

GEAR CASE ISOLATION KIT



P/N 2207577

APPLICATION

All 2016 and newer GEM® e2, e4, e6®, and eL XD models

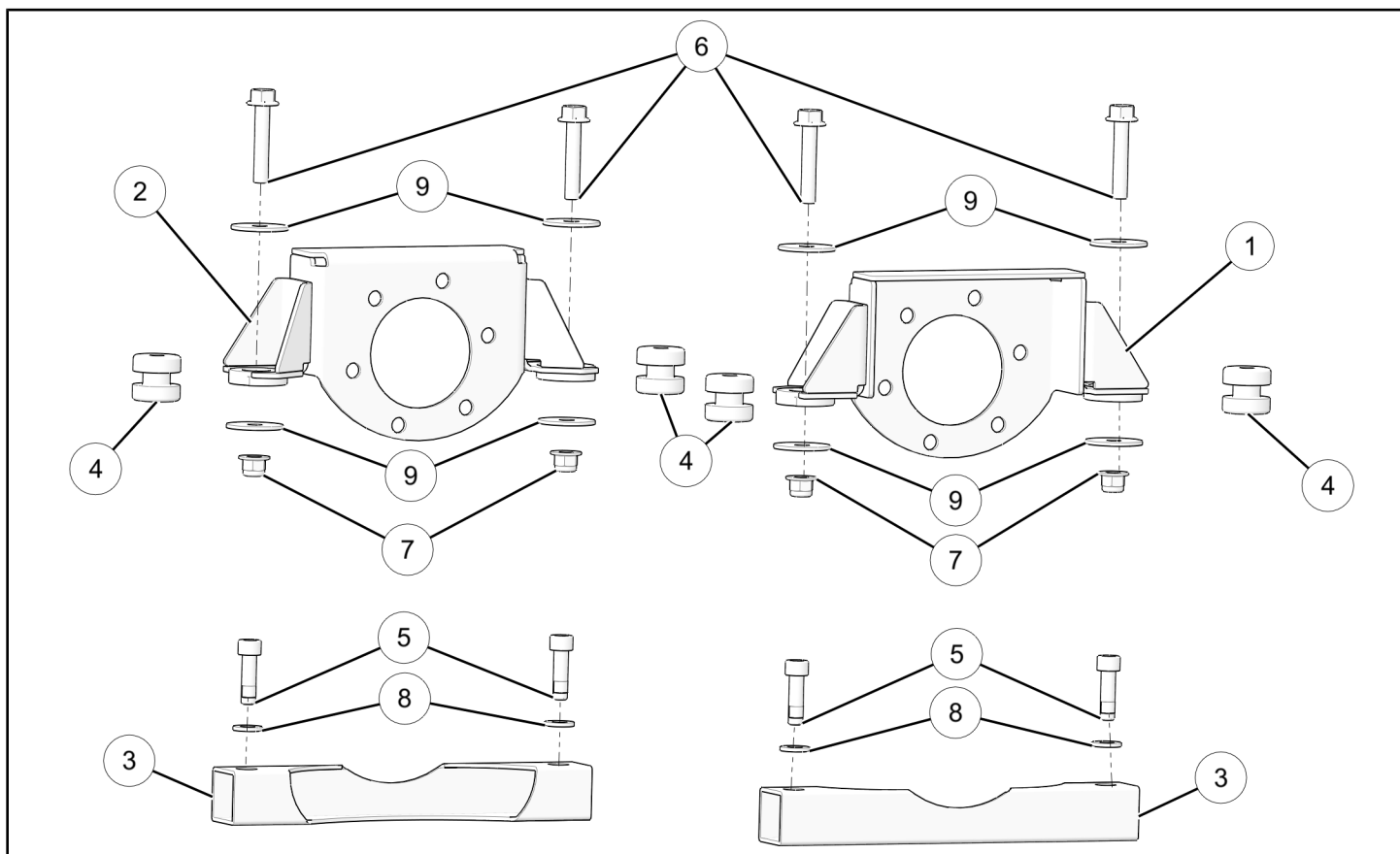
Verify accessory fitment at Polaris.com.

BEFORE YOU BEGIN

Read these instructions and check to be sure all parts and tools are accounted for. Please retain these installation instructions for future reference and parts ordering information.

KIT CONTENTS

This Kit includes:



REF	QTY	PART DESCRIPTION	PART NUMBER
1	1	Gearcase Weld, LH, Black	1023769-458
2	1	Gearcase Weld, RH, Black	1023770-458
3	2	Gearcase Mount, Black	5341028-458
4	4	Bushings, Engine Mount, Rubber	5416525
5	4	Screw, Socket Head, M10 X 1.5 X 35	7518483
6	4	Screw, Hex Flange, M10 X 1.5 X 55	7519726
7	4	Nut, Hex Flange, M10 X 1.5, Nylon	7547313

REF	QTY	PART DESCRIPTION	PART NUMBER
8	4	Washer, 0.813 X 0.406 X 0.105	7555832
9	8	Washer, 10.4 X 40 X 2.06	7557126
	1	Instructions	9928712

TOOLS REQUIRED

- Safety Glasses
- Hex Key Set, Metric
- Pliers, Push Pin Rivet
- Pry Bar
- Socket Set, Hex Bit, Metric
- Socket Set, Metric
- Wrench Set, Metric
- Torque Wrench
- Vehicle Floor Jack

CONSUMABLES REQUIRED

- P-80 Lubricant

IMPORTANT

Your Gear Case Isolation Kit is exclusively designed for your vehicle. Please read the installation instructions thoroughly before beginning. Installation is easier if the vehicle is clean and free of debris. For your safety, and to ensure a satisfactory installation, perform all installation steps correctly in the sequence shown.

ASSEMBLY TIME

Approximately 2 hours

INSTALLATION INSTRUCTIONS

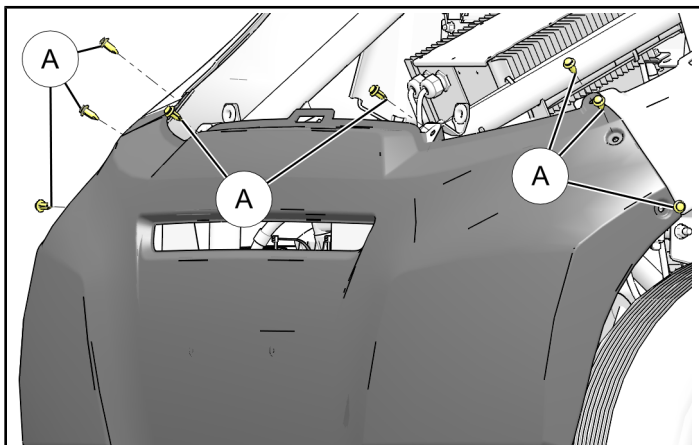
VEHICLE PREPARATION

GENERAL

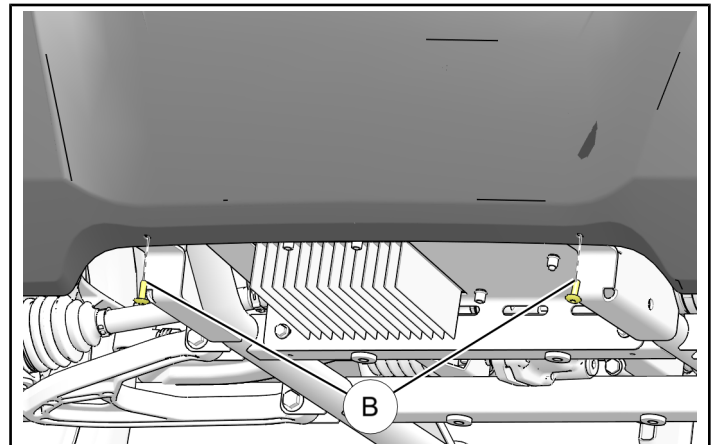
1. Apply parking brake. Turn key to **OFF** position and remove from vehicle.
2. Remove vehicle hood as per owner's manual.
3. Disconnect main electrical harness and battery as per owner's manual.

FRONT BUMPER REMOVAL

1. Remove and retain eight push-pin rivets (A), holding bumper to vehicle frame.



2. Remove and retain two screws (B) from underside of bumper.



CHARGER REMOVAL

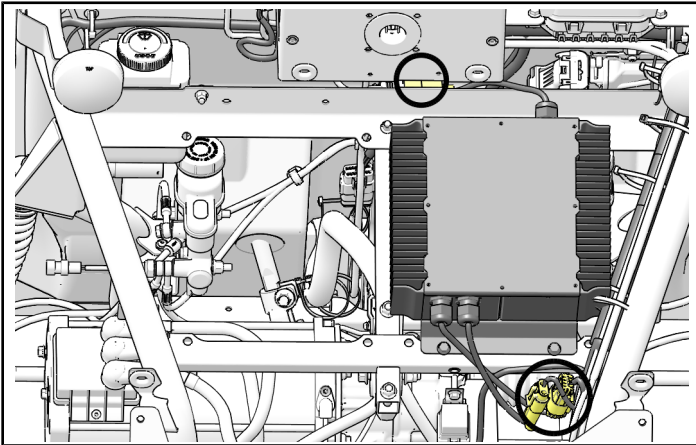
NOTE

Standard charger shown. Other configurations possible.

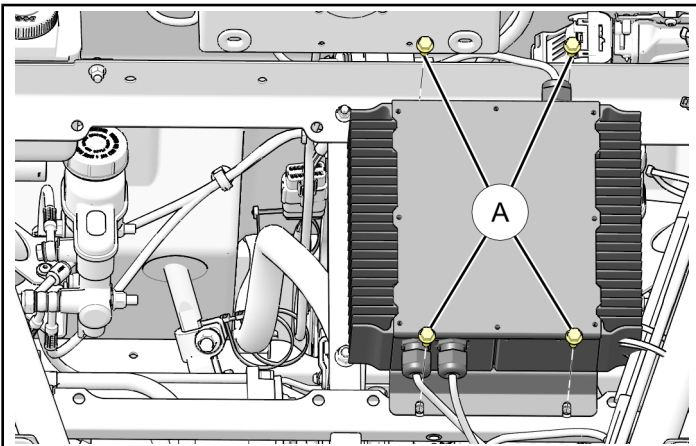
1. Remove and retain charger(s).
 - a. Disconnect all charger connections to vehicle.

NOTE

There may be up to four connections per charger.



- b. Remove and retain four screws **A** securing each charger to mounting brackets and lift charger assembly out of vehicle.



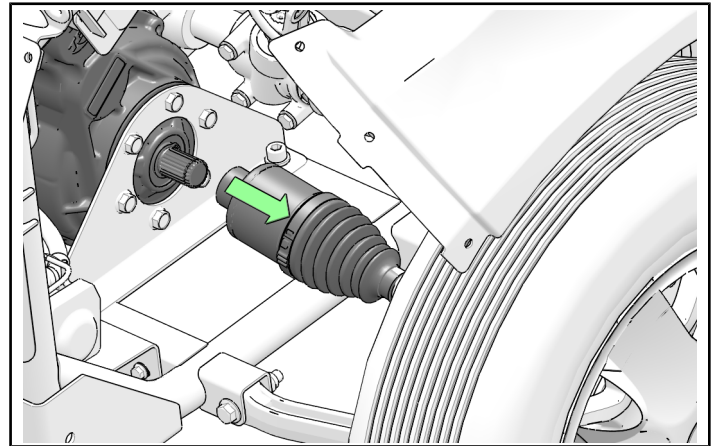
ISOLATION MOUNT INSTALLATION

IMPORTANT

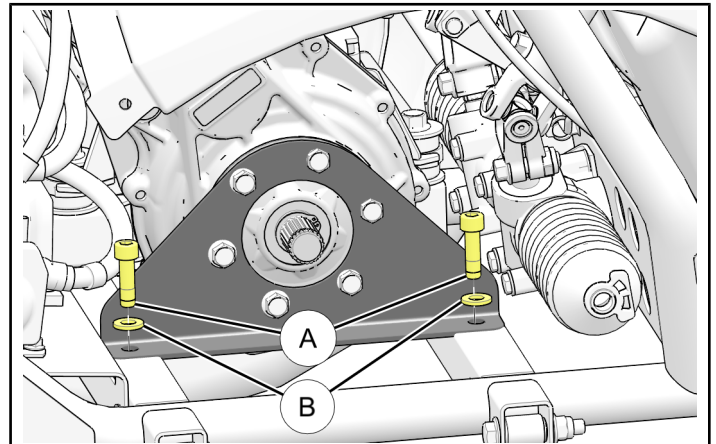
Polaris® strongly recommends second installer or mechanical support to support drive motor during installation.

LH STOCK GEAR CASE BRACKET REMOVAL

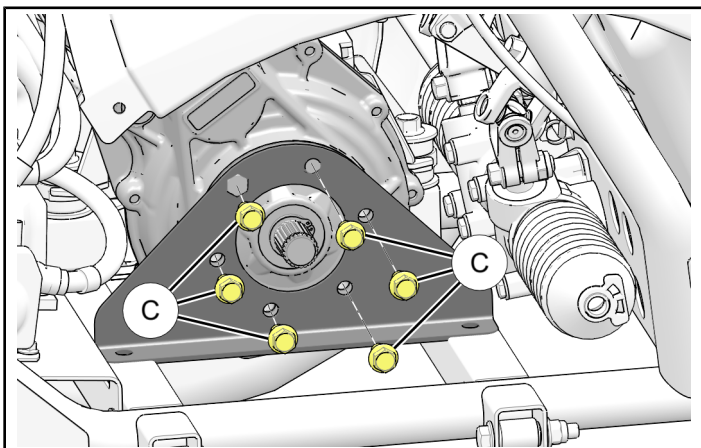
1. Remove both drive shafts.
 - a. Following all jack instructions, raise vehicle high enough to release tension on drive shafts.
 - b. With vehicle raised, remove two front drive shafts from gear case.



- c. Lower vehicle after drive shafts are removed from gear case.
2. Remove LH gear case bracket.
 - a. Remove and discard two bolts **A** and two washers **B** from LH gear case bracket.



- b. Remove and retain six bolts ③ from LH gear case bracket. Discard stock gear case bracket.



LH ISOLATION MOUNT INSTALLATION

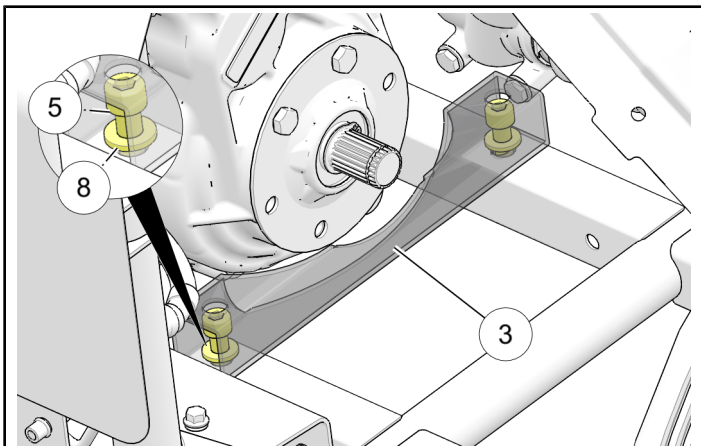
TIP

Loosen but do not remove two bolts on RH gear case bracket to ease installation of LH isolation mount.

1. Place gear case mount ③ atop vehicle frame and install with two bolts ⑤ and two washers ⑧.

TORQUE

Two bolts ⑤: **40 ft. lbs. (54 Nm)**

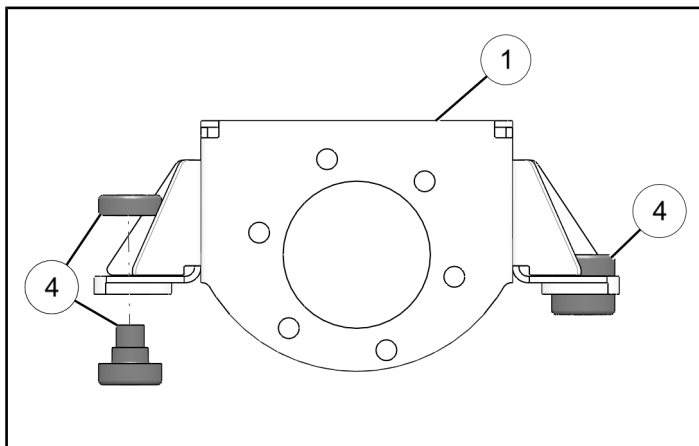


2. Prepare LH gear case bracket ①.

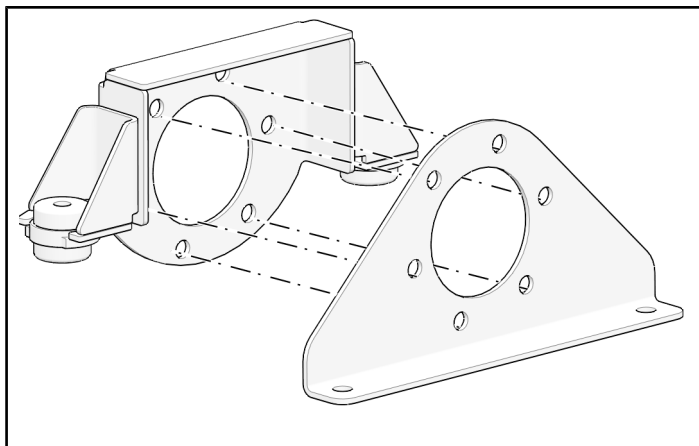
- a. Install two bushings ④ on LH gear case bracket ①.

TIP

Use temporary lubricant such as P-80 or water and soap solution to ease bushing installation.



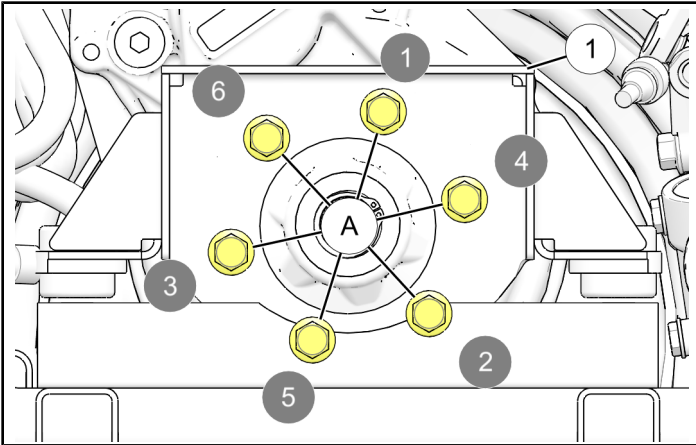
- b. Ensure proper orientation of gear case bracket by aligning with six holes of stock gear case bracket. **RH bracket differs from LH bracket.**



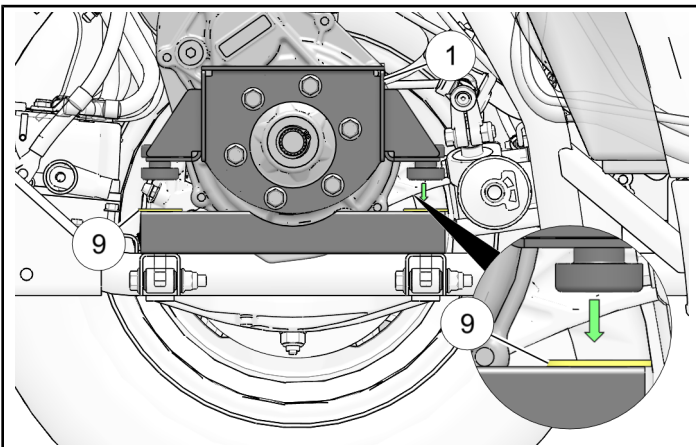
3. Install LH gear case bracket ①.
 - a. Install LH gear case bracket ① to gear case with six retained bolts ④.

TORQUE

Six bolts ④: **28 ft. lbs. (38 Nm)**



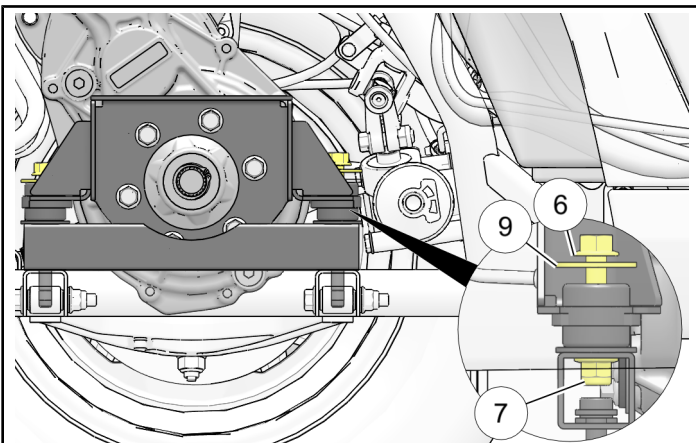
- b. Place LH gear case bracket ① atop two washers ⑨.



- c. Loosely install LH gear case bracket ① to gear case mount with two bolts ⑥, two washers ⑨, and two nuts ⑦.

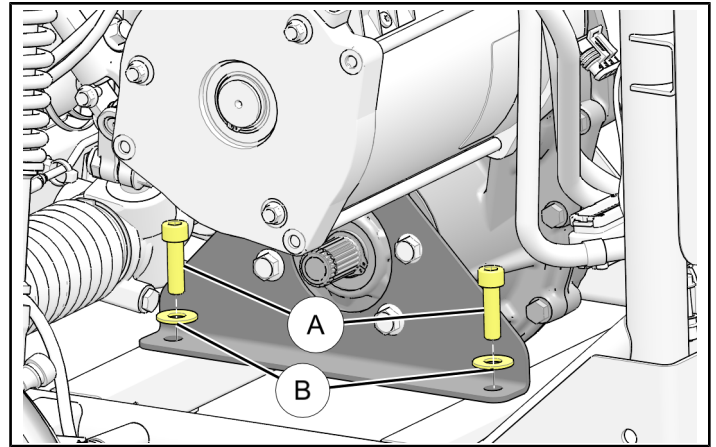
NOTE

Do not torque bolts at this time.

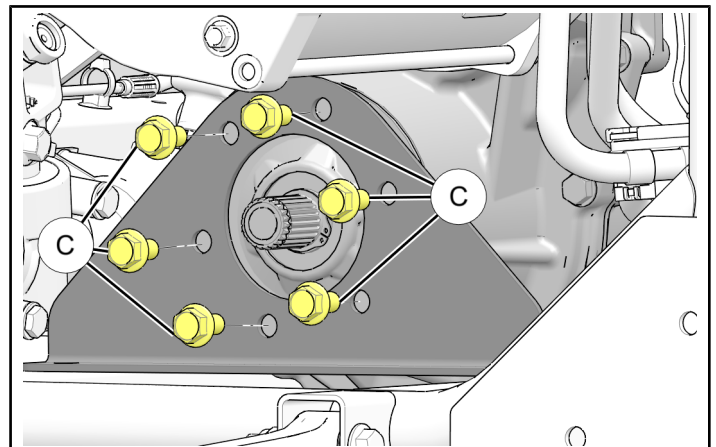


RH STOCK GEAR CASE BRACKET REMOVAL

1. Remove RH gear case bracket.
 - a. Remove and discard two bolts ④ and two washers ⑨ from RH gear case bracket.



- b. Remove and retain six bolts ④ from RH gear case bracket. Discard stock gear case bracket.

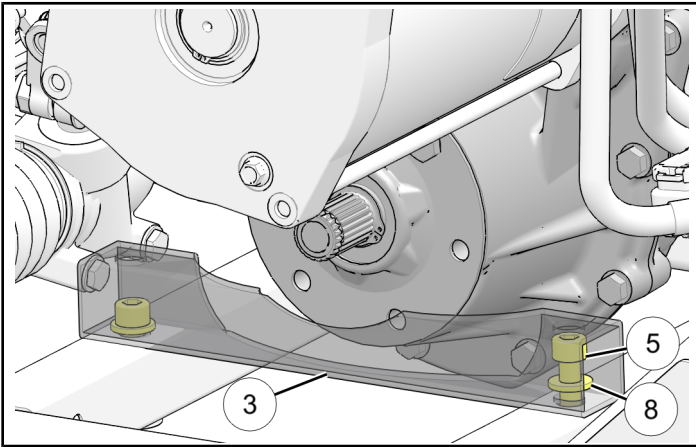


RH ISOLATION MOUNT INSTALLATION

1. Place gear case mount ③ atop vehicle frame and install with two bolts ⑤ and two washers ⑧.

TORQUE

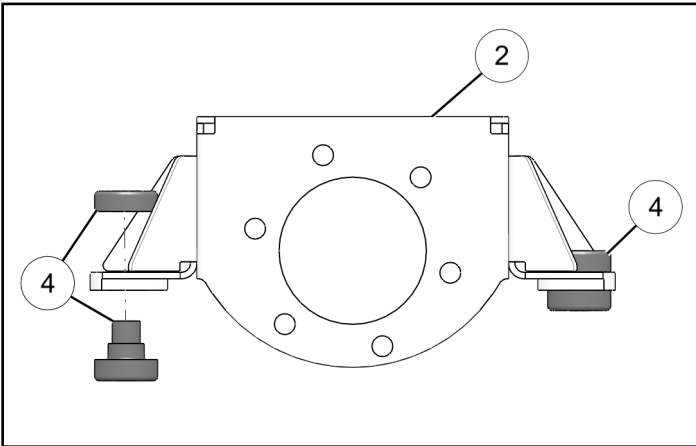
Two bolts ⑤: **40 ft. lbs. (54 Nm)**



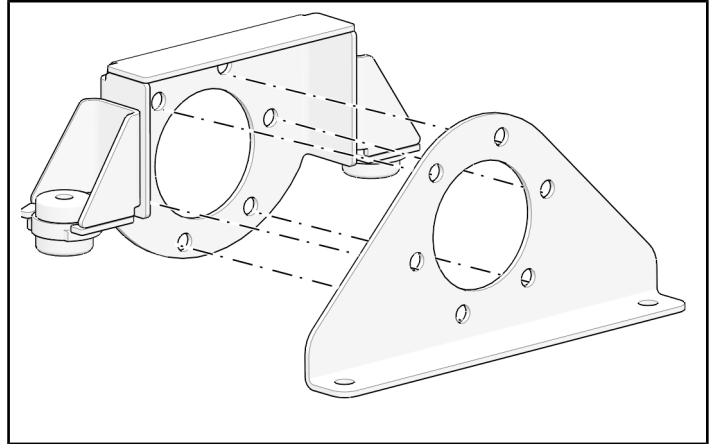
2. Prepare RH gear case bracket ②.
 - a. Install two bushings ④ on RH gear case ②.

TIP

Use temporary lubricant such as P-80 or water and soap solution to ease bushing installation.



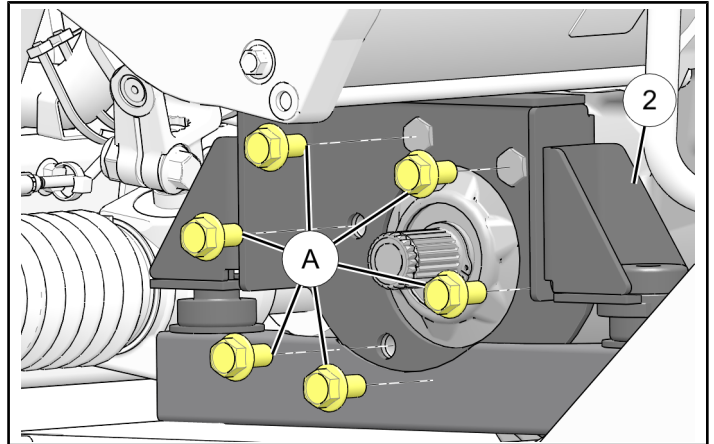
- b. Ensure proper orientation of gear case bracket by aligning with six holes of stock gear case bracket. **RH bracket differs from LH bracket.**



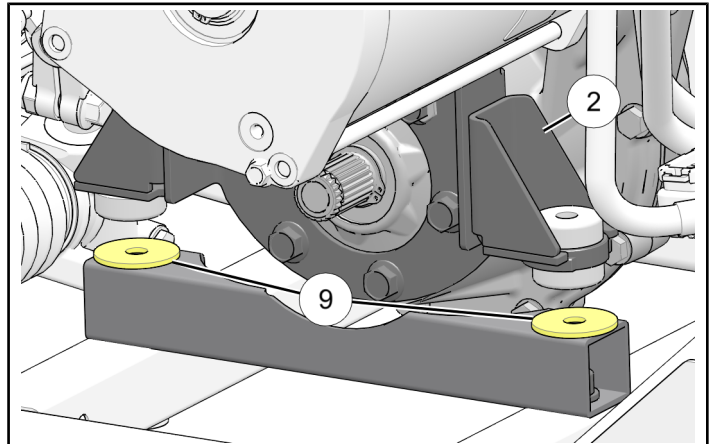
3. Install RH gear case bracket ②.
 - a. Install RH gear case bracket ② with six retained bolts ①.

TORQUE

Six bolts ①: **28 ft. lbs. (38 Nm)**



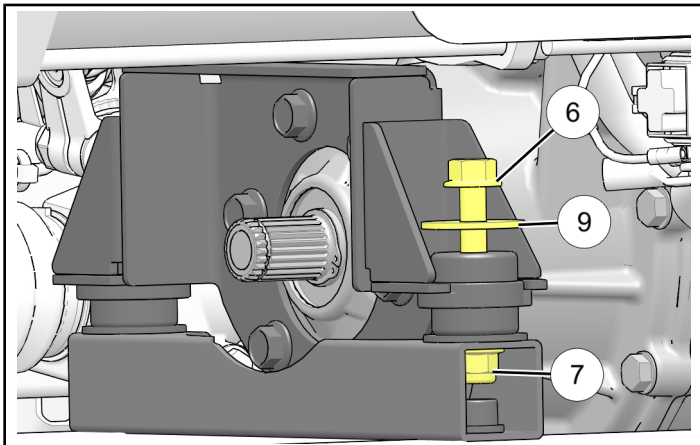
- b. Place RH gear case bracket ② atop two washers ⑨.



- c. Loosely install RH gear case ① with two bolts ⑥, two washers ⑨, and two nuts ⑦.

NOTE

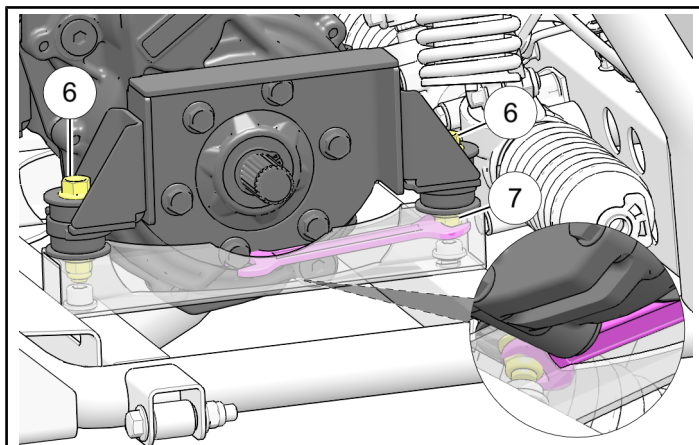
Do not torque bolts at this time.



- b. Place wrench within concave portion of LH gear case mount and position wrench on nuts ⑦.

TORQUE

Two bolts ⑥: **30 ft. lbs. (41 Nm)**

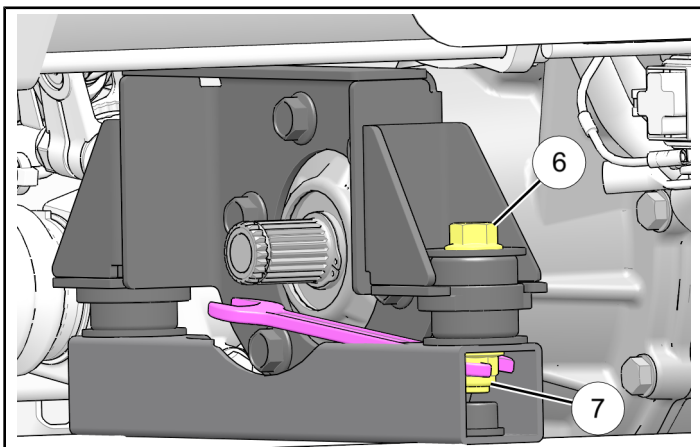


4. Complete installation.

- a. Place wrench within concave portion of RH gear case mount and position wrench on nuts ⑦.

TORQUE

Two bolts ⑥: **30 ft. lbs. (41 Nm)**



VEHICLE REASSEMBLY

1. Following all jack instructions, lift vehicle and reinstall two drive shafts.
2. Reinstall bumper with eight push-pin rivets ① and two screws ②, retained from **Vehicle Preparation** section.
3. Reinstall vehicle hood as per owner's manual.
4. Reconnect battery and main electrical harness as per owner's manual.

FEEDBACK FORM

A feedback form has been created for the installer to provide any comments, questions or concerns about the installation instructions. The form is viewable on mobile devices by scanning the QR code or by clicking [HERE](#) if viewing on a PC.

FEEDBACK FORM

