



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

**SEA-DOO WATER BOX S3/T3/ST3**

PART# - RS16141



**Applications:** Sea•Doo Models 2016-2019 S3/T3 and ST3 HULL ,1503 or 1630 ENGINE

**Approximate Installation Time:** 1 hr.

**Recommended Specialty Tools:**

None

**Part #**

N/A

**Required Materials:**

Red 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

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

**COMPONENT LIST**

ITEM		QUANTITY	PART NUMBER	DESCRIPTION
A	<input type="checkbox"/>	1		WATER BOW WITH BRASS FITTING INSTALLED
B	<input type="checkbox"/>	1	TY25MX	ZIP TIE 7"

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 -**

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

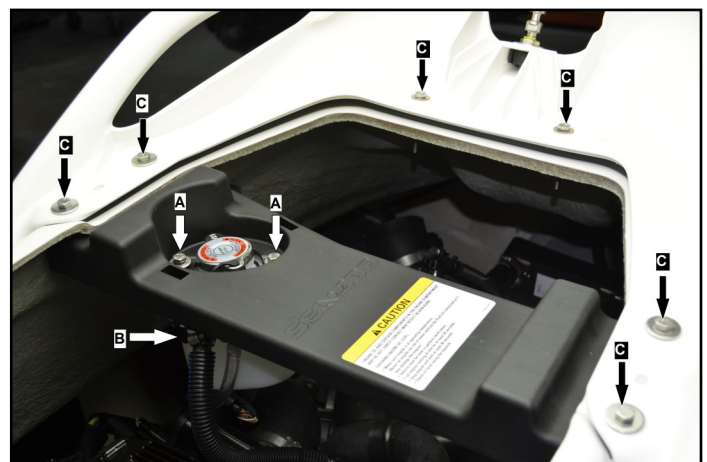


### **RXT-X/RXT/GTX-SC:**

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 5)

Figure 5



## - INSTALLATION INSTRUCTIONS -

### All models:

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

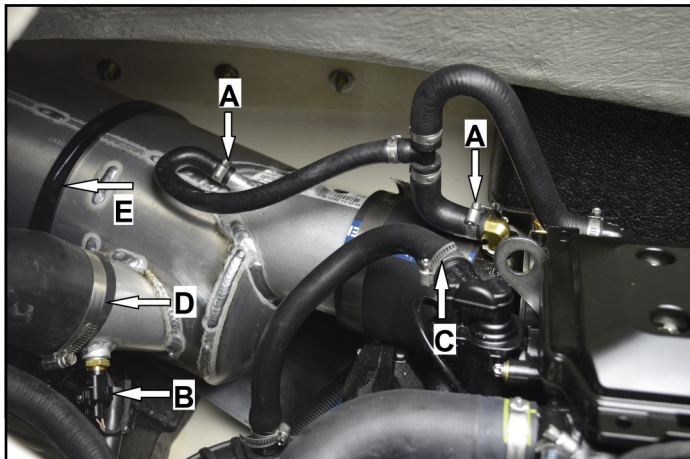
Disconnect water box overhear sensor (B).

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)

Secure cooling line to hull with supplied zip tie.

Figure 7

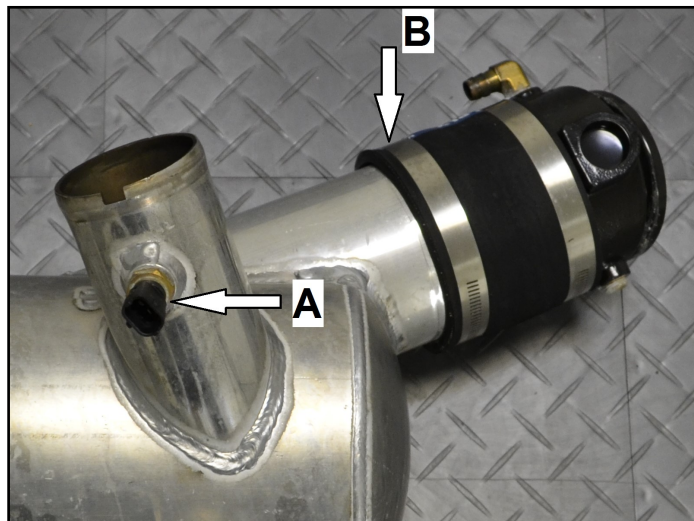


Remove water box assembly from hull.

Remove overhear sensor (A) from stock water box and install into RIVA Pro-Series Water Box. **NOTE: Apply red Loc-tite to threads. Do not over tighten.**

On stock water box loosen one clamp (B) on exhaust pipe coupler to allow coupler and exhaust pipe to be removed as one unit. (Figure 8)

Figure 8

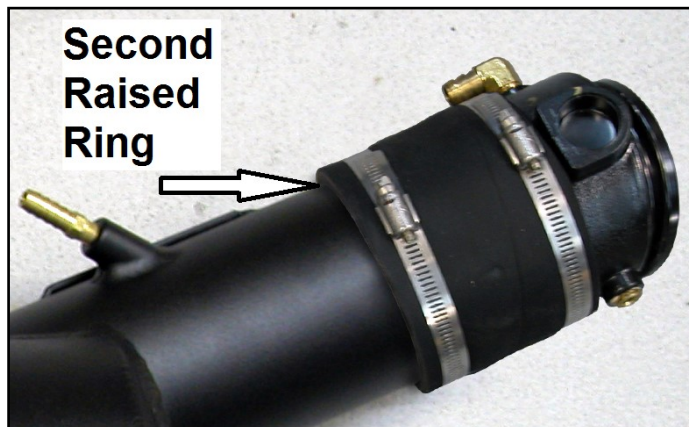


Thoroughly clean inside of coupler with a non-residual cleaner.

Liberaly coat outside of inlet tube on RIVA Pro-Series Water box with glass cleaner. Install exhaust pipe with coupler into water box inlet tube until end of coupler reaches second raised ring on water box. (Figure 9)

**NOTE: Do not tighten hose clamp yet.**

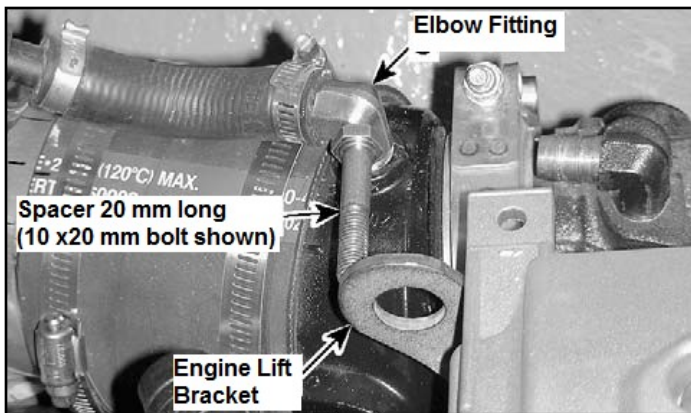
Figure 9



Insert water box assembly into hull.

Align exhaust pipe with exhaust manifold. Note measurements in instruction illustrations. Alignment is critical to prevent exhaust leaks. (Figure 10)

Figure 10



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 water box outlet 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 4). Replace engine breather hose at TOPS valve hose. **NOTE: Do not over tighten clamps.**

Replace parts applicable to your craft that were removed to access waterbox. **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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