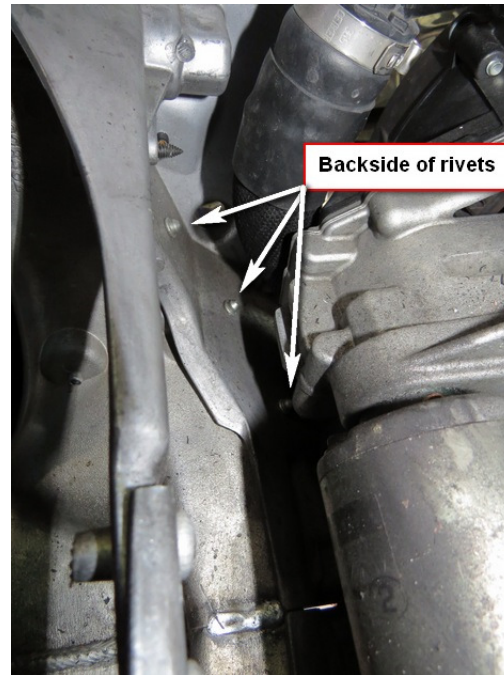
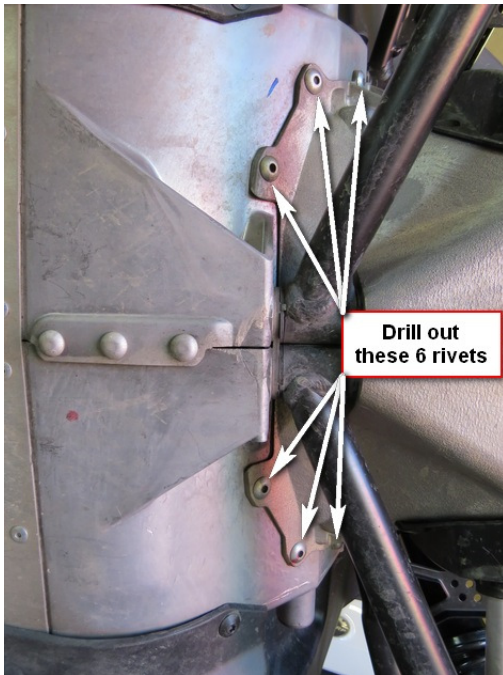




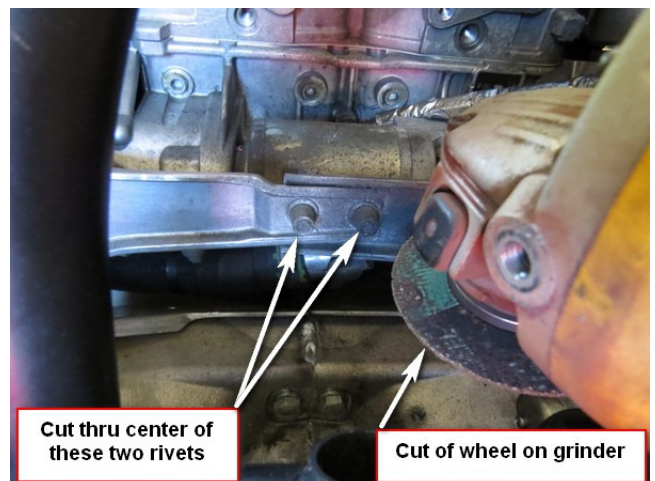
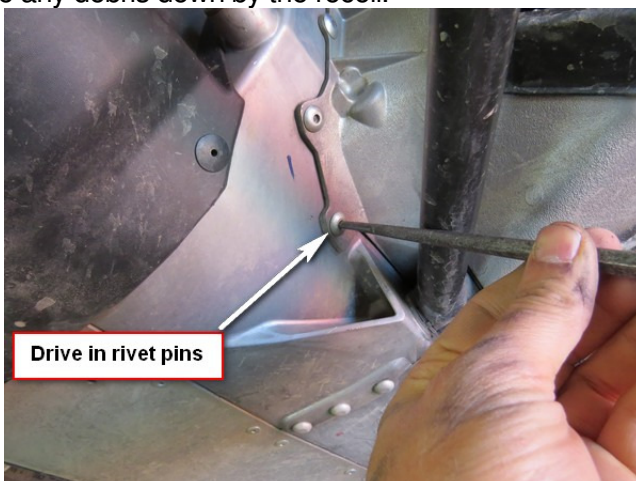
Installation Instructions 2017-20 Skidoo G4 E Module Brace Kit

Tools Needed: 10mm, 12mm, 13mm wrench and sockets, 15/64" and 1/4" drill bit, 6mm ball hex key socket, punch, hammer, small electric drill, cut off wheel.

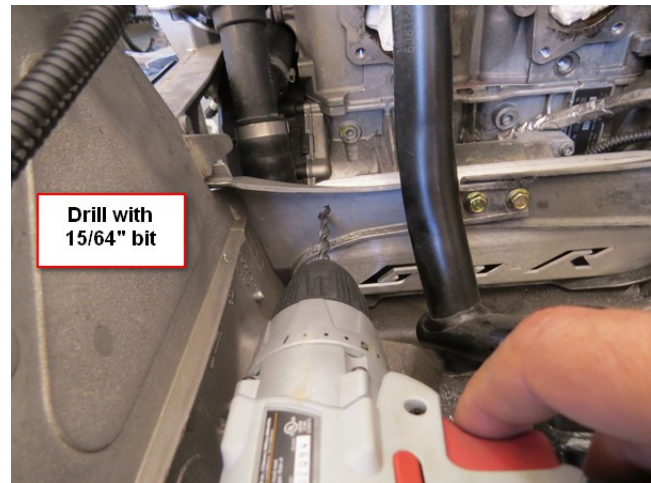
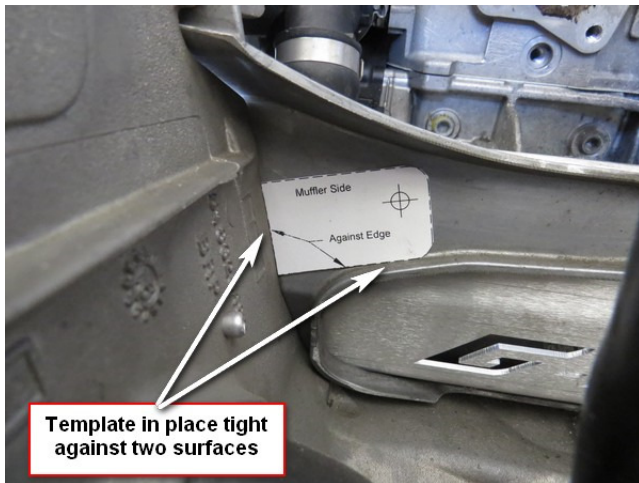
1. Remove both side panels, hood, exhaust pipe, muffler, sway bar and Y pipe.
2. Use a long 6mm ball hex key socket to for the Y pipe bolts. Carefully remove the Y pipe to not damage the gaskets.
3. There are 6 rivets that need to be drilled out. See the pictures below.



4. Use a chair under the left side handle bar and put the sled on the side with the muffler side up. Remove the muffler side shock so you can collapse the a arms to get better access to the rivets.
5. These rivets have a steel pin in the center that needs to be pushed in before drilling. Insert a small punch in the center of the rivet and use a hammer to drive the pins in. Use a 1/4" drill bit to drill the rivets. **Note: You will want to capture these pins and rivets. You don't want these floating around the belly pan as they can work their way into the clutches and cause damage. You can use a piece of duck tape on the inside of the bulkhead over these rivets. The tape will help to catch the rivet debris as you drill so it doesn't fall into the belly pan.**
6. Drill the three muffler side rivets first, reinstall the shock and repeat the same procedure for the clutch side. If any debris falls in the belly pan during the drilling it should move to the recoil side when drilling the three clutch side rivets. Remove any debris down by the recoil.



7. There are two rivets on 2017 sleds connecting the cross braces that need to be removed. Use a cut off wheel to cut thru the center of these rivets. Be careful to only cut the rivet and not the casting. See picture on previous page. After you cut the slot in the rivet use a flat screw driver in the slot to break the rivet. 2018 sleds have bolts.
8. Position E Module Brace plate in place as shown in the picture below. Install two M6x20mm bolts and nuts in the holes that you just cut the rivets out of. Don't tighten these bolts yet just use them to hold the plate in place.
9. Start by hand all six M6x16mm bolts in the rivet holes. Use Blue Loctite on these bolts for added security. Once all the bolts are started in these holes torque all 8 bolts to 106 (in-lbs).
- 10. If you are installing this E Module Brace kit by itself use the included paper template for the next step for 2017 sleds. Use the existing hole on 2018 and newer sleds. If you are also installing our front end brace kit in a 2017 skip step 11 and refer to the front end brace kit instructions. You will use the inside corner braces to locate the hole that needs to be drilled.**
11. Cut out the paper templates on the dotted lines. Position the Muffler side template as shown in the picture below and center punch the hole to be drilled. Repeat this process using the clutch side template to mark the clutch side hole. Drill both holes with a 15/64" drill bit.



12. Install the two M6x20 bolts and nuts in these holes and torque to 106 (in-lbs).
13. Vacuum all the aluminum debris from the drilling and reinstall all the parts you have removed. See the procedure on the next page for reinstalling the Y pipe.



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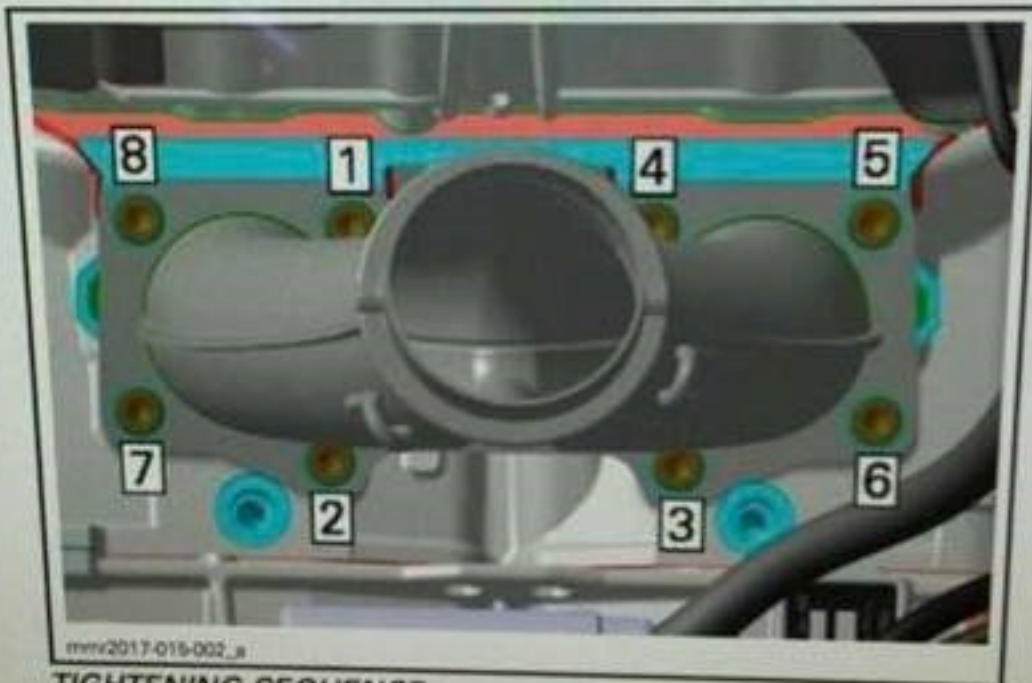
Long 6mm Ball End Hex Key Socket. Can be found at Lowes or Home Depot for \$6-\$7.



Use Blue Loctite on the Y Pipe bolts

Tighten the bolts in the sequence shown below in two steps.
Step A torque to 62 inch-lbs (or 5 ft-lbs). Final step is 25 ft-lbs.

NOTE: Perform step A on all manifold screws before proceeding with step B.



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TIGHTENING SEQUENCE

TIGHTENING PROCEDURE		
Exhaust manifold screws	Service product	LOCTITE 243 (BLUE) (P/N 293 800 060)
	Step A	7 N•m ± 0.5 N•m (62 lbf•in ± 4 lbf•in)
	Step B	34 N•m ± 4 N•m (25 lbf•ft ± 3 lbf•ft)

4. Install...