



# **RIVA RACING**

**PERFORMANCE PRODUCTS & ACCESSORIES**

## **Head Stud Kit** **PART# - RS10050-HSK**

**APPLICATION(S):** Sea-Doo 325/300/260/255/230/215hp 4-TEC Engines

**Required tools**  
OEM Service Manual

**Part#**  
CALL

**\*\*\* NOTE: Allow craft's engine to cool completely before performing installation. \*\*\***

### **- INSTALLATION INSTRUCTIONS -**

1. To ensure proper thread engagement and accurate torque readings clean ALL threads in block. Chase if necessary.
2. Clean and inspect all hardware prior to installation. Look for obvious defects or shipping damage.
3. Check all hardware for proper fit, length, and dimension prior to installation. **NOTE: We have determined there are machining variances in blocks. Stud height should be verified before finally assembly.**
4. Screw studs into block HAND TIGHT ONLY. **NOTE: Loctite may be used if a permanent mounting of the studs is preferred. However, the fasteners (nuts) must be torqued prior to the Loctite curing.**
5. Install cylinder head. Check for binding, misalignment, and valve cover clearance. **NOTE: We have determined there are machining variances in blocks. Stud height should be verified before finally assembly.**
6. Lubricate stud threads, nuts, and washers with moly assembly lubricant. Install washers and nuts and screw hand tight. If moly lubricant is not available 30wt motor oil may be used.
7. Following the torque sequence outlined in the service manual tighten the nuts in a three-step process to achieve a total of 80 ft•lb if using moly lubricant or 85 ft•lb if using 30wt motor oil.

**CYLINDER HEAD GASKET:** DO NOT reuse the original head gasket. A new OEM cylinder head gasket can be used. For modified 260/255/230/215 engines we strongly recommend using a new RIVA Pro-Series Cylinder Head Gasket (part# RS10050-CHG-1503).

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

### **Limited Warranty**

RIVA Head Stud Kits carry a Lifetime 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.