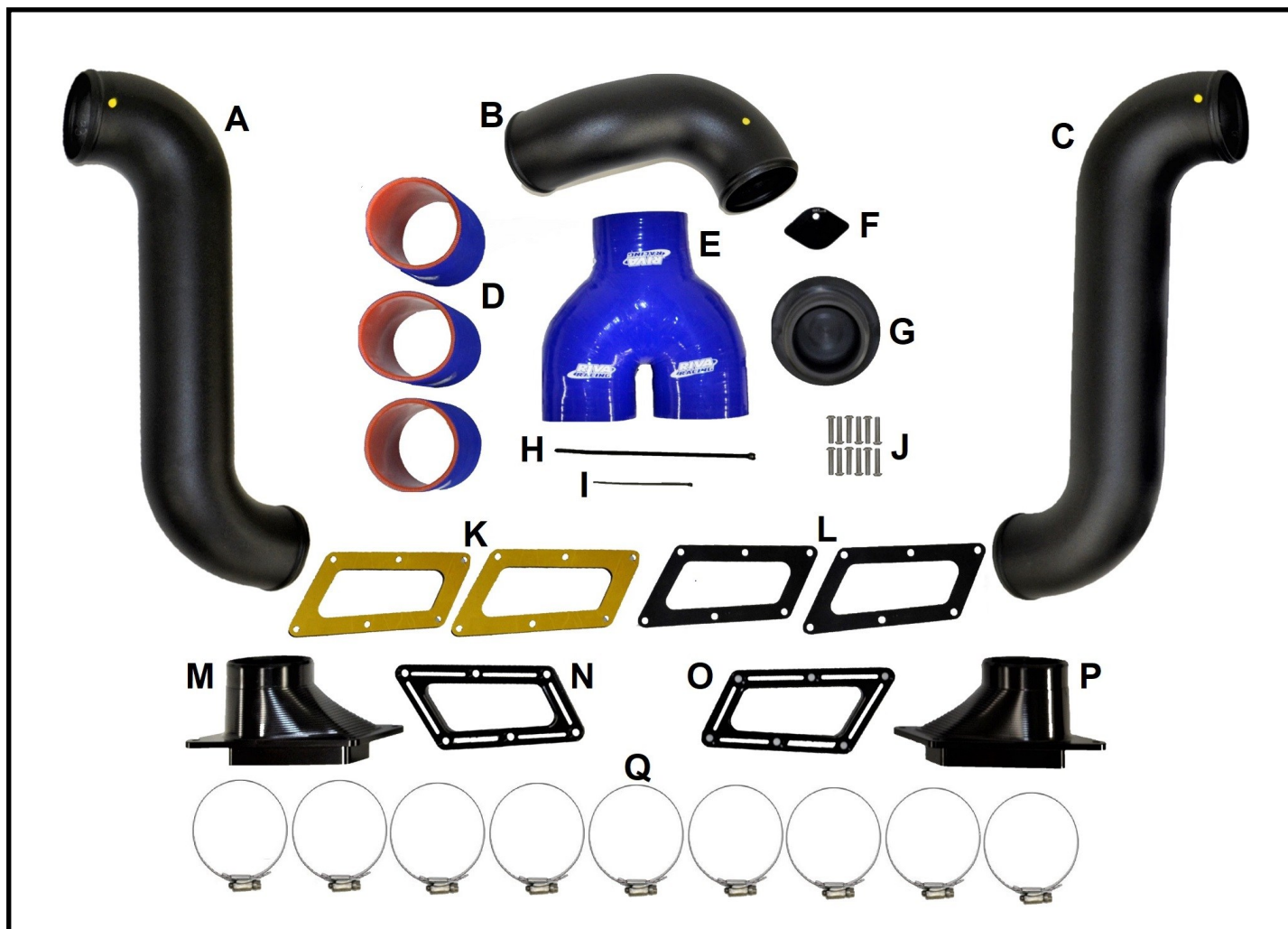




## RIVA Dual Rear Exhaust 2018+ RXT/GTX 300/230

RS15120-D



**Applications:** 2018+ RXT/GTX 300 and 230

**Approximate Installation Time:** 5 Hr.

**Recommended Specialty Tools:**

3/4" hole saw  
Roto Zip, Dremel, or small body saw  
Sanding drum or Surform tool  
Carpenter's Square

**Required Materials:**

blue Loctite  
Silicone Sealer (recommended "The Right Stuff")  
3/4" Formed Hose (required for 2023+ only)

**Part #**

N/A  
N/A  
N/A  
N/A

**Part #**

N/A  
N/A  
RS10123-SBD

**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>



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

## **RIVA Dual Rear Exhaust 2018+ RXT/GTX 300/230**

RS15120-D

### ***Notes and Precautions***

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.**

**Wear eye and breathing protection when working with fiberglass or chemicals.**

Hull Care Notice: The hulls of the craft described in these instructions are made with an acrylic and ABS outer skin. Failing to follow the recommendations below may result in damage to the acrylic/ABS surface.

BRP recommends the use of the following cleaning products with acrylic hulls and decks surface.

- 3M Marine Cleaner and Wax – Carnauba McGuilar Gold Wax – Dish soap – Fantastik Original All Purpose Cleaner
- Fabuloso All-Purpose Cleaner Liquid Solution – KLEEN-FLO Glass Kleen – Pre-Kleano 900 – WD-40
- XPS PRO C1 - Cleaner and Degreaser (Canada and USA only - not for retail)
- XPS PRO C2 - Cleaner Surface (Canada and USA only - not for retail)
- XPS PRO C4 - Cleaner Extra Foaming (Canada and USA only - not for retail)
- XPS All Purpose Cleaner and Degreaser (P/N 779313). – XPS Multi-Surface and Glass Cleaner (P/N 779316).
- XPS Wash and Wax (P/N 779310). – Spray Wax with Polymer (P/N 779320). – Vinyl and Plastic UV Protectant (P/N 779317). – Sea-Doo Hull Cleaner (P/N 779309).

**This kit is not intended for use on pollution controlled vehicles. Installation on pollution controlled vehicles may constitute a violation of state or local statutes.**



**RIVA Dual Rear Exhaust 2018+ RXT/GTX 300/230**

*RS15120-D*

**COMPONENT LIST**

Item	Description	Part Number	Qty.	Notes
A	Tube 33 Y Coupler to Left Outlet	W1-RS15120-DL	1	Yellow dot on top at Y coupler end
B	Tube 31 Waterbox to Y Coupler	W1-RS15120-DW	1	Yellow dot on top at Y coupler end
C	Tube 32 Y Coupler to Right Outlet	W1-RS15120-DR	1	Yellow dot on top at Y coupler end
D	Coupler 3 x 3	RS15-03/03	3	
E	Y Coupler	GT-RS15190-DC	1	
F	Flush Fitting Block Off		1	
G	Exhaust Outlet Block Off Plug	QCA-RS15140-PLUG	1	
H	Ziptie, Lg	TY25MX	1	
I	Ziptie, Small	TY23MX	1	
J	Bolt, 6MM X 25MM, BHCS	6C25SBCS	12	
K	Exhaust Outlet Gasket		2	3/16" Thick Self Adhesive
L	Outlet Cover Gasket		2	3/32" Thick No Adhesive
M	Left Exhaust Outlet		1	
N	Left Outlet Cover		1	
O	Right Outlet Cover		1	
P	Right Exhaust Outlet		1	
Q	Hose Clamp #48	63004-0048-052	9	

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).



## Remove Top Deck

Remove seats.

Remove access cap (A) and screws (13) at locations shown. **Note: Screws at location B go through the deck and are secured with nuts and washers underneath. Do not drop nuts and washers into hull. Retain hardware for re-use.** (Figure 1)

Remove engine compartment access cover.

**2023+ models proceed to Cooling System Modifications (2023+ Only) (page 5).**

**All other years proceed to Remove Intercooler (page 6).**

Figure 1





## Cooling System Modifications (2023+ Only)

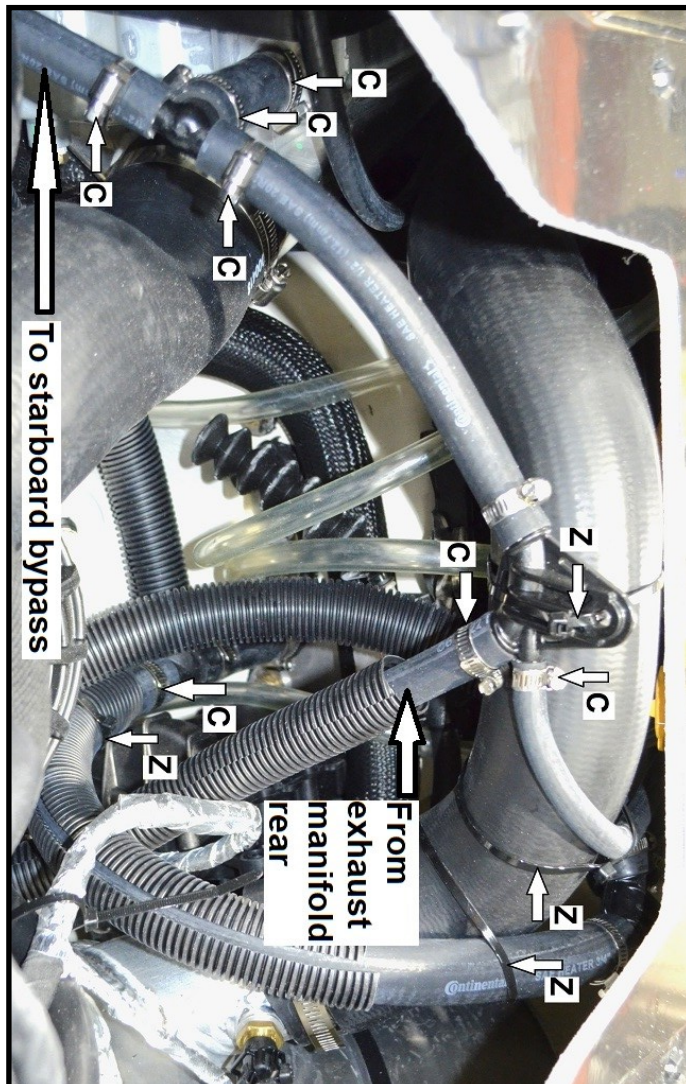
### 2023 and newer RXT and GTX models only!

#### For earlier models go to page 6, All Models Remove Intercooler

2023 and newer Sea-Doo PWCs with ST3 hull have a pair of siphon break fittings plumbed into the cooling system to prevent hard starting when the craft is left for extended periods with the stern nearly submerged and the engine not running. That system must be removed to install this RIVA exhaust. **NOTE: Reference 'Siphon Break Delete Kit' addendum on last page of these installation instructions.**

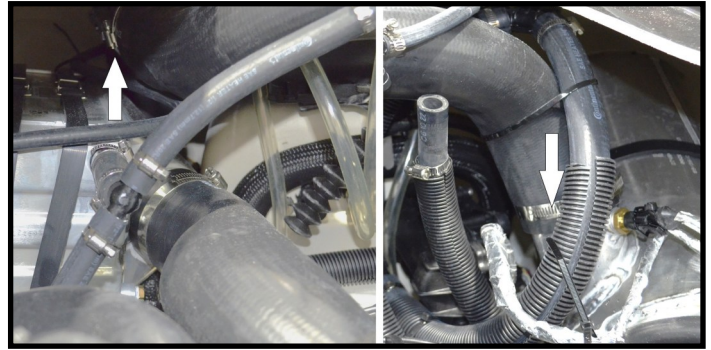
Cut zip ties (4) at locations marked Z. Loosen hose clamps (7) at locations marked C. Remove hoses from fittings at those locations. (Figure 2023 A) Save clamps for re-use. Save T fitting for re-use. Remove fitting with attached hose from craft,

Figure 2023 A



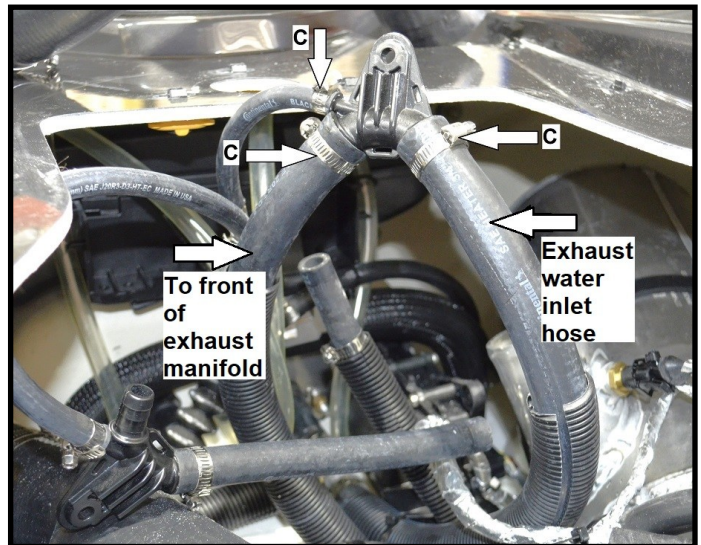
Loosen clamps (2) at both ends of OEM exhaust hose and remove exhaust hose from waterbox and resonator. (Figure 2023 B)

Figure 2023 B



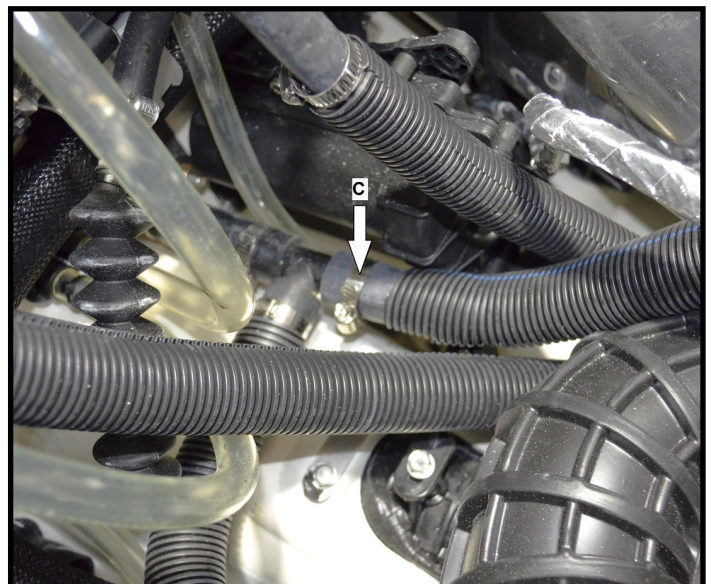
Loosen hose clamps (3) and remove fitting. Save clamps for re-use. (Figure 2023 C)

Figure 2023 C



Loosen hose clamp on exhaust water inlet hose at T fitting and remove hose. (Figure 2023 D) Save clamp for re-use.

Figure 2023 D





## Cooling System Modification (2023+ Only)

Cut 9-1/4" (20.7 cm) from the end of the 3/4" hose that runs from the underside front of the exhaust manifold to the cooling water inlet. (Hose on the left in figure 2023 C.) Cut enough from the hose sheath to allow installation of a hose clamp . (Figure 2023 E)

Figure 2023 E

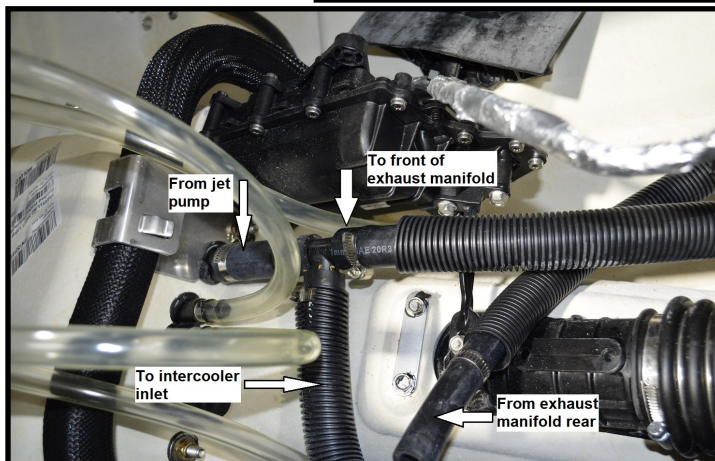
Install shortened hose onto T fitting at water inlet from jet pump.

Secure using OEM hose clamp previously removed and saved.

(Figure 2023 F) **Note: Do not tighten clamp.**



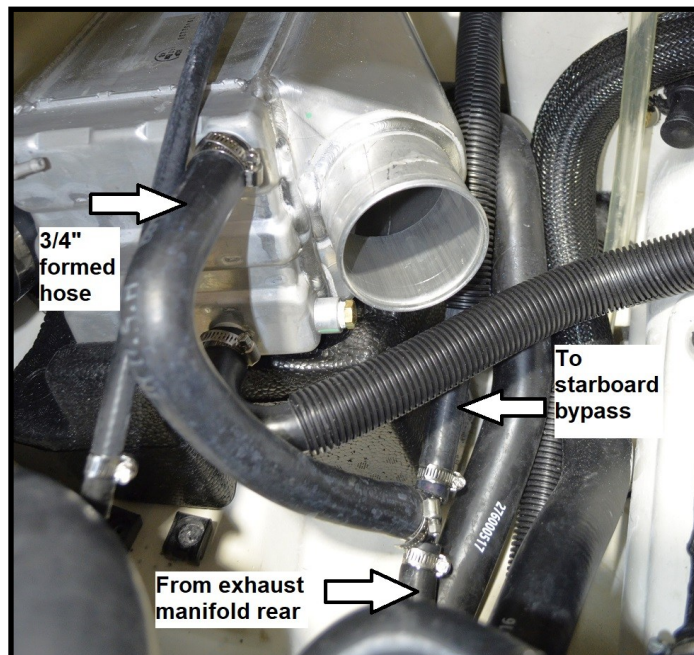
Figure 2023 F



Remove the 1/2" hose to the starboard water bypass from beneath the intercooler foam support. Cut 17-1/2" (44.5 cm) from the inner end of the 1/2" hose. Shorten hose protector to leave hose end accessible. Slip 1/2" hose clamp, previously removed, onto shortened hose and install T fitting previously removed from intercooler outlet. **Note: Do not tighten clamp.** Pass hose from rear of exhaust manifold through gap in hull below driveshaft. Slip 1/2" hose clamp, previously removed, onto hose and install onto T fitting. **Note: Do not tighten clamp.** Install short end of 3/4" formed hose (RIVA part number RS10123-SBD) onto intercooler outlet (upper fitting). **Note: Do not install clamp at this time.** Slip 3/4" hose clamp, previously removed, onto long end of 3/4" formed hose RS10123-SBD and install onto T fitting. **Note: Do not tighten clamp.** Adjust hoses on T fitting and intercooler to prevent kinking in hoses.

Tighten all clamps (3). **Note: Do not overtighten clamps.** (Figure 2023 G).

Figure 2023G



This completes the changes required specifically for 2023+ models with the siphon break installed in the cooling system.

**Proceed with the instructions for all models beginning with All Models Remove Inter-cooler (this page).**

### All Models Remove Intercooler

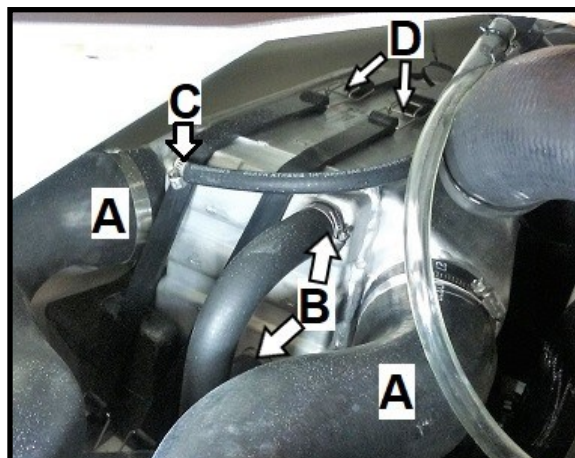
Loosen clamps at intercooler end of large hoses (2) from intercooler to engine. (A, Figure 2) Remove hoses from intercooler. Retain clamps for re-installation.

Loosen clamps on cooling water hoses (2) at intercooler. (B, Figure 2) Remove cooling water hoses from intercooler. Retain clamps for re-installation. **Note: Mark hoses upper and lower to ease re-installation.**

Loosen clamp on vent hose. (C, Figure 2) Remove vent hose from intercooler. Retain clamp for re-installation.

Disconnect intercooler straps (2). (D, Figure 2)

Figure 2



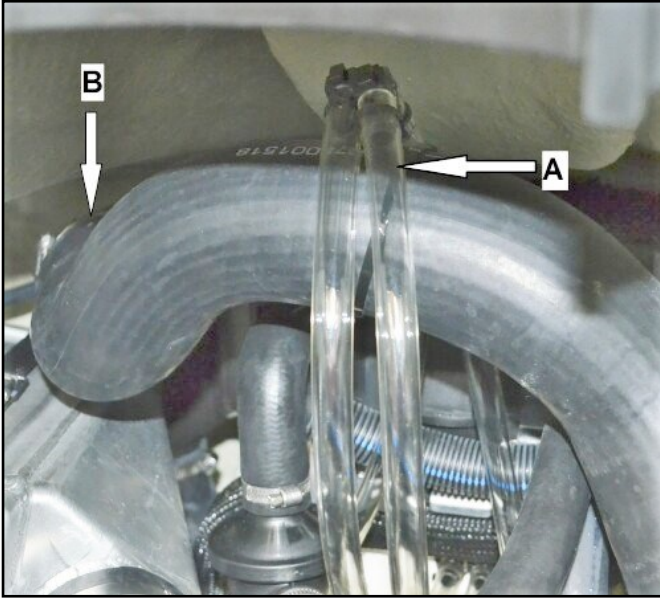


## Resonator Removal 2018-2019 Models

To remove the resonator you must remove the waterbox from the craft.

Cut zip tie (A) securing siphon bilge hoses to exhaust outlet hose. Loosen clamp on exhaust outlet hose at resonator inlet. (B). (Figure 3)

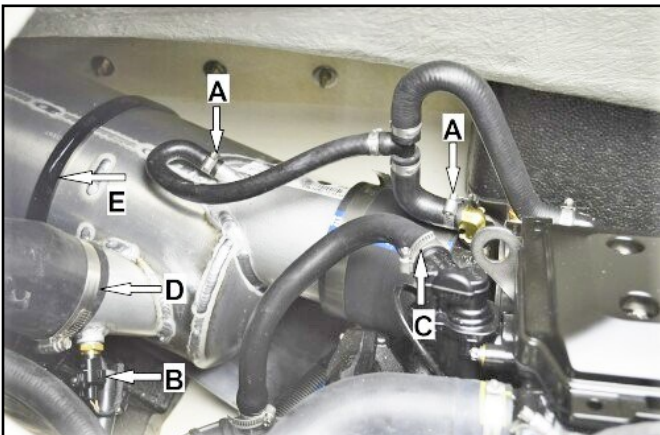
Figure 3



Loosen clamp on exhaust outlet hose at waterbox (D, Figure 4)

Remove exhaust outlet hose. Retain clamps for reuse during reassembly. Disconnect temp sensor (B). Disconnect waterlines between exhaust manifold and waterbox (A). Remove rubber strap around waterbox (E). (Figure 4)

Figure 4



At exhaust clamp loosen t-bolt nut enough to allow end ('T') to be removed from band clamp. Remove exhaust clamp. (Figure 5)

Figure 5

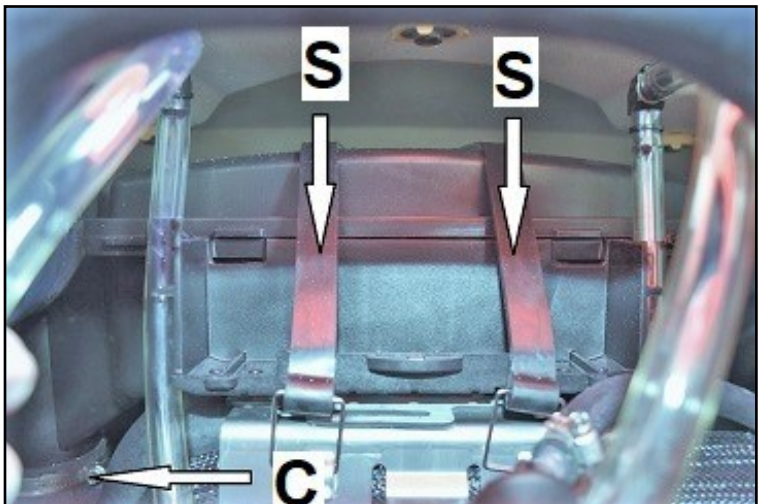


Remove waterbox assembly from hull.

Loosen clamp holding resonator to molded outlet hose (C) (Figure 6)

Disconnect resonator hold down straps (S). (Figure 6)

Figure 6



While twisting side to side, pull resonator up and out of molded outlet hose. Remove resonator from craft and discard. Retain hose clamp for use during reassembly.

Remove straps from craft and discard.

**Proceed to Exhaust Block Off installation (page 9).**

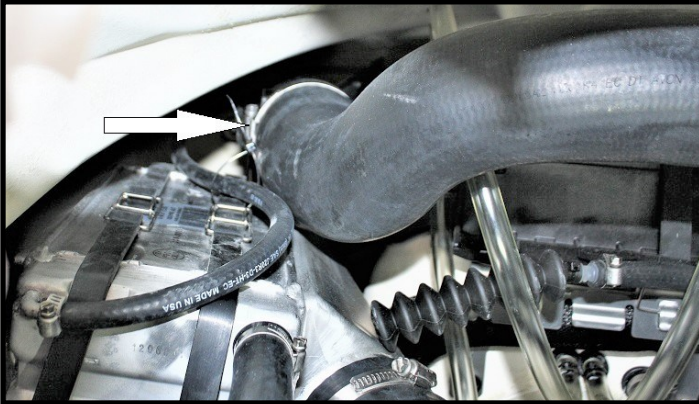


## **Resonator Removal 2020+ Models**

To remove the resonator you must remove the waterbox from the craft.

Loosen clamp on exhaust outlet hose at resonator inlet. (Figure 7)

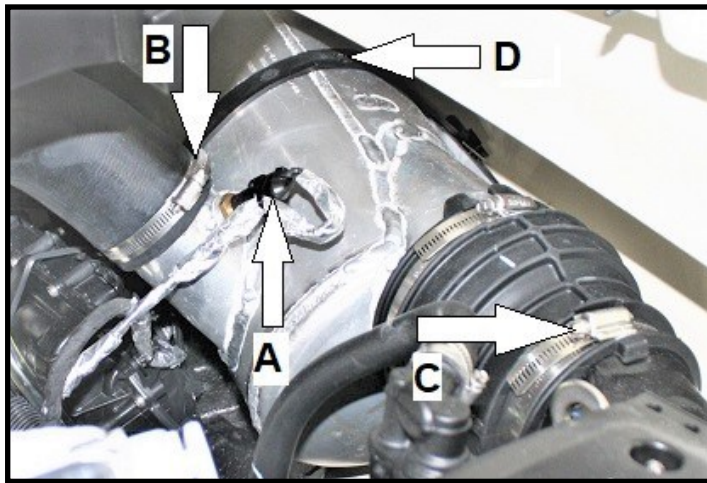
Figure 7



Disconnect exhaust temperature sensor (A). Loosen clamp (B). Remove exhaust outlet hose from waterbox and resonator. Retain clamps. (Figure 8)

Loosen clamp (C), at exhaust manifold outlet. Remove hold down strap (D). (Figure 8)

Figure 8

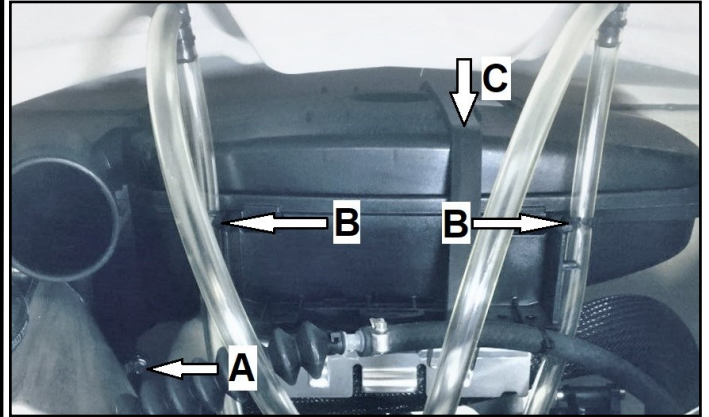


Remove waterbox assembly from hull.

Retain clamp for re-installation.

Loosen clamp holding resonator to molded outlet hose (A). Cut (2) zip ties (B) securing siphon bilge hoses to resonator. Remove rubber resonator strap (C). (Figure 9)

Figure 9



While twisting side to side, pull resonator up and out of molded outlet hose. Remove resonator from craft and discard. Retain hose clamp for use during reassembly.

**Proceed to Exhaust Block Off installation (page 9).**

## Exhaust Block Off Installation

It is necessary to remove the VTS trim ring to access the OEM exhaust outlet.

To remove the VTS trim ring use the iBR override function to move the iBR gate so you can access the bolts. **Warning! Keep hands and feet clear of the gate while moving. Serious injury could result from failure to take proper precautions.**

Put lanyard on DESS post and press start button to turn on multifunction gauge. (**Do not start craft.**)

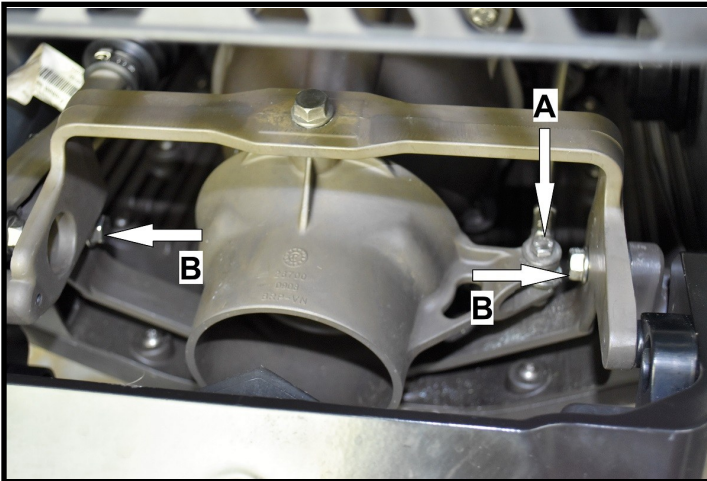
Pull in on the iBR lever. (There will be a beep.)

Press the SET button on the multifunction gauge.

Press the VTS "Down" button to move the iBR gate until you can access and remove the bolts.

Remove steering cable bolt (A). Remove (2) bolts (B) holding VTS trim ring. (Figure 10)

Figure 10



Remove VTS trim ring.

With a strap wrench or oil filter pliers grasp the nut on the exhaust through hull fitting and unscrew it. Set aside the nut for reuse later. (Figure 11)

Figure 11



Remove the through hull fitting from the craft by pulling from the inside of the hull. Retain the gasket for reuse. Remove the clamp holding the 90 degree elbow fitting to the OEM through hull fitting. Keep the clamp for later reuse. Discard the OEM through hull and elbow fittings.

Insert supplied through hull plug through hole. The head of the plug will be inside the hull. The OEM nut and gasket will be on the outside. Note that the plug has alignment tabs that must be aligned with corresponding notches in the hole. (Figure 12)

Figure 12



Place OEM sealing washer gasket onto through hull plug and thread OEM through hull nut onto the supplied through hull plug. Use strap wrench or oil filter pliers to tighten. **Note: Do not overtighten.**

Reassemble VTS trim ring and steering cable, reversing disassembly. **Apply blue Loctite to threads.**

**Proceed to Exhaust Outlets Relocation (page 10).**



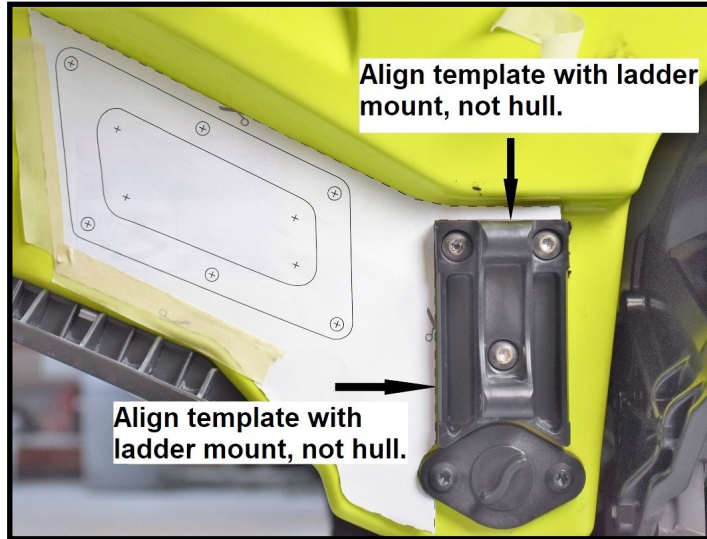
## Exhaust Outlets Relocation

Cut out supplied paper template marked RS15120 Left (Port) according to the instructions on the template. (Page 21) **Note: Cut around outside of template only.**

Do not cut out the hole for the exhaust outlet. If you print the template on your own printer make sure that the printed template is the correct size. (See the printer reference instructions on the template.)

Tape the template to the left (port) transom. (Figure 13)

Figure 13



With a small diameter drill bit mark the centers of the six bolt holes and the 4 corner radii. With a 17/64" bit drill holes through the hull at the six bolt locations marked on the template. **Be careful when drilling holes to not drill into iBR bellows which is just inside hull.** Remove template from hull.

Place cover plate on hull and insert supplied M6 x 25 bolts through cover plate and hull. Mark around inside opening of cover plate with a sharp pointed marker. (Figure 14)

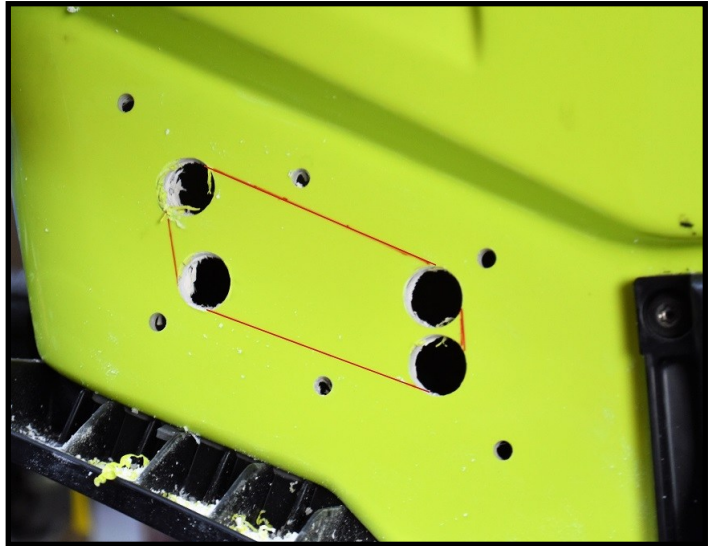
Figure 14



Remove cover plate. Using a 3/4" holesaw cut through hull at corner radii (4) previously marked with small drill bit.

(Figure 15)

Figure 15

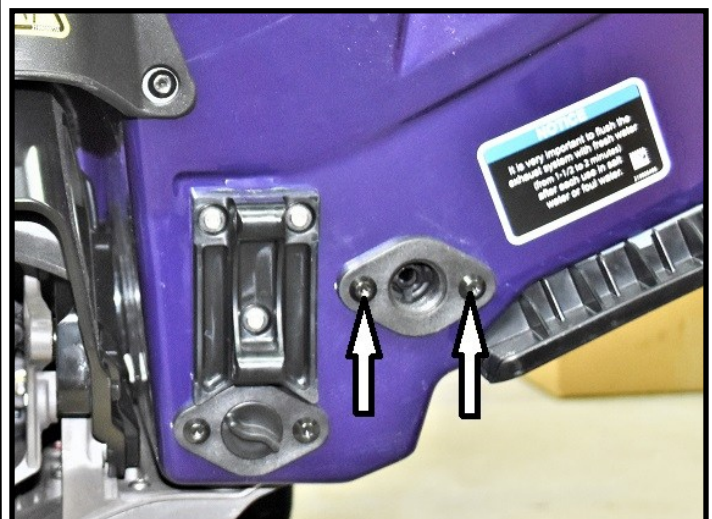


Cut between holes with a body saw, roto zip or other tool. **Note: Stay inside lines. Be careful not to cut iBR bellows inside hull.** Switch to coarse sanding drum, file or surform tool to cut to final shape and size. Insert exhaust outlet from inside of hull to verify opening size and alignment with bolt holes.

On right side (starboard) transom remove screws (2) retaining flush fitting. Retain screws for re-installation.

(Figure 16)

Figure 16



Pull flush fitting out of hull and loosen clamp connecting hose to fitting. (Figure 17, next page)



## Exhaust Outlets Relocation

Figure 17



Remove flush fitting from hose and retain for reinstallation. Push hose into hull.

Using 1/4" drill bit, enlarge existing flush fitting screw holes (2). (Figure 18).

Figure 18



Insert supplied Flush Fitting Block Off into hole from outside. **Note: Use caution to avoid bending thin metal of block off. This is a temporary installation do not put any sealer onto the block off at this time. Important: Arrow points to right (starboard) side of craft.** (Figure 19)

Figure 19



Cut out Starboard Exhaust outlet template

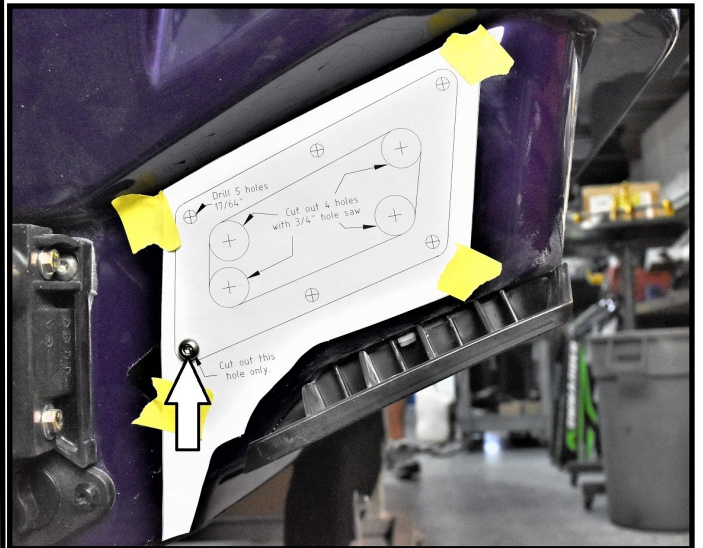
Cut out supplied paper template marked RS15120 Right (Starboard) according to the instructions on the template. (Page 21) **Note: Cut around outside of template only.**

Cut out the small hole marked “Cut out this hole only”.

Do not cut out the hole for the exhaust outlet. If you print the template on your own printer make sure that the printed template is the correct size. (See the printer reference instructions on the template.)

Insert one of the supplied M6x25 BHCS bolts through the small hole cut out of the template and thread it into the hole in the flush fitting block off. Align the top of the template with the ridge in the transom and tape in place. (Figure 20)

Figure 20



Repeat marking, drilling and cutting procedure for right (starboard) side outlet opening. (Refer to page 8.)

Remove Flush Fitting Block Off from hole and retain.

Cut out RS15120-D Flush Fitting Template (Page 23). Cut out hole marked “Cut Out This Hole Only in Template”.

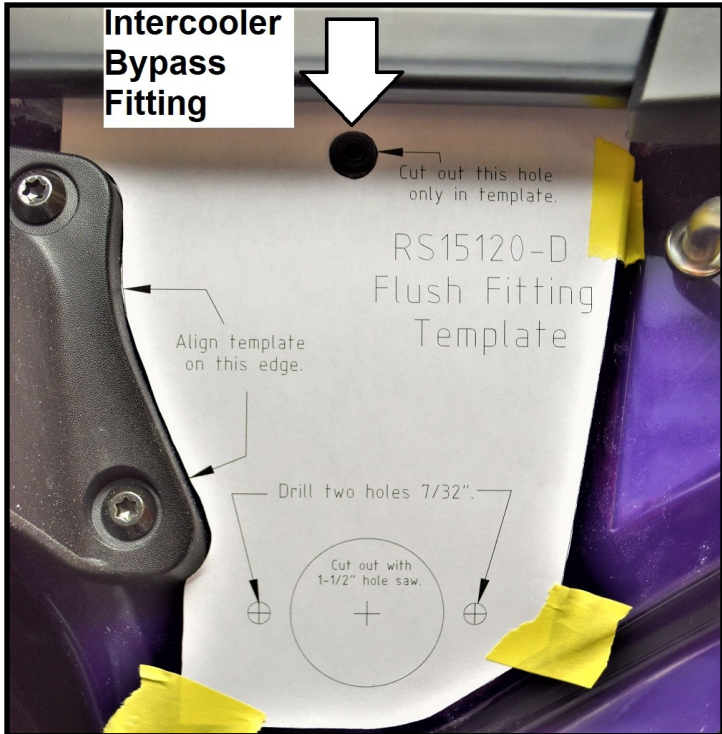
**Proceed to Flush Fitting Relocation (page 10).**



## Flush Fitting Relocation

Tape the template onto the right (starboard) transom of the craft with the small hole cut out of the template over the intercooler bypass fitting. Align the left side of the template with the iBR guard. (Figure 21)

Figure 21



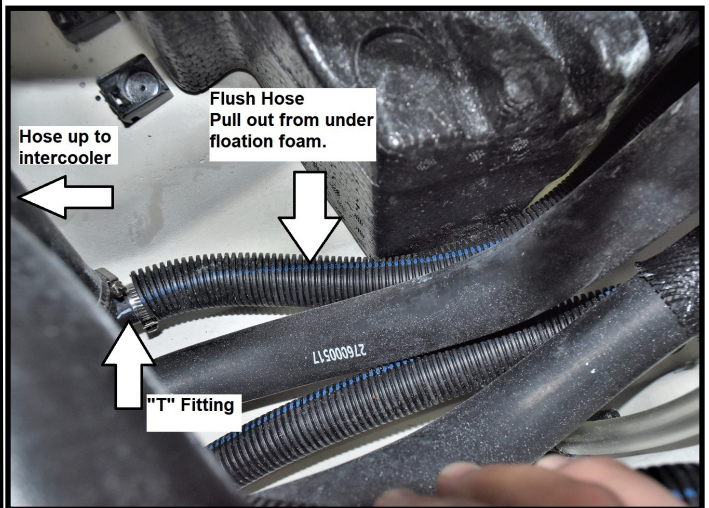
With a small diameter drill bit mark the centers of the two bolt holes and the center of the flush fitting hole. (Flush fitting hole marked "Cut out with 1-1/2" hole saw".) With a 7/32" bit, drill holes through the hull at the two bolt locations marked on the template. Remove template from hull. Cut out hole for flush fitting using a 1-1/2" hole saw. (Figure 22 )

Figure 22



Inside hull locate hose previously attached to flush fitting. (Figure 23) Pull hose out from under flotation foam.

Figure 23



Clean hull inside with air/ vacuum. Clean hull outside with BRP approved cleaner. (Refer to Hull Care Notice, page 2)

**Proceed to Exhaust Installation (page 13).**

## Exhaust Installation

**Note:** Tubes are numbered on the inside and marked with a spot of paint on the outside. When assembled the paint spots will be facing up and at the Y coupler end of each tube. (Figure 24)

Figure 24



The tubes are:

31 Waterbox to Y coupler.

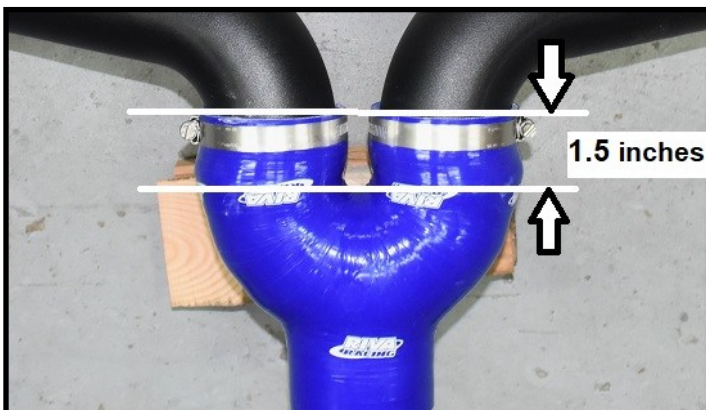
32 Y coupler to right (starboard) outlet.

33 Y coupler to left (port) outlet.

Insert ends of supplied tubes 32 and 33 with paint spots into Y coupler until they reach the curve in the coupler, approximately 1.5 inches. (Figure 25) **Note: Use foaming glass cleaner to lubricate coupler and tubes to ease installation.**

**Important: If paint marks are not visible after assembly mark tubes to indicate which side is up.**

Figure 25



Snug supplied clamps (2) over coupler/outlet joint in position shown. (Figure 25) Do not fully tighten clamp. Tubes should be able to rotate in coupler with some effort.

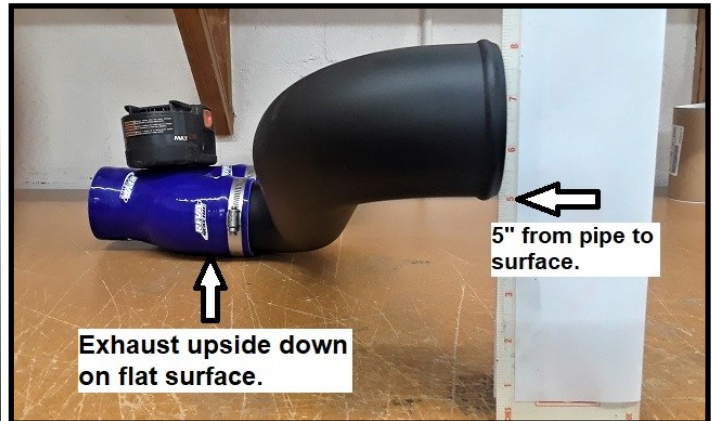
Place coupler / tubes assembly upside down on a flat surface. Paint marks should be down toward flat surface.

Place a weight on the coupler or have an assistant hold it down flat on the surface. Coupler should sit on surface flat and level without distortion.

Using a carpenter's square or ruler to measure, adjust the ends of the two pipes so the bottom of the opening in each is 5 inches above the surface. (Figure 26)

Tighten the clamps securely. **Note: Do not overtighten clamps.**

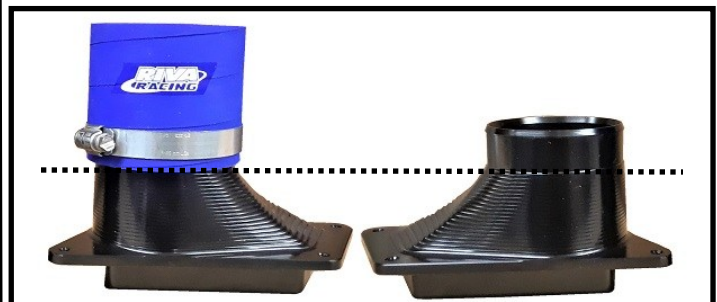
Figure 26



Install supplied couplers completely onto smooth section of outlets to point where outlets expand. (Figure 27) **Note: Use foaming glass cleaner to lubricate coupler and outlet to ease installation.**

Snug supplied clamps (2) over coupler/outlet joint in position shown. (Figure 27) Tighten clamp securely. **Notes: Do not overtighten clamps. Outlets are mirror images. Position clamps accordingly.**

Figure 27



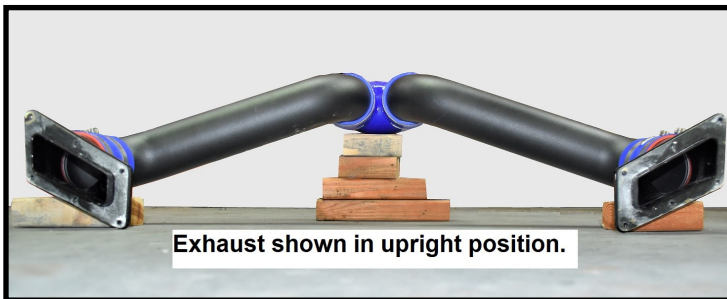
Install outlet/coupler assemblies and supplied clamps (2), onto tubes. Insert ends of tubes without paint spots into couplers until they touch the outlets. (Figure 28, next page) Snug clamps but do not tighten completely. Outlet/coupler assemblies should be able to rotate. **Notes: Location of clamp adjustment screws is important. Try to duplicate figure 30, next page. Use foaming glass cleaner to lubricate coupler and fitting to ease installation.**



## Exhaust Installation

**Be sure you have the outlets on the correct sides.  
Pipes are at outside ends of outlets.**

Figure 28

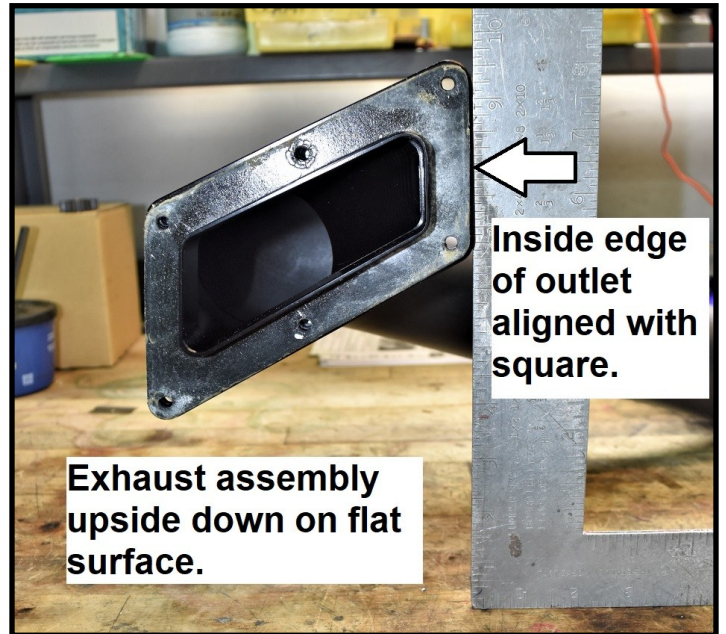


Place assembled exhaust upside down on flat surface as previously described. (Figure 26, page 11)

Using a carpenter's square or similar, rotate outlets until inside edges of outlets are perpendicular to the flat surface. (Figure 29)

Snug clamps onto outlet/pipe couplers but do not tighten. Tubes should be able to rotate with some effort in couplers.

Figure 29



Assembled exhaust should match these figures. Note angles of assembly of outlets and tubes. Note position of tightening screws on clamps. A little time spent here to make sure that parts are in proper alignment will make installation easier. (Figures 30-31)

Figure 30

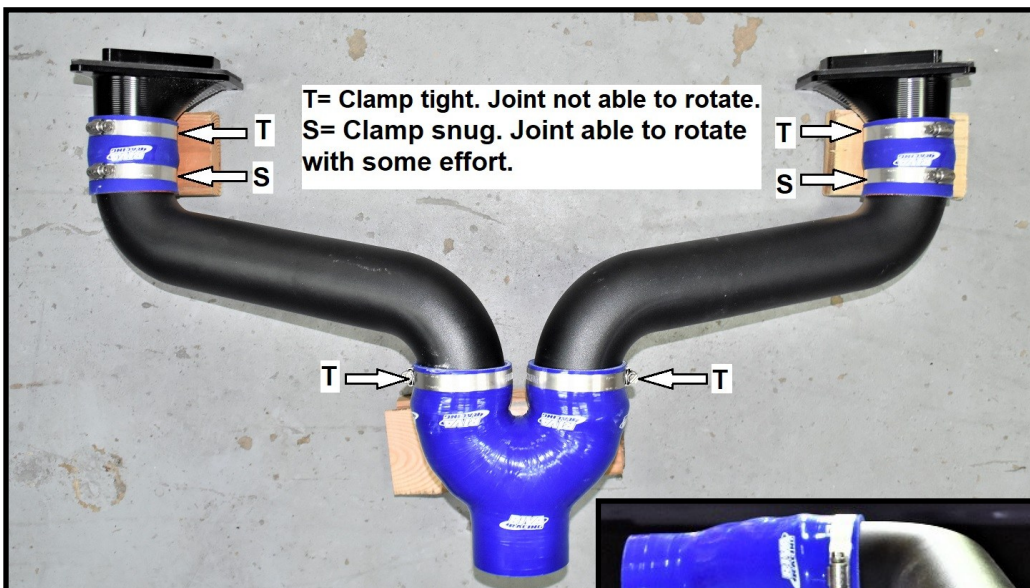
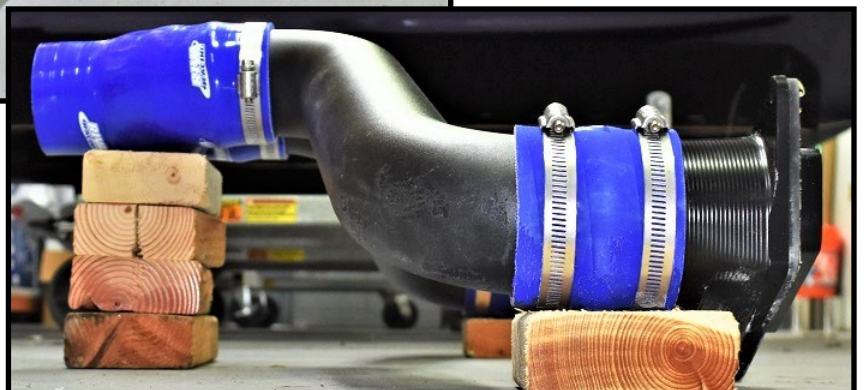


Figure 31





## Exhaust Installation

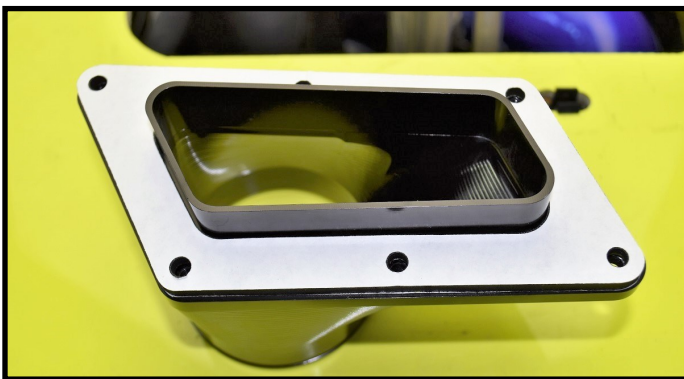
Two thick and two thin gaskets are supplied with this kit. Both are the same shape. The thick self-adhesive gasket goes on the exhaust outlet on the inside of the hull. The thin gasket without adhesive goes on the cover plate on the outside of the hull. (Figure 32)

Figure 32



Remove protective cover from one side of supplied thicker self-adhesive gasket and install one onto each outlet as shown. (Figure 33)

Figure 33



Remove remaining protective cover from gasket. **Note: Do not apply sealer to gasket.**

Insert exhaust assembly into hull beginning with left (port) outlet end. Rotate Y coupler downward and insert assembly into rear left of craft until right (starboard) outlet will enter deck opening. (Figures 34 - 36)

Figure 34



Figure 35



Figure 36



Rotate exhaust assembly inside hull until both outlets are in rear portion of hull and Y coupler is above pump tunnel.



## Exhaust Installation

Rest exhaust assembly on pump tunnel .

**Hint: If installing RIVA Power Filter Kit perform exhaust temp sensor relocation before re-installing waterbox.**

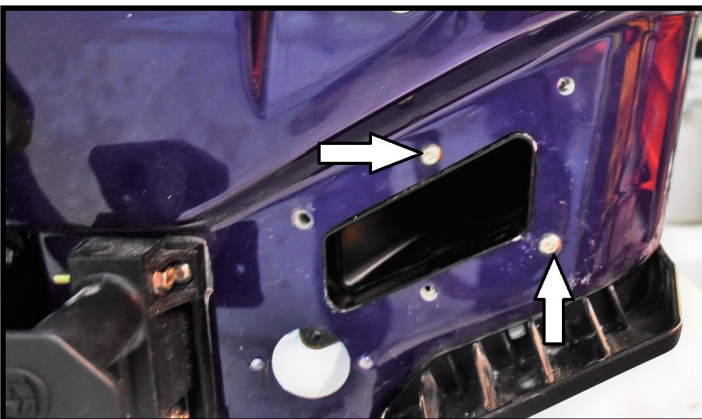
Insert waterbox into hull. Install waterbox over exhaust outlet pipe. Rotate waterbox out of position until rear end of waterbox is located near side of hull. (Figure 37) Temporarily tighten clamp to hold waterbox in position shown. **Note: Do not over tighten clamp. Do not install hold down strap.**

Figure 37



Have an assistant reach through the right (starboard) exhaust outlet hole in the transom and guide the outlet into the hole while lifting and guiding the exhaust assembly inside hull. **Note: If necessary, assistant may rotate coupler on exhaust assembly to align with opening in transom.** Temporarily install two M6 x 25 BHCS to hold outlet in position. (Figure 38)

Figure 38



Working with assistant, repeat procedure with left (port) exhaust outlet.

Loosen clamp and rotate waterbox into approximate final installed position.

Install remaining supplied coupler onto end of tube 31

without paint spot. Coupler should slide over tube approximately 1.5 inches. Secure coupler to tube with supplied clamp. (Figure 39) **Notes: Use foaming glass cleaner to lubricate coupler and tube to ease installation. Do not over tighten clamp.**

Figure 39



Loosen two remaining supplied clamps to maximum size. Slip one clamp over waterbox outlet and the other onto tube 31.

Insert end of tube 31 with paint spot into Y coupler. Tube should enter about 1.5 inches into coupler. **Note: Use foaming glass cleaner to lubricate coupler and tube to ease installation.**

Rotate tube 31 and waterbox until aligned and install coupler onto waterbox outlet. When properly installed tube and waterbox should be nearly touching inside coupler.

Align waterbox in proper installed position but do not install hold down strap yet. (Refer to waterbox final installation, page 16 for alignment.)

Position clamps previously slipped over tube 31 and waterbox outlet over couplers and tighten only enough to hold clamps in position. (Figure 40)

Figure 40



Adjust exhaust assembly as needed so that Y coupler is parallel to underside of deck, not touching deck or pump tunnel.



## Exhaust Installation

Check to assure that clamps are properly positioned over couplers and tighten clamps previously only snugged on couplers over tubes 32 and 33 at exhaust outlets. (Clamps designated S in Figure 30, page 12.) (Technique shown in Figure 41.) **Notes: Do not overtighten clamps. An electric ratchet is helpful here to extend reach but not absolutely necessary.**

Figure 41



Put a liberal coating of silicone sealer on the back surface of supplied flush fitting block off. (Figure 42)

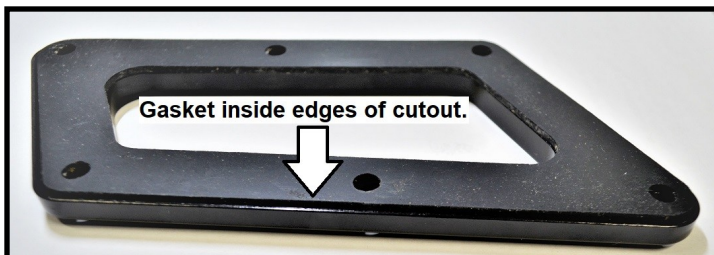
Figure 42



Press flush fitting block off into hole. **Note: Use caution and press evenly to avoid bending thin metal of block off. Important: Arrow points to right (starboard) side of craft.** (Figure 19, page 9)

Install one supplied thin gasket (see figure 32, page 13) into cutout area on back of each supplied outlet cover. (Figure 43) **Note: Do not apply sealer to gaskets or covers.**

Figure 43



Remove screws previously installed to retain one exhaust outlet in hull and install supplied cover and gasket. Secure with supplied M6 X 25 BHCS (6). (Figure 44) **Notes: Apply blue Loctite to screw threads. Do not overtighten screws. Do not apply sealer to gasket or hull surface.**

Figure 44



Repeat procedure with opposite side outlet cover.

Pull flush hose through relocated opening in transom and attach to OEM flush fitting using OEM hose clamp. **Note: Do not overtighten clamp.**

Secure fitting in new location using OEM screws, previously removed. (Figure 45) **Notes: Do not overtighten screws. Do not apply sealer to fitting.**

Figure 45



**Proceed to Waterbox and Intercooler Reinstallation (page 18).**

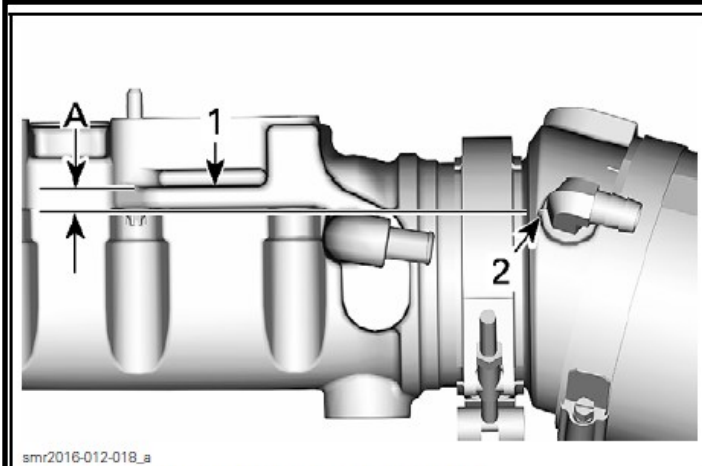
## Waterbox and Intercooler Reinstallation

**2018-2019 models only.**

Align exhaust pipe with exhaust manifold. **Note measurements in instruction illustration. Alignment is critical to prevent exhaust leaks.** (Figure 46) Tighten T clamp. **Note: Do not overtighten clamp.**

Reinstall waterlines previously removed. (Figure 4, page 7)

Figure 46

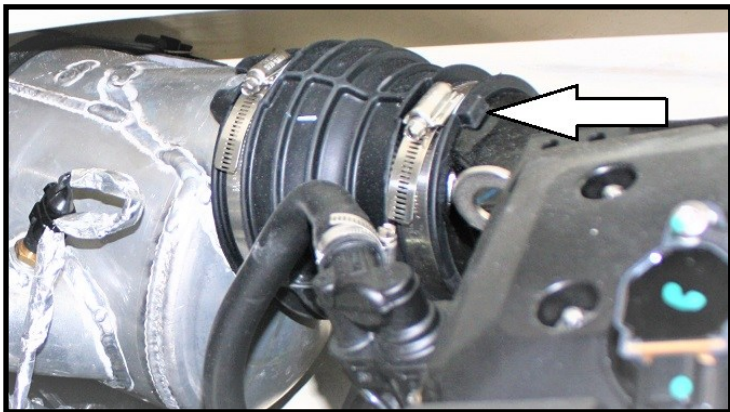


1. Exhaust manifold rib wall facing the engine
2. Exhaust pipe mark
- A. 10 mm (13/32 in)

### **2020+ Models Only**

Alignment tab on coupler must fit between bosses on exhaust manifold. (Figure 47) Tighten clamp. **Note: Do not overtighten clamp.**

Figure 47

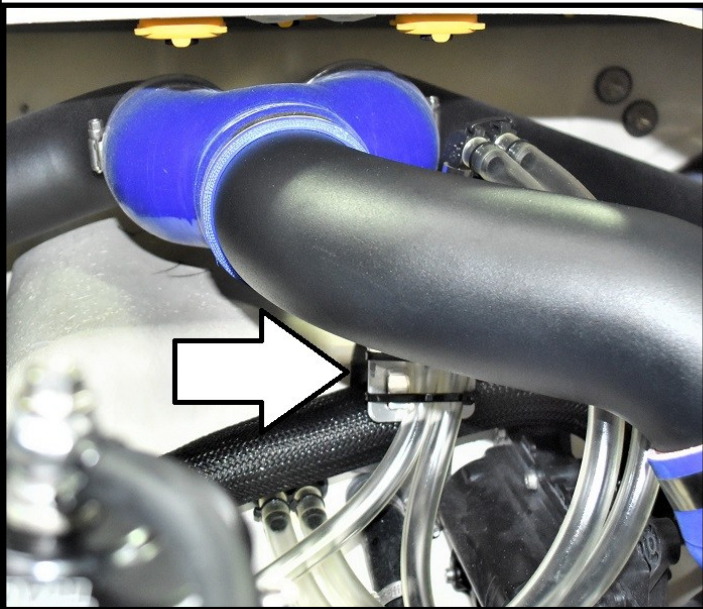


**All models:** Install waterbox hold down strap.

Reconnect exhaust temperature sensor. ( 2018-2019, B in Figure 5, Page 7. 2020+, A in figure 8, Page 8.)

**All models:** Using supplied zip ties secure siphon bilge hoses to resonator bracket in upright position as shown. (Figure 48)

Figure 48



Reinstall intercooler reversing removal procedure. (Refer to Remove Intercooler, page 6.)

Check bilge for rags, etc.

Run craft on flush hose to check for proper operation.

Reinstall top deck and seats reversing removal procedure.

(Refer to Remove Top Deck, page 4.)



## **Warranty**

***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 Rear Exit Exhaust kits carry a 6 month 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.

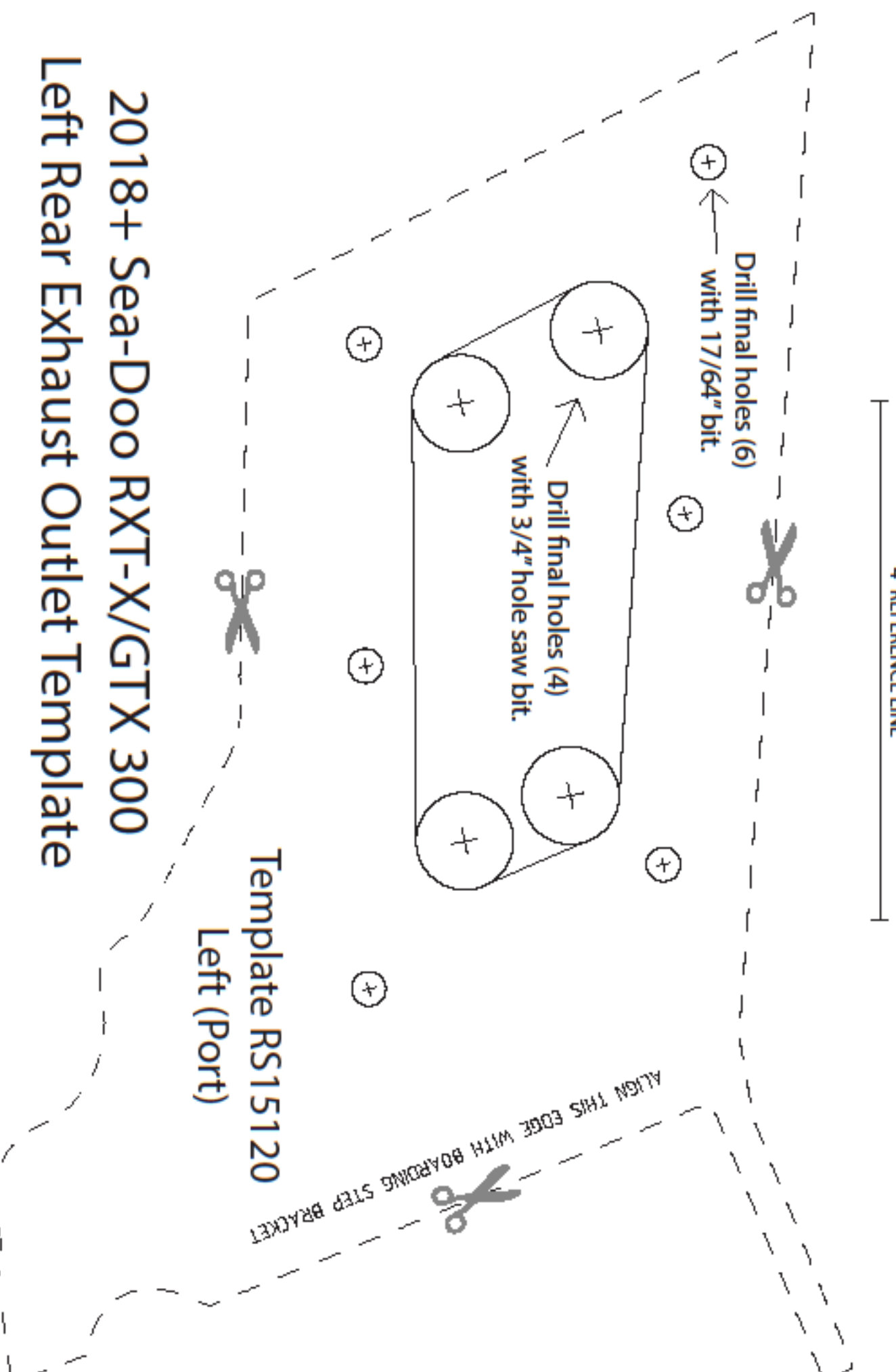
Warranty does not include the expenses related to freight or transportation of parts or compensation for any inconvenience or loss of use while being repaired. A copy of the original invoice and a Return Authorization Number (RA#) must accompany all warranty claims.

Warranted replacement parts will be returned freight collect





4" REFERENCE LINE

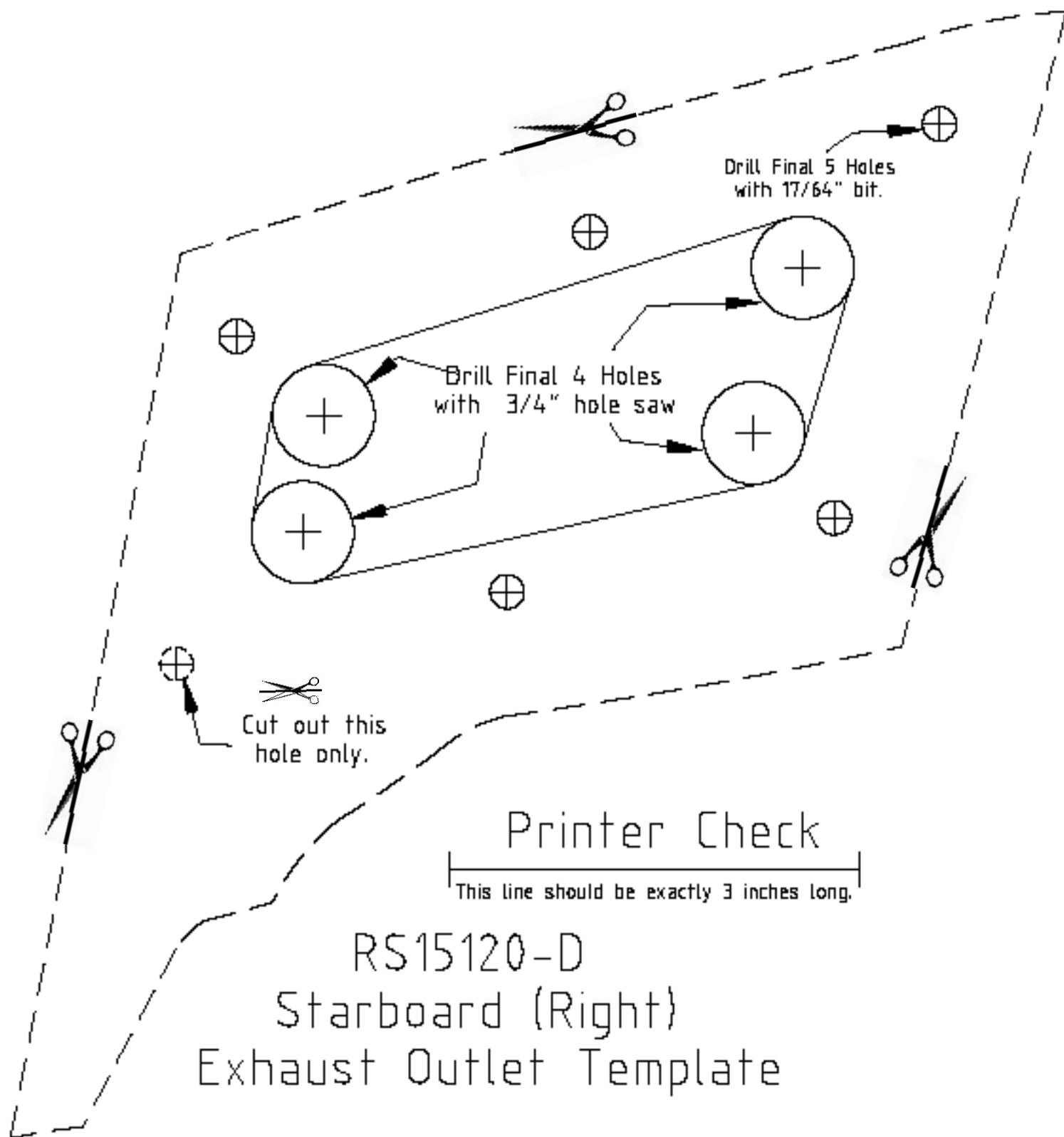


2018+ Sea-Doo RXT-X/GTX 300  
Left Rear Exhaust Outlet Template

**DO NOT USE FOR GTR/GTI**

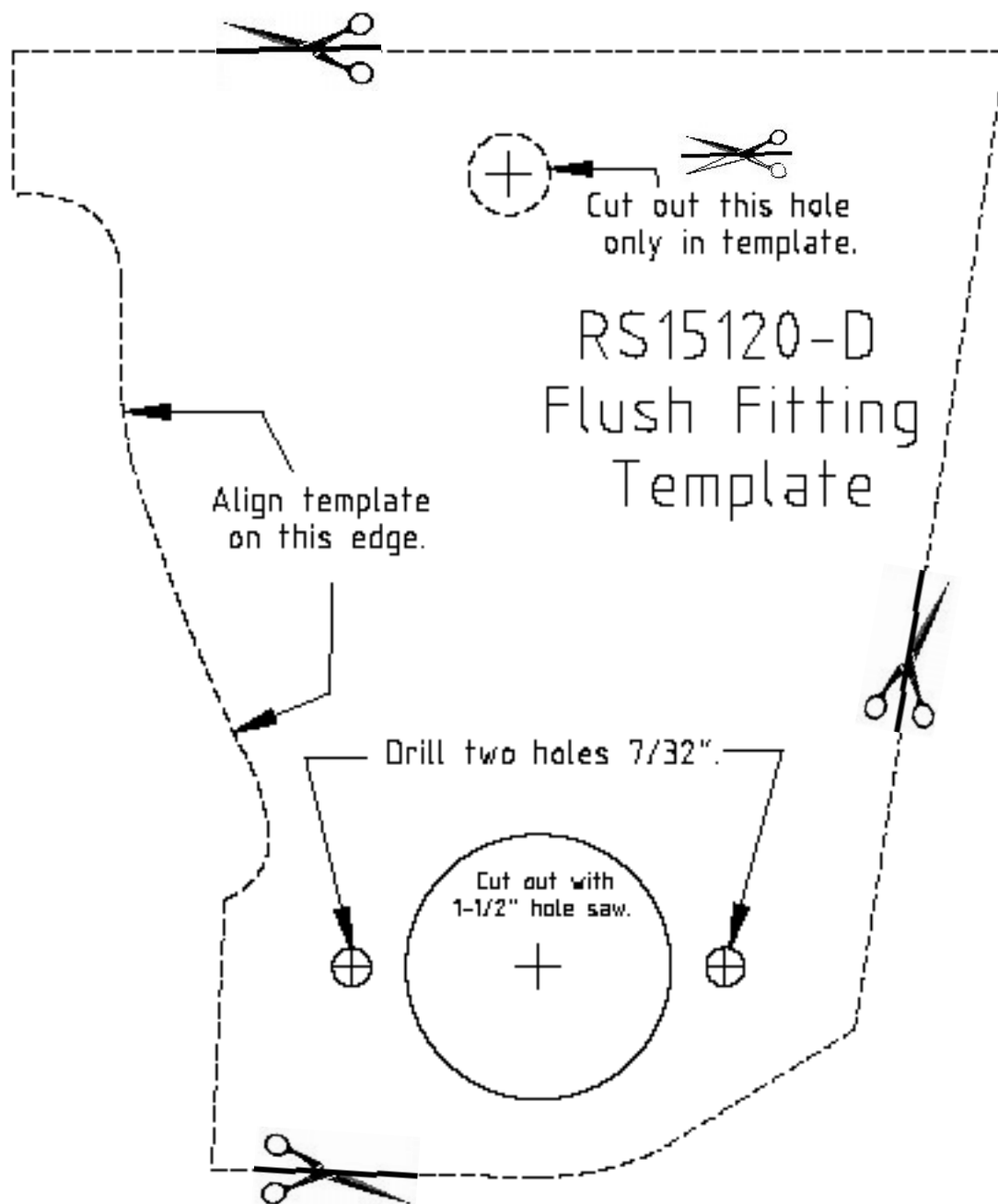




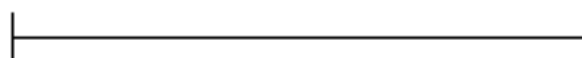








PRINT TEST



This line should be exactly 3 inches long.



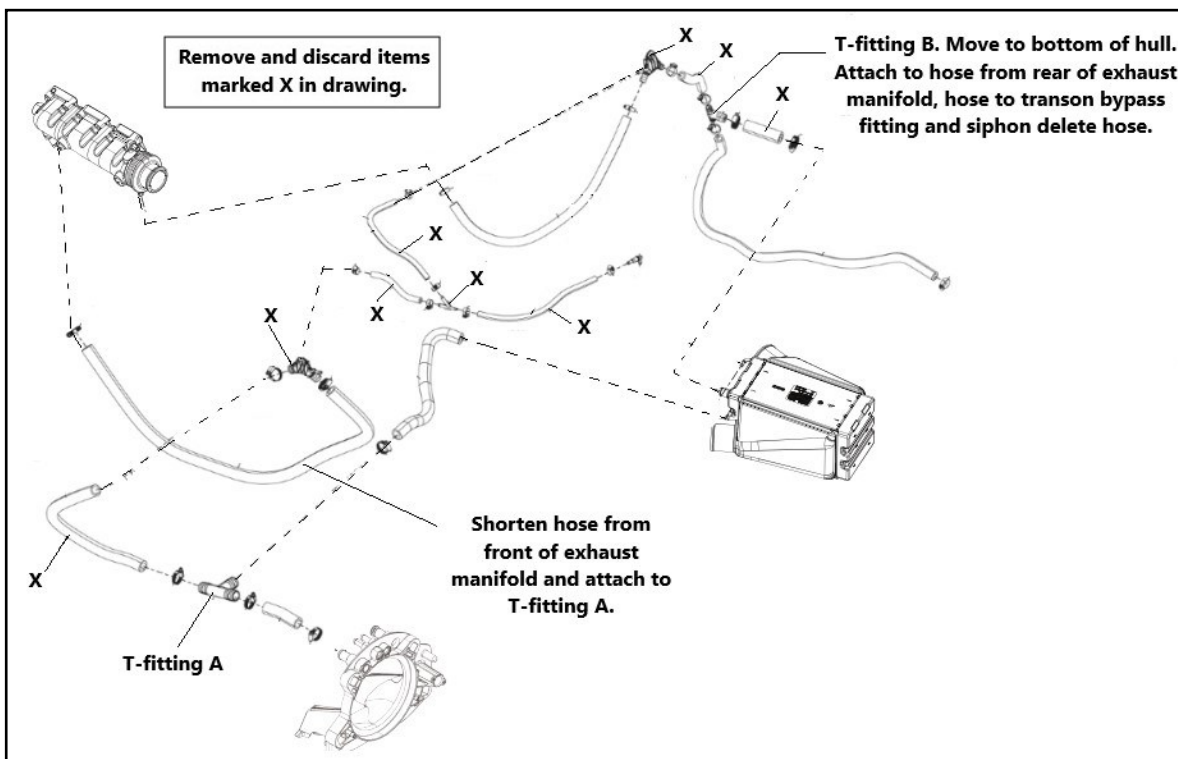




**ADDENDUM**

*Siphon Break Delete Kit RS10123-SBD*

**OEM Cooling System**



**Modified Cooling System - Siphon Break Delete Kit Installed**

