



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

## SEA-DOO 230 Rear Exit Exhaust

PART# - RS15160



**Applications:** Sea-Doo 230 models GTR, GTR-X, Wake Pro 2017-2019

**Approximate Installation Time:** 4.5 Hr.

**Recommended Specialty Tools:**

**Part #**

N/A

**Required Materials:**

**Part #**

Blue Loctite

N/A

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.

**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.

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

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



## Parts List

<b>Rear Exhaust, SD GTR 230</b>			
<b>Part # RS15160</b>			
	<u>Description</u>	<u>RIVA Part #</u>	<u>Qty. Req.</u>
A	Exhaust Tube	W1-RS15160-T	1
B	Mount Ring		1
C	Gasket		1
D	Exhaust Outlet	QCA-RS15100	1
E	Silicone Coupler, (2-3/4" x 3-1/4")	RS15-2.75/3.25	2
F	PVC Plug 3"	QCA-RS15140-PLUG	1
G	1/4-20 x 1-1/2" BHCS	702160SS	4
H	ZIP TIE 11", SS TAB	TY26MX	1

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@rivamotorsports.com](mailto:tech_support@rivamotorsports.com)

## **- INSTALLATION INSTRUCTIONS -**

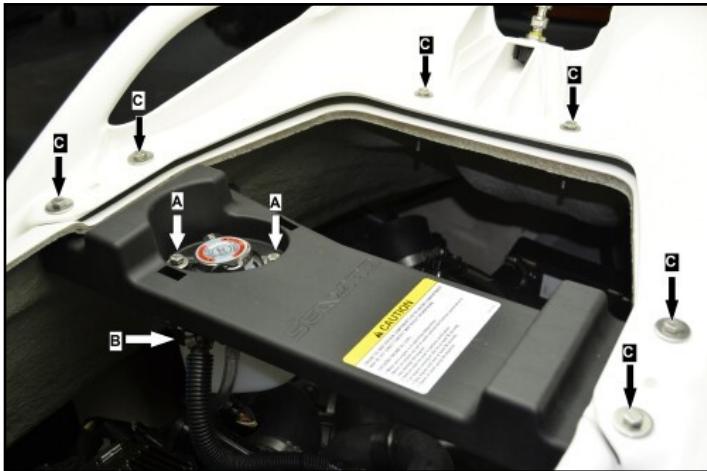
Remove or open seat.

### **Wake Pro 230:**

Remove two bolts holding coolant reservoir to deck beam (A). Pull out on retaining tabs (B) and lower the coolant reservoir away from its mounting location. Lay the reservoir to the starboard side to provide better access to the exhaust.

Remove 4 deck beam bolts and 2 grab rail bolts (C), nuts and washers. Caution: Do not drop nuts and washers into hull. Remove deck beam and grab rail assembly. (Figure 1)

Figure 1



### **GTR/ GTR-X 230:**

Remove the two bolts on each side holding the side panels in place and remove the side panels. (Figure 2)

Figure 2



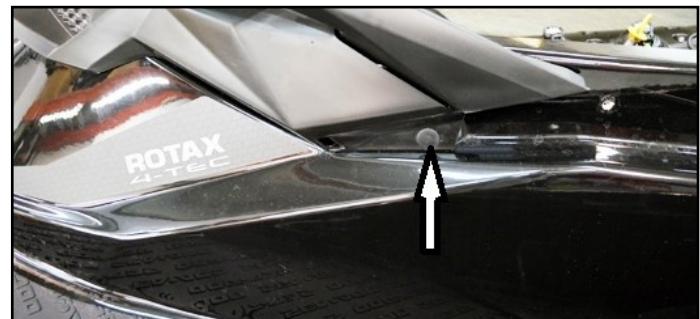
Remove 2 screws (A) and 2 plastic rivets (B) holding vent cover to rear grab handle and remove vent cover (Figure 3).

Figure 3



Remove 2 plastic rivets under side panels removed previously (Figure 4)

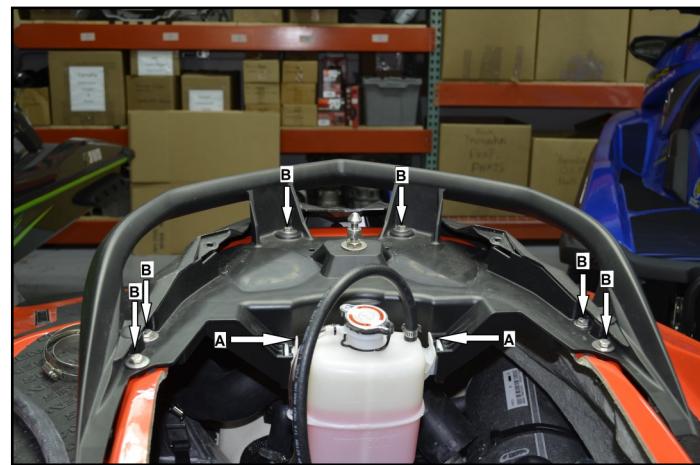
Figure 4



Press the (2) locking tabs (A) on the coolant reservoir towards the reservoir body and lift the reservoir out of its mounting location. Lay the reservoir to the starboard side to provide better access to the exhaust.

Remove (6) bolts (B), nuts and washers holding rear grab rail in place and remove grab rail. Caution: Do not drop nuts and washers into hull. (Figure 5)

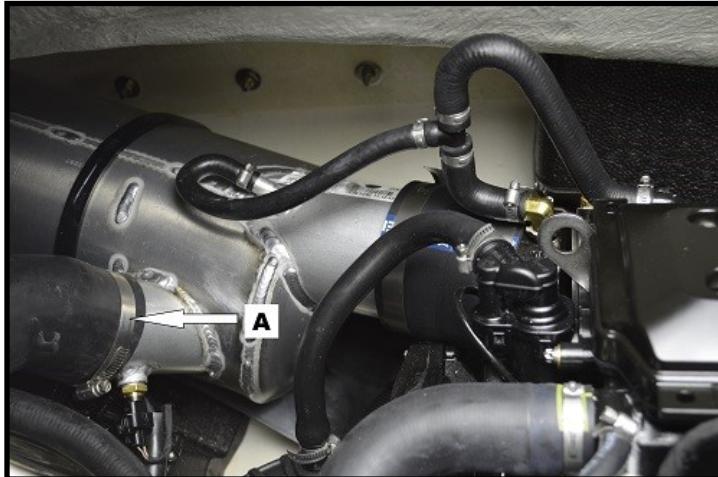
Figure 5



## - INSTALLATION INSTRUCTIONS -

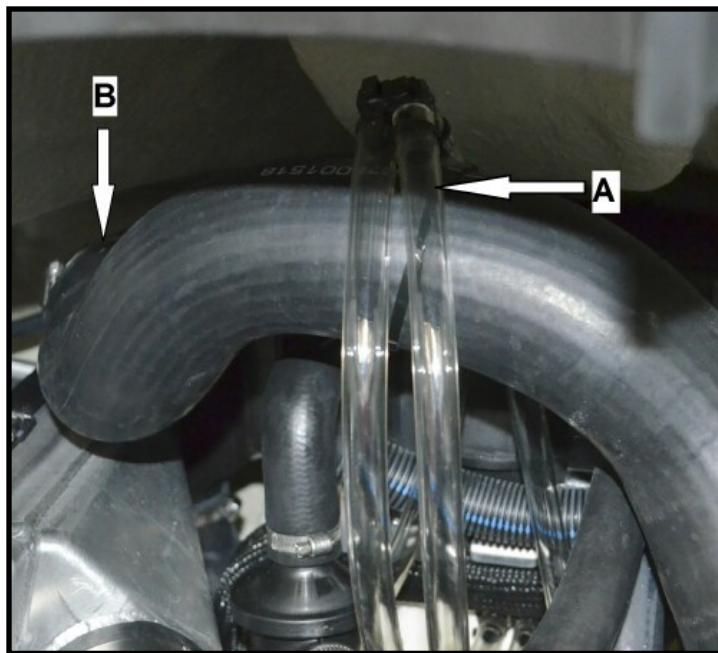
Loosen clamp and remove exhaust outlet hose from water box (A). Retain clamp for later re-use. (Figure 6)

Figure 6



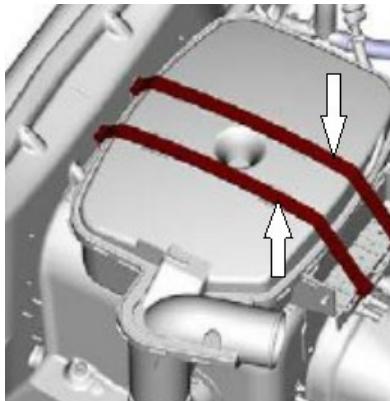
Cut the zip tie (A) securing the two clear siphon bilge hoses to the OEM Front Exhaust Hose. (Figure 7)

Figure 7



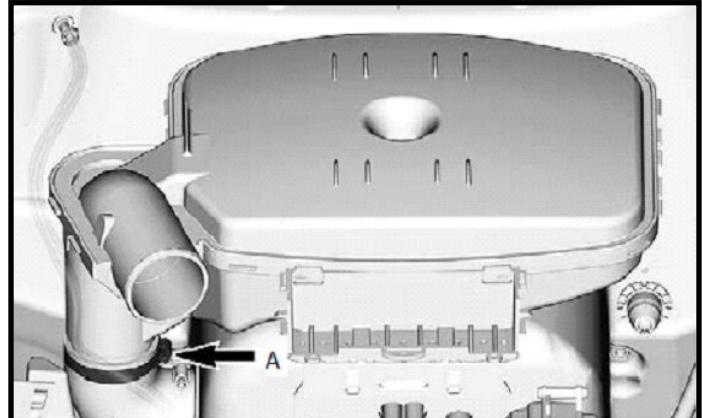
Loosen the clamp (B in figure 7) holding the OEM Front Exhaust Hose to the resonator. Remove and discard the Front Exhaust Hose. Keep the clamp for later reuse.

Remove two rubber straps holding resonator in place.



Loosen the clamp (A) holding the resonator outlet to the through hull fitting. (Figure 8)

Figure 8



Pull the resonator upward while twisting it back and forth to remove it from the outlet hose. Remove the resonator from the hull and discard as it will not be used again. Remove hose clamp and retain for later reuse.

Remove the six screws (A) holding the guard covering the iBR gate to the hull. Remove the guard. Set aside the guard and screws for reinstallation later. (Figure 9)

Figure 9



Remove the nut and bolt (B) holding the steering cable to the steering nozzle. Set aside for reinstallation later. (Figure 9)

Use iBR override function to align the openings in the iBR gate with the screws holding the iBR Support Bracket:

**Note: Remove any foreign object that may obstruct iBR actuator movement.**

**Warning! Keep hands and feet clear of the gate while moving. Serious injury could result from failure to take proper precautions.**

## - INSTALLATION INSTRUCTIONS -

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

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

Press the SET button on the multifunction gauge.

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

Remove the bolt connecting the linkage arm to the iBR gate. Set aside for reinstallation later. (Figure 11)

Figure 11



Remove the 4 bolts (A) and 2 nuts (B) holding the iBR support bracket to the jet pump. Remove the iBR gate and support bracket assembly from the ski. Set the assembly and hardware aside for reinstallation later. (Figures 12 and 13)

Figure 12

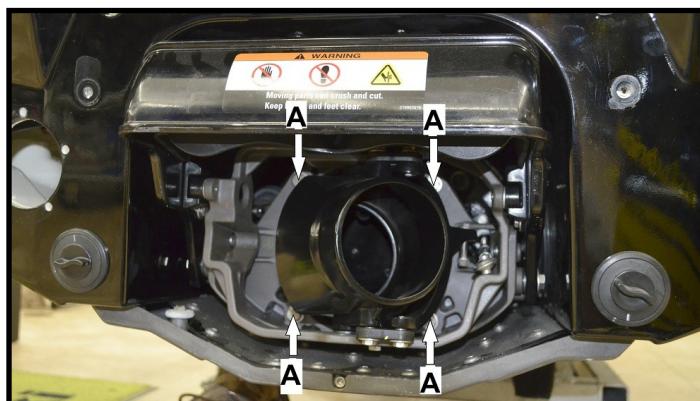
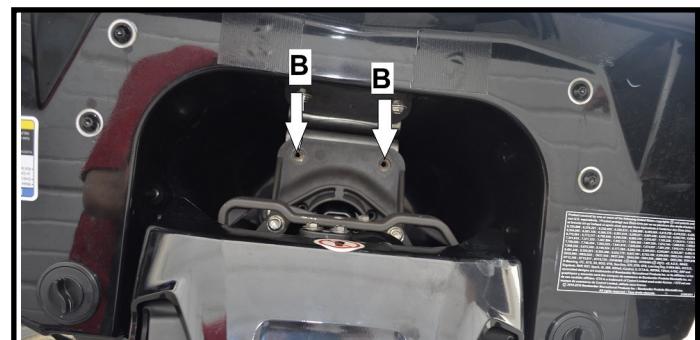


Figure 13



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 14) (Jet Pump removed for clarity.)

Figure 14



Remove the through hull fitting from the ski 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 into 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 notches in the hole. (Figure 15)

Figure 15



Reassemble iBR gate, support bracket, steering and reverse guard in reverse order of disassembly.

Place 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.

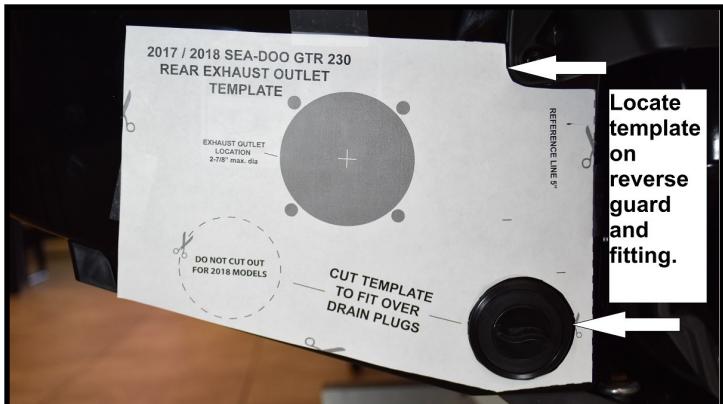
**Note: Do not overtighten.**

Cut out supplied paper template according to the instructions on the template. 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 side of the transom aligning the reference hole(s) over the hull fittings. **Note:** Some models have two fittings and some have one on the left side of the transom. (Figure 16)

## - INSTALLATION INSTRUCTIONS -

Figure 16



The outlet hole can be made using a hole saw bit, or with a Dremmel®, Roto Zip® or die grinder tool. **Note: Do not make the hole larger than 2-7/8" in diameter. Wear safety glasses.**

Clean the outside of the hull and the exhaust outlet tip with a non residual cleaner. Peel the paper backing from one side of the supplied exhaust outlet gasket. Slide it over the supplied exhaust outlet and press it into place against the flange taking care to assure that the bolt holes in the gasket and flange are properly aligned.

Peel the paper from the other side of the gasket and insert the exhaust outlet into the hole previously created. Align the RIVA logo at the bottom of the opening and press the tube into place.

Using a 1/4" bit, drill the securing bolt holes using the flange as a guide. Insert bolts into drilled holes to help locate the flange while drilling the remaining holes. **Note: Take your time. Use a sharp bit and minimal pressure to minimize breakout of the fiberglass. Wear safety glasses.**

Supplied mount ring has one flat side and one side with three raised stand-offs. Assemble on the outlet tube so the flat side of the ring is touching the inside of the hull. (Figure 17)

Figure 17



Clean fiberglass shavings and residue from inside of hull. Slide mount ring over exhaust outlet from inside of hull. Secure exhaust outlet using supplied button head bolts. **Note: Apply blue Loctite to threads of bolts. Do not overtighten bolts. Note: Inside of hull is not flat. Loosely install all bolts and tighten evenly so outlet sits flat against outside of hull.**

**TIP: To install ring slip it onto a piece of welding rod or similar stiff wire with a bent tip. Insert the wire through one of the top holes of the ring. Then jiggle the wire**

until the ring slides into place on the outlet. Push wire through bolt hole and pull to seat ring against hull. Loosely install a couple of bolts to hold the ring and remove the wire. (Figures 18 and 19)

Figure 18



Figure 19



Install supplied silicone couplers onto both ends of supplied exhaust tube. Install 3 hose clamps previously removed onto couplers. Tighten 2 hose clamps onto couplers over exhaust tube. Leave third clamp loose. **Note: Do not overtighten clamps. Tip: Lubricate inside of couplers and outside of tube with foaming glass cleaner to ease installation. (Figure 20)**

Figure 20



Insert outlet end of exhaust tube assembly onto outlet. Tighten clamp. **Note: Do not overtighten clamps. Tip: Lubricate inside of coupler and outside of outlet with foaming glass cleaner to ease installation. Use a power ratchet to extend your reach to the clamp.**

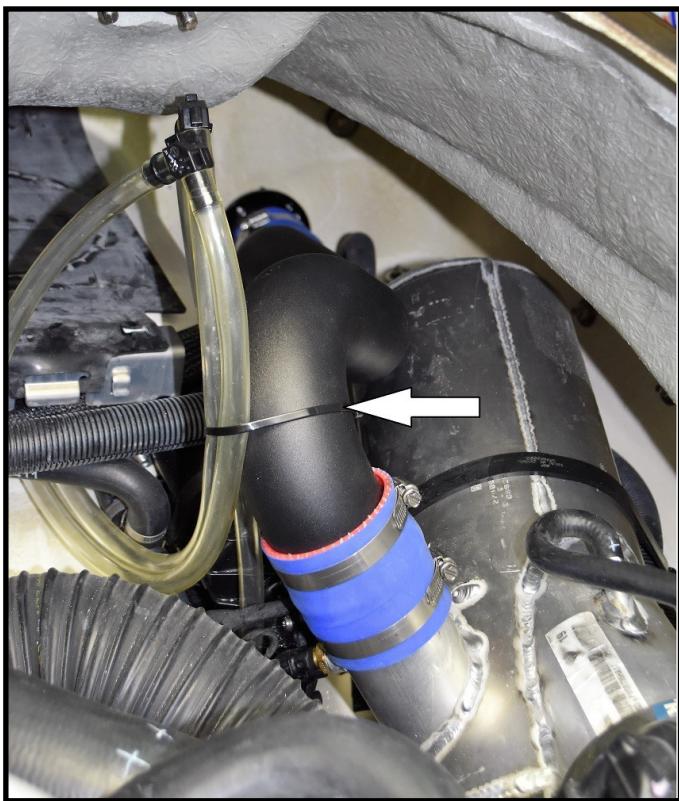
## **- INSTALLATION INSTRUCTIONS -**

**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.

Slip remaining clamp previously removed loosely onto waterbox outlet. Install waterbox end of exhaust tube onto waterbox outlet. Place clamp and tighten. **Note: Do not over-tighten clamp.** **Tip: Lubricate inside of coupler and outside of tube with foaming glass cleaner to ease installation.** (Figure 21)

Using supplied zip tie secure siphon bilge hoses in upright position. **Note: Do not crush siphon bilge hoses.** (Figure 21)

Figure 21



Replace parts applicable to your craft that were removed to access exhaust. **NOTE: Apply blue Loc-tite to bolts. Do not over tighten bolts.**

Check bilge for tools, rags, etc. Start craft and run using flush kit to check for exhaust leaks at connecting points of exhaust system. Do not run craft out of water for more than two minutes at a time.

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

### **Limited Warranty**

RIVA Rear Exhausts 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.

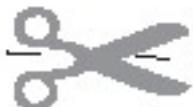
No other warranty, express or implied, including, but not limited to the implied warranties of merchantability and fitness for a particular purpose, applies. Various states do not allow for the limitation of incidental or consequential damages and therefore the above exclusion or limitation may not apply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

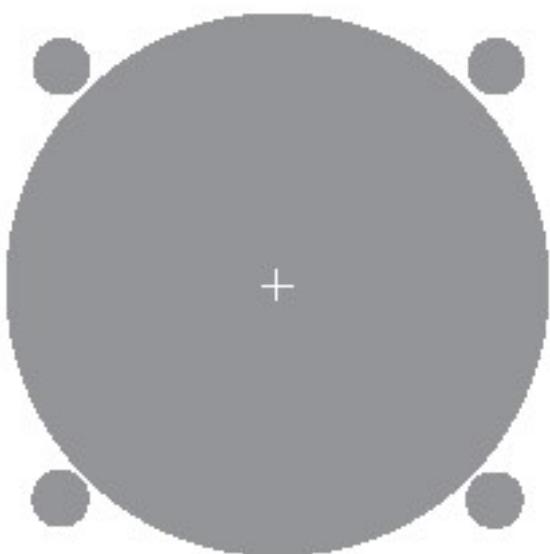
Warranted replacement parts will be returned freight collect.



**2017 / 2018 SEA-DOO GTR 230  
REAR EXHAUST OUTLET  
TEMPLATE**



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



REFERENCE LINE 4"



**DO NOT CUT OUT  
FOR 2018 MODELS**



**CUT OUT  
TO FIT OVER  
DRAIN PLUG**

