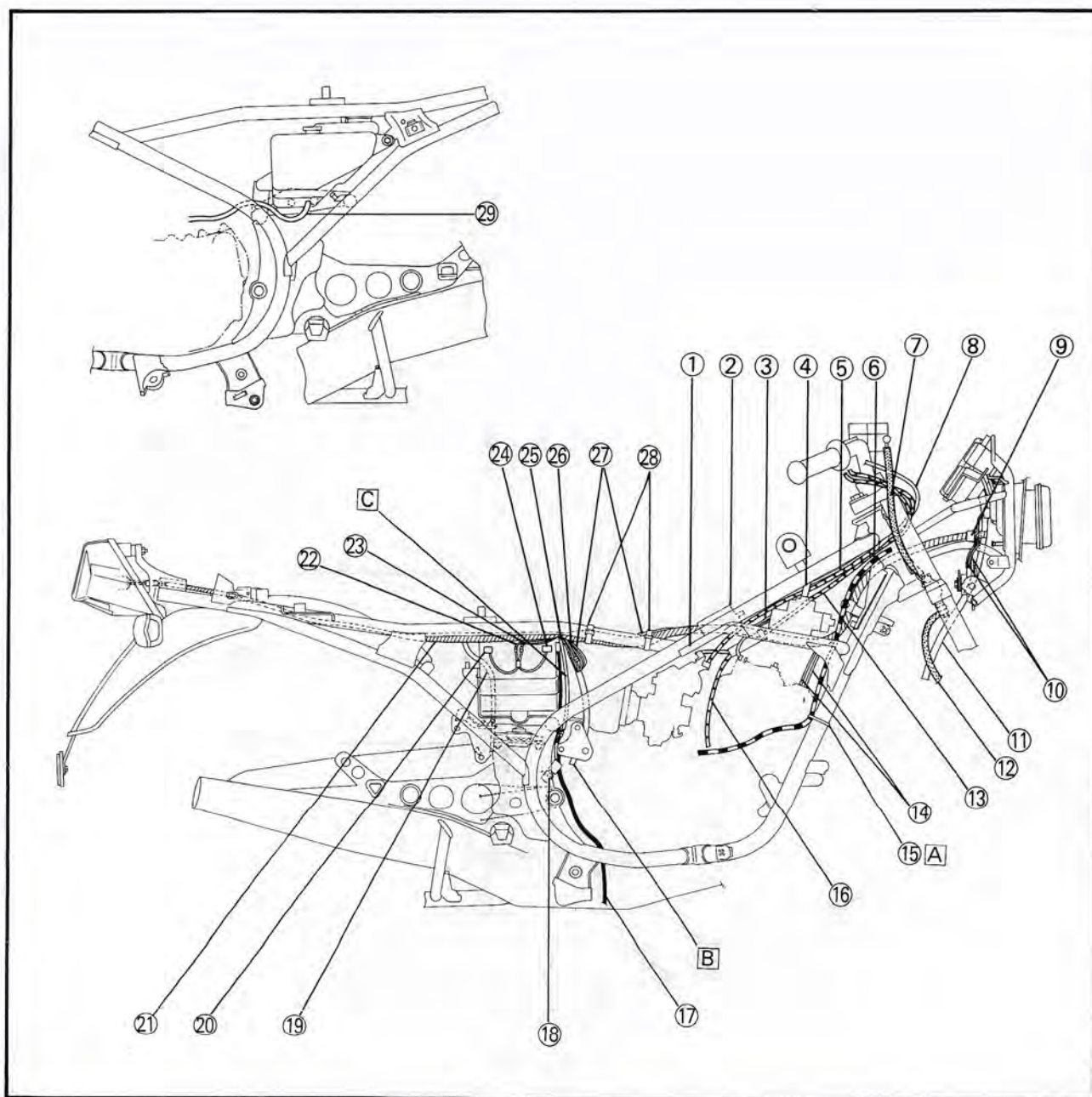


CABLE ROUTING

- ① Rectifier/regulator
- ② C.D.I. unit
- ③ Thermo-unit lead
- ④ Servomotor
- ⑤ Throttle cable 2
- ⑥ Clutch cable
- ⑦ Brake hose 1
- ⑧ Handlebar switch lead (Right)
- ⑨ Clamp
- ⑩ Horn lead (Left)
- ⑪ Speedometer cable
- ⑫ Brake hose 2
- ⑬ Throttle cable 1
- ⑭ Y.P.V.S. cable
- ⑮ Clamp

- ⑯ Pump cable
- ⑰ Battery breather hose
- ⑱ Brake switch Ass'y
- ⑲ Oil tank breather hose
- ⑳ Battery negative terminal
- ㉑ Wire harness
- ㉒ Battery negative lead
- ㉓ Battery positive lead
- ㉔ Battery positive terminal
- ㉕ Earth terminal
- ㉖ C.D.I. magneto lead
- ㉗ C.D.I. unit lead
- ㉘ Band
- ㉙ Oil hose

- Ⓐ HOLD THE CLUTCH CABLE WITH THE CLAMP.
- Ⓑ ROUTE THE CDI MAGNETO LEADS BEHIND THE ENGINE BRACKET, AND CONNECT THEM.
- Ⓒ ROUTE THE STOP SWITCH LEADS BEHIND THE ENGINE BRACKET.





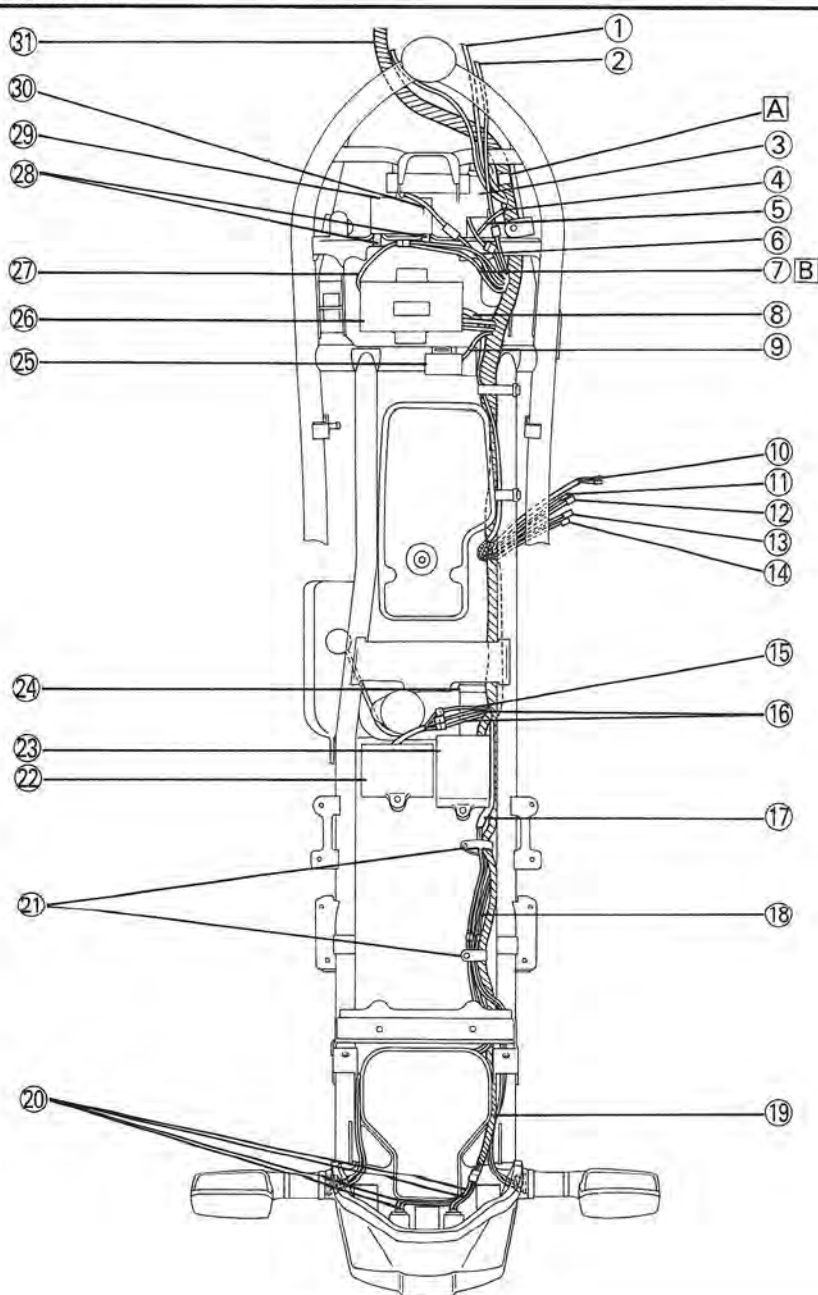
CABLE ROUTING

CABLE ROUTING

- | | |
|---------------------------------|---------------------------------|
| ① Handlebar switch lead (Right) | ①⑦ Flasher lead (Right) |
| ② Main switch lead | ①⑧ Flasher lead (Left) |
| ③ Servomotor | ①⑨ Wire harness |
| ④ Thermo unit lead | ②⑩ Tail/Brake light lead |
| ⑤ Servomotor lead | ②⑪ Clamp |
| ⑥ Rectifier/regulator lead | ②⑫ Y.P.V.S. control unit |
| ⑦ Frame earth lead | ②⑬ Fuse box |
| ⑧ C.D.I. unit lead | ②⑭ Oil tank breather hose |
| ⑨ Flasher relay lead | ②⑮ Flasher relay |
| ⑩ Brake switch lead | ②⑯ C.D.I. unit |
| ⑪ Earth terminal | ②⑰ Rectifier/regulator lead |
| ⑫ C.D.I. magneto lead | ②⑱ Plug cord |
| ⑬ Battery positive lead | ②⑲ Ignition coil |
| ⑭ Battery negative lead | ②⑳ Ignition coil lead |
| ⑮ Oil level gauge lead | ③① Handlebar switch lead (Left) |
| ⑯ Y.P.V.S. control unit lead | |

A SECURE THE LEADS WITH THE CLAMP.

B CONNECT THE GROUND LEAD TO THE SCREW ON THE REAR OF THE IGNITION COIL AND TIGHTEN THE SCREW.



SPECIFICATIONS

APPX



APPENDICES

SPECIFICATIONS

1. GENERAL SPECIFICATIONS

(DK): For Denmark

(S): For Sweden

(FL): For Finland

(G): For Germany

Model	RD350/350F			
Model Code Number	57V	1JF	1AF(G)	1JG(G)
Frame Starting Number	31K-053101	31K-077101	31K-072101	31K-085101
Engine Starting Number	31K-053101	31K-077101	31K-072101	31K-085101
Dimensions:				
Overall Length	2,095 mm (82.5 in) 2,120 mm (83.5 in) [G, DK, S] 2,160 mm (85.0 in) [FL]			
Overall Width	690 mm (27.2 in) [350] 670 mm (26.4 in) [350F]			
Overall Height	1,190 mm (46.9 in)			
Seat Height	800 mm (31.5 in)			
Wheelbase	1,385 mm (54.5 in)			
Minimum Ground Clearance	165 mm (6.5 in)			
Weight:				
With Oil and Full Fuel Tank	161 kg (355 lb) [350] 165 kg (364 lb) [350F]			
Minimum Turning Radius	2,700 mm (106 in)			
Engine:				
Type	Liquid cooled 2-stroke, gasoline, torque induction			
Cylinder Arrangement	Twin, forward inclined			
Displacement	347 cm ³			
Bore × Stroke	64.0 × 54.0 mm (2.520 × 2.126 in)			
Compression Ratio	6.0 : 1			
Starting System	Primary kick starter			
Lubrication System	Separate lubrication (Yamaha Autolube)			
Engine Oil:				
Type	Yamaha oil 2T or equivalent, Air cooled 2-stroke engine oil			
Tank Capacity	1.6 L (1.41 Imp qt, 1.69 Us qt)			
Transmission Oil:				
Type	SAE 10W30 type SE motor oil			
Oil Capacity Total	1.7 L (1.50 Imp qt, 1.80 US qt)			
Exchange	1.5 L (1.32 Imp qt, 1.59 US qt)			
Radiator Capacity (Including All Routes)	1.5 L (1.32 Imp qt, 1.59 US qt)			
Spark Plug:				
Type	BR8ES			
Gap	0.7 ~ 0.8 mm (0.02 ~ 0.03 in)			
Carburetor × Quantity/ Manufacturer	VM26SS × 2/ MIKUNI			
Air Cleaner	Wet foam rubber			



SPECIFICATIONS

Model	RD350/ 350F
Clutch Type	Wet, multiple-disc
Transmission:	
Primary Reduction System	Helical gear
Primary Reduction Ratio	66/ 23 (2.870)
Secondary Reduction System	Chain
Secondary Reduction Ratio	39/ 17 (2.294) 40/ 17 (2.352) (G)
Transmission Type	Constant mesh 6-speed
Operation System	Left foot operation
Gear Ratio 1st	36/ 14 (2.571)
2nd	32/ 18 (1.778)
3rd	29/ 22 (1.318)
4th	26/ 24 (1.083)
5th	25/ 26 (0.962)
6th	24/ 27 (0.889)
Chassis:	
Frame Type	Double cradle
Caster	26°
Trail	96 mm (3.78 in)
Fuel:	
Tank Capacity, Total	20.0 L (4.4 Imp gal, 5.28 US gal)
Reserve	2.0 L (0.44 Imp gal 0.53 US gal)
Tire	
Front	90/90-18 51H
Rear	110/80-18 58H
Braking System:	
Front	Double disc brake/Right hand operation
Rear	Single disk brake/ Right foot operation
Suspension:	
Front	Telescopic fork
Rear	Swing arm (New monocross suspension)
Shock Absorber:	
Front	Air, coil spring/oil damper
Rear	Gas, coil spring/oil damper
Wheel Travel:	
Front	140 mm (5.51 in)
Rear	100 mm (3.94 in)
Electrical:	
Ignition System	CDI
Generator System	A.C. generator
Battery:	
Type/ Capacity	12N5.5-3B/ 12V, 5.5AH

SPECIFICATIONS

APPX



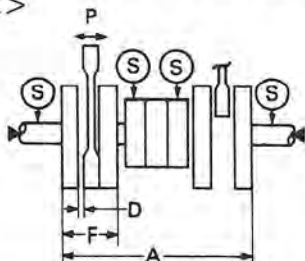
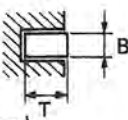
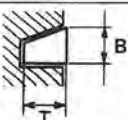
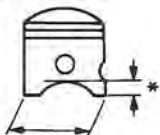
Model	RD350/ 350F
Bulb Wattage × Quantity:	
Headlight	60W/55W (Quartz bulb)
Tail/ Brake Light	12V, 5W/21W × 2
Turn Light	12V, 21W × 4
Meter Light	12V, 3.4W × 5
Auxiliary Light	12V, 4W 3.4W (England)
Indicator Light:	
“NEUTRAL”	12V, 3.4W
“HIGH BEAM”	12V, 3.4W
“OIL”	12V, 3.4W
“TURN”	12V, 3.4W



MAINTENANCE SPECIFICATIONS

Engine

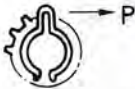
Model	RD350/350F
Cylinder Head: Combustion Chamber Volume Distortion Limit	21.3 ~ 21.9 cm ³ 0.03 mm (0.0012 in)
Cylinder: Material Bore Size /<Limit> Taper Limit Out of Round Limit	Aluminum alloy with cast iron sleeve (Cast in) $64^{+0.02}_{-0}$ mm ($2.52^{+0.0008}_{-0}$ in) / 64.1 mm (2.524 in) 0.05 mm (0.0020 in) 0.01 mm (0.0004 in)
Piston: Piston Size/ Measuring Point* Piston Clearance <Limit> Piston Oversize Piston Offset	64.0 mm (2.520 in) / 10 mm (0.39 in) 0.060 ~ 0.065 mm (0.0024 ~ 0.0026 in) 0.1 mm (0.004 in) 64.25, 64.50 mm (2.53, 2.54 in) 0 mm (0 in)
Piston Ring: Piston Ring Design/ B × T (Top) (2nd) Ring End Gap (Installed) (Top) (2nd) Ring Groove Side Clearance (Top) (2nd)	Keystone/ 1.2 × 2.6 mm (0.047 × 0.102 in) Plain (With expander)/ 1.5 × 2.15 mm (0.059 × 0.085 in) 0.30 ~ 0.45 mm (0.012 ~ 0.018 in) 0.35 ~ 0.50 mm (0.014 ~ 0.020 in) 0.02 ~ 0.06 mm (0.0008 ~ 0.0024 in) 0.03 ~ 0.07 mm (0.0012 ~ 0.0028 in)
Crankshaft: Crankshaft Assembly Width (F) (A) Crankshaft Deflection Limit (S) Connecting Rod Big End Side Clearance (D) Connecting Rod Small End Deflection (P) <Limit>	54.00 $^{+0}_{-0.05}$ mm (2.13 $^{+0}_{-0.002}$ in) 156 $^{+0.05}_{-0.10}$ mm (6.14 $^{+0.002}_{-0.004}$ in) 0.05 mm (0.002 in) 0.25 ~ 0.75 mm (0.01 ~ 0.03 in) 0.36 ~ 0.98 mm (0.0142 ~ 0.0386 in) 2.0 mm (0.08 in)
Clutch: Friction Plate Thickness/ Quantity <Wear Limit>	3.0 mm (0.12 in) × 7 2.7 mm (0.106 in)



SPECIFICATIONS

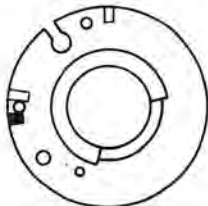
APPX



Model	RD350/350F
Clutch Plate Thickness/ Quantity <Warpage Limit> Clutch Spring Free Length/ Quantity Clutch Housing Thrust Clearance Radial Clearance Clutch Release Method Push Rod Bending Limit Primary Reduction Gear Back Lash Tolerance Primary Drive Gear Back Lash Number Primary Driven Gear Back Lash Number	1.2 mm (0.047 in) × 6 0.05 mm (0.002 in) 36.4 mm (1.43 in) × 6 0.07 ~ 0.12 mm (0.003 ~ 0.005 in) 0.011 ~ 0.048 mm (0.0004 ~ 0.0019 in) Inner push, Cam push 0.2 mm (0.008 in) 154 ~ 156 90 ~ 98 57 ~ 65
Transmission: Main Axle Deflection Limit Drive Axle Deflection Limit	0.08 mm (0.0031 in) 0.08 mm (0.0031 in)
Shifter: Type Guide Bar Bending Limit	Cam drum 0.025 mm (0.001 in)
Kick Starter: Type Kick Clip Friction Force 	Kick and mesh type P = 0.8 ~ 1.3 kg (1.8 ~ 2.9 lb)
Air Filter — Oil Grade	Foam-Air-Filter Oil or SAE 10W30 SE motor oil
Reed Valve: Material Bending Limit Valve Stopper Height 	SUS 0.5 mm (0.02 in) 10.3 ± 0.2 mm (0.41 ± 0.008 in)
Carburetor: Type/ Manufacturer/ Quantity I.D. Mark Main Jet (M.J.) Air Jet (A.J.) Jet Needle - Clip Position (J.N.) Needle Jet (N.J.) Cutaway (C.A.) Pilot Jet (P.J.) Air Screw (Turns Out)(A.S.) Starter Jet (G.S.) Float Height (F.H.) Engine Idling Speed	VM26SS/MIKUNI/2 31K00 #240 ø0.7 5K1-4 P-0 (345) 2.0 #22.5 1 and 1/4 #80 21 ± 0.5 mm (0.83 ± 0.02 in) 1,200 ± 50 r/min



SPECIFICATIONS

Model	RD350/350F
Lubrication: Autolube Pump Color Code Minimum Stroke Maximum Stroke Minimum Output/ 200 Stroke Maximum Output Pulley Adjusting Position (Adjusting Mark) 	Yellow 0.10 ~ 0.15 mm (0.004 ~ 0.006 in) 2.05 ~ 2.27 mm (0.08 ~ 0.09 in) 0.12 ~ 0.19 cm ³ (0.004 ~ 0.007 Imp oz, 0.004 ~ 0.006 US oz) 2.58 ~ 2.85 cm ³ (0.091 ~ 0.101 Imp oz, 0.087 ~ 0.096 US oz) At idle
Cooling: Radiator Core Size Width Height Thickness Radiator Cap Opening Pressure Coolant Capacity (Total) Water Pump Type Reduction Ratio	290.6 mm (11.44 in) 180 mm (7.08 in) 16 mm (0.63 in) 89.3 ± 14.7 kPa (0.9 ± 0.15 kg/cm ² , 12.8 ± 2.13 psi) 1.5 L (1.32 Imp qt, 1.59 US qt) Single-suction centrifugal pump 32/20 (1.60)
Thermostat: Opening Temperature Full Open Temperature/ Lift	71° ± 2°C (156 ± 35.6°F) 85°C (185°F)/7 mm (0.28 in)

SPECIFICATIONS

APPX



Tightening torque

Part	Thread size	Nm	m • kg	ft • lb	Remarks
Cylinder head	M 8×1.25	28	2.8	20	
Cylinder	M 8×1.25	25	2.5	18	
Spark plug	M14×1.25	20	2.0	14	
Y.P.V.S. Valve	M 5×0.8	6	0.6	4.3	
Pulley	M 6×1.0	10	1.0	7.2	
Shift pedal	M 6×1.0	16	1.6	11	
Reed valve	M 3×0.5	1	0.1	0.7	
Joint cover (Thermostatic valve)	M 6×1.0	12	1.2	8	
Housing cover	M 6×1.0	8	0.8	5.8	
Radiator cover	M 5×0.8	3	0.3	2	
Joint (Cylinder head)	M 6×1.0	12	1.2	8	
Thermosenser	M10	14	1.4	10	
Oil pump	M 5×0.8	5	0.5	3.6	
Reed valve assembly	M 6×1.0	15	1.5	11	
Primary drive gear	M16×1.0	65	6.5	47	
Clutch boss	M20×1.0	90	9.0	65	
Clutch spring	M 6×1.0	10	1.0	7.2	
Drive sprocket	M18×1.0	80	8.0	58	
Kick crank	M 8×1.25	25	2.5	18	
Shift pedal	M 6×1.0	16	1.6	11	
Flywheel magneto	M12×1.25	85	8.5	61	
Exhaust pipe	M 8×1.25	18	1.8	13	
Drain plug (Transmission)	M14×1.5	20	2.0	14	
(Coolant)	M 6×1.0	14	1.4	10	
Crankcase cover (R)	M 6×1.0	10	1.0	7.2	
(L)	M 6×1.0	7	0.7	5.1	
Crankcase (Lower)	M 8×1.25	15	1.5	10	
(Upper)	M 8×1.25	10	1.0	7.2	
Bearing cover plate	M 6×1.8	10	1.0	7.2	
Tachometer stopper plate	M 5×0.8	5	0.5	3.6	
Shift cam stopper plate	M 6×1.0	10	1.0	7	
Stopper lever	M 6×1.0	14	1.4	10	
Neutral switch	M 5×0.8	4	0.4	2.9	
Shift lever adjust screw	M 8×1.25	30	3.0	22	



SPECIFICATIONS

Chassis

Model	RD350/ 350F
Steering System: Steering Bearing Type No. / Size of Balls Upper Lower Lock to Lock Angle	Ball bearing 19 pcs. 1/4 in 19 pcs. 1/4 in 80°
Front Suspension: Front Fork Travel Front Fork Spring Free Length Spring Rate Oil Capacity Oil Level Oil Grade Air Pressure (STD) (Min. ~ Max.)	140 mm (5.51 in) 429.6 mm (16.9 in) $K_1 = 3.33 \text{ N/mm}$ (0.34 kg/mm, 19.0 lb/in) 0 ~ 140 mm (0 ~ 5.51 in) 297 cm ³ (10.48 Imp oz, 10.04 US oz) 106.1 mm (4.18 in) Fork oil 10wt or equivalent 39 kPa (0.4 kg/cm ² , 5.7 psi) 0 ~ 118 kPa (0 ~ 1.2 kg/cm ² , 0 ~ 17 psi)
Rear Suspension: Shock Absorber Travel Rear Wheel Travel Rear Absorber Spring Free Length Spring Rate Gas Properties Gas Pressure	40 mm (1.57 in) 100 mm (3.94 in) 186 mm (7.32 in) $K_1 = 103.0 \text{ N/mm}$ (10.5 kg/mm, 588 lb/in) 0 ~ 40 mm (0 ~ 1.57 in) Nitrogen gas 1,177 kPa (12 kg/cm ² , 171 psi)
Rear Arm: Swing Arm Free Play End Side	 1 mm (0.04 in) 0.1 ~ 0.3 mm (0.004 ~ 0.012 in)
Wheel: Type Rim Size/Material (Front) Rim Size/Material (Rear) Rim Run Out Limit Vertical Lateral	Cast wheel MT2.15 × 18/ Aluminum MT2.50 × 18/ Aluminum 1 mm (0.04 in) 0.5 mm (0.02 in)
Drive Chain: Type/ Manufacturer Number of Links Chain Slack	520V-SR/ DAIDO 106 30 ~ 40 mm (1.18 ~ 1.57 in)

SPECIFICATIONS

APPX



Model		RD350/350F
Disc Brake:		
Type		
Front		Dual
Rear		Single
Disc Size-Outside Dia × Thickness		267 × 5 mm (10.5 × 0.19 in)
Disc Wear Limit		4.5 mm (0.18 in)
Pad Thickness		5.5 mm (0.22 in)
Pad Wear Limit		0.5 mm (0.02 in)
Master Cylinder Inside Diameter	Front	15.87 mm (0.62 in)
	Rear	12.70 mm (0.51 in)
Caliper Cylinder Inside Diameter	Front	38.18 mm (1.5 in)
	Rear	38.18 mm (1.5 in)
Brake Fluid Type		DOT#3

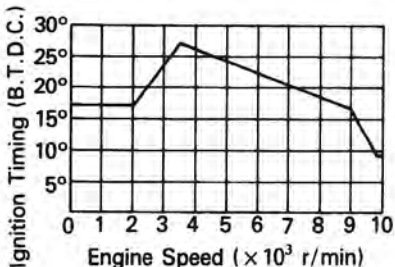
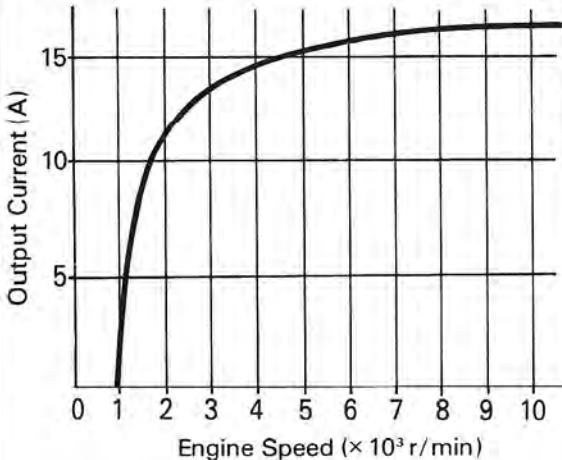
Tightening torque

Part	Thread size	Nm	m • kg	ft • lb
Engine mounting bolt	M10 × 1.25	64	6.4	46
Engine mount stay	M 8 × 1.25	23	2.3	17
Tension rod	M 8 × 1.25	25	2.5	18
Handle crown -Steering shaft	M14 × 1.25	85	8.5	61
-Inner tube	M 8 × 1.25	20	2.0	14
Handle bar -Inner tube	M 8 × 1.25	20	2.0	14
Handle bar -Handle crown	M 6 × 1.0	9	0.9	6.5
Under bracket -Inner tube	M 8 × 1.25	20	2.0	14
Fork brace	M 6 × 1.0	10	1.0	7.2
Front wheel axle	M12 × 1.25	75	7.5	54
Pivot shaft	M14 × 1.5	90	9.0	65
Rear wheel axle	M14 × 1.5	105	10.5	75
Sprocket wheel	M 8 × 1.25	32	3.2	23
Rear shock -Frame	M10 × 1.25	40	4.0	29
Relay arm -Frame	M10 × 1.25	40	4.0	29
Relay arm -Arm 1, 2	M14 × 1.5	65	6.5	47
Arm 1, 2 -Swing arm	M12 × 1.25	40	4.0	29
Brake disc -Hub	M 8 × 1.25	20	2.0	14
Master cylinder	M10 × 1.25	10	1.0	7.2
Brake hose	M10 × 1.25	26	2.6	19
Retaining bolt	M 6 × 1.0	20	2.0	14
Caliper -Bracket	M10 × 1.25	35	3.5	25
-Bleed screw	M 7 × 1.0	5	0.5	3.6
Frame -Muffler bracket	M10 × 1.25	64	6.4	46
Muffler bracket -Footrest	M10 × 1.25	64	6.4	46



SPECIFICATIONS

Electrical

Model	RD350/ 350F
Ignition System: Ignition Timing: (B.T.D.C.) Advanced Timing: (B.T.D.C.) 	17° at 1,200 r/min 27° at 3,500 r/min
CDI: CDI Unit-Model/ Manufacturer Pickup Coil Resistance (Color) Source Coil Resistance (Color)	51L/NIPPONDENSO 117Ω ± 20% (White/ Red — White/ Green) 113Ω ± 20% (Brown — Green) 4.1Ω ± 20% (Brown — Red)
Ignition Coil: Model/ Manufacturer Minimum Spark Gap Primary Winding Resistance Secondary Winding Resistance	12900-027/ NIPPONDENSO 6 mm (0.24 in) 0.33Ω ± 10% at 20°C (68°F) 3.5kΩ ± 20% at 20°C (68°F)
Spark Plug: Type/ Manufacturer	BR8ES/ N.G.K.
C.D.I. Unit: Type/ Manufacturer	52Y/ NIPPONDENSO
A.C. Generator: Model/ Manufacturer Charging Output 	51L/ NIPPONDENSO 14V14A/ 5,000 r/min
Charging Coil Resistance (Color)	0.5Ω ± 20% at 20°C (68°F) (White — White)

SPECIFICATIONS

APPX



Model	RD350/350F
Voltage Regulator: Type Model/ Manufacturer Regulating Voltage	Short circuit SH235-12C/ SHINDENGEN KOUGYOU 14.5 ± 0.5V
Rectifier: Type Model/ Manufacturer Capacity Withstand Voltage	Three phase, Full wave SH235-12C/ SHINDENGEN KOUGYOU 15A 200V
Battery: Model/ Manufacturer Charging Rate Specific Gravity	12N5.5-3B/ NIPPONDENSO 0.55A × 10 hours 1,280
Horn: Model Maximum Amperage	CF-12/ NIKKO 2.5A or less
Flasher Relay: Type Model/ Manufacturer Flasher Frequency Capacity	Semi transistor type FJ245ED/ NIPPONDENSO 85 cycle/min 12V, 21W × 2 + 3.4W
Thermo-unit: Model/ Manufacturer	YA55901NO/ NISSEI
Circuit Breaker: Type Amperage for Individual Circuit/ Quantity Main Headlight Signal Y.P.V.S. Reserve	Fuse 20A × 1 15A × 1 15A × 1 5A × 1 20A × 1, 15A × 1, 5A × 1

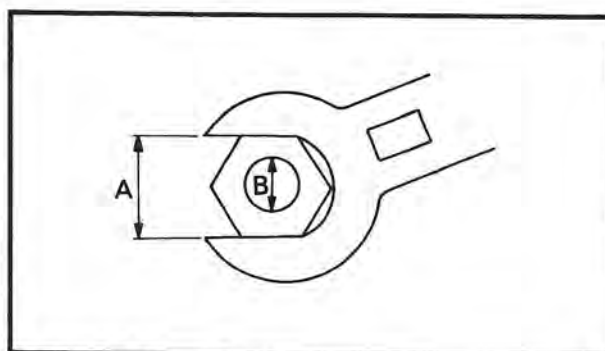


GENERAL TORQUE SPECIFICATION DEFINITION OF UNITS

GENERAL TORQUE SPECIFICATIONS

This chart specifies torque for standard fasteners with standard I.S.O. pitch threads. Torque specifications for special components or assemblies are included in the applicable sections of this book. To avoid warpage, tighten multi-fastener assemblies in a crisscross fashion, in progressive stages, until full torque is reached. Unless otherwise specified, torque specifications call for clean, dry threads. Components should be at room temperature.

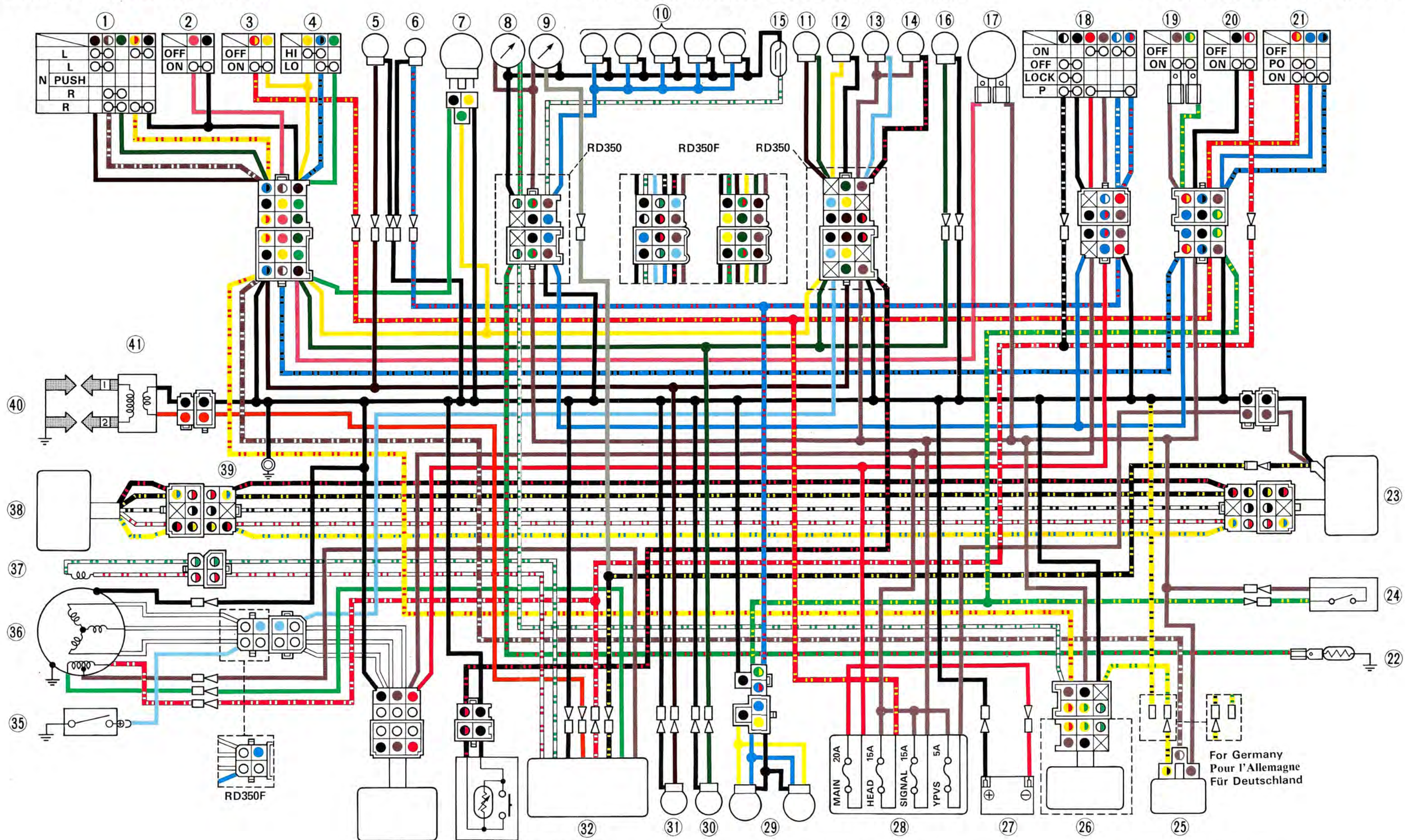
A (Nut)	B (Bolt)	General torque specifications		
		Nm	m•kg	ft•lb
10 mm	6 mm	6	0.6	4.3
12 mm	8 mm	15	1.5	11
14 mm	10 mm	30	3.0	22
17 mm	12 mm	55	5.5	40
19 mm	14 mm	85	8.5	61
22 mm	16 mm	130	13.0	94



A: Distance cross flats
B: Outside thread diameter

DEFINITION OF UNITS

Unit	Read	Definition	Measure
mm cm	millimeter centimeter	10^{-3} meter 10^{-2} meter	Length Length
kg	kilogram	10^3 gram	Weight
N	Newton	$1 \text{ kg} \times \text{m}/\text{sec}^2$	Force
Nm m • kg	Newton meter Meter kilogram	$\text{N} \times \text{m}$ $\text{m} \times \text{kg}$	Torque Torque
Pa N/mm	Pascal Newton per millimeter	N/m^2 N/mm	Pressure Spring rate
L cm^3	Liter Cubic centimeter	—	Volume or Capacity
r/min	Rotation per minute	—	Engine Speed



COLOR CODE				CODE DE COULEUR				FARBENKODIERUNG			
	Brown Brun Braun		Yellow Jaune Gelb		Blue Bleu Blau		Gray Gris Grau		Green/Red Vert/Rouge Grün/Rot		Yellow/Red Jaune/Rouge Gelb/Rot
	Red Rouge Rot		Dark Green Vert Foncé Dunkelgrün		Pink Rose Rosa		Black/White Noir/Blanc Schwarz/Weiß		Brown/White Brun/Blanc Braun/Weiß		White/Red Blanc/Rouge Weiß/Rot
	White Blanc Weiß		Chocolate Chocolat Schokoladenfarbe		Orange Orange Orange		Red/Yellow Rouge/Jaune Rot/Gelb		Yellow/Blue Jaune/Bleu Gelb/Blau		Blue/Red Bleu/Rouge Blau/Rot
	Black Noir Schwarz		Sky Blue Bleu Ciel Himmelblau		Green Vert Grün		White/Green Blanc/Vert Weiß/Grün		Green/Yellow Vert/Jaune Grün/Gelb		Black/Yellow Noir/Jaune Schwarz/Gelb
									Blue/Black Bleu/Noir Blau/Schwarz		Yellow/Black Jaune/Noir Gelb/Schwarz

1. "TURN" switch	21. "LIGHTS" switch	1. Commutateur de clignotant "TURN"	21. Contacteur d'éclairage "LIGHTS"	1. Blinklichtschalter	21. Lichtschalter „LIGHTS“
2. "HORN" switch	22. Thermo unit	2. Contacteur d'avertisseur "HORN"	22. Sonde thermique	2. Signalhornknopf „HORN“	22. Thermo-Einheit
3. "PASS" switch	23. YPVS control unit	3. Commutateur de dépassement "PASS"	23. Bloc de commande du YPVS	3. Lichtkupenschalter „PASS“	23. YPVS-Steuerung
4. "LIGHTS" (Dimmer) switch	24. Rear brake switch	4. Commutateur de feu de croisement "LIGHTS" (Dimmer)	24. Contacteur arrière du feu stop	4. Lichtschalter „LIGHTS“ (Dimmer)	24. Hinterrad-Bremslichtschalter
5. Front flasher light (L)	25. Flasher relay	5. Clignoteur avant (G)	25. Relais des clignotants	5. Vorderes Blinklicht (L)	25. Blinkerrelais
6. Auxiliary light	26. Canacelling unit (Except Germany)	6. Témoin auxiliaire	26. Unité d'arrêt (Excepté l'Allemagne)	6. Nummernschildbeleuchtung	26. Blinker-Abschaltautomatik (Außer Deutschland)
7. Headlight	27. Battery	7. Phare	27. Batterie	7. Scheinwerfer	27. Batterie
8. Temperature gauge	28. Fuse box	8. Indicateur de température	28. Bloc de fusibles	8. Temperaturmesser	28. Sicherungskasten
9. Tachometer	29. Tail/brake light	9. Compte-tours	29. Feu arrière/stop	9. Drehzahlmesser	29. Schulß/Bremsleuchte
10. Meter light	30. Rear flasher light (R)	10. Lampe de compteur	30. Clignoteur arrière (D)	10. Instrumenten-Kontrollampe	30. Hinteres Blinklicht (R)
11. "TURN" indicator light	31. Rear flasher light (L)	11. Témoin de clignotant "TURN"	31. Clignoteur arrière (G)	11. Blinkerkontrollampe „TURN“	31. Hinteres Blinklicht (L)
12. "HIGH BEAM" indicator light	32. CDI unit	12. Lampe-témoin de feu de route "HIGH BEAM"	32. Bloc CDI	12. Fernlicht-Kontrollampe „HIGH BEAM“	32. CDI-Zündeinheit
13. "NEUTRAL" indicator light	33. Oil level switch	13. Lampe-témoin de point mort "NEUTRAL"	33. Contacteur de niveau d'huile	13. Leerlauf-Kontrollampe „NEUTRAL“	33. Ölstandschalter
14. "OIL" warning indicator	34. Rectifier/Regulator	14. Lampe d'avertissement de niveau d'huile "OIL"	34. Redresseur/Régulateur	14. „Öl“-Warnanzeige	34. Gleichrichter/Spannungsregler
15. Reed switch	35. Neutral switch	15. Commutateur à lame	35. Contacteur de point mort	15. Herkonrelais	35. Leerlaufschalter
16. Front flasher light (R)	36. CDI magneto	16. Clignoteur avant (D)	36. Magnéto	16. Vorderes Blinklicht (R)	36. Magnetzünder
17. Horn	37. Pickup coil	17. Avertisseur	37. Bobine d'excitation	17. Hupe	37. Aufnahmespule
18. Main switch	38. Servomotor	18. Contacteur à clé	38. Servomoteur	18. Hauptschalter	38. Servomotor
19. Front brake switch	39. Frame earth	19. Contacteurs avant du feu stop	39. Masse	19. Vorderrad-Bremslichtschalter	39. Masse
20. "ENGINE STOP" switch	40. Spark plug	20. Interrupteur de sécurité "ENGINE STOP"	40. Bougie	20. Motorstoppschalter „ENGINE STOP“	40. Zündkerze
	41. Ignition coil		41. Bobine d'allumage		41. Zündspule



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