



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

## SEA-DOO RXT-X / GTX 300 Rear Exhaust

PART# - RS15140



**Applications:** Sea-Doo RXT-X / GTX 300 Models 2016-

**Approximate Installation Time:** 2.5 hr.

**Recommended Specialty Tools:**

Oil Filter Strap Wrench

**Part #**

N/A

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 \*\*\***



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

**Sea-Doo Water Box S3/T3 300 HP**

**COMPONENT LIST**

ITEM		QUANTITY	PART NUMBER	DESCRIPTION
A	<input type="checkbox"/>	1		Aluminum tube
B	<input type="checkbox"/>	1		Billet Outlet
C	<input type="checkbox"/>	1		Billet Retaining Ring
D	<input type="checkbox"/>	1		Gasket
E	<input type="checkbox"/>	5	LMBHS7X06040	Bolts 1/4-20 x 1-1/2"
F	<input type="checkbox"/>	2	RS15-03/03	Silicone Coupler
G	<input type="checkbox"/>	1		Through Hull Plug
H	<input type="checkbox"/>	1	TY24MX	5" Zip Tie

Packed with pride by: \_\_\_\_\_

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@rivamotorsports.com](mailto:tech_support@rivamotorsports.com)

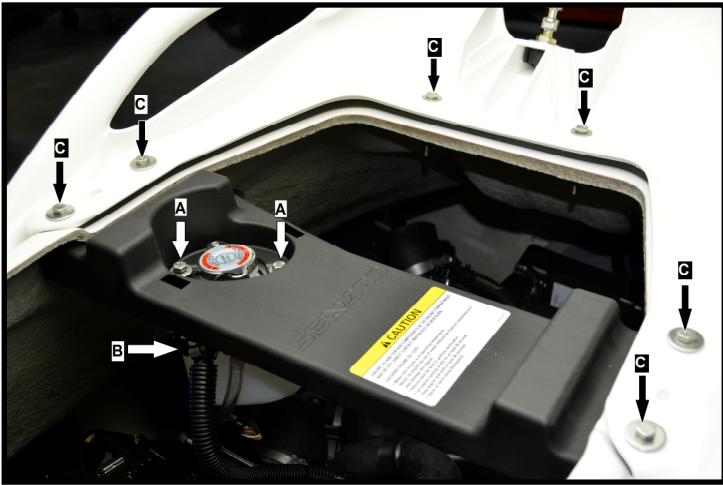
## **- INSTALLATION INSTRUCTIONS -**

Open seat.

Remove two bolts holding coolant reservoir to deck beam (A). Pull out on retaining tabs (B) and lower the coolant reservoir away from its mounting location. Lay the reservoir to the starboard side to provide better access to the exhaust.

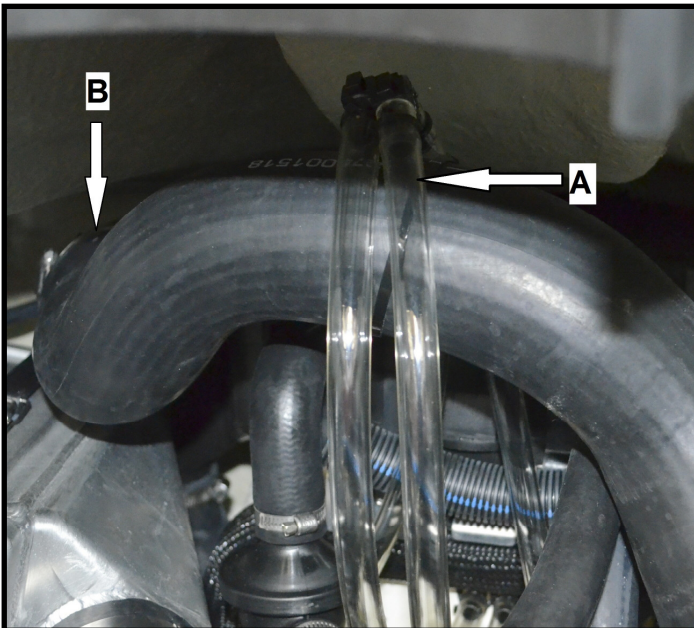
Remove 4 deck beam bolts and 2 grab rail bolts (C), nuts and washers. Caution: Do not drop nuts and washers into hull. Remove deck beam and grab rail assembly. (Figure 1)

Figure 1



Cut the zip tie (A) securing the two clear siphon bilge hoses to the OEM Front Exhaust Hose. (Figure 2)

Figure 2



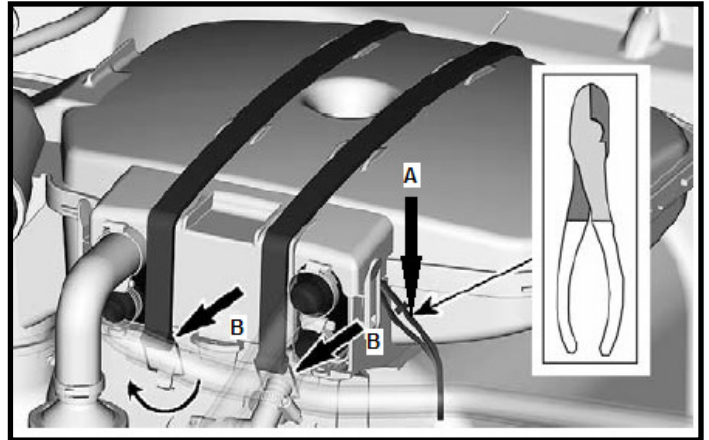
Loosen the clamp (B in figure 2) holding the OEM Front Exhaust Hose to the resonator. Loosen the clamp holding the front exhaust hose on the waterbox outlet. Remove

and discard the Front Exhaust Hose. Keep the clamps for later reuse.

Cut the zip tie (A) securing the intercooler feed hose to the plastic heat exchanger cover on the front of the resonator. (Figure 3)

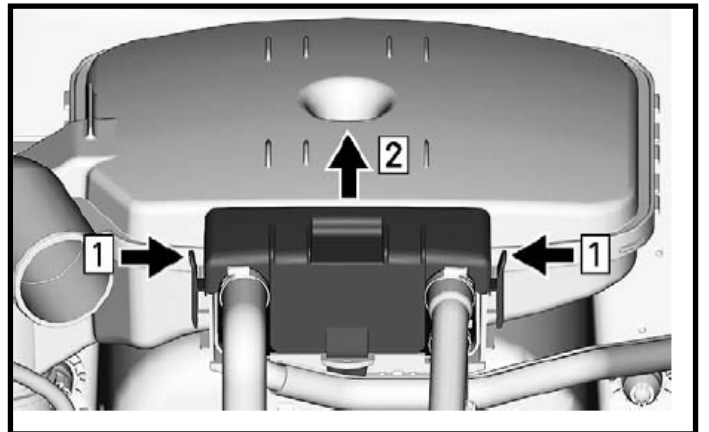
Remove the two rubber straps (B) securing the resonator in the hull. Set the straps aside for reuse later. (Figure 3)

Figure 3



Push the two locking tabs (1) on the heat exchanger cover toward the center and pull the cover upward to remove it. (Figure 4)

Figure 4



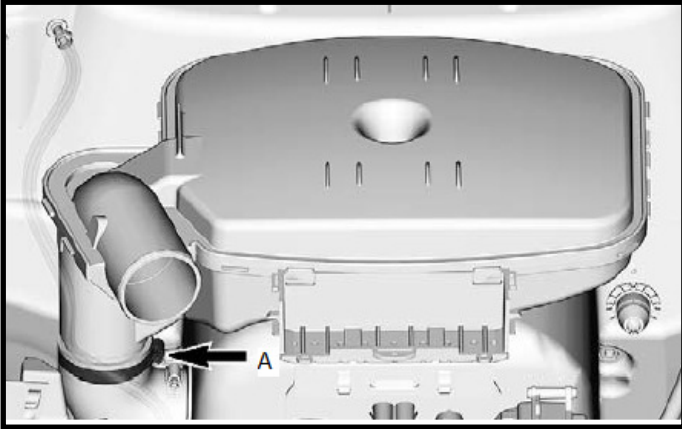
Pull the heat exchanger up to release it from the resonator bracket. Lower the heat exchanger with the attached hoses into the hull.

Loosen the clamp holding the resonator outlet to the through hull fitting..(Figure 5)



## - INSTALLATION INSTRUCTIONS -

Figure 5



Pull the resonator upward while twisting it back and forth to remove it from the through hull fitting. Remove the resonator from the hull and discard as it will not be used again. Keep the hose clamp for later reuse.

Remove the six screws (A) holding the guard covering the iBR gate to the hull. Remove the guard. Set aside the guard and screws for reinstallation later. (Figure 6)

Figure 6



Remove the nut and bolt (B) holding the steering cable to the steering nozzle. Set aside for reinstallation later. (Figure 6)

Use iBR override function to align the openings in the iBR gate with the screws holding the iBR Support Bracket:

**Note: Remove any foreign object that may obstruct iBR actuator movement.**

1. Press the START/STOP button.
2. Install the tether cord.

**NOTE: Do not start the engine. The tether cord must be installed to ensure the information center will not shut off all indications after its self test function. Briefly**

**press the START/STOP button to reactivate the electrical system when required.**

3. Pull in the iBR lever;

3.1 There will be a beep.

4. Press the VTS UP or DOWN button to move the iBR gate.

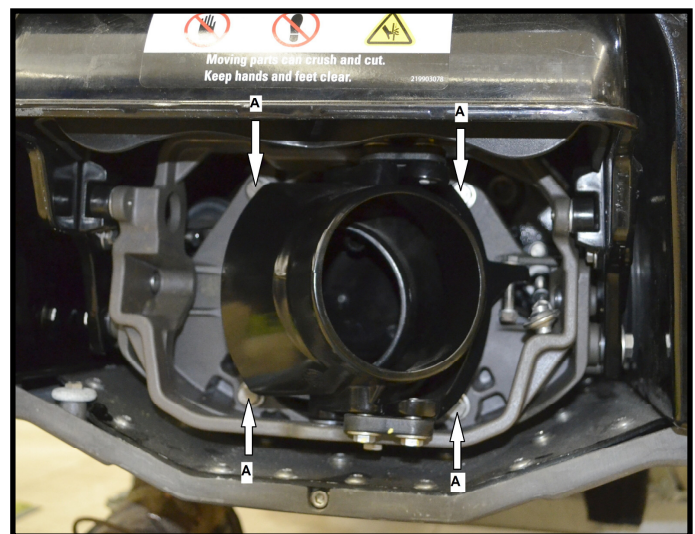
Remove the bolt connecting the linkage arm to the iBR gate. Set aside for reinstallation later. (Figure 7)

Figure 7



Remove the 4 bolts (A) and 2 nuts (B) holding the iBR support bracket to the jet pump. Remove the iBR gate and support bracket assembly from the ski. Set the assembly and hardware aside for reinstallation later. (Figures 8 and 9)

Figure 8





## - INSTALLATION INSTRUCTIONS -

Figure 9



With a strap wrench grasp the nut on the exhaust through hull fitting and unscrew it. Set aside the nut for reuse later. (Figure 10) (Jet Pump removed for clarity.)

Figure 10



Remove the through hull fitting from the ski by pulling from the inside of the hull. Retain the gasket for reuse. Remove the clamp holding the 90 degree elbow fitting to the OEM through hull fitting. Keep the clamp for later reuse. Discard the OEM through hull and elbow fittings.

Insert supplied through hull plug into hole. The head of the plug will be inside the hull. The OEM nut and gasket will be on the outside. Note that the plug has alignment tabs that must be aligned with notches in the hole. (Figure 11)

Figure 11



Place sealing washer gasket onto through hull plug and thread OEM through hull nut onto the supplied through hull plug. Use strap wrench to tighten. **Note: Do not overtighten.**

Cut out supplied paper template according to the instructions on the template. Do not cut out the hole for the exhaust outlet. If you print the template on your own printer make sure that the printed template is the correct size. See the printer reference instructions on the template.

Tape the template to the port transom. (Figure 12)

Figure 12



**Note: Hole location is critical!** Check template location by laying the supplied retaining ring on the template with the edge of the ring touching the tie down base. If the hole location is correct the template hole location will be centered in the ring. (Figure 13)

Figure 13



Hole can be made using a hole saw bit, or with a

## **- INSTALLATION INSTRUCTIONS -**

Dremmel®, Roto Zip® or die grinder tool. **Note: Do not make the hole larger than 3-1/16" in diameter. Wear safety glasses.**

Remove lower nut and washers (2) securing tie down cleat to hull. (Figure 14)

Figure 14



Modify washers as seen below. (Figure 15)

Figure 15



Replace washers with flat side facing downward towards bottom of craft. Secure with stock nut. **NOTE: Do not over tighten nut.**

Clean the outside of the hull and the exhaust outlet tip with a non residual cleaner. Peel the paper backing from one side of the supplied exhaust outlet gasket. Slide it over the supplied exhaust outlet tube and press it into place against the flange taking care to assure that the bolt holes in the gasket and flange are properly aligned.

Peel the paper from the other side of the gasket and insert the exhaust outlet into the hole previously created. Align the RIVA logo at the bottom of the opening and press the tube into place.

Using a 1/4" bit, drill the securing bolt holes using the flange as a guide. (Figure 16) Insert bolts into drilled holes to help locate the flange while drilling the remaining holes.

**Note: Take your time and use a sharp bit and minimal pressure to minimize breakout of the fiberglass. Wear Safety glasses.**

Figure 16

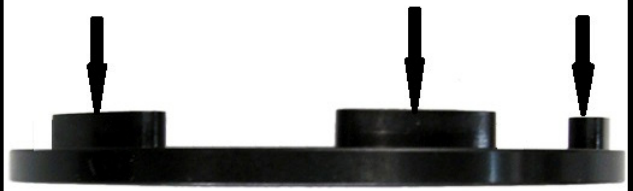


Clean fiberglass shavings and residue from inside of hull.

Install retainer ring with stand-offs against hull. Slide over exhaust outlet from inside of hull. (Figure 17)

Figure 17

### **Stand-Offs at hole locations 1, 2, and 5**

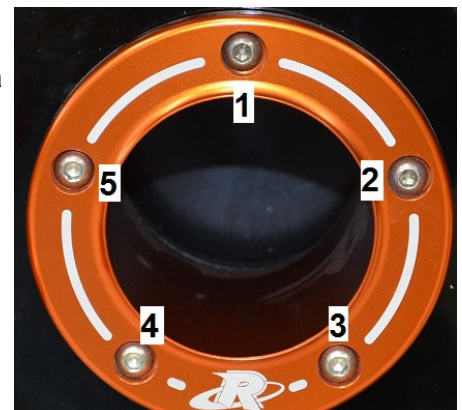


Locate stand-offs at bolt hole locations 1, 2, and 5. Secure exhaust outlet using supplied button head bolts.

**Note: Apply blue Loctite to threads of bolts. Do not overtighten bolts.** (Figure 18)

Figure 18

**TIP: To install ring slip it onto a piece of welding rod or similar stiff wire with a bent tip. Insert the wire through the top hole of the outlet. Then jiggle the wire until the ring**





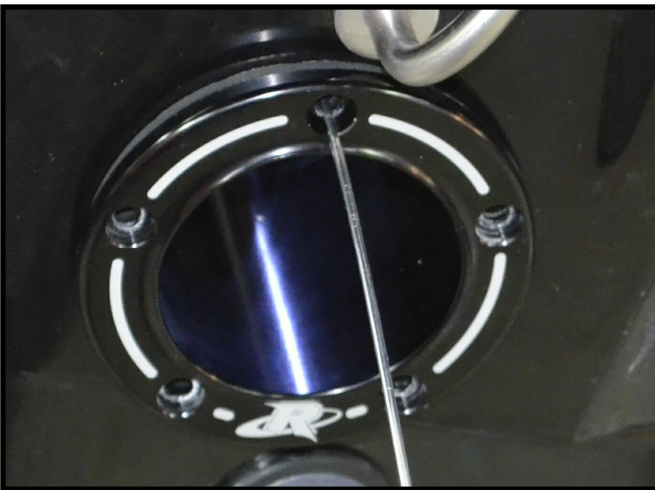
## **- INSTALLATION INSTRUCTIONS -**

slides into place on the outlet. Pull wire to seat ring against hull. Loosely install a couple of bolts to hold the ring and remove the wire. (Figures 19 and 20)

Figure 19



Figure 20



Inside hull place heat exchanger in its original location. Place OEM cover onto heat exchanger and reinstall retaining straps.

Lube inside of supplied silicone couplers and outside of exhaust tube with glass cleaner and install couplers onto tube. Clamp couplers onto tube using clamps saved during disassembly. **Do no over tighten clamps.** (Figure 21)

Figure 21



Slide a hose clamp (saved during disassembly) onto the transom end of the exhaust tube. Tighten the clamp just enough to keep it from falling off the coupler.

Lube the inside of the transom end coupler with glass cleaner. Place the exhaust into the tube and, holding the waterbox end, slide the coupler onto the outlet tube. Slide the loosely installed clamp down until it is over the coupler and the outlet tube. Tighten the clamp. (A cordless ratchet is a very helpful tool to have here.) **Note: Do not overtighten clamp.**

Using the supplied zip tie, tie the siphon bilge hoses to the heat exchanger water line. (Figure 22)

Figure 22



Secure exhaust tube coupler to water box. **NOTE: Do not over tighten clamps.**

Reassemble reverse and steering, in reverse order of disassembly. **Note: Use Blue Loc-tite on fasteners. Refer to OEM service manual for tightening sequence and torque values.**

Replace parts applicable to your craft that were removed to access exhaust. **NOTE: Apply blue Loc-tite to bolts. Do not over tighten bolts.**

Check bilge for tools, rags, etc. Start craft and run using flush kit to check for exhaust leaks at connecting points of exhaust system. Do not run craft out of water for more than two minutes at a time



## **- INSTALLATION INSTRUCTIONS -**

***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).

### **Limited Warranty**

RIVA Rear Exhausts 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.

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**2016 & Newer  
Sea-Doo RXT-X 300  
Exhaust Outlet Template**

Cut Template Along  
Dotted Line

Place at Base of  
Tie Down Cleat

**Exhaust Cut-Out  
should be 3" Dia.**

Do Not Cut Out Exhaust  
Pilot Hole Reference

