



**2020+ SEA-DOO RXP-X 300 Rear Exhaust**

PART# - RS15151



**Applications:** Sea-Doo RXP-X 300 Models 2020+

**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 \*\*\***



**2020+ SEA-DOO RXP-X 300 Rear Exhaust**

**COMPONENT LIST**

ITEM		QUANTITY	PART NUMBER	DESCRIPTION
A	<input type="checkbox"/>	1	W-RS15151-T	Aluminum tube
B	<input type="checkbox"/>	1	QCA-RS15140	Billet Outlet
C	<input type="checkbox"/>	1		Billet Retaining Ring
D	<input type="checkbox"/>	1		Gasket
E	<input type="checkbox"/>	5	842084SS	Bolt, 6 x 40mm SS BHCS
F	<input type="checkbox"/>	2	RS15-03/03	Silicone Coupler
G	<input type="checkbox"/>	1	QCA-RS15140-PLUG	Through Hull Plug
H	<input type="checkbox"/>	2	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)

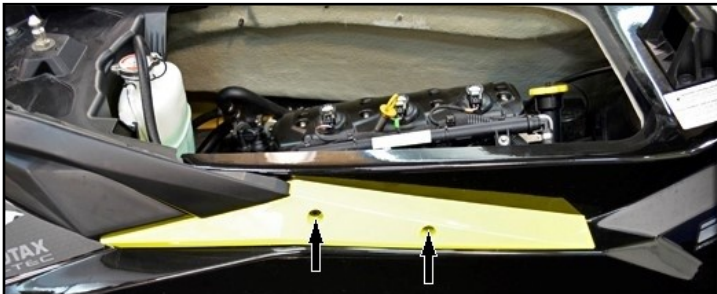
## **- INSTALLATION INSTRUCTIONS -**

Remove seat.

### **RXP-X:**

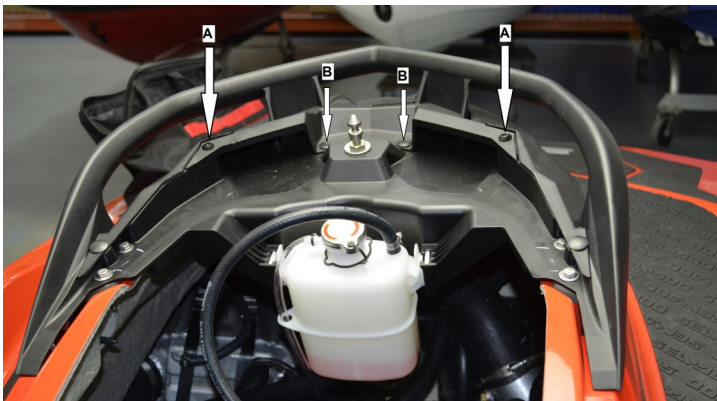
Remove the two bolts on each side holding the side panels in place and remove the side panels. (Figure 1)

Figure 1



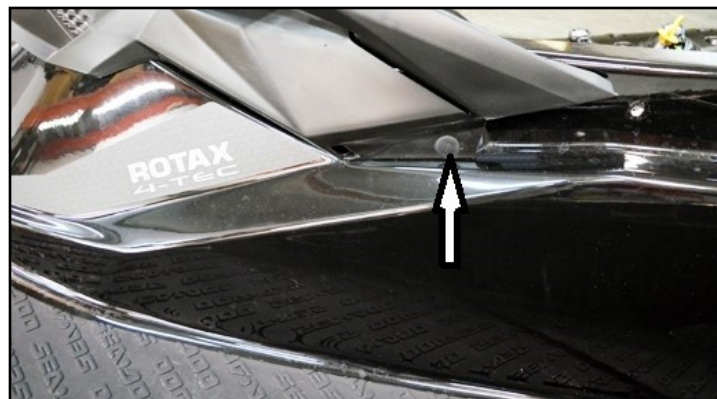
Remove 2 screws (A) and 2 plastic rivets (B) holding vent cover to rear grab handle and remove vent cover (Figure 2).

Figure 2



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

Figure 3

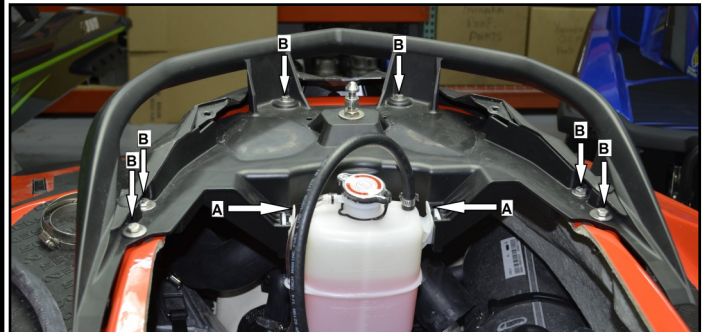


Press the (2) locking tabs (A) on the coolant reservoir towards the reservoir body and lift the reservoir out of its mounting location. Lay the reservoir to the starboard side to provide better access to the exhaust.

Remove (6) bolts (B), nuts and washers holding rear grab

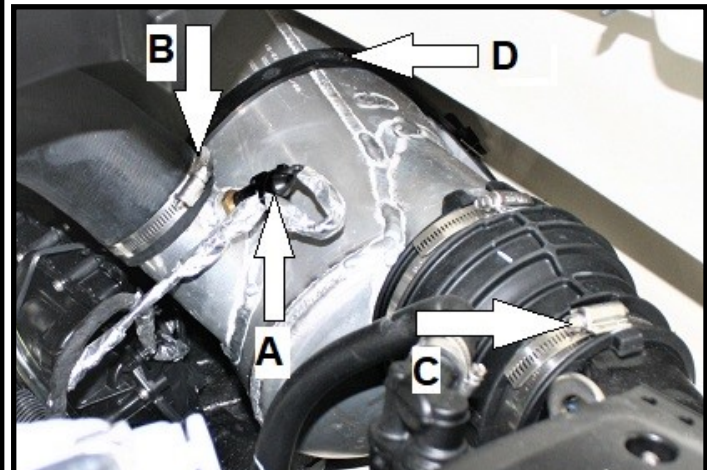
rail in place and remove grab rail. Caution: Do not drop nuts and washers into hull. (Figure 4)

Figure 4



Disconnect exhaust temperature sensor (A). Loosen clamp (B). Remove Exhaust outlet hose from Waterbox. Loosen clamp (C), at exhaust manifold outlet. Retain clamp. Remove hold down strap (D). (Figure 5)

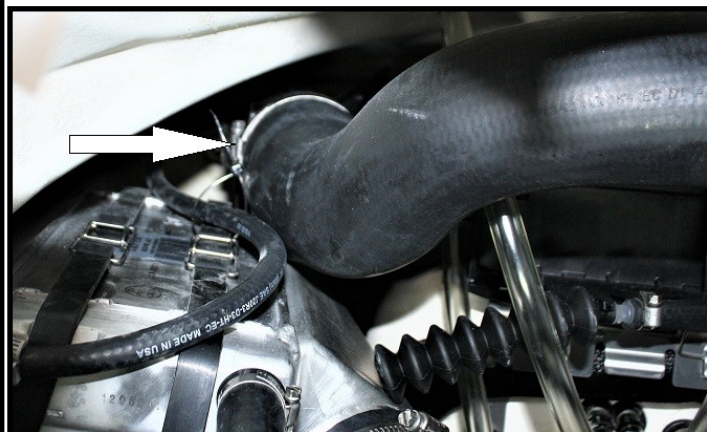
Figure 5



Remove waterbox assembly from hull.

Loosen front exhaust hose to resonator clamp.(Figure 6)  
Remove front exhaust hose from hull. Retain clamp.

Figure 6

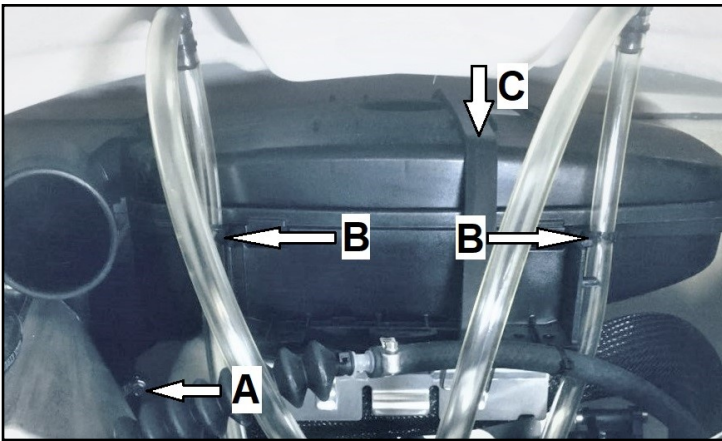




## - INSTALLATION INSTRUCTIONS -

Loosen clamp holding resonator to molded outlet hose (A). Cut (2) zip ties (B) securing siphon bilge hoses to resonator. Remove rubber resonator strap (C). (Figure 7)

Figure 7

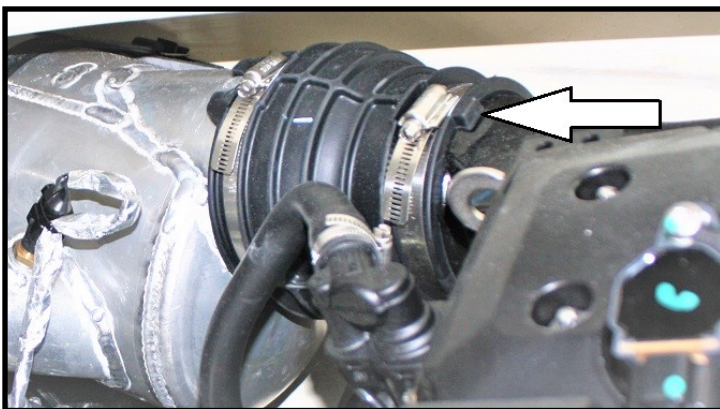


While twisting side to side pull resonator up and out of molded outlet hose. Remove resonator from craft and discard. Retain hose clamp for use during reassembly.

Reinstall waterbox reversing removal procedure. **Do not tighten clamp and do not install strap yet. Note: Spray coupler and exhaust manifold with foaming glass cleaner to ease installation**

**Note: Alignment tab on coupler must fit between bosses on exhaust manifold.** (Figure 9)

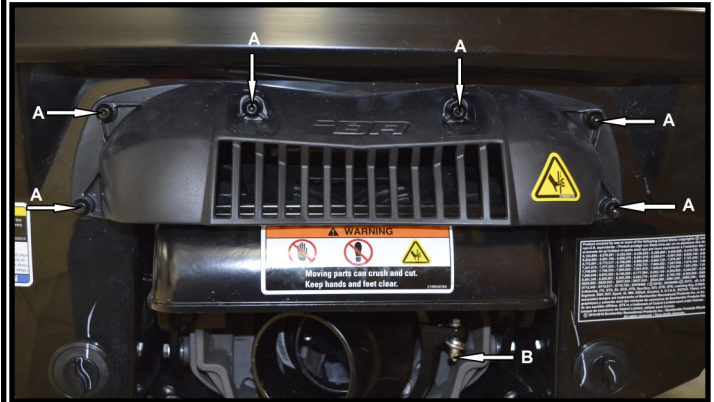
Figure 9



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 10)

Remove the nut and bolt (B) holding the steering cable to the steering nozzle. Set aside for reinstallation later. (Figure 10)

Figure 10



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 DESS key.

**NOTE: Do not start the engine. The DESS key 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 11)

Figure 11



## - INSTALLATION INSTRUCTIONS -

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 12 and 13)

Figure 12

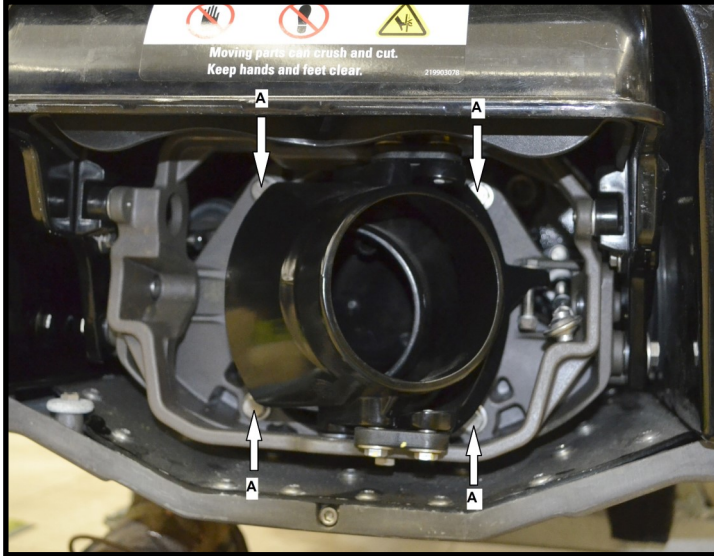


Figure 13



With a strap wrench grasp the nut on the exhaust through hull fitting and unscrew it. Set aside the nut for reuse later. (Figure 14) (Jet Pump removed for clarity.)

Figure 14



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 15)



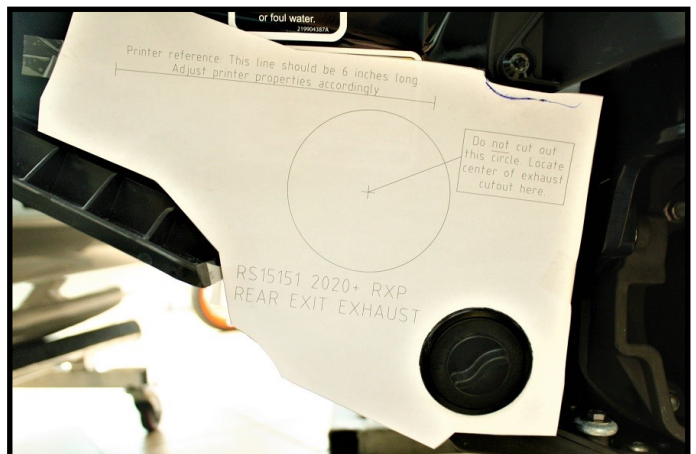
Figure 15

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 16)

Figure 16



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



## **- INSTALLATION INSTRUCTIONS -**

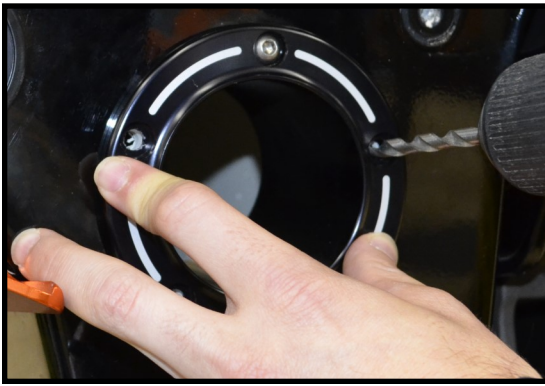
over the supplied exhaust outlet tube and press it into place against the flange taking care to assure that the bolt holes in the gasket and flange are properly aligned.

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 17) 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 17



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.**

Lube inside of supplied silicone couplers and outside of supplied exhaust tube with glass cleaner and install couplers onto tube. Clamp couplers onto tube using clamps saved during disassembly. (Figure 18)

Figure 18



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.

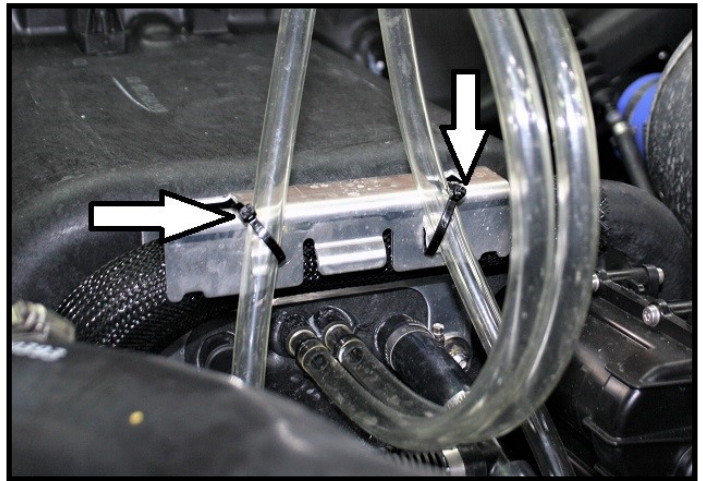
Lube the inside of the transom end coupler with glass

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 fasten the siphon bilge hoses to the resonator bracket. (Figure 19)

Figure 19



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

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

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

Reconnect waterbox overheat sensor.

Reassemble iBR gate and steering, in reverse order of disassembly. **Note: Use Blue Loctite 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 Loctite 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: This line should be 6 inches long.  
Adjust printer properties accordingly

RS15151 2020+ RXP  
REAR EXIT EXHAUST

Do not cut out  
this circle. Locate  
center of exhaust  
cutout here.

Cut out this circle.  
Place over bilge  
drain fitting.