

AMF

# Harley-Davidson

PARTS CATALOG

1980

XR-750

1972  
&  
1975  
1977

ISSUED: MARCH 1980

No. 99442-72RD

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### PATENT NOTICE

Harley-Davidson products are manufactured under one or more of the following: U.S. Patents — 2986162, 2987934, 2998809, 3116089, 3144631, 3144860, 3226994, 3229792, 3434887, 3559773, 3673359, 3680403, 3683716, 3709317, Des. 225 626.

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AMF HARLEY-DAVIDSON MOTOR CO., INC.  
Milwaukee, Wisconsin 53201

RETAIL PRICE	INDEX NO.	PART NO.	N A M E.	USED ON
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## ENGINE GASKETS, SEALS AND O-RINGS

XR1

	11100		O-RING, tappet guide (4)	72 to * — XR
	11103		O-RING, clutch gear	72 to * — XR
	11110		O-RING, rocker arm shaft (4)	72 to * — XR
	11115		O-RING, rocker arm shaft (4)	72 to * — XR
	12023		OIL SEAL, push rod cover (8)	72 to * — XR
	16774—72R		GASKET, cylinder base (2)	72 to * — XR
	18071—72R		VALVE SEAL (4)	72 to * — XR
	24821—74R		GASKET, sump	75 to * — XR
	25224—52A		GASKET, gearcase cover	72 to * — XR
	25535—74R		SEAL, pinion shaft — gear cover	75 to * — XR
	26227—58		OIL SEAL, oil pump (2 — 1975 & later)	72 to * — XR
	26256—72R		GASKET, oil pump inner cover	72 to * — XR
	26258—52		GASKET, oil pump outer cover	72 to * — XR
	26259—72R		GASKET, oil pump to crankcase	72 to * — XR
	27015—72R		INSULATOR, carburetor manifold to cylinder head (2)	72 to * — XR
	29550—55A		GASKET, magneto cover	72 to * — XR
	29550—56R		GASKET, magneto to adapter plate	72 to * — XR
	29602—56R		GASKET, adapter plate to crankcase	72 to * — XR
	32522—37		GASKET, tachometer drive assembly mounting	72 to * — XR
	34035—52		OIL SEAL, shifter shaft	72 to * — XR
	34952—52		GASKET, front chain cover	72 to * — XR
	35150—52		OIL SEAL AND RETAINER, mainshaft	72 to * — XR
	35169—52		GASKET, mainshaft oil seal	72 to * — XR
	37531—56B		OIL SEAL, clutch gear	72 to * — XR
	37740—57		OIL SEAL, sprocket	72 to * — XR
	37762—52		GASKET, clutch cover	72 to * — XR
	60567—36		GASKET, chain hole cover	72 to * — XR
	67142—52		GASKET, valve adjusting plug (4)	72 to * — XR
	83162—51		SEAL, left crankshaft bearing collar (use with 24777-69RA)	75 to * — XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
<b>CYLINDERS, ROCKER ARMS, VALVES AND GASKETS</b>				
				<b>XR2</b>
	3206B		SET SCREW, rocker arm shaft, No. 8-32 x 3/16 socket hd. (4)	72 to * — XR
	3946		BOLT, engine upper mounting — rear, 7/16-20 x 2 hex. hd.	72 to * — XR
	3960W		BOLT, engine upper mounting — front, 5/16-24 x 1 hex. hd.	72 to * — XR
	4017		BOLT, tappet guide, 5/16-18 hex. hd. (4)	72 to * — XR
	4080		BOLT, rocker arm cover, 5/16-18 x 2-3/4 (4)	72 to * — XR
	4086		BOLT, rocker arm cover, 5/16-18 x 3 hex. hd. (4)	72 to * — XR
	4392		BOLT, rocker arm cover, 5/16-18 x 3-1/4 hex. hd. (10)	72 to * — XR
	5986		SPACER, engine upper mounting	72 to * — XR
	6316W		WASHER, rocker arm cover bolt, 5/16 x 5/8 x 1/16 (18)	72 to * — XR
	6470R		WASHER, cylinder head to cylinder, 7/16 x 15/16 x 3/16 (8)	72 to * — XR
	6486HW		WASHER, engine upper mounting, 7/16 x 13/16 x 3/32	72 to * — XR
			rocker shaft, 7/16 x 13/16 x 3/32 (8)	75 to * — XR
	6495HW		WASHER, engine upper mounting — rear, 7/16 x 15/16 x 1/8	77 to * — XR
	6524W		WASHER, engine upper mounting — rear, 7/16 x 1-1/8 x 1/32 (as required)	77 to * — XR
	6702		WASHER, engine upper mounting — front, 5/16 x 11/16 x 1/16 (2)	72 to * — XR
	7039		LOCKWASHER, engine upper mounting — rear, 7/16	77 to * — XR
	7725		LOCKNUT, engine upper mounting — front, 5/16-24 x 11/32 x 1/2 hex.	72 to * — XR
	7837W		NUT, rocker shaft, 7/16-20 x 3/8 x 11/16 hex. (4)	75 to * — XR
	10013		HOSE CLAMP, 11/16" dia. (7)	72 to * — XR
	11100		O-RING, tappet guide (4)	72 to * — XR
	11110		O-RING, rocker arm shaft (4)	75 to * — XR
	11115		O-RING, rocker arm shaft (4)	72 to * — XR
	12023		OIL SEAL, push rod cover (8)	72 to * — XR
	16250—74R		MOUNT, rocker cover — front	75 to * — XR
	16251—72R		MOUNTING BRACKET, center (between cylinders)	72 to * — XR
	16472—72R		FRONT CYLINDER	72 to * — XR
	16474—72R		REAR CYLINDER	72 to * — XR
	16563—72R		LINER, cylinder (2)	72 to * — XR
	16602—30		NUT, cylinder head stud (8)	72 to * — XR
	16679—79R		CYLINDER HEAD KIT, front (unported)	72 to * — XR
			Includes besides cylinder head:	
			18052—72R INSERT, exhaust	
			18056—72R INSERT, intake	
			18170—72R VALVE GUIDE, intake	
			18170—78R VALVE GUIDE, exhaust	
	16680—79R		CYLINDER HEAD KIT, rear (unported)	72 to * — XR
			Includes besides cylinder head:	
			18052—72R INSERT, exhaust	
			18056—72R INSERT, intake	
			18170—72R VALVE GUIDE, intake	
			18179—78R VALVE GUIDE, exhaust	
	16682—72R		FRONT CYLINDER HEAD, ported & polished	72 to * — XR
	16684—72R		REAR CYLINDER HEAD, ported & polished	72 to * — XR
	16571—77R		GASKET SHIM, cylinder base, .010" thick aluminum (brown) (2)	72 to * — XR
	16572—77R		GASKET SHIM, cylinder base, .015" thick aluminum (pink) (2)	72 to * — XR
	16774—72R		GASKET, cylinder base (2)	72 to * — XR
	16818—72R		SHIM, lower valve spring collar — .015" thick	72 to * — XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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## CYLINDERS, ROCKER ARMS, VALVES AND GASKETS — CONT'D.

XR2-1

17402—79R	ROCKER ARM, rear intake	72 to *	XR
17403—79R	ROCKER ARM, rear exhaust	72 to *	XR
17404—79R	ROCKER ARM, front intake	72 to *	XR
17405—79R	ROCKER ARM, front exhaust	72 to *	XR
17435—74R	SHAFT, rocker arm (4)	75 to *	XR
17436—74R	SPACER, rocker shaft (4)	75 to *	XR
17451—72R	SHIM, rocker shaft (.007)	72 to *	XR
17452—72R	SHIM, rocker shaft (.015)	72 to *	XR
17453—72R	SHIM, rocker shaft (.036)	72 to *	XR
17514—74R	COVER, rocker arm — front	75 to *	XR
17515—74R	COVER, rocker arm — rear	75 to *	XR
17905—72RA	PUSH ROD, 9.64" long	72 to 78	XR
17907—72RA	PUSH ROD, 9.58" long	72 to 78	XR
17909—72RB	PUSH ROD, 9.70" long (2 - 1980 & later)	72 to *	XR
17915—79R	PUSH ROD, 9.50" long (2 - 1980 & later)	72 to *	XR
17935—74R	COVER, push rod (4)	75 to *	XR
17951—72R	PLUG, valve adjusting (4)	72 to *	XR
18052—72R	INSERT, exhaust valve seat (2)	72 to *	XR
18053—72R	INSERT, exhaust valve seat, .020" O.S. (2)	72 to *	XR
18054—72R	INSERT, exhaust valve seat, .040" O.S. (2)	72 to *	XR
18056—72R	INSERT, intake valve seat (2)	72 to *	XR
18059—72R	INSERT, intake valve seat, .020" O.S. (2)	72 to *	XR
18060—72R	INSERT, intake valve seat, .040" O.S. (2)	72 to *	XR
18068—74R	INTAKE VALVE, 44 mm. (2)	72 to *	XR
18069—72R	INTAKE VALVE, 42 mm. (2)	72 to *	XR
18071—72R	VALVE SEAL (4)	72 to *	XR
18079—77R	EXHAUST VALVE, 35 mm. — with .003 O.S. stem (2)	72 to *	XR
18080—72R	EXHAUST VALVE, 35 mm. (2) (standard)	72 to *	XR
18081—76R	EXHAUST VALVE, 37 mm. (2)	72 to *	XR
18170—72R	VALVE GUIDE, intake (2) (standard)	72 to *	XR
18173—72R	VALVE GUIDE, intake — .002" O.S. (2)	72 to *	XR
18174—72R	VALVE GUIDE, intake — .004" O.S. (2)	72 to *	XR
18175—72R	VALVE GUIDE, intake — .006" O.S. (2)	72 to *	XR
18177—72R	VALVE GUIDE, intake — .008" O.S. (2)	72 to *	XR
18178—72R	VALVE GUIDE, intake — .010" O.S. (2)	72 to *	XR
18170—78R	VALVE GUIDE, exhaust (2) (standard)	72 to *	XR
18173—78R	VALVE GUIDE, exhaust — .002" O.S. (2)	72 to *	XR
18174—78R	VALVE GUIDE, exhaust — .004" O.S. (2)	72 to *	XR
18175—78R	VALVE GUIDE, exhaust — .006" O.S. (2)	72 to *	XR
18177—78R	VALVE GUIDE, exhaust — .008" O.S. (2)	72 to *	XR
18178—78R	VALVE GUIDE, exhaust — .010" O.S. (2)	72 to *	XR
18200—79R	VALVE SPRING, unit (4)	79 to *	XR
18203—57A	VALVE SPRING (4)	72 to 78	XR
18204—57A	VALVE SPRING (4)	72 to 78	XR
18216—66RA	VALVE, collar and key set (4)	72 to 78	XR
18216—79R	VALVE COLLAR, with key (4)	79 to *	XR
18220—72R	COLLAR, valve spring lower (4)	72 to 78	XR
18220—79R	COLLAR, valve spring lower (4)	79 to *	XR
18241—67R	SHIM, inner valve spring — .007" thick	72 to 78	XR
18242—67R	SHIM, inner valve spring — .0149" thick	72 to 78	XR
18243—67R	SHIM, inner valve spring — .0359" thick	72 to 78	XR
18245—67R	SHIM, outer valve spring — .007" thick	72 to 78	XR
18246—67R	SHIM, outer valve spring — .0149" thick	72 to 78	XR
18247—67R	SHIM, outer valve spring — .0359" thick	72 to *	XR
18508—72R	TAPPET ASSEMBLY (4)	72 to *	XR

**NOTE:** Asterisk (\*) indicates part is used for latest model year shown on cover.

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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### CYLINDERS, ROCKER ARMS, VALVE AND GASKETS (CONT'D)

XR2-2

18534-29A	TAPPET ROLLER KIT (4)	72 to * - XR
18607-74R	TAPPET GUIDE (4)	72 to * - XR
24824-67	STUD (4)	72 to 78 - XR
26338-68	ELBOW, oil return hose (2)	72 to * - XR
63533-41	FITTING, 3/8" oil hose (steel) (4)	72 to * - XR
63541-74R	FITTING, 3/8" oil hose (aluminum) (4)	72 to * - XR
63580-66A	TEE, rocker arm cover to oil cooler line	72 to * - XR
67142-52	GASKET, valve adjusting plug (4)	72 to * - XR

### PISTONS AND RINGS

XR3

22244-72RA	PISTON AND RINGS SET, standard	72 to * - XR
	The above piston and rings set is available in the following oversizes:	
	22245-72RA .010" O.S.	
	22246-72RA .020" O.S.	
	22247-72RA .030" O.S.	
	22248-72RA .040" O.S.	
22528-74R	PISTON RING SET, standard (pkg. = 2 sets)	72 to * - XR
	The above ring set is available in the following oversizes:	
	22529-74R .010" O.S.	
	22530-74R .020" O.S.	
	22531-74R .030" O.S.	
	22532-74R .040" O.S.	
22719-72RA	PISTON PIN - 0.024" longer (2)	72 to * - XR
22720-76RA	PISTON PIN, standard (2)	72 to * - XR
24702-72R	RETAINING RING, piston pin (4)	72 to * - XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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## FLYWHEELS, SHAFTS AND CONNECTING RODS

XR4

9481R			ROLLER, crankpin, 5/16 x .308 — standard (28) . . . . .	72 to * — XR
			The above roller is available in the following oversizes:	
		9482R	.0002" O.S.	
		9483R	.0004" O.S.	
		9484R	.0006" O.S.	
		9485R	.0008" O.S.	
		9486R	.0010" O.S.	
		9487R	.0015" O.S.	
9501R			ROLLER, crankpin, 5/16 x 416 — standard (14) . . . . .	72 to * — XR
			The above roller is available in the following oversizes:	
		9502R	.0002" O.S.	
		9503R	.0004" O.S.	
		9504R	.0006" O.S.	
		9505R	.0008" O.S.	
		9506R	.0010" O.S.	
		9507R	.0015" O.S.	
		9508R	.0020" O.S.	
23704—72R			SET OF FLYWHEELS, with shafts and rods . . . . .	72 to * — XR
23754—72RB			FLYWHEEL, right (balanced) . . . . .	72 to * — XR
23755—72RB			FLYWHEEL, left (balanced) . . . . .	72 to * — XR
23960—72RA			CRANKPIN . . . . .	72 to * — XR
23963—77RA			PLUG, for crankpin 23960—72RA . . . . .	72 to * — XR
24011—67R			PINION GEAR . . . . .	72 to * — XR
24280—74R			CONNECTING ROD SET, includes: front and rear rod, crankpin, roller set and crankpin plugs . . . . .	72 to * — XR
24331—36			BUSHING, piston pin — standard (2) . . . . .	72 to * — XR
24332—36			BUSHING, piston pin — .010" O.S. (2) . . . . .	72 to * — XR
24363—55RA			RETAINER, rear (2) . . . . .	72 to * — XR
24365—55RA			RETAINER, front (2) . . . . .	72 to * — XR
24370—55R			ROLLER SET, with retainers — standard . . . . .	72 to * — XR
			The above roller set is available in the following oversizes:	
		24371—55R	.0002" O.S.	
		24372—55R	.0004" O.S.	
		24373—55R	.0006" O.S.	
		24374—55R	.0008" O.S.	
		24375—55R	.0010" O.S.	
		24376—55R	.0015" O.S.	
		24377—55R	.0020" O.S.	
24777—69RA			SPACER, bearing — left (use with seal, 83162—51) . . . . .	72 to * — XR
35367—72RA			THRUST WASHER, sprocket shaft — .105 . . . . .	72 to * — XR
35368—72RA			THRUST WASHER, sprocket shaft — .110 . . . . .	72 to * — XR
35369—72RA			THRUST WASHER, sprocket shaft — .115 . . . . .	72 to * — XR
35370—72RA			THRUST WASHER, sprocket shaft — .120 . . . . .	72 to * — XR
35374—72RA			THRUST WASHER, gear shaft — .045 . . . . .	72 to * — XR
35375—72RA			THRUST WASHER, gear shaft — .050 . . . . .	72 to * — XR
35376—72RA			THRUST WASHER, gear shaft — .055 . . . . .	72 to * — XR
35377—72RA			THRUST WASHER, gear shaft — .060 . . . . .	72 to * — XR
35409—74R			THRUST WASHER, pinion shaft . . . . .	75 to * — XR
83162—51			SEAL, bearing spacer — left side . . . . .	75 to * — XR
96680—72R			SPACING COLLAR, flywheel side play in crankcase (2) . . . . .	72 to * — XR

NOTE: Asterisk (\*) indicates part is used for latest model year shown on cover.

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
			<b>CRANKCASE</b>	<b>XR5</b>
		333	PIN, oil strainer	72 & 75 — XR
		358	DOWEL PIN, crankcase (2)	72 to * — XR
		375	DOWEL PIN, right crankcase (4)	72 to * — XR
		707	DRAIN PLUG (1)	75 to * — XR
		720	PLUG, timing hole	72 to * — XR
		1791R	SCREW, engine mount — rear, 3/8-16 x 2-3/4 socket hd. (3)	75 to * — XR
		2269W	SCREW, chain hole cover, No. 12-24 x 1/2 oval ctsk. hd. (2)	72 to * — XR
		2851	BOLT, front chain adjuster, 3/8-16 x 7/8 hex. hd. (2)	72 to * — XR
		2879W	BOLT, engine upper - rear, 3/8-16 x 1 hex. hd. (4)	72 to * — XR
		2881W	BOLT, oil pump mounting, 1/4-20 x 2 hex. hd. (5)	75 to * — XR
		2882W	BOLT, shift lever stop, 5/16-19 x 5/8 hex. hd. (2)	72 to * — XR
		3441	SCREW, primary chain cover (9)	79 to * — XR
		3720	BOLT, chain cover - oil level, 1/4-28 x 7/16 hex. hd.	72 to * — XR
		3945	BOLT, engine rear mounting - lower, 3/8-24 x 2-1/4 hex. hd. (2)	72 to * — XR
		4067	BOLT, right crankcase, 5/16-18 x 4-7/16 hex. hd.	72 to * — XR
		4068	BOLT, right crankcase, 5/16-18 x 2-3/8 hex. hd. (3)	72 to * — XR
		4100HW	BOLT, right crankcase, 5/16-18 x 4-1/16 hex. hd.	72 to * — XR
		4336W	BOLT, engine rear mounting — upper, 3/8-24 x 1-1/8 hex. hd. (1)	75 to * — XR
		4380W	BOLT, engine rear mounting — upper, 3/8-24 x 2 hex. hd. (1)	75 to * — XR
		6220W	WASHER, chain cover — oil level bolt, 1/4 x 7/16 x 1/32	72 to * — XR
		6236B	WASHER, primary chain cover (9)	79 to * — XR
		6316W	WASHER, crankcase upper center stud and front bolt 5/16 x 5/8 x 1/16 (2)	72 to * — XR
		6703	WASHER, chain cover screw, 1/4 x 5/8 x 1/16 (9)	75 to 78 — XR
		7036	LOCKWASHER, oil pump mounting (5) 72 to 78 — XR; chain cover screw, 1/4 (9)	75 to * — XR
		7038	LOCKWASHER, engine rear mounting — upper and lower, 3/8 (4)	72 to * — XR
		7041	LOCKWASHER, shift lever stop bolt, 5/16 (2)	72 to * — XR
		7753	NUT, crankcase upper center stud, 5/16-24 x 1/4 x 1/2 hex. (2)	72 to * — XR
		7775	LOCKNUT, engine front and rear mounting 3/8-24 (7)	72 to * — XR
		9028R	BEARING, cam gear shaft (3)	72 to * — XR
		9044R	ROLLER BEARING, sprocket and gear shaft (2)	72 to * — XR
		16201—58A	MOUNT, engine — rear	72 to * — XR
		16212—59R	ENGINE FRONT MOUNTING PLATE (aluminum) (2)	72 to * — XR
		16218—52	WASHER, engine front mount (8)	72 to * — XR
		16230—59R	SPACER, engine front mounting (aluminum) (2)	72 to * — XR
		16236—52	BOLT, engine front mount, 5-7/16 lg. (2)	72 to * — XR
		16237—57	BOLT, engine front mount, 6-13/16 lg. (2)	72 to * — XR
		16830—72R	STUD, cylinder to crankcase, 8-1/4 lg. (8)	72 to * — XR
		17454—72R	SCREW, primary chain cover, 1/4-20 x 5/8 socket hd. (9)	75 to 78 — XR
		24221—51	NEEDLE BEARING, cam shaft (4)	75 to * — XR

### CRANKCASE (CONT'D)

XR5-1

24512-74R	SET OF CRANKCASES .....	75 to * - XR
	NOTE: In order to use 24512-74R on 1972 engines, the following parts must be ordered separately:	
2664	SCREW, windage tray, No. 10-24 x 7/16 Pozidriv pan hd. (2)	
2825W	SCREW, sump, 1/4-20 x 1 socket hd. (2)	
6218W	WASHER, sump screw, 1/4 x 7/16 x 1/32 brass (4)	
6716	WASHER, windage tray, No. 10 x 1/2 x 3/64 (2)	
7069	LOCKWASHER, windage tray, No. 10 (2)	
24221-51	NEEDLE BEARING, cam (4)	
24821-74R	GASKET, oil sump	
24996-74R	SUMP	
24998-74R	WINDAGE TRAY, oil sump (baffle)	
24999-74R	SCREW, oil sump, 1/4-20 x 2-3/4 socket hd. (2)	
26217-74R	BODY, oil pump	
26227-58	SEAL, oil pump (2)	
26241-74R	COVER, oil pump top (tower)	
26331-74R	GEAR, oil pump tower	
35409-74R	THRUST WASHER, pinion shaft	
35412-74R	SHIM, cam (.075)	
35413-74R	SHIM, cam (.070)	
35414-74R	SHIM, cam (.065)	
35415-74R	SHIM, cam (.060)	
35416-74R	SHIM, cam (.055)	
35417-74R	SHIM, cam (.050)	
35418-74R	SHIM, cam (.045)	
63533-41	FITTING, 3/8" oil hose (steel)	
63540-62	FITTING, oil hose - 45° (2)	
63541-74R	FITTING, 3/8" oil hose (aluminum)	
63780-75R	FITTING, oil sump - with screen	
24572-79R	CAM, #3	
25474-79R	CAM, #1	
25522-79R	CAM, #2	
25524-79R	CAM, #4	
	NOTE: Old cams may be used if modified and the following 4 new shafts are ordered:	
25518-74R	CAM SHAFT (3)	
25519-74R	CAM SHAFT	
24702-52R	RETAINING RING, sprocket and gear shaft main bearing (2) .....	75 to * - XR
24810-57	STUD, crankcase upper - center .....	72 to * - XR
24975-37	OIL STRAINER .....	72 & 75 - XR
34037-52	BUSHING, shift shaft .....	72 to * - XR
34844-57B	ACCESS DOOR, transmission .....	72 to * - XR
34949-64	FRONT CHAIN COVER, complete .....	72 to * - XR
34952-52	GASKET, front chain cover .....	72 to * - XR
60567-36	GASKET, chain hole cover .....	72 to * - XR
60570-64	COVER, chain hole .....	72 to * - XR
62702-52	WASHER, drain plug (2) (1 - 1975 & later) .....	72 to * - XR
63533-41	FITTING, 3/8" oil hose (steel) .....	72 to * - XR
63541-74R	FITTING, 3/8" oil hose (aluminum) .....	72 to * - XR
63540-62	ELBOW, oil feed and return line (2) .....	72 to * - XR
63578-52	FITTING, vent line .....	72 to * - XR

NOTE: Asterisk (\*) indicates part is used for latest model year shown on cover.

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
<b>SUMP</b>				<b>XR6</b>
	2664		SCREW, sump windage tray, No. 10-24 x 7/16 Pozidriv pan hd. (2)	75 to * — XR
	2825W		SCREW, sump, 1/4-20 x 1 socket hd. (2)	75 to * — XR
	6218W		WASHER, sump mounting, 1/4 x 7/16 x 1/32 brass (4)	75 to * — XR
	6716		WASHER, sump windage tray, No. 10 x 1/2 x 3/64 (2)	75 to * — XR
	7069		LOCKWASHER, sump windage tray, No. 10 (2)	75 to * — XR
	10020		CLAMP, hose (2)	72 to * — XR
	24821-74R		GASKET, oil sump	75 to * — XR
	24996-74R		SUMP	75 to * — XR
	24998-74R		WINDAGE TRAY, oil sump (baffle)	75 to * — XR
	24999-74R		SCREW, sump mounting, 1/4-20 x 2-3/4 socket hd. (2)	75 to * — XR
	63540-62		FITTING, 45° elbow (2)	75 to * — XR
	63780-75R		FITTING, sump — with screen	75 to * — XR

<b>GEARCASE AND GEARS</b>				<b>XR7</b>
	1793R		SCREW, gearcase cover, 1/4-20 x 2-1/4 socket hd. (3)	75 to * — XR
	1794		SCREW, gearcase cover, 1/4-20 x 2-1/2 socket hd.	75 to * — XR
	1795		SCREW, gearcase cover, 1/4-20 x 3 socket hd. (2)	75 to * — XR
	1796R		SCREW, gearcase cover, 1/4-20 x 1-1/4 socket hd. (3)	75 to * — XR
	1797R		SCREW, gearcase cover 1/4-20 x 2 socket hd. (2)	75 to * — XR
	9017		BALL BEARING, #2 cam — outer	75 to * — XR
	9028R		BALL BEARING, cam gear shaft — cover (3)	72 to * — XR
	10006		STRAP, gearcase breather hose (3)	72 to * — XR
	11070R		RETAINING RING, #2 cam bearing	75 to * — XR
	24221-51		NEEDLE BEARING, cam shaft (4)	75 to * — XR
	24937-72R		FITTING, gearcase breather hose	72 to * — XR
	25200-74R		COVER, gearcase	75 to * — XR
	25224-52A		GASKET, gearcase cover	72 to * — XR
	25234-53R		RESTRICTOR PLUG, gearcase cover	72 to * — XR
	25472-79R		CAM ASSEMBLY, No. 3J — front intake (43-57-1/2)	75 to * — XR
	25474-79R		CAM ASSEMBLY, No. 1J — rear intake (43-57-1/2)	75 to * — XR
	25522-79R		CAM ASSEMBLY, No. 2J — rear exhaust (67-1/2-29)	75 to * — XR
	25524-79R		CAM ASSEMBLY, No. 4J — front exhaust (67-1/2-29)	75 to * — XR
	25518-74R		SHAFT, cam gear (#1, #3, #4)	75 to * — XR
	25519-74R		SHAFT, cam gear (#2)	75 to * — XR
	25535-74R		SEAL, pinion shaft — gear cover	75 to * — XR
	25592-74R		NEEDLE BEARING, pinion shaft	75 to * — XR
	26479-62PB		HOSE, gearcase breather	72 to * — XR
	29615-39R		COVER, tachometer shaft hole	72 to * — XR
	34037-52		BUSHING, shift shaft	72 to * — XR
	35412-74R		SHIM, cam (.075)	75 to * — XR
	35413-74R		SHIM, cam (.070)	75 to * — XR
	35414-74R		SHIM, cam (.065)	75 to * — XR
	35415-74R		SHIM, cam (.060)	75 to * — XR
	35416-74R		SHIM, cam (.055)	75 to * — XR
	35417-74R		SHIM, cam (.050)	75 to * — XR
	35418-74R		SHIM, cam (.045)	72 to * — XR

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
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### OIL PUMP

XR9

2881W			BOLT, oil pump mounting, 1/4-20 x 2 hex. hd. (5)	75 to * — XR
7036			LOCKWASHER, oil pump mounting, 1/4 (5)	72 to * — XR
26203-74R			OIL PUMP ASSEMBLY	75 to * — XR
		603	PIN	
		8866	BALL BEARING, check valve	
		26217-74R	BODY, oil pump	
		26227-58	OIL SEAL (2)	
		26241-74R	COVER, inner — tower	
		26250-56	COVER, outer	
		26256-72R	GASKET, inner cover	
		26258-52	GASKET, outer cover	
		26317-72A	IDLER GEAR, scavenger	
		26320-72R	DRIVE GEAR, scavenger	
		26322-52A	IDLER GEAR, pressure	
		26323-52A	DRIVE GEAR, pressure	
		26327-52	IDLER SHAFT	
		26331-74R	DRIVEN GEAR, oil pump — tower	
		26340-36	KEY, breather valve gear	
		26341-37	WASHER, split — scavenger gear (2)	
		26364-57	SPRING, check valve	
		26420-74R	END PLUG, check valve	
		63533-41	FITTING, 3/8" oil hose (steel)	
26259-72R			GASKET, oil pump to crankcase	72 to * — XR
26318-54R			DRIVE GEAR, oil pump	72 to * — XR

### CARBURETOR AND AIR FILTER

XR10

2851			BOLT, 3/8-16 x 7/8 hex hd. manifold mounting (4)	79 to * — XR
6388HB			WASHER, intake manifold mounting, 3/8 x 11/16 x 1/16	72 to 78 — XR
7775			LOCKNUT, intake manifold mounting, 3/8-24 x 7/16 x 9/16 hex. (4)	72 to 78 — XR
7038			LOCKWASHER, intake manifold mounting, 3/8 (4)	79 to * — XR
9955			CLAMP, carburetor mounting (4)	72 to * — XR
9956			CLAMP, air filter (2)	72 to * — XR
27015-72R			INSULATOR, carburetor manifold to cylinder head (2)	72 to * — XR
27033-72RA			INTAKE MANIFOLD, front (steel)	72 to 78 — XR
27033-72RB			INTAKE MANIFOLD, front	79 to * — XR
27036-72RA			INTAKE MANIFOLD, rear (steel)	72 to 78 — XR
27036-72RB			INTAKE MANIFOLD, rear	79 to * — XR
27060-72R			CONNECTOR, carburetor to manifold (2)	72 to 78 — XR
27060-72RA			CONNECTOR, carburetor to manifold (2)	79 to * — XR
27161-72R			CARBURETOR, with velocity stack (2)	72 to * — XR
27163-72R			VELOCITY STACK, carburetor (2)	72 to * — XR
27168-72R			SPRING, air screw (idle mixture)	72 to * — XR
27169-72R			SPRING, starting plunger	72 to * — XR
27170-72R			SPRING, idle speed screw	72 to * — XR
27171-72R			SPRING, throttle side	72 to * — XR
27173-72R			ARM, float	72 to * — XR
27174-72R			STARTING PLUNGER, complete	72 to * — XR
27175-72R			THREADED CAP, starting plunger	72 to * — XR
27176-72R			RUBBER CAP, cable adjuster	72 to * — XR
27177-72R			CAP, float guide pin (2)	72 to * — XR
27178-72R			RUBBER CAP, starting plunger	72 to * — XR

**NOTE:** Asterisk (\*) indicates part is used for latest model year shown on cover.

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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**CARBURETOR AND AIR FILTER (CONT'D)**

**XR10-1**

27179-72R	PLATE, throttle spring	72 to * - XR
27180-72R	BAFFLE PLATE, float	72 to * - XR
27182-72R	CLIP, needle jet	72 to * - XR
27184-72R	CAP, throttle slide	72 to * - XR
27185-72R	GASKET, float bowl (2)	72 to * - XR
27187-72R	NEEDLE VALVE AND SEAT, complete	72 to * - XR
27188-72R	GASKET, needle valve	72 to * - XR
27189-72R	PIN, float arm	72 to * - XR
27207-72R	WASHER, float bowl plug	72 to * - XR
27208-72R	SCREW WITH LOCKWASHER, float bowl (4)	72 to * - XR
27209-72R	AIR SCREW (idle mixture)	72 to * - XR
27210-72R	PLUG, float bowl	72 to * - XR
27211-72R	WASHER, main jet	72 to * - XR
27212-72R	SCREW, idle speed	72 to * - XR
27213-72R	FLOAT (2)	72 to * - XR
27224-72R	CLIP, starting plunger	72 to * - XR
29028-72R	AIR FILTER (2)	72 to * - XR
27186-72R	NEEDLE, No. 6DPI	72 to * - XR
27186-74R	NEEDLE, No. 6F5 (standard)	72 to * - XR
27219-72R	NEEDLE, No. 7H2	72 to * - XR
27190-72R	THROTTLE SLIDE, No. 1.0	72 to * - XR
27183-72R	THROTTLE SLIDE, No. 2.0 (standard)	72 to * - XR
27192-72R	THROTTLE SLIDE, No. 2.5	72 to * - XR
27193-72R	THROTTLE SLIDE, No. 3.0	72 to * - XR
27194-72R	THROTTLE SLIDE, No. 3.5	72 to * - XR
27167-72R	NEEDLE JET, No. 159-P2	72 to * - XR
27195-72R	NEEDLE JET, No. 159-P4 (standard)	72 to * - XR
27196-72R	NEEDLE JET, No. 159-P8	72 to * - XR
27166-72R	PILOT JET, No. 25 (standard)	72 to * - XR
27198-72R	PILOT JET, No. 30	72 to * - XR
27199-72R	PILOT JET, No. 35	72 to * - XR
27200-72R	PILOT JET, No. 40	72 to * - XR
27523-72R	PILOT JET, No. 45	72 to * - XR
27524-72R	PILOT JET, No. 50	72 to * - XR
27528-72R	PILOT JET, No. 55	72 to * - XR
27526-72R	PILOT JET, No. 60	72 to * - XR
27527-72R	PILOT JET, No. 65	72 to * - XR
27528-72R	PILOT JET, No. 70	72 to * - XR
27529-72R	PILOT JET, No. 75	72 to * - XR
27530-72R	PILOT JET, No. 80	72 to * - XR
27201-72R	MAIN JET, No. 180	72 to * - XR
27202-72R	MAIN JET, No. 185	72 to * - XR
27203-72R	MAIN JET, No. 190	72 to * - XR
27204-72R	MAIN JET, No. 195	72 to * - XR
27214-72R	MAIN JET, No. 200	72 to * - XR
27215-72R	MAIN JET, No. 210	72 to * - XR
27216-72R	MAIN JET, No. 220	72 to * - XR
27217-72R	MAIN JET, No. 230	72 to * - XR
27228-72R	MAIN JET, No. 240 (standard)	72 to * - XR
27229-72R	MAIN JET, No. 250	72 to * - XR
27230-72R	MAIN JET, No. 260	72 to * - XR
27231-72R	MAIN JET, No. 270	72 to * - XR
27232-72R	MAIN JET, No. 281	72 to * - XR

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
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### CARBURETOR AND AIR FILTER (CONT'D)

XR10-2

	27531-72R	AIR JET, No. 0.5	72 to * - XR
	27532-72R	AIR JET, No. 0.6	72 to * - XR
	27533-72R	AIR JET, No. 0.7	72 to * - XR
	27534-72R	AIR JET, No. 0.8	72 to * - XR
	27535-72R	AIR JET, No. 0.9	72 to * - XR
	27181-72R	AIR JET, No. 1.0 (standard)	72 to * - XR
	27536-72R	AIR JET, No. 1.1	72 to * - XR
	27537-72R	AIR JET, No. 1.2	72 to * - XR
	27538-72R	AIR JET, No. 1.3	72 to * - XR
	27539-72R	AIR JET, No. 1.4	72 to * - XR
	27540-72R	AIR JET, No. 1.5	72 to * - XR

### MAGNETO

XR11

NOTE: All parts having an asterisk (\*) fit late style single fire magneto 29502-72RA.

1957R	SCREW, 5/16-18 x 3/4 flat ctsk. hd., adapter plate to crankcase (2)	72 to * - XR
3974HW	BOLT, 5/16-24 x 3/4 hex. hd. (2)	72 to * - XR
6701	WASHER, 3/8 x 13/16 x 1/16	72 to * - XR
6702	WASHER, 5/16 x 11/16 x 1/16 (2)	72 to * - XR
7010	LOCKWASHER, No. 6	72 to * - XR
7015	LOCKWASHER, No. 8	72 to * - XR
7038	LOCKWASHER, 3/8	72 to * - XR
7041	LOCKWASHER, 5/16 (2)	72 to * - XR
7783	NUT, 3/8-16 x 9/16 x 5/16 hex.	72 to * - XR
9007	BEARING, 3rd bearing, magnetic rotor	72 to * - XR
9028R	BALL BEARING, intermediate gear assy. (2)	72 to * - XR
10006	CABLE STRAP, spark plug wires	72 to * - XR
29502-72RA	MAGNETO, only - with bearing (SINGLE FIRE)	72 to * - XR
29524-55A	COIL	72 & 75 - XR
29530-55A	COVER	72 & 75 - XR
29530-77R	COVER ASSEMBLY	77 to * - XR
29531-55	SCREW, magneto cover (4)	72 & 75 - XR
29531-77R	SCREW, magneto cover (4)	77 to * - XR
29532-77R	ROTOR (magnetic)	77 to * - XR
29511-69	TUNE UP KIT	72 to * - XR
	Consists of:	
	MAGNETO BREAKER POINTS	
	MAGNETO CONDENSER	
29533-77R	COIL	77 to * - XR
29534-77R	BRUSH WITH SPRING	77 to * - XR
29535-77R	ROTOR, plastic distributor	77 to * - XR
29536-56R	ROTOR (magnetic)	72 & 74 - XR
29536-77R	CLAMP, condensor (2)	77 to * - XR
29537-77R	DOWEL PIN, cover (2)	77 to * - XR
29550-55A	GASKET, magneto cover	72 to * - XR
29550-56R	GASKET, magneto to adapter plate	72 to * - XR
29561-55	BEARING SUPPORT	72 to * - XR
29562-55	BEARING, rotor cam end	72 to * - XR
29563-55	BEARING, rotor shaft end	72 to * - XR

NOTE: Asterisk (\*) indicates part is used for latest model year shown on cover.

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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### MAGNETO (CONT'D)

XR11-1

	29564-55A	WASHER, rotor grease retainer, shaft end	72 to *	XR
	29568-65	WASHER, bearing shield — .015" thick	72 to *	XR
	29600-56R	ADAPTER PLATE	72 to *	XR
	29602-56R	GASKET, adapter plate to crankcase	72 to *	XR
	29620-55	SPRING CLIP, breaker arm	72 to *	XR
	29621-55	RETAINING RING, rotor shaft end	72 to *	XR
	29622-55A	SPRING CLIP, rotor shaft end	72 to *	XR
	29624-55	WASHER, rotor shaft end	72 to *	XR
	29630-55	SEAL, rotor shaft end	72 to *	XR
	29632-55	SCREW, condenser mounting	72 to *	XR
	29633-55	SCREW AND WASHER, breaker arm (2)	72 to *	XR
	29634-55	SCREW AND WASHER, breaker arm contact	72 to *	XR
	29636-55	SET SCREW, coil (2)	72 to *	XR
	29645-62	BUSHING, ground terminal	72 to *	XR
	29660-62	NUT, ground terminal (3)	72 to *	XR
	29675-74R	GEAR, magneto drive	75 to *	XR
	29691-50R	SCREW, intermediate gear stud (2)	72 to *	XR
	29694-56R	SPACER, magneto intermediate gear stud	72 to *	XR
	29697-56R	INTERMEDIATE GEAR ASSEMBLY	72 to *	XR
	9976	CLIP, spark plug cables to frame (2)	72 & 75	XR
	31607-64	RUBBER CAP, spark plug cable (2)	72 & 74	XR
	31620-47	TERMINAL, spark plug cable (2)	72 & 74	XR
	31960-77R	CABLE, spark plug — front cylinder	72 to *	XR
	31965-64RA	CONDENSER, w/clamp	72 to *	XR
	29692-56R	STUD, magneto intermediate gear (replaced by the following:)		
	29692-78R	FLANGE, intermediate gear	72 to *	XR
	29693-78R	SHAFT, intermediate gear	72 to *	XR

### TRANSMISSION

XR12

	612	ROLL PIN, sprocket cover, 3/32 x 3/4	72 to *	XR
	2660	SCREW, mainshaft oil seal retainer, No. 10-24 x 3/8		
		Pozidriv pan hd. (4)	75 to *	XR
	3991	BOLT, transmission access door, 5/16-18 x 7/8 hex. hd. (4)	72 to *	XR
	7025W	LOCKWASHER, mainshaft oil seal retainer, No. 10 (4)	72 to *	XR
	9025	BALL BEARING, clutch gear	72 to *	XR
	9030R	BALL BEARING, mainshaft	72 to *	XR
	11103	O-RING, clutch gear	72 to *	XR
	24578-57	DOWEL PIN, access door (2)	72 to *	XR
	34844-57B	ACCESS DOOR, transmission	72 to *	XR
	34872-57A	SPROCKET COVER, complete	72 to *	XR
	34890-52	BOLT, sprocket cover — upper	72 to *	XR
	34891-52	BOLT, sprocket cover — lower	72 to *	XR
	35047-53	NUT, mainshaft	72 to *	XR
	35050-52	LOCKWASHER, mainshaft	72 to *	XR
	35112-52	RETAINING RING, mainshaft ball bearing (2)	72 to *	XR
	35150-52	OIL SEAL AND RETAINER, mainshaft	72 to *	XR
	35169-52	GASKET, mainshaft oil seal	72 to *	XR
	35787-72	BUSHING, low gear	72 to *	XR

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
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**TRANSMISSION (CONT'D)**

**XR12-1**

	35960-54		NEEDLE BEARING, countershaft (closed end)	72 to * - XR
	35961-52		NEEDLE BEARING, clutch gear & countershaft - left (access door) (2)	72 to * - XR
	37458-52		BUSHING, clutch gear	72 to * - XR
	37531-56B		OIL SEAL, clutch gear	72 to * - XR
	35343-73		THRUSTWASHER, mainshaft - right (.030")	72 to * - XR
	35344-73		THRUSTWASHER, mainshaft - right (.040")	72 to * - XR
	35349-52		THRUSTWASHER, mainshaft - right (.050")	72 to * - XR
	35350-52		THRUSTWASHER, mainshaft - right (.055")	72 to * - XR
	35351-52		THRUSTWASHER, mainshaft - right (.060")	72 to * - XR
	35352-52		THRUSTWASHER, mainshaft - right (.065")	72 to * - XR
	35353-52		THRUSTWASHER, mainshaft - right (.070")	72 to * - XR
	35354-52		THRUSTWASHER, mainshaft - right (.075")	72 to * - XR
	35326-73		THRUSTWASHER, mainshaft - right (.080")	72 to * - XR
	35355-72		THRUSTWASHER, mainshaft - right (.085")	72 to * - XR
	35361-56		THRUSTWASHER, mainshaft - left (pressed into clutch gear)	72 to * - XR
	35364-56		WASHER, mainshaft third gear	72 to * - XR
	35337-56		RETAINING RING, mainshaft third gear	72 to * - XR
	35818-72		THRUSTWASHER, countershaft - low gear - right (.020")	72 to * - XR
	35327-73		THRUSTWASHER, countershaft - low gear - right (.025")	72 to * - XR
	35819-72		THRUSTWASHER, countershaft - low gear - right (.030")	72 to * - XR
	35328-73		THRUSTWASHER, countershaft - low gear - right (.035")	72 to * - XR
	35821-72		THRUSTWASHER, countershaft - low gear - right (.040")	72 to * - XR
	35329-73		THRUSTWASHER, countershaft - low gear - right (.045")	72 to * - XR
	35820-52		THRUSTWASHER, countershaft - low gear - right (.050")	72 to * - XR
	35821-52		THRUSTWASHER, countershaft - low gear - right (.055")	72 to * - XR
	35824-52		THRUSTWASHER, countershaft - low gear - right (.060")	72 to * - XR
	35825-52		THRUSTWASHER, countershaft - low gear - right (.065")	72 to * - XR
	35828-52		THRUSTWASHER, countershaft - low gear - right (.070")	72 to * - XR
	35829-52		THRUSTWASHER, countershaft - low gear - right (.075")	72 to * - XR
	35840-52		THRUSTWASHER, countershaft - low gear - left (.065")	72 to * - XR
	35836-55		THRUSTWASHER, countershaft - low gear - left (.075")	72 to * - XR
	35838-55		THRUSTWASHER, countershaft - low gear - left (.085")	72 to * - XR
	35839-55		THRUSTWASHER, countershaft - low gear - left (.100")	72 to * - XR
	35841-58		THRUSTWASHER, second gear	72 to * - XR
	35809-58		SPACER, countershaft drive gear	72 to * - XR
	35044-72R		MAINSHAFT	72 to * - XR
	35277-61R		LOW GEAR, mainshaft - 26T	72 to * - XR
	35277-52A		LOW GEAR, mainshaft - 27T	72 to * - XR
	35277-54R		LOW GEAR, mainshaft - 28T	72 to * - XR
	35296-56		SECOND GEAR, mainshaft - 23T. (use with 35750-58)	72 to * - XR
	35296-56R		SECOND GEAR, mainshaft - 23T. (use with 35750-58R)	72 to * - XR
	35305-56		THIRD GEAR, mainshaft - 20 T. (use with 35709-54A)	72 to * - XR
	35312-66R		THIRD GEAR, mainshaft - 20T. (use with 35712-66R)	72 to * - XR
	37449-56		CLUTCH GEAR - 17 T. (use with 35695-58)	72 to * - XR
	37450-60R		CLUTCH GEAR - 18 T. (use with 35695-60R)	72 to * - XR
	37450-61R		CLUTCH GEAR - 19 T. (use with 35695-60R)	72 to * - XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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**SHIFTER**

**XR13**

350			PIN, pawl lifter arm (2)	72 to * - XR
4410			BOLT, shift lever to shaft, 1/4-28 x 7/8 hex. hd.	77 to * - XR
4621			BOLT, shifter cam, 7/16-14 x 1-1/8 hex. hd.	72 to * - XR
7036			LOCKWASHER, shift lever to shaft bolt, 1/4	72 to * - XR
7041			LOCKWASHER, shift lever rubber, 5/16	72 to * - XR
7753			NUT, shifter lever rubber, 5/16-24 x 1/4 x 1/2 hex.	72 to * - XR
9260			PIN, cam support (2)	72 to * - XR
11036			RETAINING RING, shifter pawls (2)	72 to * - XR
16825-48			PLUG, shifter shaft	72 to * - XR
34009-75			SHIFTER CAM ASSEMBLY	72 to * - XR
34016-77			SHIFTER CAM KIT	72 to * - XR
			Consists of:	
		34012-75	SHIFTER CAM, only	
		34494-74B	PAWL CARRIER	
		34514-75	PAWL CARRIER SUPPORT	
		35336-74	THRUSTWASHER, shifter cam	
34035-52			OIL SEAL, shifter shaft	72 to * - XR
34037-52			BUSHING, gear shaft shifter	72 to * - XR
34040-52			RETAINING RING, shifter cam	72 to * - XR
34060-52			THRUSTWASHER, shifter cam	72 & 75 - XR
34062-52			SHIFTER CAM FOLLOWER	72 to * - XR
34065-52			RETAINER, cam follower	72 to * - XR
34067-52			LOCK, shifter cam retainer	72 to * - XR
34068-52			SPRING, shifter cam follower	72 to * - XR
34069-71			LOCK, shifter cam bolt	72 to * - XR
34141-52A			SHAFT, shifter fork	72 to * - XR
34168-52			ROLLER, shifter finger (2)	72 to * - XR
34291-52B			SHIFTER FORK (2)	72 to * - XR
34292-72			SHIFTER FORK, + .020	72 to * - XR
34293-72			SHIFTER FORK, - .020	72 to * - XR
34461-72			SPACER, shifter pawl (2)	72 to * - XR
34476-72			SHIFTER PAWL (2)	72 to * - XR
34485-52			PLUG, carrier spring retainer (2)	72 to * - XR
34494-74B			PAWL CARRIER ASSEMBLY	72 to * - XR
34500-52A			PAWL CARRIER SPRING (2)	72 to * - XR
34506-52A			PAWL LIFTER ARM, lower	72 to * - XR
34507-52A			PAWL LIFTER ARM, upper	72 to * - XR
34514-75			PAWL CARRIER SUPPORT	72 to * - XR
34600-47R			SHIFTER LEVER ASSEMBLY (splined)	72 to * - XR
34606-52R			SHIFTER LEVER, only (splined)	72 to * - XR
34609-52			SHIFTER LEVER RUBBER (with shaft)	72 to * - XR
34628-52R			SHAFT, shifter lever (splined)	72 to * - XR
35891-66			SHIM, pawl carrier support	72 to * - XR
37222-62			SPRING, shifter pawls	72 to * - XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
			<b>CLUTCH</b>	<b>XR14</b>
	2613		SCREW, clutch cover, No. 10-24 x 1/4 Pozidriv pan hd. (12)	72 to * — XR
	7220		LOCKWASHER, clutch cover screw, No. 10 external tooth (12)	72 to * — XR
	33450—70R		SHIM, clutch sprocket assembly (as req'd)	72 to * — Xf.
	37201—54		RELEASE WORM AND LEVER, clutch	72 to * — XR
	37210—47		RELEASE WORM COVER, clutch	72 to * — XR
	37222—52		SPRING, worm lever, clutch	72 to * — XR
	37276—53		RELEASE ROD, right	72 to * — XR
	37279—56		RELEASE ROD, left	72 to * — XR
	37281—47		RELEASE ROD, left center	72 to * — XR
	37282—53		RELEASE ROD, right center	72 to * — XR
	37526—56A		NUT, clutch hub	72 to * — XR
	37533—52A		LOCKWASHER, clutch hub	72 to * — XR
	37535—52		SPACER, clutch hub	72 to * — XR
	37556—52R		CLUTCH HUB ASSEMBLY, 5 plate (accessory)	72 to * — XR
	37584—52R		STUD, 5 plate clutch hub (accessory)	72 to * — XR
	37556—57B		CLUTCH HUB ASSEMBLY, 7 plate	72 to * — XR
	37559—78R		NUT, clutch stud — aluminum (6) (5 plate accessory clutch)	72 to * — XR
	38105—78R		SPRING CUP, backing plate — aluminum (6) (5 plate accessory clutch)	72 to * — XR
			NOTE: Both of the above replace all of the following:	
	37581—52		NUT, clutch hub stud (large) (3)	
	37582—52		NUT, clutch hub stud (small) (3)	
	38013—52		PRESSURE PLATE	
	38101—52		SPRING CUP, backing plate (6)	
	37581—52		NUT, clutch hub stud (large) (3)	72 to * — XR
	37582—52		NUT, clutch hub stud (small) (3)	72 to * — XR
	37584—67		STUD, clutch hub (6)	72 to * — XR
	37702—57		CLUTCH SPROCKET ASSEMBLY — 59 T. (7 plate)	72 to * — XR
	37740—57		OIL SEAL, sprocket	72 to * — XR
	37755—57		SPACER, clutch sprocket (long)	72 to * — XR
	37756—57		SPACER, clutch sprocket (short)	72 to * — XR
	37760—65R		CLUTCH COVER (aluminum)	72 to * — XR
	37762—52		GASKET, clutch cover	72 to * — XR
	37876—52		RELEASING DISC	72 to * — XR
	37985—52A		DRIVE PLATE, fiber (7)	72 to * — XR
	37992—52		DRIVEN PLATE, steel (7)	72 to * — XR
	38013—52		PRESSURE PLATE	72 to * — XR
	38016—52		BACKING PLATE	72 to * — XR
	38076—53R		CLUTCH SPRING (6)	72 to * — XR
	38101—52		SPRING CUP, backing plate (6)	72 to * — XR
	38130—54		ADJUSTING SCREW, clutch	72 to * — XR
	38135—50		LOCKNUT, adjusting screw — clutch	72 to * — XR
	38619—57A		CABLE AND COIL ASSEMBLY, clutch	72 to * — XR

IL INDEX E NO.	PART NO.	N A M E	USED ON
<b>SPROCKETS AND CHAINS</b>			<b>XR15</b>
2851		BOLT, front chain adjuster, 3/8-16 x 7/8 hex hd. (2)	72 to * — XR
6395B		WASHER, front chain adjuster, 3/8 x 13/16 x 1/16 (2)	72 to * — XR
7038		LOCKWASHER, front chain adjuster, 3/8 (2)	72 to * — XR
23985—12		KEY, motor sprocket	72 to * — XR
24003—41R		NUT, motor sprocket	72 to * — XR
39975—54A		FRONT CHAIN ADJUSTER, with lining and retainer	72 to * — XR
39978—58		LINING, chain adjuster	72 to * — XR
39979—58A		RETAINER, chain adjuster lining	72 to * — XR
40002—52R		FRONT CHAIN, for 30 T. sprocket	72 to * — XR
40005—52RA		FRONT CHAIN, for 25 T. sprocket	72 to * — XR
40008—52RA		FRONT CHAIN, for 20 T. sprocket	72 to * — XR
40028—15C		REAR CHAIN (Duckworth)	72 to * — XR
40029—15C		REAR CHAIN (Duckworth)	72 to * — XR
40049—72R		LINK AND A HALF (Duckworth)	72 to * — XR
40053—65		CONNECTING LINK, rear chain (press fit)	72 to * — XR
40094—15		DOUBLE REPAIR LINK, rear chain (Duckworth)	72 to * — XR
40228—52R		MOTOR SPROCKET — 20T.	72 to * — XR
40233—52R		MOTOR SPROCKET — 25T.	72 to * — XR
40238—52R		MOTOR SPROCKET — 30T.	72 to * — XR
40238—64R		MOTOR SPROCKET — 34T.	72 to * — XR
41198—73		BOLT, rear wheel sprocket (5)	75 to * — XR
41454—72R		REAR WHEEL SPROCKET — 36 T.	72 to * — XR
41455—72R		REAR WHEEL SPROCKET — 37 T.	72 to * — XR
41456—72R		REAR WHEEL SPROCKET — 38 T.	72 to * — XR
41457—72R		REAR WHEEL SPROCKET — 39 T.	72 to * — XR
41453—72R		REAR WHEEL SPROCKET — 40 T.	72 to * — XR
41460—72R		REAR WHEEL SPROCKET — 41 T.	72 to * — XR
41461—72R		REAR WHEEL SPROCKET — 42 T.	72 to * — XR
41472—74R		REAR WHEEL SPROCKET — 43 T.	72 to * — XR
41473—74R		REAR WHEEL SPROCKET — 44 T.	72 to * — XR
41474—74R		REAR WHEEL SPROCKET — 45 T.	72 to * — XR
41475—74R		REAR WHEEL SPROCKET — 46 T.	72 to * — XR
41488—72R		ADAPTER, rear wheel sprocket	72 to * — XR
35200—53R		TRANSMISSION SPROCKET — 15T.	72 to * — XR
35201—53R		TRANSMISSION SPROCKET — 16T.	72 to * — XR
35202—53R		TRANSMISSION SPROCKET — 17T.	72 to * — XR
35205—52RA		TRANSMISSION SPROCKET — 18T.	72 to * — XR
35197—52		TRANSMISSION SPROCKET — 19T.	72 to * — XR
35198—52		TRANSMISSION SPROCKET — 20T.	72 to * — XR
35205—52A		TRANSMISSION SPROCKET — 21T.	72 to * — XR
35205—54B		TRANSMISSION SPROCKET — 22T.	72 to * — XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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## REAR WHEEL

XR16

	7986		NUT, rear axle, 5/16-18 x 7/16 x 1 hex.	72 to * — XR
	9012		BALL BEARING (2)	72 to * — XR
	23745-47		SPRING RING, wheel bearing — left	72 to * — XR
	40977-64R		REAR WHEEL, complete, 19" (aluminum rim and hub)	72 to * — XR
	41014-64R		HUB WITH BEARINGS, complete (aluminum)	72 to * — XR
	41022-47RA		NUT, hub	72 to * — XR
	41185-56R		SPACER, between bearings	72 to * — XR
	41195-52		SPACER, wheel bearing — right	72 to * — XR
	41196-52R		SPACER, left bearing	72 to * — XR
	41201-52		LOCKNUT, wheel bearing	72 to * — XR
	41226-52		GREASE RETAINER	72 to * — XR
	41555-70R		REAR AXLE	72 to * — XR
	41599-70R		COLLAR, rear axle (under nut)	72 to * — XR
	43009-61RA		RIM, 19" (aluminum) (2.75" wide)	72 to * — XR
	43021-48R		INNER SPOKE — 19" rim (20)	72 to * — XR
	43023-48R		OUTER SPOKE — 19" rim (20)	72 to * — XR
	43097-35R		SPOKE NIPPLE (40)	72 to * — XR

## FRONT WHEEL, 19" — 1972

XR17

	6722B		WASHER, front axle, 5/8 x 1-1/8 x 3/32	72 — XR
	7980		NUT, front axle, 5/8-18 x 7/16 x 7/8 hex.	72 — XR
	9012		BALL BEARING (2)	72 — XR
	23745-47		RETAINING RING, bearing	72 — XR
	41201-52R		LOCKNUT, wheel bearing	72 — XR
	41548-70R		AXLE, front wheel	72 — XR
	41605-70R		SPACER, front axle	72 — XR
	43009-61R		RIM, 19" (aluminum) (2.16" wide)	72 — XR
	43021-48R		INNER SPOKE — 19" rim (20)	72 — XR
	43023-48R		OUTER SPOKE — 19" rim (20)	72 — XR
	43097-35R		SPOKE NIPPLE (40)	72 — XR
	43503-64RA		FRONT WHEEL, complete (19" w/disc brake hub)	72 — XR
	43505-64R		FRONT WHEEL, complete, 18" (alum. rim and hub)	72 — XR
	43609-64R		HUB WITH BEARINGS, complete (aluminum)	72 — XR
	43636-52		GREASE RETAINER	72 — XR
	43740-64		SPACER, between bearings	72 — XR

## FRONT WHEEL, 19" — 1975 & LATER

XR18

	6722B		WASHER, front axle, 5/8 x 1-1/8 x 3/32	75 to * — XR
	7980		NUT, front axle, 5/8-18 x 7/16 x 7/8 hex.	75 to * — XR
	30151-69		BALL BEARING (2)	75 to * — XR
	41548-70R		AXLE, front wheel	75 to 78 — XR
	41548-79R		AXLE, front wheel	79 to * — XR
	41605-70R		SPACER, front axle	75 to 78 — XR
	41605-79R		SPACER, front axle	79 to * — XR
	43076-78R		RIM, 19" (aluminum) (1.85" wide)	75 to * — XR
	43077-78R		SPOKE NIPPLE (40)	75 to * — XR
	43078-78R		SPOKE, 19" rim (40)	75 to * — XR
	43318-78R		HUB WITH BEARINGS, complete (aluminum)	75 to * — XR
	43319-78R		SPACER, between bearings	75 to * — XR
	43503-64RA		FRONT WHEEL, complete — 19" (w/disc brake hub)	75 to * — XR

**NOTE:** Asterisk (\*) indicates part is used for latest model year shown on cover.

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
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### FRONT FORK — 1972 TO 1978

XR19

	1794		SCREW, handlebar clamp, 1/4-20 x 2-1/2 socket hd. (4)	78 — XR
	1861P		SCREW, drain hole, 6 mm. x 10 rd. hd. (2)	72 to 78 — XR
	2838P		SCREW, upper bracket to stem, 8 mm. x 35 socket hd. (2)	72 to 78 — XR
	2839R		SCREW, lower bracket to tube, 10 mm. x 40 socket hd. (2)	72 to 78 — XR
	2842R		SCREW, upper bracket to tube, 10 mm. x 30 socket hd. (2)	72 to 78 — XR
	3811P		BOLT, handlebar clamp, 6 mm. x 60 hex. hd. (4)	72 & 75 — XR
	3968P		SCREW, lower damper hold down, 8 mm. x 20 socket hd. (2)	72 to 78 — XR
	4439P		BOLT, slider to axle, 8 mm. x 55 hex. hd. (2)	72 to 78 — XR
	4447P		BOLT, lower bracket to stem, 8 mm. x 70 hex. hd.	72 to 78 — XR
	6242W		WASHER, handlebar clamp, 1/4 x 9/16 x 1/32 (4)	78 — XR
	7028P		LOCKWASHER, handlebar clamp, 6 mm. (4)	72 & 74 — XR
	7686		LOCKNUT, handlebar clamp, 1/4-20 x 5/16 x 7/16 hex. (4)	72 to 78 — XR
	7693P		NUT, handlebar clamp, 6 mm. x 5 x 10 hex. (4)	72 & 75 — XR
	7756P		NUT, slider to axle pinch bolt and lower bracket to stem pinch bolt, 8 mm. x 6.5 x 13 hex. (3)	72 to 78 — XR
	11055P		RETAINING RING, fork slider seal (2)	72 to 78 — XR
	11061P		RETAINING RING, damper valve body (2)	72 to 78 — XR
	11062P		RETAINING RING, upper orifice return spring (2)	72 to 78 — XR
	12008P		GASKET, fork tube cap (2)	72 to 78 — XR
	34609—61P		RUBBER, fork stop (2)	72 to 78 — XR
	45489—70R		FRONT FORK (replaced by 45489—79R)	72 to 78 — XR
	45489—79R		FRONT FORK (must use 41548—79R AXLE; and 41605—79R SPACER, for installation)	72 to 78 — XR
	45530—70R		UPPER ORIFICE (2)	72 to 78 — XR
	45531—70R		LOWER ORIFICE (2)	72 to 78 — XR
	45573—70R		PLUG, fork tube (2)	72 to 78 — XR
	45574—70R		STEM, front fork	72 to 78 — XR
	45634—61P		WASHER, slider to axle & lower bracket to stem pinch bolt (5)	72 to 78 — XR
	45734—70R		FORK BRACKET, lower	72 to 78 — XR
	45739—67M		NUT, fork stem — lower (bearing adjuster)	72 to 78 — XR
	45747—70R		NUT, fork stem — upper	72 to 78 — XR
	45826—61P		GASKET, drain screw (2)	72 to 78 — XR
	45938—70R		FORK SIDE, complete — left	72 to 78 — XR
	45939—70R		FORK SIDE, complete — right	72 to 78 — XR
	45951—70R		SLIDER ASSEMBLY, complete — right	72 to 78 — XR
	45952—70R		SLIDER ASSEMBLY, complete — left	72 to 78 — XR
	46022—67M		CLAMP, fork boot (2)	72 to 78 — XR
	46044—70R		SPACER, damper valve body (2)	72 to 78 — XR
	46046—70R		WASHER, damper piston (2)	72 to 78 — XR
	46061—70R		RETURN SPRING, upper orifice (2)	72 to 78 — XR
	46063—70R		SPRING, orifice (2)	72 to 78 — XR
	46064—70R		DAMPER SPRING (2)	72 to 78 — XR
	46091—70R		FORK TUBE (2)	72 to 78 — XR
	46099—70R		DAMPER TUBE, complete (2)	72 to 78 — XR
	46102—70R		DAMPER END (2)	72 to 78 — XR
	46103—70R		DAMPER TUBE (2)	72 to 78 — XR
	46114—76R		WASHER, damper (special "S")	72 to 78 — XR
	46124—70R		SEAL, fork slider (4)	72 to 78 — XR
	46127—70R		DAMPER PISTON (2)	72 to 78 — XR
	46136—61P		GASKET, damper tube hold down screw (2)	72 to 78 — XR
	46158—70R		VALVE BODY (2)	72 to 78 — XR
	46159—70R		VAI VF (2)	72 to 78 — XR

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
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## FRONT FORK — 1979 & LATER

XR19A

45489—79R			FRONT FORK ASSEMBLY, complete	79 to * — XR
47565—74R			FORK STOPS, complete (1-pair)	79 to * — XR
48314—70			STEERING HEAD BEARING (cone & cup) (2)	79 to * — XR
48315—60			HEAD CUP, (Timken) (2)	79 to * — XR
48371—70R			DUST SHIELD, steering head bearing (2)	79 to * — XR

## FRAME AND REAR FORK

XR20

2660			SCREW, bearing locknut, No. 10-24 x 3/8 Pozidriv pan hd.	72 to * — XR
7022			LOCKWASHER, rear fork pivot bolt, 5/8	72 to * — XR
7069			LOCKWASHER, bearing locknut, No. 10	72 to * — XR
7744			NUT, rear chain adjuster, 5/16-24 x 3/16 x 1/2 hex. (2)	72 to * — XR
7753			NUT, rear chain adjuster, 5/16-24 x 1/4 x 1/2 hex. (2)	72 to * — XR
39972—72R			ADJUSTER, rear chain (2)	72 to * — XR
47565—74R			FORK STOP, complete (1-pair)	72 to * — XR
45723—70R			SPACER, steering head — upper (2 — 1975 & 1978)	72 to 78 — XR
47022—74R			FRAME	72 to * — XR
47024—70RA			REAR FORK	72 to * — XR
47511—52			PIVOT BOLT, rear fork	72 to * — XR
47518—52			BEARING SPACER, inner	72 to * — XR
47519—52			BEARING SHIELD (2)	72 to * — XR
47525—52			LOCKWASHER, rear fork pivot bearing locknut	72 to * — XR
47550—74			BEARING KIT, rear fork	72 to * — XR
			Consists of:	
		47512—74	NUT, pivot bolt	
		47514—74	LOCKNUT, left bearing	
		47515—74	LOCKNUT, right bearing	
		47517—74	BEARING SPACER, outer	
		47521—74	BEARING, rear fork (2)	
48314—70			STEERING HEAD BEARING (cone & cup) (2)	72 to * — XR
48315—60			HEAD CUP (Timken) (2)	72 to * — XR
48371—70R			DUST SHIELD, steering head bearing (2)	72 to * — XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
<b>FOOTRESTS</b>				<b>XR21</b>
	3996		BOLT, right footrest plate to sprocket cover stud, 5/16-24 x 7/8 hex. hd. ....	72 to * - XR
	4415		BOLT, left footrest plate to frame, 3/8-24 x 3 hex. hd. (2) .	72 to * - XR
	4716W		BOLT, right footrest plate to sprocket cover, 3/8-16 x 1-1/4 hex. hd. ....	72 to * - XR
	6388HB		WASHER, left footrest plate to frame, 3/8 x 11/16 x 1/16 (2) .....	72 to * - XR
	6701		WASHER, right footrest plate to sprocket cover, 3/8 x 13/16 x 1/16 .....	72 to * - XR
	6702		WASHER, right footrest plate to sprocket cover stud, 5/16 x 11/16 x 1/16 .....	72 to * - XR
	7038		LOCKWASHER, right footrest plate to sprocket cover, 3/8	72 to * - XR
	7041		LOCKWASHER, right footrest plate to sprocket cover stud, 5/16 .....	72 to * - XR
	7775		LOCKNUT, left footrest plate to frame, 3/8-24 x 7/16 x 9/16 hex. (2) .....	72 to * - XR
	34891-52		STUD, sprocket cover mounting .....	72 to * - XR
	50919-70R		SPACER, right footrest plate to sprocket cover .....	72 to * - XR
	50920-70R		SPACER, left footrest plate to frame (2) .....	72 to * - XR
	50940-52		FOOTREST RUBBER, only (2) .....	72 to * - XR
	50939-60R		FOOTREST AND RUBBER (aluminum) .....	72 to * - XR
	50978-70R		RIGHT FOOTREST, complete .....	72 to * - XR
			Consists of:	
		7725	LOCKNUT, 5/16-24	
		7775	LOCKNUT, 3/8-24	
		50939-60R	FOOTREST AND RUBBER (aluminum)	
		50970-52	BOLT, footrest pivot	
		50974-52R	STUD, footrest to support plate	
		50974-70R	SUPPORT PLATE (aluminum)	
	50979-70R		LEFT FOOTREST, complete .....	72 to * - XR
			Consists of:	
		7725	LOCKNUT, 5/16-24	
		7775	LOCKNUT, 3/8-24	
		50939-60R	FOOTREST AND RUBBER (aluminum)	
		50970-52	BOLT, footrest pivot	
		50971-60R	SUPPORT PLATE, footrest (aluminum)	
		50974-52R	STUD, footrest to support plate	
	50939-52		FOOTREST AND RUBBER (steel) .....	72 to * - XR

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
		<b>SEAT</b>		<b>XR22</b>
		3825	BOLT, seat mounting — front, 1/4-28 x 1 hex. hd. (2)	72 to * — XR
		3974HW	BOLT, seat mounting — rear, 5/16-24 x 3/4 hex. hd. (2)	72 to * — XR
		6229W	WASHER, seat mounting — rear, 5/16 x 1-1/16 x 5/8 (2)	72 to * — XR
		6703	WASHER, seat mounting — front, 1/4 x 5/8 x 1/16 (4)	72 to * — XR
		7727	LOCKNUT, seat mounting — rear, 5/16-24 x 1/4 x 1/2 hex. (2)	72 to * — XR
		52002—74R	SEAT, complete with cover (will fit 1972 with modification)	75 to * — XR
		52050—70R	SEAT COVER, only	72 to * — XR

		<b>SHOCK ABSORBER</b>		<b>XR23</b>
		4724	BOLT, shock absorber mounting, 3/8-24 x 1-1/2 hex. hd. (4)	72 to * — XR
		7776W	LOCKNUT, shock absorber mounting, 3/8-24 x 3/4 x 9/16 hex. (4)	72 to * — XR
		54510—70RA	SHOCK ABSORBER, complete (2) S & W	72 to * — XR

		<b>HANDLEBAR</b>		<b>XR24</b>
		1205	SCREW, handlebar bracket clamp, No. 10-24 x 3/8 Pozidriv fil. hd. (2)	72 to * — XR
		10006	CABLE STRAP, clutch cable	72 to * — XR
		11036	RETAINING RING, pivot pin	72 to * — XR
		38619—57A	CABLE AND COIL ASSEMBLY, clutch	72 to * — XR
		38690—55	CABLE OILER	72 to * — XR
		38705—65	BRACKET, handlebar	72 to * — XR
		45024—65A	HANDLEBAR, with pins and nylon bushings	72 to * — XR
		45030—65A	CLAMP, handlebar bracket	72 to * — XR
		45031—65	PIVOT PIN, handlebar	72 to * — XR
		45034—68	ANCHOR PIN, handlebar	72 to * — XR
		56027—70R	HANDLEBAR	72 to * — XR
		56209—74R	THROTTLE CONTROL GRIP, dual	72 to * — XR
		56222—62P	RUBBER GRIP, only — right	72 to * — XR
		56223—62P	RUBBER GRIP, only — left	72 to * — XR
		56357—74R	THROTTLE CABLE, front	72 to * — XR
		56358—74R	THROTTLE CABLE, rear	72 to * — XR
		91891—61	SPACER, handlebar and bracket (2)	72 to * — XR

		<b>CUT-OUT SWITCH</b>		<b>XR25</b>
		10006	CABLE STRAP (2)	72 to * — XR
		31997—65P	RUBBER BOOT, cut-out switch wire	72 to * — XR
		71500—63M	CUT-OUT SWITCH ASSEMBLY	72 to * — XR
		71636—63M	SCREW, cut-out switch clamp	72 to * — XR
		71642—63M	NUT, cut-out switch clamp screw	72 to * — XR
		71643—63M	SPACER, cut-out switch clamp screw (2)	72 to * — XR

RETAIL PRICE	INDEX NO.	PART NO.	NAME	USED ON
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**GAS TANK**

**XR26**

6229W			WASHER, tank mounting plate to tank, 5/16 x 1-1/16 x 1/16 (2)	72 to * — XR
7727			LOCKNUT, tank mounting plate to tank, 5/16-24 x 1/4 x 1/2 hex. (2)	72 to * — XR
10013			HOSE CLAMP (2)	72 to * — XR
60993—72R			FITTING, gas hose — straight, 1/8 P.T.F.	72 to 78 — XR
60998—70R			NAME TRANSFER, gas tank — left	72 to * — XR
60999—70R			NAME TRANSFER, gas tank — right	72 to * — XR
61011—79R			GAS TANK, only — 2-1/2 gallon	79 to * — XR
61103—36			FILLER CAP	72 to * — XR
61557—72R			STUD, gas tank mounting (2)	72 to * — XR
61571—74R			DECAL, "Harley-Davidson" — script (white)	72 to * — XR
61601—79R			VALVE, shut-off	79 to * — XR
61634—62R			PAD, between tank and frame	72 to * — XR
61636—63R			PAD, mounting plate (4)	72 to * — XR
61657—63R			MOUNTING PLATE, gas tank w/ pads	72 to 78 — XR
61657—79R			BRACKET, tank mounting	79 to * — XR
61788—68R			DECAL, 14" "Harley-Davidson" — block letters (black & white)	72 to * — XR
62762—52			RUBBER WASHER, gas tank support (2)	72 to * — XR

**OIL TANK**

**XR27**

10014			HOSE CLAMP, 1/2" dia. (2)	72 to * — XR
10020			HOSE CLAMP, 11/16" dia. (4)	72 to * — XR
26338—68			ELBOW, large dia. hose	72 to * — XR
41835—30R			SPRING, oil tank mounting (2) 3-7/16 long	72 to * — XR
53254—74			PAD, oil tank (4)	72 to * — XR
62375—57			ELBOW, small dia. hose	72 to * — XR
62499—72R			OIL TANK, only	72 to * — XR
62625—70			FILLER CAP, oil tank — with dipstick	72 to * — XR
63533—41			FITTING, 3/8" oil hose (steel)	72 to * — XR

**OIL COOLER — 1972 to 1978**

**XR28**

3952			BOLT, cooler mounting, 5/16-18 x 7/16 hex. hd. (2)	72 to 78 — XR
6702			WASHER, oil cooler mounting, 5/16 x 11/16 x 1/16 (2)	72 to 78 — XR
7041			LOCKWASHER, oil cooler mounting, 5/16 (2)	72 to 78 — XR
7739			LOCKNUT, oil cooler mounting, 5/16-18 x 11/32 x 1/2 hex. (2)	72 to 78 — XR
26440—72RA			OIL COOLER	72 to 78 — XR
50235—63			RUBBER MOUNT, oil cooler (2)	72 to 78 — XR
62696—62			ELBOW FITTING, oil cooler (2)	72 to 78 — XR
63500—68			HOSE, 3/8 I.D. x 5/8 O.D. x 25 ft. long	72 to 78 — XR
63541—74R			FITTING, 3/8" oil hose (aluminum)	72 to 78 — XR

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
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## EXHAUST SYSTEM

XR29

3960W			BOLT, exhaust pipes mounting — front, 5/16-24 x 1 hex. hd.	77 to * — XR
4014W			BOLT, exhaust pipes mounting rear, 5/16-24 x 1-1/4 (2)	79 to * — XR
4053W			BOLT, exhaust pipes mounting clamp, 5/16-24 x 2 hex. hd.	72 & 75 — XR
4391			BOLT, exhaust pipes mounting — rear, 5/16-24 x 5/8 hex. hd.	77 to 78 — XR
6229W			WASHER-SPACER, exhaust pipes mounting — rear 5/16 x 1-1/16 x 1/16 steel	79 to * — XR
6702			WASHER, exhaust pipes mounting, 5/16 x 11/16 x 1/16 (4)	77 to * — XR
7725			LOCKNUT, exhaust pipes mounting, 5/16-24 x 11/32 x 1/2 hex. (2)	72 to * — XR
10027R			CLAMP, exhaust pipes mounting	72 to * — XR
41835—57R			SPRING, exhaust pipe (2)	72 to * — XR
61135—57			SPACER, exhaust pipes mounting — rear (2)	79 to * — XR
65456—72RA			EXHAUST PIPE AND MEGAPHONE, front (1-5/8" O.D. with silencer)	72 to * — XR
65503—72RA			EXHAUST PIPE AND MEGAPHONE, rear (1-4/8" O.D. with silencer)	72 to * — XR
65526—77R			MEGAPHONE, only — rear	72 to * — XR
65533—77R			HEADER PIPE, front, 1-5/8" O.D. pipe	72 to * — XR
65534—77R			MEGAPHONE, only — front	72 to * — XR
65535—77R			MUFFLER INSERT (2)	72 to * — XR
65536—77R			MUFFLER PACKING (fiberglass) (2)	72 to * — XR
65537—77R			HEADER PIPE, rear, 1-5/8" O.D. pipe	72 to * — XR

## TACHOMETER

XR30

1300B			SCREW, tachometer drive assembly mounting, No. 12-24 x 1/2 fil. hd. (2)	72 to * — XR
7030W			LOCKWASHER, tachometer drive assembly mounting, No. 12 (2)	72 to * — XR
32522—37			GASKET, tachometer drive assembly mounting	72 to * — XR
32531—36			DRIVEN GEAR (on drive assembly), 2:1 ratio	72 & 75 — XR
32532—74R			DRIVEN GEAR (on drive assembly), 4:1 ratio	77 to * — XR
25851—37			DRIVE GEAR (on #2 cam), 2:1 ratio	72 & 75 — XR
92049—74R			DRIVE GEAR (on #2 cam) 4:1 ratio	77 to * — XR
92051—65			TACHOMETER HEAD, 2:1 ratio	72 & 75 — XR
92051—74R			TACHOMETER HEAD, 4:1 ratio	77 to * — XR
92064—72R			DRIVE ASSEMBLY, tachometer, 2:1 ratio	72 & 75 — XR
92064—74R			DRIVE ASSEMBLY, tachometer, 4:1 ratio	77 to * — XR
92067—53R			ADAPTER CAP, top of drive assembly	72 & 75 — XR
92067—74R			ADAPTER CAP, top of drive assembly, 4:1 ratio	77 to * — XR
92150—66R			DRIVE CABLE ASSEMBLY, 2:1 ratio	72 & 74 — XR
92150—74R			DRIVE CABLE ASSEMBLY, 4:1 ratio	77 to * — XR
92151—74R			INNER CABLE, only, 4:1 ratio	77 to * — XR
92152—74R			SPADE END WITH WASHER, tachometer drive	77 to * — XR

NOTE: Asterisk (\*) indicates part is used for latest model year change or cover.

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
<b>NUMBER PLATE AND NUMBERS</b>				<b>XR31</b>
	91737-60R		NUMBER PLATE, aluminum	72 to * - XR
	91740-68R		TRANSFER, numeral "0"	72 to * - XR
	91741-68R		TRANSFER, numeral "1"	72 to * - XR
	91742-68R		TRANSFER, numeral "2"	72 to * - XR
	91743-68R		TRANSFER, numeral "3"	72 to * - XR
	91744-68R		TRANSFER, numeral "4"	72 to * - XR
	91745-68R		TRANSFER, numeral "5"	72 to * - XR
	91746-68R		TRANSFER, numeral "6"	72 to * - XR
	91747-68R		TRANSFER, numeral "7"	72 to * - XR
	91748-68R		TRANSFER, numeral "8"	72 to * - XR
	91749-68R		TRANSFER, numeral "9"	72 to * - XR
<b>WHEEL WEIGHTS</b>				<b>XR32</b>
	95587-75		WHEEL WEIGHT, 1/2 oz., stick-on type	72 to * - XR
	95588-75		WHEEL WEIGHT, 1 oz., stick-on type	72 to * - XR
<b>OIL FILTER</b>				<b>XR33</b>
	63781-72R		OIL FILTER, 3/4-16 thread (Fram PH966B)	72 to * - XR
<b>REAR BRAKE</b>				<b>XR34</b>
	2894		SCREW, 1/4-20 x 3/4 ctsk. flat socket hd. (self locking)	
			(8)	72 to * - XR
	39968-72R		ADJUSTER, rear chain - left side	72 to * - XR
	41022-47RA		LOCKNUT, brake disc adapter	72 to * - XR
	41489-72R		ADAPTER, brake disc	72 to * - XR
	41717-72R		ROD END, rear brake - male thread	72 to * - XR
	41718-72R		ROD END, rear brake - female thread	72 to * - XR
	41760-76		REBUILD KIT, master cylinder	72 to * - XR
	41767-72R		MASTER CYLINDER, with "up" mounted lever	72 to * - XR
	41770-76		LEVER, master cylinder down mounted type	72 to * - XR
	41796-72R		DISC, rear	72 to * - XR
	74425-68		HOSE, poly	72 to * - XR
	74428-68		HOSE FITTING, base to male pipe thread - straight	72 to * - XR
<b>SERVICE MANUAL</b>				<b>XR35</b>
	99491-80R		SERVICE MANUAL	80 to * - XR

# COMMON HARDWARE

## SCREWS

1175	SCREW, No. 10-24 x 1/4 fil. hd.
1205	SCREW, No. 10-24 x 3/8 Pozidriv fil. hd.
1300B	SCREW, No. 12-24 x 1/2 fil. hd.
1369	SCREW, 1/4-20 x 11/16 fil. hd.
1791R	SCREW, 3/8-16 x 2-3/4 socket hd.
1793R	SCREW, 1/4-20 x 2-1/4 socket hd.
1794	SCREW, 1/4-20 x 2-1/2 socket hd.
1795	SCREW, 1/4-20 x 3 socket hd.
1796R	SCREW, 1/4-20 x 1-1/4 socket hd.
1797R	SCREW, 1/4-20 x 2 socket hd.
1861P	SCREW, 6 mm. x 10 rd. hd.
1957R	SCREW, 5/16-18 x 3/4 flat ctsk. hd.
2269W	SCREW, No. 12-24 x 1/2 oval ctsk. hd.
2353	SCREW, 1/4-20 x 2-5/16 oval hd.
2355R	SCREW, 1/4-20 x 3-1/16 oval. hd.
2613	SCREW, No. 10-24 x 1/4 Pozidriv pan hd.
2660	SCREW, No. 10-24 x 3/8 Pozidriv pan hd.
2664	SCREW, No. 10-24 x 7/16 Pozidriv pan hd.
2669W	SCREW, No. 10-24 x 3/8 rd. hd.
2672B	SCREW, No. 10-24 x 1/2 rd. hd.
2825W	SCREW, 1/4-20 x 1 socket hd.
2838R	SCREW, 8 mm. x 35 socket hd.
2839R	SCREW, 10 mm. x 40 socket hd.
2842R	SCREW, 10 mm. x 30 socket hd.
3206B	SET SCREW, No. 8-32 x 3/16 socket hd.
3789	SCREW, 1/4-20 x 3/4 socket hd.
3968P	SCREW, 8 mm. x 20 socket hd.

## BOLTS

2851	BOLT, 3/8-16 x 7/8 hex hd.
2879W	BOLT, 3/8-16 x 1 hex. hd.
2881W	BOLT, 1/4-20 x 2 hex. hd.
2882W	BOLT, 5/16-19 x 5/8 hex. hd.
3720	BOLT, 1/4-28 x 7/16 hex. hd.
3791	BOLT, 1/4-28 x 3/4 hex. hd.
3811P	BOLT, 6 mm. x 60 hex. hd.
3825	BOLT, 1/4-28 x 1 hex. hd.
3945	BOLT, 3/8-24 x 2-1/4 hex. hd.
3946	BOLT, 7/16-20 x 2 hex. hd.
3952	BOLT, 5/16-18 x 7/16 hex. hd.
3960W	BOLT, 5/16-24 x 1 hex. hd.
3974HW	BOLT, 5/16-24 x 3/4 hex. hd.
3987	BOLT, 5/16-18 x 3/4 hex. hd.
3991	BOLT, 5/16-18 x 7/8 hex. hd.
3996	BOLT, 5/16-24 x 7/8 hex. hd.
4017	BOLT, 5/16-18 hex. hd.
4053W	BOLT, 5/16-24 x 2 hex. hd.
4066	BOLT, 5/16-18 x 2-3/8 hex. hd.
4067	BOLT, 5/16-18 x 4-1/2 hex. hd.
4068	BOLT, 5/16-18 x 2-1/2 hex. hd.
4086	BOLT, 5/16-18 x 3 hex. hd.
4100HW	BOLT, 5/16-18 x 4-1/16 hex. hd.
4300	BOLT, 3/8-16 x 7/8 hex. hd.
4336W	BOLT, 3/8-24 x 1-1/8 hex. hd.
4380W	BOLT, 3/8-24 x 2 hex. hd.
4391	BOLT, 5/16-24 x 5/8 hex. hd.
4392	BOLT, 5/16-18 x 3-1/4 hex. hd.
4410	BOLT, 1/4-28 x 7/8 hex. hd.
4415	BOLT, 3/8-24 x 3 hex. hd.
4439P	BOLT, 8 mm. x 55 hex. hd.
4447P	BOLT, 8 mm. x 70 hex. hd.
4621	BOLT, 7/16-14 x 1-1/8 hex. hd.
4716W	BOLT, 3/8-16 x 1-1/4 hex. hd.
4724	BOLT, 3/8-24 x 1-1/2 hex. hd.

## WASHERS

6203B	WASHER, 1/4 x 1/2 x 1/16
6218W	WASHER, 1/4 x 7/16 x 1/32 brass
6220W	WASHER, 1/4 x 7/16 x 1/32
6229W	WASHER, 5/16 x 1-1/16 x 5/8
6242W	WASHER, 1/4 x 9/16 x 1/32
6316W	WASHER, 5/16 x 5/8 x 1/16
6388HB	WASHER, 3/8 x 11/16 x 1/16
6395B	WASHER, 3/8 x 13/16 x 1/16
6470R	WASHER, 7/16 x 15/16 x 3/16
6486HW	WASHER, 7/16 x 13/16 x 3/32
6495HW	WASHER, 7/16 x 15/16 x 1/8
6524W	WASHER, 7/16 x 1-1/8 x 1/32
6701	WASHER, 3/8 x 13/16 x 1/16
6702	WASHER, 5/16 x 11/16 x 1/16
6703	WASHER, 1/4 x 5/8 x 1/16
6716	WASHER, No. 10 x 1/2 x 3/64
6722B	WASHER, 5/8 x 1-1/8 x 3/32

## LOCKWASHERS

7010	LOCKWASHER, No. 6
7015	LOCKWASHER, No. 8
7025W	LOCKWASHER, No. 10
7028P	LOCKWASHER, 6 mm.
7030W	LOCKWASHER, No. 12
7036	LOCKWASHER, 1/4
7038	LOCKWASHER, 3/8
7039	LOCKWASHER, 7/16
7041	LOCKWASHER, 5/16
7056	LOCKWASHER, 7/16
7069	LOCKWASHER, No. 10
7072	LOCKWASHER, 5/8

## NUTS

7676	NUT, 1/4-28 x 7/32 x 7/16 hex.
7686	LOCKNUT, 1/4-20 x 5/16 x 7/16 hex.
7693P	NUT, 6 mm. x 5 x 10 hex.
7725	LOCKNUT, 5/16-24 x 11/32 x 1/2 hex.
7727	LOCKNUT, 5/16-24 x 1/4 x 1/2 hex.
7739	LOCKNUT, 5/16-18 x 11/32 x 1/2 hex.
7744	NUT, 5/16-24 x 3/16 x 1/2 hex.
7753	NUT, 5/16-24 x 1/4 x 1/2 hex.
7756P	NUT, 8 mm. x 6.5 x 13 hex.
7775	LOCKNUT, 3/8-24 x 7/16 x 9/16 hex.
7676	NUT, 1/4-28 x 7/32 x 7/16 hex.
7783	NUT, 3/8-16 x 9/16 x 5/16 hex.
7837W	NUT, 7/16-20 x 3/8 x 11/16 hex.
7980	NUT, 5/8-18 x 7/16 x 7/8 hex.
7986	NUT, 5/16-18 x 7/16 x 1 hex.

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18177-78R	3	<b>24374-55R</b>	<b>5</b>	26259-72R	9	27193-72R	10	29502-72KA	11
18178-72R	3	<b>24375-55R</b>	<b>5</b>		0	27194-72K	10	29511-69	11
18178-78R	3	24376-55R	5	26317-72A	9	27195-72R	10	29524-55A	11
18179-78K	2	24377-55K	5	26318-54K	9	27196-72K	10	29530-55A	11
18200-79R	3	24572-79R	7	26320-72R	9	27198-72K	10	29530-77K	11
18203-57A	3	24578-57	12	26322-52A	9	27199-72R	10	29531-55	11
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18216-66RA	3	24702-72K	4	26327-52	9	27201-72R	10	29532-77R	11
18216-79R	3	24777-69RA	5	26331-74R	7	27202-72K	10	29533-77R	11
18220-72K	3	24810-57	7		9	27203-72R	10	29534-77K	11
18220-79K	3	24821-74R	7	26338-68	4	27204-72K	10	29535-77R	11
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18242-67K	3		0	26340-36	9	27208-72R	10	29536-77R	11
18243-67K	3	24824-67	4	26341-37	9	27209-72R	10	29537-77R	11
18245-67K	3	24937-72K	8	26364-57	9	27210-72R	10	29550-55A	0
18246-67K	3	24975-37	7	26420-74R	9	27211-72K	10		11
18247-67R	3	24996-74K	7	26440-72KA	22	27212-72R	10	29550-56K	0
18508-72K	3		8	26479-62PB	8	27213-72K	10		11
18534-29A	4	24998-74R	7	27015-72R	9	27214-72K	10	29561-55	11
18607-74K	4		8		0	27215-72R	10	29562-55	11
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22246-72KA	4		8	27036-72KA	9	27219-72R	10	29568-65	12
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22531-74R	4	25474-79K	7	27165-72K	10	27232-72R	10	29621-55	12
22532-74R	4		8	27166-72K	10	27233-72K	10	29622-55A	12
22719-72KA	4	25518-74R	7	27167-72R	10	27234-72K	10	29624-55	12
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23704-72K	5	25519-74R	7	27169-72R	9	27250-72K	10	29632-55	12
23745-47	17		8	27170-72R	9	27251-72R	10	29633-62	12
	17	25522-79K	7	27171-72R	9	27252-72K	10	29634-55	12
23754-72RE	5		8	27173-72K	9	27253-72K	10	29636-55	12
23755-72RB	5	25524-79R	7	27174-72K	9	27523-72R	10	29645-62	12
23960-72RA	5		8	27175-72R	9	27524-72K	10	29660-62	12
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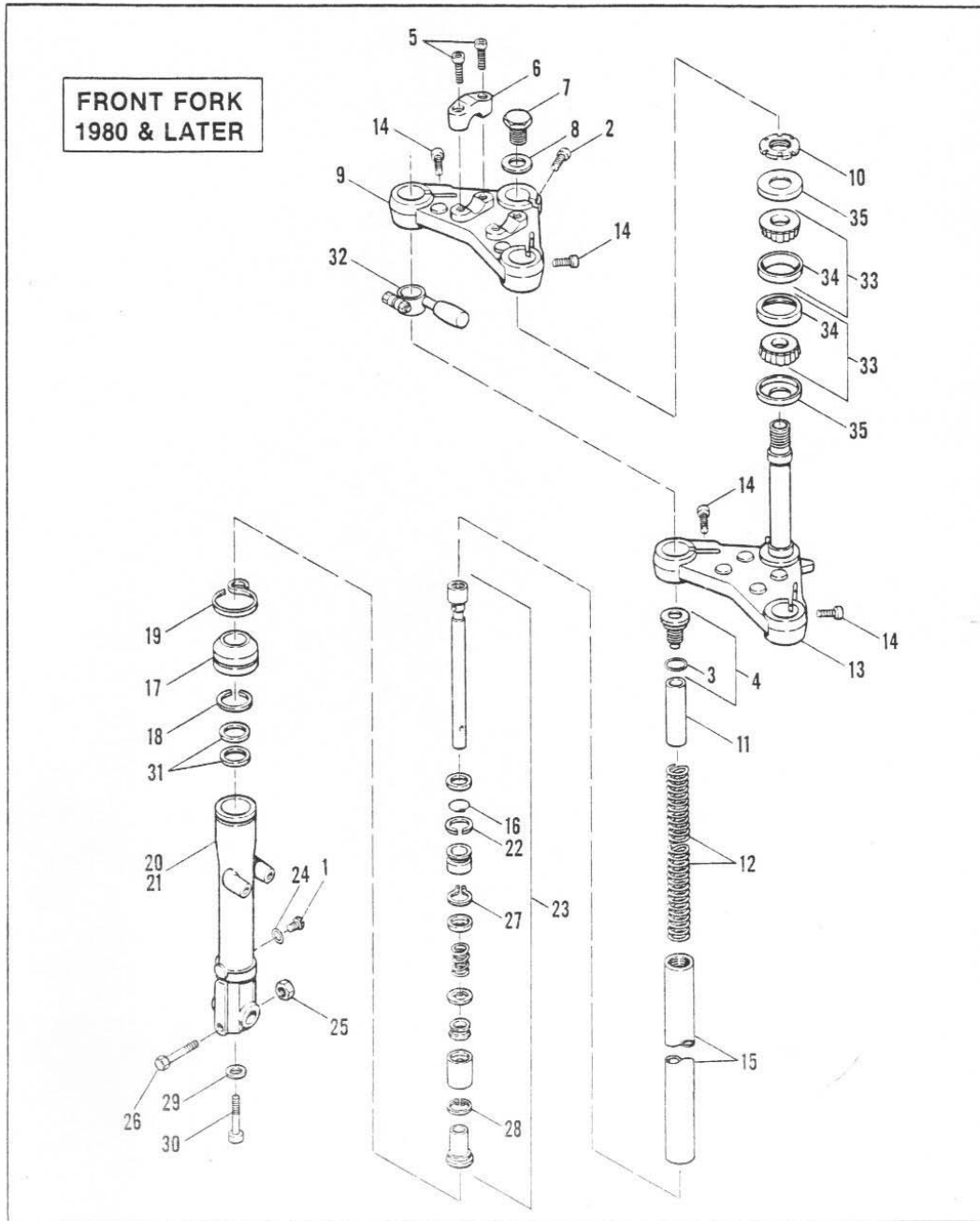
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June 24, 1980

P&A #106

This bulletin contains the illustration and component part numbers for the Marzocchi Front Fork, Part No. 45489-79R, used on the 1980 XR-750. Please insert this bulletin into your 1972-1980 XR-750 Parts Catalog (99442-72RD), page 19, for future reference.



## FRONT FORK — 1980 &amp; LATER

XR19A

RETAIL PRICE	INDEX NO.	PART NO.	N A M E	USED ON
	1	1861P	SCREW, drain hole, 6 mm. x 10 rd. hd. (2)	80 to * — XR
	2	2838P	SCREW, upper bracket to stem, 8 mm. x 35 socket hd.	80 to * — XR
	3	12008P	O-RING, fork tube plug (2)	80 to * — XR
	4	45480-80R	PLUG ASSEMBLY, fork tube (2)	80 to * — XR
	5	45481-80R	SCREW, handlebar clamp, 8 mm. x 30 socket hd. (4)	80 to * — XR
	6	45482-80R	CLAMP, handlebar (2)	80 to * — XR
	7	45483-80R	BOLT, fork stem, 20 mm. x 1.5	80 to * — XR
	8	45484-80R	WASHER, fork stem	80 to * — XR
	9	45485-80R	UPPER BRACKET	80 to * — XR
	10	45487-80R	ADJUSTER, bearing	80 to * — XR
	11	45488-80R	SPACER, fork spring (2)	80 to * — XR
		45489-79R	FRONT FORK ASSEMBLY, complete	80 to * — XR
	12	45490-80R	SPRING (2)	80 to * — XR
	13	45491-80R	STEM AND BRACKET	80 to * — XR
	14	45492-80R	SCREW, 10 mm. x 35 socket hd. (4)	80 to * — XR
	15	45493-80R	FORK TUBE (2)	80 to * — XR
	16	45497-80R	EXPANDER WIRE, damper piston ring (2)	80 to * — XR
	17	45499-80R	BOOT (2)	80 to * — XR
	18	45501-80R	RETAINING RING, oil seal (2)	80 to * — XR
	19	45502-80R	CLAMP, fork boot (2)	80 to * — XR
	20	45503-80R	FORK SLIDER, left	80 to * — XR
	21	45504-80R	FORK SLIDER, right	80 to * — XR
	22	45505-80R	PISTON RING, damper valve (2)	80 to * — XR
	23	45506-80R	DAMPER TUBE ASSEMBLY, with screw and washer (2)	80 to * — XR
	24	45507-80R	O-RING, drain screw (2)	80 to * — XR
	25	45508-80R	LOCKNUT, 8 mm. x 8 x 13 hex. hd. (2)	80 to * — XR
	26	45510-80R	BOLT, 8 mm. x 55 hex. hd. (2)	80 to * — XR
	27	45511-80R	RETAINING RING, damper tube (2)	80 to * — XR
	28	45512-80R	RETAINING RING, fork tube (2)	80 to * — XR
	29	45513-80R	WASHER, damper tube (2)	80 to * — XR
	30	45515-80R	SCREW, damper tube, 12 mm. x 35 socket hd. (2)	80 to * — XR
	31	46124-70R	SEAL, fork slider (4)	80 to * — XR
	32	47565-74R	FORK STOPS, pair	80 to * — XR
	33	48314-70	STEERING HEAD BEARING (cup & cone) (2)	80 to * — XR
	34	48315-60	BEARING CUP, steering head (Timken) (2)	80 to * — XR
	35	48371-70R	DUST SHIELD, steering head bearing (2)	80 to * — XR



## XR 750 TRANSMISSION UPDATE

Remember the 1:04 third gear ratio available for the KR's? The same gears that made this possible were used later on the XR where they failed as a result of the additional HP.

This ratio is again obtainable by using a new clutch gear and countershaft drive gear combination.

Part numbers are:

35698-92R	Drive Gear Countershaft .....	24t
37452-92R	Clutch Gear .....	20t

Gears above must be used as a set. 1st, 2nd and 3rd gear ratios will change as follows:

		<b>TRANSMISSION GEAR COMBINATIONS</b>	
<b>GEAR</b>	<b>RATIO</b>		
1st .....	1.91	17t. countershaft -	27t. mainshaft
2nd .....	1.38	20t. countershaft -	23t. mainshaft
3rd .....	1.04	23t. countershaft -	20t. mainshaft

### CAUTION

Do not use 20t. clutch gear (P/N 37450-56RA) with 24t. countershaft drive gear.

To identify both 20t. clutch gears, check outside diameter of teeth.

For P/N 37450-56RA: .....	O.D. = 2.27
For P/N 37452-92R: .....	O.D. = 2.35

### Additional Main Bearing Information

Bearings with a **PLAIN** outer race (no groove) and plastic cage are available from NSK.

### CAUTION

These bearings have standard (STD) internal clearance (less than C 3) and can only be used in crankcases in which the bearings do no longer fit tight.

Recommended bearing numbers currently used are:

<b>NSK #</b>	<b>Internal Clearance</b>	<b>Outer Race</b>
22206 HC	STD	Plain
22206 HE4C3	C3	Grooved

(The second bearing has been listed in Bulletin R-108)

Contact: NSK Bearing Corp.  
 250 Covington Drive  
 Bloomington, IL 60108  
 708 / 924-8000  
 800 / 255-4773

Ask for the distributor assigned to your area.