

# DURA CLUTCH INSTALLATION

## DC-XPEDITION CALIBRATION UPGRADE KITS

SVI, LLC 11JUL2024 REV 4

KIT PART #: 15-571, 15-586, 15-587, 15-588, 15-589

MODEL: K-DC-CAL UPGR-XPED-A, C, D, E, F

DESCRIPTION:

MY24 XPEDITION ALL MODELS

**PURPOSE:** Provides predictable and smooth engagement. More than double the belt pinch force. Lowers operating rpm considerably for a better driving experience. In turn, this kit will increase fuel mileage.

**KIT CONTENTS:**

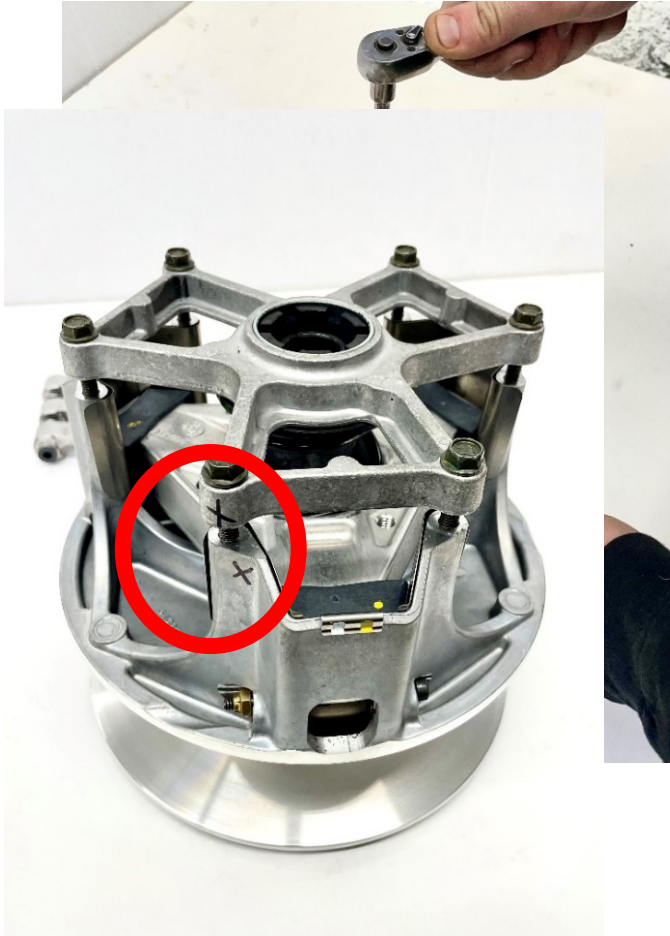
1. 10-306 QTY 3, ASM-WEIGHT BUSHED XZ76 (15-571)  
10-313 QTY 3, ASM-WEIGHT BUSHED XZ68 (15-586 & 15-587)  
10-314 QTY 3, ASM-WEIGHT BUSHED XZ60 (15-588 & 15-589)
2. 90-076 STOP SHIM
3. 50-021 SPRING, DRIVE
4. 3211186 DRIVE BELT
5. 98-120 INSTRUCTION-INSTALL EXPEDITION UPGRADE (THESE INSTRUCTIONS)



### PRIMARY CLUTCH REMOVAL

1. Remove the clutch housing cover.
2. Remove Primary clutch bolt. Remove the Primary clutch with puller SVI 99-012. Greasing the end of the puller slightly will aid in removal. Do not get grease on any clutch components.

Tools needed: 3/8-inch thin wall socket, 10mm socket, ratchet, 1/8-inch hex wrench. NOTE: light duty 1/4" or 3/8" drive power tools may be used. DO NOT use heavy duty impact power tools.



Remove cover bolts (x6) with 10mm socket.  
Be sure to make a mark on the cover and the tower  
of the clutch so you know how they line up for re-  
assembly.

- Remove cover, spring and spring shim. **THIS STOCK SPRING & SHIM WILL NOT BE USED AGAIN.**





- With a 3/8" socket and 1/8" hex wrench, remove the three weight pins and nuts. Pay attention to which direction the weight pins run through the hole. Install the three new weights supplied in the kit. Re use the weight pins and nuts from last step.

Tighten up all three weight pin nuts. The nuts will bottom out on the weight pin shoulder when tight.

- Install the new spring.



-Install the stop shim on top of the spring.



This photo shows the spring installed with the stop shim.

Re install the cover, slowly tightening the cover bolts in an alternating pattern. Be sure to line up your marks on the cover and the tower. Torque cover bolts to **9 ft./lbs.** or **108 in./lbs.**



Install new belt into secondary, using belt tool open secondary so belt seats down into secondary  
-Place belt into primary then install primary clutch onto post.

-Torque primary clutch bolt to **96 ft./lbs.**

-Re install clutch housing cover removed in step 1. Torque the cover bolts to **53 in./lbs.**

\*Drive the machine for 5 miles to break in the new belt. Vary speeds and then let the machine cool down to heat cycle the belt.

-If you have questions or issues you can go to [duraclutch.com](http://duraclutch.com) to submit us an email,  
or call us at (218-967-8205)