

# Polaris 380/360 Factory Tune-up Kit Installation Instructions

## Tools Needed:

- Philips screwdriver
- Needle nose pliers
- Small flathead screwdriver

## Disassembly

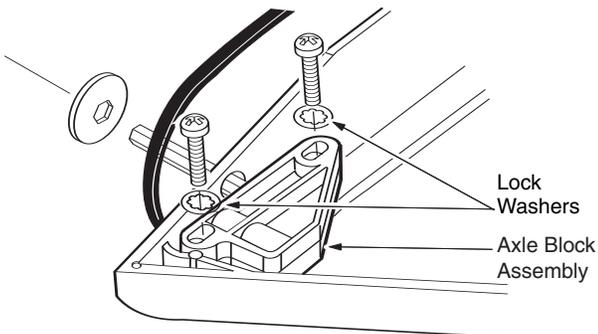
1. Remove the all-purpose bag, head float, top cover(s), and feed pipe.
2. Remove the four screws that secure the frame to the base. Remove the frame from the base and remove the upper turbine housing.

**Note: Locate the gears, bearings and e-clips, and note their positions on the shaft before dismantling the frame.**

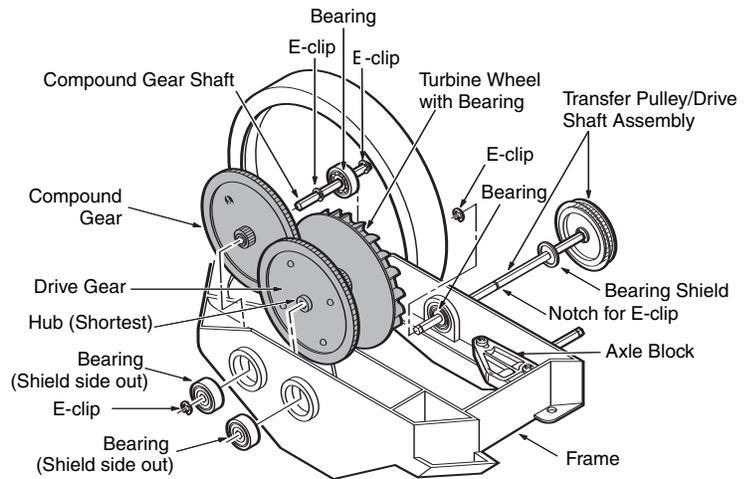
3. Disengage the large and small belts by pushing the belt off the pulley while turning the wheel.
4. Remove the hub caps, e-clips, wheels, belts, axle blocks, transfer pulley, gears, bearings and turbine wheel. These parts can be discarded.

## Assembly

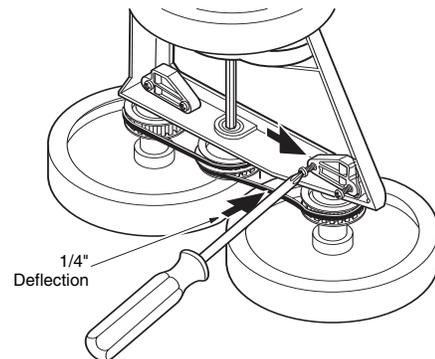
1. Install the new axle blocks using the lock washers with screws. Tighten screws loosely to keep them in place.



2. Install bearings facing inboard. Insert compound gear shaft with inner bearing. Install new compound gear. **Note: Gear may seem tight.**
3. Once gear is installed attach e-clip. Push the compound gear shaft through, secure it to the other side with another e-clip. E-clips should snap into place.
4. Place the longest hub of the new drive gear into the new turbine wheel.



5. Push the drive shaft through the new turbine bearing, turbine wheel, drive gear and install single-side wheel with bearing. Secure with e-clip.
6. Lay the frame on the single wheel side and place the drive belts over the axle block shafts. Install the new bearing shields.
7. Install the new double-side wheels with bearings, e-clips and the hub caps. Engage each belt by pushing the belt onto the pulley while turning the wheel. The small belt should be on the inside of the transfer pulley and the large belt on the outside with the belt divider separating them.
8. Place the frame on the double wheel side. Push the axle blocks toward the outside edge of the Polaris until the belts have 1/4" tension and tighten the axle block screws.



9. Secure the base to the frame. Install feed pipe, upper turbine housing, top cover(s), head float, and the all-purpose bag.