



RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Replacement Engine Sleeves

Application

Yamaha 1.8L Engine
Sea-Doo 1503/1630 (except 325)

Part #

RY10040-SLV-615
RS10050-SLV-1503

The following specifications are provided as a guide only. We strongly recommend that only an experienced machinist prepare and install these sleeves. Failure to properly prep and install these sleeves falls solely on the end user. Due to the nature of performance applications these sleeves are sold without any express warranty or any implied warranty of merchantability or fitness for a particular purpose. RIVA Racing shall not, under any circumstances, be liable for any special, incidental or consequential damages, including, but not limited to damage, or loss of profits or revenue, cost of purchased or replacement goods, or claims of customers of the purchaser, which may arise and/or result from sale, installation or use of these sleeves. Installation will adversely affect the vehicle manufacturer's warranty coverage.

INSTALLATION GUIDELINES:

- Do not machine or modify sleeves prior to installation.
- Remove original, damaged sleeve(s) and bore engine block for a press-fit clearance of 0.002" to replacement sleeve(s).
- Leave a step (landing) inside engine block for bottom edge of replacement sleeve(s) to stop against when installed.
- Prior to installing sleeve(s) the engine block must be +100°F greater in temperature than the replacement sleeve(s) itself.
- Install chamfered end of replacement sleeve(s) into engine block.
- Allow engine block to cool completely after installing replacement sleeve(s). We strongly recommend the use of a torque plate while allowing engine block to cool.
- Replacement sleeve(s) must be bored to clearance specifications of piston manufacturer and then finish honed. We strongly recommend the use of a torque plate when boring replacement sleeve(s).
- Engine block must be decked, after replacement sleeves are bored & honed, to ensure proper head gasket sealing surface integrity. No more than 0.005" of material should be removed.

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@rivaracing.com.