



SEA-DOO® JET BOATS



SPEEDSTER

5 8 9 4

SPORTSTER

5 8 9 5

CHALLENGER

5 8 9 6

**S H O P
M A N U A L**

2 1 9 1 0 0 0 4 4



SEAFOOD®
JET BOATS

*1996
Shop Manual*

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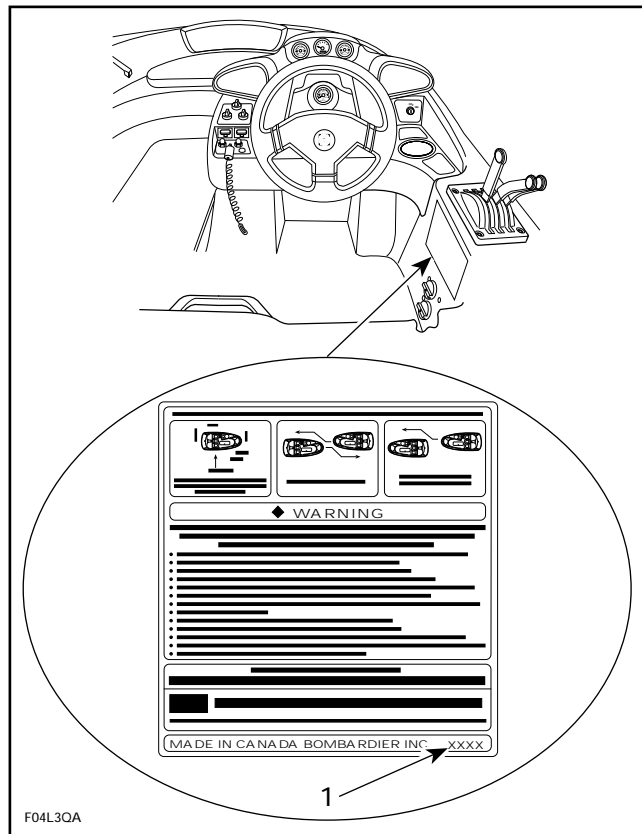
INTRODUCTION

This Shop Manual covers the following BOMBARDIER made SEA-DOO® jet boats.

MODEL	MODEL NUMBER
SPORTSTER	5895
SPEEDSTER	5894
CHALLENGER	5896

BOAT MODEL NUMBER

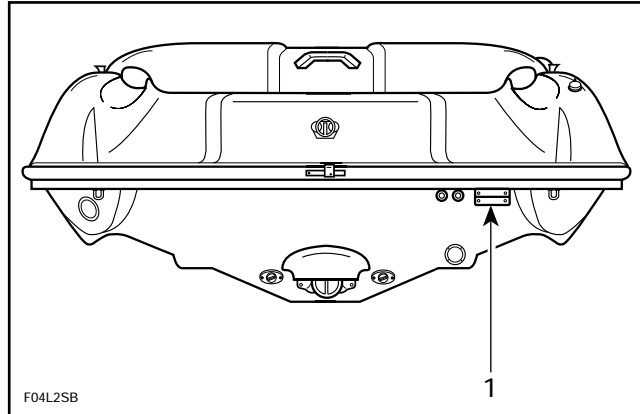
The jet boat model number can be found on RH side of operator position.



1. Model number

HULL IDENTIFICATION NUMBER (H.I.N.)

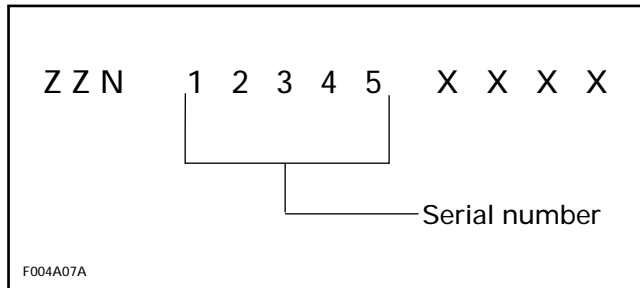
The Hull Identification Number (H.I.N.) is located at right hand rear side of hull.



TYPICAL

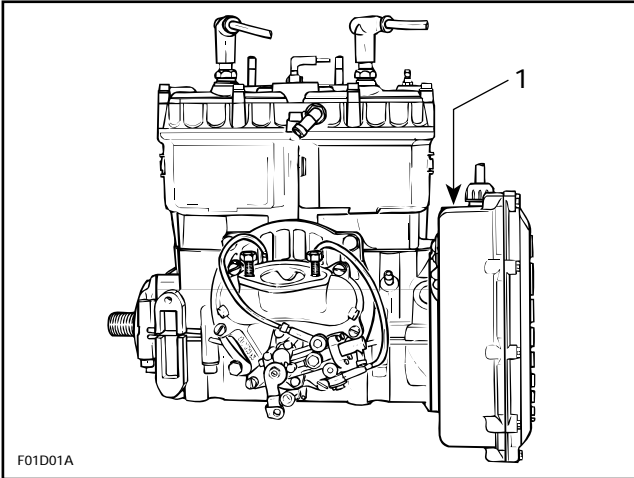
1. Hull Identification (H.I.N.)

The 5 digits after ZZN are the boat serial number.



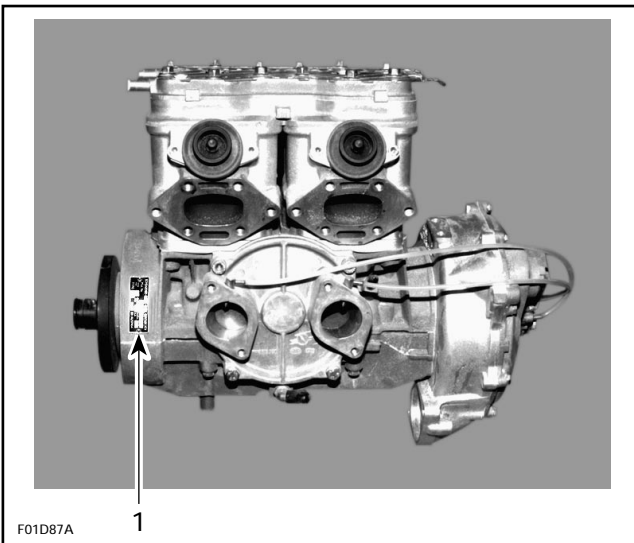
ENGINE IDENTIFICATION NUMBER (E.I.N.)

It is located on the upper side of the magneto housing.



TYPICAL-717 ENGINE

1. Engine Identification Number (E.I.N.)



787 ENGINE

1. Engine Identification Number (E.I.N.)

ARRANGEMENT OF THIS MANUAL

The manual is divided into 12 major sections :

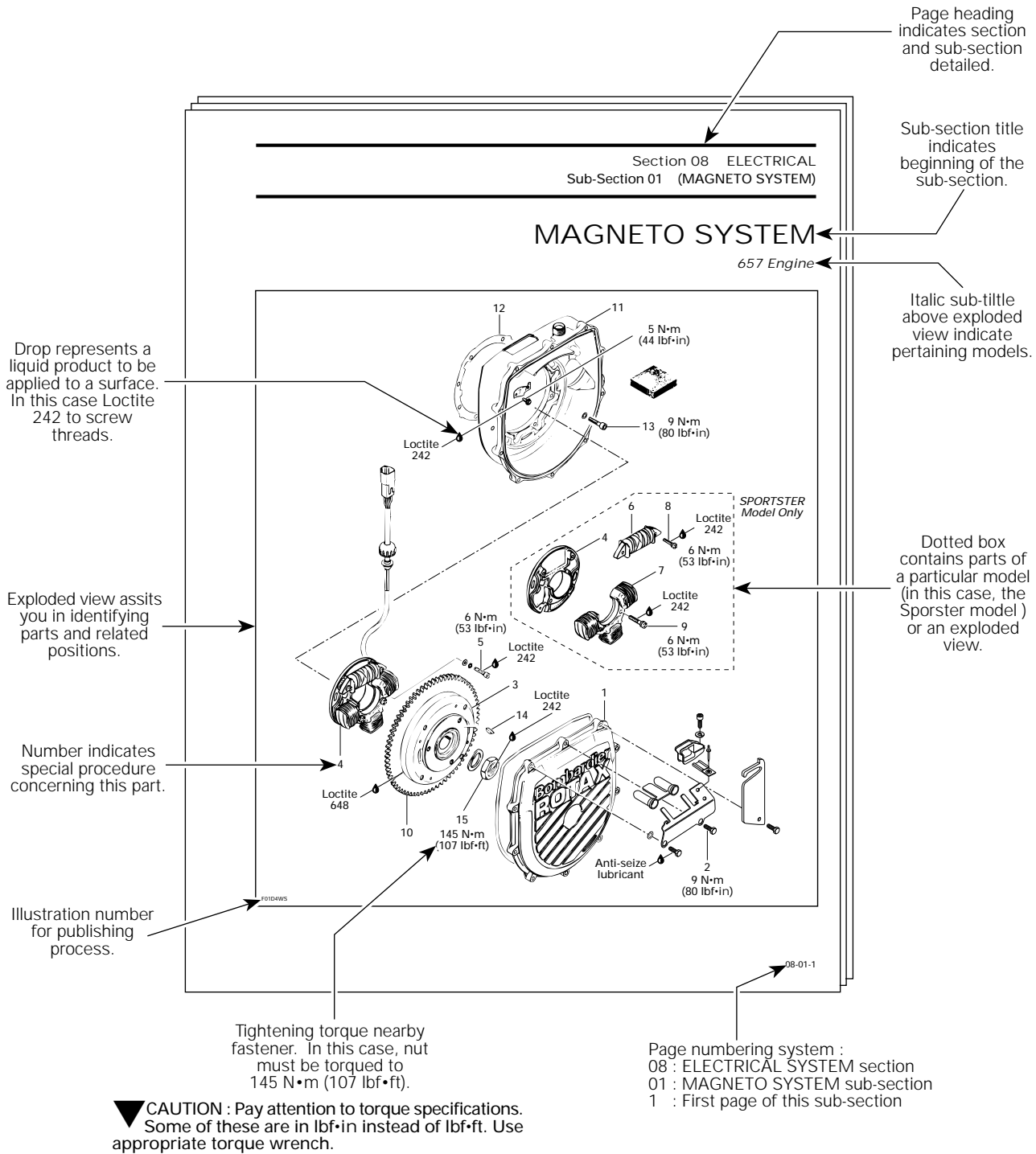
- 01 SERVICE TOOLS AND PRODUCTS
- 02 MAINTENANCE
- 03 TROUBLESHOOTING
- 04 ENGINE
- 05 COOLING SYSTEM
- 06 FUEL SYSTEM
- 07 LUBRICATION SYSTEM
- 08 ELECTRICAL
- 09 PROPULSION AND DRIVE SYSTEMS
- 10 STEERING SYSTEM
- 11 HULL / DECK
- 12 TECHNICAL DATA

Each section is divided in various sub-sections, and again, each sub-section has one or more division. A table of contents is included at the beginning of most sections.

1996 BOMBARDIER JET BOAT SHOP MANUAL

This *Shop Manual* uses technical terms which may be slightly different from the ones in the *Parts Catalog*.

TYPICAL PAGE



1996 BOMBARDIER JET BOAT SHOP MANUAL

This *Shop Manual* uses technical terms which may be slightly different from the ones in the *Parts Catalog*.

TYPICAL PAGE

Section 08 ELECTRICAL
Sub-Section 01 (MAGNETO SYSTEM)

MAGNETO SYSTEM
657 Engine

Page heading indicates section and sub-section detailed.

Sub-section title indicates beginning of the sub-section.

Italic sub-title above exploded view indicate pertaining models.

Drop represents a liquid product to be applied to a surface. In this case Loctite 242 to screw threads.

Exploded view assists you in identifying parts and related positions.

Number indicates special procedure concerning this part.

Illustration number for publishing process.

Tightening torque nearby fastener. In this case, nut must be torqued to 145 N•m (107 lbf•ft).

SPORTSTER Model Only

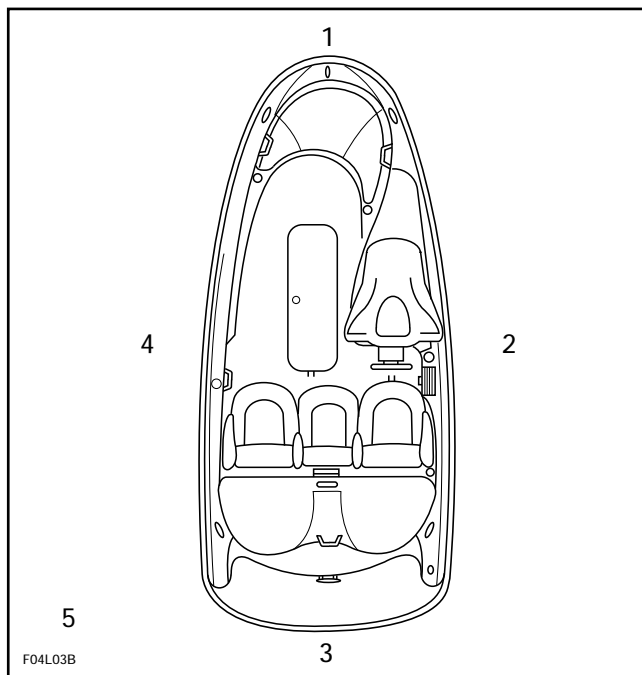
Dotted box contains parts of a particular model (in this case, the Sportster model) or an exploded view.

Page numbering system :
08 : ELECTRICAL SYSTEM section
01 : MAGNETO SYSTEM sub-section
1 : First page of this sub-section

CAUTION : Pay attention to torque specifications. Some of these are in lbf•in instead of lbf•ft. Use appropriate torque wrench.

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GENERAL INFORMATION



1. BOW (front)
2. STARBOARD (RH)
3. STERN (rear)
4. PORT (LH)

5. In marine industry, PORT, STARBOARD, BOW and STERN are used to refer to LEFT, RIGHT, FRONT and REAR respectively. They always refer to the operator's position sitting in boat.

The information and component / system descriptions contained in this manual are correct at time of publication. Bombardier Inc. however, maintains a policy of continuous improvement of its products without imposing upon itself any obligation to install them on products previously manufactured.

Bombardier Inc. reserves the right at any time to discontinue or change specifications, designs, features, models or equipment without incurring obligation.

This Shop Manual uses technical terms which may be different from the ones of the Parts Catalogs.

When ordering parts always refer to the specific model Parts Catalogs.

ILLUSTRATIONS AND PROCEDURES

The illustrations show the typical construction of the different assemblies and, in all cases, may not reproduce the full detail or exact shape of the parts shown, however, they represent parts which have the same or a similar function.

▼ **CAUTION** : These boats are designed with parts dimensioned in both the metric and the imperial systems. When replacing fasteners, make sure to use only those recommended by Bombardier. Mismatched or incorrect fasteners could cause damage to the boat or possible personal injury.

As many of the procedures in this manual are interrelated, we suggest, that before undertaking any task, you read and thoroughly understand the entire section or sub-section in which the procedure is contained.

A number of procedures throughout the book require the use of special tools. Before commencing any procedure, be sure that you have on hand all the tools required, or approved equivalents.

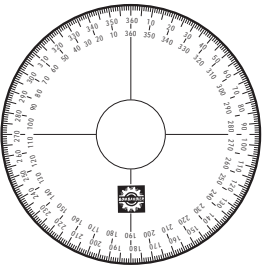
Technical Publications
Bombardier Inc.
Valcourt (Quebec), Canada

MANDATORY TOOLS

O NOTE : The numbers outlined in black (example : **1**) are reference numbers to tools from other divisions (Sea-Doo and / or Sea-Doo Jet Boats). Matching numbers are the same tool even if the part numbers are different.

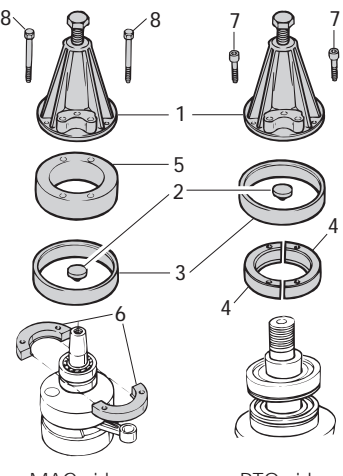
ENGINE

Degree wheel
 P / N 295 000 007 **1**



A00B334

APPLICATION
 All models.



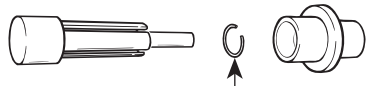
MAG side PTO side

F01D884

1) Puller P / N 290 876 298	200
2) Protective cap (both ends) P / N 290 876 557	554
3) Ring (both ends) P / N 290 977 490	555
4) Ring halves (PTO) P / N 290 977 475 (2)	556
5) Distance ring (MAG) P / N 290 876 569	557
6) Ring halves (MAG) P / N 290 276 025 (2)	558
7) Screw M8 x 40 P / N 290 840 681 (2)	559
8) Screw M8 x 70 P / N 290 841 201 (2)	560

APPLICATION
 All models.

Piston circlip installer
 A) P / N 295 000 077 **202**
 B) P / N 290 877 016 **548**

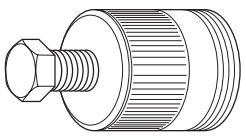


Piston circlip

A01B1P4

APPLICATION
 A) 587 engine.
 B) 657 and 717 engines.

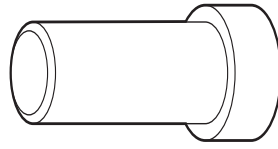
Puller
 P / N 295 000 106 **5**



A00C1A4

APPLICATION
 All models.

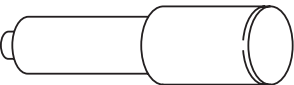
Pusher
 P / N 290 876 605 **229**



A00C0Y4

APPLICATION
 All models.

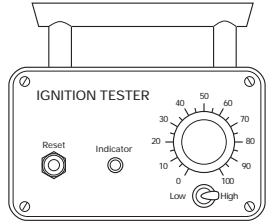
Pusher
 P / N 290 876 500 **12**



A00B2J4

APPLICATION
 All models.

Bombardier ignition tester
 P / N 295 000 008 **236**

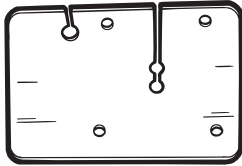


A00C1K4

APPLICATION
 All models.

Section 01 SERVICE TOOLS AND PRODUCTS
 Sub-Section 01 (MANDATORY TOOLS)

Rubber pad **547**
 P / N 295 000 101



F01B0J4

Puller plate **549**
 P / N 290 876 080



A00C1R4

Extension handle **550**
 P / N 295 000 125



F01D164

Screw M8 x 35 (3) **551**
 P / N 290 841 591



F00A094

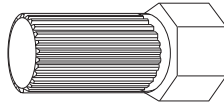
Sleeve (3) **552**
 P / N 290 847 220



F00A0A4

APPLICATION
 All models.

PTO flywheel remover / installer **553**
 P / N 295 000 001



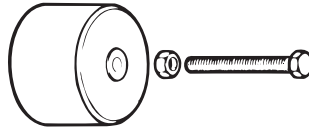
F01J0T4

APPLICATION

All models.

NOTE : This tool is also used for the impeller.

Puller **562**
 P / N 290 876 488

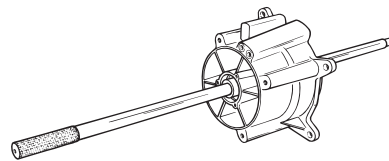


F01B0I4

APPLICATION

All models.

- A) Alignment tool support **563**
 P / N 295 000 090
- B) Alignment shaft **571**
 P / N 295 000 093

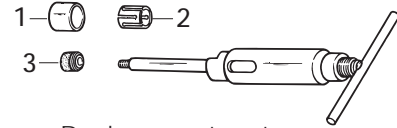


F01L2R4

APPLICATION

All models.

Piston pin puller **566**
 P / N 295 000 092



Replacement parts :

- 1. Locating sleeve **772**
 P / N 290 877 181
- 2. Expansion sleeve **771**
 P / N 290 877 041
- 3. Extracting nut **770**
 P / N 290 877 155

F01B0V4

APPLICATION

All engines.

MPEM programmer **567**
 P / N 295 000 127



F01B254

APPLICATION

787 engine.

Section 01 SERVICE TOOLS AND PRODUCTS
Sub-Section 01 (MANDATORY TOOLS)

Ring gear blocking tool
P / N 295 000 134

568



F01B264

APPLICATION
787 engine.

Ring gear puller tool
P / N 420 976 235

569



F01B294

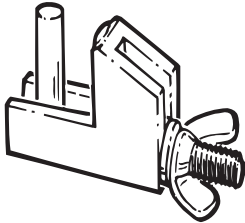
APPLICATION
787 engine.

Section 01 SERVICE TOOLS AND PRODUCTS
Sub-Section 01 (MANDATORY TOOLS)

COOLING / FUEL / OIL SYSTEMS

Hose pincher
P / N 295 000 076

2

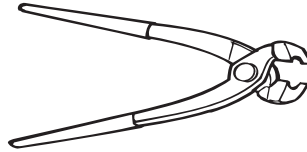


A01B214

APPLICATION
All models.

Pliers
P / N 295 000 070

601

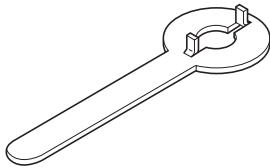


F01D174

APPLICATION
All models.

Gear holder
P / N 290 277 905

235

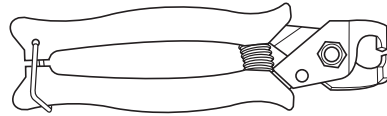


A00C164

APPLICATION
717 engine.

Pliers
P / N 295 000 054

606



F01B1T4

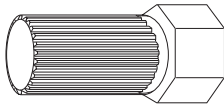
APPLICATION
All models.

NOTE : This tool is also used for the propulsion system.

PROPULSION SYSTEM

Impeller remover /
installer
P / N 295 000 001

553



F01J0T4

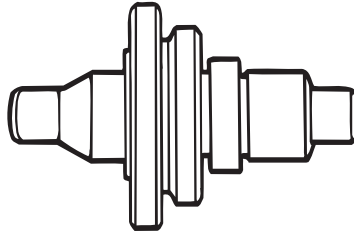
APPLICATION

All models.

O NOTE : This tool is also used for the PTO flywheel.

Bearing / seal installer
P / N 295 000 107

604



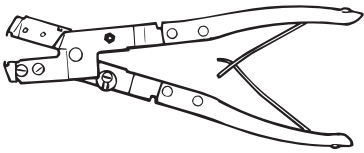
F01J4K4

APPLICATION

All models.

Pliers
P / N 295 000 069

602



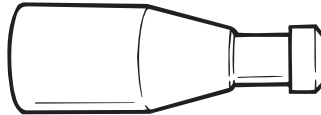
F01D184

APPLICATION

All models.

Impeller shaft guide
P / N 295 000 002

605



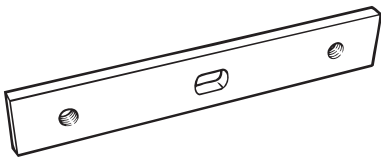
F01J104

APPLICATION

All models.

Impeller shaft holder
P / N 295 000 082

603



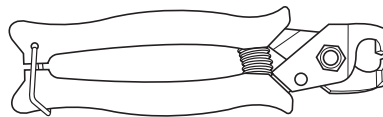
F01B0W4

APPLICATION

All models.

Pliers
P / N 295 000 054

606



F01B1T4

APPLICATION

All models.

O NOTE : This tool is also used for the fuel system.

RECOMMENDED TOOLS

O NOTE : The numbers outlined in black (example : **1**) are reference numbers to tools from other divisions (Sea-Doo and / or Sea-Doo Jet Boats). Matching numbers are the same tool even if the part numbers are different.

ENGINE

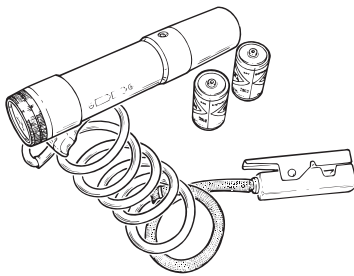
Ring compressor **766**
 P / N 290 876 979



A01B1T4

APPLICATION
 All engines.

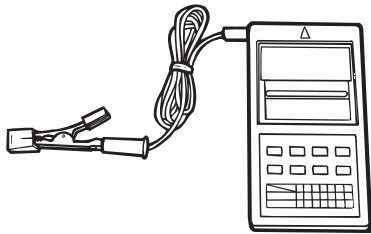
Stroboscopic timing light **225**
 P / N 295 000 078



A01B2K4

APPLICATION
 All models.

Digital / induction type tachometer **237**
 P / N 295 000 100



F01B1G4

APPLICATION
 All models.

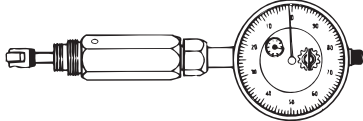
Coil centering tool **209**
 P / N 290 876 922



A01B1V4

APPLICATION
 717 engine.

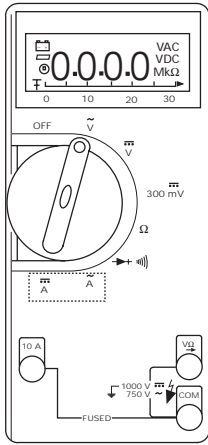
Dial indicator (TDC gauge) **230**
 P / N 295 000 143



A00B2E4

APPLICATION
 All models.

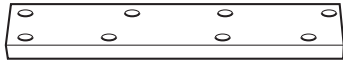
Digital multimeter **242**
 P / N 529 022 000



F01B1O4

APPLICATION
 All models.


Cylinder aligning tool **220**
 P / N 290 876 904



A00B084

APPLICATION
 All models.

Distance gauge **561**
 A) P / N 290 876 827 **760**
 B) P / N 290 876 828

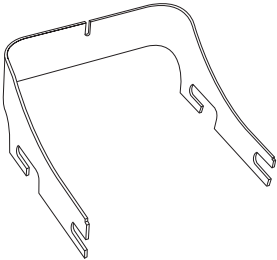


F01B0H4

APPLICATION
 A) 717 engine.
 B) 787 engine.

Section 01 SERVICE TOOLS AND PRODUCTS
 Sub-Section 02 (RECOMMENDED TOOLS)

Timing mark pointer **774**
 P / N 295 000 130



F01B204

APPLICATION
 717 engine.

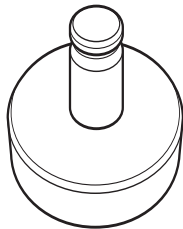
Timing mark pointer **754**
 P / N 295 000 135



F01H544

APPLICATION
 787 engine.

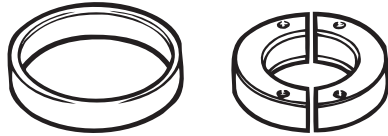
Oil seal pusher **759**
 P / N 290 877 740



F01B2C4

APPLICATION
 787 engine.

Ring halves and ring
 P / N 290 876 330 (halves) **761**
 P / N 290 876 480 (ring) **762**



F01B2D4

APPLICATION
 787 engine.

Engine lifting device
 Not sold by Bombardier
 Do it yourself
 Refer to *Shop Manual* section
 04-01

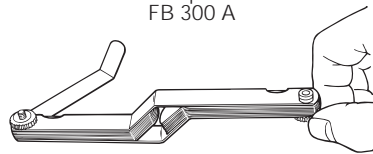


F01D0A4

APPLICATION
 All models.

Feeler gauge 45°
 Not sold by Bombardier

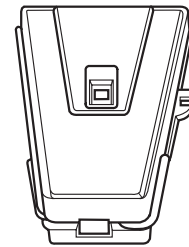
Snap-on
 FB 300 A



F01B1K4

APPLICATION
 All models.

Spark tester
 Not sold by Bombardier
 Superex Canada Ltd
 No. 15-785

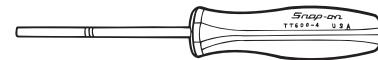


F01B1H4

APPLICATION
 All models.

Terminal remover
 Not sold by Bombardier

Snap-on
 TT 600-4

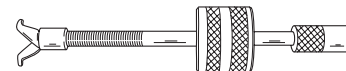


F01B1J4

APPLICATION
 All models.

Slide hammer puller
 Not sold by Bombardier

Snap-on : Handle CJ93-1
 Hammer CJ125-6
 Claws CJ93-4



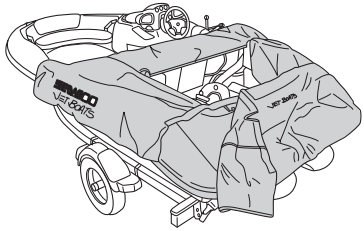
NOTE : This tool is also
 used to pull out impeller
 shaft seal.

F01J0Z4

APPLICATION
 All models.

Section 01 SERVICE TOOLS AND PRODUCTS
Sub-Section 02 (RECOMMENDED TOOLS)

Protective mat **890**
P / N 295 000 129

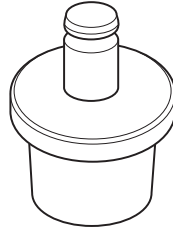


F04L1V4

APPLICATION

All models.

Rotary valve shaft
pusher **757**
P / N 290 876 609

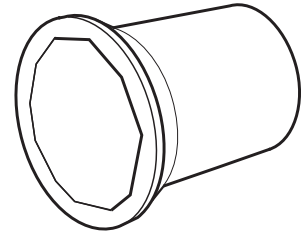


F01B2B4

APPLICATION

787 engine.

Exhaust outlet tool **831**
P / N 295 000 132

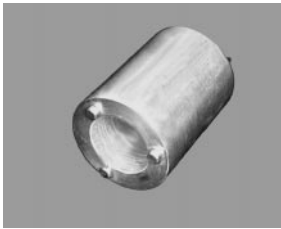


F01B2A4

APPLICATION

Sportster and Speedster.

Safety lanyard switch tool **775**
P / N 295 000 121

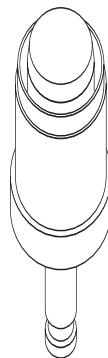


F01B244

APPLICATION

All models.

Handle **758**
P / N 290 877 650

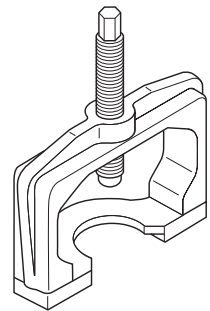


A00C3V4

APPLICATION

787 engine.

Gear / bearing puller **765**
P / N 290 877 665



F04B034

APPLICATION

787 engine.

A) Four-pin magneto
harness **763**

P / N 295 000 131

B) Six-pin magneto
harness **755**

P / N 295 000 136



F01B284

APPLICATION

A) 717 engine.

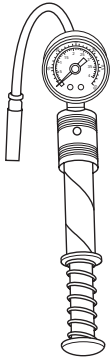
B) 787 engine.

Section 01 SERVICE TOOLS AND PRODUCTS
Sub-Section 02 (RECOMMENDED TOOLS)

COOLING / FUEL / OIL SYSTEMS

Pump gauge tester
(carburetor)
P / N 295 000 114

826

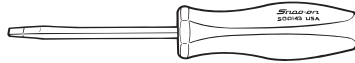


F01B0X4

APPLICATION
All models.

Screwdriver
Not sold by Bombardier

Snap-on
SDD-143



F01B1P4

APPLICATION
All models.

Lighted adjustable mirror
Not sold by Bombardier

Snap-on
50101

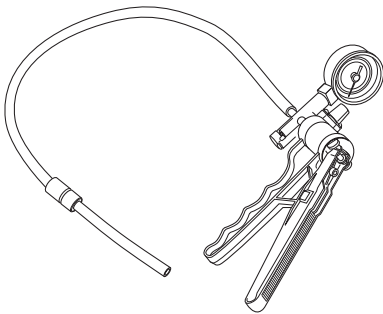


F01B114

APPLICATION
All models.

Pump gauge tester
(fuel / oil reservoirs)
P / N 295 000 085

827

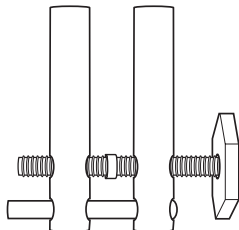


F01B0Y4

APPLICATION
All models.

Hose pincher
P / N 529 030 400

773



F01B234

APPLICATION
All engines.

PROPULSION SYSTEM

Fitting
 P / N 295 000 086 **828**

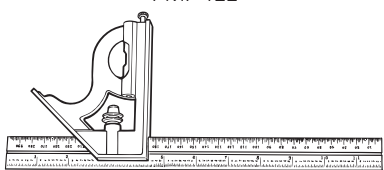


F01B0Z4

APPLICATION
 All models.

Machinist's square
 Not sold by Bombardier

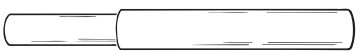
Snap-on
 PMF 122



F02B064

APPLICATION
 Models equipped with reverse.

Bearing remover
 Not sold by Bombardier
 Do it yourself
 Refer to *Shop Manual* section 09-01

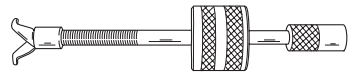


F01J114

APPLICATION
 All models.

Slide hammer puller
 Not sold by Bombardier

Snap-on : Handle CJ93-1
 Hammer CJ125-6
 Claws CJ93-4



NOTE : This tool is also used to remove rotary valve shaft bearing.

F01J0Z4

APPLICATION
 All models.

Fitting remover
 Not sold by Bombardier
 Do it yourself
 Refer to *Shop Manual* section 09-01

Deep socket
 14 mm
 (9/16 in)



F01J2RA


APPLICATION
 All models.

Flexible spout (oil) **834**
 P / N 414 8373 00

APPLICATION
 All models.

Hacksaw
 Not sold by Bombardier

Snap-on
 HS3



F01B1M4


APPLICATION
 All models.

SERVICE PRODUCTS

O NOTE : The numbers outlined in black (example : **1**) are reference numbers to tools from other divisions (Sea-Doo and / or Sea-Doo Jet Boats). Matching numbers are the same tool even if the part numbers are different.

Medium strength threadlocker **154**
 P / N 293 800 015

Loctite 242 (blue)
 (10 mL)




A00B324

APPLICATION
 Cylinder head screws
 (All engines).
 Tuned pipe nut and screws.
 Engine rubber mount screws.
 Armature plate screws.
 Magneto flywheel / crankshaft.
 Carburetor mount nuts / screws.
 Magneto coil screws.
 Impeller housing cover screws
 (except for plastic pumps).
 Venturi / impeller housing
 screws.
 Intake grate screws.
 Engine support screws.
 Impeller housing / hull nuts.
 Steering nozzle screws.
 Reverse gate screws.

High strength threadlocker **155**
 P / N 293 800 005

Loctite 271 (red)
 (10 mL)




A00B2U4

APPLICATION
 Impeller shaft thread.

High temperature threadlocker **359**
 P / N 290 899 788


Loctite 648 (green)
 (5 g)



A00B3D4

APPLICATION
 Crankcase / plug at end of rotary
 valve shaft.
 Magneto / ring gear.

Paste gasket **152**
 P / N 293 800 007




Loctite 515
 (50 mL)

A00B2T4

APPLICATION
 Cylinder sleeve / O-ring groove.
 Crankcase halves mating surface.
 Crankcase screws.

Paste gasket **376**
 P / N 293 800 038



Loctite 518
 (50 mL)

F01B124

APPLICATION
 Impeller housing cover.
 Venturi / impeller housing.
 Impeller shaft seal.

Section 01 SERVICE TOOLS AND PRODUCTS
 Sub-Section 03 (SERVICE PRODUCTS)

Solvent **157**
 P / N 293 800 019

Loctite Safety
 Solvent 755



A00B3M4

APPLICATION

Impeller shaft threads.
 Drive shaft splines.
 Impeller threads and splines.

Primer for paste gasket **158**
 P / N 293 600 013

Loctite
 Locquic Primer N
 170 g (6 oz)



A00B3N4

APPLICATION

Crankcase halves mating
 surface.
 Impeller shaft thread.
 Venturi / impeller housing
 mating surface.

Gasket stripper **935**
 N / P 295 500 110



F01B1W4

APPLICATION

Mating surfaces of cylinders and
 crankcase.
 Crankcase halves.

Pipe sealant **358**
 P / N 293 800 018

Loctite 592
 (50 mL)



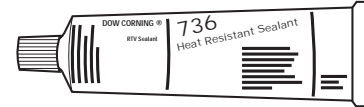
A00B2W4

APPLICATION

Plug on impeller housing cover.
 Plastic fitting tool (P / N 295 000
 086) on impeller housing cover.
 Cooling system fittings.

Heat resistant sealant **374**
 P / N 413 709 200

Dow Corning 736



A00B3U4

APPLICATION

Tuned pipe.

Dielectric grease **350**
 P / N 293 550 004

Dow Corning



F01B164

APPLICATION

Battery posts and cable con-
 nectors.
 Thermosensor switch.

Grease **924**
 P / N 293 550 005

(400 g)



A00B2L4

APPLICATION

PTO flywheel.

Section 01 SERVICE TOOLS AND PRODUCTS
 Sub-Section 03 (SERVICE PRODUCTS)

Synthetic grease **912**
 P / N 293 550 010



Sea-Doo
 (400 g)

F01B154

APPLICATION
 Cylinder and cylinder head screws.
 Carburetor linkage.
 Impeller shaft seal lips.
 Drive shaft / impeller splines.
 PTO flywheel

Lubricant
 Not sold by Bombardier




G.E. Versilube
 G341M
 or
 Esso Beacon 325

A00B1T4

APPLICATION
 Sliding surface of starter armature shaft splines.

Anti-seize lubricant **362**
 P / N 293 800 023




Loctite anti-seize
 lubricant
 12 oz (454 g)

F01B174

APPLICATION
 Crankshaft thread / PTO flywheel.
 Crankshaft bearing seat.
 Spark plug threads.
 Ignition housing cover screws.

Penetrating lubricant **913**
 P / N 293 600 016



Bombardier
 Lube

F01B0S4

APPLICATION
 Throttle cable.
 Wear ring (when new).
 Corroded parts.
 Water flooded engine.
 Storage.


Sea-Doo fuel stabilizer **375**
 P / N 413 408 600



A00B3V4

APPLICATION
 Fuel system.

Bombardier-Rotax injection oil **915**
 P / N 413 802 900 12 x 1 L



F01B184

APPLICATION
 All models.

Section 01 SERVICE TOOLS AND PRODUCTS
 Sub-Section 03 (SERVICE PRODUCTS)

Bombardier-Rotax
 injection oil

P / N 413 803 000 3 x 4 L **916**

P / N 413 803 200 205 L **962**



F01B2H4

APPLICATION

All models.

Jet pump oil

914

P / N 293 600 011

Sea-Doo jet pump
 synthetic oil



F01B0P4

APPLICATION

All models.

A) Silicone «Ultra Black»

901

P / N 293 800 030

B) Silicone

902

«Ultra Black HB»

P / N 293 800 028



(300 mL)

F01B1A4

APPLICATION

Ride shoe.

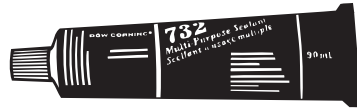
Jet pump fittings.

732 Multi-purpose sealant

917

P / N 293 800 006

Dow Corning
 (Clear)



F01B1C4

APPLICATION

Ride shoe screws.

Sealant adhesive

934

P / N 293 800 033

(Clear)



F01B1S4

APPLICATION

Ride shoe screws.

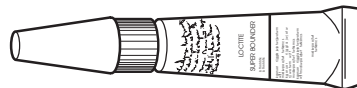
Sponson.

General purpose instant
 adhesive

373

P / N 293 800 021

Loctite 495



A00B2V4

APPLICATION

Rubber to metal bonding and
 most hard plastic.

Adhesive activator

931

P / N 293 530 036



F01B1Z4

APPLICATION

Decals.

Sea-Doo Cleaner

P / N 293 110 001 400 g

946

P / N 293 110 002 4 L

947



F01B2J4

APPLICATION

All models.

Section 01 SERVICE TOOLS AND PRODUCTS
 Sub-Section 03 (SERVICE PRODUCTS)

Gelcoat spray paint
 Super white
 P / N 293 500 076

933

Sea-Doo
 paint



F01B1Q4

APPLICATION

All models.

Spray paint for metallic parts only

A) White
 P / N 293 500 029

926

B) Purple
 P / N 293 500 020

930

Sea-Doo
 paint



F01B0Q4

APPLICATION

A) Engine assembly.
 B) Tuned pipe and muffler.

Gun Kote
 Not sold by Bombardier

Kal-Gard
 Coating & Mfg. Corp.

APPLICATION

Magneto and armature plate.

Loctite sealant
 P / N 413 7103 00

961

APPLICATION

Exhaust system 787 engine.

Gelcoat (liquid)
 1 liter super white
 P / N 293 500 075

943

APPLICATION

All models.

Epoxy glue
 Not sold by Bombardier
 3M-05900

APPLICATION

All models.

Gelcoat repair kit
 P / N 295 500 216

945

APPLICATION

All models.

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