



**UNISON**

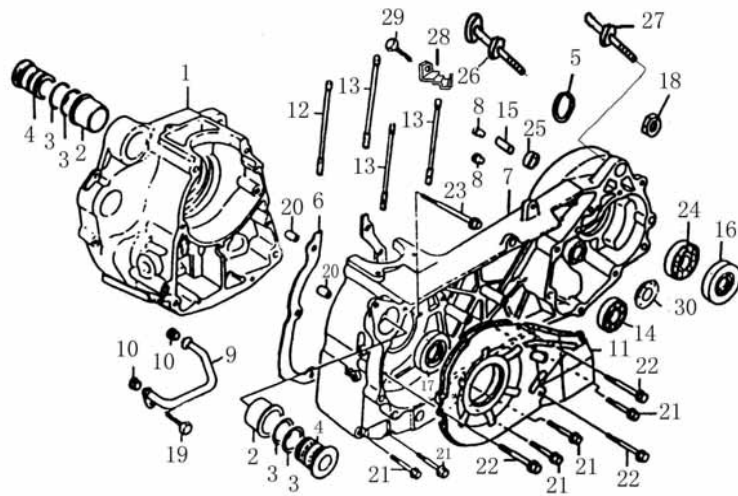
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ILLUSTRATED PARTS LIST

**RAGE 250 & MOBILITY 250**

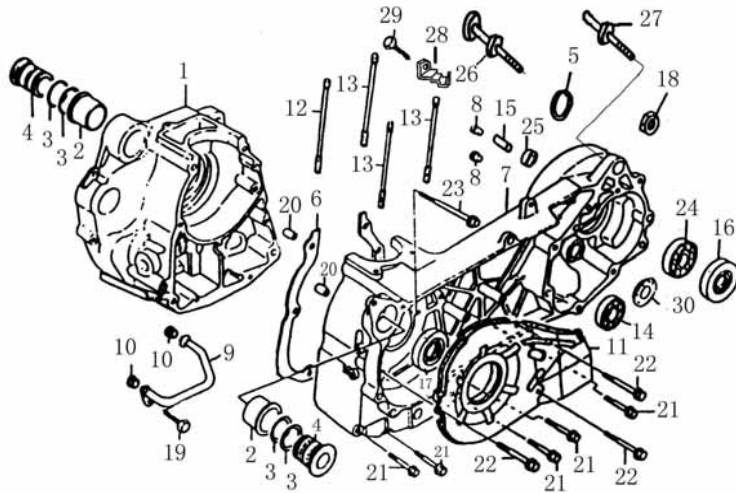
MODELS 2004 AND UP (VER.A)

**250cc SERIES**

**M1****CRANKCASE ASSEMBLY****R 250CC**

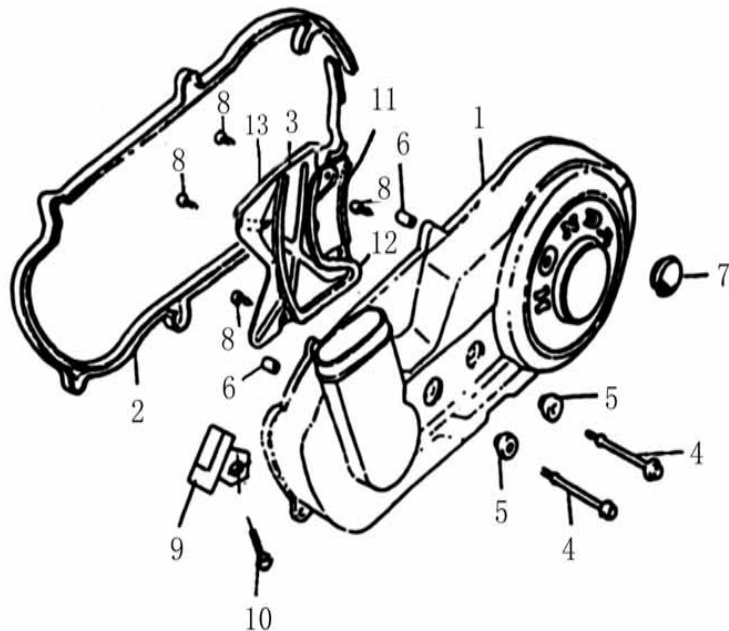
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	07032501	SEA-11200-00	RIGHT CRANKCASE COMP.	1
2	07032502	SEB-11010-00	OUTER BUSH, ENGINE HANGER	2
3	07032503	SEB-11008-00	O-RING, 15.8×2.4	4
4	07032504	SEB-11009-00	INNER BUSH, ENGINE HANGER	2
5	07032505	SEB-11013-00	O-RING, 7.5×1.5	1
6	07032506	SEA-11003-00	GASKET, CRANKCASE	1
7	07032507	SEA-11100-00	LEFT CRANKCASE COMP.	1
8	07032508	172MM-011014	CUSHION WASHER, BRAKE SHOE	2
9	07032509	SEA-11400-00	INNER OIL PIPE SET	1
10	07032510	SEA-11002-00	SEAL RING, INNER OIL PIPE	2
11	07032511	SEA-11300-00	HEAT INSULATOR COMP.	1
12	07032512	SEA-90031-00	BOLT B, CYLINDER STUD	1
13	07032513	SEA-90032-00	BOLT A, CYLINDER STUD	3
14	07032514	TMB301	BEARING	1
15	07032515	172MM-011007	BUSH, FIXING PIN	1
16	07032516	96500-34525-00	SEAL, 34×52×5	1
17	07032517	96500-28408-00	SEAL, 28×40×8	1
18	07032518	94071-08012	THRUST NUT, M8	1
19	07032519	95701-06012-98	BOLT, M6×12	1



**M1****CRANKCASE ASSEMBLY****R 250CC**

ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
20	07000013	94301-10140-00	DOWEL PIN 10X14	2
21	07032521	96001-06060-00	BOLT, M6×60	5
22	07032522	96001-06070-00	BOLT, M6×70	3
23	07032523	96001-06125-00	BOLT, M6×125	1
24	07032524	96110-62050-00	BEARING	1
25	07032525	172MM-011008	SEAL, 14x20x3.5	1
26	07032526	SEA-11010-00	FIXING PIN, BRAKE SHOE	1
27	07032527	172MM-011006	BEARING, REAR SUSPEND	1
28	070325283	172MM-011011	PRESS LINE PLATE, BRAKE CABLE	1
29	07032529	152MI-090005	BOLT, M6x16	1
30	07032530	HMK1416	BEARING	1



**M2****LEFT SIDE COVER ASSEMBLY****R 250CC**

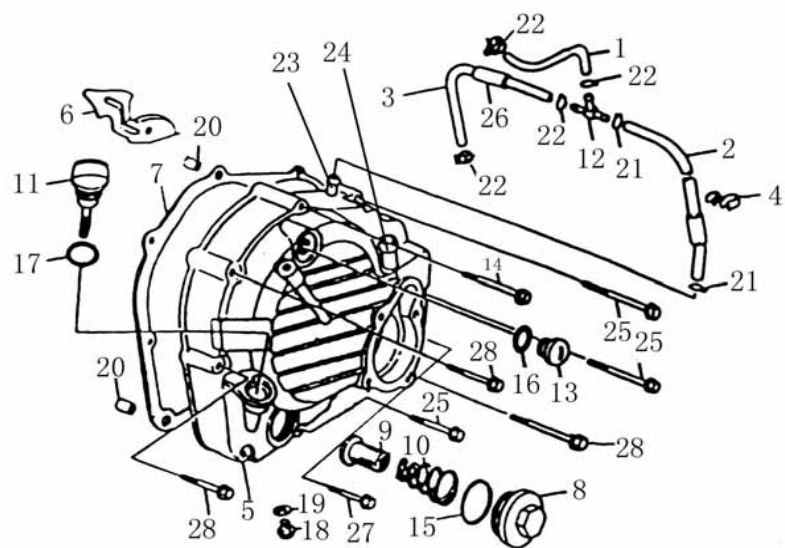
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	40032501	SEA-12001-00	LEFT SIDE COVER	1
2	40032502	SEA-12007-00	SEALING BAR, LEFT SIDE COVER	1
3	40032503	SEA-12004-00	RETAINING PLATE	1
4	40032504	SEA-12003-00	BOLT, COVER PLATE	2
5	40032505	152MI-012200	CUSHION BLOCK COMP.	2
6	40032506	94301-10160	DOWEL PIN, $\phi 10 \times 16$	2
7	40032507	SEA-12008-00	PLUG, INSPECTION	1
8	40032508	93500-05008	FLAT SCREW	4
9	40032509	172MM-012100	CLAMP SET	1
10	37032525	96001-06016-00	BOLT, M6 $\times$ 16	2
11	40032511	172MM-012002	DUTYPROOF STRIP 1	1
12	40032512	172MM-012006	DUTYPROOF STRIP 2	1
13	40032513	172MM-012005	MAT	1



**M3**

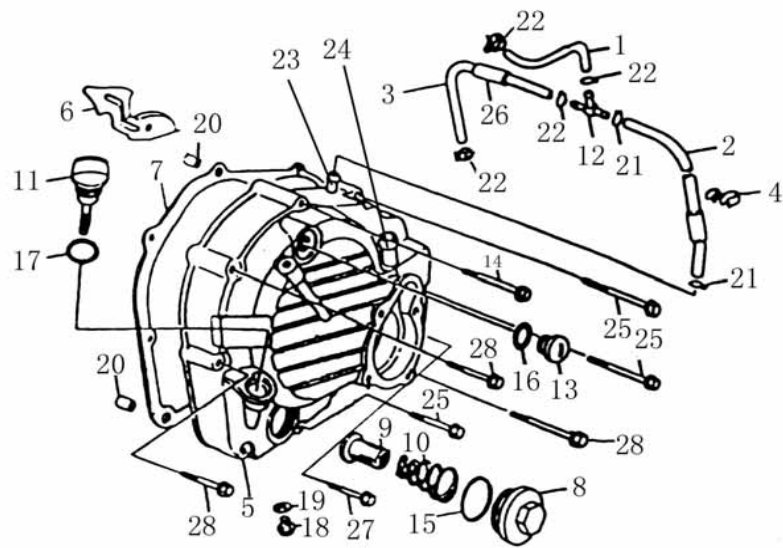
**RIGHT SIDE COVER ASSEMBLY**

**R 250CC**



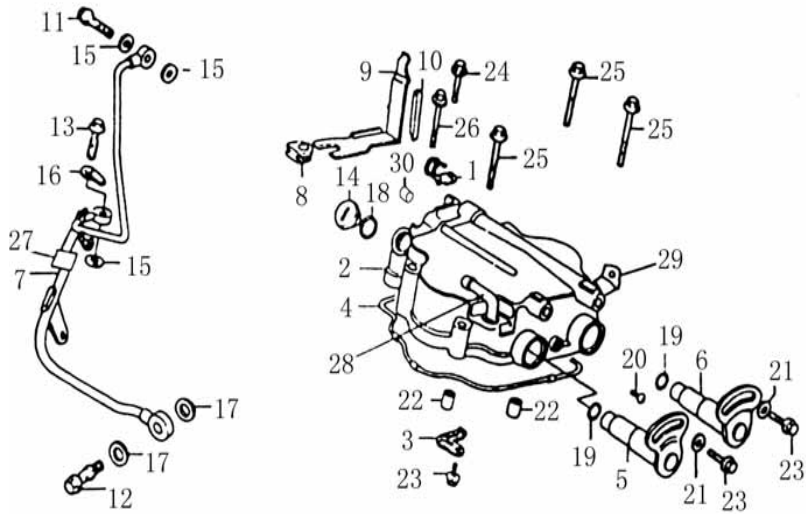
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	30032501	SEA-13013-00	HOSE, BREATHER	1
2	30032502	SEA-13100-00	HOSE COMP., RIGHT SIDE COVER	1
3	30032503	SEA-13015-00	HOSE, AIR CLEANER	1
4	30032504	SEA-13016-00	HOSE CLIP	1
5	30032505	SEA-13002-00	RIGHT SIDE COVER	1
6	30032506	172MM-013008	RETAINING PLATE	1
7	30032507	SEA-13012-00	GASKET, RIGHT SIDE COVER	1
8	30032508	SEA-13007-00	COVER, STRAINER	1
9	30032509	SEB-13100-00	FILTER ELEMENT COMP.	1
10	30032510	SEA-13006-00	SPRING	1
11	30032511	SEA-13001-00	GUIDE, OIL LEVEL	1
12	30032512	SEA-13019-00	T JOINT, BREATHER	1
13	30032513	SEB-21008-00	PLUG, INSPETION	1
14	30032514	SEA-13031-00	BOLT, M6×80	1
15	30032515	UCA-91302-00	O-RING, 30×3.55	1
16	30032516	SEB-21009-00	SEAL RING, PLUG	1
17	30032517	UCA-91307-00	O-RING, 18×3.55	1
18	30032518	92800-12000	DRAIN PLUG, M12×1.5	1
19	30032519	94109-12000	WASHER, 12	2
20	37000062	94301-08140	DOWEL PIN, φ8×14	2



**M3****RIGHT SIDE COVER ASSEMBLY****R 250CC**

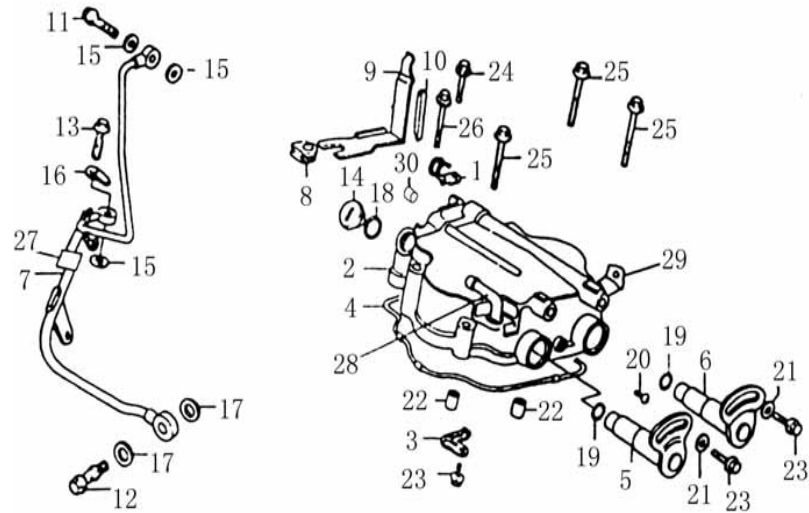
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
21	30032521	SEA-1999A-10	CLIP	2
22	30032522	SEA-1999A-12	CLIP	4
23	30032523	SEA-13010-00	JOINT, BREATHER	1
24	30032524	SEA-13009-00	JOINT, WATER OUTLET	1
25	30032525	96001-06040-00	BOLT, M6×40	3
26	30032526	172MM-013026	OVERSLEEVE, HOSE	1
27	04032515	96001-06028-00	BOLT, M6×28	2
28	07032522	96001-06070-00	BOLT, M6×70	3



**M4****CYLINDER HEAD COVER ASSEMBLY****R 250CC**

ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	36032501	SEA-21009-00	CLIP	1
2	3603502	SEA-21001-00	COVER, CYLINDER HEAD	1
3	36032503	SEA-21006-00	RETAINING PLATE	1
4	36032504	SEB-21011-00	GASKET, CYLINDER HEAD COVER	1
5	36032505	SEC-21100-00	AXLE COMP., INTAKE ROCKER	1
6	36032506	SEC-21200-00	AXLE COMP., EXHAUST ROCKER	1
7	36032507	SEC-21400-00	OUTER OIL PIPE COMP.	1
8	36032508	SEB-21001-00	RUBBER, OIL PIPE	1
9	36032509	SEA-21431-00	HOLDER, OIL PIPE	1
10	36032510	SEB-21003-00	CUSHION BAR	1
11	36032511	SEB-21004-00	JOINT BOLT, M8×25	1
12	36032512	SEB-21015-00	JOINT BOLT, M12×1.25	1
13	36032513	SEB-21013-00	JOINT BOLT C, M8×25	1
14	36032514	SEB-21008-00	CAP, TOP INSPECTION	1
15	36032515	SEA-21016-00	WASHER 8	3
16	36032516	SEB-21012-00	WASHER	1
17	30032519	94109-12000	WASHER 12	2
18	36032518	SEB-21009-00	SEAL RING, TOP CAP	1
19	36032519	SEB-21010-00	SEAL RING, ROCKER AXLE	2
20	63032520	SEA-20000	FLAT SCREW	1



**M4****CYLINDER HEAD COVER ASSEMBLY****R 250CC**

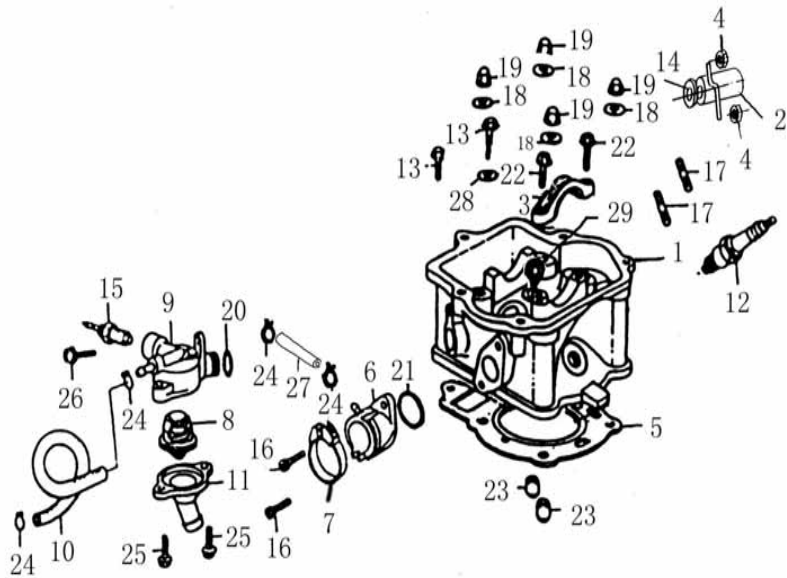
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
21	07032540	94060-06013	WASHER 6×12×1	2
22	07000013	94301-10140-00	DOWEL PIN, φ10×14	2
23	36032523	96001-06012-00	BOLT, M6×12	3
24	07032537	96001-06025-00	FLANGE BOLT 6X25	2
25	36032525	96001-06050-00	BOLT, M6×50	3
26	36032526	96001-06055-00	BOLT, M6×55	1
27	36032527	SEA-21404-00	CUSHION OVERSLEEVE	1
28	36032528	172MM-021002	BREATHER	1
29	36032529	172MM-021300	HOLDER COMP., AIR CLEANER	1
30	36032530	172MM-021008	PLUG	1



M5

CYLINDER HEAD ASSEMBLY

R 250CC



ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	37032501	SEA-22100-00	CYLINDER HEAD COMP.	1
2	37032502	172MM-022700	FLANGE COMP. EXHAUST PIPE	1
3	37032503	SEB-22014-00	COVER, CAMSHAFT BEARING	1
4	37032504	172MM-022008	NUT, EXHAUST PIPE	2
5	37032505	SEA-22010-00	GASKET, CYLINDER HEAD	1
6	37032506	SEA-22900-00	JOINT COMP., CARBURETOR	1
7	37032507	SEA-22500-00	CLAMP SET, INTAKE	1
8	37032508	SEB-22810-00	THERMOSTAT COMP.	1
9	37032509	SEB-22803-00	UPPER CASE, THERMOSTAT	1
10	37032510	SEB-22021-00	COOLING HOSE I , CARBURETOR	1
11	377032511	SEA-22601-00	LOWER CASE, THERMOSTAT	1
12	37032512	DPR7EA-9	SPARK PLUG COMP.	1
13	07032537	96001-06025	BOLT, M6×25	2
14	37032514	172MM-022800	GASKET, EXHAUST PORT	1
15	37032515	SEB-22600-00	TRANSDUCER, WATER TEMPERATURE	1
16	37032516	HS06018D-A+K	SCREW, INNER HEX HEAD	2
17	37032517	172MM-022007	STUD, EXHAUST PIPE	2
18	37032518	UCA-90465-00	WASHER 8	4
19	37032519	SEB-22013-00	CAP NUT M8	4
20	37032520	SEB-22804-00	O-RING, 14.8×1.9	1

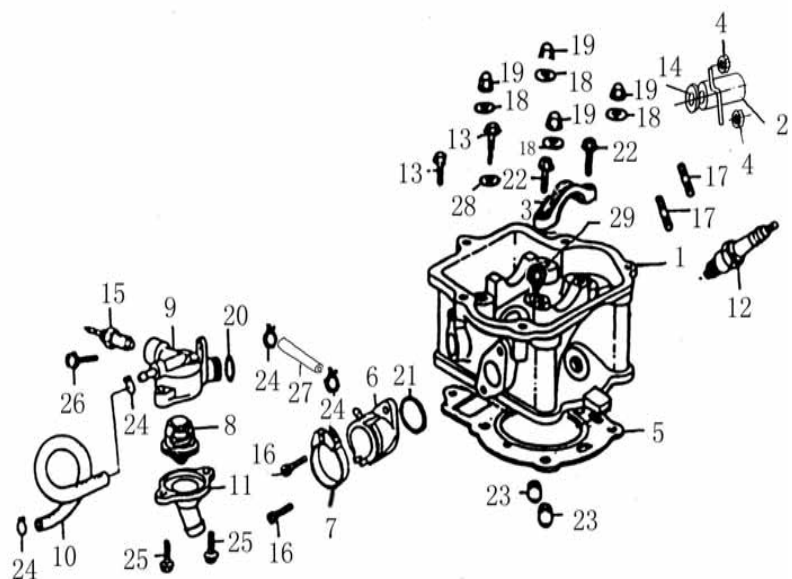


**M5**

**CYLINDER HEAD ASSEMBLY**

**R 250CC**

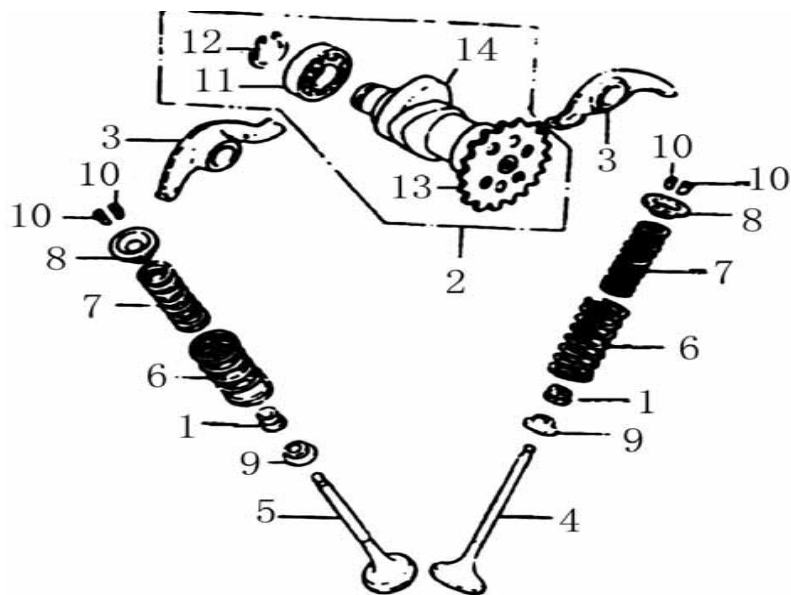
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
21	37032521	SEA-22009-00	O-RING, 31×2	1
22	01032514	96001-06022-00	BOLT, M6×22	2
23	07000013	94301-10140-00	DOWEL PIN 10X14	2
24	37032524	SEA-1999A-6	CLIP	4
25	37032525	96001-06016-00	BOLT, M6×16	2
26	01032513	96001-06018-00	BOLT, M6×18	2
27	37032527	SEB-22017-00	BREATHER PIPE · CARBURETER	1
28	07032540	94060-06013	WASHER 6×12×1 (RG/MT 250)	2
29	37032529	SEB-23303-00	PLUGM12×1	1



**M6**

**AIR MIX DEVICE**

**R 250CC**



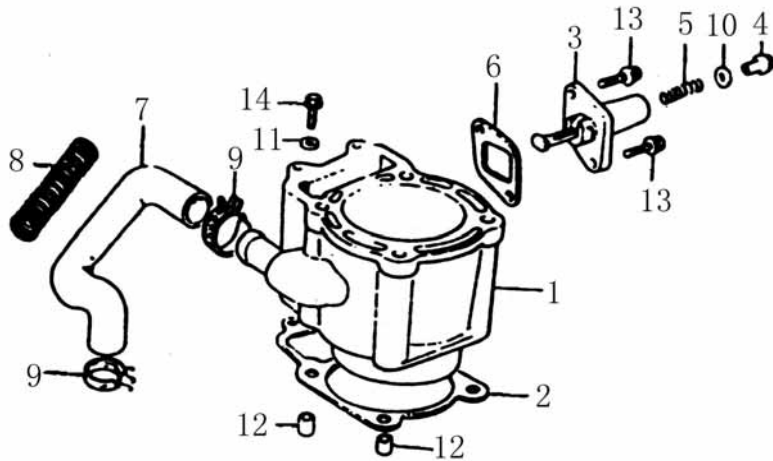
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	03032501	SEB-22500-00	SEAL RING SET	2
2	03032502	SEA-14100-00 & NTN: 16002	CAMSHAFT COMP.	1
3	03032503	SEB-21007-00	ARM, VALVE ROCKER	2
4	03032504	SEA-22001-00	VALVE, INTAKE	1
5	03032505	SEA-22005-00	VALVE, EXHAUST	1
6	03032506	SEA-22002-00	OUTER SPRING, VALVE	2
7	03032507	SEA-22003-00	INNER SPRING, VALVE	2
8	03032508	SEB-22005-00	RETAINER, VALVE SPRING	2
9	03032509	SEB-22001-00	SEAT, VALVE SPRING	2
10	03032510	SEB-22006-00	VALVE CLIP	4
11	03032511	NTN: 16002	BEARING	1
12	03032512	GB894. 1-86-15	CIRCLIP	1
13	03032513	172MM-022310	CHAIN WHEEL	1
14	03032514	172MM-022301	CAMSHAFT	1



**M7**

**CYLINDER BODY ASSEMBLY**

**R 250CC**



ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	01032501	SEA-23100-00	CYLINDER BODY COMP.	1
2	01032502	SEA-23002-00	GASKET, CYLINDER	1
3	01032503	SEB-23300-00	TENSIONER COMP.	1
4	01032504	SEB-23307-00	BOLT, SPRING HOLDER	1
5	01032505	SEB-23306-00	SPRING	1
6	01032506	SEB-23004-00	GASKET, TENSIONER	1
7	01032507	SEA-23007-00	HOSE, WATER INLET	1
8	01032508	172MM-023009	GUARD SHIELD, WATER PIPE	1
9	01032509	SEA-1999B-24	CLAMP	2
10	01032510	SEB-23005-00	WASHER 8.5	1
11	07032540	94060-06013	WASHER 6×12×1	2
12	07000013	94301-10140-00	DOWEL PIN 10X14	2
13	01032513	96001-06018-00	BOLT, M6×18	2
14	01032514	96001-06022-00	BOLT, M6×22	2

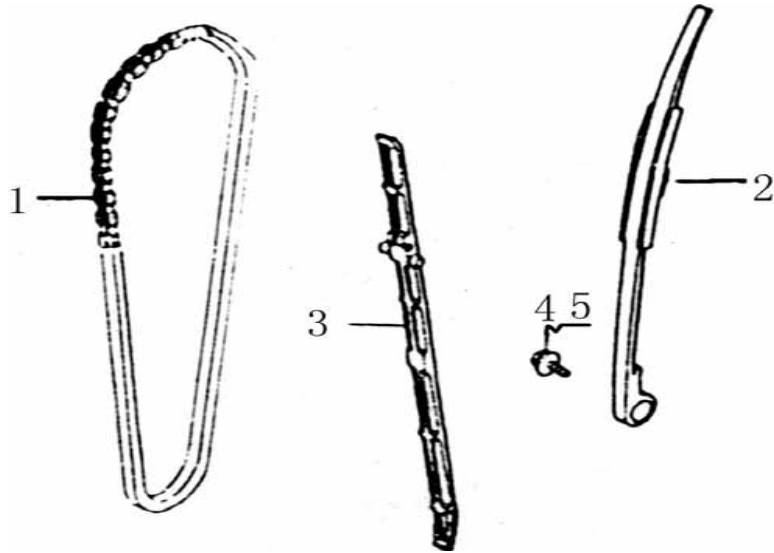


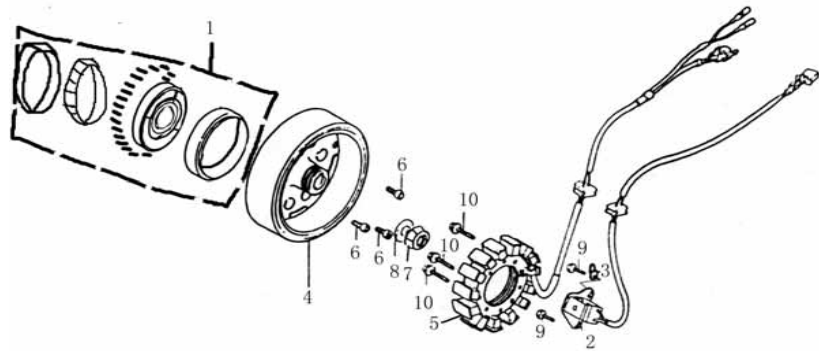
M8

# CAMSHAFT CHAIN

R 250CC

ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	38032501	SEA-14401-00	CHAIN, CAMSHAFT DRIVE	1
2	3832502	SEA-23200-00	TENSIONER SET, CHAIN	1
3	38032503	SEA-23001-00	GUIDE, CHAIN	1
4	38032504	94060-06018-07	BIG GASKET	1
5	38032505	95701-06012-98	HEX BOLT	1



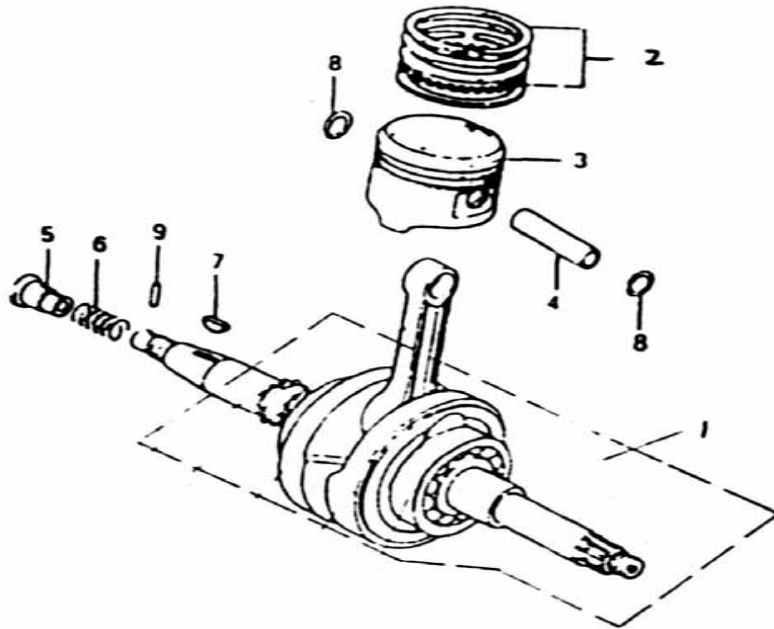
**M9****ACG****R 250CC**

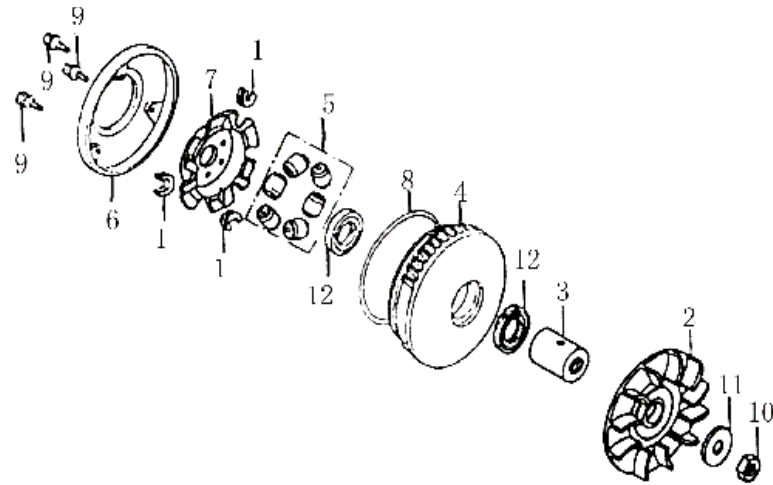
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	10032501	SEA-94000-00	OVERRIDING CLUTCH COMP.	1
2	10032502	SEA-33000-00	COIL, PICK UP	1
3	10032503	SEA-13008-00	HOLDER, WIRE	1
4	10032504	SEA-31000-00	ROTOR COMP.	1
5	10032505	SEA-32000-00	COIL ASSEMBLY, STARTER	1
6	10032506	HS08018D-A+K	SCREW, INNER HEX HEAD	3
7	10032507	SEA-40001-00	NUT, M16×1	1
8	10032508	SEA-40002-00	WASHER, 16.3×30×2	1
9	10032509	95701-05016-08	BOLT, M5×16	2
10	10032510	96001-06030-00	BOLT, M6×30	3
11	10032511	SEA-30000-00	MAGNETO ASSY	1



**M10****CRANKSHAFT ASSEMBLY & PISTON****R 250CC**

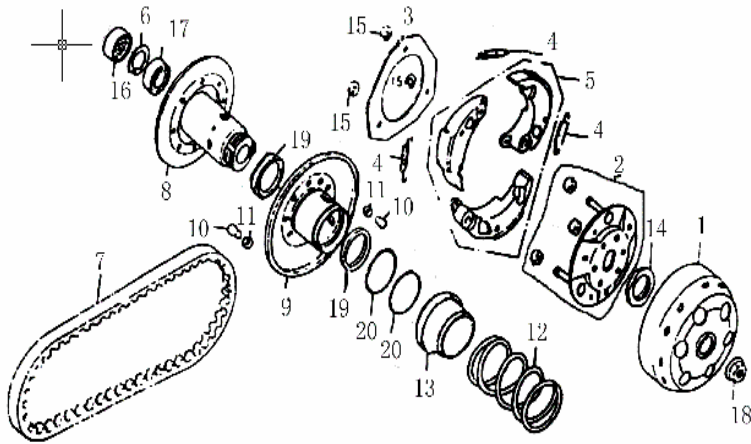
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	02032501	SEA-41000-00	CRANKSHAFT COMP.	1
2	02032502	SEA-4A000-00	OIL RING SET	1
3	02032503	SEA-40005-00	PISTON	1
4	02032504	SEA-40007-00	PIN, PISTON	1
5	02032505	SEB-40011-00	JOINT, OIL PASSAGE	1
6	02032506	SEB-40010-00	SPRING , JOINT	1
7	02032507	UCA-90720-00	CIRCULAR KEY	1
8	02032508	SEA-40006-00	CIRCLIP, PISTON PIN	2
9	02032509	SEA-20002-00	PIN	1



**M11****GEARSHIFT ASSEMBLY****R 250CC**

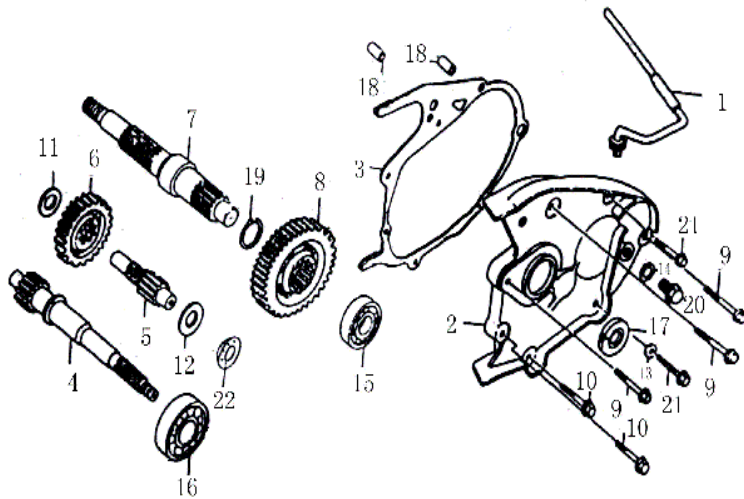
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	12032523	SEA-51004-00	SLIDING PIECE	3
2	12032524	SEA-51005-00	DRIVE FACE COMP.	1
3	12032525	SEA-51003-00	COLLAR, DRIVE FACE	1
4	12032526	SEA-51100-00	MOVABLE DRIVE FACE COMP.	1
5	12032527	SEA-51200-00	WEIGHT ROTOR COMP.	1
6	12032528	SEA-51001-00	COVER, DRIVE FACE	1
7	12032529	SEA-51002-00	RAMP PLATE	1
8	12032530	SEA-112-265	O-RING 112×2.65	1
9	12032531	92101-04010-08	BOLT SET M4×10	3
10	12032532	SEA-51007-00	NUT, M14×1.5	1
11	12032533	SEA-51006-00	WASHER, 14.5×30×2	1
12	12032534	SEB-51003-00	SEAL, 27×34×3.5	1



**M12****CLUTCH ASSEMBLY****R 250CC**

ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	09032501	SEA-52500-00	CLUTCH OUTER COMP.	1
2	09032502	172MM-052400	HUB, CLUTCH RELEASE	1
3	09032503	172MM-052003	END PLATE, CLUTCH	1
4	09032504	172MM-052006	RETURN SPRING, CLUTCH	3
5	09032505	SEA-52600-00	WEIGHT SET, CLUTCH	1
6	09032506	GB/T8931-86-28	CIRCLIP	1
7	09032507	SEA-52700-00	DRIVEN BELT	1
8	09032508	SEA-52300-00	DRIVEN FACE COMP.	1
9	09032509	SEA-52100-00	MOVABLE DRIVEN FACE COMP.	1
10	09032510	172MM-052002	GUIDE PIN	2
11	09032511	172MM-052001	ROLLAR, GUIDE	2
12	09032512	SEA-52004-00	SPRING, CLUTCH	1
13	09032513	172MM-052200	SEAL COLLAR	1
14	09032514	SEA-52005-00	RETAINING NUT, M30X1	1
15	09032515	GB/T896-86-6	CIRCLIP	2
16	09032516	GB278-89-1060902	BEARING	1
17	09032517	172MM-052310	BEARING, NEEDLE 22X29X18	1
18	09032518	172MM-052008	BOLT, M12X1.25	1
19	09032519	172MM-052104	SEAL, MOVABLE DRIVEN FACE	2
20	09032520	GB3452.1-82-46.2X1.8	O-RING	2



**M13****TRANSMISSION****R 250CC**

ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	12032501	SEA-62000-00	BREATHER HOSE COMP.	1
2	12032502	SEA-60009-00	COVER, GEARBOX	1
3	12032503	SEA-61000-00	GASKET COMP., GEARBOX COVER	1
4	12032504	SEA-60001-00	DRIVE SHAFT	1
5	12032505	SEA-60003-00	COUNTER SHAFT COMP.	1
6	12032506	SEA-60006-00	GEAR, COUNTER SHAFT	1
7	12032507	SEA-23431-00	FINAL SHAFT	1
8	12032508	SEA-60008-00	FINAL GEAR	1
9	12032509	92101-08038-10	BOLT, M8×38	3
10	12032510	92101-08028-10	BOLT, M8×28	1
11	12032511	SEB-60003-00	THRUST WASHER 14	1
12	12032512	SEA-60004-00	THRUST WASHER 14	1
13	12032513	UCA-90461-00	WASHER 6	1
14	12032514	UCA-90545-00	WASHER 10	1
15	12032515	96100-6304	BEARING	1
16	12032516	96100-62/22	BEARING, 22×50×14	1
17	12032517	96500-22356	SEAL	1
18	07000013	94301-10140-00	DOWEL PIN, $\varphi$ 10×14	2
19	12032519	GB/T894.1-86-24	CIRCLIP	1
20	12032520	95701-10012-08	DRAIN PLUG, M10×1.25	1

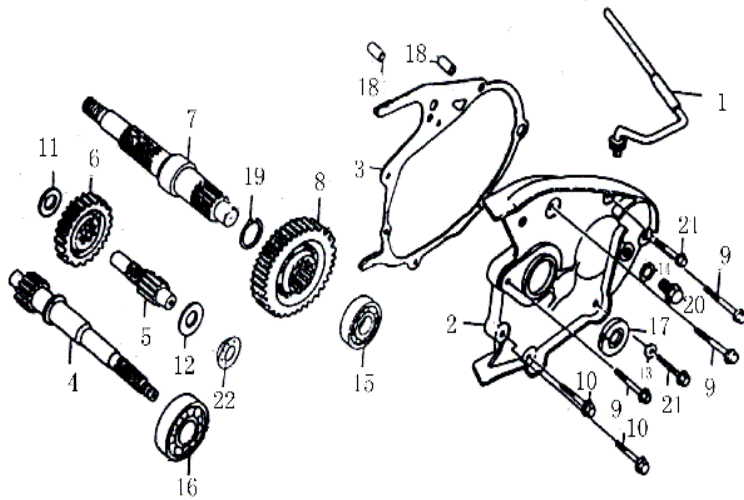


M13

# TRANSMISSION

R 250CC

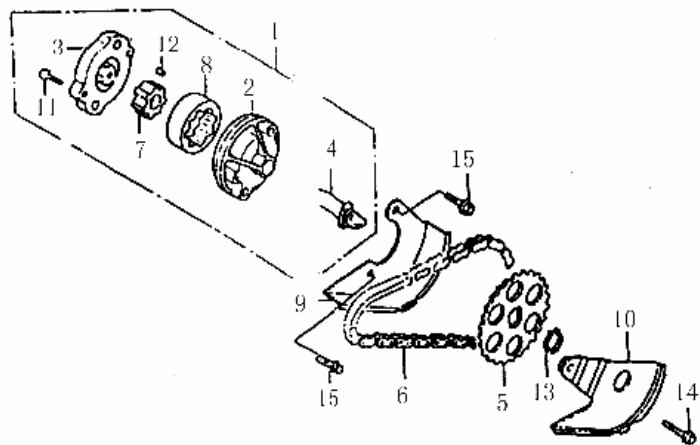
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
21	12032521	96001-06032-00	BOLT, M6×32	2
22	12032522	HMK-1416	BEARING, NEEDLE	1



**M14**

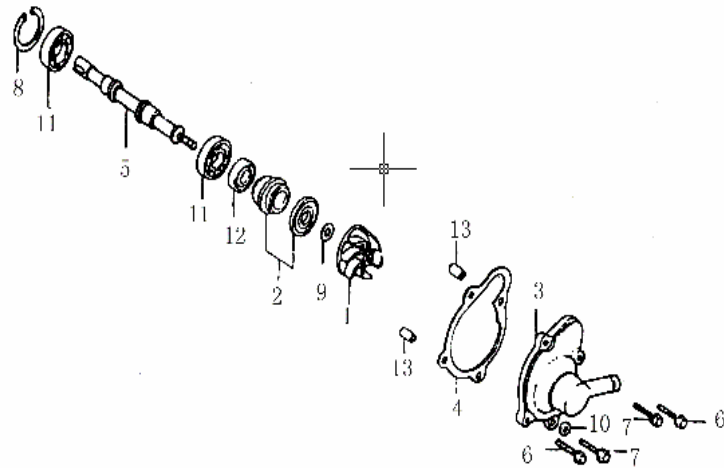
**OIL PUMP ASSEMBLY**

**R 250CC**



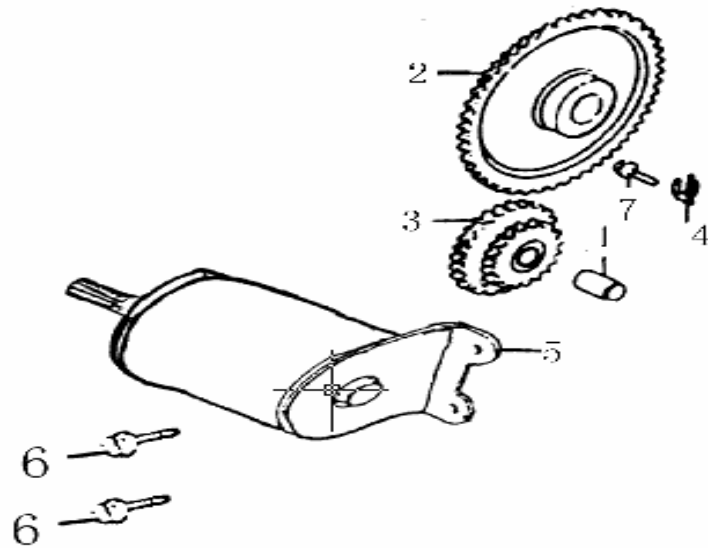
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	04032501	SEB-71000-00 & 152MI-071002 & 152MI-071003 & 152MI-071001 & 152MI-071004 & 152MI-071005	OIL PUMP COMP.	1
2	04032502	152MI-071002	OIL PUMP BODY	1
3	04032503	152MI-071003	COVER PLATE, OIL PUMP	1
4	04032504	152MI-071001	SHAFT, OIL PUMP	1
5	04032505	SEB-70001-00	SPROCKET, OIL PUMP	1
6	04032506	SEB-73000-00	CHAIN, OIL PUMP	1
7	04032507	152MI-071004	INNER ROTOR, OIL PUMP	1
8	04032508	152MI-071005	OUTER ROTOR, OIL PUMP	1
9	04032509	SEB-70002-00	SEPERATING PLATE COMP. A	1
10	04032510	SEB-72000-00	SEPERATING PLATE COMP. B	1
11	04032511	GB878-85-M3X12	SCREW	1
12	04032512	152MI-071006	DOWEL PIN, 4X6.5	1
13	04032513	94510-10000	CIRCLIP	1
14	36032523	96001-06012-00	BOLT, M6×12	3
15	04032515	96001-06028-00	BOLT, M6×28	2



**M15****WATER PUMP ASSEMBLY****R 250CC**

ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	07032531	SEA-80004-00	IMPELLER, WATER PUMP	1
2	07032532	SEB-81000-00	WATER SEAL COMP.	1
3	07032533	SEA-80003-00	COVER, WATER PUMP	1
4	07032534	SEA-80002-00	GASKET, WATER PUMP COVER	1
5	07032535	SEA-80001-00	SHAFT, WATER PUMP	1
6	30032525	96001-06040-00	BOLT M6×40	3
7	07032537	96001-06025	BOLT, M6×25	2
8	07032538	94520-19000	CIRCLIP	1
9	07032539	SEB-80007-00	WASHER 7.5×13×1.2	1
10	07032540	94060-06013	WASHER 6×12×1	2
11	07032541	96100-6800	BEARING	2
12	07032542	SEA-80005-00	OIL SEAL 10×20×5	1
13	7032520	94301-080140-00	DOWEL PIN, φ8×14	2



**M16****ELECTRICAL STARTING ASSEMBLY****R 250CC**

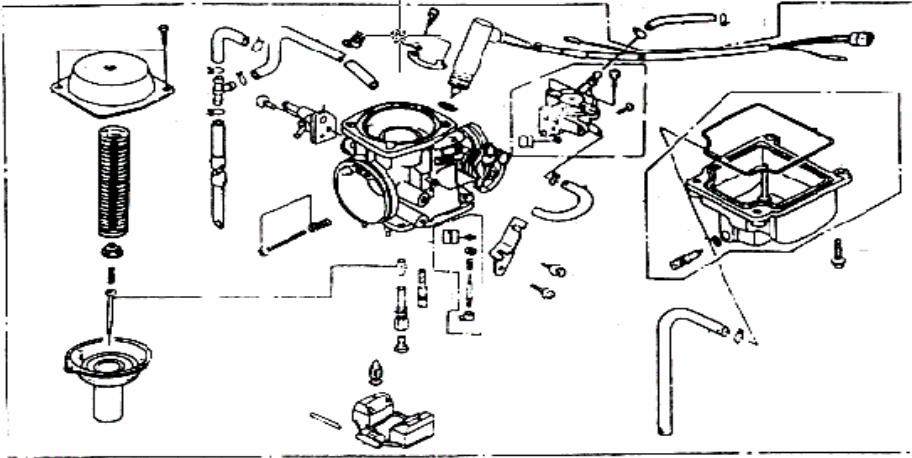
ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	11032501	SEA-90001-00	SHAFT, GEAR COMPOUND	1
2	11032502	SEA-92000-00	DRIVEN GEAR COMP.	1
3	11032503	SEA-91000-00	GEAR COMPOUND	1
4	11032504	SEA-90007-00	HOLDER	1
5	11032505	SEA-93000-00	STARTING MOTOR COMP.	1
6	01032514	96001-06022-00	BOLT, M6×22	2
7	11032507	96001-06014-00	BOLT, M6×14	1



**M17**

**CARBURETOR ASSEMBLY**

**R 250CC**



ITEM	UNISON NO.	PARTS NO.	DESCRIPTION	QTY
1	06032501	SEA-16100-00	CARBURETOR ASSY.	1

