



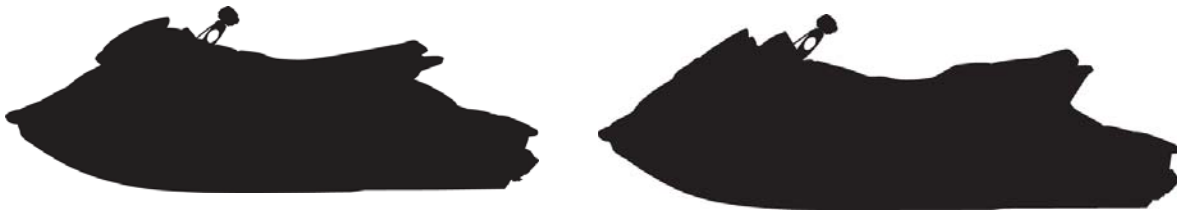
RIVA RACING
PERFORMANCE PRODUCTS & ACCESSORIES

Rear Exhaust Kit
PART# RS15050-1

We strongly recommend the use of a Sea•Doo service manual to familiarize yourself with the various components and procedures involved with this installation. Please note that some of the original clamps, hoses and hardware removed in the disassembly process will be used in the installation process. These instructions have been written in point form and refer to illustrations and templates. Please follow these step-by-step instructions and illustrations carefully.

NOTE: These installation instructions are broken up into 2 booklets.

**This booklet is for 255hp
RXP-X & RXT-X applications.**



**For 215hp RXP, RXT or GTX-SC
applications please refer to other booklet.**

– INSTALLATION INSTRUCTIONS –

Required Tools

Dremmel®, Roto Zip® or Die Grinder
VTS Socket Tool
Exhaust Outlet Tool

Part#

N/A
295 000 133
295 000 132

Recommended Tools

Sea-Doo Service Manual

Part#

219 100 313

Read through the installation instructions entirely before beginning. Prior to installing this kit you are required to install our O.P.A.S. Performance Block-off Kit first (part# RS29050-1). We also recommend the use of our Power Filter Kit (part# RS13050).

1. Connect D.E.S.S. lanyard. Set VTS to fully up position. Remove D.E.S.S. lanyard.
2. Remove seat(s). Remove engine coolant tank from mounting location.
3. **RXP-X:** Remove engine cowling (5 bolts total). (see illustration #1)
RXT-X: Remove top half of deck beam (4 bolts total). (see illustration #2) Remove bottom half of deck beam. (see illustration #3) Discard vent tube.
4. Remove exhaust hose connecting water box (muffler) to exhaust baffle and discard.
RXT-X see illustration #4.
RXP-X: see illustration #5. Remove intercooler outlet hose first to access exhaust baffle. (see illustration #6)
5. Remove hoses between intercooler and engine (2) and discard.
RXT-X see illustration #4
RXP-X: see illustration #5.
6. Place clean rags in openings left when hoses were removed.
7. At air intake tube located under intake manifold loosen clamps at both ends and disconnect hoses. (see illustration #7 & 8)
8. Slide tube forward. **RXT-X ONLY:** Gently lift upward on tube to remove the two plastic grommets securing tube to hull and then slide tube forward.
9. At supercharger move end of air tube connected to inlet out of way (towards water box). (see illustration #8)
10. At pump disconnect VTS rod from VTS shaft. Remove rubber boot sealing VTS motor shaft. Remove nut securing VTS motor assembly to hull. (see illustration #9) Inside hull remove VTS from thru-hull fitting and set aside.
11. Inside hull remove OEM intercooler bracket (4 bolts total). (see illustration #10)
RXT-X models follow step 12. RXP-X models proceed to Step 13.
12. Loosen bolts securing throttle body to intake manifold. (see illustration #8) Remove throttle body and place on top of intake manifold assembly.
13. Loosen clamp securing exhaust baffle to exhaust outlet hose. Remove bolt securing exhaust baffle to hull. (see illustration #11) Remove exhaust baffle and discard.
RXT-X models follow step 14. RXP-X models proceed to Step 15.
14. Replace throttle body. **NOTE: Apply blue Loc-tite to bolts. Do not over tighten. Make sure throttle body lubrication hose is connected to throttle body.**
15. Remove stock exhaust outlet. Install supplied exhaust outlet block-off in its place and secure using stock gasket and lock nut. (see illustration #12) **NOTE: Apply silicone sealant to stock gasket and block-off threads. Do not over tighten lock nut.**
16. Using the supplied template for your craft [**RXP-X page 8 • RXT-X page 9**] mark location on left side of transom where supplied billet exhaust outlet flange is to be installed. Hole can be made using a hole saw bit or with a Dremmel®, Roto Zip® or die grinder tool. **NOTE: Do not make hole larger than 2-7/8" in diameter. Wear safety glasses and a dust mask. We strongly recommend the use of a shop-vac during this step as well.**

17. Thoroughly clean inside of hull and transom surfaces (inside and out) so they are free of fiberglass dust.
18. Install supplied rubber gasket onto exhaust outlet. Install exhaust outlet into hull from outside. Apply silicone to retainer ring and install onto exhaust outlet from inside of hull. Secure using supplied hardware. **NOTE: Apply blue Loc-tite to threads of bolts. Do not over tighten bolts. Bolts are over tightened if rubber gasket begins to squeeze out from behind exhaust outlet flange.**
19. Remove fitting in end of supplied aluminum exhaust tube. Apply pipe thread sealant to supplied brass block-off fitting and install into aluminum exhaust tube. (see illustration #14) **NOTE: Do not over tighten fitting.**
20. Install supplied 4-1/2" silicone coupler onto straight end of exhaust tube enough so it may be secured properly. Secure with OE hose clamp. (see illustration #14) **NOTE: Do not over tighten clamp.** Loosely install second OE hose clamp.
21. Thoroughly clean water box outlet with a non-residual cleaner. Install supplied 2-1/2" silicone coupler onto water box outlet. Secure with OE hose clamp. **NOTE: Do not over tighten clamp.** Loosely install second OE hose clamp.
21. Apply a generous amount of glass cleaner into couplers. Install outlet end of exhaust tube first and curved end onto water box second. Secure hose clamps. (see illustration #15) **NOTE: Do not over tighten clamps.**
22. Reconnect air intake tube located under intake manifold removed during step #'s 7 & 8. **NOTE: Do not over tighten clamps.**
23. Refer to RIVA RXP-X/RXT-X OEM Intercooler Upgrade Kit installation instructions from this point on.

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 Rear Exhaust Kits 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 -

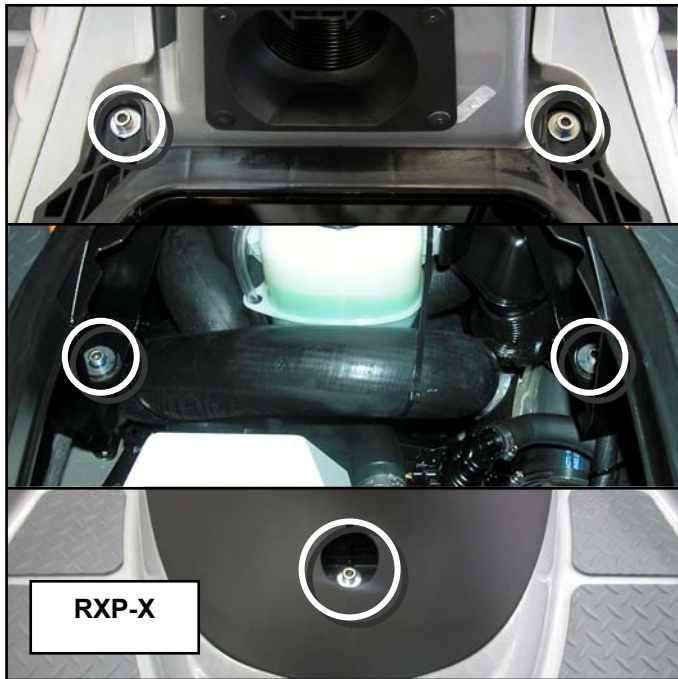


Illustration #1

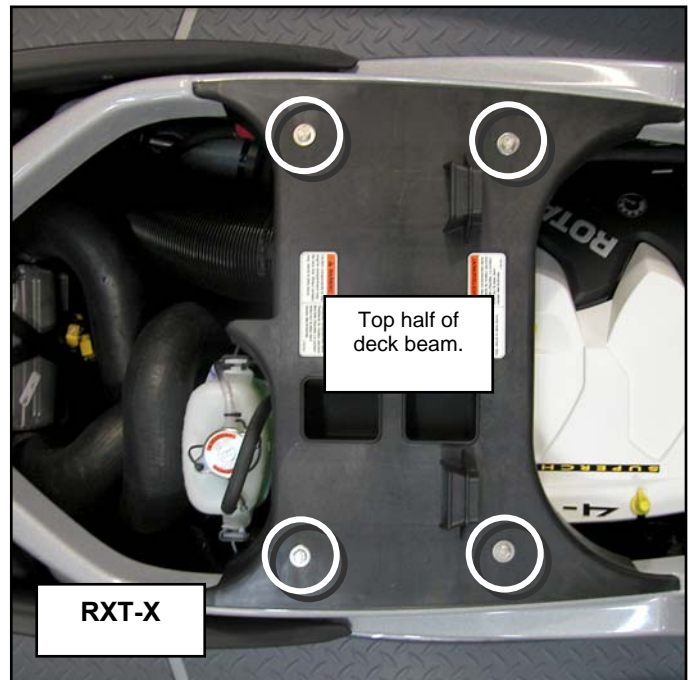


Illustration #2

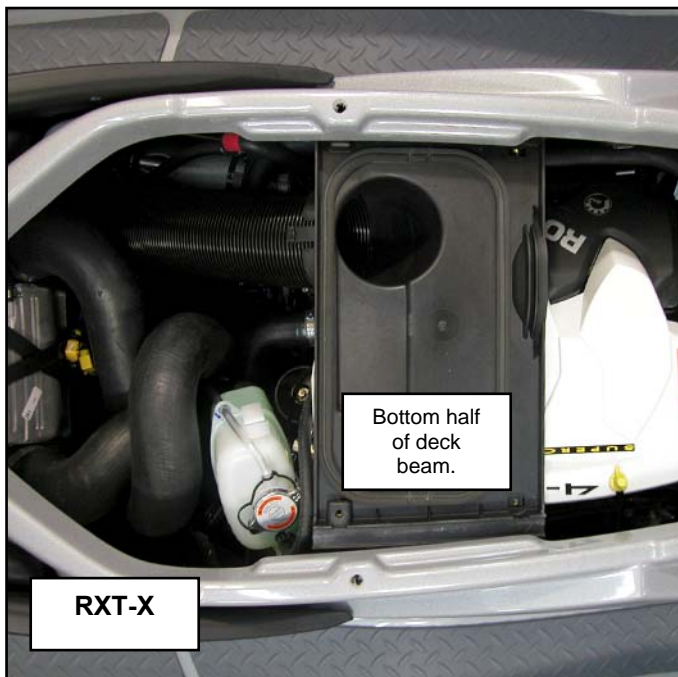


Illustration #3

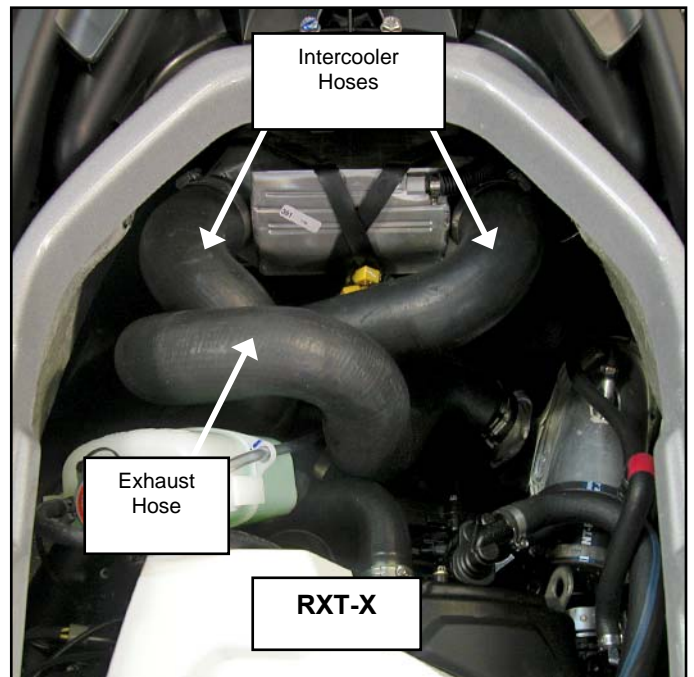


Illustration #4

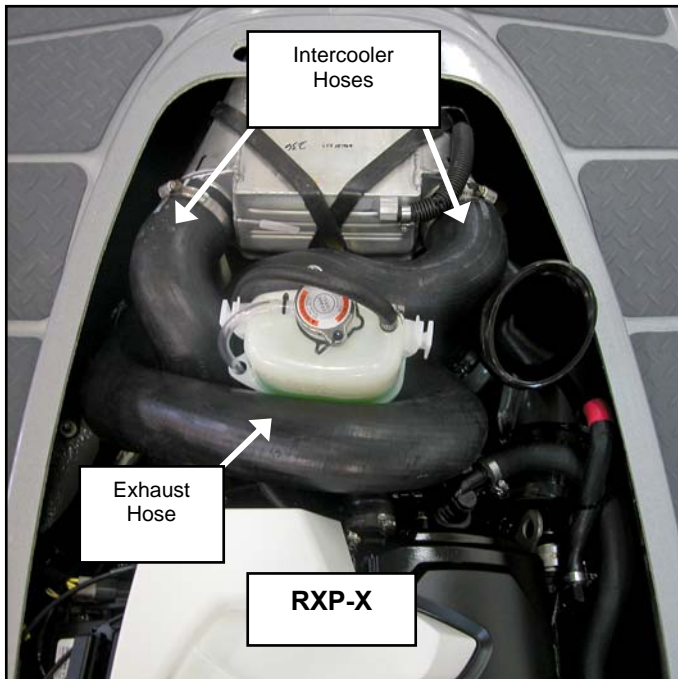


Illustration #5

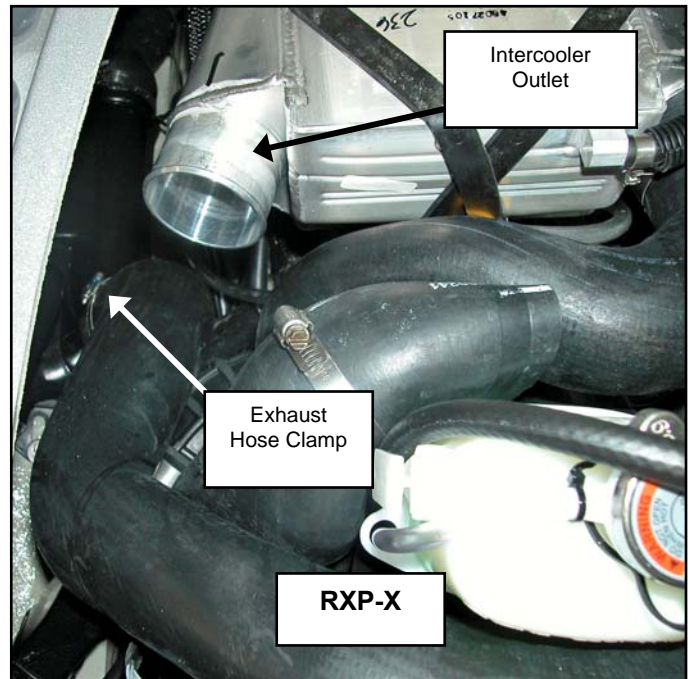


Illustration #6



Illustration #7

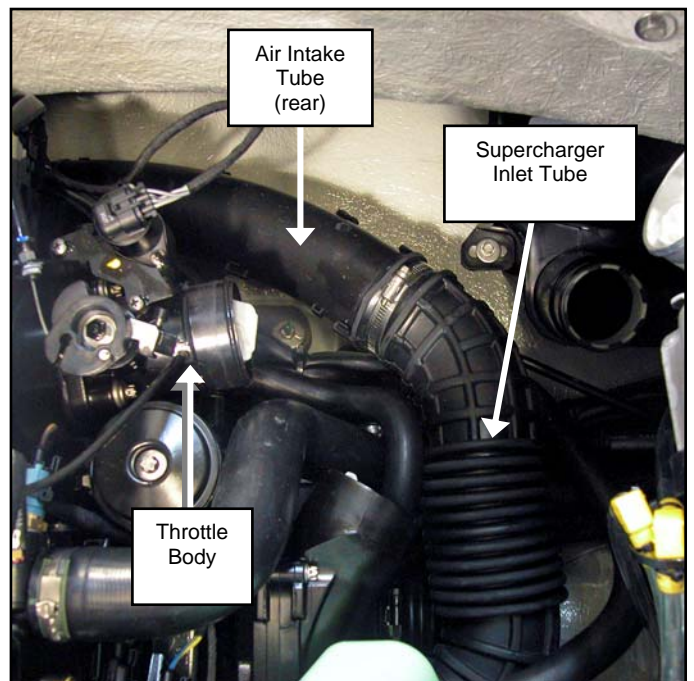


Illustration #8

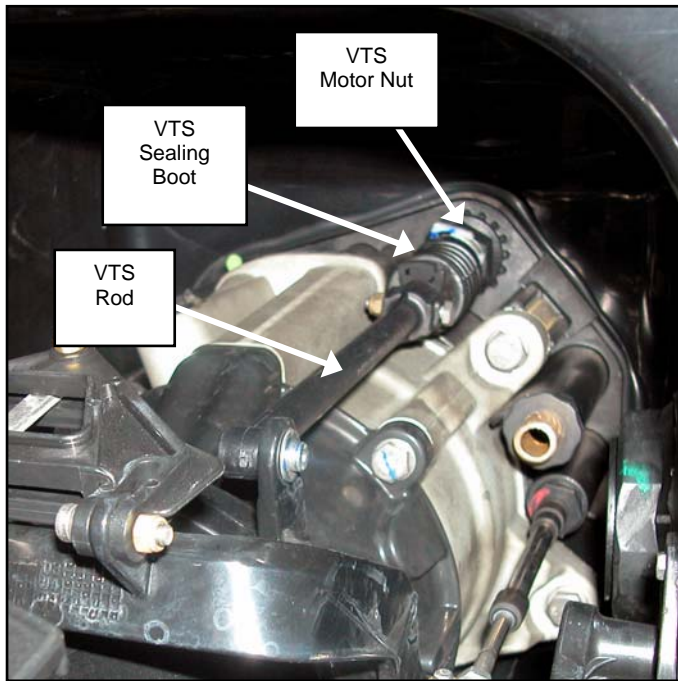


Illustration #9

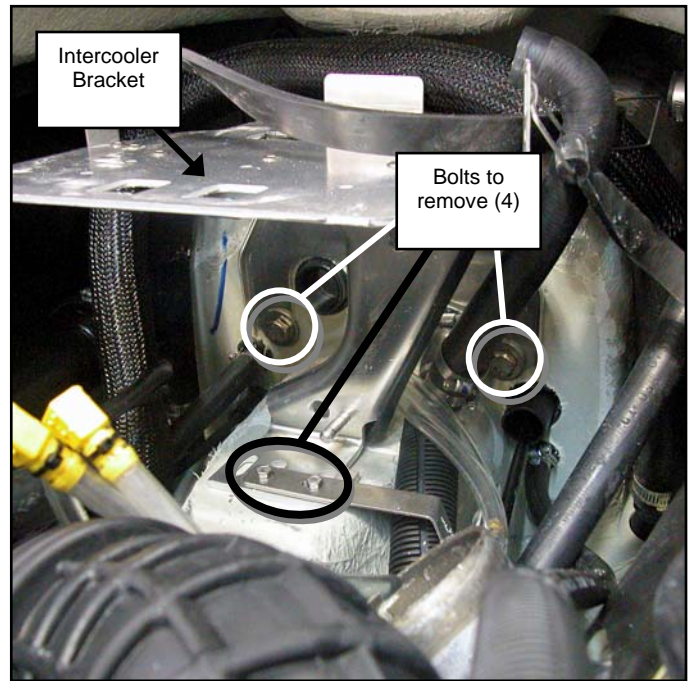


Illustration #10

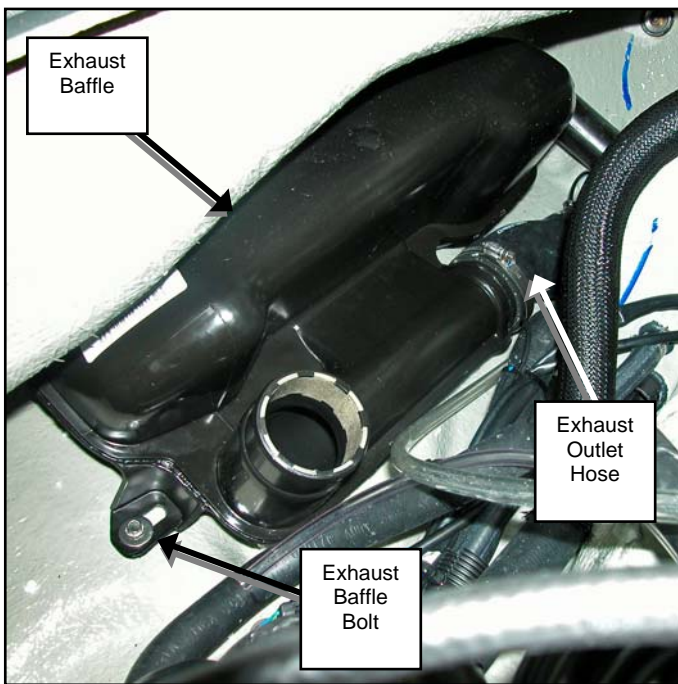


Illustration #11



Illustration #12



Illustration #13



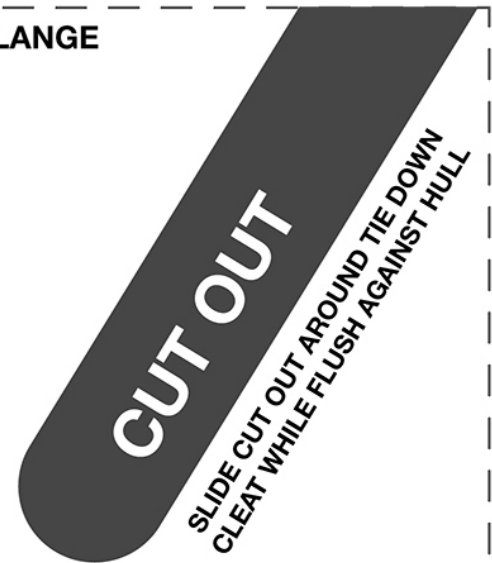
Illustration #14



Illustration #15

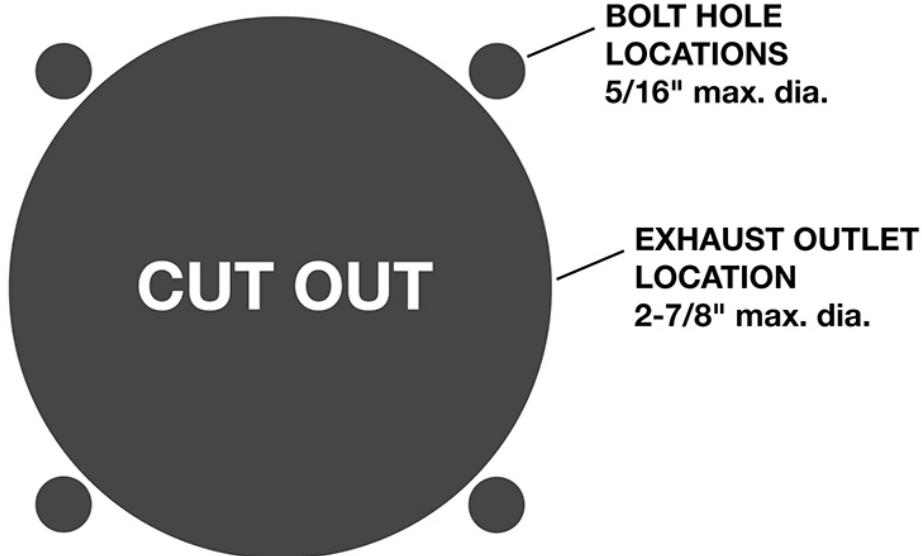
255hp RXP-X Rear Exhaust Outlet Template

CUT OUT TEMPLATE ALONG DOTTED LINE
THIS EDGE AGAINST UNDERSIDE OF BOND FLANGE



IMPORTANT:
Be sure template is
flush against transom

255hp RXP-X Rear Exhaust Outlet Template



CUT OUT ALL 5 CIRCLES

CUT OUT TEMPLATE ALONG DOTTED LINE

255hp RXT-X Rear Exhaust Outlet Template

CUT OUT TEMPLATE ALONG DOTTED LINE

THIS EDGE AGAINST UNDERSIDE OF BOND FLANGE

CUT OUT

SLIDE CUT OUT AROUND TIE DOWN
CLEAT WHILE FLUSH AGAINST HULL

IMPORTANT:
Be sure template is
flush against transom

255hp RXT-X Rear Exhaust Outlet Template

EXHAUST OUTLET
LOCATION
2-7/8" max. dia.

BOLT HOLE
LOCATIONS
5/16" max. dia.

CUT OUT

CUT OUT ALL 5 CIRCLES

CUT OUT TEMPLATE ALONG DOTTED LINE