



RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Sea-Doo 4-TEC Cam Gear Bolt Kit

RS19050-CGB



Applications:

All Sea-Doo 4-TEC Engines

Approximate Installation Time:

1 hour

Recommended Specialty Tools:

Properly Calibrated Torque Wrench

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>

Required Materials:

Loctite 243

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.

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

 **Do not use electric or air operated impact tools.** 

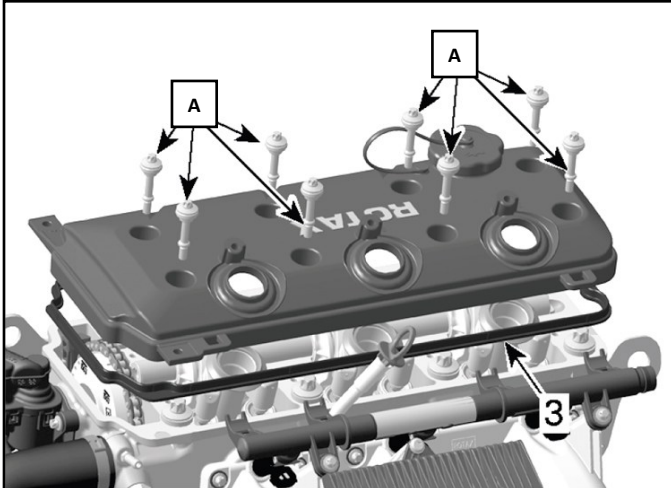
- INSTALLATION INSTRUCTIONS -

Remove seats and engine service deck if equipped.

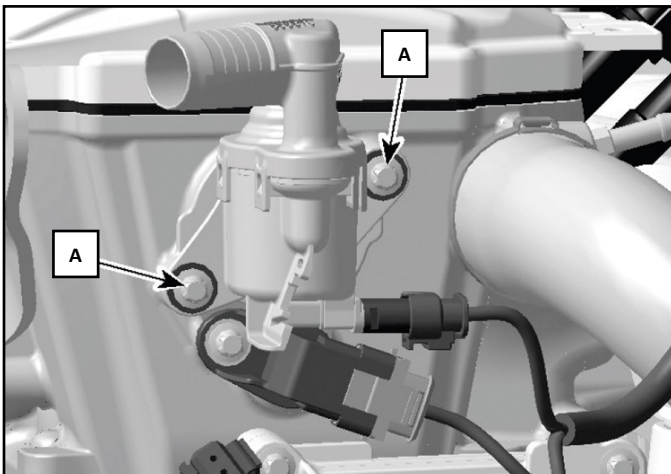
Remove plastic engine cover.

Remove spark plug coils.

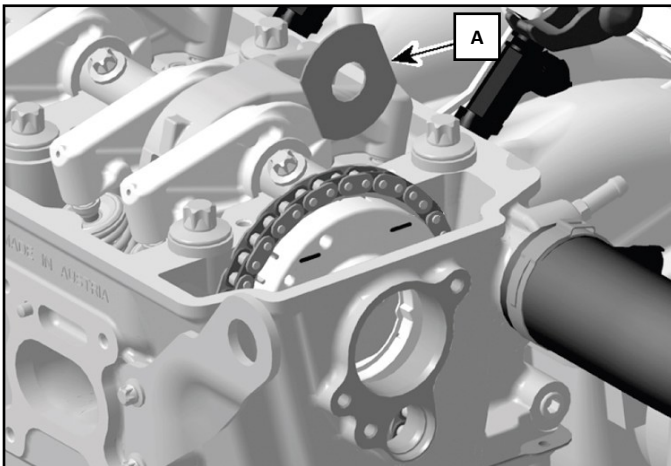
Remove valve cover (A - 8 bolts).



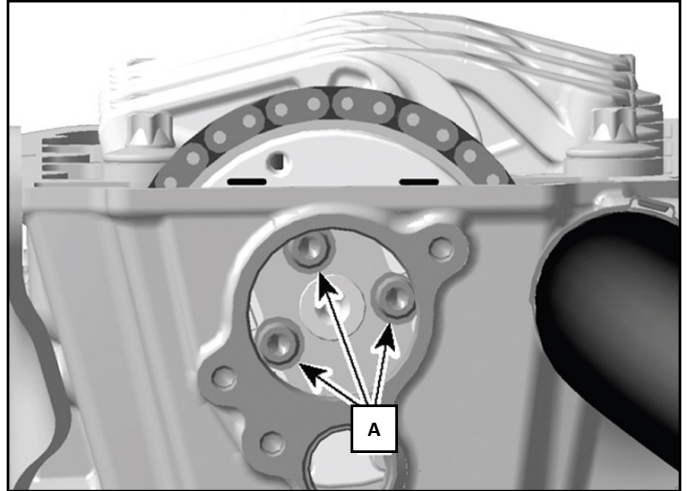
Remove engine blow-by valve (A - 2 bolts).



NOTE: Remove thrust (A) washer carefully so as not to allow it to fall into motor.



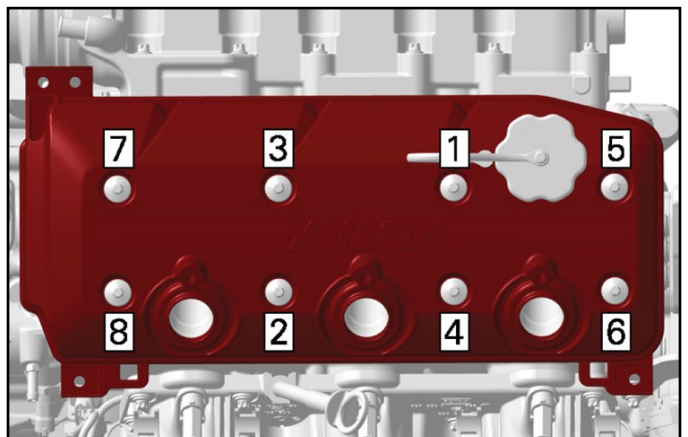
Three bolts (A) secure the cam gear to the cam shaft. Remove and replace 1 bolt at a time. **NOTE:** Apply **Loctite 243** to bolts. **Torque to 12 ft•lb (16 N•m).**



Replace engine blow-by valve. **NOTE:** **BRP** recommends replacing blow-by valve v-ring. Apply engine oil to o-ring, v-ring & thrust washer. Apply **Loctite 243** to bolts. **Torque to 6 ft•lb (9 N•m).**

Thoroughly clean top edge of cylinder head and sealing surface on valve cover with a non-residual cleaner. **NOTE:** **BRP** recommends replacing valve cover gasket.

Replace valve cover. **NOTE:** **Torque bolts in sequence to 6 ft•lb (9 N•m).**



Check bilge for rags, tools etc.

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

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

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***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 Cam Gear Bolts 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.