

# DURA CLUTCH

PRECISION PERFORMANCE

## INSTALLATION

### 15-640-641-642-643 DC-RZR XP1000 RXL

SVI, LLC 18NOV2025 REV 2

KIT PART #: 15-640-641-642-643

MODEL: DC-RZR XP1000 RXL

DESCRIPTION: MY2024-2026 RZR XP1000 ALL MODELS

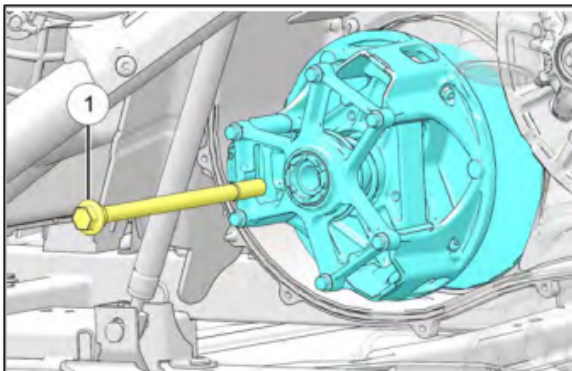
#### KIT CONTENTS:

1. 10-400 ASM-RXL PRIM 37G (15-640)
- 10-363 ASM-RXL PRIM 35G (15-641)
- 10-362 ASM-RXL PRIM 31G (15-642)
- 10-380 ASM-RXL PRIM 28G (15-643)
2. 35-080 BELT
3. 10-393 SECONDARY
4. 25-262 BUSHING- PRIMARY CLUTCH
5. 75-111 PRIMARY SCREW
6. 75-110 SECONDARY SCREW M8x1.25x50
7. 90-082 WASHER-SECONDARY SCREW
8. 99-036 THREADLOCKER-BLUE
9. 99-028 TOOL-T60 BIT SOCKET 3/8"
10. 90-081 QTY 3 SECONDARY SHIM-RING 23.25X32.25X0.5
11. 97-087 DECAL-DC CLUTCH HOUSING DASH 35-080 RXL
12. 98-066 DURACLUTCH R SERIES WARRANTY
13. 98-148 INSTRUCTION- INSTALLATION (THESE INSTRUCTIONS)

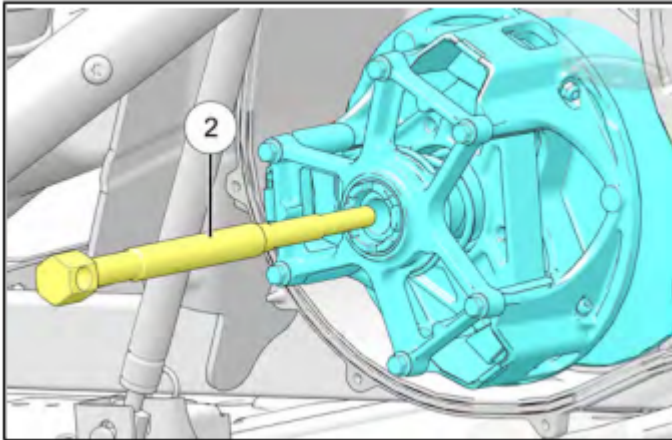
NOTE: BEFORE CLUTCH INSTALLATION ensure clutch box is clean, no loose debris, no belt debris and no signs of oil residue or moisture. Check to ensure clutch cover seal is in place and in good shape.

#### DURACLUTCH INSTALLATION

1. Loosen clamp on hose connected to clutch cover and move hose out of the way.
2. Lift rear of the machine off the ground and remove rear lower shock bolt and move shock out of the way.
3. Place transmission into Park and remove the clutch housing cover. Recommended tool: 8mm socket with flex drive extension.
4. Remove Primary clutch bolt.



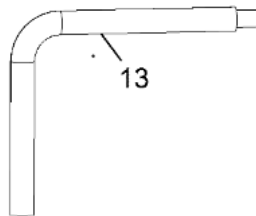
5. Pull the Polaris primary from the engine crankshaft using PN 99-012 puller. Greasing the end of the puller slightly will aid in removal. Do not get grease on any clutch components. Remove belt.



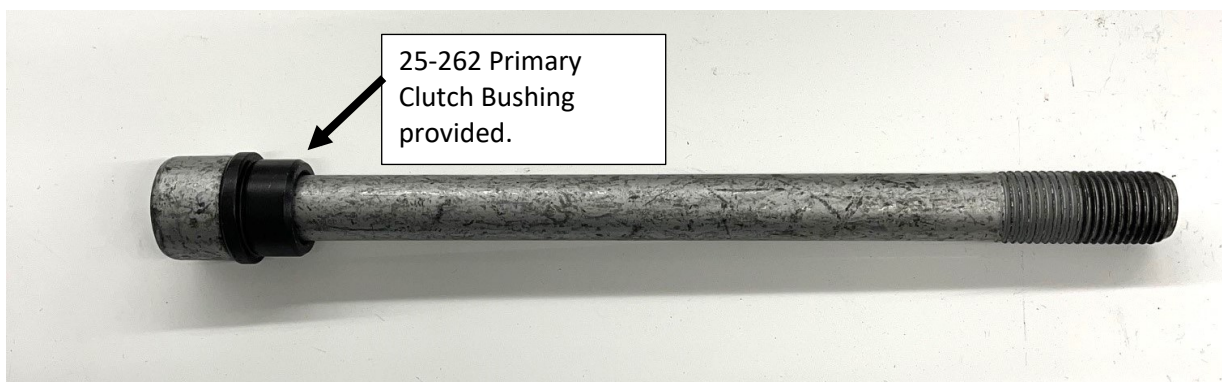
6. Clean the engine tapered shaft and the RXL Primary clutch bore with alcohol or degreaser. Do not lubricate.
7. Remove the Secondary clutch, keep all shims removed, set all hardware aside, they will not be used.
8. Install the new secondary. Install shims removed in #7, use new secondary screw provided with kit and place blue threadlocker on secondary screw threads and tighten screw to **27 ft-lbs.**
9. Open secondary sheaves using belt install tool provided with the vehicle in the tool bag. Screw tool into secondary to open the sheaves, this will allow the belt to seat into sheaves.



95-090 BELT INSTALL TOOL

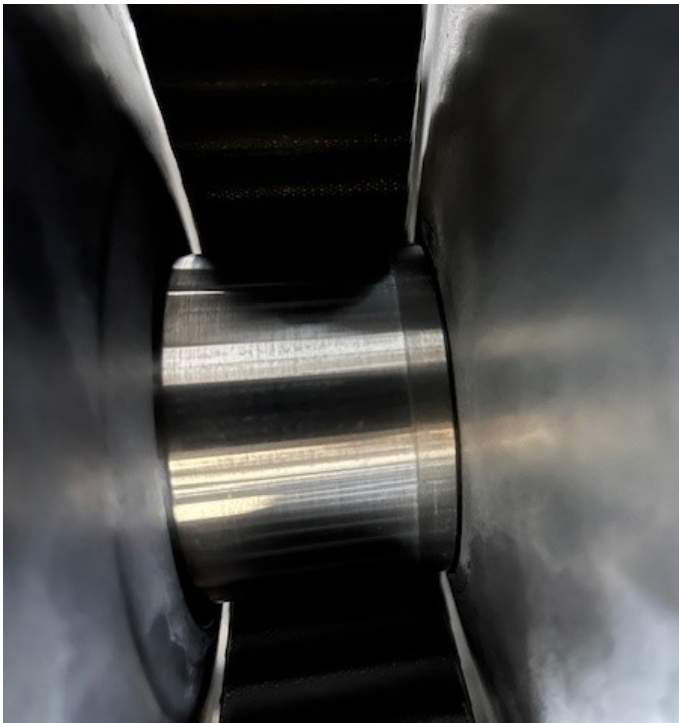


10. Seat the belt into the secondary so you can read the writing on the belt and then into the RXL Primary sheaves and install primary on the post. Install 25-262 bushing onto primary screw included with kit, make sure it gets seated all the way to the screw head as shown, if tight remove burr on shoulder of primary screw. Tighten screw to **60 ft-lbs.** **UNSCREW & REMOVE THE BELT INSTALL TOOL FROM THE SECONDARY.** Spin the secondary back and forth a few times by hand to allow belt back to top of secondary.





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 has fast rotation 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. or b. to determine next action. Check out our YouTube channel for an alignment video.  
<https://www.youtube.com/user/SpecialtyVehiclesInt>.



- A. If the belt is up against the primary fixed sheave (inward), remove belt with belt install tool used in step 9. Then remove secondary screw and one shim washer. Install secondary screw and belt. **UNSCREW & REMOVE THE BELT INSTALL TOOL FROM THE SECONDARY.** Spin the secondary back and forth a few times by hand to allow belt back to top of secondary. Start machine to reset alignment. If the secondary still rotates fast and rides against fixed sheave, repeat process and remove another shim washer. Repeat until there is slight to no rotation, remember the blue threadlocker on the secondary screw when alignment is complete and torque to spec, proceed to step 13.
- B. If the belt is up against the primary moveable sheave (outward), remove belt with belt install tool used in step 9. Then remove secondary screw and add one shim washer provided with kit. Install secondary screw and belt. **UNSCREW & REMOVE THE BELT INSTALL TOOL FROM THE SECONDARY.** Spin the secondary back and forth a few times by hand to allow belt back to top of secondary. Start machine to reset alignment. If the secondary still rotates fast and rides against the moveable sheave, repeat process and add another shim washer. Repeat until there is slight to no rotation, remember the blue threadlocker on the secondary screw when alignment is complete and torque to spec, proceed to step 13.

13. Install outer clutch housing. Ensure seal is good or replace with SVI PN 35-110.

14. Note: The clutch cover screws are 6mm screws (8mm hex head) that are easy to cross thread. They screw into an aluminum back cover.



Torque spec: 53 in-lbs (4.417 ft-lbs). This is like a screwdriver torque. Use a hand wrench or a clutch screw gun at a very low setting.

15. Install the shock into lower mount and install hardware removed in step 2, torque to 70 ft-lbs.

16. Install hose removed in step 1. Tighten hose clamps to 27 in-lbs (2.25 ft-lbs)

#### DECALS

17. Apply two decals as shown – on the clutch housing and 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.

