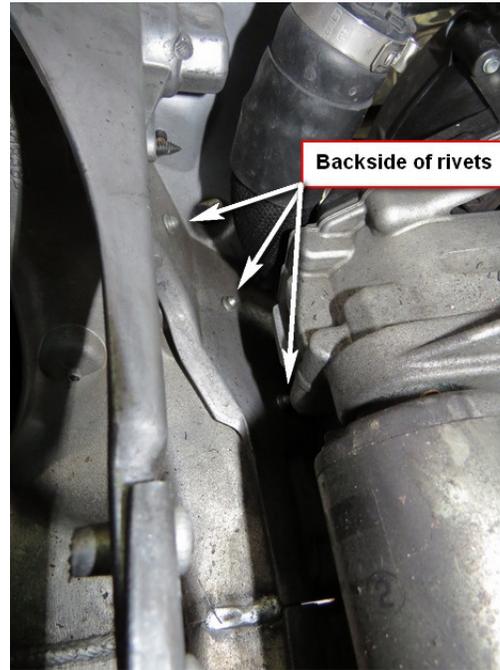
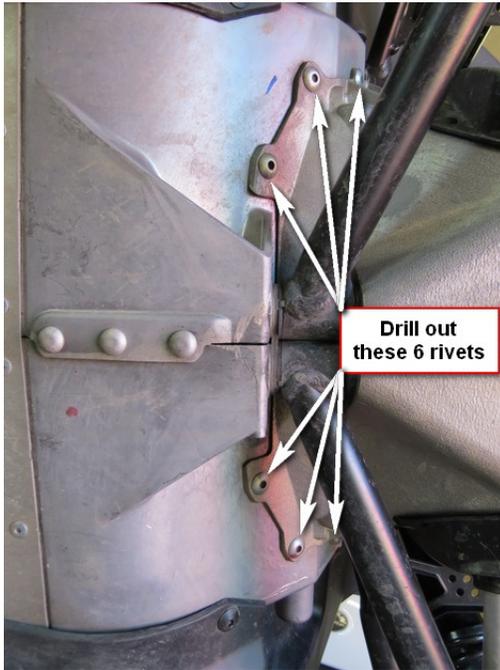




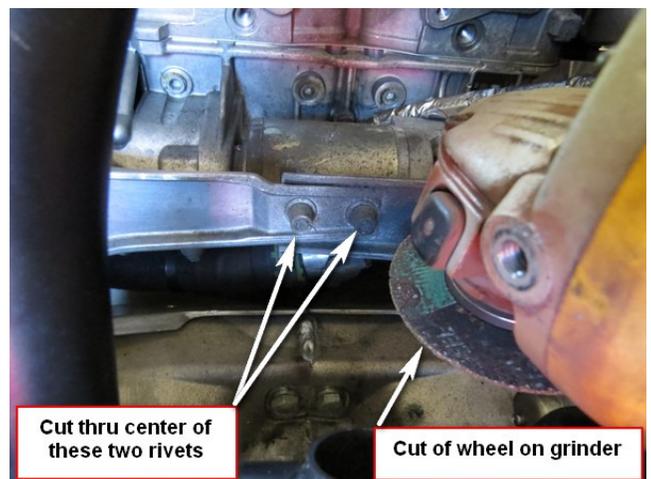
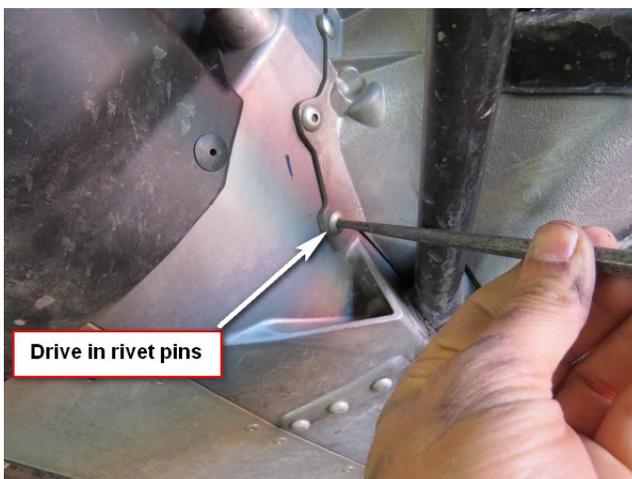
Installation Instructions 2017 Skidoo G4 E Module Brace Kit

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

1. Remove both side panels, hood, exhaust pipe, muffler, Y pipe and sway bar.
2. There are 6 rivets that need to be drilled out. See the pictures below.



3. 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.
4. 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 hold the pins and rivet debris as you drill so it doesn't fall into the belly pan.
5. 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.



6. There are two rivets 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.
7. 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.



8. 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).
9. If you are installing this E Module Brace kit by itself use the included paper templates for the next step. If you are also installing our front end brace kit you will use the corner braces to locate the holes for the next step.
10. Cut out the paper templates on the dotted lines. Position the Muffler side template as shown in the picture above 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.



11. Install the two M6x20 bolts and nuts in these holes and torque to 106 (in-lbs).
12. Vacuum all the aluminum debris from the drilling and reinstall all the parts you have removed.

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