



RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Sea-Doo 4-TEC 1630 2020+

Pro-Series Waterbox

RS16142



Applications: All Sea-Doo 4-TEC 1630 2020+ 130/170/230/300

Approximate Installation Time: 1 hr.

Recommended Specialty Tools:

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 *****

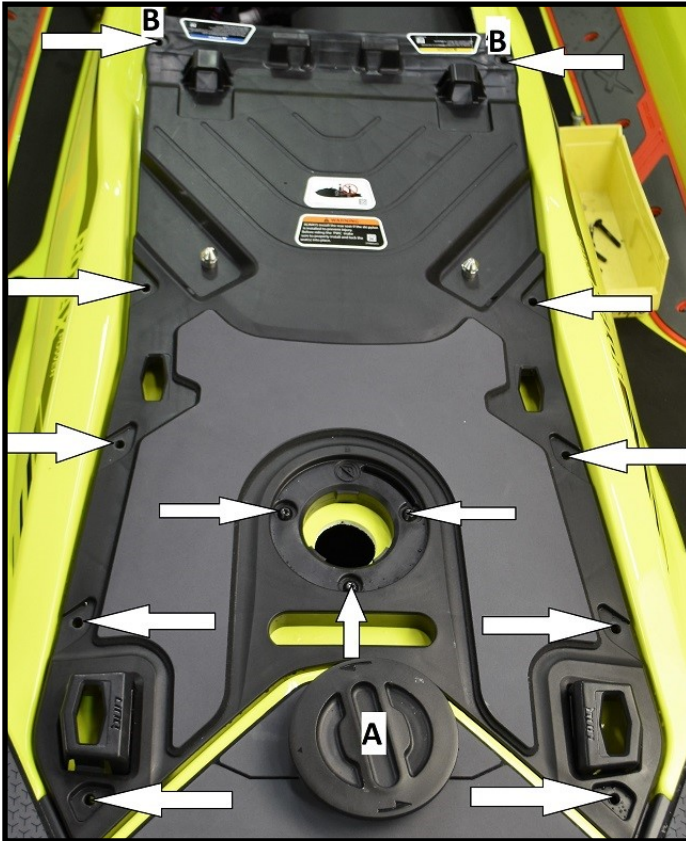


- INSTALLATION INSTRUCTIONS -

RXT/GTX/GTR/GTI

Remove seats. Remove access cap (A) and screws (13) at locations shown. **Note: Screws at location B go through the deck and are secured with nuts and washers underneath. Do not drop nuts and washers into hull.** Retain hardware for re-use. (Figure 1)

Figure 1

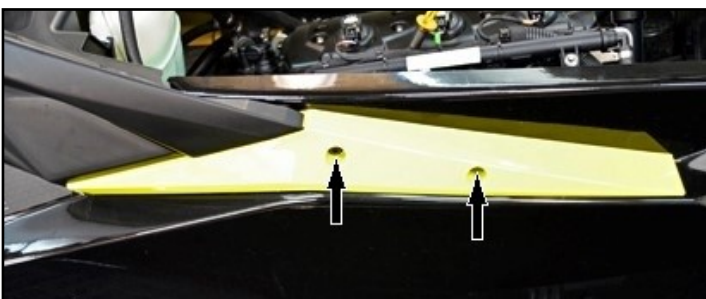


Remove engine compartment access cover. Remove plastic engine cover.

RXP-X

Remove seat. Remove the two bolts on each side holding the side panels in place and remove the side panels. (Figure 2)

Figure 2



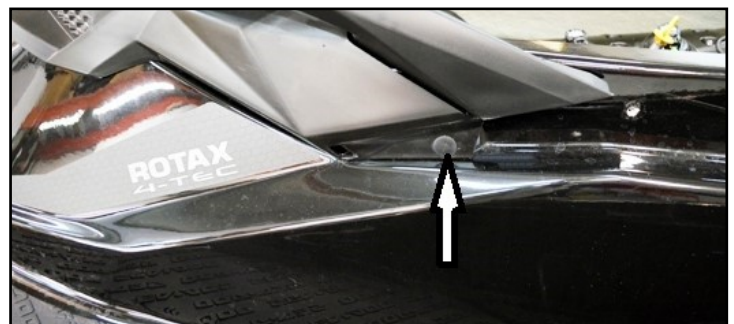
Remove 2 screws (A) and 2 plastic rivets (B) holding vent cover to rear grab handle and remove vent cover (Figure 3).

Figure 3



Remove 2 plastic rivets under side panels removed previously (Figure 4)

Figure 4



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 5)

Figure 5

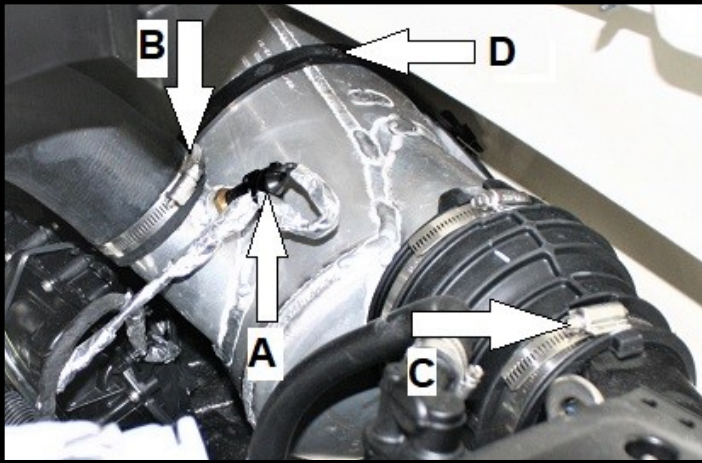


- INSTALLATION INSTRUCTIONS -

All Models

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 6)

Figure 6



Remove water box assembly from hull. Remove temp sensor and coupler from OEM waterbox and install on supplied RIVA waterbox. Align locator pin on supplied RIVA waterbox with notch in OEM coupler. (A in Figure 7)

Figure 7



Install waterbox with coupler into hull. Align front coupler tab on flat on exhaust manifold. (B in Figure 7)

Install front exhaust hose and clamp on waterbox outlet.
Tip: Lubricate hose and waterbox outlet with foaming glass cleaner to ease installation.

Install waterbox hold down strap. **Tip: Lubricate underside of strap and top of waterbox with foaming glass cleaner to ease installation.**

Tighten all exhaust hose clamps. **Do not overtighten clamps.** Reconnect temp sensor.

Replace parts previously removed to access exhaust.

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.

Limited Warranty

RIVA Pro-Series Waterboxes 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.