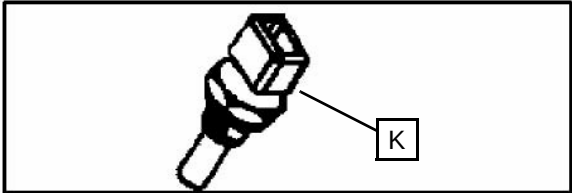


 = T
Thermostat Housing Bolt Torque: 84 ± 8 in. lbs. (9.5± 0.9 Nm)

12. Install temperature sender (K) and torque to specification.



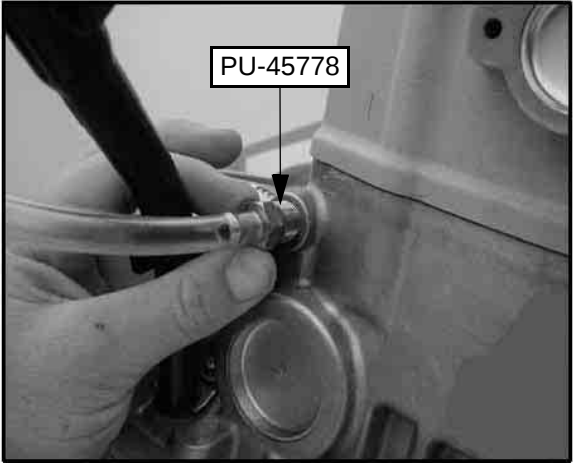
 = T
Temperature Sender Torque: 17 ± 2 ft.lbs. (23 ± 3 Nm)

Oil Pump Priming

1. After the engine is completely assembled and ready for installation, the engine must be properly primed with Polaris PS-4 PLUS 2W-50 Synthetic Oil (PN 2876244). Fill the oil filter three-quarters full with Polaris PS-4 PLUS 2W-50 Synthetic Engine Oil (PN 2876244). Let the oil soak into the filter for 8-10 minutes. Install the filter onto the engine.



2. Remove primer plug from the engine. Install Oil System Priming Adapter (**PU-45778**) into the oil plug hole. Push 3-5 oz. (approx.) of Polaris PS-4 PLUS 2W-50 Synthetic into the adapter or until resistance is felt. Remove the adapter. Apply sealant to the plug threads. Install the plug and torque to specification.



 = T
Primer Plug Torque 18 ± 2 ft.lbs. (24.4 ± 2.71 Nm)

CAUTION
After any reassembly or rebuild, the engine must be primed using the Oil Priming Adapter (PU-45778) and a 3/4-full oil filter before initial start-up. Follow the steps in this section to properly prime the engine and aid proper engine break in. Failure to perform this procedure may cause internal engine damage on initial start-up.

Engine Break-In

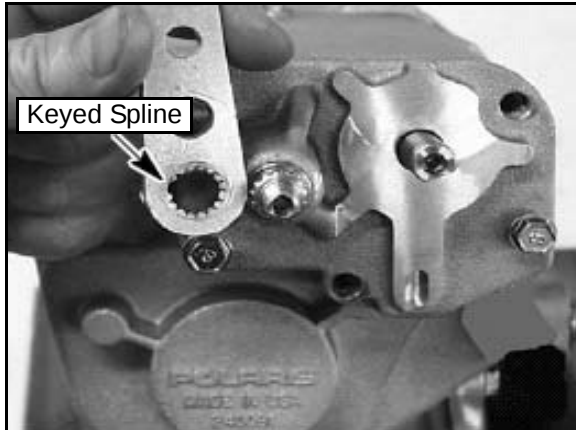
Refer to “Engine Break-In Period” under “Engine Installation Notes” listed earlier in this chapter.

TRANSMISSION

32. Torque the remaining bolts to 7-9 ft.lbs. (10-12 Nm).

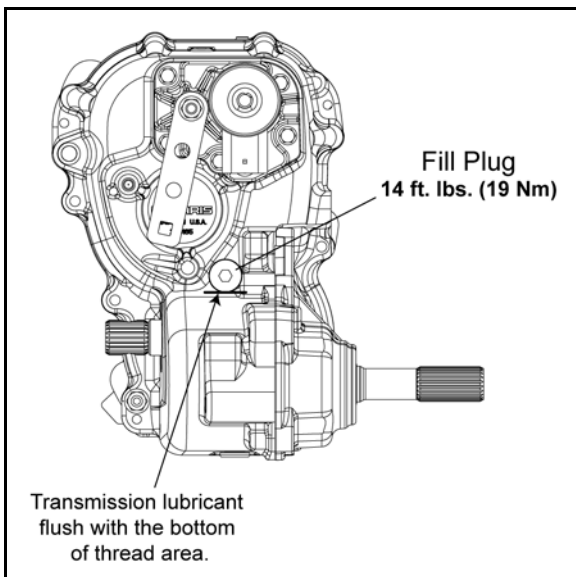
Cover Bolt Torque:
7-9 ft. lbs. (10-12 Nm)

33. Install a new bellcrank onto the shift shaft. Note the keyed spline on the bellcrank and shaft. Install the washer and nut. Torque the bellcrank nut to 12-18 ft. lbs. (16-24 Nm).



Bellcrank Nut Torque:
12-18 ft. lbs. (16-24 Nm)

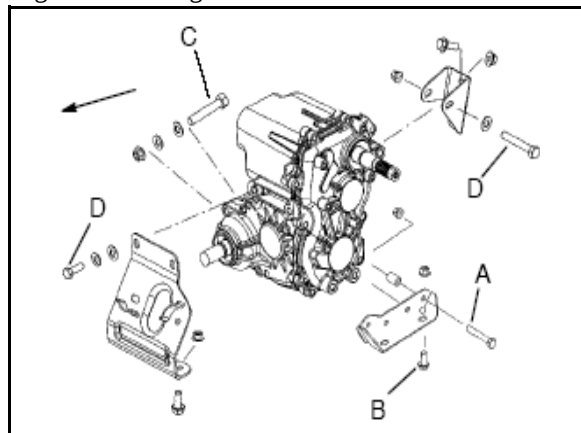
34. Install transmission and add Polaris AGL Gearcase Lubricant (PN 2873602).



AGL Gearcase Lube
43.6 oz. (1290 ml)

Transmission Installation

1. Install transmission from right side of vehicle.
2. Align the front input shaft to the front propshaft yoke on the vehicle and install the propshaft.
3. Align the rear output shaft to the mid or rear propshaft yoke and roll pin hole.
4. Slide the mid or rear propshaft onto the rear output shaft and drive a NEW roll pin into the propshaft yoke.
5. Position transmission in frame.
6. Loosely install the front transmission to frame bolts.
7. Loosely install the rear transmission to frame bolt.
8. Loosely install the three bottom transmission to frame bolts.
9. Tighten mounting fasteners in order A-D as shown.



Transmission Mounting Bolts Torque
25 ft. lbs. (34.5 Nm)

NOTE: Be sure to tighten the lower transmission bolts first, this ensures that the transmission is tight against the lower frame and helps to properly align the transmission.

10. If torque stop was removed, set clearance to .060-.080 in. (1.52-2.03 mm).
11. Reinstall the shift linkage rod, the air intake hose, and the vent hose on top of the transmission.

NOTE: Align clutches as outlined in Chapter 6.

12. Refer to Chapter 6 for PVT installation.