

DURA CLUTCH INSTALLATION

15-580 UPGRADE KIT MRZR DSL

SVI, LLC 28AUG2024

KIT PART #: 15-580

MODEL: K-UPGRADE MRZR

DESCRIPTION: MY17-19 MILITARY RZR TURBO DIESEL MODELS

KIT CONTENTS:

1. PRIMARY CLUTCH
2. SECONDARY CLUTCH
3. 35-082 BELT
4. 30-091 TOOL-BELT INSTALL
5. 99-023 LOCTITE 243 0.5ML
6. 98-138 INSTALL INSTRUCTIONS 15-580 (THESE INSTRUCTIONS)

Notes to MRZR models

Make sure clutch intake screen is clean and not missing by right rear tire. Blow out clutches at least every 500 miles or sooner riding in dusty conditions. If driving 10 mph or less in dusty conditions do more frequent.

INSTALLATION

1. Remove clutch cover.
2. Remove the Secondary clutch, retain hardware.
3. Install new Secondary from kit. Place a drop of BLUE Loctite provided with kit on the secondary screw threads. Tighten screw to 38 ft-lbs.
4. Remove Primary clutch screw, Belleville washer and clutch retaining washer, save for later use. Remove the Primary clutch with puller SVI PN 99-012. Greasing the end of the puller slightly will aid in removal. Do not get grease on any clutch components.
5. Clean the engine tapered shaft and Primary clutch bore with alcohol or degreaser. Do not lubricate.
6. Slip the belt into the Secondary so you can read the part number on the belt and using Belt Install Tool open secondary so belt will seat down into clutch. Sometimes a screwdriver is needed to assist lowering into clutch.

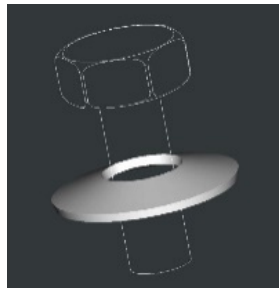


- Slide belt into primary clutch, then install on post.



- Install primary hardware removed in step 3. Tighten primary screw to 90 ft-lbs.

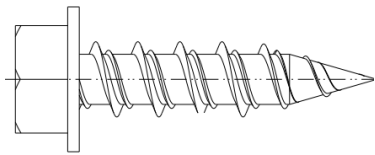
How Belleville washer is installed on primary screw



- Once primary is torqued, with transmission in PARK, spin secondary clutch back & forth a few times to allow belt back to top of secondary.

- Install outer clutch housing.

Note: The clutch cover screws are hi-lo screws designed for plastic. They can be used over and over in the same hole but must not be over-torqued.



Torque spec: 50 in-lbs (4 ft-lbs). This is like a screwdriver torque. Use a hand wrench or a clutch screw gun at a very low setting.

- Ensure cover seal is good or replace with SVI PN 35-045. To ensure the primary does not rub against the cover push up and back on the housing while lightly snugging the bottom screws. Then tighten the top rear screw followed by the other top screws. Then tighten all remaining screws including the bottom screws evenly. After starting the engine if you hear the primary rubbing, push on the cover while the engine is running in different directions to see which way will eliminate the rubbing. Stop the engine and loosen the housing screws and retighten using the above sequence while pushing on the cover in the direction that eliminated the rubbing. If this does not eliminate the rubbing try installing a new gasket SVI PN 35-045 and go through the bolt tightening sequence again. If you cannot eliminate the rubbing the cover is heat warped and you may have to install a new cover and perhaps a new back plate. You may also try using a heat gun to remove heat sag in the cover.