



## JCR-1075-SET

### INSTALLATION INSTRUCTIONS SXR 1500 REAR SPONSONS

Check out the install video on our website!

<https://jcracing.com/product/sxr1500-rear-sponsons/>

#### Included in the package are the following parts:

Base Sponson Set

Mid Sponson Set (if added on)

Rear Blade Sponson Set

Hardware:

8X M6-1 X 35mm Long Socket Head Cap Screws (Base Sponson to Hull)

16X M6-1 X 12mm Long Low Profile Socket Head Cap Screws (Rear Blades)

4X M5-.8 X 12mm Long Flat Head Socket Cap Screws (Mid Sponsons/filler plates to Base Sponsons)

4X M6-1 X 30mm Long Button Head Cap Screws (Mid Sponsons if added)

8X M6 Flat Washers (Mid Sponsons if added)

4X M6-1 Nylock Nuts (Mid Sponsons if added)

#### What you will need:

¼" drill bit and drill (If mounting mid sponsons)

C-Clamp (If adding connected mid sponsons)

Marine Grade Silicone (optional)

10mm wrench, M4 and M5 allen keys

1. Remove existing sponsons and clean the surfaces where the sponson will be installed.
2. If you ordered the connected mid sponsons, drill out the 6<sup>th</sup> and 7<sup>th</sup> rivet from the rear using a ¼" drill bit. If you are using our #219 mid sponsons, follow the instructions that came with them.

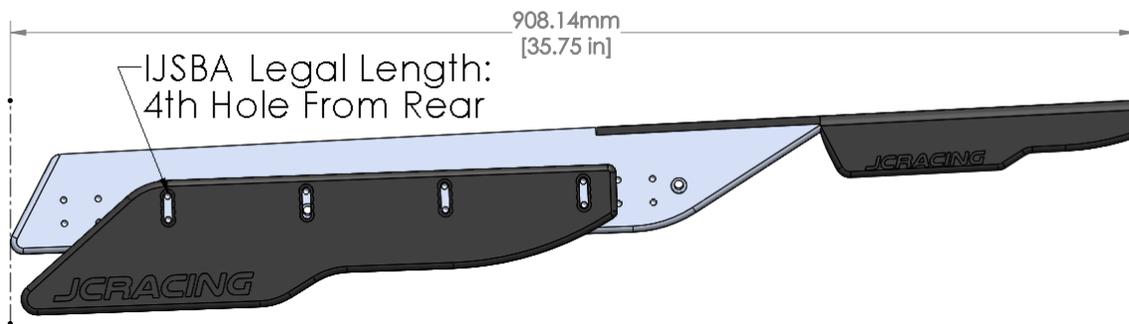


3. Attach the connected mid sponsons (or the filler plates if you didn't order the connected mid sponsons) to the base sponsons using 2X M5 flat head screws on each side.
4. Test fit the sponson dry first, then spread a very thin layer of marine grade silicone (optional) around the surface of the sponson that contacts the hull and on the 4 holes that mount against the hull.

- Align the front hole of the new sponson with the front threaded insert on the hull. Tap the bottom of the sponson up and towards the hull until it “pops” in. Make sure the holes are aligned if you are having trouble. It shouldn’t take more than a smack with the palm of your hand or a rubber mallet. If necessary, use a C Clamp to squeeze the bottom of the base sponson up against the underside of the bond flange to align the 4 holes.
- While pushing up on the sponson to assure the sponson is pressed up firmly under the bond flange, tighten the 4 M6-1 X 35mm long screws.
- Use a C-Clamp as shown to assure the mid sponson (if installing) is all the way up underneath the bond flange with no gap in the front. Match drill through the rivet holes and through the mid sponson. Secure the mid sponson using the 4 Button Head screws, flat washers and nylock nuts, then remove C-Clamp once tight.



- Mount the rear blade using the supplied M6 X 12mm long low profile screws. Note that 8 per side were supplied only if you want to mount them at the lowest position which leaves 2 inches of blade below the base sponson. **We suggest starting with that position** and on the 4<sup>th</sup> from the rear holes as shown in the picture below. Please note that if you are racing IJSBA sanctioned events, the overall length of this sponson CAN NOT exceed 36 inches in overall length **AND** the rear tip of the blade can not exceed the outside of the bond flange when the plastic bumper is removed. If you mount the rear blade on any of the holes towards the rear from the 4<sup>th</sup> hole shown, you will get disqualified. The holes that were added to the rear are purely for testing and recreational use. If you are not using the connected mid sponson, and you are using our “Race” rear blade, you can legally mount the “race” blade all the way in the back.



- Repeat the install for the other side.

If you have any questions on the install, please feel free to call or email us:

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