

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
B01 ENGINE				
ENGINE, OH	SKYACTIV-G 1.3,Without i-ELOOP system	B0101AHX	20.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.3,With i-ELOOP system	B0101QHX	20.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0101BHX	20.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts	B0101CHX	20.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop,Without Mazda M Hybrid]</i>	B0101SHX	20.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0101THX	20.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R

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ENGINE, OH	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT	B0101UHX	20.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-stop,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-stop]</i>	B01012HX	20.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT	B0101VHX	20.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop	B01013HX	20.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0101DHX	20.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0101EHX	20.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R

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ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0101FHX	20.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0101GHX	20.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0101HHX	20.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0101JHX	20.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0101WHX	20.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0101YHX	20.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0101ZHX	20.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head (B0401), R&R◆Piston (B0507), R&R

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ENGINE, OH	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B01011HX	20.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-stop,With Mazda M Hybrid</i>	<i>B01014HX</i>	<i>21.0</i>	<i>◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R</i>
ENGINE, OH	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop,With Mazda M Hybrid</i>	<i>B01015HX</i>	<i>20.8</i>	<i>◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R</i>
ENGINE, OH	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0101RHX	23.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	[SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts]/[SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts]	B0101KHX	23.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0101LHX	23.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0101MHX	23.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
ENGINE, OH	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0101PHX	23.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, OH	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0101NHX	23.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head (B0401), R&R ◆Piston (B0507), R&R
ENGINE, R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0101ARX	5.6	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.3,With i-ELOOP system	B01011RX	5.7	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,5MT,PCM cover with standard bolts,Without i-stop	B0101BRX	5.4	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,5MT,PCM cover with standard bolts,With i-stop	B0101CRX	5.5	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,5MT,PCM cover with shear-off bolts	B0101DRX	5.6	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,6MT,PCM cover with standard bolts	B0101ERX	5.4	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,6MT,PCM cover with shear-off bolts	B0101FRX	5.5	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,6AT	B0101GRX	5.6	◆Front crossmember assembly, R&R

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ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Without Mazda M Hybrid	B01014RX	5.8	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,5MT,PCM cover with standard bolts	B0101HRX	5.5	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,5MT,PCM cover with shear-off bolts	B0101JRX	5.6	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6MT,PCM cover with standard bolts,Without i-ELOOP system	B0101KRX	5.5	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6MT,PCM cover with standard bolts,With i-ELOOP system	B0101LRX	5.6	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6MT,PCM cover with shear-off bolts,Without i-ELOOP system	B0101MRX	5.6	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6MT,PCM cover with shear-off bolts,With i-ELOOP system	B0101NRX	5.8	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6AT,PCM cover with standard bolts,Without i-ELOOP system	B0101PRX	5.7	◆Front crossmember assembly, R&R

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ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6AT,PCM cover with standard bolts,With i-ELOOP system	B0101QRX	5.8	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6AT,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0101RRX	5.7	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6AT,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0101SRX	5.9	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,6AT,PCM cover with shear-off bolts,With i-stop	B0101TRX	5.8	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve	B01015RX	5.9	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With Mazda M Hybrid,PCM cover with shear-off bolts	B01016RX	6.0	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With Mazda M Hybrid,PCM cover with standard bolts	B01017RX	5.8	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B01012RX	6.8	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B01013RX	7.0	◆Front crossmember assembly, R&R

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ENGINE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0101URX	7.0	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0101VRX	7.2	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0101WRX	7.0	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0101ZRX	7.2	◆Front crossmember assembly, R&R
ENGINE, R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0101YRX	7.1	◆Front crossmember assembly, R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0102ARX	11.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆ Timing chain (B0210), R&R ◆ Cylinder head gasket (B0402), R&R ◆ Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0102SRX	11.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆ Timing chain (B0210), R&R ◆ Cylinder head gasket (B0402), R&R ◆ Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0102BRX	11.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆ Timing chain (B0210), R&R ◆ Cylinder head gasket (B0402), R&R ◆ Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0102CRX	11.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆ Timing chain (B0210), R&R ◆ Cylinder head gasket (B0402), R&R ◆ Oil pan gasket (D0201), R&R

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SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, Without i-stop	B0102DRX	11.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, With i-stop	B0102ERX	11.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, Without i-stop	B01024RX	11.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, With i-stop, Without Mazda M Hybrid	B0102URX	11.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 5MT	B0102VRX	12.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 6MT, With i-stop, Without Mazda M Hybrid] [SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 6MT, Without i-stop]	B01023RX	11.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R

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SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT	B0102WRX	11.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0102FRX	11.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0102GRX	11.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0102HRX	11.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0102JRX	11.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0102KRX	11.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0102LRX	11.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R

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SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0102YRX	11.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0102ZRX	12.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B01021RX	12.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B01022RX	12.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-stop,With Mazda M Hybrid	B01025RX	12.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,With Mazda M Hybrid	B01026RX	12.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0102TRX	14.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0102MRX	14.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B01027RX	14.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0102NRX	14.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0102PRX	14.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0102RRX	14.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
SHORT ENGINE, R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0102QRX	14.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0103ARX	7.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PARTIAL ENGINE, R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0103RRX	7.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0103BRX	7.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0103CRX	7.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts	B0103DRX	7.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT	B0103TRX	7.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0103VRX	7.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop,Without Mazda M Hybrid	B01034RX	7.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop	B01035RX	7.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT	B0103URX	8.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-stop,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-stop]	B01033RX	7.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT	B0103WRX	7.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0103ERX	7.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0103FRX	7.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0103GRX	7.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0103HRX	7.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0103JRX	7.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0103KRX	8.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0103YRX	7.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0103ZRX	8.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B01031RX	8.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Intake manifold gasket (F0102), R&R◆Exhaust manifold gasket (F0202), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B01032RX	8.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop,With Mazda M Hybrid	B01036RX	8.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-stop,With Mazda M Hybrid	B01038RX	8.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R ◆Exhaust manifold gasket (F0202), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0103SRX	10.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0103LRX	10.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B01037RX	10.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0103MRX	10.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0103NRX	10.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0103QRX	10.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R
PARTIAL ENGINE, R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0103PRX	10.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Intake manifold gasket (F0102), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
B02 ENGINE FRONT				
TIMING CHAIN [GEAR] COVER, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,With i-stop]	B0201ARX	3.4	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Without i-stop	B0201BRX	3.3	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Without i-stop	B0201CRX	3.4	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,With i-stop	B0201DRX	3.5	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Without i-stop	B0201HRX	3.4	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve]	B0201GRX	3.5	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts	B0201ERX	5.1	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts	B0201FRX	5.3	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN [GEAR] COVER GASKET, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0202ARX	3.3	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve	B0202BRX	3.4	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER GASKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Without i-stop	B0202FRX	3.4	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER GASKET, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve]	B0202ERX	3.5	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER GASKET, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts	B0202CRX	5.0	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
TIMING CHAIN [GEAR] COVER GASKET, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts	B0202DRX	5.2	◆Cylinder head cover gasket (B0403), R&R ◆Crankshaft pulley (B0206), R&R◆Oil pan gasket (D0201), R&R
OIL SEAL [CRANKSHAFT FRONT], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5,Without Coolant Control Valve]/[SKYACTIV-G 1.5,With Coolant Control Valve,Without Mazda M Hybrid]	B0204ARX	0.6	◆Crankshaft pulley (B0206), R&R
OIL SEAL [CRANKSHAFT FRONT], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,With Mazda M Hybrid	B0204CRX	0.7	◆Crankshaft pulley (B0206), R&R
OIL SEAL [CRANKSHAFT FRONT], R&R	SKYACTIV-D 1.5	B0204BRX	0.7	◆Crankshaft pulley (B0206), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CRANKSHAFT PULLEY AND/OR PLATE, R&R	<i>[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5,Without Coolant Control Valve]/[SKYACTIV-G 1.5,With Coolant Control Valve,Without Mazda M Hybrid]</i>	B0206ARX	0.6	
CRANKSHAFT PULLEY AND/OR PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,With Mazda M Hybrid	B0206CRX	0.7	
CRANKSHAFT PULLEY AND/OR PLATE, R&R	SKYACTIV-D 1.5	B0206BRX	0.7	
TIMING CHAIN, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0210ARX	3.6	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
TIMING CHAIN, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Without i-stop	B0210BRX	3.7	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
TIMING CHAIN, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,With i-stop	B0210CRX	3.8	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
TIMING CHAIN, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Without i-stop	B0210GRX	3.7	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
TIMING CHAIN, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve]	B0210FRX	3.8	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
TIMING CHAIN, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts	B0210DRX	5.6	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
TIMING CHAIN, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts	B0210ERX	5.8	◆Timing chain cover gasket (B0202), R&R◆ Chain adjuster assembly (B0212), R&R
CHAIN ADJUSTER ASSEMBLY, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0212ARX	3.5	◆Timing chain cover gasket (B0202), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CHAIN ADJUSTER ASSEMBLY, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Without i-stop	B0212BRX	3.6	◆Timing chain cover gasket (B0202), R&R
CHAIN ADJUSTER ASSEMBLY, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,With i-stop	B0212CRX	3.7	◆Timing chain cover gasket (B0202), R&R
CHAIN ADJUSTER ASSEMBLY, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Without i-stop	B0212GRX	3.7	◆Timing chain cover gasket (B0202), R&R
CHAIN ADJUSTER ASSEMBLY, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve]	B0212FRX	3.7	◆Timing chain cover gasket (B0202), R&R
CHAIN ADJUSTER ASSEMBLY, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts	B0212DRX	5.1	◆Timing chain cover gasket (B0202), R&R
CHAIN ADJUSTER ASSEMBLY, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts	B0212ERX	5.3	◆Timing chain cover gasket (B0202), R&R
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.3,Camshaft side,Intake camshaft side]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Camshaft side,Intake camshaft side]	B0223ARX	1.5	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.3,Camshaft side,Exhaust camshaft side]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Camshaft side,Exhaust camshaft side]	B0223BRX	1.2	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.3,Camshaft side,All (Intake camshaft side and exhaust camshaft side)]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side)]	B0223CRX	1.5	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.3,Crankshaft side]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Crankshaft side]	B0223DRX	3.7	◆Timing chain cover gasket (B0202), R&R
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,Intake camshaft side	B0223ERX	1.4	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with standard bolts	B0223FRX	2.7	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with shear-off bolts,Without i-ELOOP system	B0223GRX	2.8	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with shear-off bolts,With i-ELOOP system	B0223TRX	3.0	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with standard bolts	B0223HRX	2.7	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts,Without i-ELOOP system	B0223JRX	2.8	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts,With i-ELOOP system	B0223URX	3.0	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Crankshaft side	B0223KRX	3.8	◆Timing chain cover gasket (B0202), R&R
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,Intake camshaft side,Without i-stop	B02236RX	1.4	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,Intake camshaft side,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,Intake camshaft side]	B0223VRX	1.5	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with standard bolts]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with standard bolts]	B0223WRX	2.7	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with shear-off bolts,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with shear-off bolts,Without i-ELOOP system]</i>	B0223YRX	2.8	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with standard bolts]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with standard bolts]	B0223ZRX	2.7	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN SPROCKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts,Without i-ELOOP system]</i>	B02231RX	2.8	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Crankshaft side,Without i-stop	B02237RX	3.7	◆Timing chain cover gasket (B0202), R&R
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Crankshaft side,With i-stop	B02232RX	3.8	◆Timing chain cover gasket (B0202), R&R
TIMING CHAIN SPROCKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,Exhaust camshaft side,PCM cover with shear-off bolts,With Mazda M Hybrid]</i>	B02233RX	3.0	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN SPROCKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Camshaft side,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts,With Mazda M Hybrid]</i>	B02234RX	3.0	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Crankshaft side	B02235RX	3.8	◆Timing chain cover gasket (B0202), R&R
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,Intake camshaft side	B0223LRX	3.4	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,Exhaust camshaft side,PCM cover with standard bolts	B0223MRX	3.7	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,Exhaust camshaft side,PCM cover with shear-off bolts	B0223NRX	3.9	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,All (Intake camshaft side and exhaust camshaft side),PCM cover with standard bolts	B0223PRX	3.8	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,All (Intake camshaft side and exhaust camshaft side),PCM cover with shear-off bolts	B0223QRX	4.0	◆Timing chain (B0210), D&C
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,Crankshaft side,PCM cover with standard bolts	B0223RRX	5.4	◆Timing chain cover gasket (B0202), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
TIMING CHAIN SPROCKET, R&R	SKYACTIV-D 1.5,Crankshaft side,PCM cover with shear-off bolts	B0223SRX	5.6	◆Timing chain cover gasket (B0202), R&R
OIL CONTROL VALVE [OCV], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5,Without Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5,With Coolant Control Valve]	B0226ARX	0.6	◆Cylinder head cover gasket (B0403), R&R
OIL CONTROL VALVE [OCV], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,Without i-stop	B0226BRX	0.5	◆Cylinder head cover gasket (B0403), R&R
ELECTRIC VARIABLE VALVE TIMING MOTOR/DRIVER, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Without i-stop	B0228ARX	0.3	
ELECTRIC VARIABLE VALVE TIMING MOTOR/DRIVER, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,With i-stop	B0228BRX	0.4	
ELECTRIC VARIABLE VALVE TIMING MOTOR/DRIVER, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Without i-stop	B0228DRX	0.3	
ELECTRIC VARIABLE VALVE TIMING MOTOR/DRIVER, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve]	B0228CRX	0.4	
B03 ENGINE REAR				
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.3	B0302KRX	4.1	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,5MT,Without i-stop	B0302ARX	3.9	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,5MT,With i-stop,PCM cover with standard bolts	B0302BRX	4.0	◆Flywheel assembly (H0101), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,5MT,With i-stop,PCM cover with shear-off bolts	B0302CRX	4.1	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,Without i-stop,PCM cover with standard bolts	B0302DRX	3.9	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,Without i-stop,PCM cover with shear-off bolts	B0302ERX	4.0	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,Without i-ELOOP system,PCM cover with standard bolts	B0302FRX	4.0	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,Without i-ELOOP system,PCM cover with shear-off bolts	B0302GRX	4.1	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,With i-ELOOP system,PCM cover with standard bolts	B0302HRX	4.0	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,With i-ELOOP system,PCM cover with shear-off bolts	B0302JRX	4.3	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,Without i-stop,Without i-ELOOP system,PCM cover with standard bolts	B0302LRX	4.0	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,Without i-stop,Without i-ELOOP system,PCM cover with shear-off bolts	B0302MRX	4.1	◆Drive plate (K0317), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,Without i-stop,With i-ELOOP system	B0302NRX	4.3	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,With i-stop,Without i-ELOOP system,PCM cover with standard bolts	B0302PRX	4.1	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,With i-stop,Without i-ELOOP system,PCM cover with shear-off bolts	B0302QRX	4.2	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,With i-stop,With i-ELOOP system	B0302RRX	4.2	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,5MT,PCM cover with standard bolts	B0302WRX	4.4	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,5MT,PCM cover with shear-off bolts	B0302YRX	4.5	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with standard bolts,Without i-ELOOP system	B0302ZRX	4.5	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with standard bolts,With i-ELOOP system	B03022RX	4.5	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with shear-off bolts,Without i-stop	B03026RX	4.5	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B03021RX	4.6	◆Flywheel assembly (H0101), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B03023RX	4.7	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with standard bolts,With Mazda M Hybrid	B03027RX	4.6	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	[SKYACTIV-G 1.5,With Coolant Control Valve,6AT,PCM cover with standard bolts]/[SKYACTIV-G 1.5,With Coolant Control Valve,6AT,PCM cover with shear-off bolts,Without i-stop]	B03024RX	4.5	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6AT,PCM cover with shear-off bolts,With i-stop	B03025RX	4.6	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system	B0302SRX	4.4	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system	B0302TRX	4.7	◆Flywheel assembly (H0101), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system	B0302URX	4.9	◆Drive plate (K0317), R&R
OIL SEAL [CRANKSHAFT REAR], R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0302VRX	5.2	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,5MT,Without i-stop	B0303ARX	3.8	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,5MT,With i-stop,PCM cover with standard bolts	B0303BRX	4.0	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,5MT,With i-stop,PCM cover with shear-off bolts	B0303CRX	4.0	◆Flywheel assembly (H0101), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,Without i-stop,PCM cover with standard bolts	B0303DRX	3.8	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,Without i-stop,PCM cover with shear-off bolts	B0303ERX	3.9	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,Without i-ELOOP system,PCM cover with standard bolts	B0303FRX	4.0	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,Without i-ELOOP system,PCM cover with shear-off bolts	B0303GRX	4.0	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,With i-ELOOP system,PCM cover with standard bolts	B0303HRX	4.0	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6MT,With i-stop,With i-ELOOP system,PCM cover with shear-off bolts	B0303JRX	4.2	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.3	B0303KRX	4.0	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,Without i-stop,Without i-ELOOP system,PCM cover with standard bolts	B0303LRX	4.0	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,Without i-stop,Without i-ELOOP system,PCM cover with shear-off bolts	B0303MRX	4.1	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,Without i-stop,With i-ELOOP system	B0303NRX	4.3	◆Drive plate (K0317), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,With i-stop,Without i-ELOOP system,PCM cover with standard bolts	B0303PRX	4.1	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,With i-stop,Without i-ELOOP system,PCM cover with shear-off bolts	B0303QRX	4.2	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,6AT,With i-stop,With i-ELOOP system	B0303RRX	4.1	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,5MT,PCM cover with standard bolts	B0303WRX	4.4	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,5MT,PCM cover with shear-off bolts	B0303YRX	4.5	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with standard bolts,Without i-ELOOP system	B0303ZRX	4.4	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with standard bolts,With i-ELOOP system	B03032RX	4.5	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with shear-off bolts,Without i-stop	B03036RX	4.4	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B03031RX	4.5	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B03033RX	4.7	◆Flywheel assembly (H0101), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6MT,PCM cover with standard bolts,With Mazda M Hybrid	B03037RX	4.6	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	[SKYACTIV-G 1.5,With Coolant Control Valve,6AT,PCM cover with standard bolts]/[SKYACTIV-G 1.5,With Coolant Control Valve,6AT,PCM cover with shear-off bolts,Without i-stop]	B03034RX	4.4	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,6AT,PCM cover with shear-off bolts,With i-stop	B03035RX	4.5	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system	B0303SRX	4.4	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system	B0303TRX	4.6	◆Flywheel assembly (H0101), R&R
END PLATE, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system	B0303URX	4.9	◆Drive plate (K0317), R&R
END PLATE, R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0303VRX	5.1	◆Drive plate (K0317), R&R
B04 CYLINDER HEAD				
CYLINDER HEAD, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0401ARX	11.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0401BRX	11.9	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0401CRX	12.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B0401HRX	12.1	◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, 6MT, Without i-stop	B0401SRX	11.8	◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, 5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 6MT, Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, 6MT, With i-stop]	B0401JRX	11.9	◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, 6AT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 6AT, Without i-stop]	B0401KRX	11.9	◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 5MT	B0401LRX	12.0	◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, 6AT, With i-stop	B0401MRX	12.0	◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Intake & exhaust valve (B0405), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0401NRX	12.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0401RRX	12.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-ELOOP system	B0401PRX	12.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-ELOOP system	B0401QRX	12.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0401TRX	12.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system	B0401DRX	15.8	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0401ERX	15.9	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system	B0401FRX	16.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER HEAD, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system	B0401GRX	16.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
CYLINDER HEAD GASKET, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0402ARX	7.8	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0402BRX	8.1	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0402CRX	8.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0402GRX	8.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,Without i-stop	B0402SRX	7.9	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop	B0402TRX	7.9	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER HEAD GASKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop]</i>	B0402JRX	8.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,With i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop]</i>	B0402KRX	8.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]</i>	B0402LRX	8.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B0402MRX	8.1	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0402NRX	8.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0402PRX	8.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-ELOOP system	B0402QRX	8.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-ELOOP system	B0402RRX	8.4	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0402URX	8.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6MT	B0402DRX	12.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6AT	B0402WRX	12.1	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0402ERX	12.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6MT	B0402HRX	12.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD GASKET, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6AT	B0402VRX	12.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER HEAD GASKET, R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system	B0402FRX	12.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
CYLINDER HEAD COVER ASSEMBLY AND/OR GASKET, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5,Without Coolant Control Valve,With i-stop]/[SKYACTIV-G 1.5,With Coolant Control Valve]	B0403ARX	0.6	
CYLINDER HEAD COVER ASSEMBLY AND/OR GASKET, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,Without i-stop	B0403BRX	0.5	
CYLINDER HEAD COVER ASSEMBLY AND/OR GASKET, R&R	SKYACTIV-D 1.5	B0403CRX	1.8	◆Fuel injection pipe (F0318), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0404ARX	13.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0404BRX	13.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0404CRX	13.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0404HRX	13.7	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,Without i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without Mazda M Hybrid]</i>	B0404JRX	13.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,With i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop]</i>	B0404KRX	13.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT	B0404LRX	13.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B0404MRX	13.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0404NRX	13.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0404PRX	13.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-ELOOP system	B0404QRX	13.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-ELOOP system	B0404RRX	13.8	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0404SRX	13.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With Mazda M Hybrid	B0404TRX	13.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system	B0404DRX	17.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0404ERX	17.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system	B0404FRX	17.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE GUIDE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system	B0404GRX	17.7	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve (B0405), R&R
INTAKE AND EXHAUST VALVE [ALL], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0405ARX	11.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0405BRX	11.9	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0405CRX	12.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0405HRX	12.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop	B0405SRX	11.7	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,Without i-stop	B0405TRX	11.7	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop]</i>	B0405JRX	11.8	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,With i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop]</i>	B0405KRX	11.8	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]</i>	B0405LRX	11.8	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B0405MRX	11.9	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0405NRX	12.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0405PRX	12.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-ELOOP system	B0405QRX	12.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-ELOOP system	B0405RRX	12.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0405URX	12.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system	B0405DRX	15.8	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0405ERX	15.9	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system	B0405FRX	16.0	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system	B0405GRX	16.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Intake & exhaust valve seal/spring (B0406)/(B0407), R&R◆Valve lapping
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0406ARX	10.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0406BRX	10.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0406CRX	10.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0406GRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop	B0406SRX	10.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop]</i>	B0406JRX	10.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop]	B0406KRX	10.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT	B0406LRX	10.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B0406MRX	10.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0406NRX	10.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0406PRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-ELOOP system	B0406QRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-ELOOP system	B0406RRX	10.7	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0406TRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6MT	B0406DRX	14.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	[SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system,6MT]/[SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6AT]	B0406ERX	14.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	[SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system,6AT]/[SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6MT]	B0406HRX	14.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SEAL [ALL], R&R	[SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6AT]	B0406FRX	14.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0407ARX	10.1	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0407BRX	10.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0407CRX	10.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0407GRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT]</i>	B0407JRX	10.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop]	B0407KRX	10.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT	B0407LRX	10.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B0407MRX	10.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0407NRX	10.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0407PRX	10.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without i-ELOOP system	B0407QRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With i-ELOOP system	B0407RRX	10.6	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0407SRX	10.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6MT	B0407DRX	14.2	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	<i>[SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system,6MT]/[SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6AT]</i>	B0407ERX	14.3	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	<i>[SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system,6AT]/[SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6MT]</i>	B0407HRX	14.4	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
INTAKE AND EXHAUST VALVE SPRING [ALL], R&R	<i>[SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6AT]</i>	B0407FRX	14.5	◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.3	B0408ARX	2.6	◆Timing chain (B0210), D&C◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0408BRX	2.5	◆Timing chain (B0210), D&C◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0408CRX	2.6	◆Timing chain (B0210), D&C◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0408DRX	2.6	◆Timing chain (B0210), D&C◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0408ERX	2.7	◆Timing chain (B0210), D&C◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0408FRX	2.9	◆Timing chain (B0210), D&C◆Camshaft (B0411), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, Without i-ELOOP system	B0408LRX	2.9	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B0408MRX	3.1	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, Without i-stop	B0408SRX	2.8	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts]	B0408NRX	2.9	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, Without i-ELOOP system]	B0408PRX	2.9	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B0408QRX	3.1	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With Mazda M Hybrid	B0408RRX	3.1	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system	B0408GRX	4.1	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0408HRX	4.2	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system	B0408JRX	4.3	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
VALVE ROCKER ARM AND/OR SHAFT [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system	B0408KRX	4.4	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts]	B0410ARX	2.7	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0410BRX	2.7	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0410CRX	2.8	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0410DRX	3.0	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0410ERX	3.1	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B0410HRX	3.3	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, Without i-stop	B0410MRX	2.9	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, With i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, Without i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts]</i>	B0410JRX	3.0	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, With i-stop, Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, Without i-ELOOP system]</i>	B0410KRX	3.1	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B0410LRX	3.2	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With Mazda M Hybrid	B0410NRX	3.2	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system	B0410FRX	4.3	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0410QRX	4.4	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system	B0410GRX	4.5	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
HYDRAULIC LASH ADJUSTER [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system	B0410PRX	4.6	◆Timing chain (B0210), D&C ◆Camshaft (B0411), R&R
CAMSHAFT, R&R	SKYACTIV-G 1.3,Intake camshaft	B0411ARX	1.5	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.3,Exhaust camshaft	B0411BRX	2.3	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.3,All	B0411CRX	2.6	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Intake camshaft	B0411DRX	1.5	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Exhaust camshaft,PCM cover with standard bolts	B0411ERX	2.3	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts	B0411FRX	2.4	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,All,PCM cover with standard bolts	B0411GRX	2.6	◆Timing chain (B0210), D&C

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,All,PCM cover with shear-off bolts	B0411HRX	2.7	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Intake camshaft	B0411JRX	1.6	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Exhaust camshaft,PCM cover with standard bolts	B0411KRX	2.7	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,Without i-ELOOP system	B0411LRX	2.8	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,With i-ELOOP system	B0411VRX	3.0	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,All,PCM cover with standard bolts	B0411MRX	2.9	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,All,PCM cover with shear-off bolts,Without i-ELOOP system	B0411WRX	2.9	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,All,PCM cover with shear-off bolts,With i-ELOOP system	B0411YRX	3.1	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Intake camshaft,Without i-stop	B04118RX	1.5	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Intake camshaft,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Intake camshaft]	B04111RX	1.6	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with standard bolts,Without i-stop	B04119RX	2.6	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with standard bolts,With i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,Without i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with standard bolts]	B04112RX	2.7	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CAMSHAFT, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,With i-stop,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,Without i-ELOOP system]</i>	B04113RX	2.8	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	<i>[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,Exhaust camshaft,PCM cover with shear-off bolts,With i-stop,With Mazda M Hybrid]</i>	B04114RX	3.0	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,All,PCM cover with standard bolts,With i-stop]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,All,PCM cover with standard bolts]</i>	B04115RX	2.9	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,All,PCM cover with standard bolts,Without i-stop</i>	B0411AR1	2.8	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,All,PCM cover with shear-off bolts,Without i-stop</i>	B0411BR1	2.9	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CAMSHAFT, R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,All,PCM cover with shear-off bolts,With i-stop,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,All,PCM cover with shear-off bolts,Without i-ELOOP system]</i>	B04116RX	2.9	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	<i>[SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,All,PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,All,PCM cover with shear-off bolts,With i-stop,With Mazda M Hybrid]</i>	B04117RX	3.1	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-D 1.5,Intake camshaft	B0411NRX	3.4	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-D 1.5,Exhaust camshaft,PCM cover with standard bolts	B0411PRX	4.1	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-D 1.5,Exhaust camshaft,PCM cover with shear-off bolts	B0411QRX	4.3	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-D 1.5,All,PCM cover with standard bolts,Without i-ELOOP system	B0411RRX	4.1	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-D 1.5,All,PCM cover with standard bolts,With i-ELOOP system	B0411SRX	4.2	◆Timing chain (B0210), D&C
CAMSHAFT, R&R	SKYACTIV-D 1.5,All,PCM cover with shear-off bolts,Without i-ELOOP system	B0411TRX	4.3	◆Timing chain (B0210), D&C

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CAMSHAFT, R&R	SKYACTIV-D 1.5,All,PCM cover with shear-off bolts,With i-ELOOP system	B0411URX	4.4	◆Timing chain (B0210), D&C
BOLT [CYLINDER HEAD] [ALL], R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve]	B0418ERX	7.8	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0418FRX	8.1	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0418GRX	8.2	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0418HRX	8.3	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop]</i>	B0418JRX	8.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	<i>[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,With i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop]</i>	B0418KRX	8.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
BOLT [CYLINDER HEAD] [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]	B0418LRX	8.0	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B0418MRX	8.1	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT,Without i-stop]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop]	B0418TRX	7.9	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT	B0418NRX	8.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0418PRX	8.2	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0418QRX	8.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0418RRX	8.4	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B0418SRX	8.3	◆Timing chain (B0210), R&R◆Intake manifold gasket (F0102), R&R◆Cylinder head assembly, R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6MT	B0418ARX	12.0	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,Without i-ELOOP system,6AT	B0418URX	12.1	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-D 1.5,PCM cover with standard bolts,With i-ELOOP system	B0418BRX	12.2	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6MT	B0418DRX	12.2	◆Cylinder head gasket (B0402), R&R
BOLT [CYLINDER HEAD] [ALL], R&R	[SKYACTIV-D 1.5,PCM cover with shear-off bolts,With i-ELOOP system]/[SKYACTIV-D 1.5,PCM cover with shear-off bolts,Without i-ELOOP system,6AT]	B0418CRX	12.3	◆Cylinder head gasket (B0402), R&R
B05 CYLINDER BLOCK				
CYLINDER BLOCK, R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0501ARX	13.7	◆Front crossmember assembly, R&R◆Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER BLOCK, R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0501RRX	13.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0501BRX	13.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0501CRX	13.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0501DRX	13.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0501ERX	13.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without Mazda M Hybrid	B0501URX	14.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6MT	B05014RX	14.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6AT	B05015RX	14.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]	B0501VRX	14.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop	B05012RX	14.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B05013RX	14.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0501FRX	13.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0501GRX	14.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0501HRX	13.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0501JRX	14.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0501KRX	14.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0501LRX	14.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0501WRX	14.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0501YRX	14.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0501ZRX	14.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B05011RX	14.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,With Mazda M Hybrid	B05016RX	14.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B05018RX	14.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0501SRX	16.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B0501MRX	16.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0501TRX	16.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0501NRX	17.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0501PRX	16.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0501QRX	16.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Crankshaft (B0502), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CYLINDER BLOCK, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B05017RX	16.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Crankshaft (B0502), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0502ARX	10.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0502RRX	10.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0502BRX	10.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0502CRX	10.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0502DRX	10.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without Mazda M Hybrid	B0502URX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CRANKSHAFT, R&R	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6MT</i>	B05023RX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6AT</i>	B05024RX	10.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B05022RX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without Mazda M Hybrid</i>	B0502VRX	11.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0502ERX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0502FRX	11.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0502GRX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0502HRX	11.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0502JRX	11.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0502KRX	11.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0502WRX	11.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0502YRX	11.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0502ZRX	11.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B05021RX	11.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,With Mazda M Hybrid	B05025RX	11.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With Mazda M Hybrid	B05026RX	11.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0502SRX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B0502TRX	13.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0502LRX	13.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0502MRX	13.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0502NRX	13.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R ◆Main bearing (B0503), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0502QRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
CRANKSHAFT, R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0502PRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R◆Main bearing (B0503), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0503ARX	10.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0503SRX	10.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0503BRX	10.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0503CRX	10.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0503DRX	10.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0503ERX	10.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without Mazda M Hybrid	B0503VRX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B05034RX	10.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B05033RX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without Mazda M Hybrid	B0503WRX	11.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0503FRX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0503GRX	11.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0503HRX	11.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0503JRX	11.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0503KRX	11.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0503LRX	11.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0503YRX	11.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0503ZRX	11.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B05031RX	11.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B05032RX	11.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With Mazda M Hybrid	B05035RX	11.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,With Mazda M Hybrid	B05036RX	11.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0503TRX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B0503URX	13.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0503MRX	13.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0503NRX	13.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0503PRX	13.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0503RRX	13.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
MAIN BEARING [ALL], R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0503QRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0504ARX	12.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0504RRX	12.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0504BRX	12.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0504CRX	12.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0504DRX	12.9	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,5MT	B0504TRX	13.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6AT	B0504URX	13.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,Without i-stop	B05044RX	13.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop,Without Mazda M Hybrid]	B0504VRX	13.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop	B05042RX	13.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B05043RX	13.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0504ERX	13.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0504FRX	13.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0504GRX	13.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0504HRX	13.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0504JRX	13.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0504KRX	13.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0504WRX	13.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0504YRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0504ZRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B05041RX	13.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B05045RX	13.7	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod bearing (B0505), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,6MT,With i-stop,With Mazda M Hybrid	B05046RX	13.5	◆Front crossmember assembly, R&R ◆Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0504SRX	15.5	◆Front crossmember assembly, R&R ◆Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	[SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts]/[SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts]	B0504LRX	15.6	◆Front crossmember assembly, R&R ◆Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0504MRX	15.8	◆Front crossmember assembly, R&R ◆Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0504NRX	15.4	◆Front crossmember assembly, R&R ◆Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R
CONNECTING ROD [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0504QRX	15.7	◆Front crossmember assembly, R&R ◆Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD [ALL], R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0504PRX	15.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod bearing (B0505), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0505ARX	9.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0505RRX	9.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts	B0505BRX	9.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0505CRX	9.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0505DRX	9.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without Mazda M Hybrid	B0505URX	10.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6AT	B05053RX	9.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6MT	B05054RX	10.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B05052RX	10.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	<i>SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without Mazda M Hybrid</i>	B0505VRX	10.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0505ERX	10.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0505FRX	10.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0505GRX	10.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0505HRX	10.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0505JRX	10.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, With i-stop, With i-ELOOP system	B0505KRX	10.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, Without i-ELOOP system	B0505WRX	10.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, With i-ELOOP system	B0505YRX	10.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, Without i-ELOOP system	B0505ZRX	10.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B05051RX	10.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, With i-stop, With Mazda M Hybrid	B05055RX	10.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, With i-stop, With Mazda M Hybrid	B05056RX	10.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5, 6MT, Without i-ELOOP system, PCM cover with standard bolts	B0505SRX	12.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts	B0505LRX	12.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts	B0505TRX	12.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0505MRX	12.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0505NRX	12.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0505QRX	12.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
CONNECTING ROD BEARING [ALL], R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0505PRX	12.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.3	B0506ARX	12.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0506BRX	12.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0506CRX	12.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0506DRX	12.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0506ERX	13.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without Mazda M Hybrid	B0506SRX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6AT	B05061RX	13.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6MT	B05062RX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0506ZRX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without Mazda M Hybrid	B0506TRX	13.4	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0506FRX	13.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0506GRX	13.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0506HRX	13.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0506JRX	13.3	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0506KRX	13.2	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With i-ELOOP system	B0506LRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0506URX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0506VRX	13.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system	B0506WRX	13.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system	B0506YRX	13.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,With Mazda M Hybrid	B05063RX	13.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,With Mazda M Hybrid	B05064RX	13.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0506RRX	15.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	[SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts]/[SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts]	B0506MRX	15.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON RING [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0506NRX	15.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0506PRX	15.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0506QRX	15.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON RING [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B05065RX	15.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.3,Without i-ELOOP system	B0507ARX	13.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.3,With i-ELOOP system	B0507SRX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-stop	B0507BRX	13.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0507CRX	13.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop	B0507DRX	13.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop	B0507ERX	13.3	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without Mazda M Hybrid	B0507URX	13.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6AT	B05074RX	13.5	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆ Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,Without i-stop,6MT	B05075RX	13.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆ Piston ring (B0506), R&R
PISTON [ALL], R&R	[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,5MT]/[SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,Without Mazda M Hybrid]	B0507VRX	13.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,Without i-stop	B05072RX	13.6	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6AT,With i-stop	B05073RX	13.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system	B0507FRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system	B0507GRX	13.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,Without i-ELOOP system	B0507HRX	13.4	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-stop,With i-ELOOP system	B0507JRX	13.6	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system),Without Coolant Control Valve,PCM cover with shear-off bolts,With i-stop,Without i-ELOOP system	B0507KRX	13.5	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R

ILLUSTRATION

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), Without Coolant Control Valve, PCM cover with shear-off bolts, With i-stop, With i-ELOOP system	B0507LRX	13.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, Without i-ELOOP system	B0507WRX	13.7	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with standard bolts, With i-ELOOP system	B0507YRX	13.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, Without i-ELOOP system	B0507ZRX	13.8	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-2-1 exhaust system), With Coolant Control Valve, PCM cover with shear-off bolts, With i-ELOOP system	B05071RX	14.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R

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OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with shear-off bolts,6MT,With Mazda M Hybrid	B05076RX	14.1	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆ Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-G 1.5 (with 4-1 exhaust system),With Coolant Control Valve,PCM cover with standard bolts,With i-stop,With Mazda M Hybrid	B05077RX	13.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆ Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with standard bolts	B0507TRX	15.9	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	[SKYACTIV-D 1.5,6MT,Without i-ELOOP system,PCM cover with shear-off bolts]/[SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with standard bolts]	B0507MRX	16.0	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-D 1.5,6MT,With i-ELOOP system,PCM cover with shear-off bolts	B0507NRX	16.2	◆Front crossmember assembly, R&R ◆ Engine (B0101), R&R ◆Timing chain (B0210), R&R ◆Cylinder head gasket (B0402), R&R ◆Oil pan gasket (D0201), R&R ◆Connecting rod (B0504), R&R ◆Piston ring (B0506), R&R

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
PISTON [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with standard bolts	B0507PRX	15.8	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-D 1.5,6AT,Without i-ELOOP system,PCM cover with shear-off bolts	B0507RRX	16.1	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
PISTON [ALL], R&R	SKYACTIV-D 1.5,6AT,With i-ELOOP system	B0507QRX	16.0	◆Front crossmember assembly, R&R◆ Engine (B0101), R&R◆Timing chain (B0210), R&R◆Cylinder head gasket (B0402), R&R◆Oil pan gasket (D0201), R&R◆Connecting rod (B0504), R&R◆Piston ring (B0506), R&R
OIL BAFFLE PLATE OR VIBRATION REDUCING STIFFENER, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5,Without Coolant Control Valve]/[SKYACTIV-G 1.5,With Coolant Control Valve]	B0509XRX	1.0	◆Oil pan gasket (D0201), R&R
B06 ENGINE MOUNT				
ENGINE MOUNT RUBBER NO.1, R&R		B0602XRX	0.4	
ENGINE MOUNT RUBBER NO.3, R&R	[SKYACTIV-G 1.3]/[SKYACTIV-G 1.5,Without Coolant Control Valve]/[SKYACTIV-G 1.5,With Coolant Control Valve]	B0604ARX	0.6	
ENGINE MOUNT RUBBER NO.3, R&R	SKYACTIV-D 1.5	B0604BRX	0.8	
ENGINE MOUNT RUBBER NO.4, R&R	SKYACTIV-G 1.3	B0605ARX	0.9	
ENGINE MOUNT RUBBER NO.4, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,PCM cover with standard bolts,Without i-stop	B0605BRX	0.8	

OPERATION	VARIATION	OPERATION NUMBER	REPAIR TIME	INCLUDES
ENGINE MOUNT RUBBER NO.4, R&R	[SKYACTIV-G 1.5,Without Coolant Control Valve,PCM cover with standard bolts,With i-stop,Without i-ELOOP system]/[SKYACTIV-G 1.5,With Coolant Control Valve,PCM cover with standard bolts,Without i-ELOOP system]	B0605CRX	0.9	
ENGINE MOUNT RUBBER NO.4, R&R	[SKYACTIV-G 1.5,Without Coolant Control Valve,PCM cover with standard bolts,With i-stop,With i-ELOOP system]/[SKYACTIV-G 1.5,With Coolant Control Valve,PCM cover with standard bolts,With i-ELOOP system]	B0605DRX	1.0	
ENGINE MOUNT RUBBER NO.4, R&R	[SKYACTIV-G 1.5,Without Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system]/[SKYACTIV-G 1.5,With Coolant Control Valve,PCM cover with shear-off bolts,Without i-ELOOP system]	B0605ERX	0.9	
ENGINE MOUNT RUBBER NO.4, R&R	SKYACTIV-G 1.5,Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system,Without i-stop	B0605FRX	1.0	
ENGINE MOUNT RUBBER NO.4, R&R	[SKYACTIV-G 1.5,Without Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system,With i-stop]/[SKYACTIV-G 1.5,With Coolant Control Valve,PCM cover with shear-off bolts,With i-ELOOP system]	B0605GRX	1.1	
ENGINE MOUNT RUBBER NO.4, R&R	SKYACTIV-G 1.5,With Coolant Control Valve,PCM cover with standard bolts,With Mazda M Hybrid	B0605KRX	0.9	
ENGINE MOUNT RUBBER NO.4, R&R	SKYACTIV-D 1.5,Without i-ELOOP system	B0605HRX	0.8	
ENGINE MOUNT RUBBER NO.4, R&R	SKYACTIV-D 1.5,With i-ELOOP system	B0605JRX	0.9	