



Performance Valve Guides

Application

Yamaha 1.8L Engine
Sea-Doo 1503/1630

Part #

RY19040-PVG-KIT
RS19050-PVG-KIT

The following specifications are provided as a guide only. We strongly recommend that only an experienced machinist prepare and install these valve guides. Failure to properly prep and install these valve guides falls solely on the end user. Due to the nature of performance applications these valve guides are sold without any express warranty or any implied warranty of merchantability or fitness for a particular purpose. RIVA Racing shall not, under any circumstances, be liable for any special, incidental or consequential damages, including, but not limited to damage, or loss of profits or revenue, cost of purchased or replacement goods, or claims of customers of the purchaser, which may arise and/or result from sale, installation or use of these valve guides. Installation will adversely affect the vehicle manufacturer's warranty coverage.

INSTALLATION GUIDELINES:

- Do not machine or modify valve guide(s) I.D. or O.D. prior to installation. *
- Carefully remove original, damaged valve guide(s) from cylinder head. It may be necessary to heat aluminum around valve guide(s).
- Thoroughly clean cylinder head and inspect for damage. If any damage is detected the cylinder head should be replaced.
- Prior to installing new valve guide(s) the cylinder head should be heated to 100°F in temperature. We recommend placing new valve guide(s) in a freezer for 1 hour prior to installation.
- Install valve guide(s) evenly into cylinder head by hand. Do not force or press into head using any tools.
- Allow cylinder head to cool completely after installing replacement valve guide(s).
- Replacement valve guide(s) I.D. must be honed and reamed to clearance specifications of cylinder head manufacturer prior to installing valves and running engine. Refer to OEM service manual.

* = I.D. of new valve guide is intentionally smaller than OEM specification. Valve Guide O.D. should not be modified or altered.

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.