



RIVA RACING

PERFORMANCE PRODUCTS & ACCESSORIES

Sea•Doo Heavy-duty Supercharger Clutch Washers

PART# - RS1751-HDW-945, -946 & -948

APPLICATION(S): 255hp RXP-X/RXT-X & 215hp RXP/RXT/GTX-SC

Required tools

Torx Screw Adapter
Impeller Shaft Holder

Part#

529 035 938
RS1750-HDW-949

Recommended tools

Oetiker Pliers
Service Manual

Part#

C-48550347
Please call

- INSTALLATION INSTRUCTIONS -

1. Remove D.E.S.S. lanyard.
2. Remove seat bridge (RXT-X, RXT & GTX models) or engine compartment cowling (RXP-X & RXP models).
3. Remove inlet and outlet hoses attached to supercharger unit.
4. Remove exhaust pipe from exhaust manifold. Disconnect muffler restraining strap and slide muffler rearward.
5. Remove the three M6 x 35mm Torx bolts (2 lower/front & 1 upper/rear) that secure supercharger unit to engine. (see illustration #'s 1&2) **NOTE:** You will need a special Torx adapter to remove and replace the upper/rear Torx bolt. This can be purchased through our parts department, at any Sea•Doo Dealer or reputable tool company.
6. Remove supercharger unit from engine. **NOTE: It is extremely important that the area utilized to work on the supercharger unit is very clean. Any foreign debris introduced into the supercharger unit will cause damage.**
7. Secure impeller shaft at rear of supercharger unit using Sea•Doo shaft holding tool. Remove impeller shaft nut and set aside. (see illustration #3)
8. Remove supercharger shaft components and place on a clean surface in order they are removed. **NOTE: BRP recommends that you replace the Supercharger clutch/shaft assembly (to `08 spec). Order part# 420881100.**
9. Discard OEM clutch washers. (see illustration #4)
10. Thoroughly clean engine side of supercharger impeller shaft and impeller shaft components using a non-residual cleaner only. Coat supercharger components to be installed with BRP 4-stroke XPS oil. **NOTE: Use only BRP 4-stroke XPS oil in your supercharged engine.**
11. Install RIVA HD Clutch Washers:
2008 Models: Install one supplied washer onto supercharger impeller shaft. (see illustration #4) Wrap new needle bearings around impeller shaft and remove adhesive backing. Install supercharger gear over needle bearings. Install second supplied washer onto impeller shaft.
2007 & older Models that have not updated to `08 spec shaft: Install supplied 'L' washer onto supercharger impeller shaft. (see illustration #4) Wrap new needle bearings around impeller shaft and remove adhesive backing. Install supercharger gear over needle bearings. Install supplied 'S' washer onto impeller shaft.
12. Install lock washer, spring washers, L-ring and impeller shaft nut. (see illustration #'s 4&5) **NOTE: Apply RED Loc-Tite to threads on shaft.** Torque nut to 22 ft•lbs / 30 N•m.
13. Spin supercharger impeller to ensure smooth operation.
14. Inspect o-rings on engine side of supercharger housing. If either is damaged replace both.
15. Coat unpainted area on engine side of supercharger unit with anti-seize. (see illustration #6)
16. Install supercharger unit onto engine. **NOTE:** It may be necessary to rotate supercharger impeller to allow supercharger gear to mesh with flywheel gear.
17. Secure supercharger unit to engine using the three M6 x 35mm Torx bolts removed in step 5. **NOTE: Use BLUE Loc-Tite.** Torque to 89 lbf•in / 10 N•m.

18. Replace supercharger inlet and outlet hoses.
19. Replace exhaust hoses removed in step 4.
20. Installation is now complete! Run craft on flush kit to check for leaks and to ensure smooth operation of supercharger.

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 Heavy-duty Clutch Washers carry a 90-day 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 must accompany all warranty claims.

Warranted replacement parts will be returned freight collect.

- INSTALLATION IMAGES -

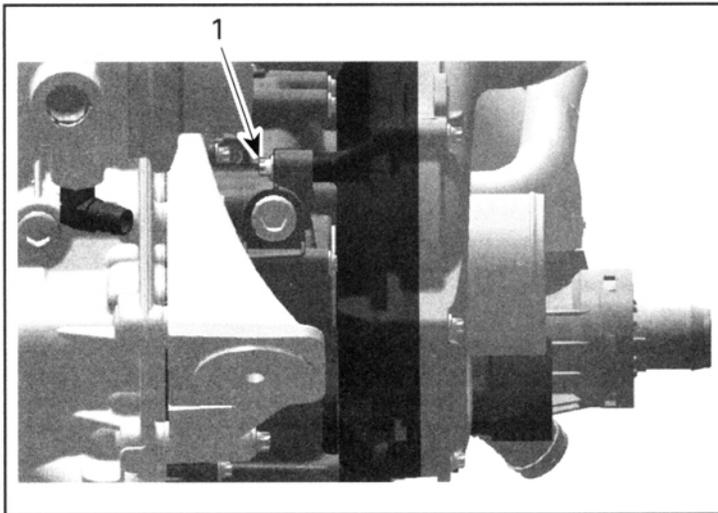


Illustration #1

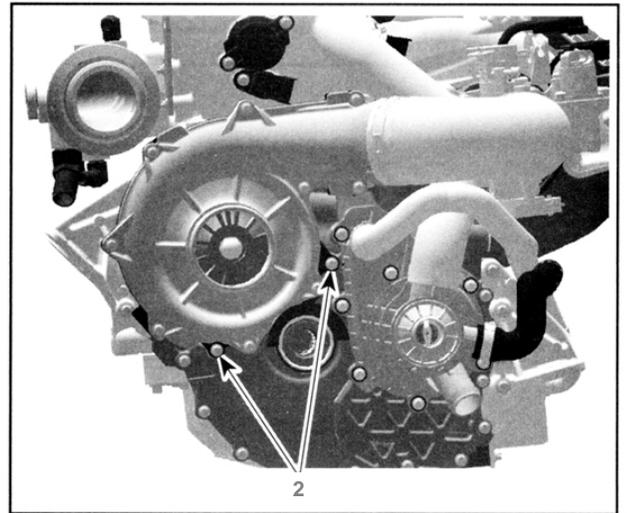


Illustration #2

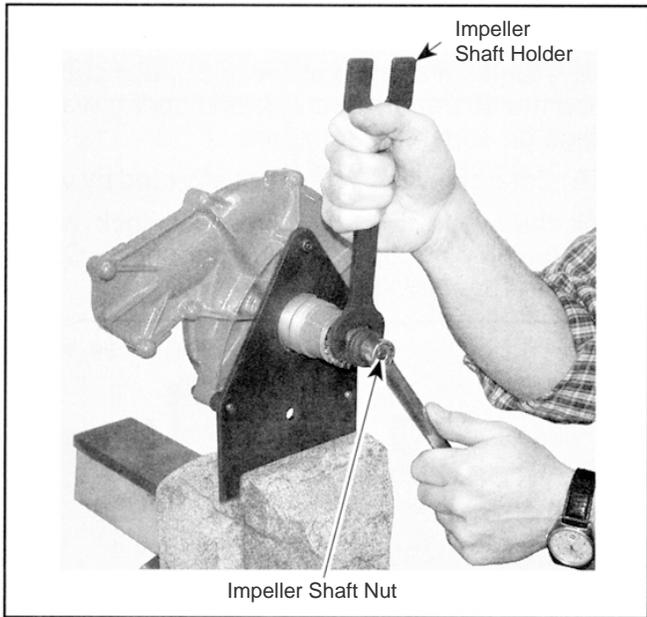
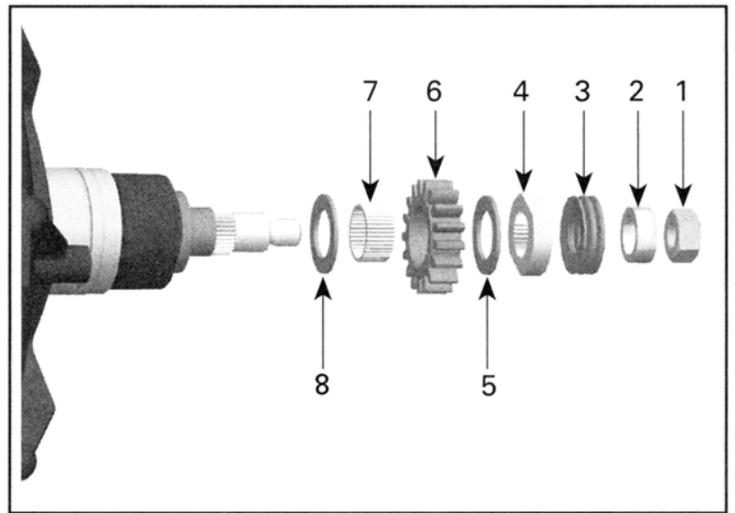


Illustration #3



- | | |
|--------------------------------------|---|
| 1- Impeller Shaft Nut | 6- Supercharger Gear |
| 2- L-ring | 7- Needle Bearings (40) |
| 3- Spring Washers | 8- Large ID Clutch Washer ('07 & older - 'L') |
| 4- Lock Washer | |
| 5- Clutch Washer ('07 & older - 'S') | |

Illustration #4

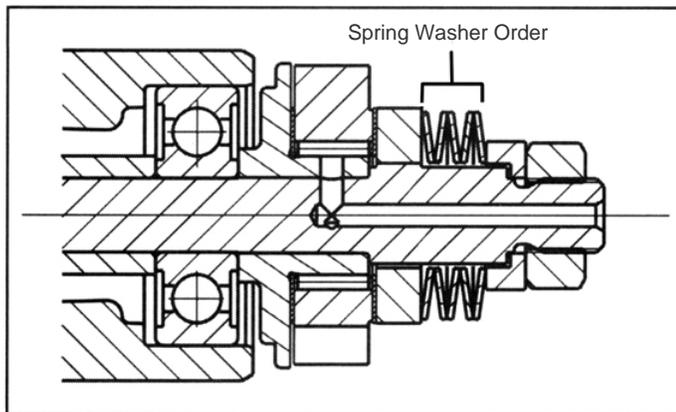


Illustration #5

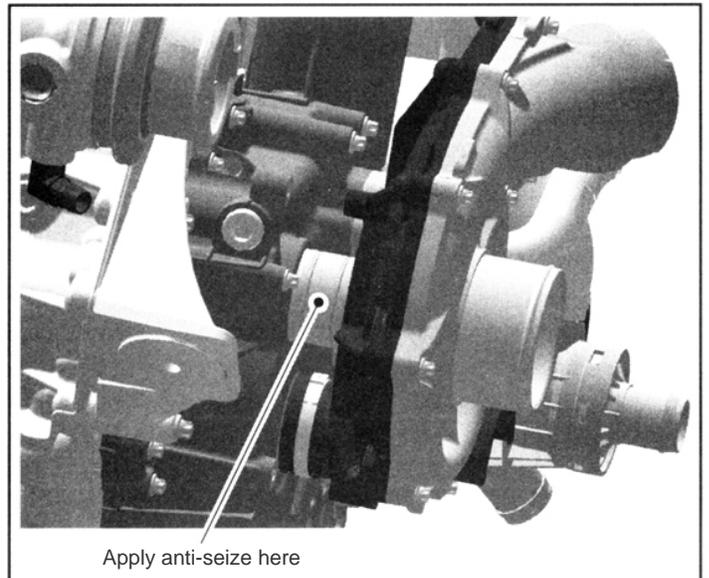


Illustration #6