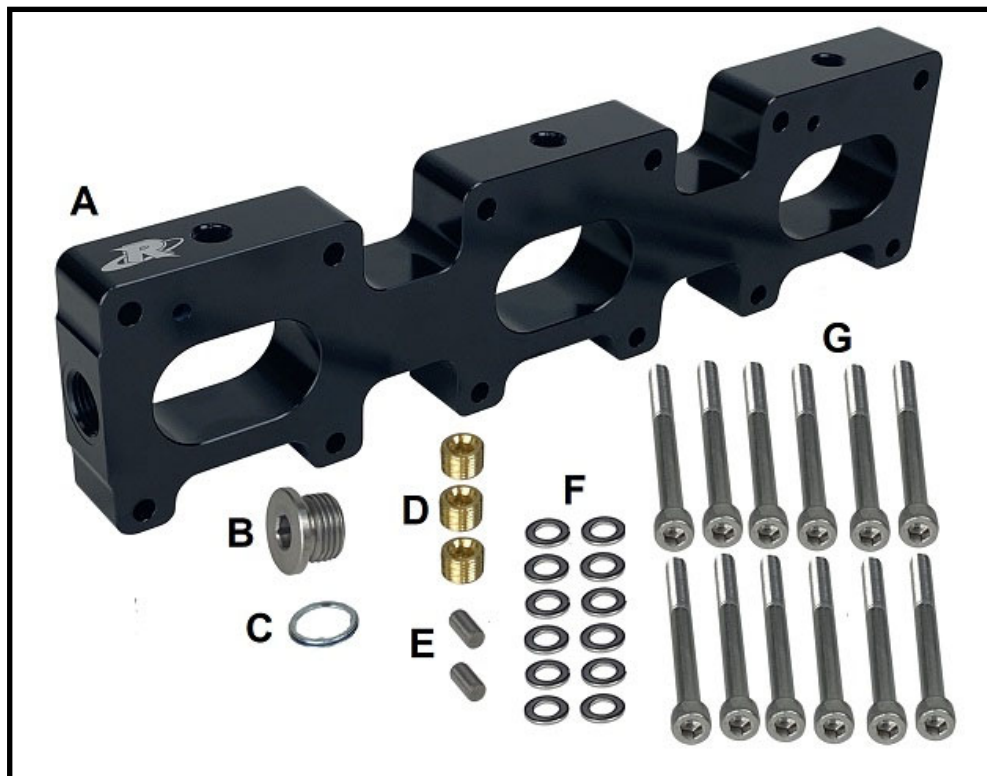




Sea-Doo Exhaust Race Plate

RS18050-ERP



COMPONENT LIST

Item	Description	RIVA Part #	Qty.
A	Billet Exhaust Spacer	QCA-RS18050-ERP	1
B	SS Plug	RPS-5259SS	1
C	18 mm Sealing Washer	CHA91591	1
D	1/8" NPT Brass Plug Counter Sunk	109UA	3
E	5 x 10 mm Dowel Pin	93600A511	2
F	M6 Flat Washer	.6NWTFS	12
G	Bolt M6 X 70 SHCS	.6C70SHCS	12

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@rivaracing.com.

Applications: Sea-Doo Supercharged 1503 and 1630 Engines

Approximate Installation Time: 1 Hr.

Recommended Specialty Tools:

Torx E8 Socket

Required Materials:

Blue Loctite

Part #

N/A

Part #

N/A

GET THE LATEST UPDATES!

Prior to installation, go to the RIVA Racing online Instruction Library to download the latest version of these instructions:

<https://rivaracing.com/instructions>



RIVA RACING

PERFORMANCE PRODUCTS & ACCESSORIES

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 *****

Caution: Whenever using electric or battery operated tools inside the hull be sure it is well ventilated and no fumes are present. Failure to do so could result in a fire, or explosion and serious personal injury or death.

This kit is not intended for use on pollution controlled vehicles. Installation on pollution controlled vehicles may constitute a violation of state or local statutes.

- INSTALLATION INSTRUCTIONS -

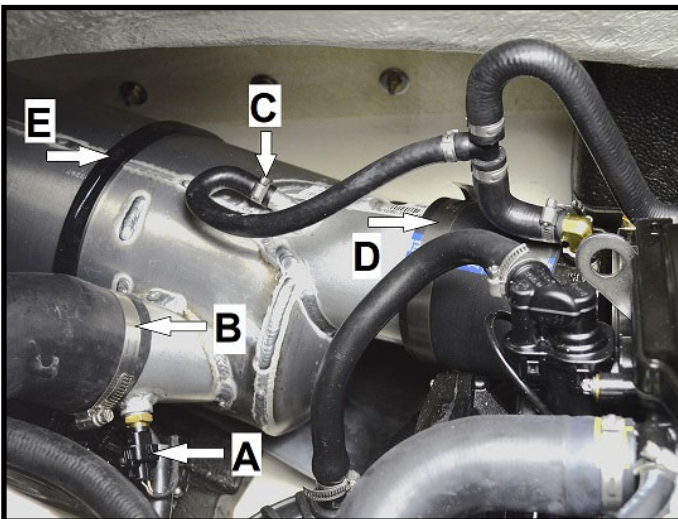
Remove seat and any access panels, deck beam, rear grab handle, engine cover, etc. necessary to access engine, exhaust manifold, and waterbox. Refer to OEM service manual if needed.

2019 and earlier models:

Disconnect exhaust temperature sensor (A). Loosen waterbox outlet clamp (B). Disconnect outlet hose from waterbox. Loosen water hose clamp (C). Disconnect water hose from waterbox. Loosen waterbox inlet clamp (D) and slide clamp down off inlet coupler onto waterbox inlet. Disconnect hold down strap (E) from securing hooks. (Figure 1)

Move waterbox to the rear to disconnect from inlet coupler.

Figure 1

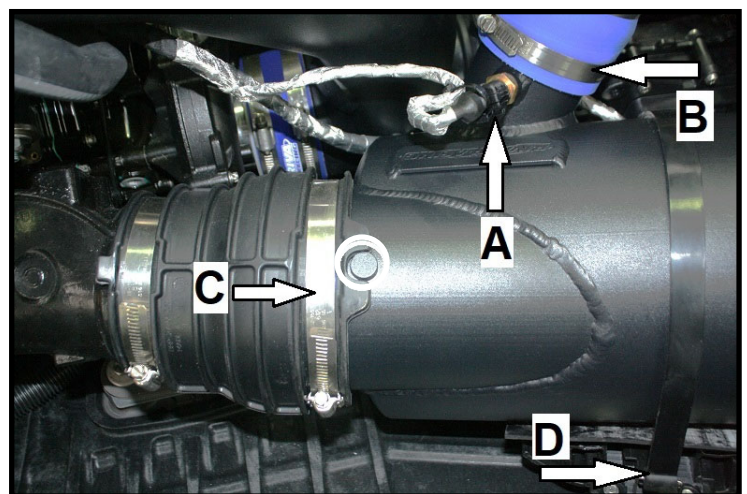


2020 and later models:

Disconnect exhaust temperature sensor (A). Loosen waterbox outlet clamp (B). Disconnect outlet hose from waterbox. Loosen waterbox inlet clamp (C). Disconnect hold down strap (D) from securing hooks. (Figure 2)

Move waterbox to the rear to disconnect from inlet coupler.

Figure 2

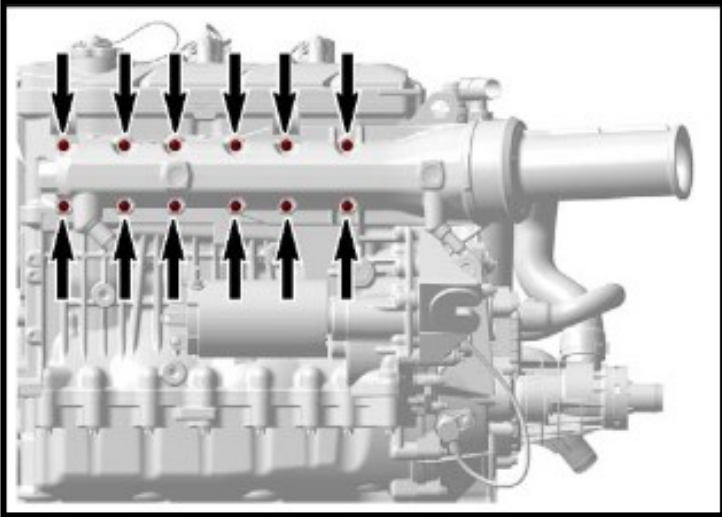


- INSTALLATION INSTRUCTIONS -

All models:

Using Torx E8 socket remove bolts (12) securing exhaust manifold to cylinder head. (Figure 3)

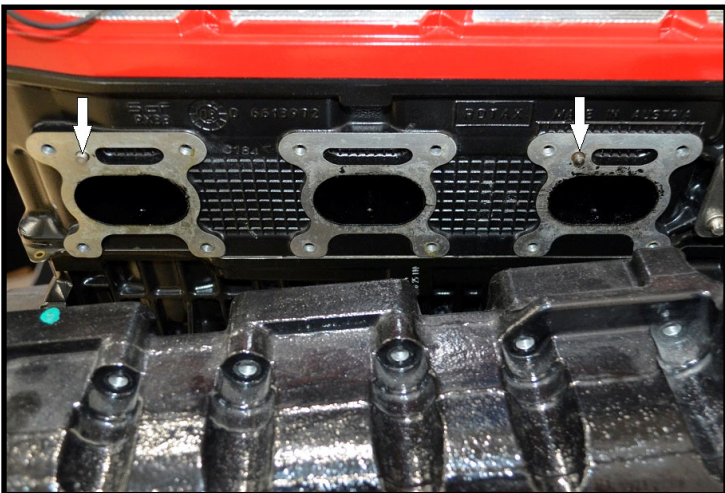
Figure 3



Separate exhaust manifold from cylinder head.

There are two dowel pins that locate the exhaust manifold on the cylinder head when installed. Inspect the cylinder head and the exhaust manifold and note the locations of the installed dowel pins. There are holes for dowel pins on both faces of the RIVA ERP. Orient the RIVA ERP so that the RIVA logo is at the top front of the engine when installed. Install the two supplied dowel pins into the holes in the ERP in the locations that do not have the OEM dowel pins. (Figure 3)

Figure 3

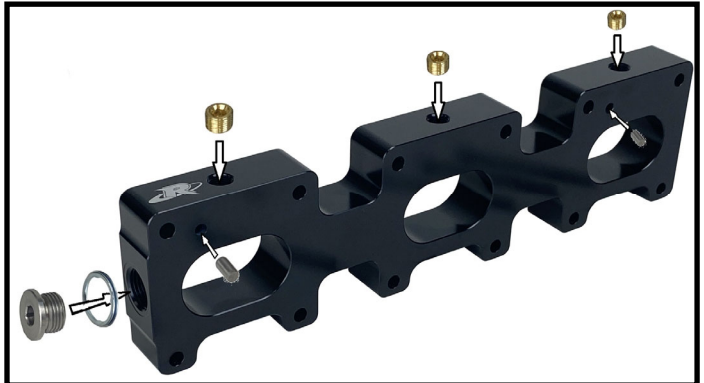


Using a 3/16" hex key install the three supplied brass plugs into the three holes in the top of the ERP. **Note: Do not over tighten plugs.**

Install supplied 18 mm sealing washer onto supplied stainless plug. Using an M8 hex key install into hole at front end of ERP. **Note: Do not over tighten plug.**

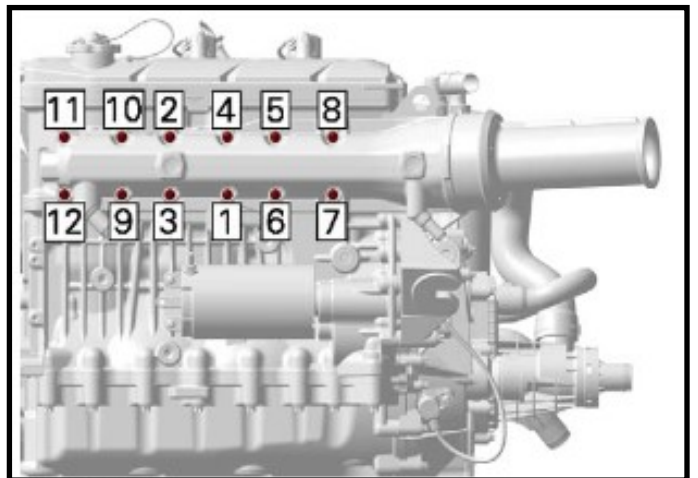
Option: If you are installing on O2 sensor it may be installed at this time rather than the stainless plug. (Figure 4)

Figure 4



Install ERP onto cylinder head aligning dowel pins with holes. Install exhaust manifold onto ERP aligning dowel pins with holes. Secure with supplied M6 x 70 bolts and flat washers (12 each). **Notes: Use blue Loctite on bolt threads. Do not put any type of sealer on mating surfaces.** Tighten bolts in two steps to 7 ft•lb. (9 N•m) in sequence shown. (Figure 5) **Note: do not over tighten bolts.**

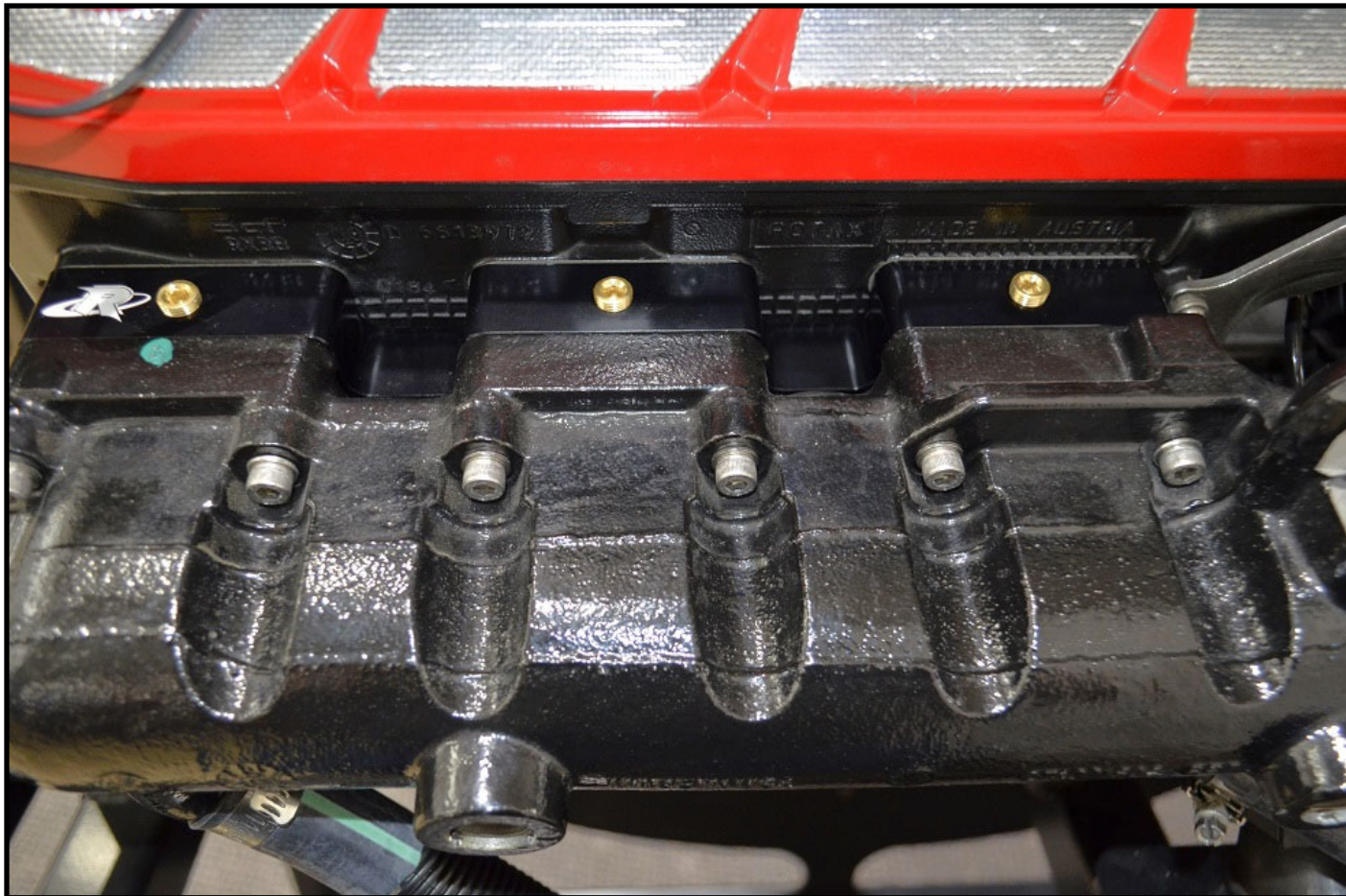
Figure 5



Reinstall waterbox reversing removal procedure. On 2020+ models be sure that locating boss on waterbox aligns with cutout in coupler. (Circled in figure 2, page 2.)

Check bilge for rags, tools etc. Run craft on a flush hose to check for proper operation.

Replace engine cover, bodywork and seat(s) previously removed.



***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@rivaracing.com.

Limited Warranty

RIVA Exhaust Race Plates carry a 1-year 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.