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Yamaha GP1200R Billet Head Installation Instructions

<u>Qty</u>	<u>Part#</u>	<u>Description</u>
1	YA1200R	billet head shell
3	YA80cc	dome (last 2#'s = size of dome)
3	OR043	dome compression o'ring - viton
3	OR020	upper dome o'ring (around plug hole)
3	OR024	head shell to dome o'ring
3	OR048	outer head shell o'ring (water sealing)
12	HW8X50HEX	8x50mm hex bolt
4	HW8X55HEX	8x55mm hex bolt
16	HW8MMFLT	8mm flat washer
6	BF1415	1/4npt x 1/2" brass barb fitting
6	HC8	#8 hose clamp
1	WMBYA1200	Water manifold block
2	HW1075SPCR	1.075" tall aluminum spacer

Note: Water outlets are on the intake side and the ADA Head will only install this way. The head must be installed this way for proper water cooling. Silicone is not necessary, on any of the surfaces.

Installation Procedure

- 1) Install all o'rings in ADA Billet Head, use grease to hold them in place(not super glue).
- 2) Apply grease on the OR020 o'ring on the top of the dome, this will allow the dome to easily slide into the head shell.
- 3) Remove the stock head and head gasket and clean the top of the cylinder.
- 4) Double -check to insure that all o'rings are in place on the ADA Billet Head, then place the head on the cylinder with the water outlets on the carburetor side.
- 5) Install the 12 8x50 hex bolts, with flat washers, in all of locations except for the 2 holes where the front bracket mounts and each of the 2 locations where the exhaust bracket mounts. The holes where the exhaust bracket mounts are not recessed and are flush with the top of the head. If not using the exhaust mount brackets, use the 4 8x55 hex bolts, with flat washers, in the locations that are not recessed. If using the exhaust mount brackets, use the stock head bolts for those locations. Also, makes sure that the o'ring provided with the ADA exhaust bracket is in place when installing the bracket. You will also need to use the allen bolt provided with the bracket to secure the bracket to the head shell. On the 2 front head bolt locations use the 2 aluminum spacers to mount the stock bracket using 2 of the stock head bolts. First torque all head bolts to 15ft/lbs and then torque to 18ft/lbs. Start at the center and work outwards from side to side. Do this twice and recheck after the first time out and then check periodically.
- 6) The water routing will be done the same as stock. The ADA head has each cylinders water jacket independent from each other. Water cannot flow from one cylinder to another through the ADA head. If you choose to route the water different than stock, you must remember to keep the outlet resistance equal on each cylinder. For stock routing, install the provided brass fittings into the head and the water manifold. You will then need to use 1/2" waterline to connect the outlet of each head to each one of the brass fitting on the water manifold. You will then need to connect the built-in outlets of the water manifold to the stock hoses that were removed from the stock head. It is best to idle the boat with the seat off the 1st time out, to insure that all waterlines are secured and that there are no water leaks.