



# RIVA RACING

PERFORMANCE PRODUCTS & ACCESSORIES

## Pro-Series 4-stroke Pistons

**PART# - RS1001-1503-8.4-010**

The following specifications are provided as a guide only. We strongly recommend that only an experienced engine builder prepare and install this piston following the steps outlined in the OE Service Manual. Failure to properly prep and install this piston falls solely on the end user. Due to the nature of performance applications this piston is 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 this piston. Installation of this piston will adversely affect the vehicle manufacturer's warranty coverage.

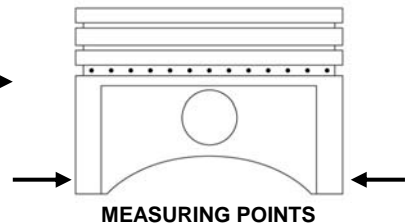
### PISTON SPECIFICATIONS:

MOTOR TYPE	Sea-Doo 4-TEC	COMP. RATIO	8.4:1
HEAD TYPE	4-valve	COMP. DIST.	1.1607" (29.48mm)
DISPLACEMENT	1500cc	INTAKE *	.120" (3.05mm) 17-degree
PISTON TYPE	Dish	EXHAUST *	.105" (2.67mm) 18-degree
BORE	3.947" (100.19mm)	* Valve pocket depth measured from deck.	
STROKE	2.5" (63.4mm)	* Will accept +1mm valve.	
		TARGET WEIGHT	419 grams

### IMPORTANT CLEARANCE INFORMATION:

**CYLINDER WALL** .0032" ~ .0037"

Measure at bottom of piston skirt as shown at right.



### RING GAPS

Stock	.0065"
Modified	.0075"
Boosted	.0080"

Use chart below to determine ring end gap. Multiply bore size X ring end gap factor.

### EXAMPLE:

4.125" bore x .0080" ring end gap factor = .033" minimum ring end gap.

**NOTE:** These are general guidelines. Always fit ring to intended cylinder.

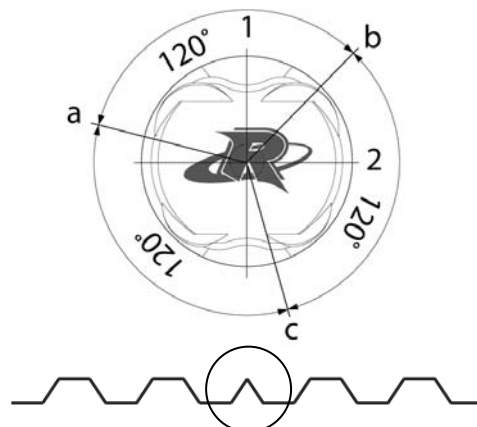
### RING ORIENTATION INFORMATION:

- a** Top ring (silver)
- b** 2nd ring (dark grey)

**NOTE:** If a mark is present on rings install with that side up towards top of piston.

- c** Oil ring rails (2)
- 1** Piston trust side axis
- 2** Piston pin bore axis

**NOTE:** Do not align ring gap with 1 or 2.



**NOTE:** Oil ring expander tips correctly butted together.

**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).