PRECISION PERFORMANCE

DURACLUTCH INSTALLATION
15-585 K-DC-RANGER1000-H AEBS RXS

SVI, LLC 24NOV2026 REV8

KIT PART #: 15-585
MODEL: K-DC-RANGER1000-H AEBS RXS
DESCRIPTION: MY20-CURRENT RANGER 1000 MY20-CURRENT RANGER CREW 1000 (Non-XP models). MY20-CURRENT PRO XD COMMERCIAL FULL SIZE GAS MODELS. MY20-CURRENT BOBCAT UV34 & UV34XL GAS. MY20-CURRENT GRAVELY ATLAS JSV 3400 This model has the Polaris P190X Clutch.

Does not fit

MY20-Current ALL RANGER **XP**1000 AND **XP**1000 CREW MODELS.

KIT CONTENTS:

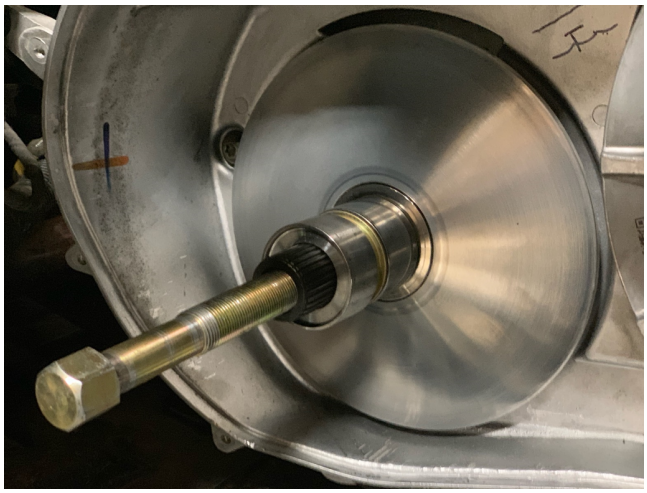
1. 10-349 ASM-DCPRIM 33G EBS RXS
   10-369 ASM-DCPRIM 30G EBS RXS
   10-288 ASM-DCPRIM 26G EBS RXS
2. 25-146 BUSHING-CLUTCH WASHER
3. 75-047 SCREW-CLUTCH
4. 99-024 TOOL-12MM BIT SOCKET 3/8 DRIVE
5. 99-028 TOOL-T60 BIT SOCKET3/8” DRIVE
6. 10-290 ASM-DC SECONDARY 9.5 PREM ROLL
7. 90-063 QTY 2 SECONDARY SHIM
8. 35-070 BELT
9. 75-088 SECONDARY SCREW M8X1.25X75
10. 90-059 SECONDARY WASHER-DOMED
11. 90-011 LOCK WASHER-SPRING 5/16
12. 99-036 THREADLOCKER-BLUE
13. 30-091 TOOL-BELT INSTALL
14. 10-254 CLUTCH COVER-OUTER
15. 97-067 DECAL-DC CLUTCH HOUSING DASH 35-070
16. 98-066 DURACLUTCH WARRANTY
17. 98-132 INSTALLATION INSTRUCTIONS 15-585 (THESE INSTRUCTIONS)

DURACLUTCH INSTALLATION

1. Remove airbox to plenum hose. Remove the clutch housing cover. Recommended tool: 8mm socket with flex drive extension. New Clutch Cover provided with kit will be used upon reassembly.
2. Remove Primary clutch bolt. Remove the Polaris primary outer movable sheave assembly. Pull off by hand holding the central shaft in place with your thumb. Move around the clutch, with a pulling and rocking motion.



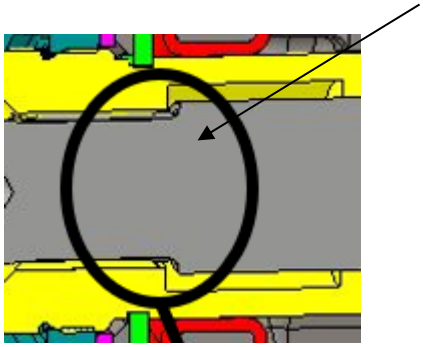
3. Pull the Polaris primary fixed sheave from the engine crankshaft using PN 99-012 puller. Greasing the end of the puller slightly will aid in removal. Do not get grease on any clutch components.



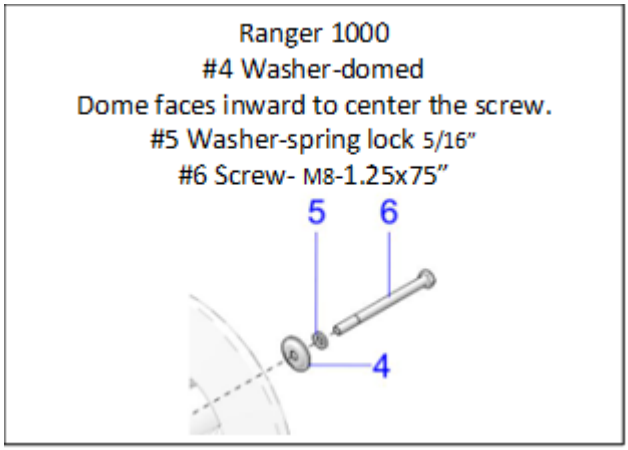
4. Clean the engine tapered shaft and DURACLUTCH Primary clutch bore with alcohol or degreaser. Do not lubricate.
5. Remove the Secondary clutch. Stock shim washers are not used so remove. (see pic below) Place one of the 90-063 shims provided with kit on the transmission shaft up against the spline shoulder.

Do not use stock shims





6. Install DURACLUTCH Secondary using new bolt, spring lock and domed washer provided with kit. Place blue Threadlocker on secondary bolt threads and tighten bolt to 27 ft-lbs.



7. 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 tool to seat lower into clutch.

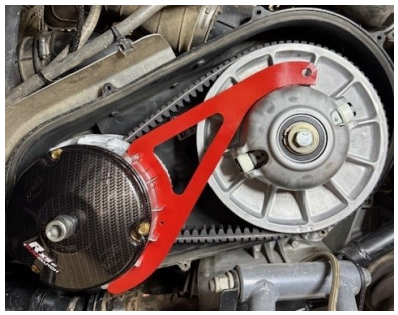


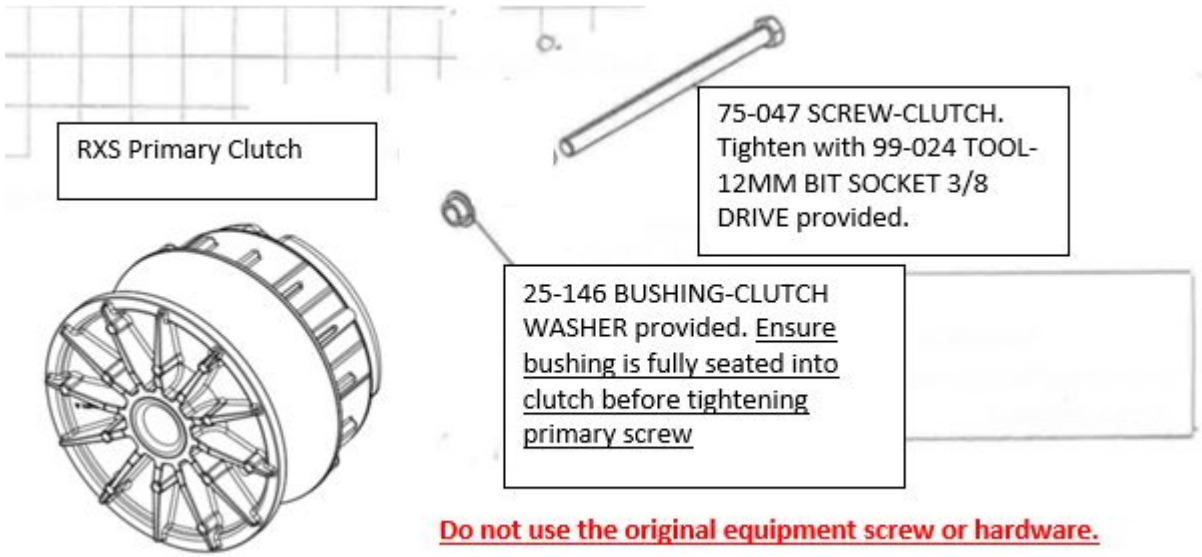
8. Slide belt into primary clutch, then install on post.





9. Install DURACLUTCH Primary with hardware provided as shown below. **VERY IMPORTANT -Torque bolt to 60 ft-lbs. <u>Over tightening will not allow clutch to operate properly and cause damage and failure of the clutch.</u>** SVI PN 99-034 Torque Tool (Sold Separately) shown below to hold the primary clutch when torquing the primary screw.





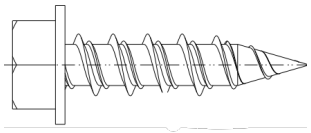
10. Set belt tension. Place transmission in Park and make sure machine is turned off. Rotate secondary by hand to seat belt in secondary clutch until belt tension is tight.

11. Once belt tension is set, start machine and verify that the secondary clutch has slight to no rotation at idle. (If slight rotation this will go away after belt break-in) If slight to no rotation, proceed to step 13. If the secondary is spinning fast, proceed to step 12.

12. If the secondary rotates fast, turn machine off and check to see where the belt is riding in between the primary sheaves. The ideal belt location should be centered with a small gap on each side between the sheaves, a cell phone picture may help see where belt is riding. Follow steps a. <u>or</u> b. to determine the next action.
    a. If belt is up against fixed sheave (inward), remove belt and secondary screw & secondary and add one shim washer included in kit onto shaft. Install secondary, secondary screw and belt, start machine to reset alignment. If the secondary still rotates fast and rides against fixed sheave, add another shim washer. Repeat until there is slight to no rotation, remember to blue Threadlocker secondary screw when alignment is complete and torque to spec, proceed to step 13.

b. If belt is up against moveable sheave (outward), remove belt, secondary screw & secondary and remove one shim washer. Install secondary, secondary screw and belt, start machine to reset alignment. If the secondary still rotates fast and rides against the movable sheave, remove another shim washer. Repeat until there is slight to no rotation, remember to blue Threadlocker the secondary screw when alignment is complete and torque to spec, proceed to step 13.

13. Install NEW outer clutch cover housing provided with kit. Ensure seal is good or replace with SVI PN 35-045.
    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.
14. Install airbox to plenum hose removed in step 1.
15. **Recommended Belt Break-In Procedure**

Do NOT immediately run wide open throttle. Do NOT immediately pull heavy loads.

Drive the vehicle in a "normal" operating mode for 10-15 minutes and let the vehicle cool down to ambient temperatures. A few normal drive cycles, heating the belt up and cooling it down will help season the belt and remove any mold release from the belt manufacturing process. The clutch system will be ready for full function after about 10 miles of running.

NOTE: If the transmission shifts hard after break-in there are likely issues other than drag in the clutches. See your dealer or call DURACLUTCH service (218-967-8205).

DECALS

16. Apply two decals as shown – one on the clutch cover housing and one on the dash. Clean surface with alcohol or similar solvent. Decal application is important to alert service technicians that the stock Polaris clutches have been replaced.





For installation video go to www.duraclutch.com

DURACLUTCH R-SERIES WARRANTY

The DURACLUTCH warranty is separate from the Polaris vehicle warranty. SVI, LLC provides a limited warranty on the DURACLUTCH for defects in materials and workmanship for general consumer use. This includes the primary, secondary and belt. It does not cover claims of defective design. SVI, LLC is responsible for DURACLUTCH warranty.

The warranty term of coverage is as follows:

- Belt: One (1) Year.
- Primary and Secondary: One (1) Year.

The term begins on the date of purchase by the original purchaser. This warranty is transferable to a subsequent owner but does not extend the original term of the warranty.

This limited warranty does not cover acts of God, accidental damage, normal wear and tear, abuse, or improper handling.

The following conditions void the warranty:

1. Improper installation.
2. Installation of tires with a diameter greater than the O.E.M. tire diameter without compensating gear reduction such as portals, transmission gearing or both.
3. Not performing prescribed routine maintenance by removing the clutch housing every 500 miles to 1) blow the dust out of the primary and secondary clutch, 2) examine the belt, and other components for abnormal wear indicating a problem needing corrective action.
4. Not insuring adequate and continuous cooling air through the clutch housing. This includes intake vents and outlets plugged with snow, dust, or debris. SVI offers an Engine and Clutch Intake Kit for certain models that prevent vehicle intakes from plugging with snow and dust.
5. Use of an improper belt. *Appropriate DURACLUTCH belt must be used*.
6. Modifying calibration, such as primary spring and roller, or secondary spring and cam.
7. Water in the clutch housing. Water damage or rust on clutches, this includes if you have gotten clutches wet while riding, washing the machine or wet when clutches are removed.
8. Abnormal dust conditions such as abrasive dust or running in very dusty conditions without filters or particle separators.
9. Driver abuse such as continuing to operate in HI gear when LO gear is the proper gear.

This warranty replaces all previous warranties expressed or implied.

www.duraclutch.com SVI Sales, 5112 Northstar Lane Suite 2, Nisswa, MN 56468 USA

11FEB2022Rev2

98-066 Document