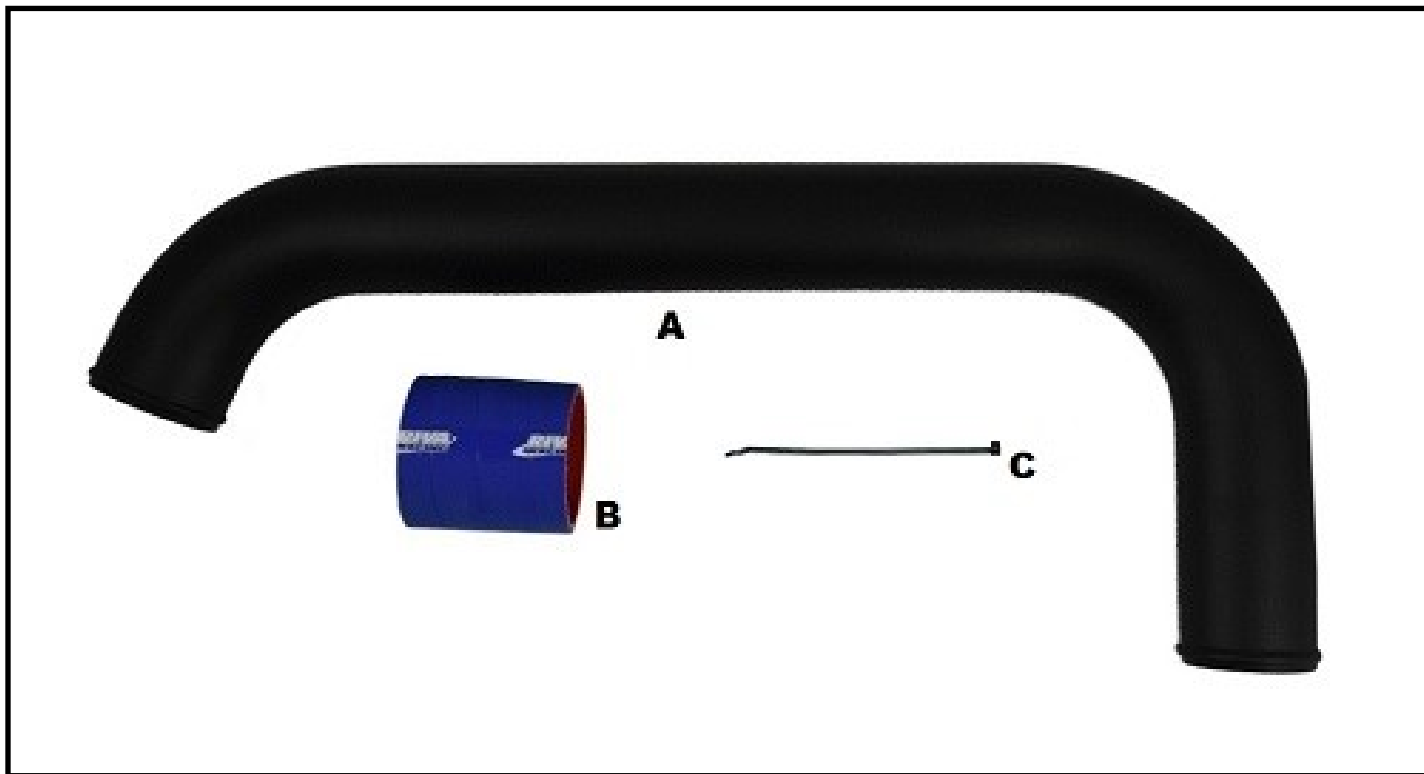




**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

## SEA-DOO 230 Free Flow Exhaust

PART# - RS16160



**Applications:** Sea•Doo 230 models GTR, GTR-X, Wake Pro 2017-19

**Approximate Installation Time:** 1.5 hr.

**Recommended Specialty Tools:**

N/A

**Part #**

**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 \*\*\***



**RIVA RACING**  
PERFORMANCE PRODUCTS & ACCESSORIES

**Sea-Doo Free Flow Exhaust GTR/GTR-X, Wake Pro 230 HP 2017-19**

**COMPONENT LIST**

ITEM		QUANTITY	PART NUMBER	DESCRIPTION
A	<input type="checkbox"/>	1		Aluminum tube
B	<input type="checkbox"/>	2	RS15-2.75/3.25	Silicone Coupler
C	<input type="checkbox"/>	1	TY26MX	11" Zip Tie

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 -**

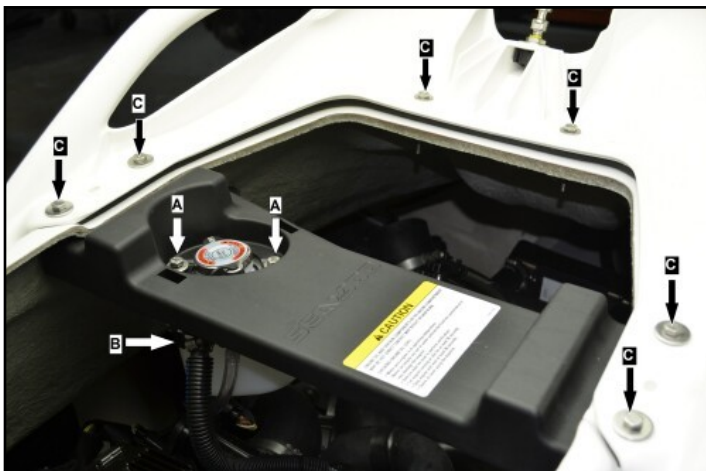
Remove or open seat.

### **Wake Pro 230:**

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 1)

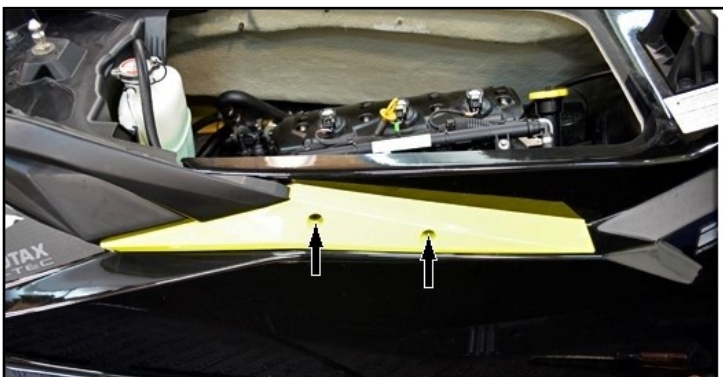
Figure 1



### **GTR/ GTR-X 230:**

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

Figure 2



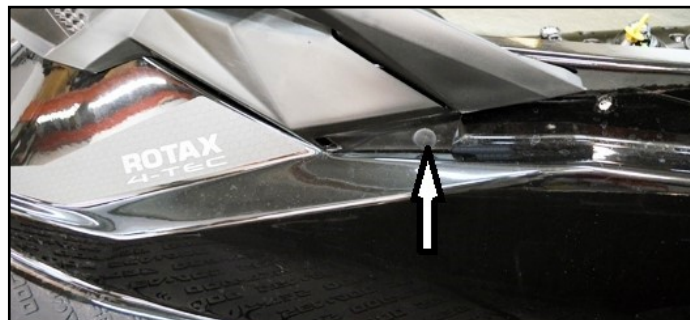
Remove 2 screws (A) and 2 plastic rivets (B) holding vent cover to rear grab handle and remove vent cover (Figure 3).

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

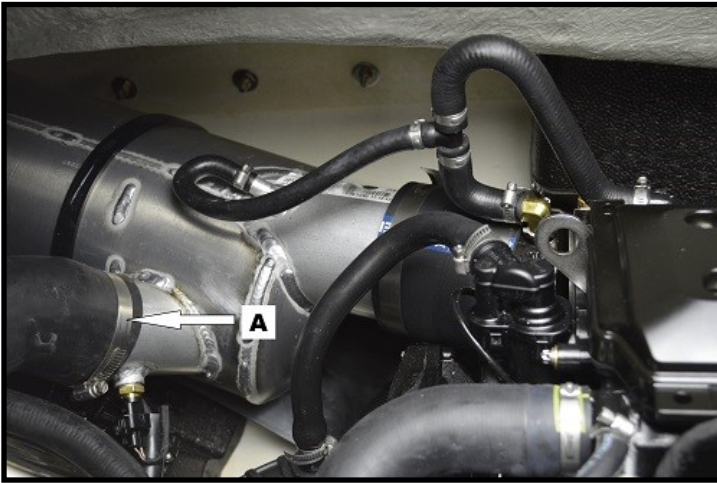




## - INSTALLATION INSTRUCTIONS -

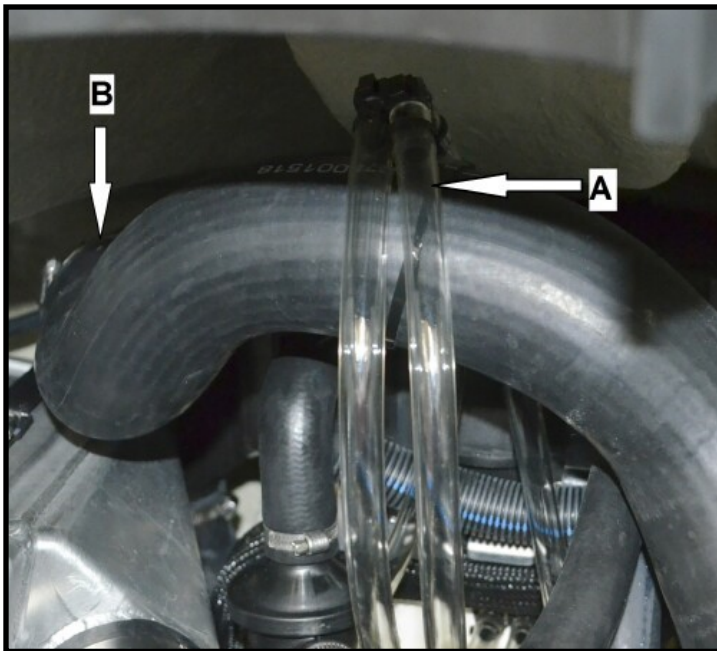
Loosen clamp and remove exhaust outlet hose from water box (A). Retain clamp for later re-use. (Figure 6)

Figure 6



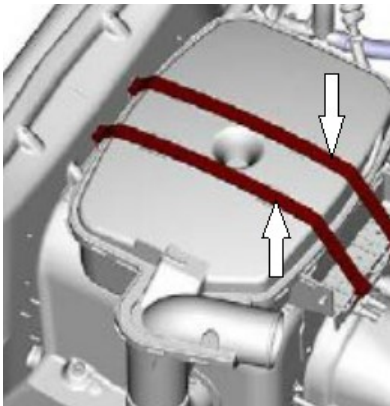
Cut the zip tie (A) securing the two clear siphon bilge hoses to the OEM Front Exhaust Hose. (Figure 7)

Figure 7



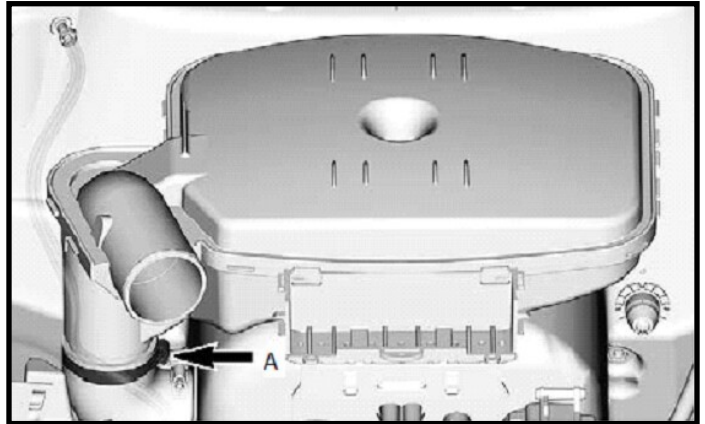
Loosen the clamp (B in figure 7) holding the OEM Front Exhaust Hose to the resonator. Remove and discard the Front Exhaust Hose. Keep the clamp for later reuse.

Remove two rubber straps holding resonator in place.



Loosen the clamp (A) holding the resonator outlet to the through hull fitting..(Figure 8)

Figure 8



Pull the resonator upward while twisting it back and forth to remove it from the through hull fitting. Remove the resonator from the hull and discard as it will not be used again. Remove hose clamp and retain for later reuse.

Place supplied silicone coupler on water box end of supplied exhaust tube. **Tip: Lubricate inside of coupler and outside of tube with glass cleaner.** Slip three OEM hose clamps (previously saved) onto coupler over tube. **Note: Do not tighten clamps.** (Figure 9)

Figure 9



Insert exhaust tube into OEM exhaust through hull outlet. **Tip: Lubricate inside of OEM outlet and outside of tube with glass cleaner.** Install water box end of pipe onto water box outlet. **Tip: Lubricate outside of water box outlet and inside of coupler with glass cleaner.** Slide

## **- INSTALLATION INSTRUCTIONS -**

one clamp down tube into place on through hull outlet. Tighten clamps at through hull end and water box end of tube. **Note: Do not over tighten clamps.** (Figure 10)

Figure 10



Using supplied zip tie secure siphon bilge hoses in up-right position

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