



RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Rear Exhaust Kit
PART# RS15050-1

We strongly recommend the use of a Sea-Doo service manual to familiarize yourself with the various components and procedures involved with this installation. Please note that some of the original clamps, hoses and hardware removed in the disassembly process will be used in the installation process. These instructions have been written in point form and refer to illustrations and templates. Please follow these step-by-step instructions and illustrations carefully.

NOTE: These installation instructions are broken up into 2 booklets.

**This booklet is for 215hp RXP,
RXT, & GTX-SC applications.**



**For 255hp RXP-X & RXT-X applications
please refer to other booklet.**

– INSTALLATION INSTRUCTIONS –

Required Specialty Tools

	Part#
Dremmel®, Roto Zip® or Die Grinder	N/A
VTS Socket Tool	295 000 133
Exhaust Outlet Tool	295 000 132

Recommended Specialty Tools

	Part#
Sea-Doo Service Manual	219 100 313

Read through the installation instructions entirely before beginning. Prior to installing this kit you are required to install our O.P.A.S. Performance Block-off Kit first (part# RS29050-1). We also recommend the use of our Power Filter Kit (part# RS13050).

1. Remove D.E.S.S. lanyard.
2. Unclip engine coolant overflow tank and remove from mounting location.
3. **RXP:** Remove engine cowling (5 bolts total). (see illustration #'s 1 & 2)
RXT/GTX-SC: Remove top half of deck beam (4 bolts total). (see illustration #3) Remove bottom half of deck beam. (see illustration #4) Discard vent tube.
4. Remove large exhaust hose connecting water box to exhaust outlet baffle. (see illustration #5) **NOTE: Retain OE hose clamps for use during installation.**

RXP models follow steps 5~9 (see illustrations 6 & 7). RXT/GTX-SC models skip to step 10.

5. Connect D.E.S.S. lanyard. Set VTS to fully up position. Remove D.E.S.S. lanyard.
6. At pump disconnect VTS rod from VTS shaft.
7. Remove rubber boot sealing VTS motor shaft.
8. Remove nut securing VTS motor assembly to hull. (see illustration #7)
9. Inside hull remove VTS from thru-hull fitting and set aside.
10. Loosen and remove M10 bolt and spacer securing front of exhaust baffle to hull. (see illustration #8) Remove exhaust baffle and exhaust hose connected to exhaust outlet. **NOTE: Retain OE hose clamps for use later during installation.**
11. Remove stock exhaust outlet. Install supplied exhaust outlet block-off in its place and secure using stock gasket and lock nut. (see illustration #9) **NOTE: Apply silicone sealant to stock gasket and block-off threads. Do not over tighten lock nut.**

RXP models follow step 12. RXT/GTX-SC models skip to step 13.

12. Replace VTS motor and pump assembly in reverse order of steps 5~9.
13. Using the supplied template for your craft [RXP page 8 • RXT/GTX-SC page 9] mark location on left side of transom where supplied billet exhaust outlet flange is to be installed. Hole can be made using a hole saw bit or with a Dremmel®, Roto Zip® or die grinder tool. **NOTE: Do not make hole larger than 2-7/8" in diameter. Wear safety glasses and a dust mask. We strongly recommend the use of a shop-vac during this step as well.**
14. Thoroughly clean inside of hull and transom surfaces (inside and out) so they are free of fiberglass dust.
15. Install supplied rubber gasket onto exhaust outlet. Install exhaust outlet into hull. Apply silicone to retainer ring and install onto exhaust outlet inside of hull. Secure using supplied hardware. (see illustration #10) **NOTE: Apply blue Loc-tite to threads of bolts. Do not over tighten bolts. Bolts are over tightened if rubber gasket begins to squeeze out from behind exhaust outlet flange.**

‘07 and older models follow step 16. ‘08 models skip to step 17.

16. Attach end of exhaust cooling bypass waterline to fitting in end of exhaust tube and secure using supplied hose clamp. (see illustration #11) For **RXP** models this line was removed from stock exhaust outlet. For **RXT/GTX-SC** models this line is attached to fitting at pump transom. (see illustration #13) After removing install supplied block-off cap and secure with supplied zip tie. **NOTE: Do not over tighten clamps or zip tie.**
17. Remove fitting in end of supplied aluminum exhaust tube. Apply pipe thread sealant to supplied brass block-off fitting and install into aluminum exhaust tube. **NOTE: Do not over tighten fitting.**

18. Install supplied 4-1/2" silicone coupler onto straight end of exhaust tube enough so it may be secured properly. Secure with OE hose clamp. (see illustration #11) **NOTE: Do not over tighten clamp.** Loosely install second OE hose clamp.
19. Thoroughly clean water box outlet with a non-residual cleaner. Install supplied 2-1/2" silicone coupler onto water box outlet. Secure with OE hose clamp. **NOTE: Do not over tighten clamp.** Loosely install second OE hose clamp.
21. Apply a generous amount of glass cleaner into couplers. Install exhaust tube and secure hose clamps. (see illustration #12)
22. Replace components applicable to your craft that were removed during step #3. **NOTE: Use BLUE Loc-tite. Do not over tighten bolts.**
23. Replace engine coolant overflow tank.
24. Installation is now complete. Thoroughly inspect engine compartment and bilge for tools, rags, parts, etc. Run craft on stand using flush kit. After engine cools check all hoses and clamps to make sure they are secure. **NOTE: Do not over tighten clamps.**

Remember, the water belongs to everyone. Please ride responsibly!

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@rivamotorsports.com

LIMITED WARRANTY

RIVA Rear Exhaust Kits carry a 90-day 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 must accompany all warranty claims.

Warranted replacement parts will be returned freight collect.

- INSTALLATION IMAGES -

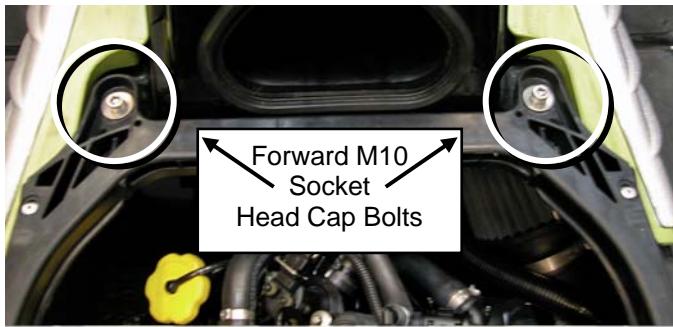


Illustration 1
RXP MODELS

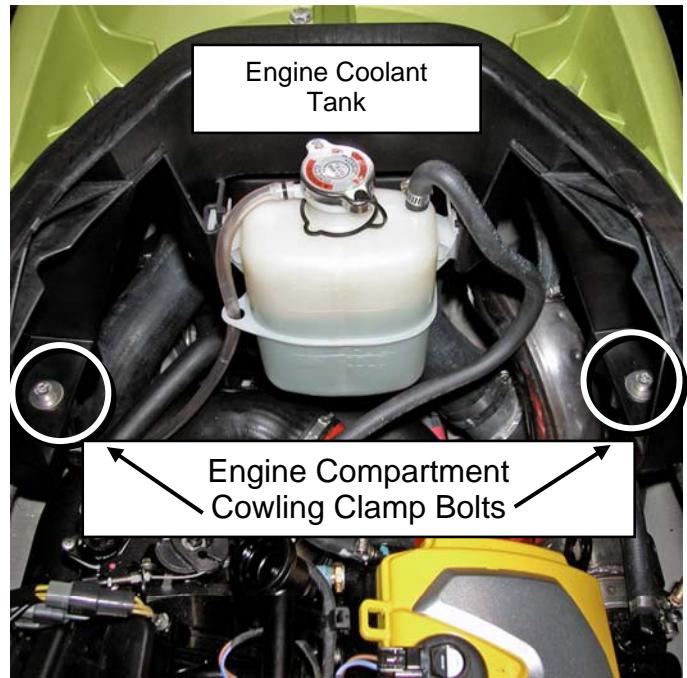


Illustration 2
RXP MODELS

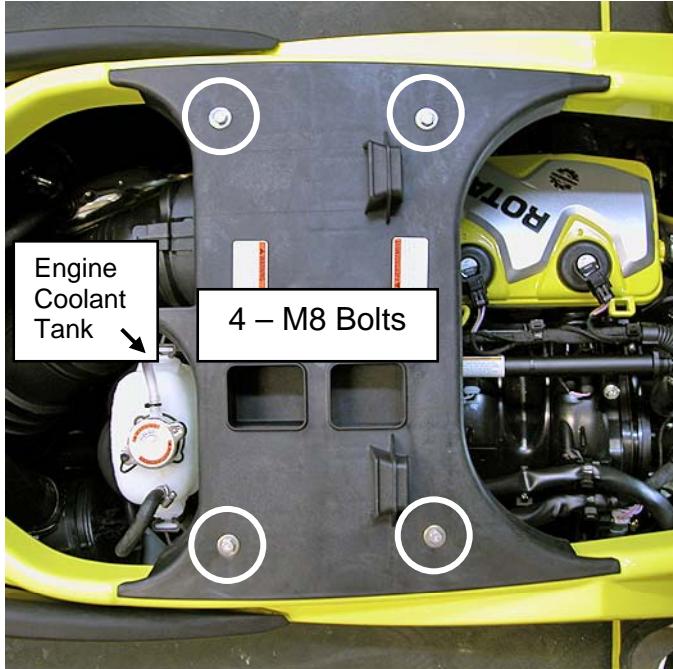


Illustration 3
RXT/GTX-SC MODELS

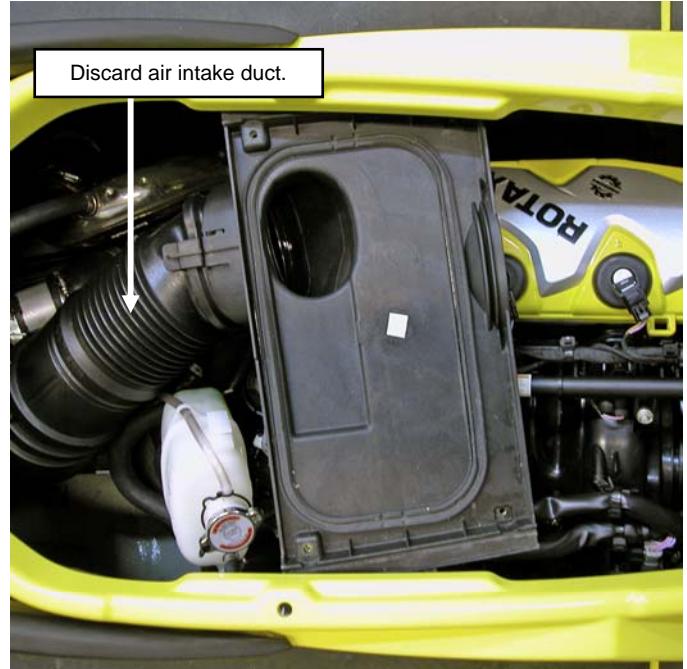


Illustration 4
RXT/GTX-SC MODELS

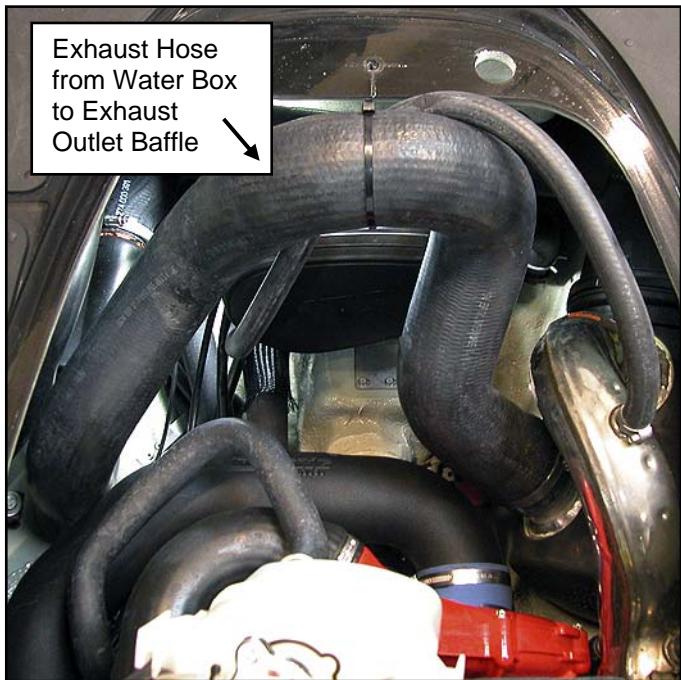


Illustration 5

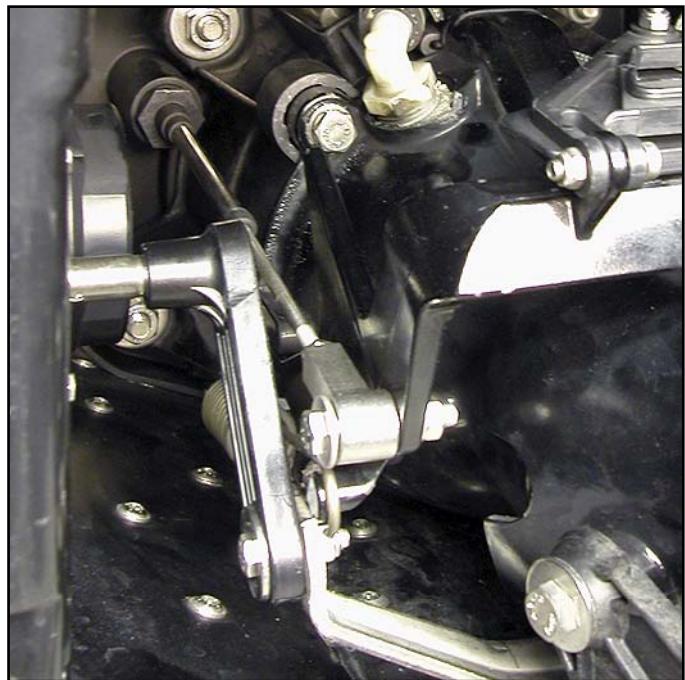


Illustration 6

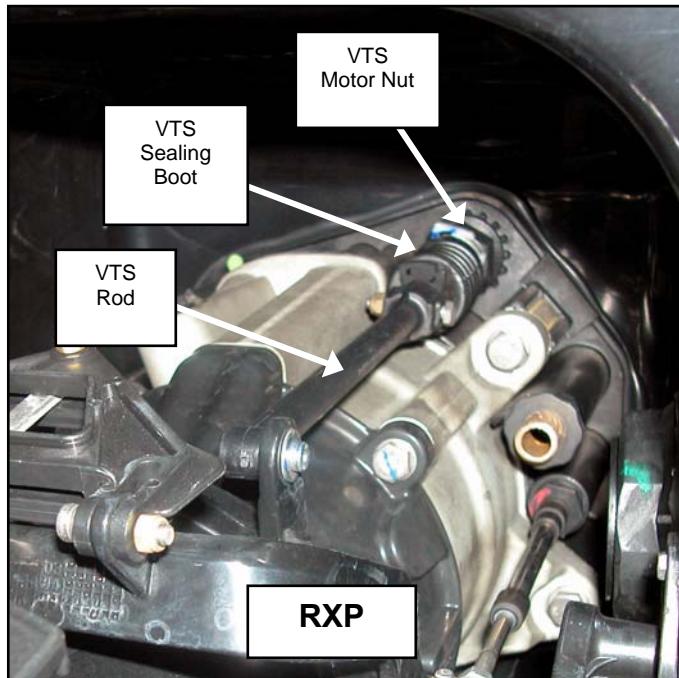


Illustration 7

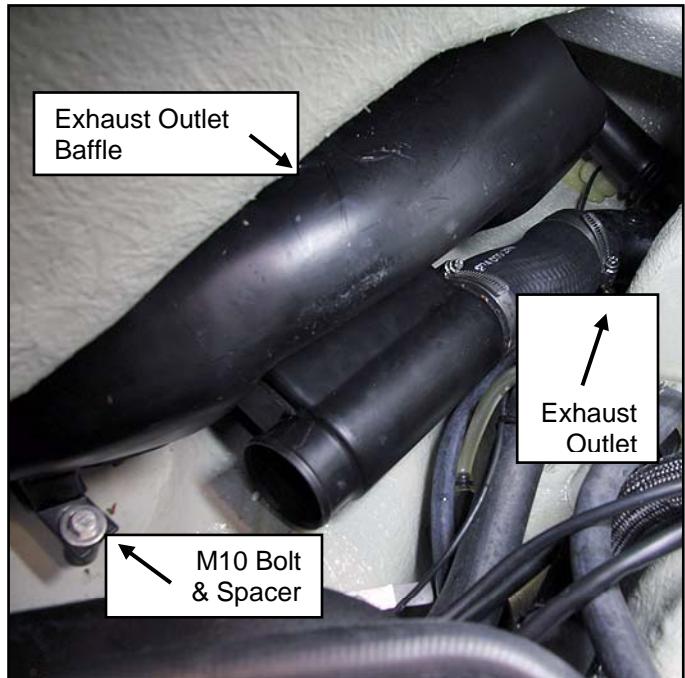


Illustration 8



Illustration 9

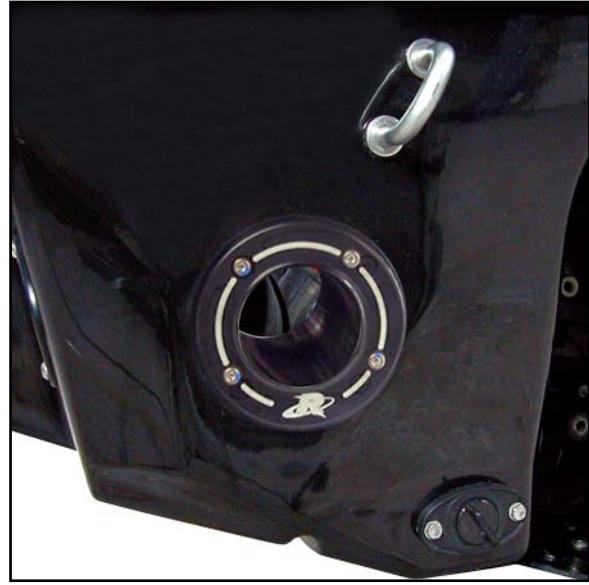


Illustration 10



Illustration 11

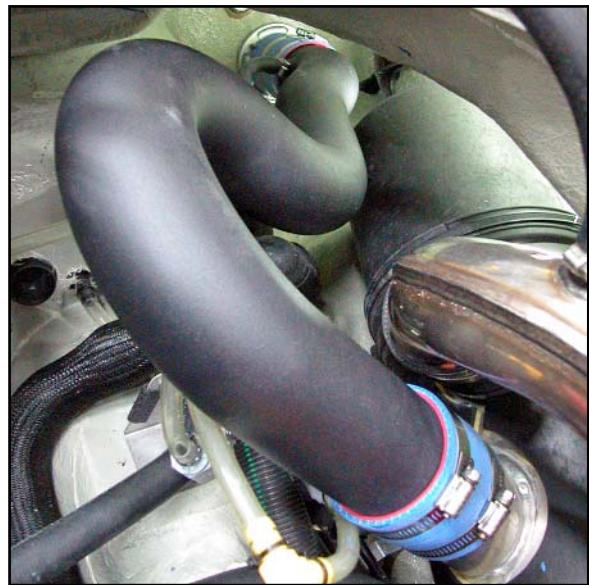


Illustration 12

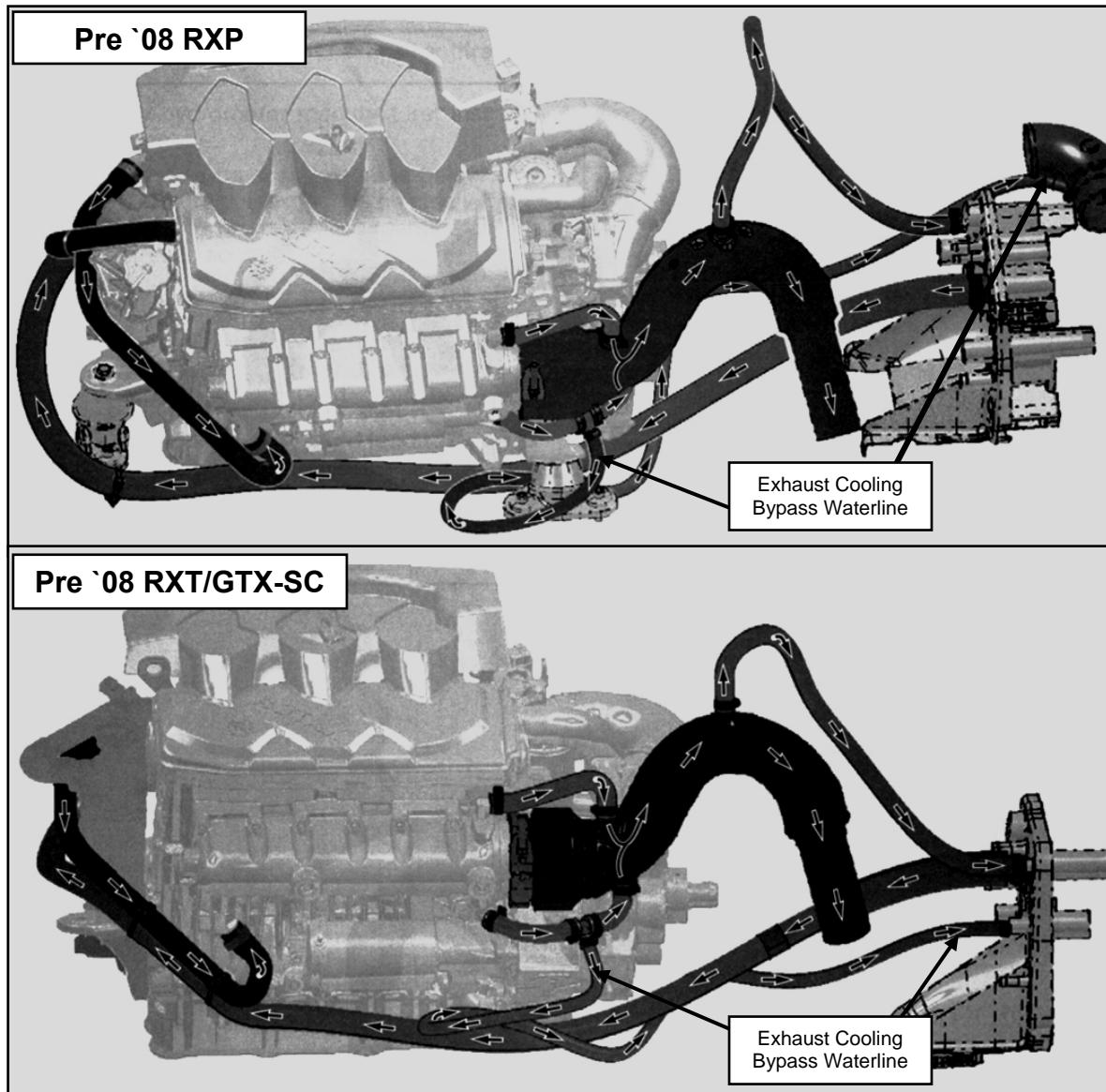


Illustration 13 - Cooling System Reference

215hp RXP Rear Exhaust Outlet Template

CUT OUT TEMPLATE ALONG DOTTED LINE
THIS EDGE AGAINST UNDERSIDE OF BOND FLANGE



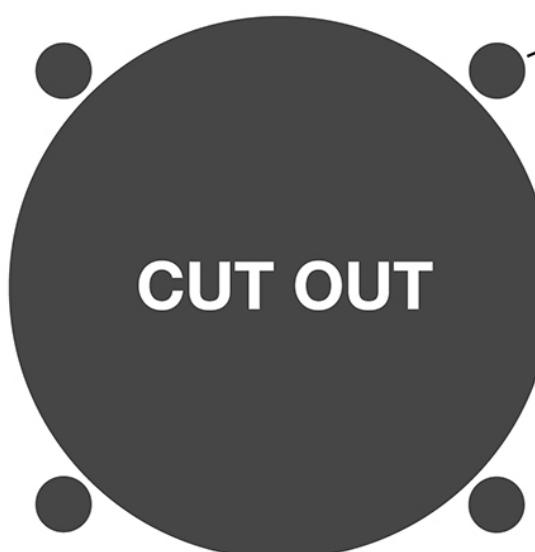
IMPORTANT:
Be sure template is
flush against transom

CUT OUT

SLIDE CUT OUT AROUND TIE DOWN
CLEAT WHILE FLUSH AGAINST HULL



215hp RXP Rear Exhaust Outlet Template



CUT OUT ALL 5 CIRCLES



CUT OUT TEMPLATE ALONG DOTTED LINE

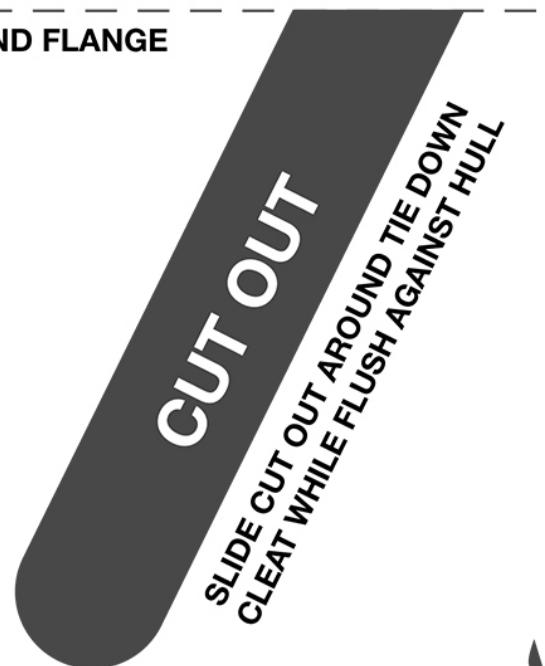
215hp RXT/GTX-SC Rear Exhaust Outlet Template

CUT OUT TEMPLATE ALONG DOTTED LINE

THIS EDGE AGAINST UNDERSIDE OF BOND FLANGE



IMPORTANT:
Be sure template is
flush against transom



215hp RXT/GTX-SC Rear Exhaust Outlet Template

EXHAUST OUTLET
LOCATION
2-7/8" max. dia.

BOLT HOLE
LOCATIONS
5/16" max. dia.

CUT OUT

CUT OUT ALL 5 CIRCLES



CUT OUT TEMPLATE ALONG DOTTED LINE