



**Sea-Doo 2020+ GTR, GTI 130/170 and Wake 170 Rear Exhaust Kit**

RS15180-1



**Applications:** 2020+ Sea-Doo GTR, GTI 130/170 and Wake 170

**Approximate Installation Time:** 6 Hr. (Including removal and re-installation of top deck.)

**Recommended Specialty Tools:**

None

**Part #**

**Required Materials:**

Blue Loctite

**Part #**

N/A

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Prior to installation, go to the RIVA Racing online Instruction Library to download the latest version of these instructions:

<https://rivaracing.com/instructions>



**Sea-Doo 2020+ GTR, GTI 130/170 and Wake 170 Rear Exhaust Kit**

*RS15180-1*

**COMPONENT LIST**

Item	Description	Part Number	Qty.	Comments
A	Exhaust Tube	W1-RS15120-T	1	
B	Exhaust Outlet	QCA-RS15120-1	1	
C	Cover Plate		1	
D	Coupler 3" x 3"	RS15-03/03	2	
E	Block-off	QCA-RS15180-PLUG	1	
F	Hose Clamp, #48	63004-0048-052	2	
G	Outlet Gasket		1	Thick
H	Outlet Cover Gasket		1	Thin
I	Bolt, 6MM X 25MM, BHCS	.6C25SBCS	6	
J	Zip Tie, Small	TY23MX	1	
K	Zip Tie, Large	TY25MX	1	

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 \*\*\***

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

## **- INSTALLATION INSTRUCTIONS -**

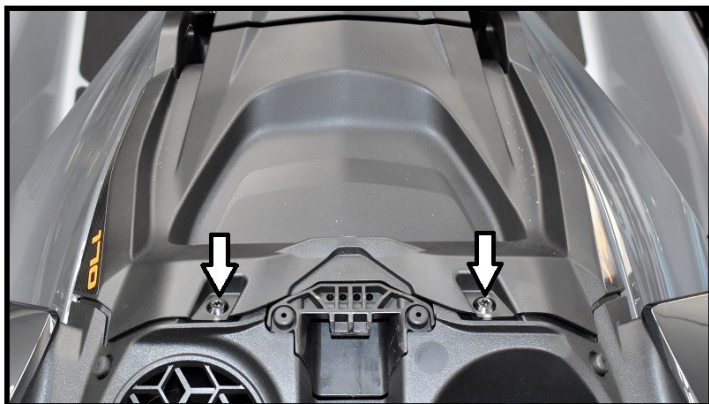
### **Part 1. Separating top deck from hull**

While it is possible to install this rear exit exhaust kit in the conventional manner by reaching into the engine compartment through the top opening, RIVA recommends separating the top deck from the hull to facilitate access.

Remove seats.

Open front storage compartment and remove screws (2) retaining gauge panel. (Figure 1)

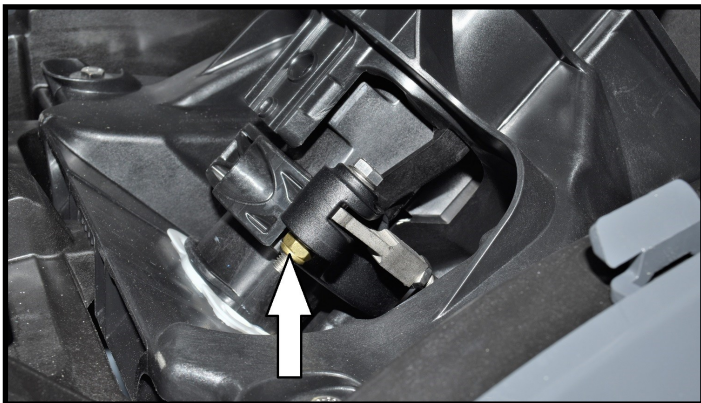
Figure 1



Pull gauge panel up to remove from craft.

Remove steering cable bolt and nut to disconnect steering cable. (Figure 2)

Figure 2



Remove screw securing left side lateral trim panel. (Figure 3)

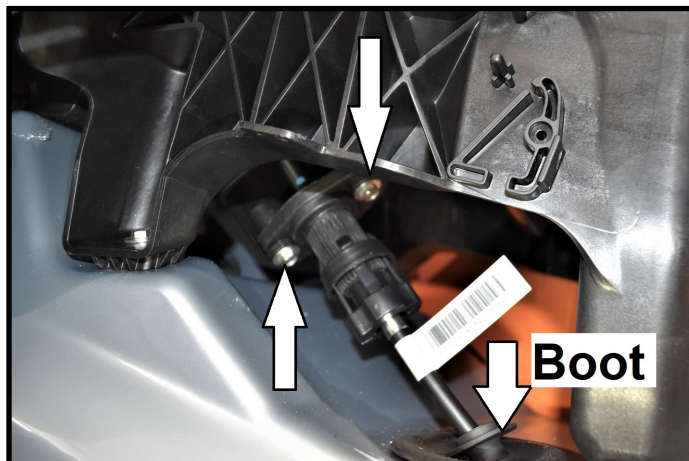
Figure 3



Pull trim panel straight back to remove from craft.

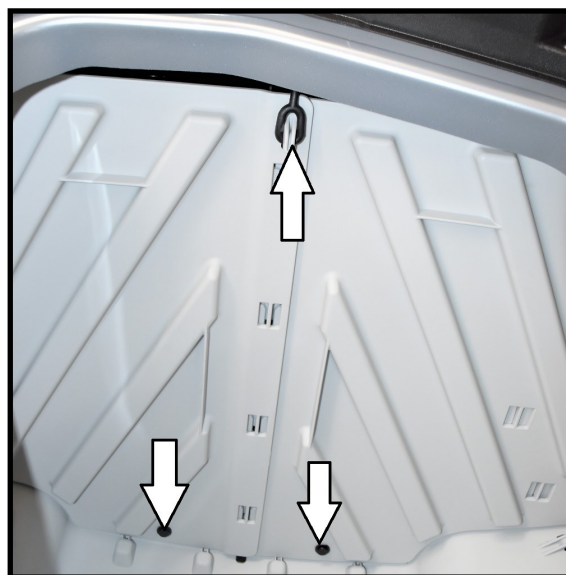
Remove bolts (2) securing steering cable adjuster to body. Push rubber boot down cable and free of body panel. (Figure 4)

Figure 4



Inside front storage compartment remove plastic rivets (2) and disconnect elastic cord. (Figure 5)

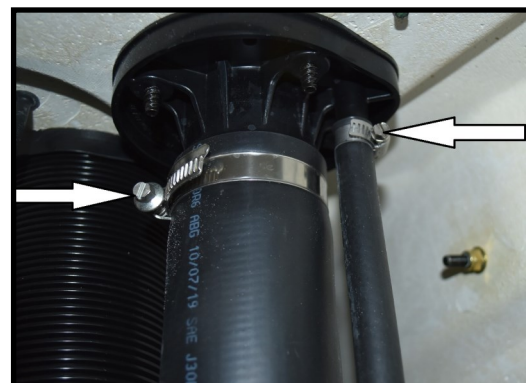
Figure 5



Separate bulkhead halves and remove from storage compartment.

Loosen hose clamps on fuel filler and vent hose. (Figure 6)

Figure 6



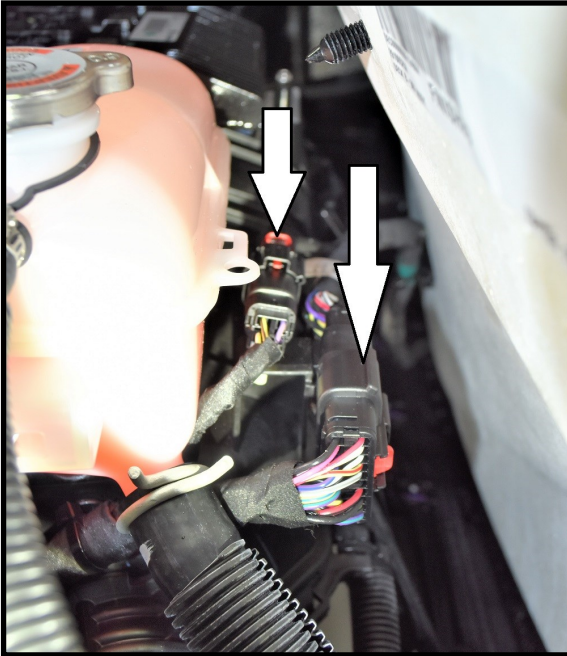


## **- INSTALLATION INSTRUCTIONS -**

Remove fuel filler hose from fitting and cover with a clean shop rag. Remove vent line from fitting. Save clamps for re-installation.

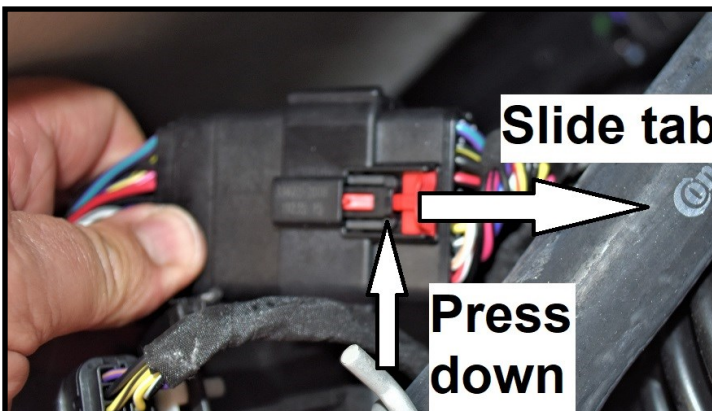
Inside engine compartment on right side of coolant reservoir locate two steering harness connectors. (Figure 11)

Figure 11



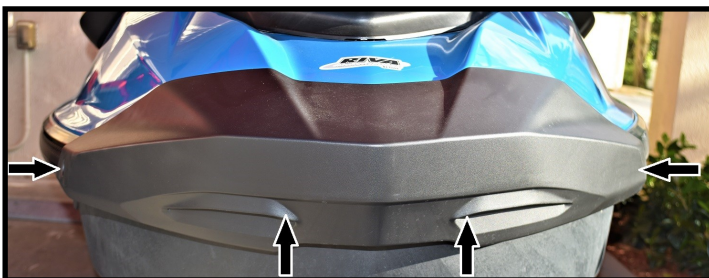
Slide the connectors off the holder. Slide the red tab all the way out. Press down on lock tab while pulling connector apart. (Figure 12)

Figure 12



Remove front bumper screws (4). (Figure 13)

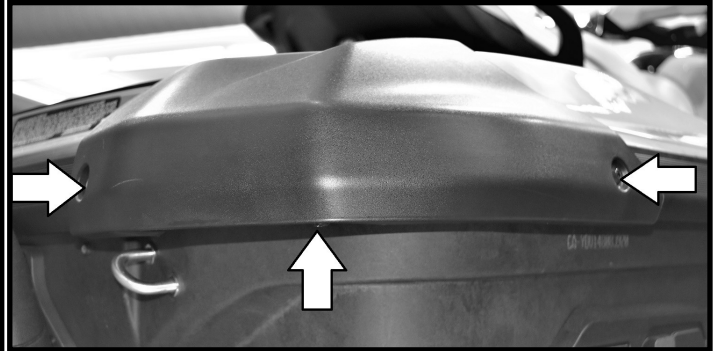
Figure 13



Remove front bumper.

Remove screws in both rear corner bumper covers. (3 per side.) (Figure 14)

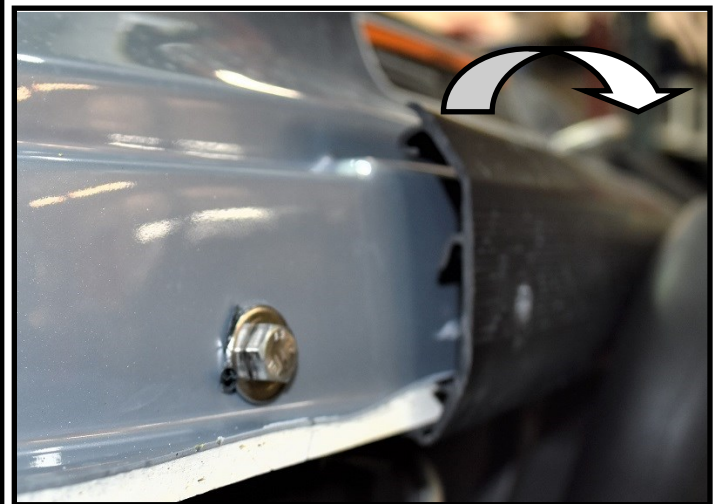
Figure 14



Remove both rear corner bumper covers.

Grasp rear bumper and pull top edge out while rotating downward to remove bumper. (Figure 15)

Figure 15



Before removing side bumpers mark where one end of each bumper lies on body. This will make it easier to position the bumper correctly when installing. (Figure 16)

Figure 16



As with rear bumper, pull top of side bumpers out and down to remove from craft.

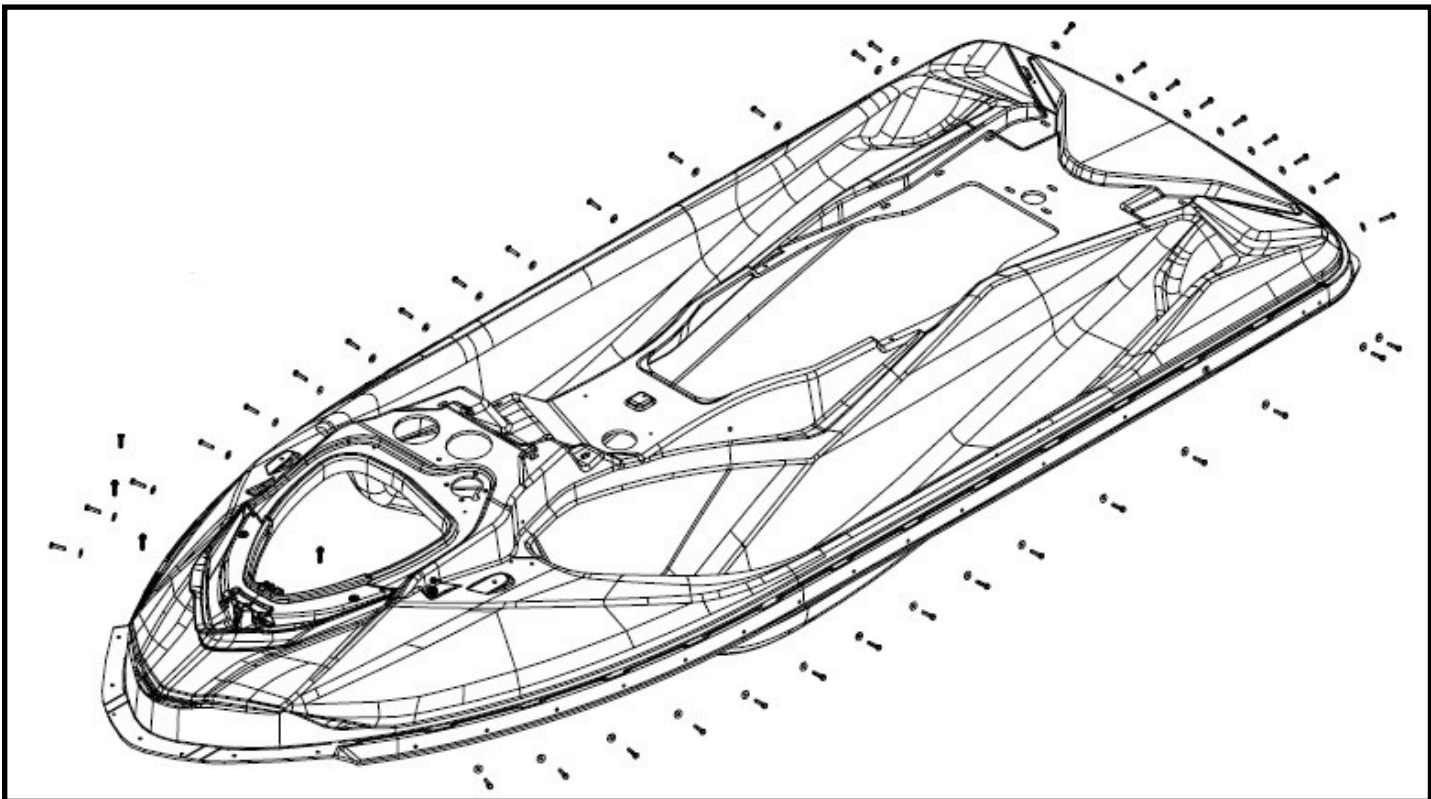
Place bumpers, corner bumper covers and screws aside for re-installation later.



## **- INSTALLATION INSTRUCTIONS -**

Remove bolts (40) around the perimeter of the hull and body. (Figure 17)

Figure 17



With assistance, remove top deck by lifting straight up from hull. Guide steering cable through cable access hole in top deck. Set top deck aside.

### **Part 2 Installation of Rear Exhaust**

Figure 18

Cut zip-ties (2) (Z, Figure 18) securing siphon bilge hoses to resonator.

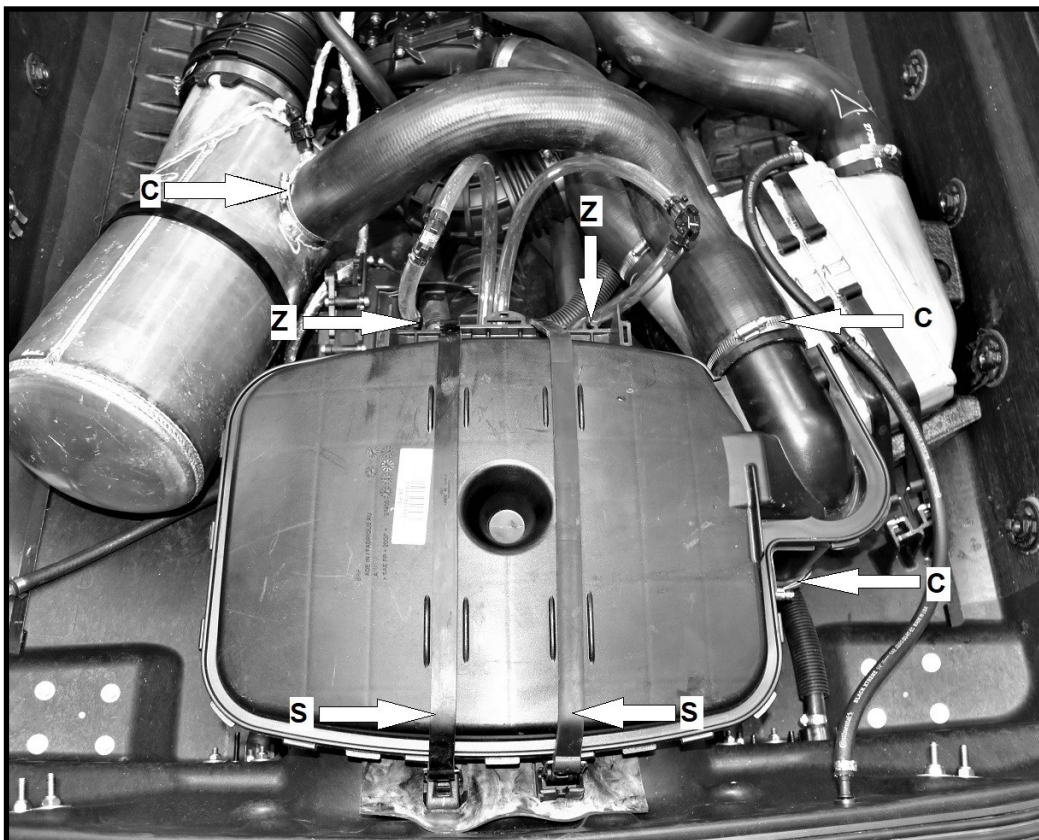
Loosen clamps (3) (C, Figure 18) holding exhaust hose to water-box and resonator and resonator to outlet hose.

Remove exhaust hose from water-box and resonator. Set clamps aside for re-use.

Remove rubber straps (2) (S, Figure 18)

Pull resonator up and out of outlet hose.

Remove rubber pad under resonator.



## **- INSTALLATION INSTRUCTIONS -**

Insert supplied block-off plug into outlet hose. **Hint: Use foaming glass cleaner to lubricate couplers and fittings to ease assembly**

Secure block-off into outlet hose with OEM clamp. (Figure 19) **Note: Do not over-tighten clamp.**

Figure 19



Cut out supplied paper template according to the instructions on the template. (Page 9)

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 20)

Figure 20



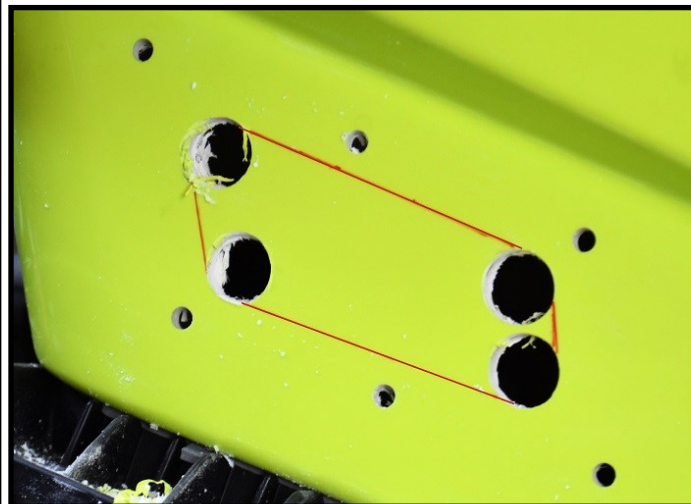
With a 1/8" drill bit mark the centers of the bolt holes (6) and the corner radii (4). With a 17/64" bit drill holes through the hull at the bolt locations (6) marked on the template. Remove template from hull. Place supplied cover plate on hull and insert bolts through cover plate and hull. Mark around inside opening of cover plate with a sharp pointed marker. (Figure 21)

Figure 21



Remove cover plate. Using a 3/4" holesaw cut through hull at corner radii (4) previously marked with 1/8" drill bit. (Figure 22)

Figure 22



Cut between holes with a body saw, roto zip or other tool. Stay inside lines. Switch to coarse sanding drum, file or surform tool to cut to final shape and size. Insert exhaust outlet from inside of hull to verify opening size and alignment with bolt holes.

One thick and one thin gasket are supplied with this kit. Both are the same shape. The thick self-adhesive gasket goes on the exhaust outlet on the inside of the hull. The thin gasket without adhesive goes on the cover plate on the outside of the hull. (Figure 23, next page)



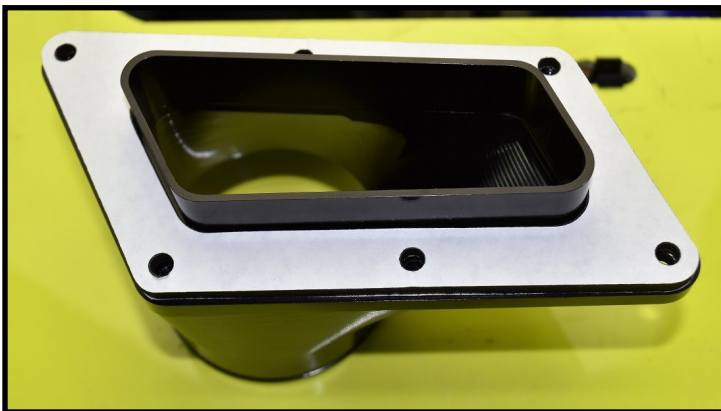
## - INSTALLATION INSTRUCTIONS -

Figure 23



Remove protective cover from one side of supplied self adhesive gasket and install onto supplied exhaust outlet as shown. (Figure 24) **Note: Do not apply sealer to gasket.**

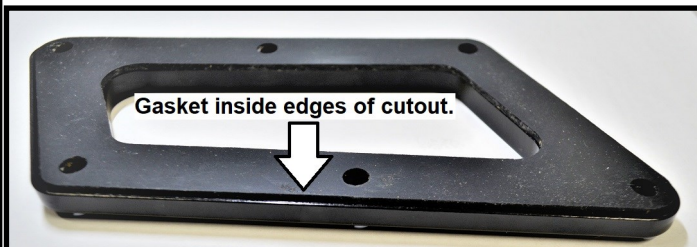
Figure 24



Remove second protective paper cover from outlet gasket. Insert outlet into hull and align with opening. **Note: Do not apply sealer to gasket.**

Install one supplied thin gasket (see figure 32, page 13) into cutout area on back of each supplied outlet cover. (Figure 25) **Note: Do not apply sealer to gaskets or covers.**

Figure 25



Install cover plate with supplied 6mm BHCS(6). Tighten screws evenly around cover plate. **Apply Blue Loctite to screw threads. Do not over-tighten screws as this could squeeze gasket out of place. Do not apply sealer to gasket.** (Figure 26)

Figure 26



Install supplied silicone couplers (2) onto each end of supplied exhaust tube. (Figure 27) **Hint: Use foaming glass cleaner to lubricate couplers and fittings to ease assembly.**

Slip hose clamps (4) (2 removed from OEM exhaust hose and 2 supplied with kit) loosely over couplers. **Note: Do not tighten clamps at this time.**

Figure 27



Install assembled tube with couplers and clamps onto exhaust outlet and waterbox outlet. (Figure 28, next page) **Hint: Use foaming glass cleaner to lubricate couplers and fittings to ease assembly.**

## - INSTALLATION INSTRUCTIONS -

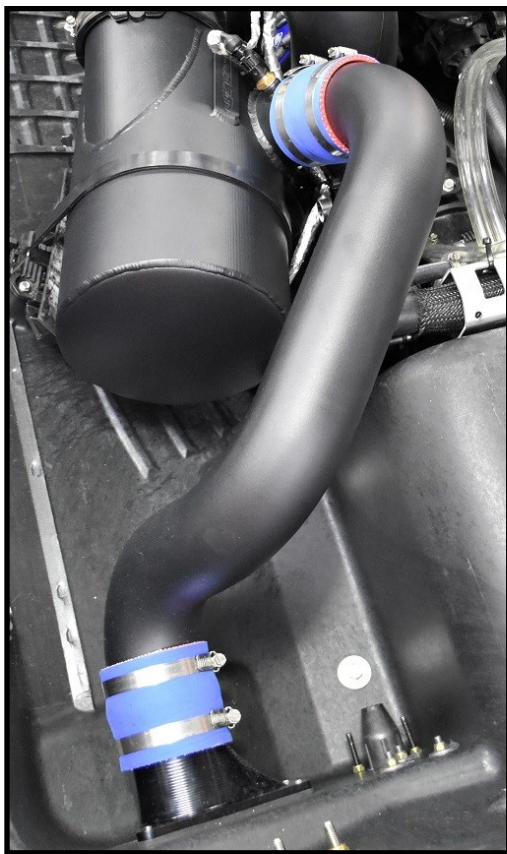


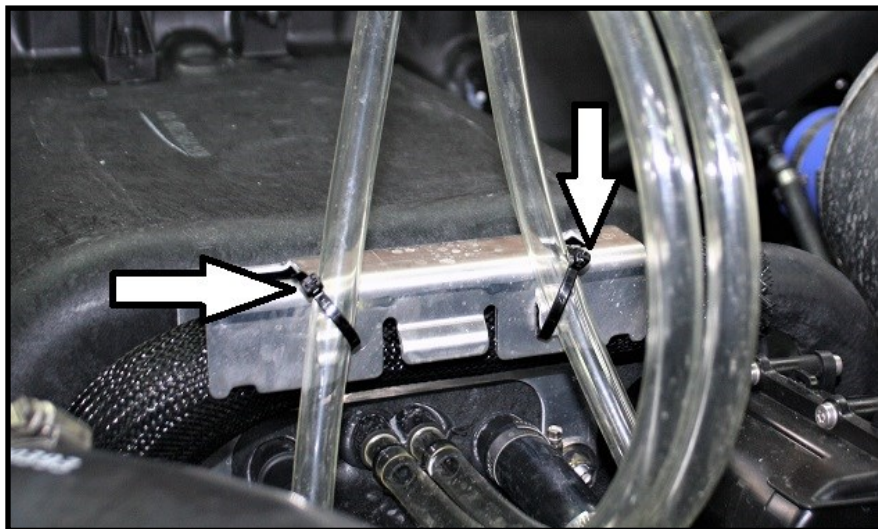
Figure 28

Position clamps over couplers onto waterbox, tube and outlet. Tighten.

**Note: Do not over-tighten clamps.**

Using supplied zip ties secure siphon bilge tubes to resonator bracket in up-right position.

(Figure 29)



### Part 3 Re-installation of top deck

Check bilge for tools, rags, etc.

Re-install upper deck, steering, electrical connections and bodywork, reversing disassembly procedure, using previously removed OEM hardware. **Note: Verify hull seal is in place before installation of top deck.**

Install and tighten top deck to hull with OEM hardware beginning at the rear then moving from rear to front in a criss-cross pattern. Lastly, install fasteners at bow. (Figures 30-32) Torque fasteners to 5-1/2 ft.lb. (7.5 Nm)

Figure 30

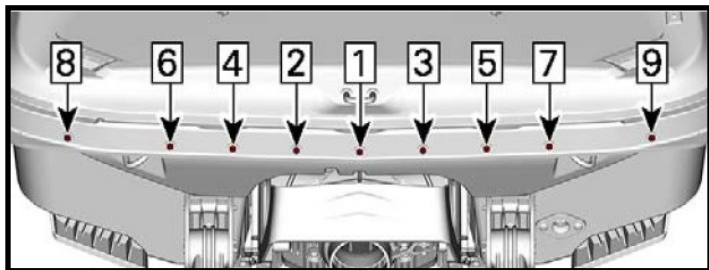


Figure 31

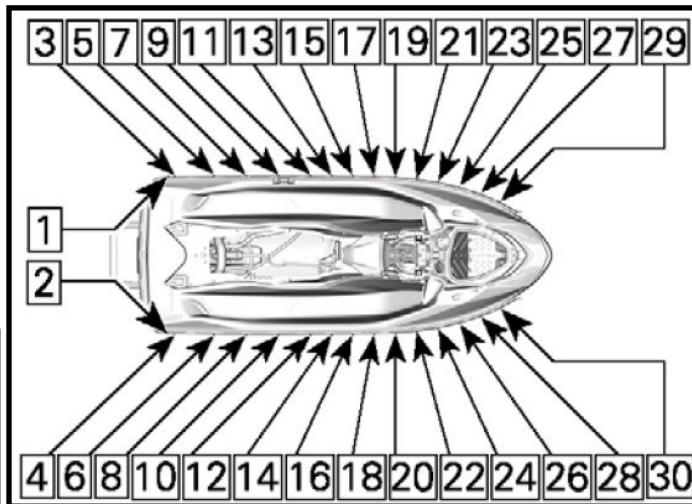
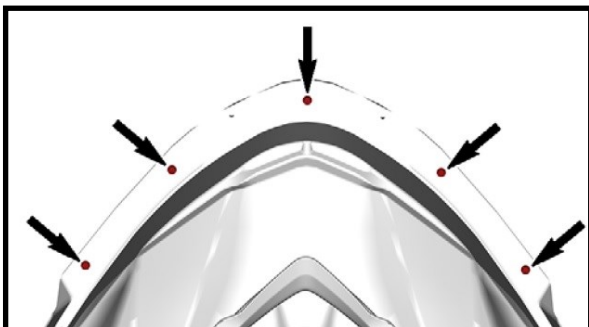


Figure 32





## **- INSTALLATION INSTRUCTIONS -**

Re-install bumpers with OEM hardware reversing removal procedure. Use alignment marks previously made to locate side bumpers. Install side bumpers first followed by rear and front bumpers.

Run craft on a flush kit to check for proper operation.

***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 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.

4" REFERENCE LINE

Bolt Holes (6) to Secure Outlet in Place  
Drill out to 17/64" I.D. final size.

**CORNER RADIUS (4)**  
Mark centers with 1/8" drill bit first.  
Then, drill with 3/4" hole saw bit.  
Finish with body saw, roto zip  
or other cutting tool.

Bolt Holes (6) to Secure Outlet in Place  
Drill out to 17/64" I.D. final size.

ALIGN THIS EDGE WITH BOARDING STEP BRACKET

## 2020+ Sea-Doo GTR/GTI Rear Exhaust Outlet Template

**DO NOT USE FOR 2018 & NEWER RXT/GTX (ST3)**