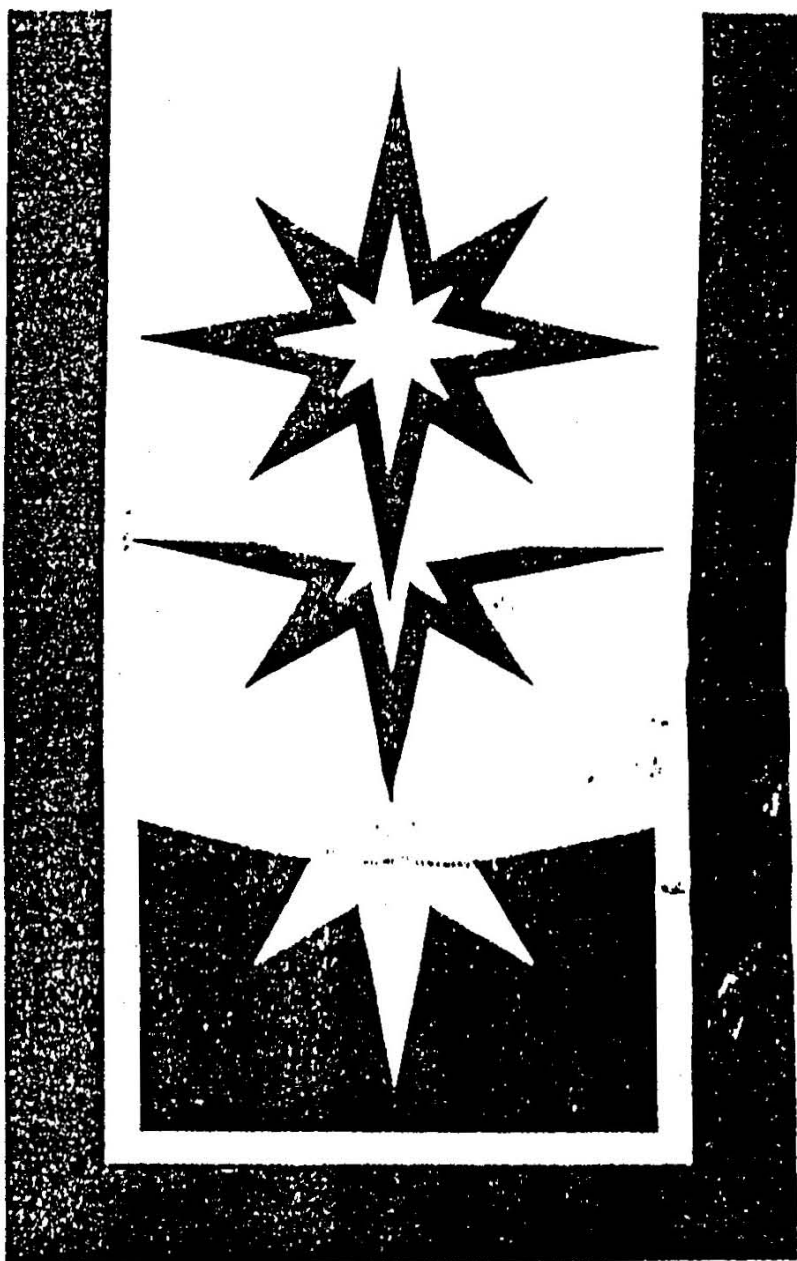




1979 Polaris RXL Mod Kit Manual

Polaris **TEXTRON**

Polaris E-Z-Go Division of Textron Inc.

RXL 340 MOD KIT INSTALLATION AND PARTS LIST

Kit Components:

Part No. 2870462

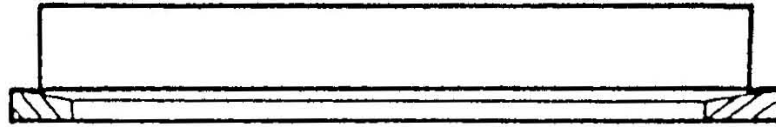
Polaris Part No.	Fuji Part No.	Description	Quantity per Kit
2631188		Hood RXL	1
1260449		exhaust flange	2
5410310		hose - engine to tank	1
1260446		l.h. pipe	1
1260447		r.h. pipe	1
5223877		panel - tunnel back	1
3082985	139-16901-03	cylinder gasket	4
3082986	139-12601-01	cylinder	1
3082987	139-12602-01	cylinder	1
3082988	139-13201-01	cylinder head	2
3082935	146-15101-01	head gasket	4
3082758	003-70060-00	gasket	2
3082989	139-23404-11	piston	2
3082497	139-23501-03	piston ring	4
3081714	110-25006-03	clip	4
3081648	110-22901-03	small end bearing	2
3080126	107-23301-03	piston pin	2
3082737	110-25003-23	piston pin spacer	4
3080077	003-20060-00	spring washer	12
3082990	139-57001-13	pulley (drive)	1
3082991	139-57101-03	spacer	1
3082992	139-57201-00	water pump assy.	1
3082993	139-57901-03	belt	2
3082994	139-57701-03	inlet water manifold	1
3082995	139-57801-03	outlet water manifold	1
3082937	146-56201-03	manifold gasket	4
3082996	139-58001-03	main hose	1
3082724	139-56801-03	hose clamp	2
3082997	139-58101-03	hose clamp	2
3082720	139-65101-11	adapter	2
3082530	131-65201-35	band assy.	2
3080078	003-10060-00	washer	8
3082910	002-38080-00	flange nut	8
3082505	020-00800-00	washer	10
3082911	002-38100-00	flange nut	8

Polaris Part No.	Fuji Part No.	Description	Quantity per Kit
3082507	020-01000-60	washer	8
3081582	004-31061-00	screw	2
3080109	001-66064-00	bolt	4
3082952	001-66086-20	bolt	1
3082901	001-66083-50	bolt	1
3082939	002-17060-00	nut	8
3082062	011-91000-20	socket head bolt	4
3082718	040-10800-10	plug	1
3082719	003-70080-00	gasket (aluminum)	1
3082955	139-55501-21	by-pass plug	1
3082956	021-11400-20	gasket	1
3082716	009-02140-00	bleeder	3
3082717	003-70140-00	gasket	3

It will be necessary to remove the engine from the chassis. Completely disassemble the engine, clean and dry all parts thoroughly.

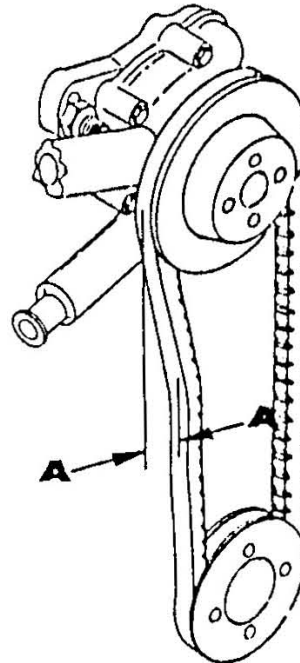
- Using the top half of the crankcase as a reference, the transfer port inlets should be checked for correct mating to the cylinder.
 - set the top half of the crankcase on the cylinder
 - use a hook scribe and mark the crankcase using the cylinders as a guide
 - grind the crankcase to match your scribe line and polish
- Install exhaust flange and gasket. Match the flange to the cylinder by grinding and polish before installation. Chamfer any rough ports - transfer, intake and exhaust.
- Check the crankshaft for straightness (see 1978 RXL manual, Sec. IV, page 16).
 Note: serviceable shaft total runout should not exceed .004".
 Wash all parts in soapy water, rinse, preserve with thin coat of oil.
- Grease labyrinth seal, assemble crankshaft in the case and install new seals at both ends.
- Install new cylinder base gaskets and match to the case.
- Install the pistons, "→" marking toward the flywheel. Install the spiral loc keepers.
- Install the rings on the piston.
 Note: The rings are keystone type and are beveled to the inside.

The bevel must be to the top of the piston. See Diagram:



8. Apply oil to the piston, ring and cylinder. Position the ring at the locator pin and slip the cylinder over the piston using your fingers to fit the ring.
9. Install new head gaskets, large diameter metal surface towards cylinder. Install heads, flat washer, lock washers and nuts. Torque large cylinder nuts 21-23 ft. lbs. and small head nuts 16-18 ft. lbs.
10. Position the stator plate on the case with the stator plate timing ~~mark~~ approximately .050 above the crankcase parting line and secure. (26° @ 4000 RPM.) See RXL manual, Section IV, page 5. Install flywheel, torque to 60-65 ft. lbs. Install spacer and water pump cog drive and starter cup, secure with screws. Install pump belt and recoil.
11. Install the water pump* and position the pump belt on the water pump pulley and adjust. Belt tension can be adjusted by loosening pump hold down screws and moving the pump up or down. See diagram:

1/4" deflection
at point "A"



*It is necessary to remove the water pump pulley to install the pump securing bolts.

12. Install water inlet and outlet gaskets, manifolds and secure. Install the hose from water pump to inlet manifold and secure with clamps.
13. Install secondary coil, and install engine in chassis. Torque motor mount bolts to 55-60 ft. lbs.
14. Connect radiator hose to water pump, connect hose P/N 5410130 to surge tank and outlet manifold and secure with clamps. Install heat gauge sending unit. Plug water by-passes with plug P/N 3082955 (3) and gasket P/N 3082956 (3). Install drive clutch and kit expansion chamber P/N 1260447 r.h. and P/N 1260446 l.h.