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## Sea Doo 785/800 Billet Head Instructions

<u>Quantity</u>	<u>ADA Part#</u>	<u>Description</u>
1	SD800	Billet head Shell
2	SD80cc	Removable Dome (last 2 #'s=dome size)
2	OR020	Oring Around Top of Dome
2	OR024	Head Shell to Dome Oring
1	BF1415	1/4" npt x 1/2" Brass Barb
2	BF18PLG	Brass Plug - 1/8" npt

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### **Read First!**

Please read these instructions completely through before starting the installation.

The water outlets are on the intake side of the ADA Racing® billet cylinder head. The head must be installed this way for proper cooling.

Do not use silicone or gasket sealer on any of the head surfaces.

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### **Installation Procedure**

- 1) Remove the stock head and clean the top surface of the cylinder.
- 2) Install the domes and all orings in the ADA billet head. Use grease to hold orings in place, do not use glue or gasket sealer of any kind!
- 3) Check the length of the stock head bolts to insure that they are not too long. To do this, remove the stock orings from the top of the cylinders. Place the billet head on top of the cylinders and install one of the head bolts. Check to see if the bolt tightens down onto the head or if the bolt bottoms out in the threads. If the bolt bottoms out, you will either need to shorten the stock head bolts or use washers(not provided). Remove the bolt and the billet head.
- 4) Wipe the stock orings clean and place back into their respective grooves in the top of the cylinders.
- 5) Place the ADA Racing® billet head onto the top of the cylinder, with the water outlets on the intake side. Install and hand tighten the stock head bolts, after having made sure the length is correct.
- 6) Torque the head bolts to 15 ft/lbs, starting from the bolts in the center of the head and working your way out in a criss-cross pattern.
- 7) Now, torque the head bolts to 18 ft/lbs in the center-out criss-cross pattern.
- 8) Water routing can be done in a number of different ways, the 2 most common are described below. For both of the described ways you will install the 2 1/8" npt brass plugs into the holes in the ADA Racing® billet head. These are additional water outlets for custom applications. The 1st way to route the water and for warmer water temperature applications, run the 1/2" water inlet line from the pump to the 1/2" hose barb fitting in the center of the head. Then run the 1/2" line from the bottom of the head pipe to the outlet in the rear of the boat. For cold water applications, reverse the water flow. Run the water in the bottom of the head pipe and have it exit out the head. These are the 2 most basic ways to route the water flow and they will work with the stock pipe and most aftermarket exhaust systems as well. One thing to remember, since the cylinders are separate, always keep equal flow to and from both cylinders if using the 2 additional 1/8" npt outlets/inlets provided in the top of the billet head.
- 9) Carb jetting should not be required, but you should check plug color as with any performance enhancing modification.