



RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Crankcase Main Stud Kit
PART# - RS10850-CMSK

APPLICATION(S): Sea-Doo 215/230/255/260/300

Required tools
OEM Service Manual

Part#
CALL

***** NOTE: Allow craft's engine to cool thoroughly before performing installation. *****

- INSTALLATION INSTRUCTIONS -

1. To ensure proper thread engagement and accurate torque readings clean ALL threads in block. Chase if necessary.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damages.
3. Check all hardware for proper fit, length and dimension prior to installing.
4. Screw studs into block HAND TIGHT ONLY. **NOTE: Loc-tite may be used if a permanent mounting of the studs is preferred. However, the fasteners must be torqued prior to the Loc-tite curing.**
5. Install crankshaft. Check for binding or misalignment.
6. Lubricate stud threads, nuts and washers with 30w motor oil **ONLY**. This is due to higher friction on studs as well as inconsistencies in the clamping of fasteners when motor oil or other low-quality lubricants are used.
7. Install washers and nuts and screw hand tight.
8. Following the torque sequence outlined in the service manual tighten the nuts in a three-step process to achieve a total of 50 ft•lb.

NOTE: When changing from factory fasteners to high-strength fasteners, clamping force and tolerances will change, therefore it will be necessary to check the main bearing bores for proper size and out of round condition after installation of the studs and align hone the cylinder block if necessary. The main bores should always be align honed using the same fasteners and lubricant which will be installed during final engine assembly at the recommended preload.

***Remember, the water belongs to everyone.
Please ride responsibly and respect the environment!***

Technical Support

For answers to questions regarding installation or trouble shooting RIVA Performance Products contact:
RIVA Technical Support directly at (954) 247-0705 or by e-mail at tech_support@rivaracing.com.

Limited Warranty

RIVA Crankcase Main Stud Kits carry a Lifetime limited warranty to the original purchaser. They are warranted to be free of defects in materials and workmanship under normal use and service. Customer modified components will be void of warranty. This warranty is limited to defects in the primary components only. Finish and/or wear marks in or on primary components are not covered under this warranty.

RIVA Racing's liability is expressly limited to the repair or replacement of the components contained within or associated with this kit. RIVA Racing agrees to repair or at RIVA's option, replace any defective unit without charge, if product is returned to RIVA Racing freight prepaid within the warranty period. Any equipment returned which, in RIVA's opinion, has been subjected to misuse, abuse, overheating or accident shall not be covered by this warranty.

RIVA Racing shall have no liability for special, incidental or consequential damages or injury to persons or property from any cause arising from the sale, installation or use of this product.

No other warranty, express or implied, including, but not limited to the implied warranties of merchantability and fitness for a particular purpose, applies. Various states do not allow for the limitation of incidental or consequential damages and therefore the above exclusion or limitation may not apply to you.

Warranty does not include the expenses related to freight or transportation of parts or compensation for any inconvenience or loss of use while being repaired. A copy of the original invoice and a Return Authorization Number (RA#) must accompany all warranty claims.

Warranted replacement parts will be returned freight collect.