

**\*\*\* FOR COMPETITION USE ONLY as per US EPA regulations \*\*\***

**Factory Pipe**  
**Bill of Materials**  
**Yamaha GP1200R Triple Pipe**  
**Down Stream Exhaust Kit**

<b><u>Item</u></b>	<b><u>Qty</u></b>	<b><u>Part Number</u></b>	<b><u>Part Description</u></b>
-	1	COMASM0934	GP1200R Waterbox hardware kit (contains items 1-10)
1	2	COMHOS0110	5" Silicone coupler (2-3/8" long)
2	4	COMCLP0080	#600 S.S. 5 " High torque clamp
3	6	COMCLP0021	#32 S.S. 2" High torque clamp
4	3	COMHOS0081	2" Silicone coupler (4" long)
5	1	COMGAS0355	429 Buna N o-ring
6	4	COMFAS0006	6 x 1.0 x 16 S.S. Hex head bolt
7	4	COMFAS0009	6mm S.S. Flat washer with 3/4" OD
8	1	COMFTG0093	1/4" NPT Pipe plug
9	2	COMRED0001	GP1200R Mag/Ctr stinger reducer
10	1	COMRED0002	GP1200R PTO stinger reducer
11	1	COMST12006	GP1200R Waterbox PTO stinger, 2"
12	1	COMST12004	GP1200R Waterbox CTR stinger, 2"
13	1	COMST12005	GP1200R Waterbox Mag stinger, 2"
14	1	COMCH1200WB01	GP1200R Waterbox only
15	1	COMTUB0010	GP1200R Waterbox thru-hull flange w/ 5" crossover tube
16	1	COMTUB0009	GP1200R Waterbox CTR crossover tube, 5"

- < **CHECK CONTENTS AGAINST BILL OF MATERIALS. REPORT ANY SHORTAGES WHERE YOU PURCHASED YOUR FACTORY PIPE.**
- < **READ ALL INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION.**
- < **CARBURETOR ADJUSTMENTS MAY BE REQUIRED BEFORE RUNNING THIS EXHAUST KIT**

**Factory Pipe Instructions**  
**Yamaha GP1200R Triple Pipe**  
**Down Stream Exhaust Kit**

Disconnect the battery and remove it from the battery box. Disconnect the coil wires and any other wires connected to the side of the battery box. Then remove the battery box and electrical box. Remove your existing triple pipe stinger tubes and collector. Now remove the complete rear section of the exhaust including the waterbox. Be sure to save the waterbox strap as you will use it with your new Factory Pipe waterbox. To give yourself more room to work we recommend removing the PTO chamber. Remove the pump assembly including the impeller housing. After this has been completed you are now ready to install the down stream exhaust system.

**REAR OUTLET**

Locate (Item #17) the paper template included in this kit. This template will aid you in the installation of the 5" rear outlet. Set up the template per the instructions located on the template. If you do not have this template do not attempt this installation as the location of this outlet is very important. You will only get one chance so take your time.

Now that you have the outlet hole cut and drilled per the template you can install the rear flange section of the down stream exhaust system. Locate (Item #15) thru-hull flange w/ 5" crossover tube. Secure the flange section using (Items #5,6,7) 429 Buna N O-ring, 4 - 6mm x 16mm hex bolts and 4 - 6mm flat washers. The 5" O-ring seals this surface but you can also use marine grade silicone around the bolt holes to aid in the sealing.

**STINGER INSERTS**

With the down stream exhaust system you will need to install smaller stingers into your existing Factory Pipe Triple Pipes. Locate (Items #9,10) Stinger inserts. These stingers are mandatory for proper performance gains with this kit. These stingers have been designed to slide into the inner jacket of your triple pipes. When stingers are in place you can use a punch to crimp the inside stinger jacket around the new stinger inserts. You may also choose to have these stinger inserts welded in. If you choose to weld them make sure to leave the water jacket open as water from the outer jacket cools the inner jacket. A couple of small welds will be sufficient.

**WATERBOX AND STINGER TUBES**

The next step will be installing the waterbox (item #14). Place your new waterbox in the hull in the same location as the OEM waterbox. Locate (Item #16) the center crossover tube. Before strapping the waterbox in place you will need to install the center section of the outlet tube and tighten all hose clamps. Now strap the waterbox in place. Locate (Items # 3,4) 2" hose clamps, 2" silicone hose couplers. Place these silicone hoses and hose clamps on the tubes that are located on the front of the waterbox. Go ahead and clamp silicone hoses to the waterbox and slide the other clamps on the hoses and leave loose for now. Locate (Item #13) the mag stinger tube will be installed first. You may do a complete install on this tube and tighten all clamps. Locate (Item #12) the center stinger tube. You may install the waterbox side and clamp but do not install on the pipe stinger. You will need to install the PTO chamber at this time. Now go back and finish the installation of the center stinger tube and clamp. Locate (Item #11) the PTO stinger tube and install and finish tightening all clamps.

Now you may reinstall the battery box and reconnect any wires that you may have disconnected. Reconnect the battery and your installation should be complete. It is always a good idea to double

check all connections and clamps.