

RACER TECH - RZR XP TURBO / 1000 - ARM KIT INSTALLATION

Thank you for your purchase! We've put a lot of work into building the best bolt-on kit available. There are a few key points one should know to install this kit. If you have any additional questions, please feel free to call tech support anytime at (616) 928-0616. Or email at tech@racertech.com

- **Your kit will utilize the OEM pivot hardware, bushing sleeves and bushings.**
- **If you've purchased your kit with our Delrin Bushing upgrade you will need to reuse everything less the OEM bushings. WE DO NOT RECOMMEND GREASING THE DELRIN BUSHINGS. Unless you ride in areas with extremely high carbon content in the soil**
- **Upon final assembly, you MUST use **RED** Loc-Tite on all of the hardware assemblies involved in installing this kit.**
- **PLEASE read *all* directions before removing stock parts.**

This kit includes:

- (4) Arms
- (6) Grease zerks for inner pivots (press-in)
- (2) Custom heim joints for lower arms w/ jam nuts
- (2) Mono balls for upper arms with snap ring
- (4) Inner spindle adapter pins
- (4) Outer spindle adapter caps
- (4) Spindle adapter bolts (3/8-24 x 3/4" S.H.C.S.)
- (2) Shock mount bolts with nyloc nuts (M10-1.5 x 55mm hex bolts)

Start with disassembly of the OEM suspension. You can leave the axles in the spindle if you'd prefer. We find it a little easier to separate them however.



- Start by pounding in the grease zerks. (The easiest method is a 7mm socket and a hammer.)
- Next install the heim joints to the lower arm and make sure the jam nut is fully threaded until it stops at the head. Leave the jam nut loose for now. You may install the spindle adapter hardware at this point or wait. The picture below shows the assembly.



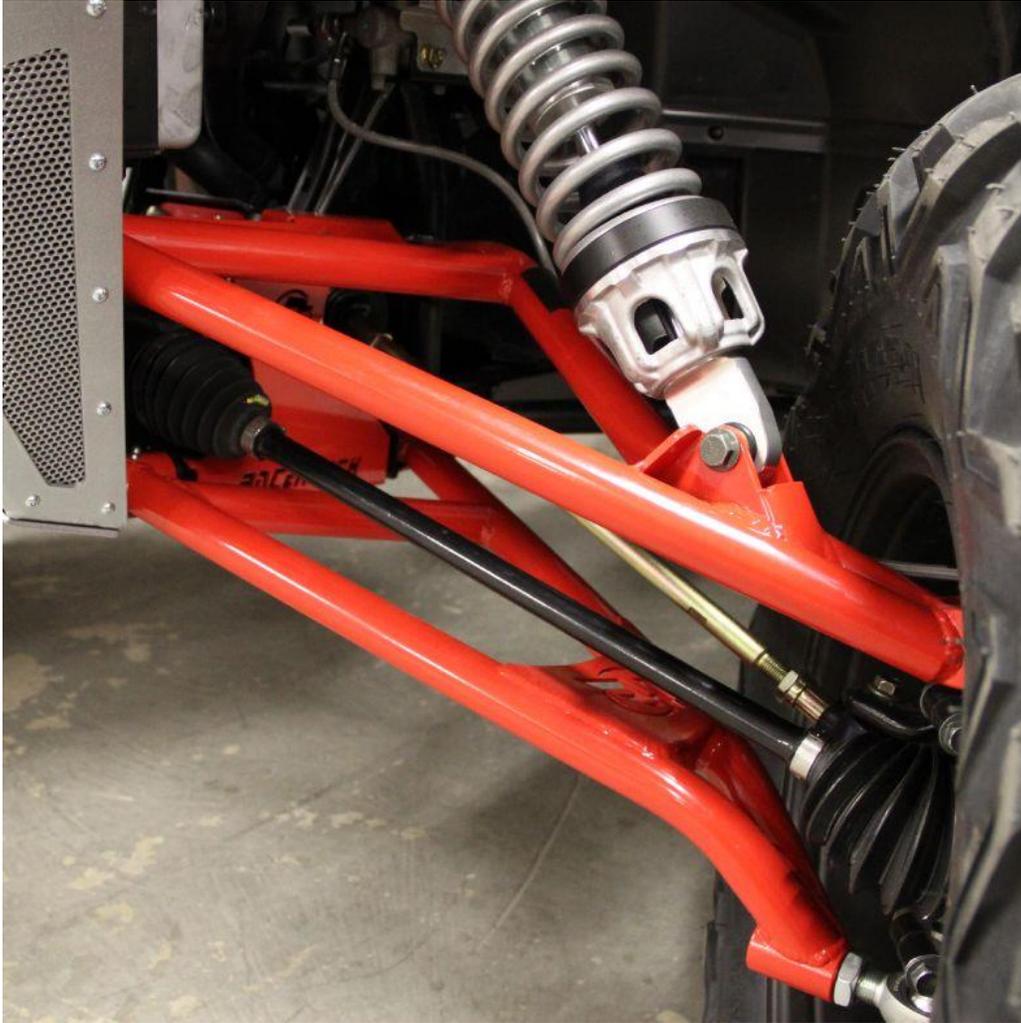
- Next you will install the mono-balls in to the upper arms. These are meant to be a tight fit so take care in making sure the mono-ball is aligned perfectly straight with the cup on the arm. We recommend using hydraulic shop press whenever available but a large socket and a hammer to pound the mono-ball in to the arm. It's ideal to apply pressure on the exterior body of the mono-ball but if a socket isn't available you can use a brass (or softer metal) drift to impact directly on the outer surface of the inner ball. Note: these should not require extremely high force to press in. If you feel the force you're using is too much to start; first check to make sure the outer diameter is perfectly parallel with the inner diameter of the cup. This is the number one reason for issues with these. Second, make sure there is not too much powdercoat build up inside the cup. We try to be careful for this but sometimes you'll need to sand some of the coating out before installing the mono-ball. Just try not to remove any of the metal from the inside when sanding. **Take time with this part of the installation. The better this fit is the longer the assembly will last.**
- Once the mono-ball is pressed in completely. Check to make sure the snap ring groove is fully exposed. This is also a very high precision fit so some adjustments may be necessary. Once the snap ring groove is cleared use a snap ring pliers to install the snap ring. (We recommend positioning the opening of the snap ring to either face directly forward or directly rearward on the RZR.) Use a hammer and a punch to tap around the snap ring to **assure it is FULLY seated.**
- The final assembly will look as shown in the next picture.



- The next step is to install the inner pivot bushings and sleeves in to the arms. Whether you are using the OEM hardware for this or Racer Tech upgrades the installation is the same. The bushings should be tight inside the arms but NOT so tight you need to beat them in! If needed you should sand down the O.D. of the bushings where they contact the I.D. of the arms. **The desired final assembly will be a very snug fit but with enough clearance in the bushing I.D. that the inner sleeves can move with limited friction.** Another note to take is to inspect the final assembly to be sure the inner sleeves protrude just slightly on both sides beyond the outer bushing surface. The arm tabs should tighten against the inner sleeves and not the bushings.
- Modify your hardware as needed. The better this assembly is the longer the bushings and chassis will last without issues.



- We recommend installing the inner spindle adapter pins in to the spindles at this time. The machined grooves will locate the pins when installing the OEM bolts. These bolts should be **VERY** tight after final assembly. **NO FREE PLAY.**
- Next you will mount the arms to the chassis. We recommend starting with the lower arms and loosely fitting the spindle adapter hardware. Then install the upper arms, attach to the spindle and last connect the lower shock mount and the sway bar (if your model has one).
- Tighten all the inner pivot hardware as tight as possible at this point.
- Then tighten the shock hardware and snug up the spindle adapter bolts on upper and lower arms.
- At this point you will check the camber settings on the arms. A simple and easy starting point is to make sure the brake calipers are level at 0° when the suspension is fully extended.
- Mainly, the camber setting at ride height should be negative $.5^\circ$ to 1° depending on driver preference. This means the top of the tire will be leaned in towards the middle of the vehicle. The higher the degree of negative camber the more the front tires will bite in a turn. Although 1° negative is the most you should use.
- Once the camber is set, remove the spindle adapter bolts one at a time and liberally apply **RED** Loctite to the threads. **THIS IS CRITICAL.** By design, there is no retention on this bolt so it is **CRITICAL** you use a high-strength thread locker on all four of these and tighten them as much as possible during final assembly. (If you ever need to remove these a butane torch or other focused heat source can be applied to the head of the bolt for about 30 seconds and the thread locker will melt.)
- If you disassembled the axles initially, the axle nuts should be torqued to 65 ft. lbs.
- Before driving, the alignment of the steering **MUST** be centered and the toe-in should be set at $1/8''$ inwards overall.
- Last, use the supplied zip-ties to secure the brake lines to the rear tubes of the upper arms.



This concludes the installation of this kit. You can adjust the camber setting you suit your driving style from here but the rest should be all set and MUCH more durable than the OEM suspension.

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Disclaimer: Racer Tech / Spectrum Fabrication Inc. will assume no responsibility for accidents or injuries due to improper installation or use of our products. Ride at your own risk!