



RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Sea-Doo Pro-Series Steering System

RS20230-BK



Applications: Sea-Doo 2025+ RXT-X 325

Approximate Installation Time: 1 Hour

Recommended Specialty Tools:

Star Hex Bit Set

Required Materials:

Red Loctite

Aftermarket Handlebars

Aftermarket Grips

Part #

[RS35187](#)

Part #

N/A

See page 6

See page 6

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>



Sea-Doo Pro-Series Steering System

RS20230-BK

COMPONENT LIST

| ITEM | DESCRIPTION | PART # | QTY | NOTES |
|------|--------------------------------|-----------|-----|-------|
| A | RIVA BILLET STEERING SHAFT | RS20230 | 1 | |
| B | RIVA BILLET HANDLEBAR CLAMP | | 1 | |
| C | RIVA BILLET STEERING ARM | | 1 | |
| D | RIVA BILLET STEERING ARM CLAMP | | 1 | |
| E | M8 X 25 SHCS | .8C25SCHS | 6 | |
| F | M8 FLAT WASHER | .8NWTFS | 2 | |
| G | Zip Tie, 7-inch | TY25MX | 3 | |

NOTES & 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.

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.

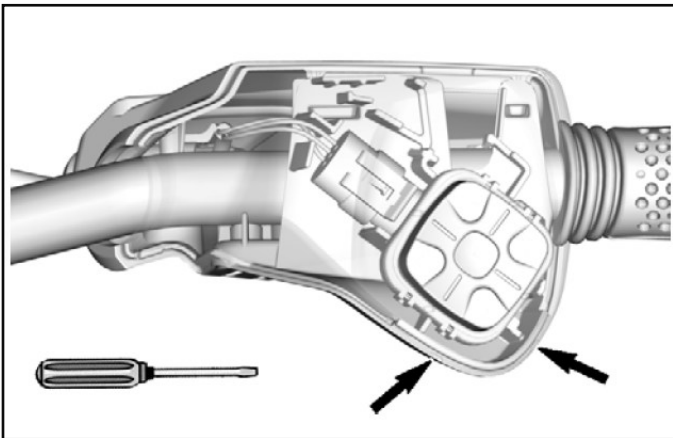
Installation Instructions

OEM STEERING REMOVAL

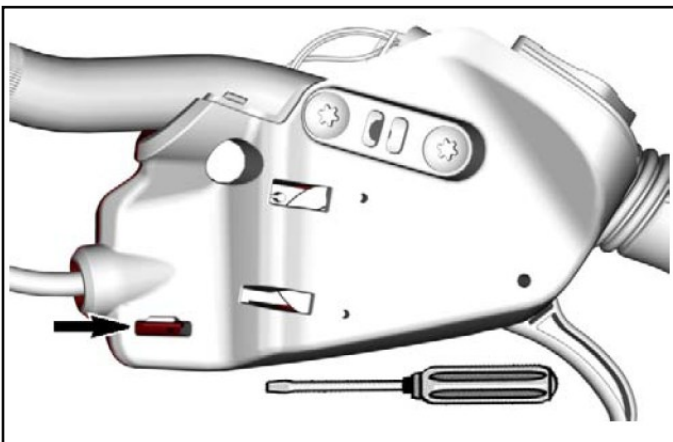
Remove stock steering pad (1 Torx screw).



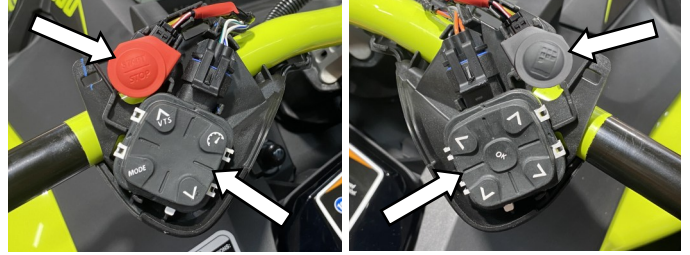
Remove switch (control pad) covers on both sides by prying out and up at designated locations at lower edge on each cover. Set covers aside. **TIP:** Insert small, flat screwdriver behind tab and pry upward.



Remove throttle & iBR lever covers by releasing tabs at underside of control housings and set aside. **TIP:** Insert small, flat screwdriver behind tab and pry towards bow of craft.



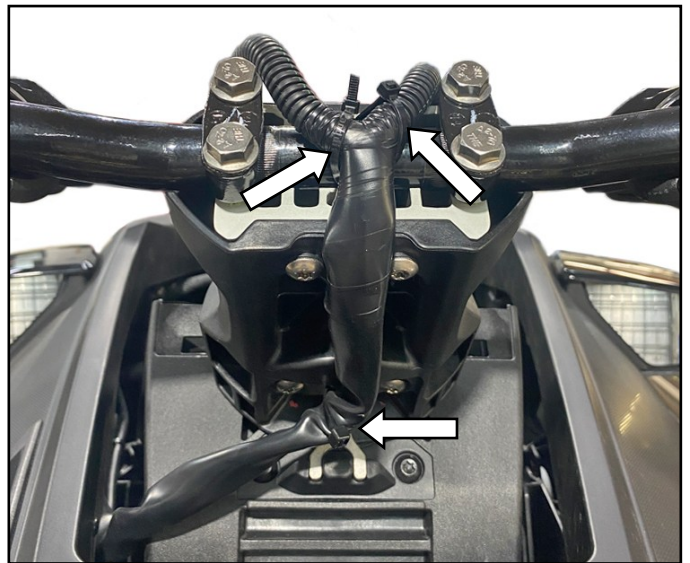
Remove switches (control pads) from control housings (2 per side).



Remove control housings from handlebars (2 Torx screws each side). Save hardware for use later.



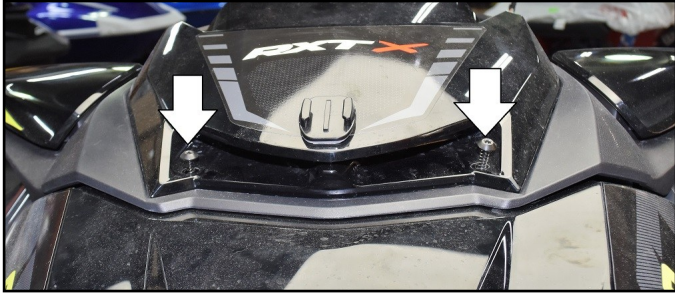
At steering, remove zip ties securing wiring harness in place.



Place controls back, over top of glove box.

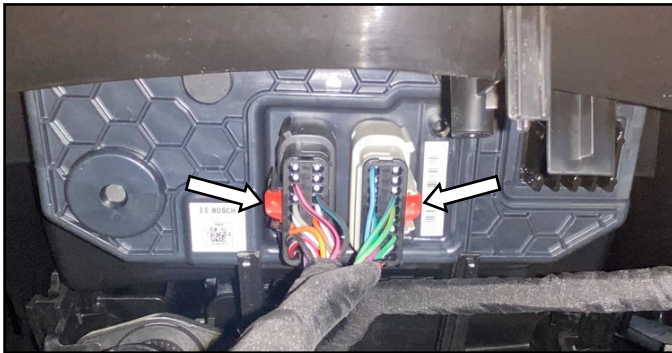
Installation Instructions

In front of digital dash display, remove Torx screws (2) securing cover.



Remove cover by sliding forward.

Inside, locate digital dash display connectors (2). Unlock red locking tabs and unplug connectors and move aside.



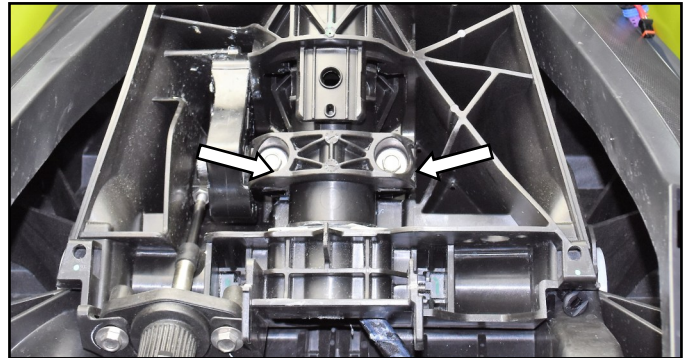
At base of steering column, on each side, insert a flat-bladed screwdriver between the upper half of display support/steering column cover and lower half. Carefully pry apart while moving the cover up and forward.



Back inside, at base of digital dash display there are locking tabs securing the display support/steering column cover in place. Pry tabs outward to release display support/steering column cover.



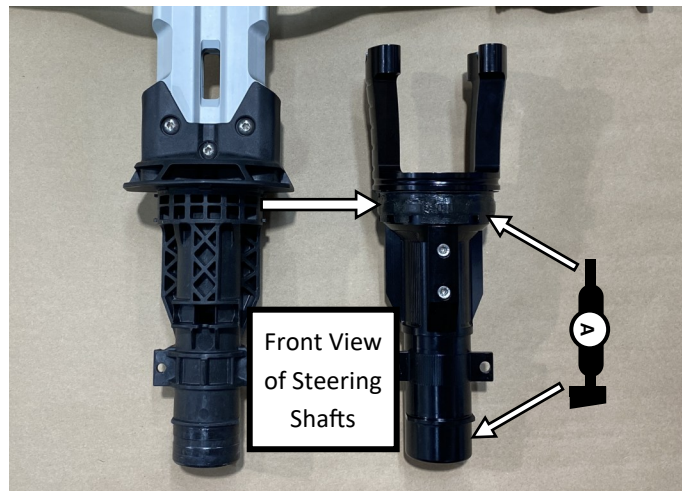
At steering column, remove bolts (2) securing steering column in place. Remove pieces and discard.



Center steering and completely remove assembly by pulling up.

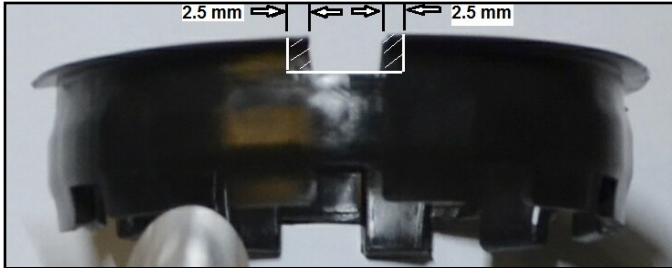
Remove plastic OEM steering arm from steering column support and discard. Install supplied billet steering arm directly in its place. **NOTE: Coat friction surfaces of billet steering arm with waterproof grease.**

Transfer upper steering shaft bushing from OEM steering shaft to supplied billet steering shaft. **(NOTE: Bushing fits only one way (same as on OEM steering shaft)).**



Installation Instructions

Due to variances between OEM steering columns and bushings on various models some bushings may not fit the supplied RIVA steering column without modification. Slip bushing onto supplied RIVA steering column and check fit of locating notches over locating bosses on steering column. One notch is narrower than the others. If bushing does not fit all three bosses, locate narrow notch on bushing and widen 0.098in/2.5mm using a sharp utility knife. **Note: Use caution. Bushing material is very soft and cuts easily.**

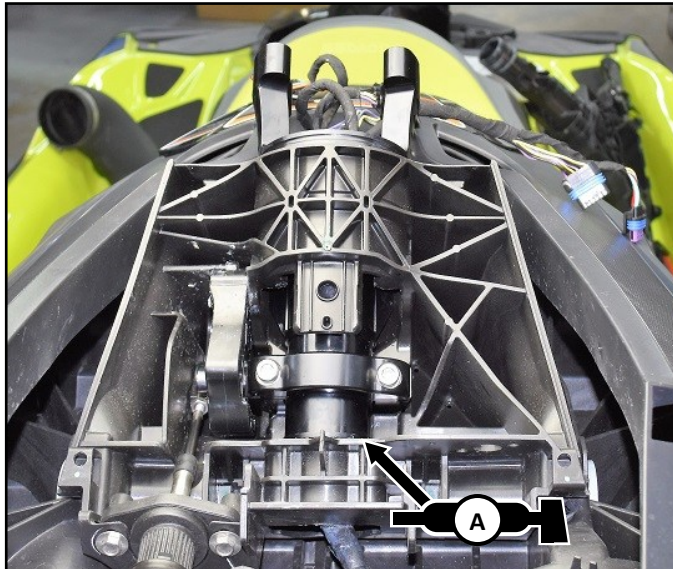


Apply water proof grease to outside of upper steering shaft bushing and to lower steering shaft bushing friction surfaces.

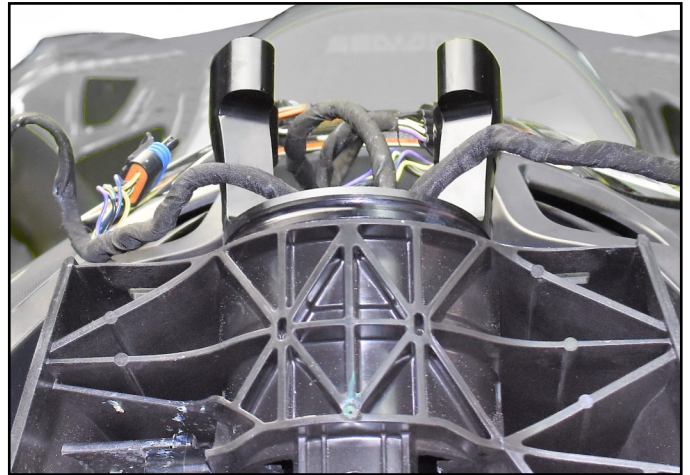
RIVA STEERING INSTALLATION

Install steering column by inserting end of billet steering shaft into lower steering shaft bushing. **NOTE: Apply waterproof grease to end of steering shaft and inside of steering shaft bushing. Steering shaft fits only one way in steering column.**

Secure billet steering shaft in steering column support with supplied billet steering clamp and supplied M8x25 SHCS & M8 flat washers (2 each). **NOTE: Apply red Loctite to bolts. Torque to 15 ft•lb (20 N•m).**

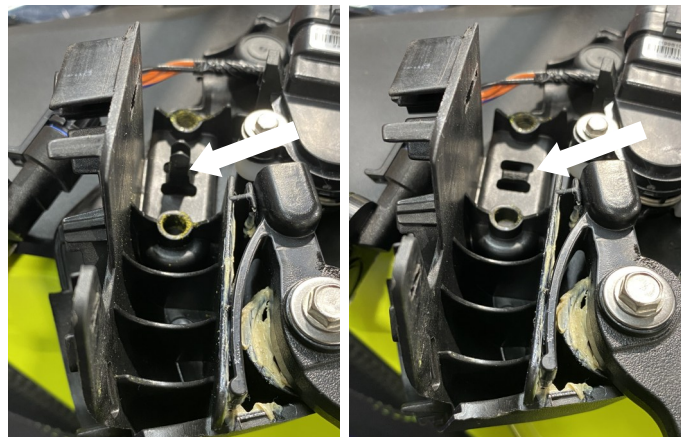


Place controls forward over dash display so that main trunk of wiring harness is between handlebar cradles of billet steering shaft.



Install aftermarket handlebars and center side to side. Secure handlebars using supplied clamp and M8x25 SHCS (4). **NOTE: Apply red Loctite to threads. Ensure handlebar cross-bar is directly over clamp. Torque bolts evenly in a crisscross pattern to 15 ft•lb (20 N•m).**

Remove (snip) locating tabs on control housings.



Secure control housings to aftermarket handlebars using hardware previously removed. **NOTE: Apply red Loctite to threads. Torque to 18 ft•lb (2 N•m).**

Installation Instructions

Replace switches (control pads) and control housing covers in reverse order of removal. **NOTE: Take care not to pinch wires between control housing covers and control housings. Be sure all pieces are properly aligned before snapping together. Do not force together!**

Secure electrical wires with supplied zip ties.

Install aftermarket grips.

Installation of your RIVA Pro-Series Steering System is now complete.

Run craft on flush kit no more than 1 minute to check for normal operation.

CONTROL OPTIONS

RIVA Racing Handlebar Option:

RIVA Sea-Doo 'PRO-BAR' 30" Runabout Bars

Item #: [RY207BK-BAR-2](#)

RIVA Racing Grip Options:

ODI Rogue Lock-On Grips, 130mm, No Flange, Black

Item #: [L31RGB-S](#)

ODI Ruffian Lock-On Grips, 130mm, No Flange, Black

Item #: [L32RFB-S](#)

RIVA ODI Grip End Cap & Clamp Kits

Item #: [RY206-COLOR](#)

RIVA Racing Control Lever Option:

RIVA Sea-Doo Billet iControl Levers

Item #: [RS24090-ICL-COLOR](#)

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 Steering Systems 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.