

Congratulations! You have just purchased the most powerful and technologically advanced exhaust system on the market today. Countless hours of dyno and on-water testing have produced the best pipes available. Speedwerx... power to the people.

### TOOLS & SUPPLIES NEEDED:

- Liquid Thread Sealer
- Silicone Spray Lubricant
- Anti-Seize Lubricant
- Tube of Silicone
- Small Zip Ties
- Drill Bit for Thru-Hull Water Exits
- Drill Bit for Hole in Grab Bracket
- File
- Exhaust Spring Tool
- 3/8" Electric Drill
- Metric Allen Wrenches
- Metric Socket Set
- Metric Nut Drivers
- Medium Crescent Wrenches
- Die Grinder or Dremel Tool w/  
Aluminum Cutting Bit & Cut-Off Disk
- Utility Knife

### PARTS LIST:

- (22) Size 6 Hose Clamps
- (12) 2 1/2" Hose Clamps
- (2) 3/8" x 3/8" 90° Brass Fittings
- (6) 1/4" x 3/8" Brass Fittings
- (1) 1/4" x 1/2" Brass Fitting
- (3) 3/8" Screened Brass Fittings
- (9) 1/8" x 5/16" 90° Brass Fittings
- (3) 1/8" x 3/8" 90° Brass Fittings
- (1) 1/4" Brass Plug
- (2) Exh. Mount Plate Bolts 10x1.25x30mm
- (12) Exh. Manifold Bolts 10x1.25x40mm
- (6) Washers for Lord Mounts
- (6) 3/8" Nylock Nuts
- (1) 2 1/2" x 3/8" Bolt
- (2) 1 1/4" x 3/8" Bolts
- (12) SS washers for Exh. Manifold
- (2) 3/4" x 3/8" Bolts
- (1) 1" x 3/8" Bolt
- (6) 3" x 2" I.D. Hoses
- (6) Rubber Mounts
- (3) Exh. Gaskets
- (6) Long Springs
- (9) O-Rings
- (1) Mounting Plate
- (1) Collector
- (1) 8-hole Water Manifold
- (1) Aluminum Spacer
- (9ft.) 3/8" Clear Hose
- (9ft.) 5/16" Clear Hose
- (6ft.) 1/2" Clear Hose
- (2) Straight Exh. Manifolds
- (1) Angled Exh. Manifold
- (5) 90° Bypass Fittings

## STEP PRE-INSTALLATION

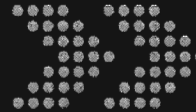
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- Inspect parts list and double check for all items
- Read through entire installation instructions before starting assembly.

## STEP REMOVE STOCK PARTS

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- Battery and Electrical Box
- Entire Exhaust System
- Rear Grab Handle
- ! DO NOT remove Exhaust Mount in front of Engine !

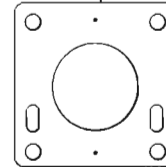


### STEP 3 INSTALLATION (Manifolds & Water Fittings)

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- Locate the (3) billet exhaust manifolds; note that one is different - this one belongs on the Mag side. (Mag is front cyl., PTO is back and Ctr is Center.)
- Note gasket orientation on exhaust manifold, the manifold is not symmetrical so take notice and install with the larger opening at the bottom.
- Grind off weld nuts on stock grab handles stainless steel mounting plate, then drill existing holes.
- Install (1) 1/2" OD fitting on each side of water distribution box, then install (6) 3/8" OD fittings in remaining locations (use thread sealer.) If using dual cooling, install two fittings.
- If using dual cooling, you must install second water inlet from pump to the thru hull fitting normally used for the stock bilge. When disconnecting the stock bilge it is strongly advised to use either "duck-bill" drains or an electric bilge pump.

Exhaust Manifold Gasket  
Top



### STEP 4 PIPE INSTALLATION

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- Locate the (3) 3/8" barbed 90° water outlets and install them in the exhaust manifolds. Use liquid thread sealer. Position water outlet 45° downward from installed location.
- Attach exhaust manifolds and gaskets to cylinders with supplied allen bolts and washers. As noted in pre-installation, locate the different manifold and install it on the Mag cylinder with the water fittings oriented towards the front of the boat. Torque to 30 ft./lbs.
- Install (3) rubber o-rings on the leading edge of each pipe.
- Install the (3) screened water fittings in the pipes. Using liquid thread sealer, install one fitting in each pipe at the 2" long fitting mount.
- Install mounting bracket and rubber vibration dampeners on Mag pipe as shown in diagram 1.
- Install rubber dampeners on PTO pipe.

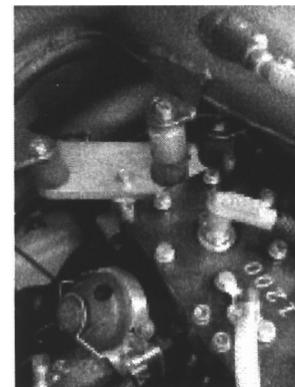
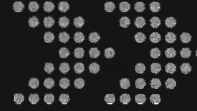


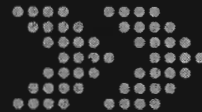
Diagram 1



## STEP PIPE INSTALLATION (Continued)

### 4

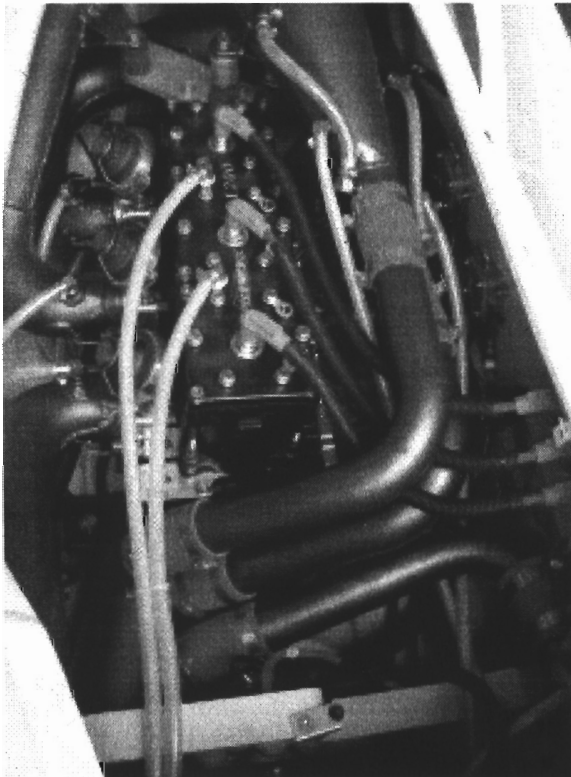
- Install Mag pipe first, using stock exhaust mount in front of engine.
- Install CTR pipe, then lift it and install aluminum spacer between pipe and rubber dampener closest to cylinder head.
- Install PTO pipe, aligning rubber mounts with stock grab handle mounting plate.
- Run 1/2" ID hose from pump inlet at the rear of boat, to side of Water Distribution Box (WDB). (Locate the WDB under the CTR exhaust manifold.)
- Run 3/8" ID hose from stock bilge fitting (next to the pump) to side of the WDB.
- Run 3/8" hose from (3) of the water fittings in WDB to (3) exhaust manifolds.
- Install 90° fittings in pipes closest to leading edge o-rings and run 3/8" hose to the remaining (3) fittings in the WDB. The PTO pipe will have to wait until you can reinstall it later.
- Install Water Box and clamp stock 5" diameter hose to leading edge.
- Fit exhaust collector and clamp to leading edge of Water Box, do not tighten.
- Reinstall PTO pipe.
- Clamp supplied hose to (3) tubes on exhaust collector and (3) pipes (stinger side.)
- Fit extension pipes from stinger to exhaust collector, rotate collector and extensions until you get the best fit. Clamp all hoses to secure position.
- Remove PTO pipe again.
- Loosen clamp on Water Box and rotate approx. 10° so outlet points toward center of boat.
- Locate stock Water Box to Resonator hose. Fit carefully between the Water Box and exhaust outlet. The end with the sharpest angle goes towards the Water Box.
- Now permanently install the PTO pipe.
- Locate (6) exhaust springs and install using a spring expansion tool.
- Run hose from (2) fittings on cylinder head to (2) thru-hull water fittings. You will have a total of (5) water bypass outlets.
- On each pipe, run 3/8" ID hose from screened fitting to stinger fittings.
- Finish all hose plumbing and check all clamps before riding.



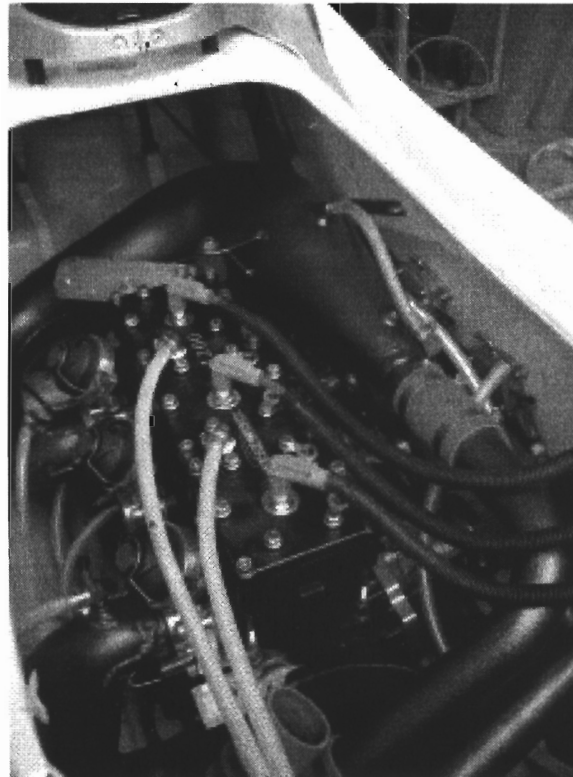
### STEP 5 ADDITIONAL SET-UP TIPS

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- When installing these pipes it is advised to slot mounting holes 3/8" in the battery box to move the electrical box towards the carb side of the deck to allow for easier access when working on the pipes or motor. Zip tie sensors to the box.
- Disconnect and plug the stock pipe drains in lower bond line area. Use silicone in fittings and also in hose.
- Do not use Loctite in the rubber vibration dampeners.
- Mount external fuel pumps 2" above the top edge of 4" Tau Ceti Flame Arrestors. Allowing you access to the carbs.
- Use a 1/4" NPT tap when installing the second cooling pick up in the pump.



Speedwerx GP1200R Dry Pipes Installed (Complete)



Speedwerx GP1200R Dry Pipes Installed (Center pipe removed)