



# YAMAHA

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# YZ125H YZ250H/YZ465H ASSEMBLY MANUAL





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## FOREWORD

This Assembly Manual contains the information required for the unpacking and assembly of Yamaha machines so that the Yamaha serviceman can assemble the machines in the correct manner. To perform machine assembly, a basic knowledge of service and Yamaha machines is required. Therefore, all Yamaha dealers are urged to study the service of Yamaha machines using the relevant service manuals.

## NOTICE

The service specifications given in this Assembly Manual are based on the model as manufactured. When this model may require improvements, the service specifications may be subject to change in the future. Modifications are inevitable and significant changes in specifications or procedures will be forwarded to Authorized Yamaha dealers. The assembly procedure is described in the order that the mechanic should follow, and the correct service tools should be used in the correct manner. Failure to do this may result in poor performance and harm to the rider.

### **CONCERNING CRATE DAMAGE:**

**Follow the Instructions in the Dealer Warranty Handbook, Procedure Section.**

Particularly important information is distinguished in this manual by the following notations:

**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 machine.

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

**YZ125H/YZ250H/YZ465H**

**ASSEMBLY MANUAL**

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## PREPARATION

To assemble the machine correctly, the following supplies and working space are required.

### Supplies

Oils, greases, shop rags, electrical contact cleaner.

### Workshop

The workshop where the machine is assembled should be clean and large. The floor should be level.

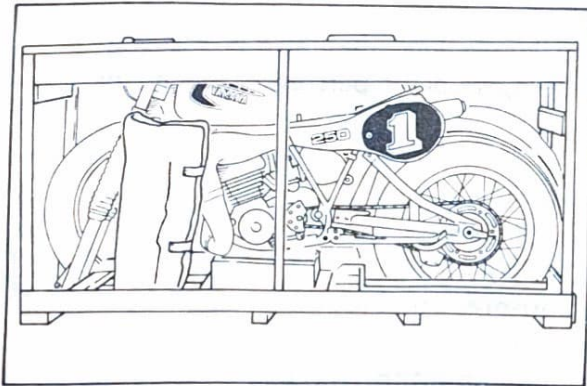
## UNPACKING

### Note on transportation

Use caution when transporting the crate to service shop. Do not subject crate to heavy shock.

### Procedure for unpacking

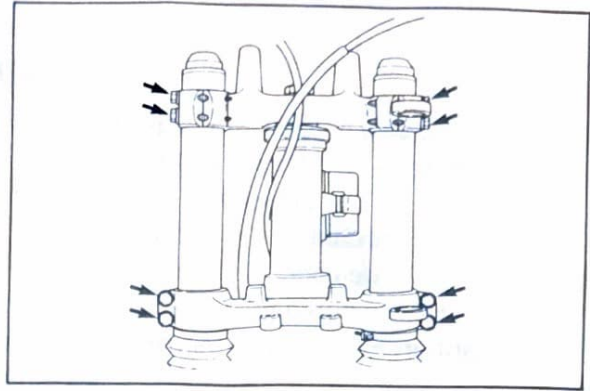
1. To remove the machine and parts packed in the cardboard crate, cut the vinyl bands around the box using scissors. Next, remove the exterior carton by lifting it straight up, and remove the foam tray.



2. Remove the front wheel, seat and cardboard crate.
3. Remove the nails from each corner of the crate, and remove the struts.
4. Remove the front fender held between the rear tire and the rear fender.

### 5. Front fork holding bar removal (For YZ250H/465H)

- a. Loosen the upper and lower bracket pinch bolts, while holding the front fork outer tube so that the front forks do not drop. Remove the front fork holding bar.

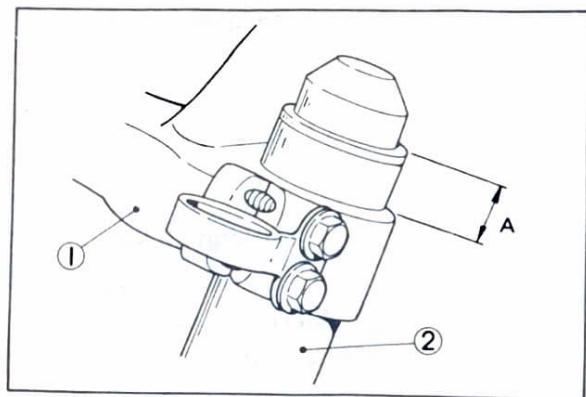


### CAUTION:

When doing above procedure care should be taken that the front fork inner tube does not hit your face or body.

- b. Adjust length "A" to the value specified below.

Length "A": 16 mm (0.64 in)

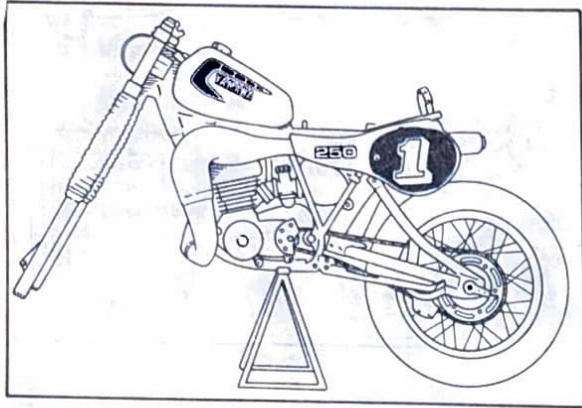


1. Handle crown      2. Inner tube

- c. Retighten the front fork pinch bolts to the specified torque below.

Tightening torque: 2.3 m·kg (16 ft·lb)

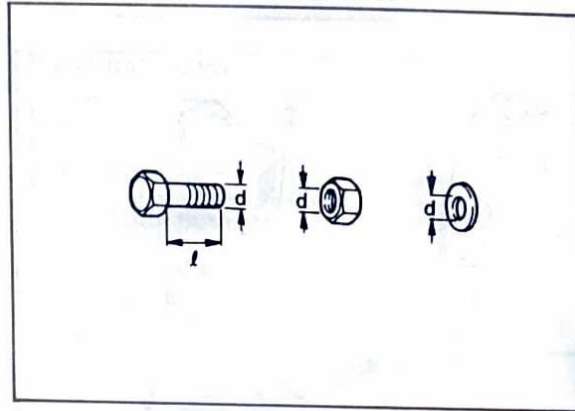
6. Lift up the machine, and remove the rear wheel section from the lower wooden case.  
Then take out the machine.
7. Place a machine stand under the engine to keep the front of the machine raised off the floor. Take care so that the machine does not fall over.



## PARTS CHECK LIST

Before starting the assembly, check for damaged or missing parts (listed below). Also check the machine for damage, scratches and other defects.

**NOTE:** \_\_\_\_\_  
The sizes of bolts, nuts, washers and collars are shown below. The sizes of special parts are indicated in the respective tables.

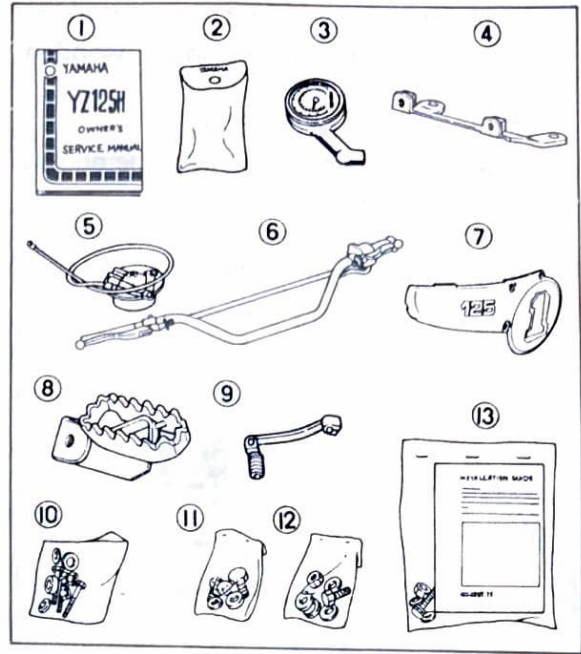
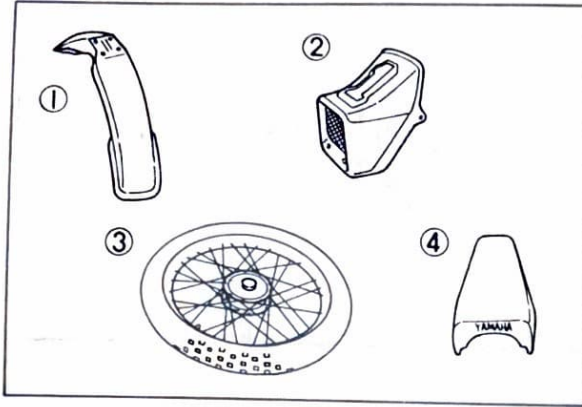


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## PARTS CHECK LIST FOR YZ125H

### Parts list: Cardboard crate

No.	Part name	Q'ty
1	Front fender	1
2	Number plate	1
3	Front wheel	1
4	Seat	1

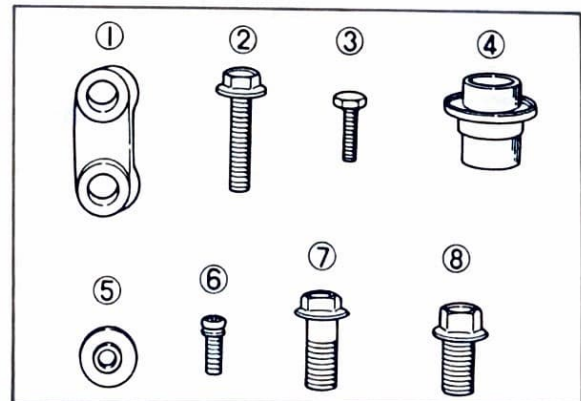


### Parts list: Vinyl bag "A"

No.	Part name	Q'ty	Remarks
1	Handle upper holder	2	Handle-bar
2	Flange bolt (d = 6 mm, l = 20 mm)	4	
3	Bolt (d = 6 mm, l = 20 mm)	1	Change pedal
4	Wheel collar	1	Front wheel
5	Plate washer	2	Side cover (L)
6	Panhead screw with washer (d = 6 mm, l = 15 mm)	2	
7	Washer based head bolt (d = 12 mm, l = 25 mm)	1	Footrest (Left)
8	Flange bolt (d = 10 mm, l = 20 mm)	1	

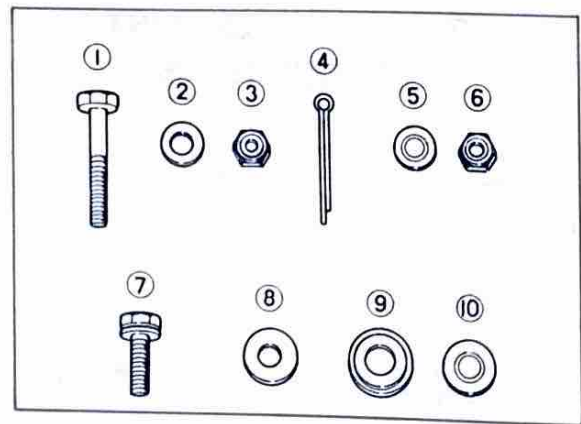
### Parts list: Foam styrol care

No.	Part name	Q'ty
1	Owner's Service Manual	1
2	Tool kit	1
3	Air gauge	1
4	No. plate stay	1
5	Brake shoe plate	1
6	Handlebar assembly	1
7	Side cover (left)	1
8	Footrest (left)	1
9	Change pedal	1
10	Vinyl bag "A"	1
11	Vinyl bag "B"	1
12	Vinyl bag "C"	1
13	Fender plate kit	1



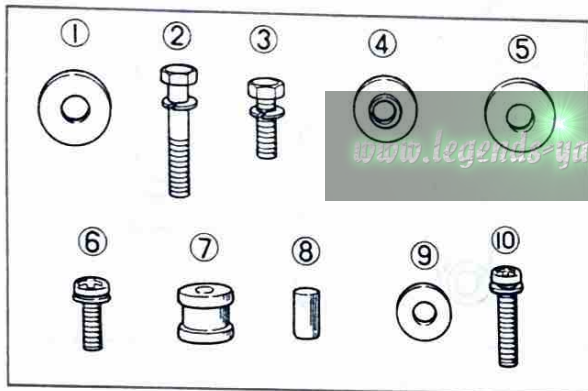
**Parts list: Vinyl bag "B"**

No.	Part name	Q'ty	Remarks
1	Plate washer	4	Front fender
2	Bolt with washer (d = 6 mm, l = 35 mm)	2	
3	Bolt with washer (d = 6 mm, l = 20 mm)	2	
4	Washer	4	
5	Washer	2	Number plate
6	Panhead screw with washer (d = 6 mm, l = 16 mm)	2	
7	Grommet	2	
8	Collar	2	
9	Washer	2	
10	Panhead screw with washer (d = 6 mm, l = 25 mm)	2	



**Parts list: Owner's tool kit**

No.	Part name	Q'ty
1	Tool bag	1
2	Rotor puller	2
3	Special spanner	1
4	Air gauge	1

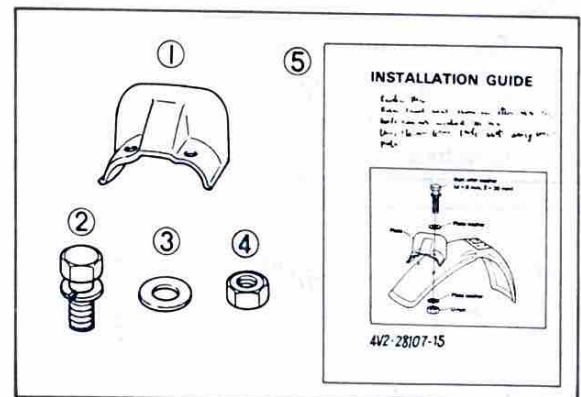


**Parts list: Fender plate kit**

No.	Part name	Q'ty
1	Fender plate	1
2	Bolt with washer (d = 6 mm, l = 20 mm)	2
3	Plate washer	4
4	U-nut	2
5	Installation guide	1

**Parts list: Vinyl bag "C"**

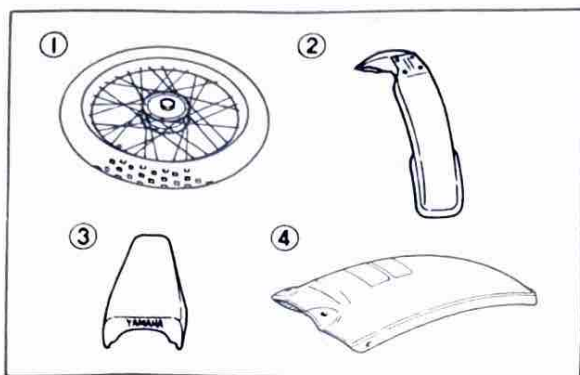
No.	Part name	Q'ty	Remarks
1	Bolt (d = 6 mm, l = 35 mm)	2	Seat
2	Washer	2	
3	U-nut	2	
4	Sprit pin	1	Front wheel
5	Washer	1	Front brake
6	Nut	1	
7	Bolt with washer (d = 6 mm, l = 20mm)	2	No. plate stay
8	Plate washer	2	
9	Grommet	2	
10	Spacer	2	



## PARTS CHECK LIST FOR YZ250H/465H

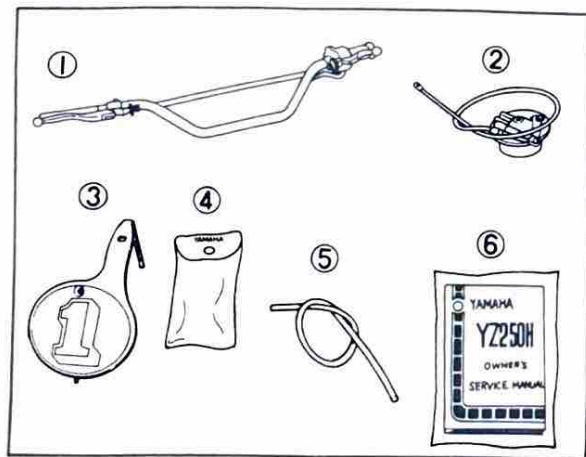
### Parts list: Carton box

No.	Part name	Q'ty
1	Front wheel	1
2	Front fender	1
3	Seat	1
4	Rear fender	1



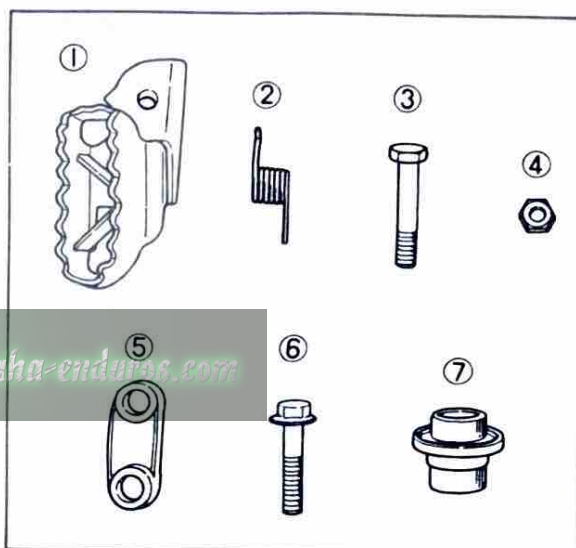
### Parts list: Foam tray

No.	Part name	Q'ty
1	Handlebar assembly	1
2	Brake shoe plate assembly (with brake wire)	1
3	Number plate	1
4	Tool kit	1
5	Fuel tank breather pipe	1
6	Owner's Service Manual (within Air check gauge, vinyl bags)	1



### Parts list: Vinyl bag "D"

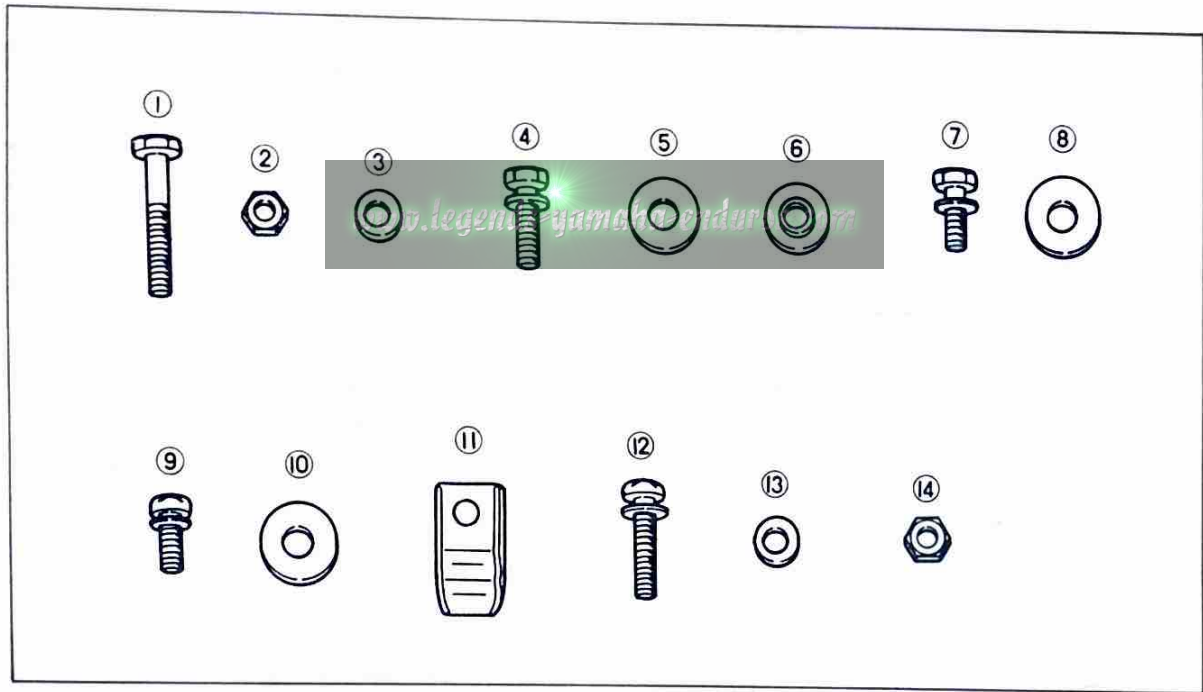
No.	Part name	Q'ty	Remarks
1	Footrest (right)	1	Footrest
2	Torsion spring	1	
3	Bolt (d = 8 mm, l = 28 mm)	1	
4	U-nut (d = 8 mm)	1	
5	Upper holder	2	Handlebar
6	Flange bolt (d = 8 mm, l = 35 mm)	4	
7	Wheel axle collar	1	Front wheel



**Parts list: Vinyl bag "E"**

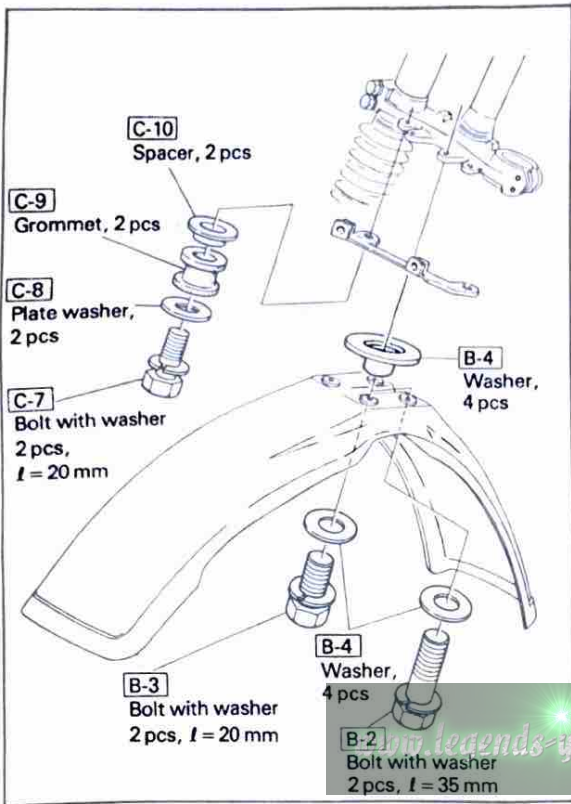
No.	Part name	Q'ty	Remarks
1	Bolt (d = 6 mm, l = 35 mm)	2	Seat
2	U-nut (d = 6 mm)	2	
3	Plate washer (d = 6.5 mm)	2	
4	Bolt with washer (d = 6 mm, l = 20 mm)	4	Front fender
5	Plate washer (d = 6.5 mm)	4	
6	Washer (d = 6.5 mm)	4	
7	Bolt with washer (d = 6 mm, l = 16 mm)	4	Rear fender
8	Plate washer (d = 6.5 mm)	4	

9	Panhead screw (d = 6 mm, l = 12 mm)	1	Number plate
10	Plate washer (d = 6.5 mm)	1	
11	Clamp	2	Brake wire
12	Panhead screw with washer (d = 6 mm, l = 25 mm)	1	
13	Plate washer (d = 6.5 mm)	1	
14	Nut (d = 6 mm)	1	

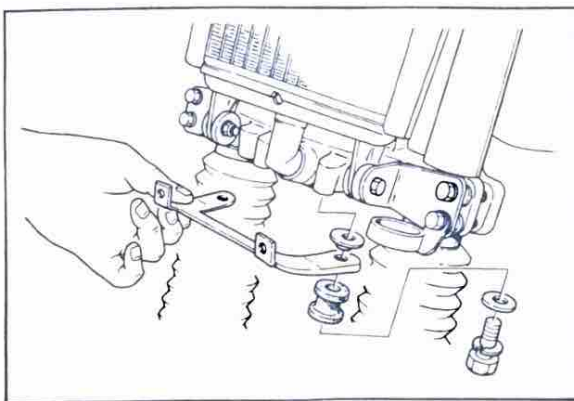


# SET-UP PROCEDURES FOR YZ125H

## Number plate stay and front fender installation



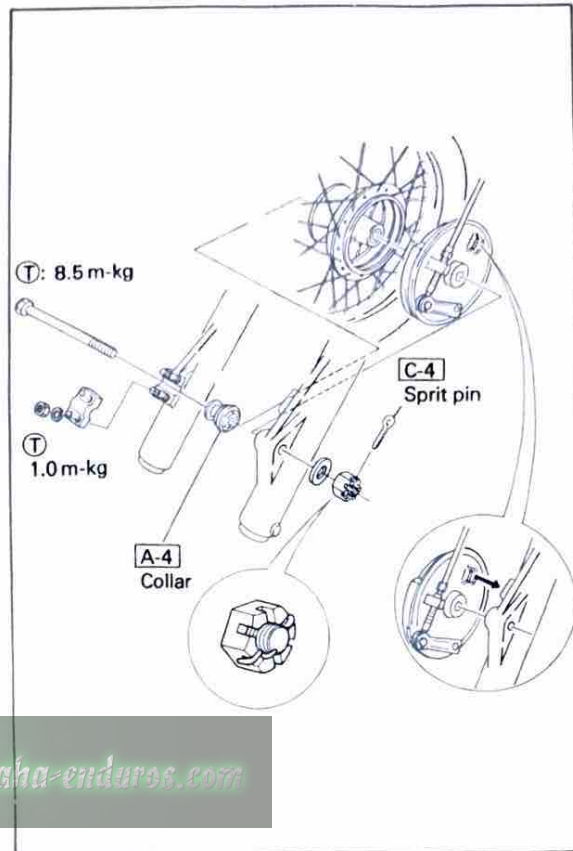
1. Install the number plate stay under the bracket bolts with washers, plate washer, Grommet and spacer.



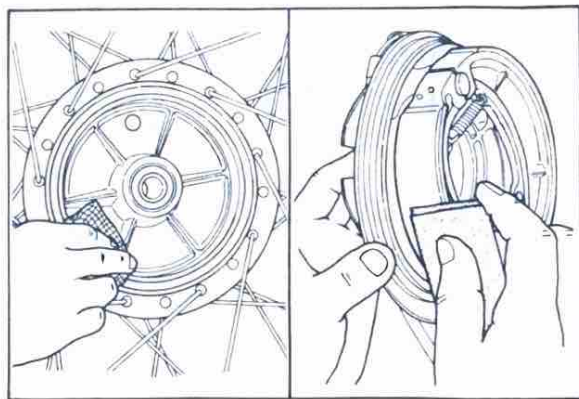
2. Insert the front fender between the front forks, and secure the front fender using bolts with spring washer, flat washers, and washers.

Tightening torque: 0.45 m·kg (3.25 ft·lb)

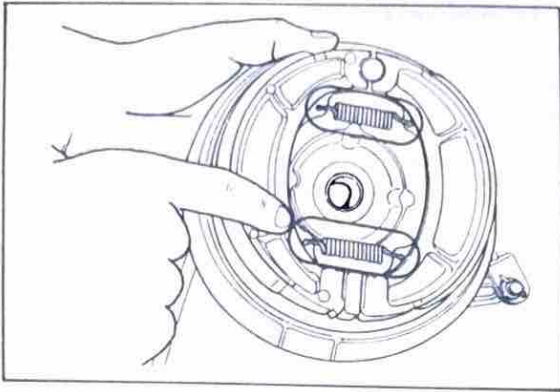
## Front wheel installation



1. Clean the brake shoe linings and wheel hub with a clean cloth.

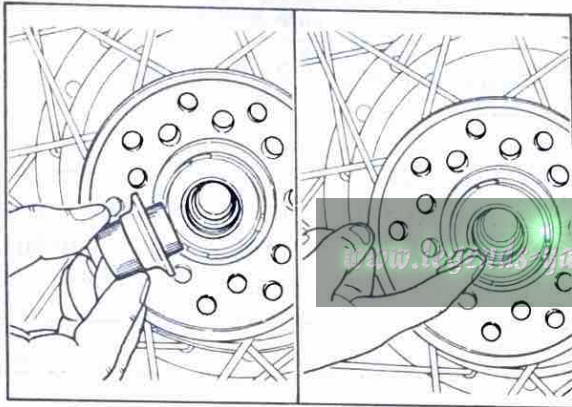


2. Make sure the brake shoes and springs are correctly installed in the shoe plate assembly. If any one of them is out of position, correct per the figure.

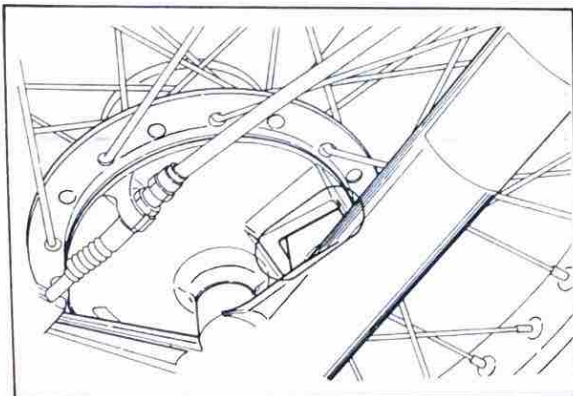


**NOTE:**

To avoid damaging the oil seal lip, apply a light coat of lithium base grease to the oil seal lip and collar. If the collar is dirty, clean it with a rag.



3. Insert the front wheel between the front fork legs so that the stopper (projection) on the front fork end correctly engages the slot in the brake shoe plate.



4. Apply grease to the axle and install the axle nut.
5. Torque the axle nut to specification.

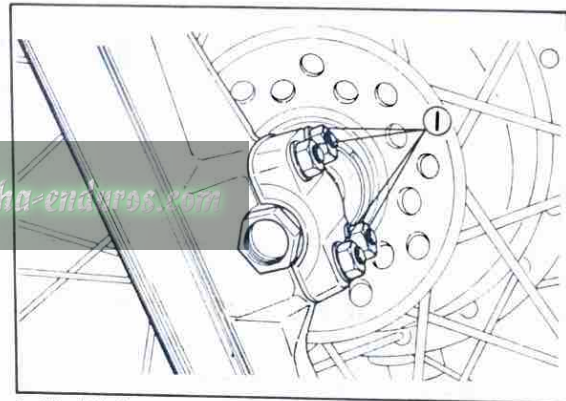
Tightening torque: 8.5 m-kg (60 ft-lb)

6. Torque the axle holder nuts to specification.

Tightening torque: 1.0 m-kg (7 ft-lb)

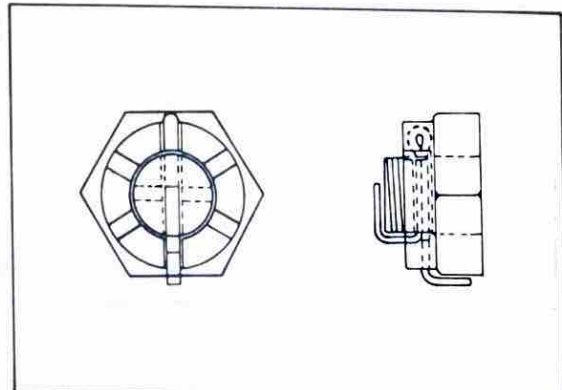
**NOTE:**

When tightening the axle holder nuts, first tighten the nuts on the upper side of the axle holder then tighten the nuts on the lower side.

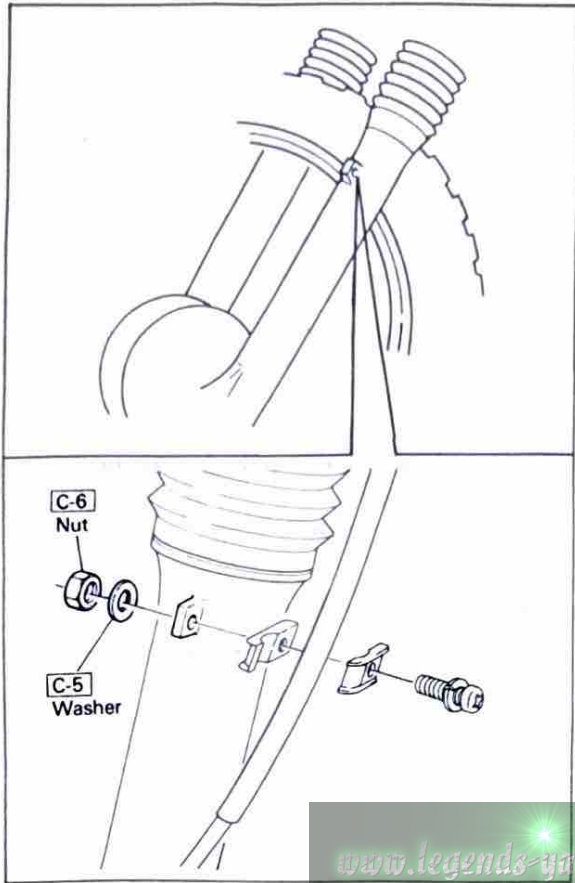


1. Pinch bolt

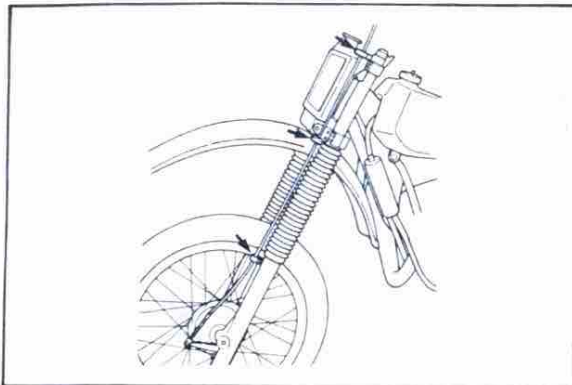
7. Lock the nut with the cotter pin. The pin should be inserted downward, and the pin ends should be bent.



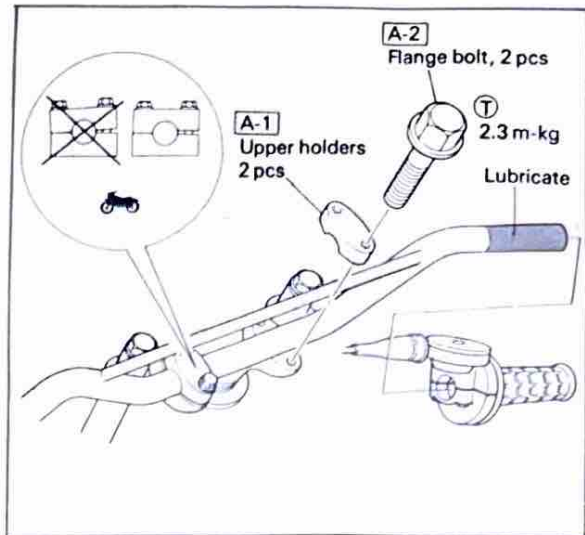
## Wire holder installation



1. Install the brake cable clamps to the boss on the left front fork leg, then pass the brake cable in the cable guides.
2. Pass the brake wire through each holder.



## Handlebar, Throttle grip installation

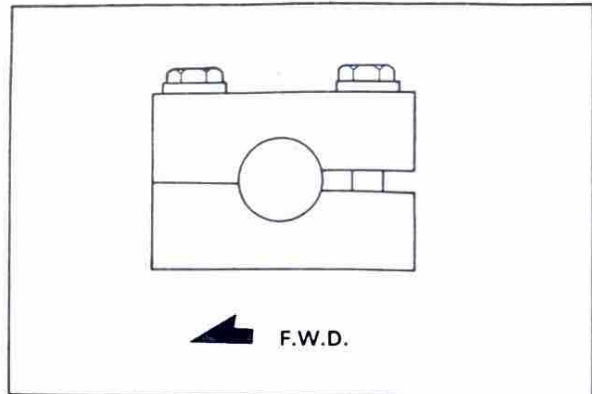


1. Install the handlebar assembly.

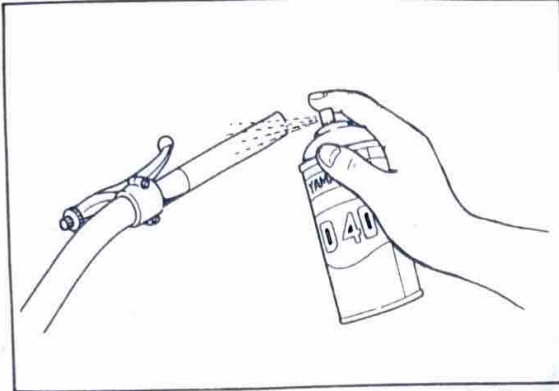
Tightening torque: 2.3 m-kG (16 ft-lb)

### CAUTION:

First tighten the bolts on the front side of the handlebar holder then tighten the bolts on the rear side.

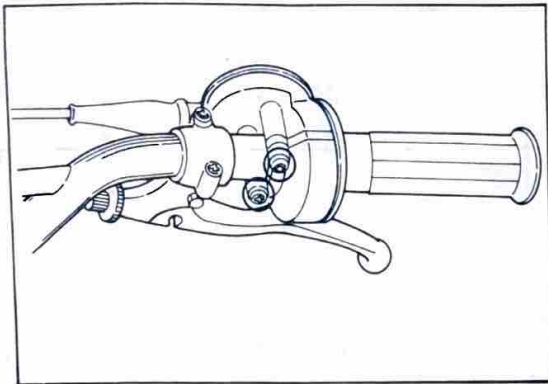


2. Wipe off any dust on the right handlebar end, and spray the lubricant to the handlebar end and the throttle grip housing.

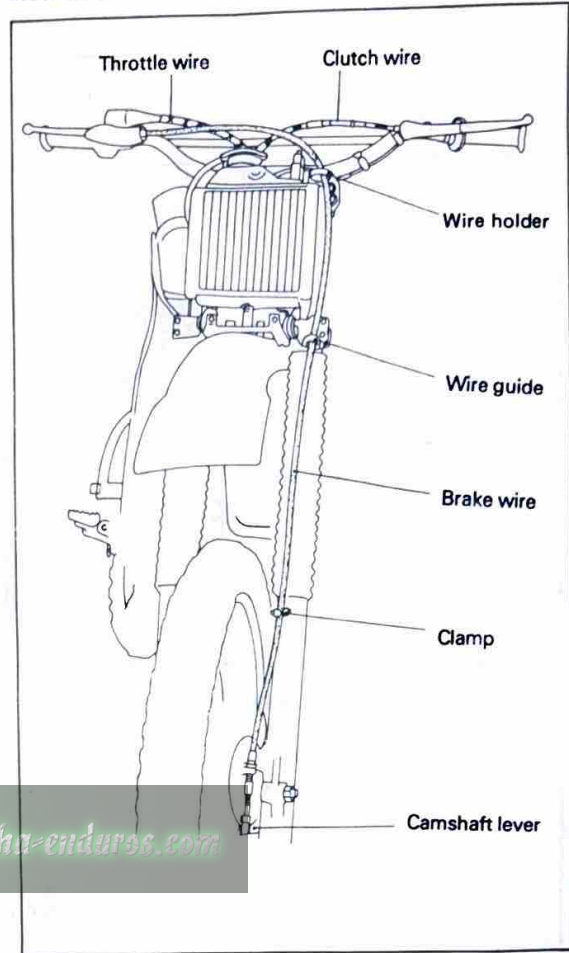


3. Slip the throttle grip over the handlebar, and push the grip onto the handlebar until it bottoms. Slide it back about 2 mm (0.08 in), and assemble the throttle housing using the screws provided.

**CAUTION:**  
Tighten the screws in the stages and maintain an equal gap on each side of holder.



## Brake and clutch wire installation

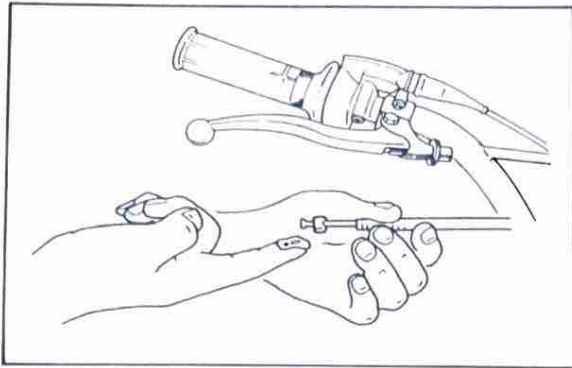


**WARNING:**  
Route throttle cable, clutch cable and brake cable with special care so that they have a proper amount of play. Be sure that the throttle is not affected when the handlebars are turned to the right or left.

### 1. Brake wire and clutch wire installation

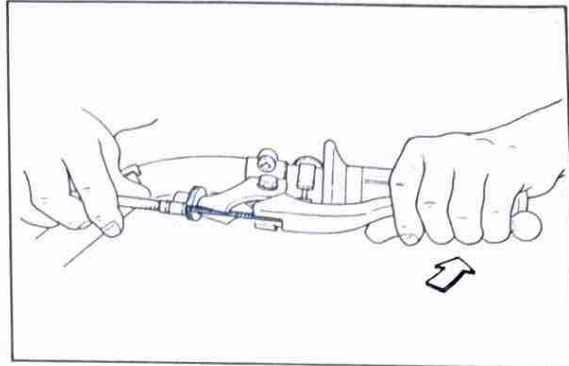
**NOTE:** \_\_\_\_\_

Before assembly, lubricate cables with a suitable cable lubricant.

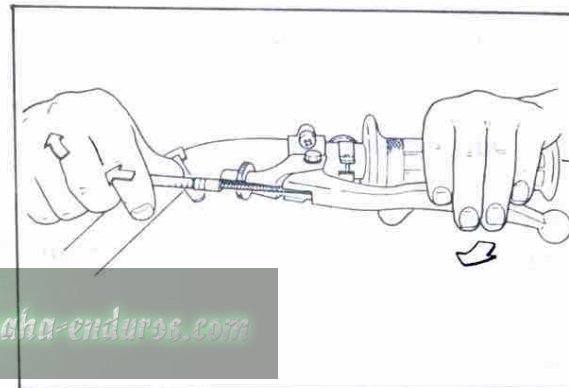
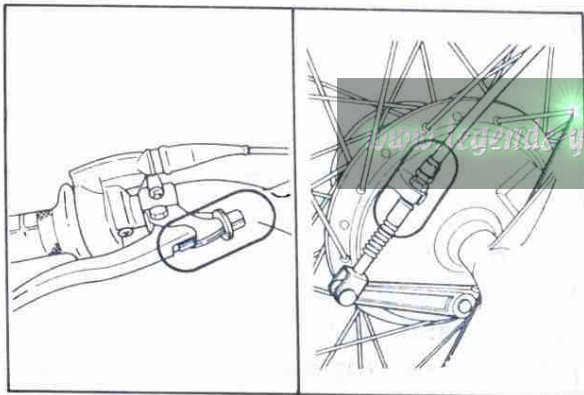


**WARNING:** \_\_\_\_\_

Proper cable and wire routing is essential to assure safe vehicle operation.

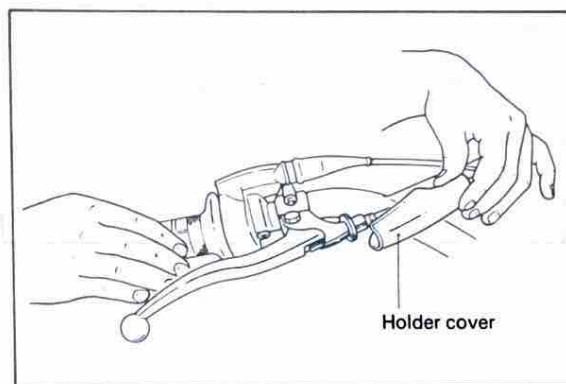


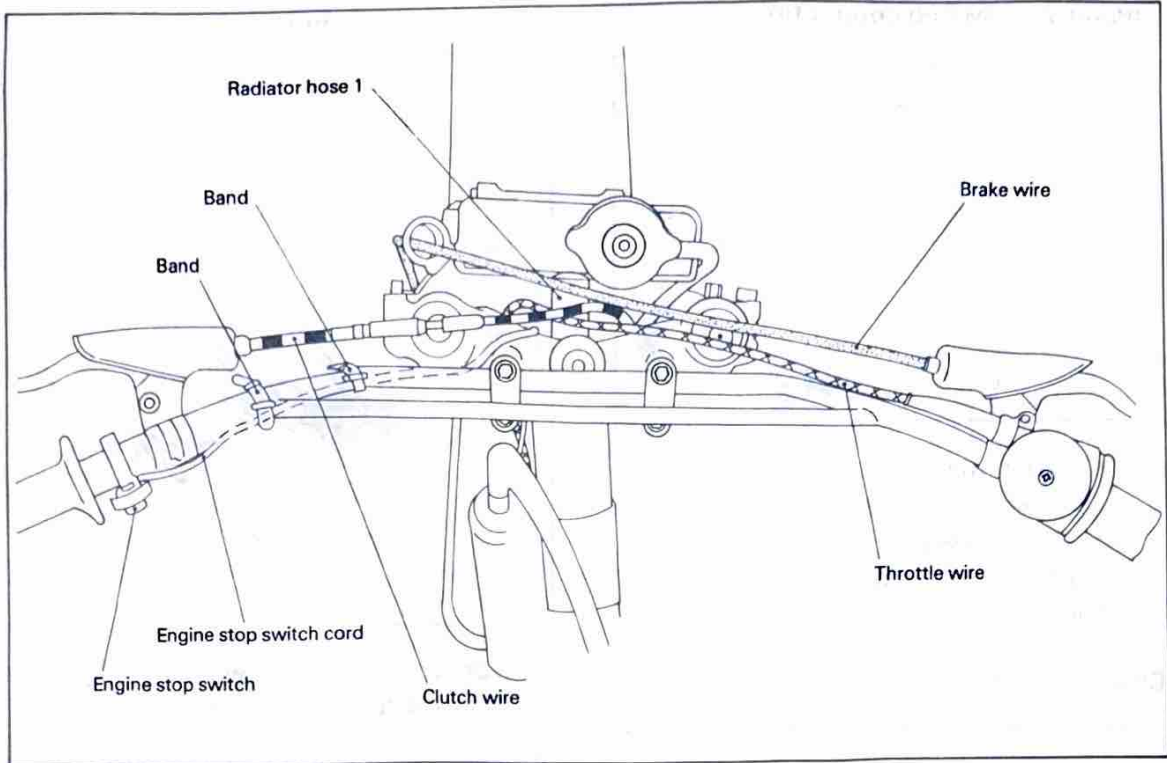
2. Screw in the cable length adjusters on the brake shoe plate and cable length adjuster.



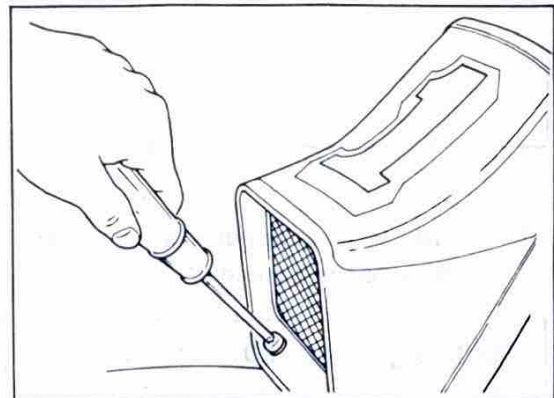
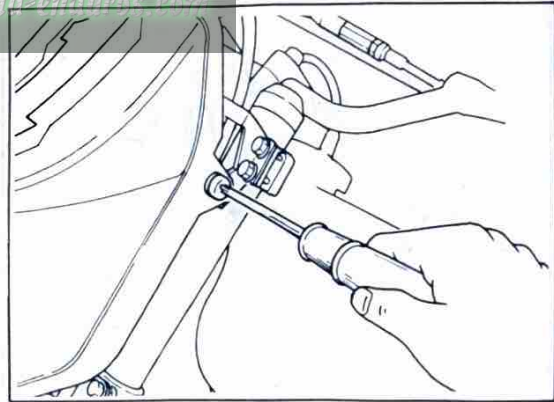
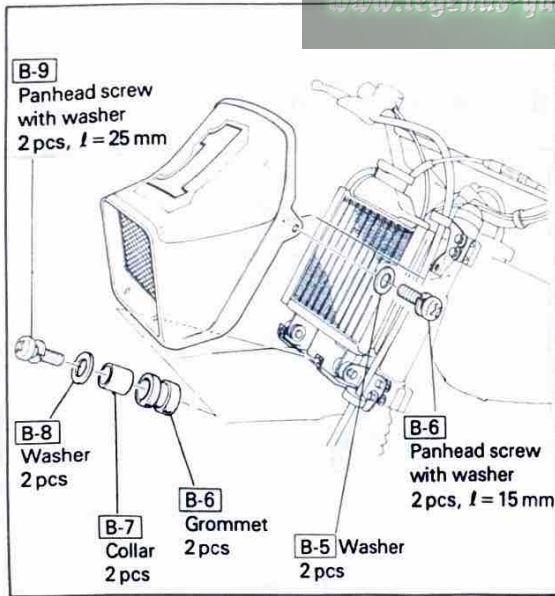
3. Fully loosen the lever adjuster lock nut and screw in the adjuster until it is tight. Next, align the slits in the adjuster and adjuster lock nut with the slit in the lever holder.
4. Insert the wire end into the lever hold, and hook the outer cable end onto the adjuster lock nut; then squeeze the lever. Next, while pulling the outer cable in the direction opposite the lever, release the lever quickly. While releasing it, seat the outer cable into the adjuster.

5. Cover the brake and clutch lever holders with the holder covers.



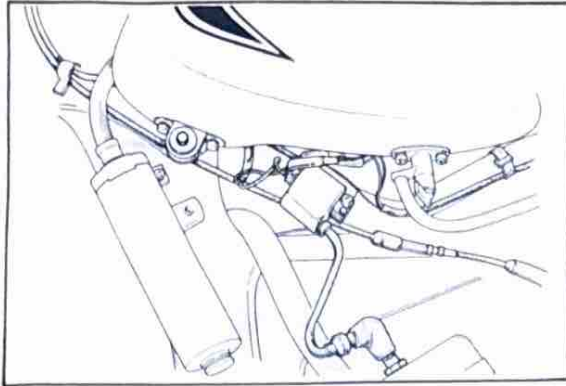


### Number plate installation



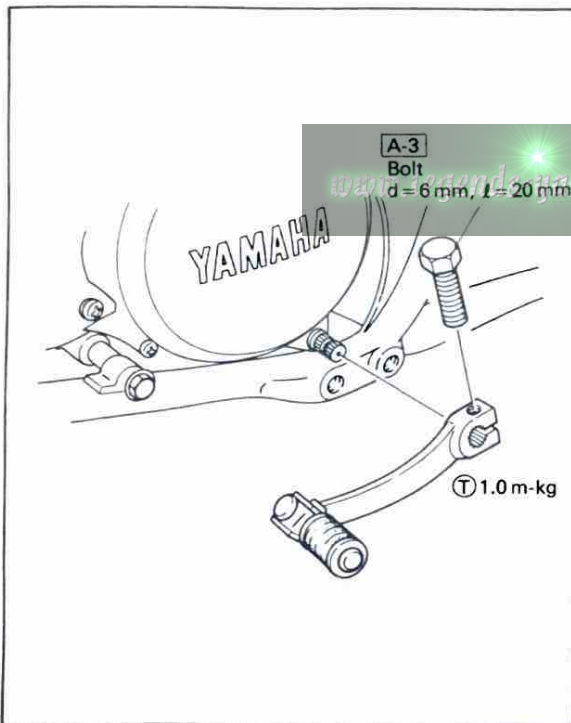
1. Install the number plate using the Panhead screws with washers, Gromets, Collars and washers.

### Engine stop switch connection



1. Connect the engine stop switch lead wire (coming from the engine stop switch) to the lead wire (black/white) coming from the magneto assembly in the connector.

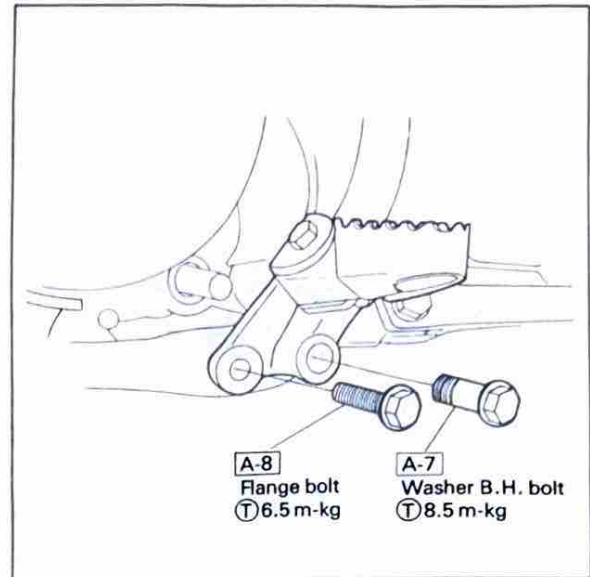
### Change pedal installation



1. Install the change pedal so it is almost parallel to the top end of the footrest.

Tightening torque: 1.0 m-k (7 ft-lb)

### Footrest installation



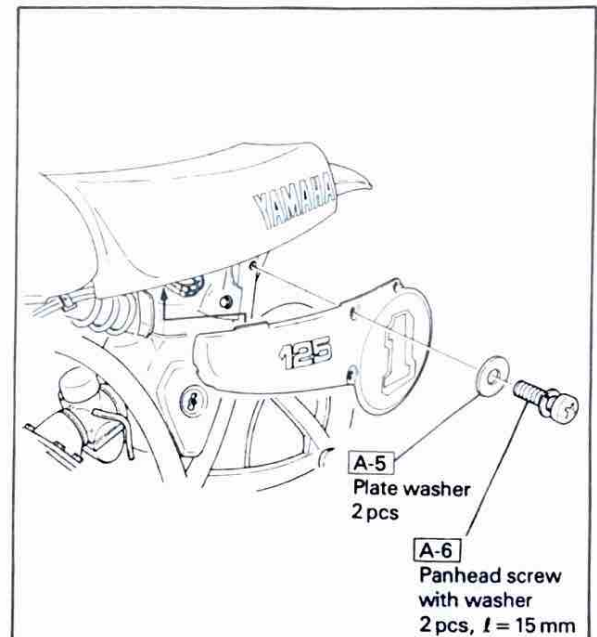
1. Secure the footrest with the flange bolt and washer based head bolt.

Tightening torque:

M10: 6.5 m-k (46 ft-lb)

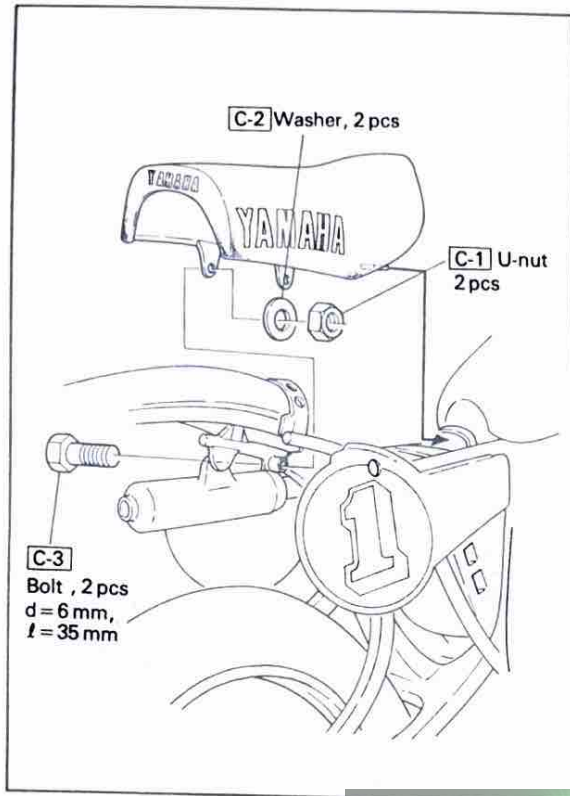
M12: 8.5 m-k (60 ft-lb)

### Side cover (L) installation

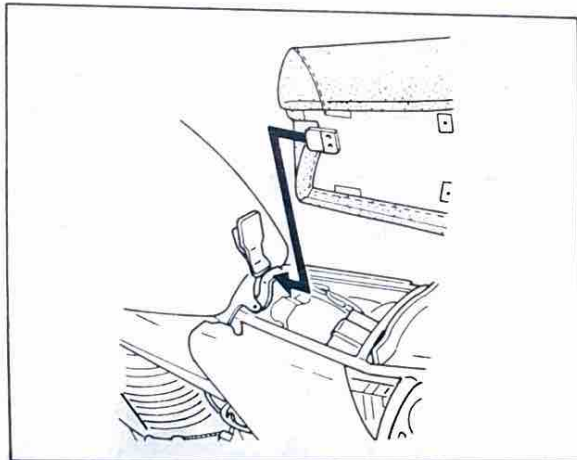


1. Install the side cover using the panhead screw with washers and plate washers.
2. When installing the side cover, be careful not to tighten it excessively.

## Seat installation



1. Put the seat tab under the frame, and install the seat.



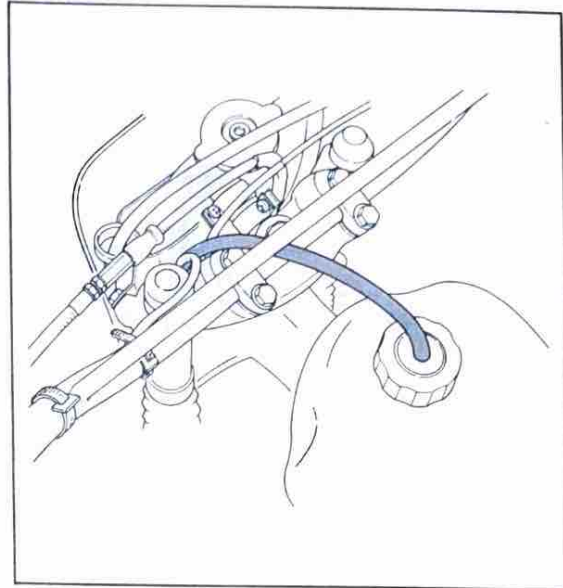
### NOTE:

The bolt should be inserted from the inside to the outside.

2. Install the semidouble seat to the frame using bolts, plate washers and U-nuts.

Tightening torque: 0.5 m·kg (3.6 ft·lb)

## Fuel tank breather pipe installation

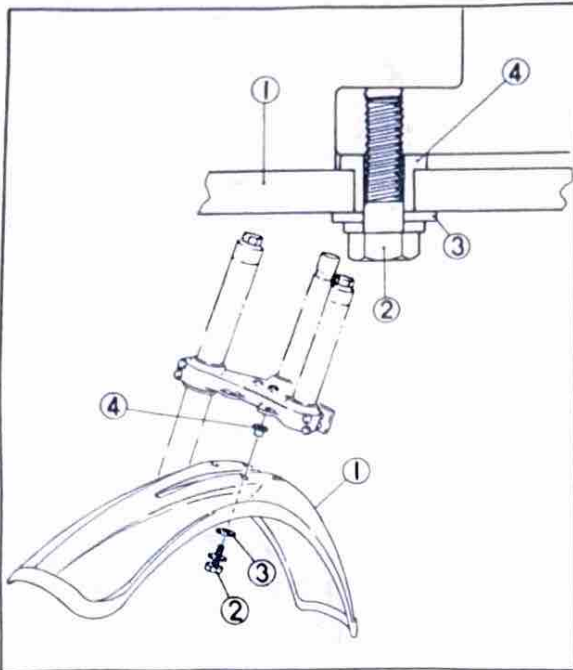


1. Connect one end of the air breather pipe to the fuel tank filler cap, and other end go down along the head pipe.

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# SET-UP PROCEDURES FOR YZ250H/465H

## Front fender installation



- 1. Front fender
- 2. Bolt with spring washer [E-4]
- 3. Plain washer [E-5]
- 4. Washer [E-6]

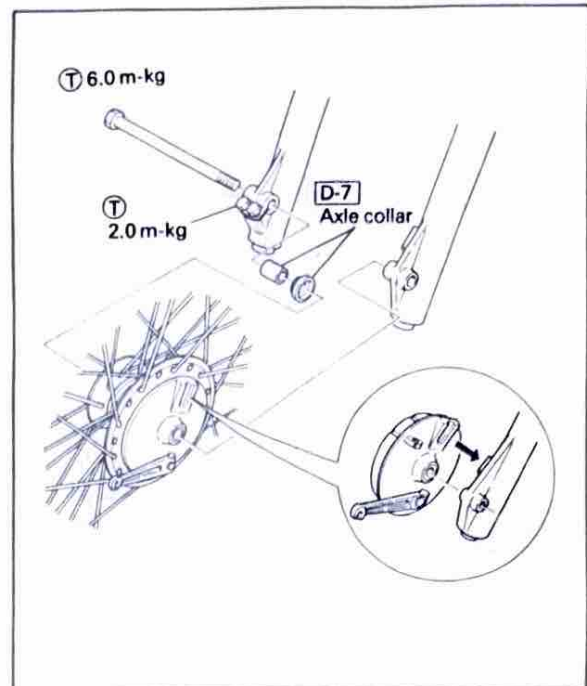
1. Insert the front fender between the front forks, and secure the front fender using bolts with washers, plain washers and washers.

Tightening torque: 0.6 m-k<sub>g</sub> (5 ft-lb)

### NOTICE:

This manual describes the set-up procedure that can be applied to the YZ250H/465H only. For the rest, refer to the YZ125H SET-UP PROCEDURES.

## Front wheel installation

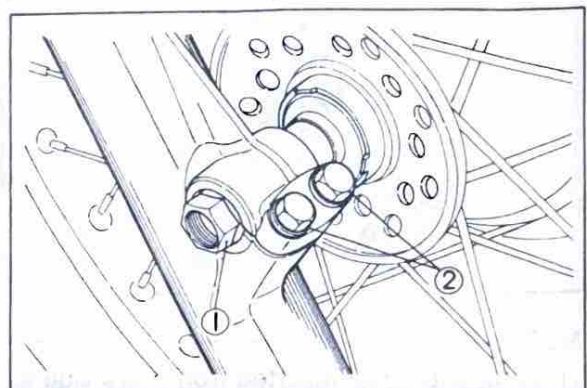


1. Torque the axle and axle holder bolts to specification.

Tightening torque:

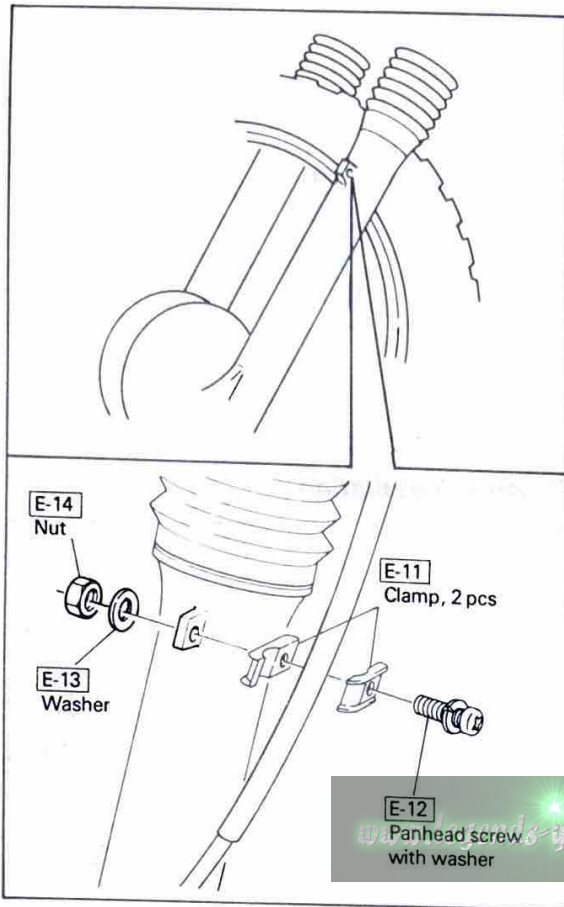
Axle: 6.0 m-k<sub>g</sub> (42 ft-lb)

Axle holder nut: 2.0 m-k<sub>g</sub> (14 ft-lb)

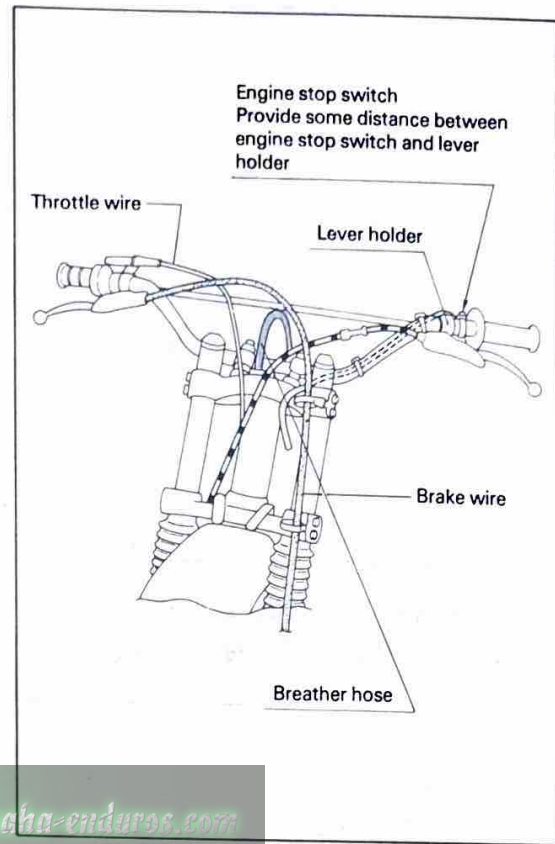


- 1. Axle
- 2. Axle holder bolt

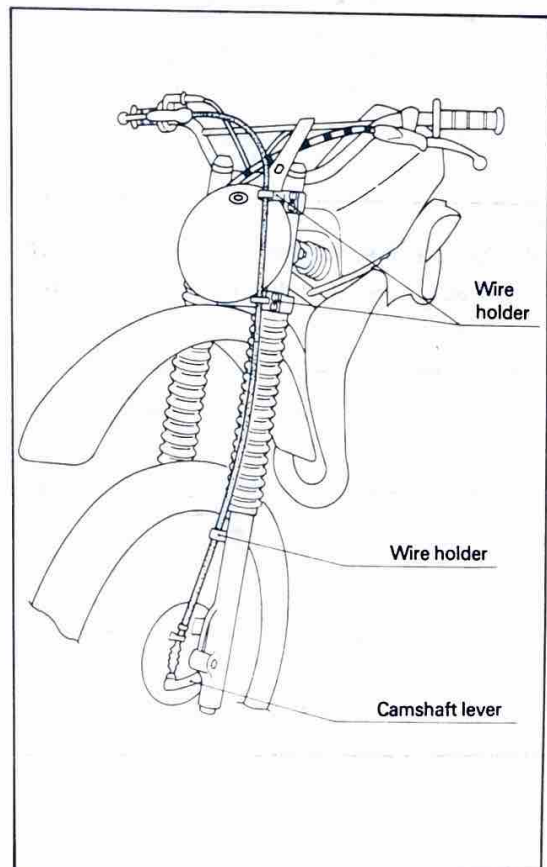
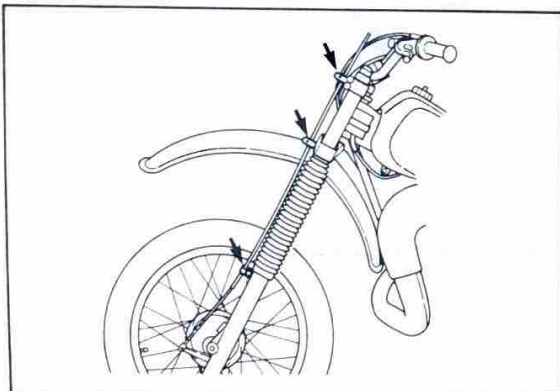
## Wire holder installation



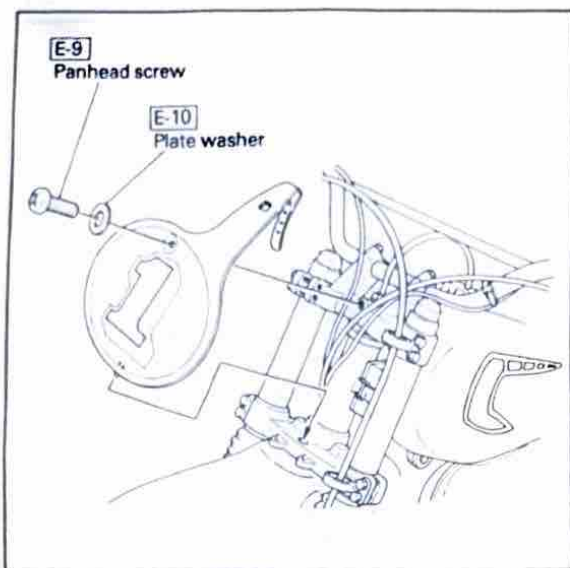
## Brake and clutch wire installation



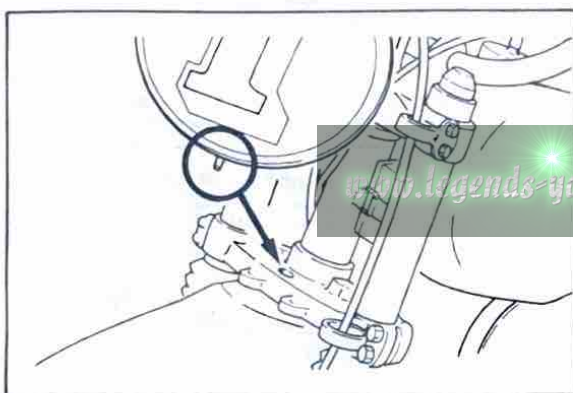
1. Pass the brake wire through each holder and secure the clamps to the fork with pan head screws, washers, flat washers, and nuts.



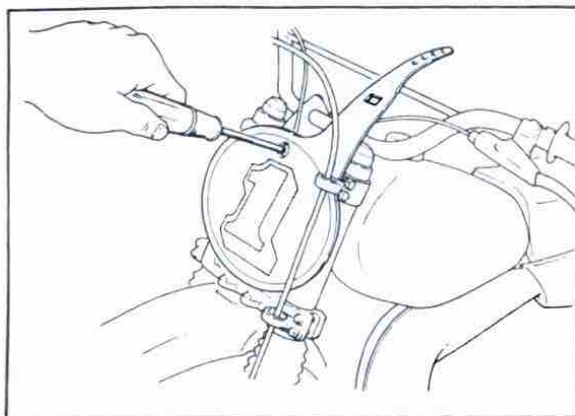
## Number plate installation



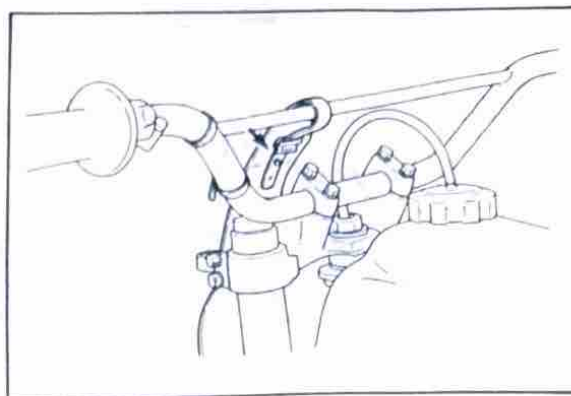
1. Insert the projection on the number plate into the hole in the under-bracket.



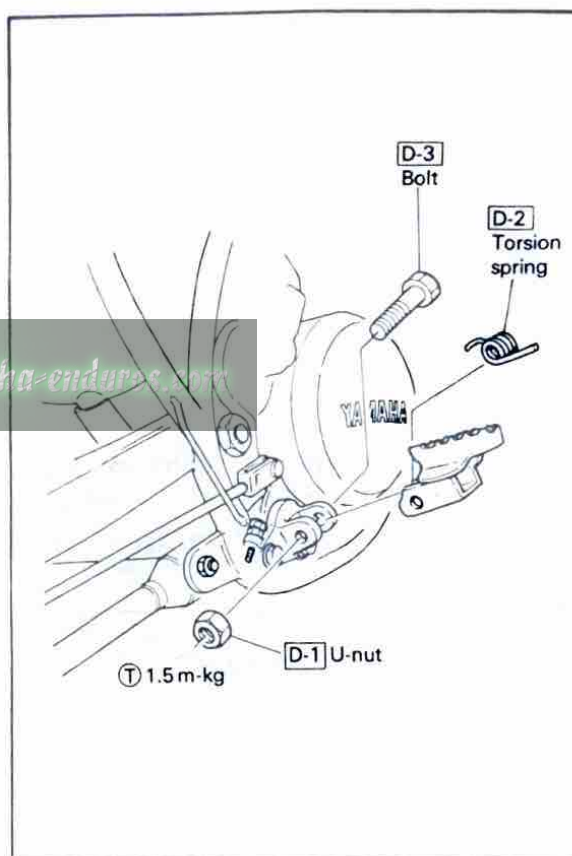
2. Secure the number plate to the upper-bracket with pan head screw and washers.



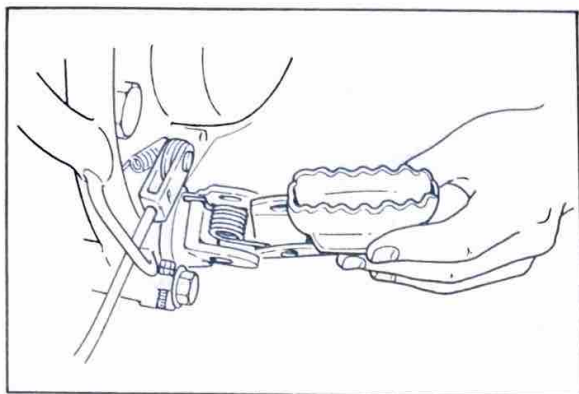
3. Secure the number plate to the tension bar.



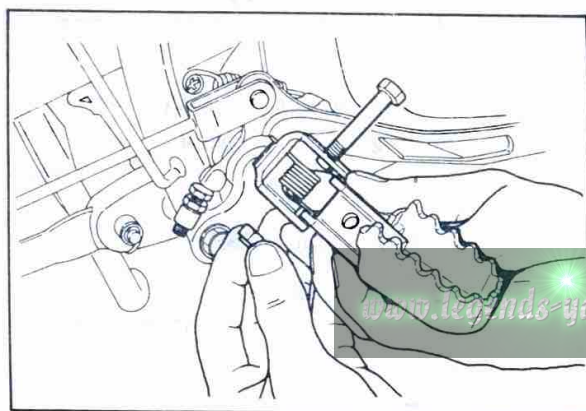
## Footrest installation



1. Hook one end of the return spring onto the bracket and insert the other end into the footrest.



2. Insert the bolt downward into the bracket.

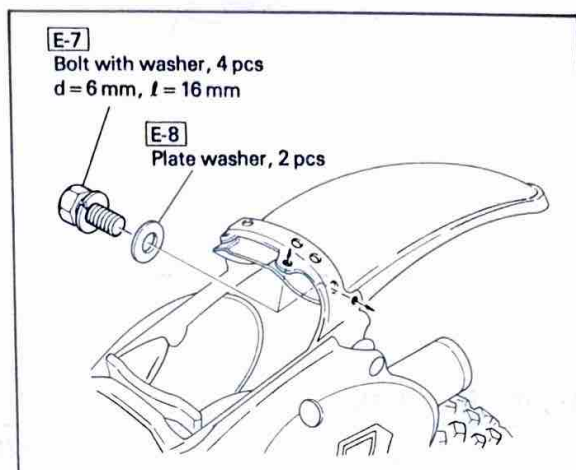


Tightening torque:  
1.5 m·kg (10 ft·lb)

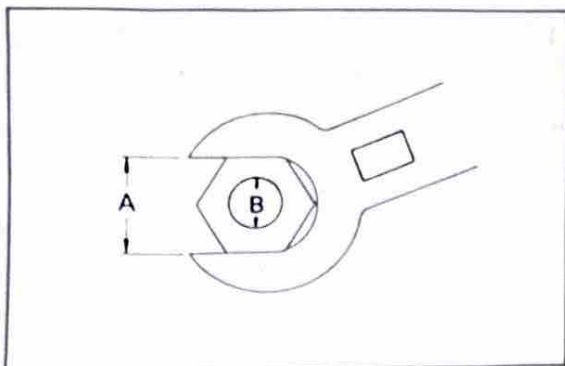
**NOTE:** \_\_\_\_\_  
After installing the footrest, check that it moves smoothly.  
\_\_\_\_\_

## Rear fender installation

1. Install the rear fender using the bolts with spring washers and flat washers.



## TORQUE SPECIFICATION



A (Nut)	B (Bolt)	Standard tightening torque	
		m-kg	ft-lb
10 mm	6 mm	0.6	4.5
12 mm	8 mm	1.5	11
14 mm	10 mm	3.0	22
17 mm	12 mm	5.5	40
19 mm	14 mm	8.5	61
22 mm	16 mm	13.0	94

### Tightening torque

Engine	YZ125H	YZ250H/465H
Cylinder	M8 2.5m-kg (18ft-lb)	←
Spark plug	M14 2.5m-kg (18ft-lb)	←
Cylinder	M10 3.8m-kg (26ft-lb)	M10 3.3m-kg (24ft-lb)
Kick crank	M10 3.5m-kg (26ft-lb)	M12 5.0m-kg (36ft-lb)
Change pedal	M6 1.0m-kg ( 7ft-lb)	←
Rotor	M10 3.5m-kg (26ft-lb)	←
Stator	M6 0.8m-kg ( 6ft-lb)	←
Chassis	YZ125H	YZ250H/465H
Handle crown:		
Steering shaft	M22 12.5m-kg (88ft-lb)	←
Inner tube	M8 2.3m-kg (16ft-lb)	←
Handle holder	M8 2.3m-kg (16ft-lb)	←
Under braket	M8 2.3m-kg (16ft-lb)	←
Front wheel axle	M14 8.5m-kg (60ft-lb)	M14 6.0m-kg (42ft-lb)
Axle holder	M6 1.0m-kg ( 7ft-lb)	M8 2.0m-kg (14ft-lb)
Rear wheel axle	M16 8.5m-kg (60ft-lb)	M18 10.0m-kg (70ft-lb)
Foot rest	M10 6.5m-kg (46ft-lb)	M12 10.0m-kg (70ft-lb)
	M12 8.5m-kg (60ft-lb)	

## INSPECTIONS AND ADJUSTMENTS

### Inspections

After all packed parts are installed, check to see that all these parts and other parts (mounted or installed at the Yamaha factory) are correctly mounted or installed, or tightened or adjusted to specification. This check-up should be started with the front of the machine.

### Item

Wheel spokes	..... Tension
Wheel rims	..... Deflection, alignment
Wheel tires	..... Tire pressure
Wheel axle nuts	..... Tightening torque
Fenders	..... Mounting
Steering head	..... Operation adjustment
Handle holder	..... Tightening torque
Clutch lever	..... Operation, freeplay, mounting
Brake lever	..... Operation, freeplay, mounting
Throttle housing	.. Operation, position, freeplay, mounting
Number plate	..... Mounting
Engine mounting bolt	..... Tightening torque
Carburetor joints	..... Tightness
Footrest	..... Position, mounting
Shift pedal	..... Operation, mounting
Brake pedal	..... Operation, freeplay, mounting
Seat	..... Mounting
Fuel tank	..... Mounting
Fuel pipe	..... Connection, mounting
Fuel breather pipe	..... Connection, routing
Rear shock absorber	..... Mounting, cotter pin
Swing arm pivot shaft	..... Tightening torque
Chain puller	..... Alignment
Transmission	..... Oil level
Control cables	..... Lubrication
Electrical components	..... Operation, adjustment

## TROUBLESHOOTING

If the engine will not start or will not start easily after inspections and adjustment, check the following parts.

### 1. Ignition timing — Checking and adjustment

After starting the engine, check the ignition timing, and if necessary, adjust.

Ignition timing (B.T.D.C.):

YZ125H: 2.27 mm (0.089 in)

YZ250H: 0.61 mm (0.024 in)

YZ465H: 2.0 mm (0.08 in)

### 2. Spark plug-checking and adjustment

When the machine is stored or not used for a long period of time, oil may accumulate on the spark plug. If so, hard starting will result. Remove the spark plug, and clean it as required.

Spark plug:

YZ125H: N-59G

YZ250H: N-2G (Champion)

YZ465H: N-3

### 3. Carburetor — Cleaning

- Put a rag under the carburetor so fuel does not contact the crankcase.
- Loosen the drain screws and drain the standing fuel.
- Retighten the drain screws securely.

#### WARNING:

#### FUEL IS HIGHLY FLAMMABLE:

- \* Always turn off engine when draining.
- \* Take care not to spill any fuel on the engine or exhaust pipes/mufflers when draining.
- \* Never drain fuel while smoking or in the vicinity of an open flame.

## ADJUSTMENTS

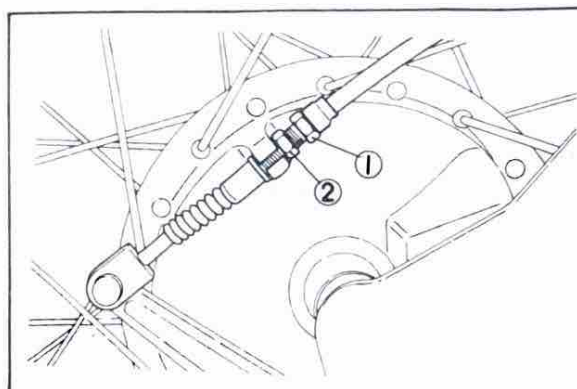
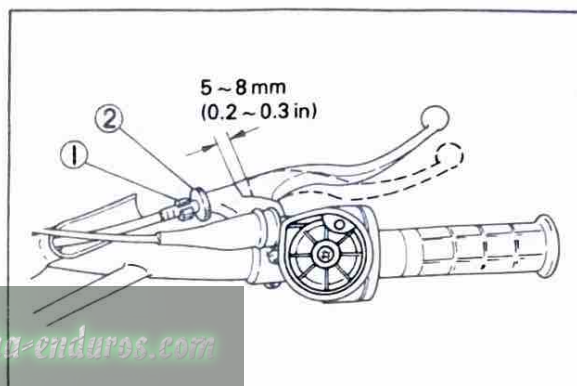
#### NOTE:

This section deals with the main points only. For details, refer to the owner's service manual for this model.

#### Front brake

The front brake should be adjusted to suit rider preference within a 5 ~ 8 mm (0.2 ~ 0.3 in) free play at the lever pivot side.

- Loosen the adjuster lock nut.
- Turn the cable length adjuster in or out until adjustment is suitable.
- Tighten the adjuster lock nut.



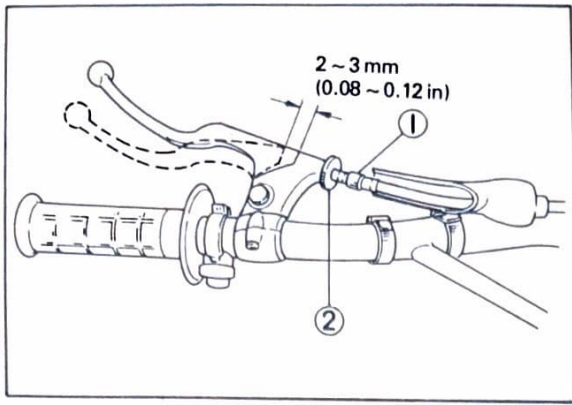
1. Adjuster 2. Lock nut

#### Clutch wire

The clutch should be adjusted to suit rider preference within a 2 ~ 3 mm (0.08 ~ 0.12 in) free play at the lever pivot side.

Loosen the clutch wire adjuster lock nut at the clutch lever, and adjust the clutch wire by turning the wire adjuster.

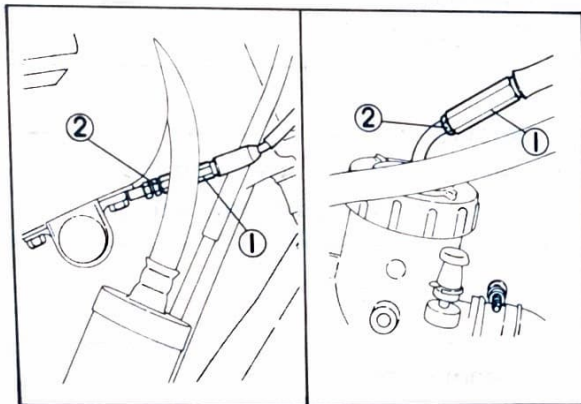
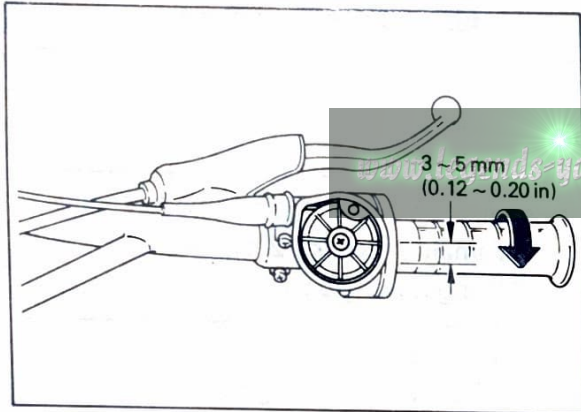
Turning the adjuster clockwise (the adjuster is tightened) increases clutch wire play, while turning counterclockwise decreases the play.



1. Adjuster 2. Lock nut

### Throttle cable freeplay

Check free play by turning the throttle grip. The free play should be 3 ~ 5 mm (0.12 ~ 0.20 in) at the grip flange. Loosen the lock nut and turn the adjuster to make the necessary adjustment. After adjusting be sure to tight the lock nut properly.

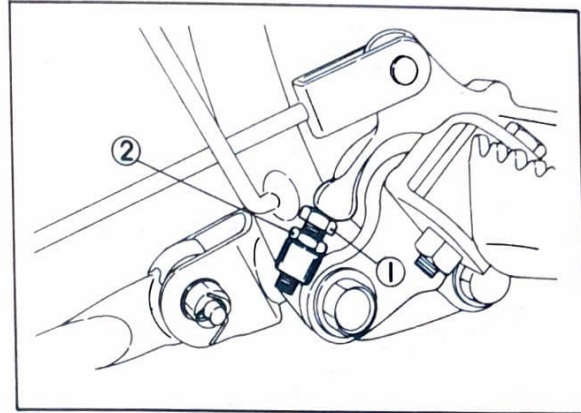


1. Adjuster 2. Lock nut

### Brake pedal position

The position of the rear brake pedal should be adjusted to suit the rider. Loosen the lock nut and adjust the pedal height by turning the adjuster.

After adjusting, check for correct rear brake play. Do not forget to tighten the lock nut.



1. Adjuster 2. Lock nut

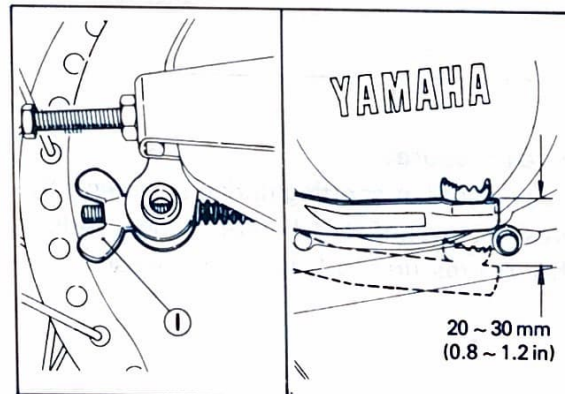
### Rear Brake

The rear brake should be adjusted to suit rider preference within a 20 ~ 30 mm (0.8 ~ 1.2 in) free play at the brake pedal end.

Turn the adjusting nut on the rear brake ferule in or out until brake pedal freeplay is suitable.

#### NOTE:

Rear brake pedal adjustment must be checked whenever chain is adjusted or rear wheel is removed and then re-installed.

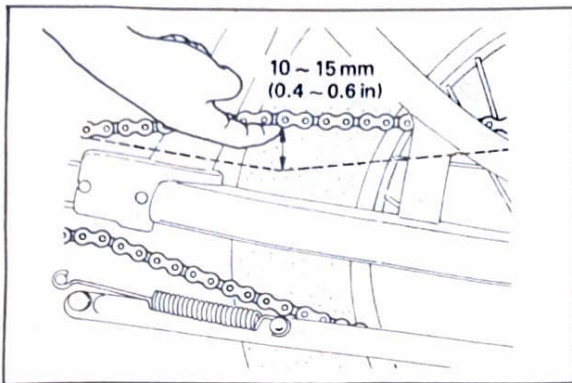


1. Adjuster

### Drive chain tension check

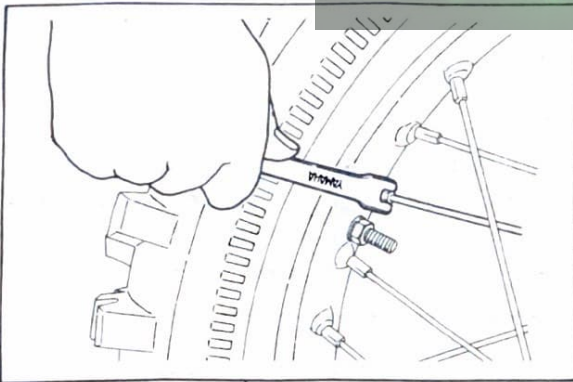
To check the chain play, the machine must stand vertically with its both wheels on the ground and without operator on it.

Check the tension at the position shown in the illustration. The normal vertical deflection is approximately 10 ~ 15 mm (0.39 ~ 0.59 in). If the deflection exceeds 15 mm (0.59 in) adjust the chain tension.



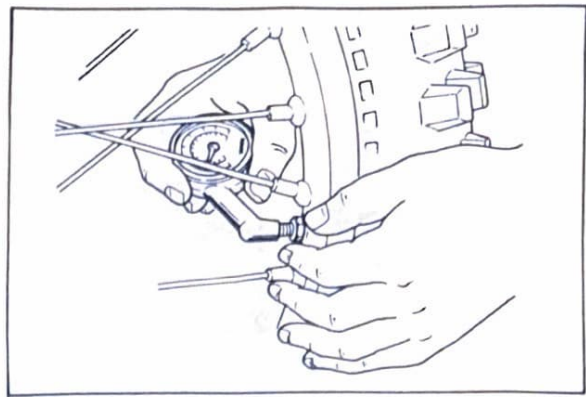
### Spokes

Tap each spoke with an iron rod for sound. If one spoke makes a dull flat sound, then check it for looseness. And tighten it.



### Tire pressures

To prevent flat-spotting during shipment, the tires are overinflated before crating. Adjust the tire pressures to 1.0 kg/cm<sup>2</sup> (14 psi).



### Fuel

Use premium gasoline with an octane rating of 90 +. Mix the gasoline and oil at the specified gas/oil ratio.

#### Tank capacity:

YZ125H: 6.5 lit (1.7 US gal)

YZ250H: 7.6 lit (2.0 US gal)

YZ465H: 9.0 lit (2.4 US gal)

### Engine mixing oil

Recommended oil: Yamalube "R"  
(Yamalube Racing 2-cycle oil)  
Mixing ratio: 16 : 1

If for any reason you should use another oil, select it from the following list.

\*Castrol R30  
Mixing ratio: 20 : 1

#### CAUTION:

Always use the same brand oil. Use only one of the recommended oils.

### Transmission oil

Recommended oil:  
Yamalube 4-cycle oil or SAE  
10W/30 "SE" motor oil

#### Oil capacity (Exchange):

YZ125H: 750 cc (0.8 US qt)

YZ250H: 750 cc (0.8 US qt)

YZ465H: 650 cc (0.69 US qt)

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