



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

## Sea-Doo 325 Intake Manifold Bushing & Seal Kit

RS12220-IBSK



### Applications:

All 325hp Sea-Doo Models

### Approximate Installation Time:

1 hour

### **GET THE LATEST UPDATES!**

Prior to installation, go to the RIVA Racing online Instruction Library to download the latest version of these instructions:

<https://rivaracing.com/instructions>

### Recommended Specialty Tools:

Star Socket

### Part #

RS09531

### Required Materials:

Blue Loctite

### Part #

N/A



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### **COMPONENT LIST**

<u>ITEM</u>	<u>DESCRIPTION</u>	<u>RIVA PART #</u>	<u>QTY</u>	<u>NOTES</u>
A	Intake Manifold Gasket	420950740	3	
B	Intake Manifold Bushing	6221	7	
C	M6 x 25 Torx Screws	.6C25SPCS	7	
	Zip Tie, MED.	TY24MX	5	Not pictured

Your kit was inspected and verified before being carefully packaged by our staff. Please check package contents before beginning assembly. If you have a question about missing or damaged items please contact RIVA Technical Support directly at (954) 247-0705 or by e-mail at [tech\\_support@rivaracing.com](mailto:tech_support@rivaracing.com).

We strongly recommend the use of a service manual to familiarize yourself with the various components and procedures involved with this installation. Please note that some of the original hardware removed in the disassembly process will be used in the installation process. These instructions have been written in step-by-step format and refer to illustrations. Read through instructions entirely before performing installation. Please follow these step-by-step instructions and illustrations carefully.

**\*\*\* ALLOW ENGINE TO COOL COMPLETELY BEFORE PERFORMING INSTALLATION \*\*\***

**\*\*\* NO SMOKING \*\*\* NO SMOKING \*\*\* NO SMOKING \*\*\***

**Caution: Whenever using electric or battery operated tools inside the hull be sure it is well ventilated and no fumes are present. Failure to do so could result in a fire, or explosion and serious personal injury or death.**

## **- INSTALLATION INSTRUCTIONS -**

Remove seat(s).

Remove engine service cover (13 Torx screws).

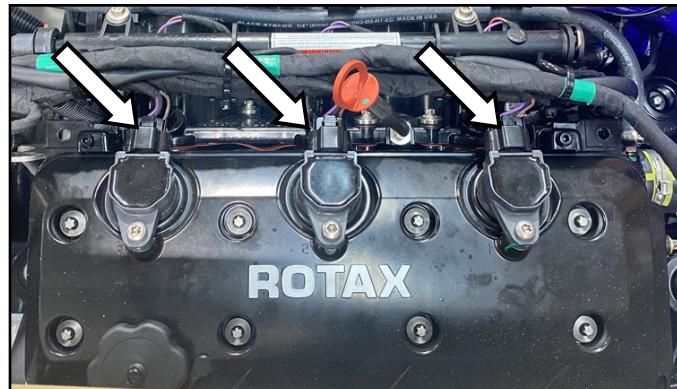
Unclip straps (2) securing plastic air intake tube to intake manifold.



Remove plastic air intake tube. **TIP: Remove plastic clips on air intake tube cradle. They are easy to dislodge and they are not available separately!**

Remove plastic engine cover.

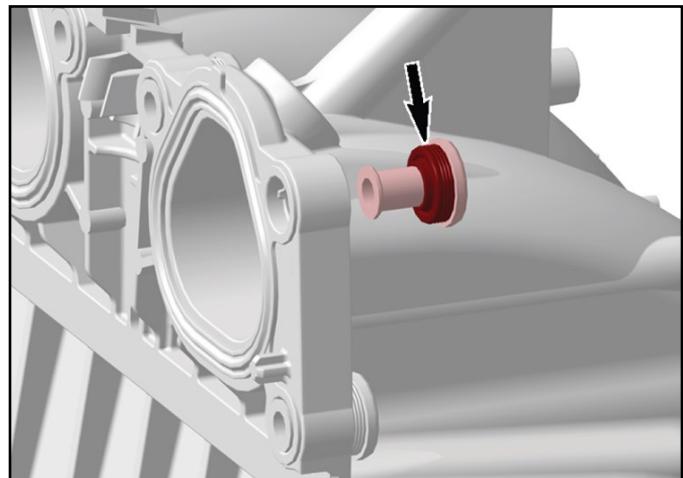
Disconnect coils (3).



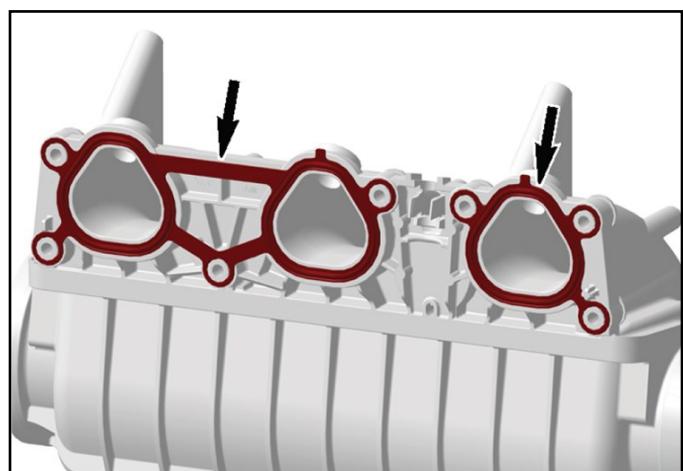
Remove bolts (8) securing intake manifold and discard.



Carefully remove inserts (8) from intake manifold and discard.

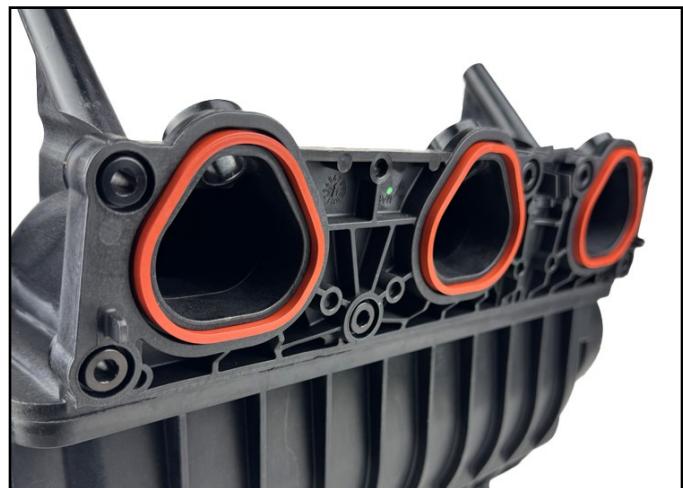


Pull intake manifold away from cylinder head to access sealing gaskets. **NOTE: It may be necessary to remove zip ties securing electrical wiring harnesses.**



Remove original sealing gaskets (2) and discard.

Carefully install supplied individual gaskets (3). **NOTE: Ensure gaskets are properly seated in grooves.**



## **- INSTALLATION INSTRUCTIONS -**

Allow intake manifold to rest against cylinder head.

Insert supplied bushings (8) into intake manifold bolt hole locations.



Secure intake manifold using supplied M6 x 25 Torx screws. **NOTE: Apply blue Loctite to threads. Torque bolts in sequence to 80 in•lb (9 N•m).**



Secure electrical wiring harness with supplied zip ties.

Reconnect coils (3).

Replace plastic engine cover.

Replace plastic air intake tube and secure.

Check bilge for rags, tools etc.

Run craft on a flush hose to check for proper operation.

Replace engine service cover and/or seat(s) previously removed.

***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](mailto:tech_support@rivaracing.com).

### **Limited Warranty**

RIVA Intake Manifold Bushing & Seal Kits carry a 1-year 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.