



*“Setting the World’s
Performance Standards”*

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High-strength Spider Insert 50-338

Specialized Tools Recommended

- SLP Clutch Cover Removal Tool #20-303
- SLP Belt Removal Tool #20-217
- SLP Clutch Press Tool #20-222

Other Tools Required

- 15mm Socket & Ratchet
- Torque Wrench
- #25 Torx Socket & Ratchet
- External Snap Retaining Ring Pliers

Disassembly

Step 1: Remove the clutch cover retaining screws and remove clutch cover from the RZR. (SLP Clutch Cover Removal Tool #20-303 highly recommended for this process)

Note: As long as the rear of the RZR is not elevated on a jack or jack stands, the clutch cover can be removed without removing the tire or unhooking the lower shock mount.

Step 2: Remove the belt. (SLP Belt Removal Tool #20-217 highly recommended for this process)

Step 3: Using the 15mm socket and ratchet, remove secondary clutch retaining bolt and remove clutch from splined shaft. Having the RZR in gear will help with bolt removal.

Step 4: Using the #25 torx socket and ratchet, remove the (4) torx screws holding the helix to the secondary clutch. Remove the helix from the clutch.

Step 5: Compress the spider in the secondary clutch using clutch press tool (SLP #20-222) or spring compression tool and remove the snap ring.

Step 6: Remove the spider from the secondary clutch.

Step 7: Remove the spider insert and rubber damper from the bottom of the spider.



Step 8: Check the spider insert for cracks or total breakage. If broken replace with our high strength version #50-338. If rubber damper is damaged, replace with #50-337.

Re-assembly

Step 9: Assemble spider with rubber damper and spider insert. The double spline on the spider insert must line up with the white paint mark on the top of the spider. See Illustration #2



Illustration #2

Step 10: Compress the spider into the secondary clutch using a clutch compression tool (SLP #20-222). The double spine on the shaft and spider insert must line up for assembly. See Illustration #3

Step 11: Install snap ring into the groove in the shaft directly above the spider. Make sure the snap ring fully seats before removing clutch press tool.

Step 12: Line up the X on the helix with the X on the clutch and install using the (4) torx head screws removed in step #4.

Step 13: Slide secondary clutch onto splined shaft of the RZR. Having the RZR in gear will help when aligning the splines.

Step 14: Install the secondary clutch retaining bolt and torque to **40 ft/lbs (54 Nm)**.

Step 15: Install the belt. (SLP Belt Removal Tool #20-217 highly recommended) With the RZR in "Park", rotate the secondary clutch counter-clockwise until the belt is at full ride height.

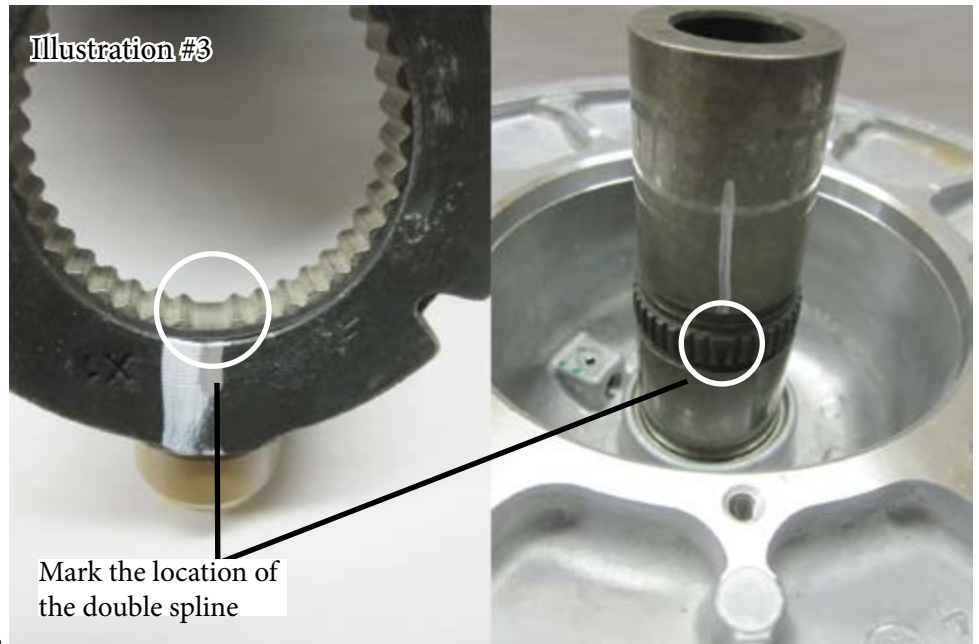


Illustration #3

Mark the location of the double spline

Step 16: Install the clutch cover making sure the stock seal is in place. (SLP Clutch Cover Removal Tool #20-303 highly recommended)