



DURA CLUTCH INSTALLATION

15-624 15-625 15-626 K-DC-RANGER TITANXP1000 AEBS RXS

SVI, LLC 02DEC2025

KIT PART #: 15-624 15-625 15-626

MODEL: K-DC-RANGER TITAN XP1000 AEBS RXS

DESCRIPTION: MY17 RANGER 1000XP ALL MODELS, MY18 RANGERCREW 1000XP ALL MODELS

KIT CONTENTS:

1. 10-349 ASM-DCPRIM 33G EBS1000 R SERIES **(15-624)**
10-369 ASM-DCPRIM 30G EBS1000 R SERIES **(15-625)**
10-288 ASM-DCPRIM 26G EBS1000 R SERIES **(15-626)**
2. 25-146 SHOULDER WASHER
3. 75-047 SCREW-CLUTCH
4. 99-024 TOOL-12MM BIT SOCKET 3/8 DRIVE (SUBSTITUTE 99-007 TOOL-12MM BIT SOCKET 1/2 DRIVE)
5. 10-282 SECONDARY CLUTCH 9.5 PREM ROLL
6. 75-058 SECONDARY BOLT-M10X1.25X65 8.8 HX ZY
7. 90-056 SECONDARY WASHER-.406X1.25X.125 BELLE-Y 7556130
8. 90-060 QTY 4 SHIM 0.922X1.015X0.036
9. 90-085 QTY 1 SHIM 0.922X1.015X0.100
10. 99-036 BLUE THREADLOCKER
11. 35-063 BELT
12. 30-091 TOOL-BELT INSTALL
13. 97-066 DECAL-DC CLUTCH HOUSING DASH 35-063
14. 98-066 DURA CLUTCH WARRANTY R SERIES
15. 98-145 INSTRUCTION-INSTALLATION 15-624 625 626 (THESE INSTRUCTIONS)

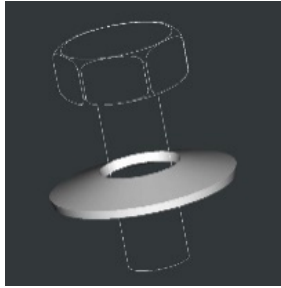
DURA CLUTCH INSTALLATION

1. Remove the clutch housing cover and the secondary clutch.
2. Place one 90-085 shim and three of the 90-060 shims provided with kit on the transmission shaft up against the spline shoulder.



3. Install the DURACLUTCH Secondary. Use the Secondary bolt and beveled washer supplied with this kit. Do not use O.E. (Original Equipment) hardware. Place a drop of BLUE THREADLOCKER provided with kit on the secondary bolt. Tighten the Secondary bolt to 45 ft-lbs.

How Belleville washer
is installed on
secondary bolt



4. Remove Primary clutch bolt. Remove the Primary clutch with puller, SVI 99-012 (Sold Separately). 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.



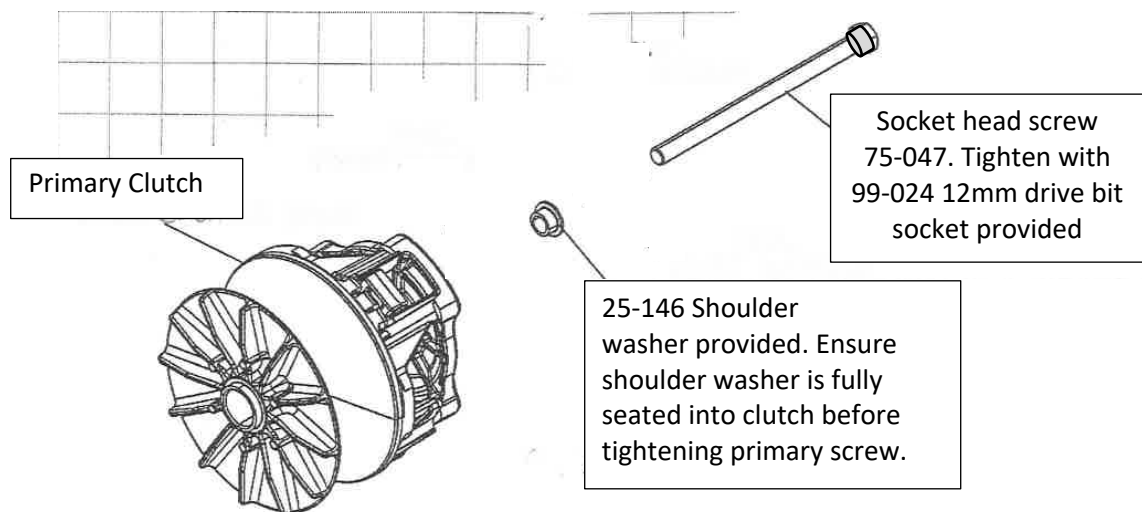
7. Slide belt into primary clutch, then install on post.



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



9. 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.



Do not use original equipment screw or hardware with primary.

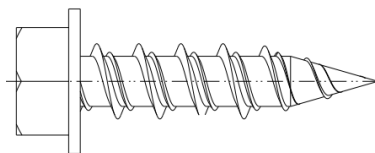
10. Once belt tension is set, start machine and verify that the secondary clutch has slight to no rotation at idle. (If slight rotation this will go away after belt break-in) If slight to no rotation, proceed to step 12. If the secondary is spinning fast, proceed to step 11.
11. If the secondary rotates 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. or 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 12.
 - 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 secondary screw when alignment is complete and torque to spec, proceed to step 12.

To watch a video on R-Series alignment go to our YouTube channel

<https://www.youtube.com/watch?v=auhmTrhk7Oo&t=17s>

12. Install outer clutch housing. Ensure seal is good or replace with DURACLUTCH seal part # 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. Attach hose to clutch cover and tighten clamp.



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.

13. Drive vehicle for 5 miles to break-in DURACLUTCH kit components.

NOTE: If the transmission still 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).

14. DECALS

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



To watch an installation video, go to www.duraclutch.com or our YouTube channel.

<https://www.youtube.com/@Duraclutch/videos>