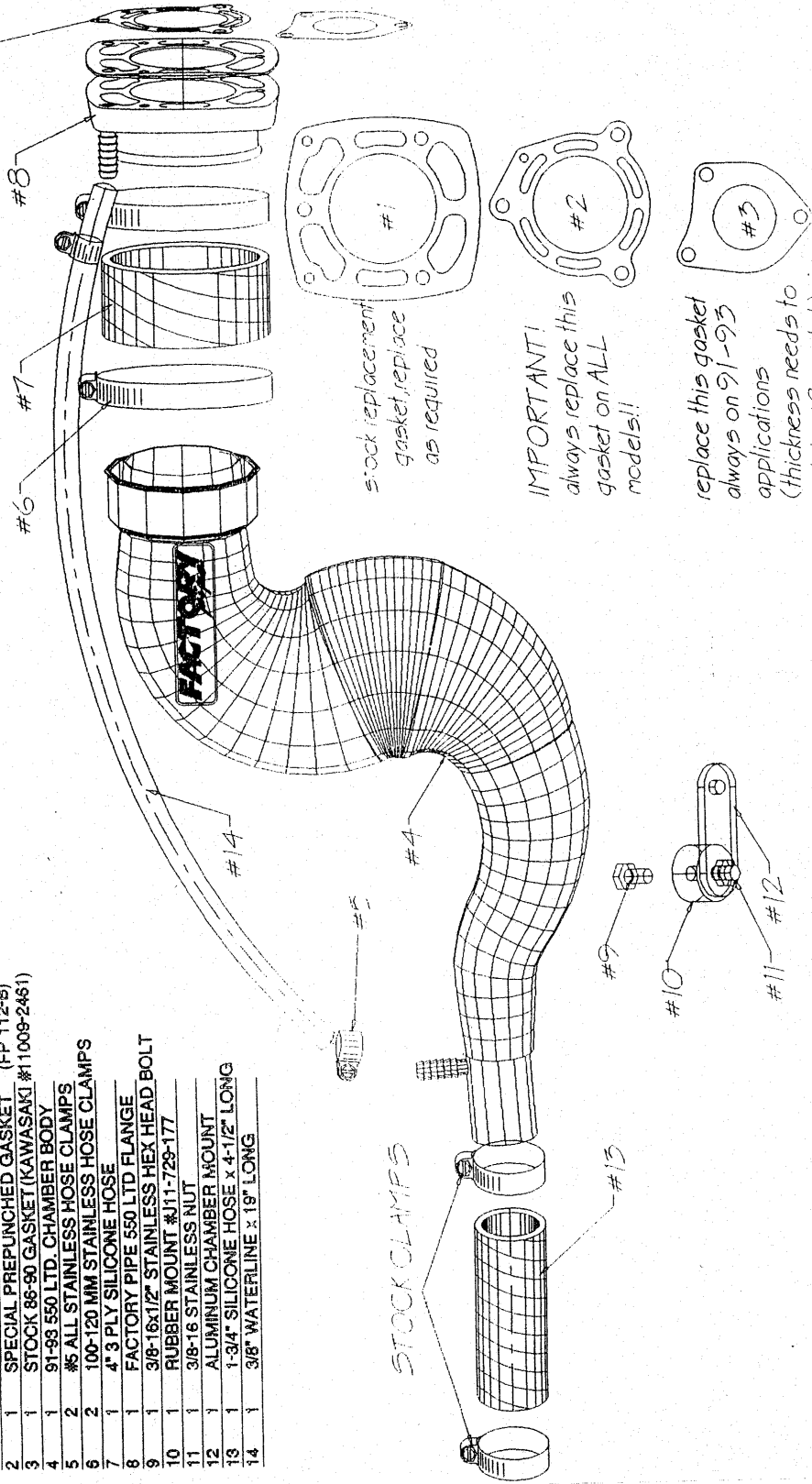


FACTORY 91-93 550 LTD. PIPE-BILL OF MATERIALS

ITEM#	QTY.	PART DESCRIPTION
1	1	O.E.M. 86-90 GASKET (OR FP112-A)
2	1	SPECIAL PREPUNCHED GASKET (FP 112-B)
3	1	STOCK 86-90 GASKET (KAWASAKI #11009-2461)
4	1	91-93 550 LTD. CHAMBER BODY
5	2	#5 ALL STAINLESS HOSE CLAMPS
6	2	100-120 MM STAINLESS HOSE CLAMPS
7	1	4" 3 PLY SILICONE HOSE
8	1	FACTORY PIPE 550 LTD FLANGE
9	1	3/8-16x1/2" STAINLESS HEX HEAD BOLT
10	1	RUBBER MOUNT #J11-729-177
11	1	3/8-16 STAINLESS NUT
12	1	ALUMINUM CHAMBER MOUNT
13	1	1-3/4" SILICONE HOSE x 4-1/2" LONG
14	1	3/8" WATERLINE x 19" LONG

ALWAYS REPLACE THIS GASKET!!



stock replacement
gasket, replace
as required

IMPORTANT!
always replace this
gasket on ALL
models!!

replace this gasket
always on 91-93
applications
(thickness needs to
1 1/2
1 1/2
1 1/2)

STOCK CLAMPS

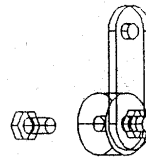
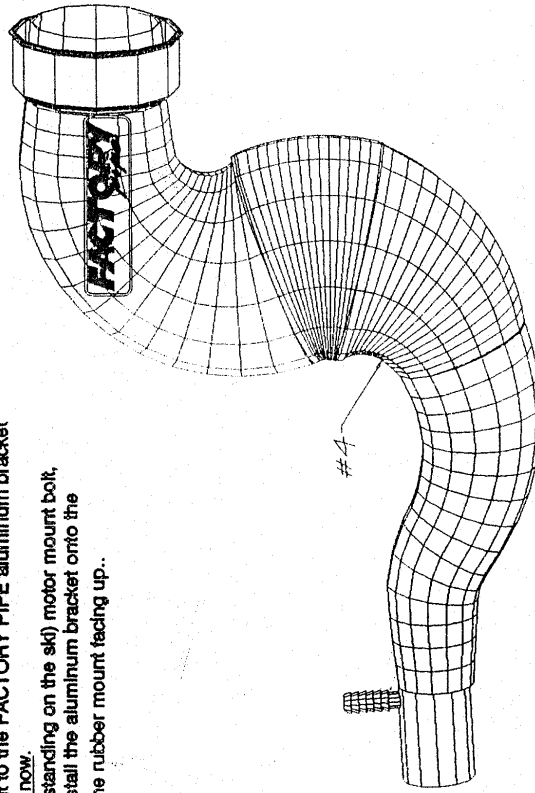
FACTORY 91-93 550 LTD. PIPE ASSEMBLY INSTRUCTIONS

STEP #1

Remove your stock exhaust "bread box". Remove the 3, 8mm studs from the stock "bread box". Install those same studs into your new **FACTORY** PIPE aluminum flange(#8). REMOVE THE STOCK GASKETS FROM THE STOCK 180 DEGREE ALUMINUM ELBOW AND REPLACE WITH THE **FACTORY** PIPE #2 AND #3 GASKETS. Bolt the **FACTORY** PIPE aluminum flange to your stock exhaust manifold.

Bolt the male end of the rubber mount to the **FACTORY** PIPE aluminum bracket using the 3/8-16 nut provided, tighten now.

Remove your stock left front (as your standing on the ski) motor mount bolt, toss the fat stainless steel washer. Install the aluminum bracket onto the motor mount "FINGER TIGHT" with the rubber mount facing up..



Place the chamber in the ski **WITHOUT** the silicone hoses. Rotate the aluminum bracket to line the rubber mount up with the bracket that's welded to the chamber. Tighten the aluminum bracket/motor mount. Double check the alignment of the rubber mount with the bracket on the chamber. Remove the chamber from the ski.

STEP #2

..Install the 4" silicone coupler onto the FACTORY PIPE aluminum flange, and secure with a 100-120mm hose clamp(#6). Slip your FACTORY PIPE chamber into the silicone coupler. Install the 1-3/4"x4-1/2" silicone hose onto the waterbox and chamber. Secure with the stock KAWASAKI hose clamps. Secure with the 3/8-16 bolt and lock washer into the chamber bracket/ rubber mount FINGER TIGHT. Check to make sure the pipe doesn't hit anything. You may have to rotate the pipe around a bit to clear everything, but it will clear. Install the remaining 100-120mm hose clamps onto the 4" silicone coupler and tighten. Tighten the clamps on the 1-3/4" hose tighten the 3/8-16 bolt into the rubber mount. Install the 3/8" waterline onto the barbed fittings on the flange and the chamber. Tighten the clamps.

THIS DOES NOT LINE UP WITH THE HOLE IN YOUR STOCK MANIFOLD BY DESIGN!!

