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## Sea Doo 951 Billet Head Instructions

<u>Quantity</u>	<u>ADA Part#</u>	<u>Description</u>
1	SD951	Billet head Shell
2	SD95cc	Removable Dome (last 2 #'s=dome size)
2	OR044	Compression Oring - Dome to Cylinder
2	OR024	Head Shell to Dome Oring
2	OR020	Oring Around Top of Dome
1	ORSD951	Outer Head Shell Water Sealing Oring
2	BF18PLG	Brass Plug - 1/8" npt

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### **Read First!**

Please read these instructions completely through before starting the installation.

You must remove the water fitting from the stock head and install it in the ADA Racing® billet head. Plug the 2 additional holes in the ADA head with the supplied brass plugs. The additional water outlets are provided for custom water routing applications. This head is designed to be a bolt-on performance part. If you are using an aftermarket exhaust and water routing is different than stock, please consult the manufacturer of the aftermarket exhaust.

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) Install the ADA Racing® billet head onto the cylinder. Make sure that all orings stay in place and do not come out of their groove, causing them to get pinched.
- 4) First, hand tighten all of the bolts and outer stud nuts. Then snug them with a wrench, working from the center of the head out, in a criss-cross pattern.
- 5) Torque the 8mm head bolts and the outer stud nuts to 15ft/lbs, in a center-out criss-cross pattern.
- 6) Now torque the bolts and nuts to 18ft/lbs.
- 7) Torque the outer nuts to 23ft/lbs, working in a center-out criss-cross pattern.
- 8) Recheck the torque on all of the 8mm bolts to 18ft/lbs and the outer nuts to 23ft/lbs.
- 9) Re-torque the head bolts after the 1st time riding and then periodically thereafter.