



RIVA RACING

PERFORMANCE PRODUCTS & ACCESSORIES

Free Flow Exhaust Kit

PART# - RS16080

APPLICATION(S): Sea-Doo RXP-X & RXT-X (255hp)

Required tools (RXP-X ONLY)

VTS Socket Tool

Part#

295000133

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

- INSTALLATION INSTRUCTIONS -

1. Remove seat(s). Remove engine coolant tank from mounting location.
2. **RXP-X:** Remove engine cowling (5 bolts total). (see illustration #1)
RXT-X: Remove top half of deck beam (4 bolts total). (see illustration #2) Remove bottom half of deck beam. (see illustration #3)
3. Remove exhaust hose connecting water box (muffler) to exhaust baffle.
RXT-X see illustration #4.
RXP-X: see illustration #5. Remove intercooler outlet hose first to access exhaust baffle. (see illustration #6)
4. Remove hoses between intercooler and engine (2). **NOTE: Mark hoses to identify location and direction.**
RXT-X see illustration #4
RXP-X: see illustration #5.
5. Place clean rags in openings left when hoses were removed.
6. At air intake tube located under intake manifold loosen clamps at both ends and disconnect hoses. (see illustration #7 & 8)
7. Slide tube forward. **RXT-X ONLY:** Gently lift upward on tube to remove the two plastic grommets securing tube to hull.
8. At supercharger move end of air tube connected to inlet out of way (towards water box). (see illustration #8)
9. **RXP-X ONLY (RXT-X Proceed to Step 7)**
 - a. At pump remove VTS rod, rubber boot sealing VTS motor shaft & nut securing VTS motor to hull. (see illustration #9)
 - b. Remove intercooler completely.
 - c. Remove intercooler bracket. (see illustration #10)
 - d. Remove VTS from thru-hull fitting and set aside.
10. **RXT-X ONLY (RXP-X Proceed to Step 11)** Loosen bolts securing throttle body to intake manifold. (see illustration #8) Remove throttle body and place on top of intake manifold assembly.
11. Loosen clamp securing exhaust baffle to exhaust outlet hose. Remove bolt securing exhaust baffle to hull. (see illustration #11) Remove and discard exhaust baffle.
12. **RXT-X ONLY (RXP-X Proceed to Step 13)** Replace throttle body. **NOTE: Apply blue Loc-tite to bolts. Do not over tighten. Make sure throttle body lubrication hose is connected to throttle body.**
13. Thoroughly clean exhaust outlet hose using a non-residual cleaner. Apply a liberal amount of glass cleaner to inside of exhaust outlet hose and onto straight end of supplied Free Flow Exhaust Tube. Insert straight end into exhaust outlet hose. **TIP:** You may need to use a small screwdriver to leverage tube into hose. Take care not to damage exhaust outlet hose or Free Flow Tube.
14. Place exhaust hose between water box and Free Flow Tube to check alignment of Free Flow Tube. Remove exhaust hose and tighten clamp securing Free Flow Tube to exhaust outlet hose. (see illustration #12) **NOTE: Do not over tighten clamp.**

15. Reconnect air intake tube located under intake manifold. **NOTE: Do not over tighten clamps.**
16. **RXP-X ONLY (RXT-X Proceed to Step 17)**
 - a. Replace intercooler bracket. (see illustration #10) **NOTE: Apply red Loc-tite to bolts. Do not over tighten bolts.**
 - b. Replace VTS into thru-hull fitting. **NOTE: Make sure VTS housing is secured to intercooler bracket at bottom.**
 - c. At pump secure VTS motor to hull. Replace and secure rubber boot sealing VTS motor shaft. Replace VTS rod. (see illustration #9) **NOTE: Apply blue Loc-tite to bolts. Do not over tighten bolts.**
 - d. Replace intercooler. Don't forget rubber pad! **NOTE: Do not over tighten clamps.**
17. Replace hoses between intercooler and engine (2). Secure using OE clamps. **NOTE: Be sure to remove rags from openings! Do not over tighten clamps.**
18. Replace exhaust hose connecting water box (muffler) to Free Flow Tube. Secure using OE clamps. **NOTE: Be sure to remove rags from openings! Do not over tighten clamps.**
19. Replace parts applicable to your craft that were removed during step #2. **NOTE: Apply blue Loc-tite to bolts. Do not over tighten bolts.**
20. Check bilge for tools, rags, etc. Start craft and run using flush kit to check for exhaust leaks at connecting points of Free Flow Exhaust Kit. Do not run craft out of water for more than two minutes at a time.

Remember, the water belongs to everyone. Please ride responsibly!

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.

Limited Warranty

RIVA Free Flow Exhaust Kits carry a one year 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.

- INSTALLATION IMAGES -

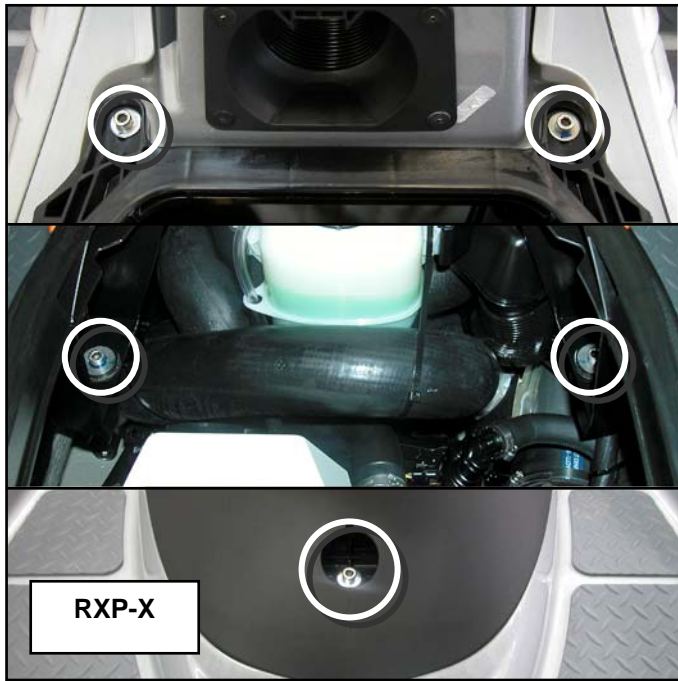


Illustration #1



Illustration #2

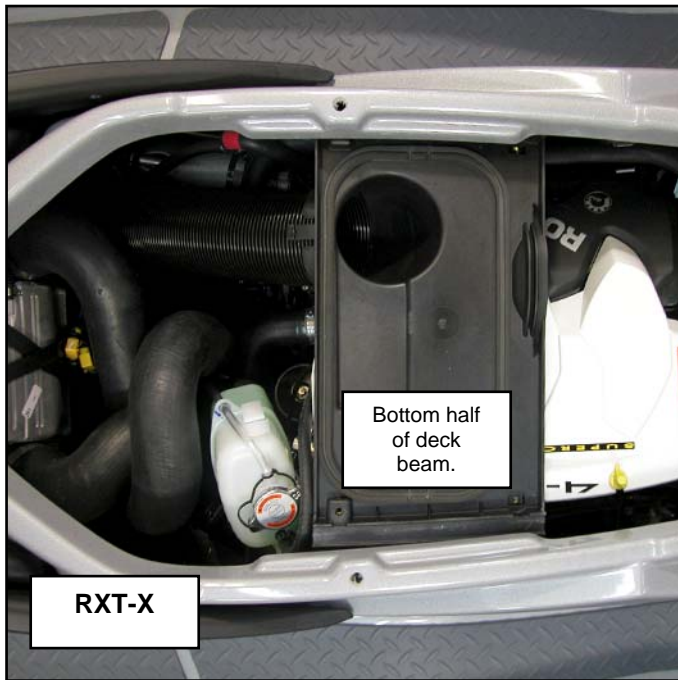


Illustration #3

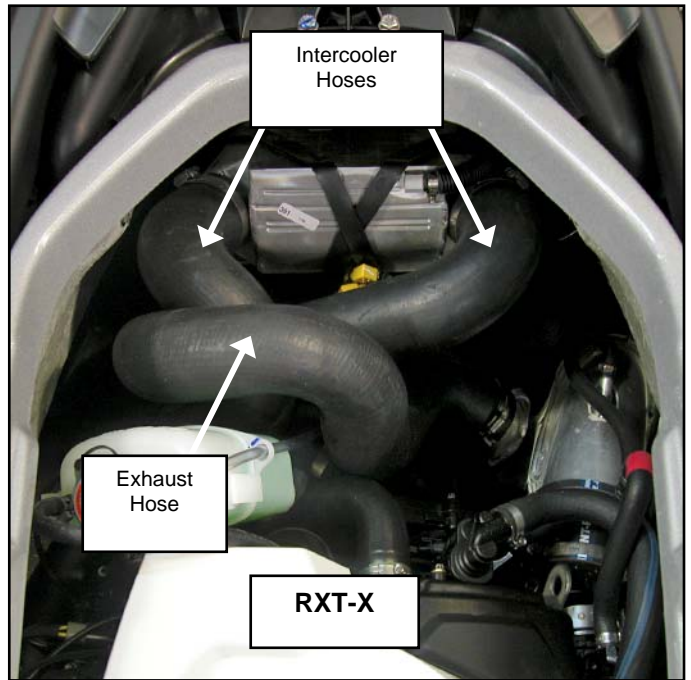


Illustration #4

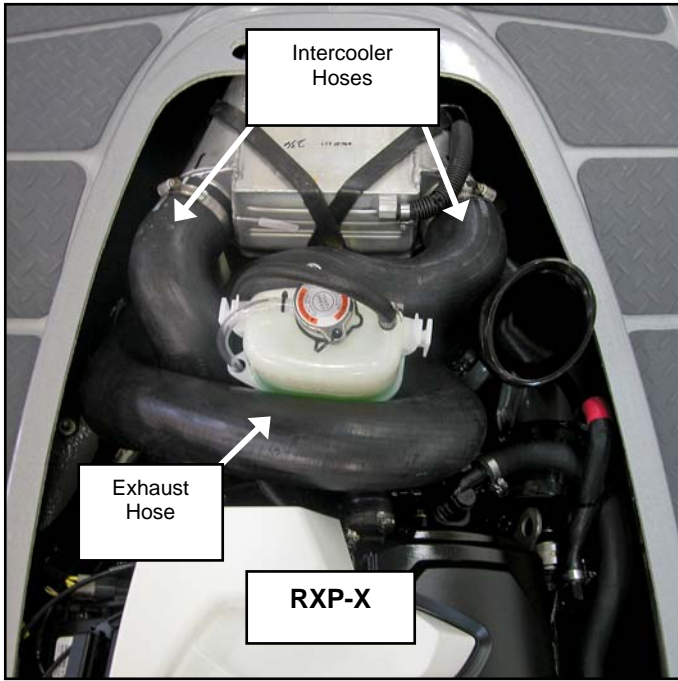


Illustration #5

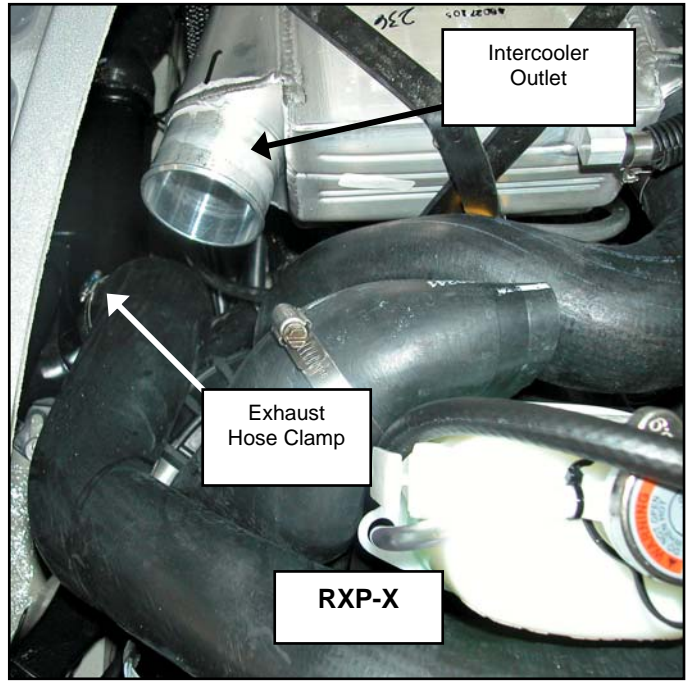


Illustration #6

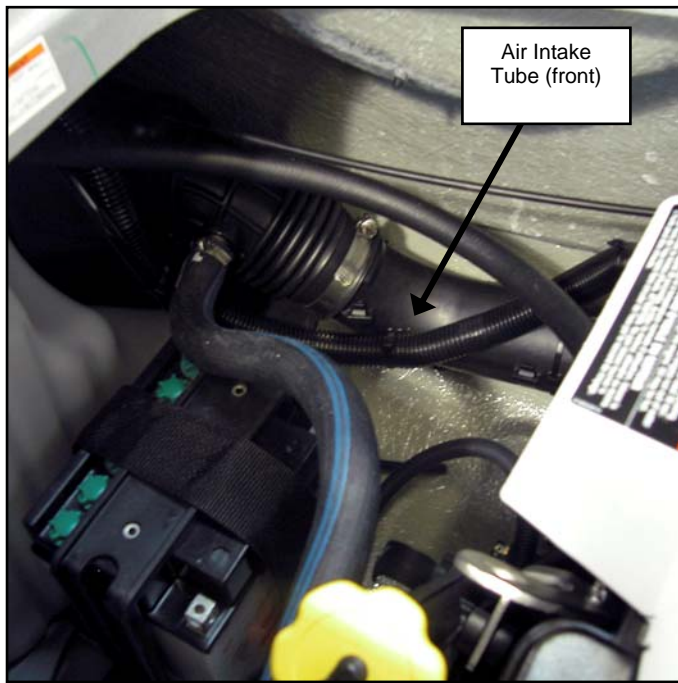


Illustration #7

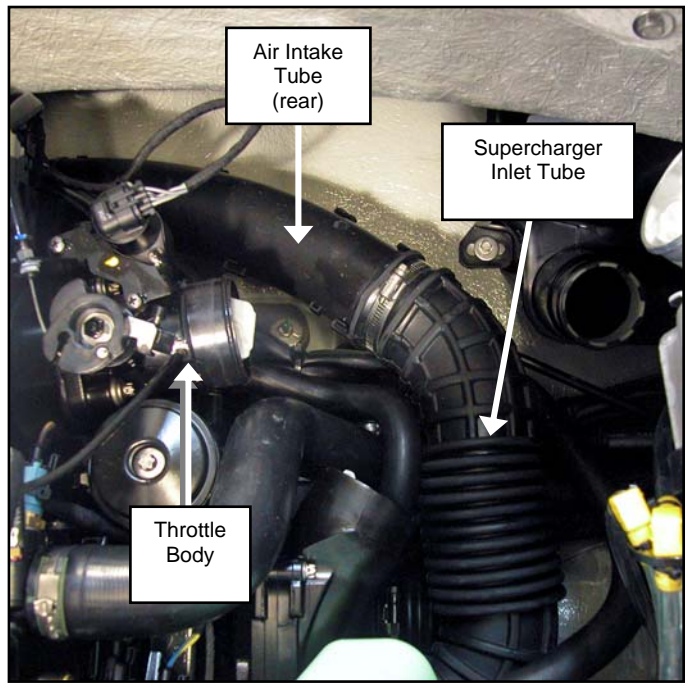


Illustration #8

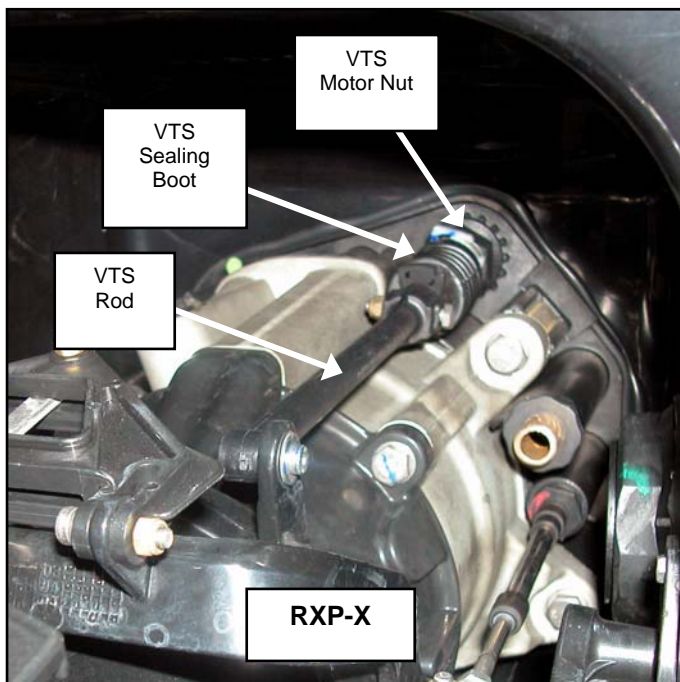


Illustration #9

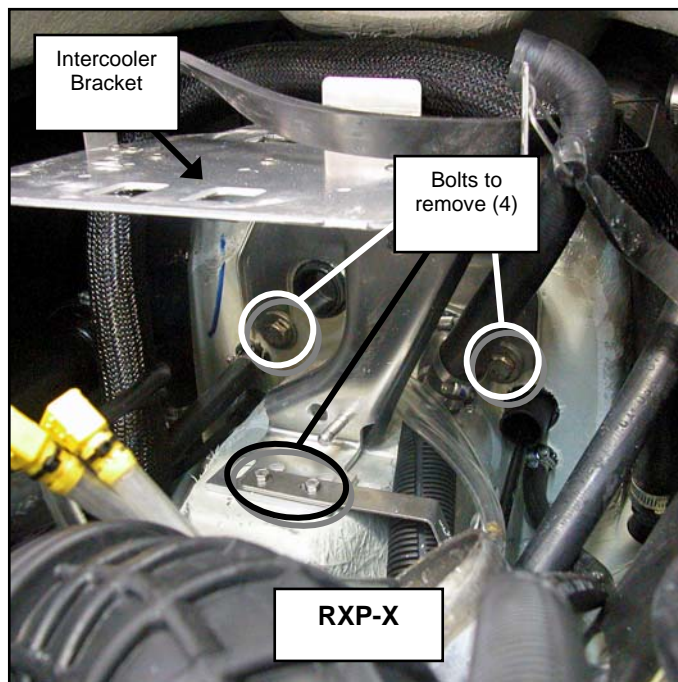


Illustration #10

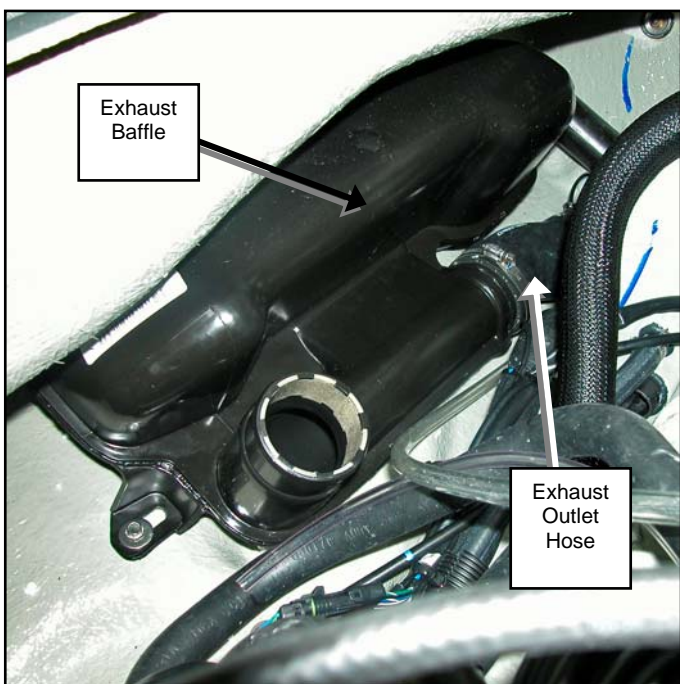


Illustration #11

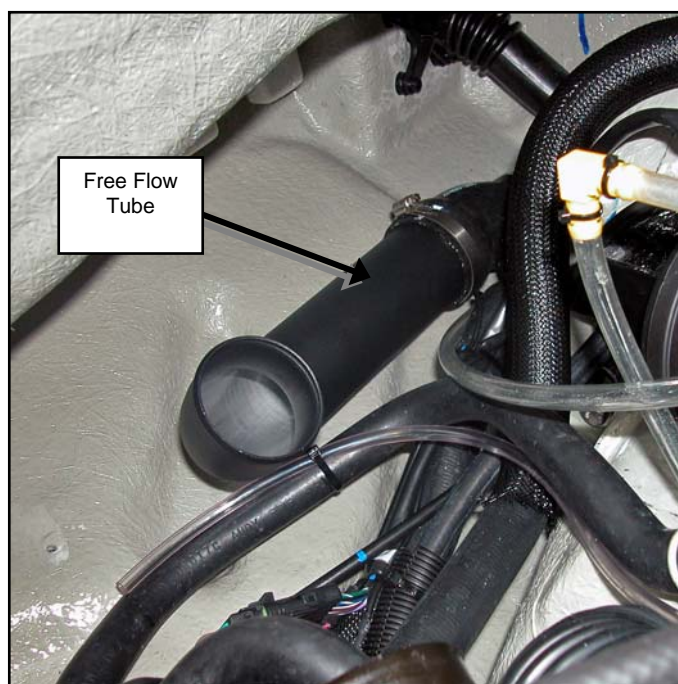


Illustration #12