



**SEA-DOO RXP-X 300 Rear Exhaust**

PART# - RS15150



**Applications:** Sea•Doo RXP-X 300 Models 2016-2019

**Approximate Installation Time:** 3.5 hr.

**Recommended Specialty Tools:**

Oil Filter Strap Wrench

**Part #**

N/A

**Required Materials:**

Blue Loctite

**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

**Rear Exit Exhaust RXP-X 300**

**RS15150**

**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

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 -**

Remove or open seat.

### **RXP-X:**

Remove the two bolts on each side holding the side panels in place and remove the side panels. (Figure 1)

Figure 1



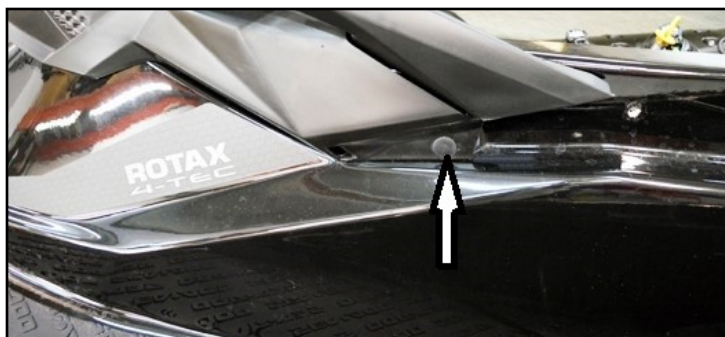
Remove 2 screws (A) and 2 plastic rivets (B) holding vent cover to rear grab handle and remove vent cover (Figure 2).

Figure 2



Remove 2 plastic rivets under side panels removed previously (Figure 3)

Figure 3



Press the (2) locking tabs (A) on the coolant reservoir towards the reservoir body and lift the reservoir out of its mounting location. Lay the reservoir to the starboard side to provide better access to the exhaust.

Remove (6) bolts (B), nuts and washers holding rear grab rail in place and remove grab rail. Caution: Do not drop nuts and washers into hull. (Figure 4)

Figure 4



Disconnect waterlines between exhaust manifold and stock water box (A)

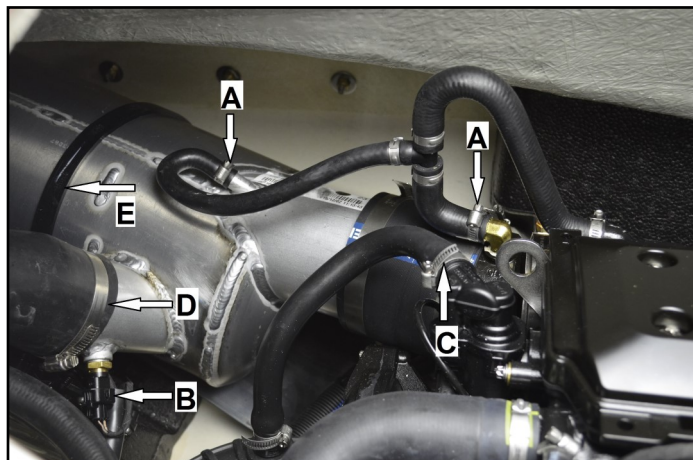
Disconnect water box overheats sensor (B).

Disconnect engine breather hose from TOPS valve at rear of cylinder head (C).

Disconnect exhaust outlet hose from water box (D).

Remove rubber strap around waterbox (E). (Figure 6)

Figure 6

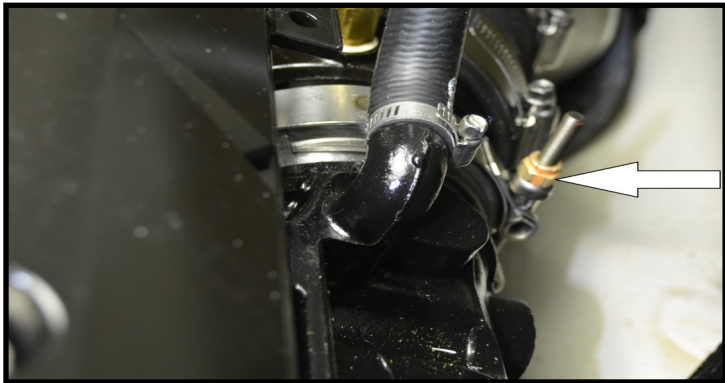


At exhaust clamp loosen t-bolt nut enough to allow end ('T') to be removed from band clamp. Remove exhaust clamp. (Figure 7)



## - INSTALLATION INSTRUCTIONS -

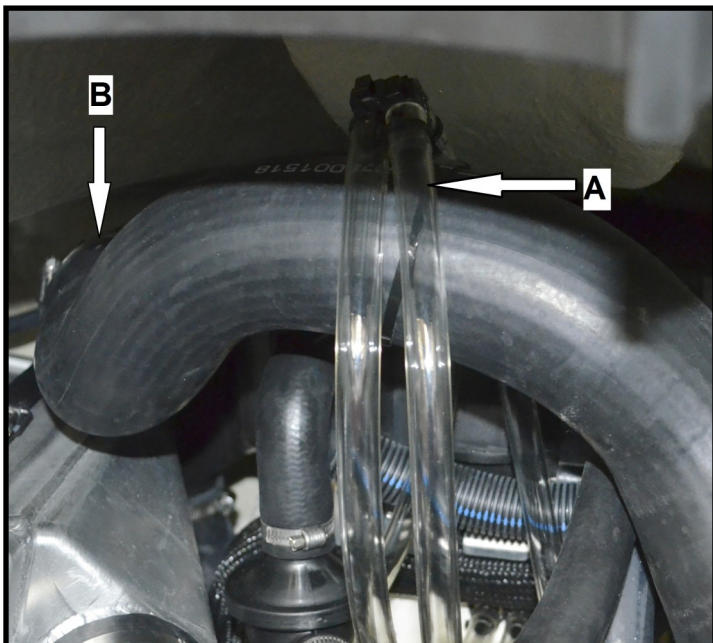
Figure 7



Remove water box assembly from hull and set aside for reinstallation later.

Cut the zip tie (A) securing the two clear siphon bilge hoses to the OEM Front Exhaust Hose. (Figure 8)

Figure 8

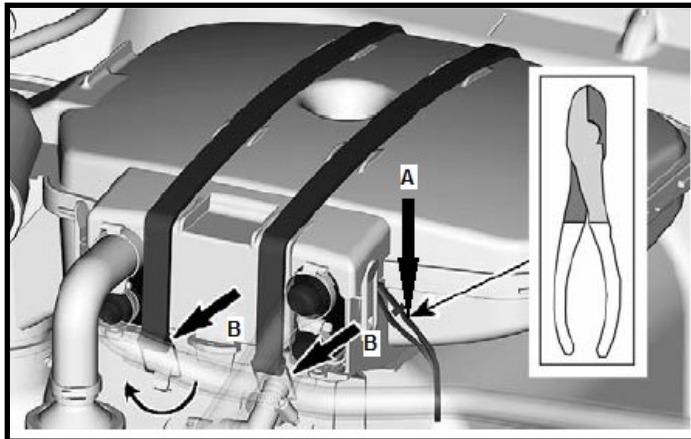


Loosen the clamp (B in figure 8) holding the OEM Front Exhaust Hose to the resonator. Remove and discard the Front Exhaust Hose. Keep the clamp for later reuse.

Cut the zip tie (A) securing the intercooler feed hose to the plastic heat exchanger cover on the front of the resonator. (Figure 9)

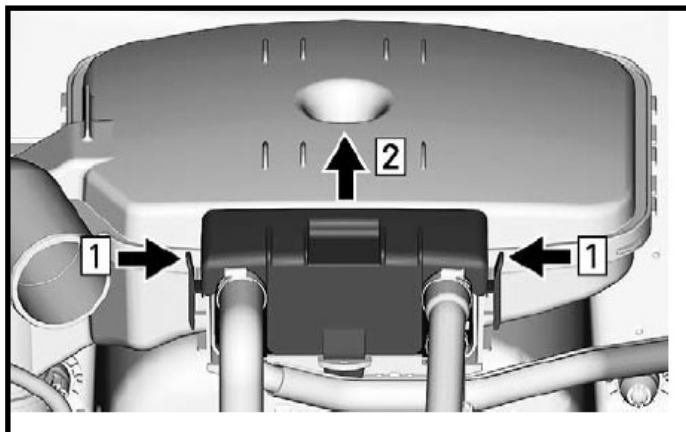
Remove the two rubber straps (B) securing the resonator in the hull. Set the straps aside for reuse later. (Figure 9)

Figure 9



Push the two locking tabs (1) on the heat exchanger cover toward the center and pull the cover upward to remove it. (Figure 10)

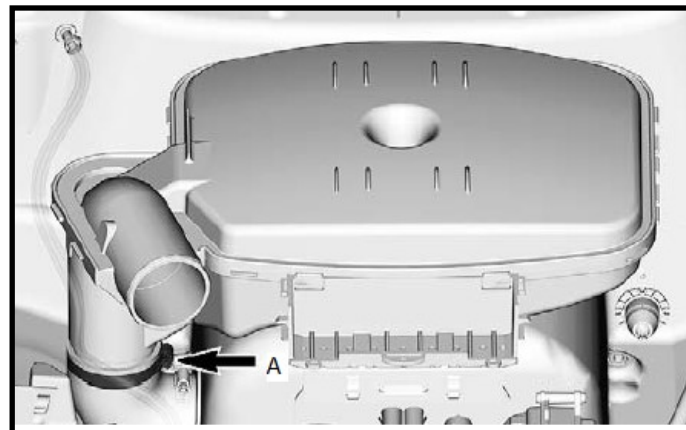
Figure 10



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 11)

Figure 11



## **- INSTALLATION INSTRUCTIONS -**

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 12)

Figure 12



Remove the nut and bolt (B) holding the steering cable to the steering nozzle. Set aside for reinstallation later. (Figure 12)

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 13)

Figure 13



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 14 and 15)

Figure 14

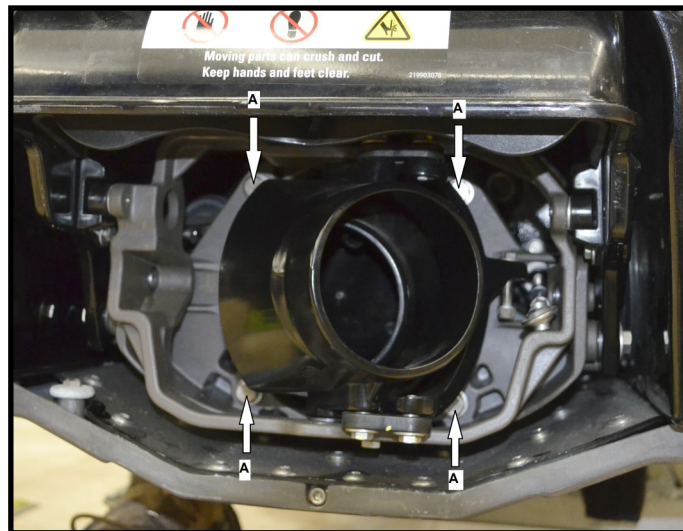


Figure 15





## - INSTALLATION INSTRUCTIONS -

With a strap wrench grasp the nut on the exhaust through hull fitting and unscrew it. Set aside the nut for reuse later. (Figure 16) (Jet Pump removed for clarity.)

Figure 16



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 17)

Figure 17

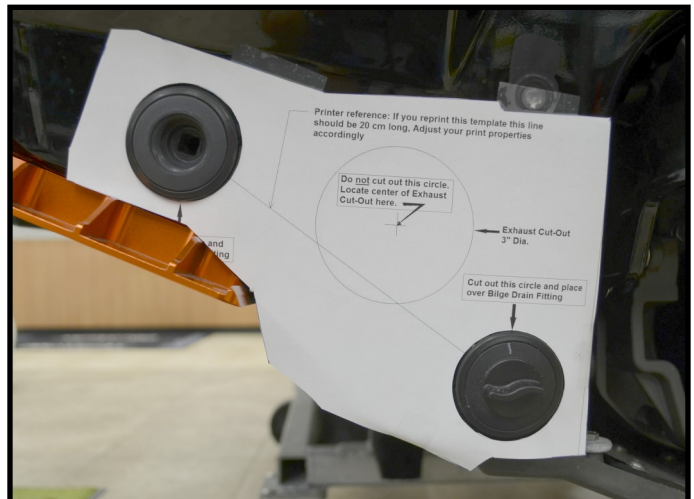


Place sealing washer gasket onto through hull plug and thread OEM through hull nut onto the supplied through hull plug. Use strap wrench to tighten. **Note: Do not overtighten.**

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 18)

Figure 18



Hole can be made using a hole saw bit, or with a Dremmel®, Roto Zip® or die grinder tool. **Note: Do not make the hole larger than 3-1/16" in diameter. Wear safety glasses.**

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 19) 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 19



## **- INSTALLATION INSTRUCTIONS -**

Clean fiberglass shavings and residue from inside of hull.

Install retainer ring, flat side to transom, onto exhaust outlet from inside of hull. Secure exhaust outlet using supplied button head bolts. **Note: Apply blue Loctite to threads of bolts. Do not overtighten bolts.**

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. (Figure 20)

Figure 20



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 the clamp.**

Using the supplied zip tie tie the siphon bilge hoses to the heat exchanger water line. (Figure 21)

Figure 21



Insert water box assembly into hull.

Align exhaust pipe with exhaust manifold. Note measurements in instruction illustrations. Alignment is critical to prevent exhaust leaks. (Figures 22 and 23)

Figure 21

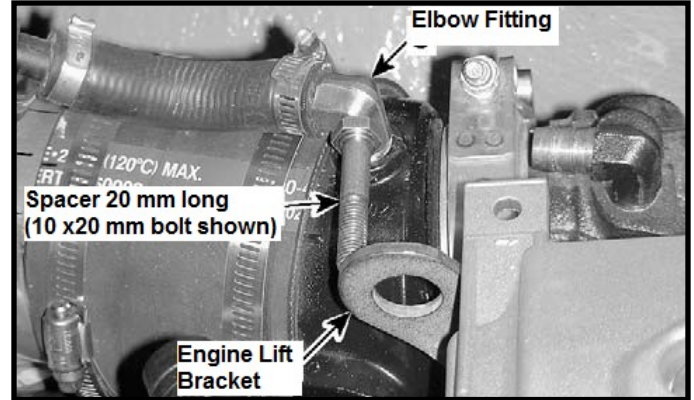
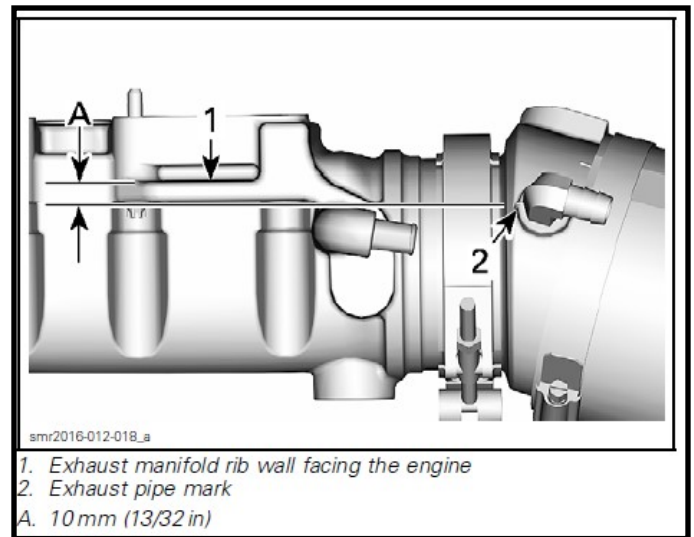


Figure 22



Install exhaust clamp and t-bolt. **NOTE: Check alignment between exhaust pipe and exhaust manifold.**

Align water box with coupler. Secure coupler. **NOTE: Do not tighten clamp.**

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

Install water box hold down strap. **TIP:** Spray underside of water box strap with glass cleaner.

Once water box inlet and outlet couplers are in place and water box is properly aligned tighten all of the inlet and outlet clamps. **Note: Do not over tighten clamps.**

Reconnect water box overheat sensor.

Replace cooling lines previously removed. (See Figure 6). Replace engine breather hose at TOPS valve hose. **NOTE: Do not over tighten clamps.**

## **- INSTALLATION INSTRUCTIONS -**

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

***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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Printer reference: If you reprint this template this line should be 20 cm long, adjust your print properties accordingly

Locate center of Exhaust first before cutting out circle

Exhaust Cut-Out should be 3" Dia.

Cut out this circle and place over Bilge Drain Fitting

Cut out this circle and place over Flush Fitting

# 2016 Sea-Doo RXP-X 300 Rear Exhaust Outlet Template