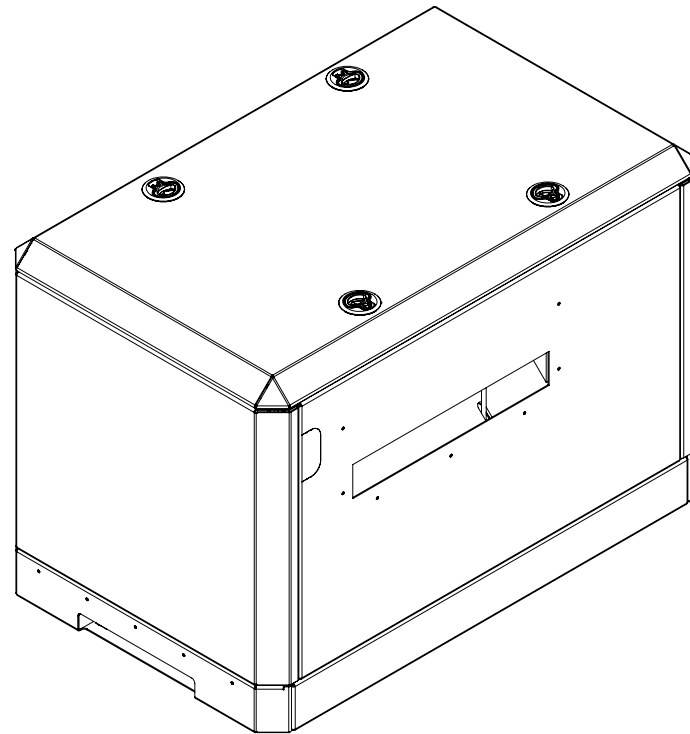
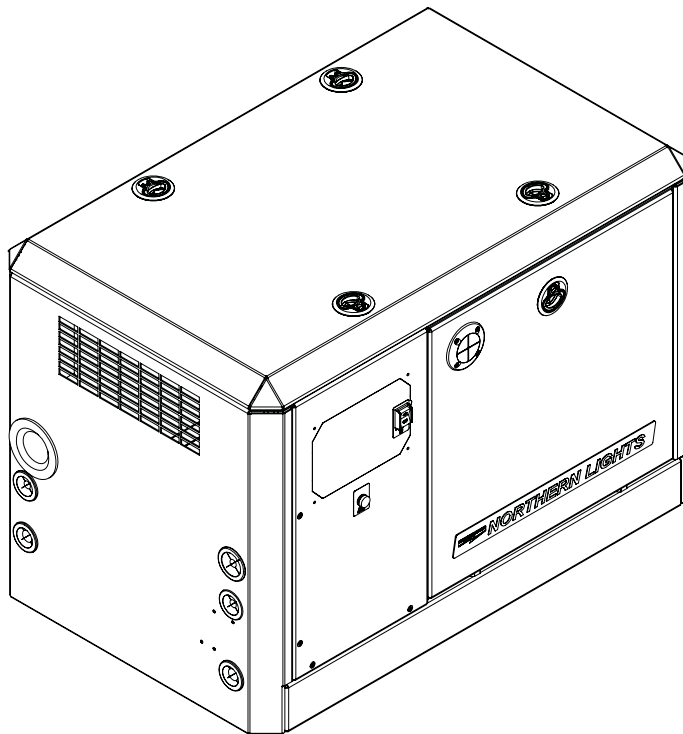




M773LW3GN

GEM Series Sound Enclosure

Assembly Instructions



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LIT NO.: L835 11/25



M773LW3GN GEM Sound Enclosure (p/n: 06-78665)

ITEM #	DESCRIPTION	ADE P/N	QTY	NOTES
1.	Junction box bridge cover assembly	06-78632	1	
2.	Rear panel assembly	06-78662	1	
3.	Non-service side valence assembly	06-78637	1	
4.	Service side valence assembly	06-78635	1	
5.	Front lower valence assembly	06-78633	1	
6.	Non-service side panel assembly	06-78636	1	
7.	Service side aft panel assembly	06-78658	1	
8.	Front panel assembly	06-78651	1	
9.	Seal bar assembly	06-78659	1	
10.	Top panel assembly	06-78656	1	
11.	Service side panel assembly	22-78603	1	
12.	Sound shield wire harness	12-72026	1	
13.	M8 x 20 18-8, S/S hex head capscrew	12-00776	4	
14.	M8 lock washer, S/S	15-00705	4	
15.	M8 flat washer, S/S	15-11000	4	
16.	Grommet edging	44-70034	15"	
17.	Sound foam snorkel receiver	55-78676	1	

SPECIFICATIONS

Enclosure:

Length (OA)	35.0 in (889 mm)
Width	22.0 in (559 mm)
Height	24.4 in (620 mm)
Assembled weight (shield only)	43 lbs (19.5 kg)
Assembled weight (with generator set)	580 lbs (263.1 kg)

Prior to assembly, inspect all components for damage. Report any damage to the shipping company. Check the packing list in the back of this manual to ensure that all parts are included.

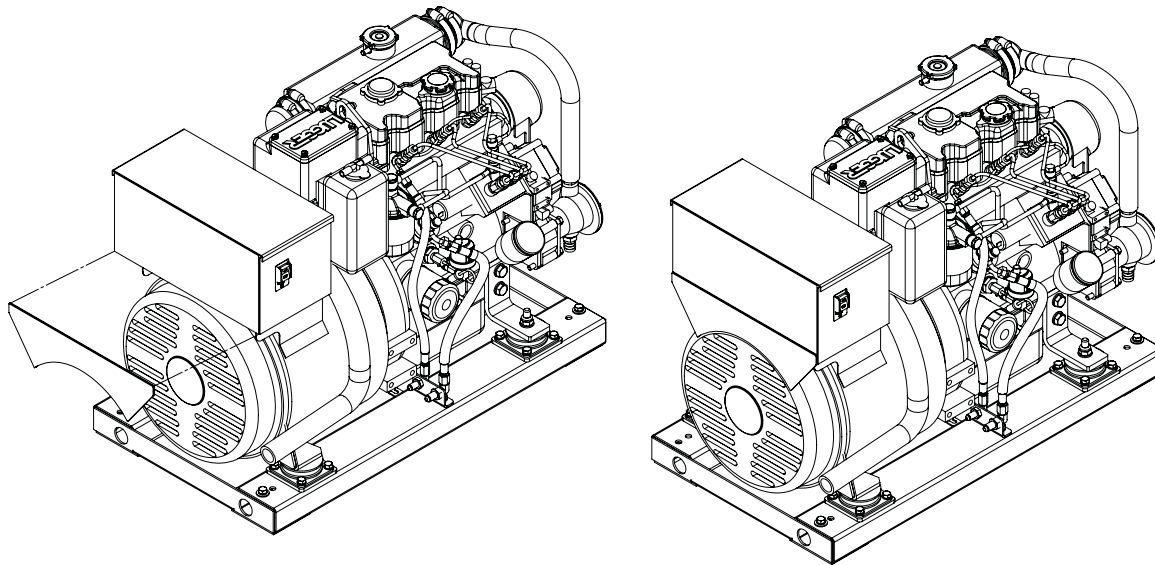
NOTE: The generator set features a single lifting eye. However, the generator may still possess original factory lift points. These need to be loosened and rotated down until they are below the highest point of the engine. Be sure to return those bolts before completing assembly.

Select a mounting location in accordance with the guidelines in the IM1000 Installation Manual. The generator set must typically be mounted on rigid, flat surface above a strong structure (such as vessel's stringers) to minimize vibration transference to the hull.

Note that the generator set is designed for single side service. When viewed from the rear, the right hand side is the service side and should be exposed for easy maintenance access.

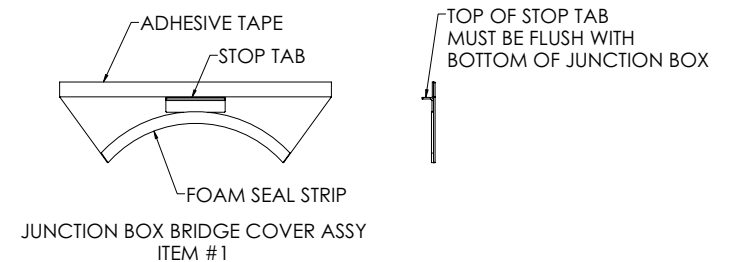
Install the generator set in the vessel as near to a level attitude as possible. Ensure that the enclosure's left hand side and rear are at the recommended distances (6 inches recommended, 4 inches minimum) from the vessel's bulkheads.

TO REDUCE THE CHANCE OF INTAKE/EXHAUST AIR RECIRCULATION, AVOID POSITIONING THE ENCLOSURE INTO CORNERS WITH THE OVERHEAD BLOCKED

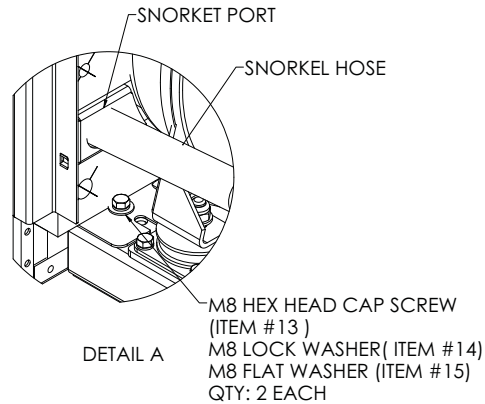
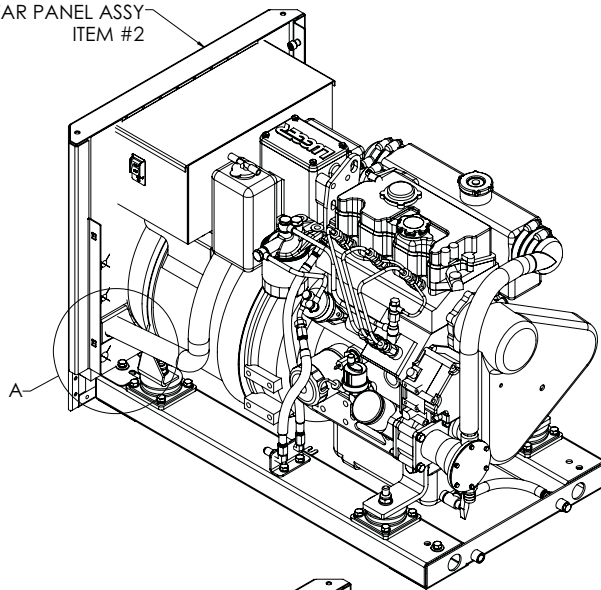


STEP 1.

INSTALL BRIDGE COVER (ITEM #1). REMOVE ADHESIVE BACKING FROM ADHESIVE TAPE AND ALIGN EDGES OF BRIDGE COVER WITH EDGES OF JUNCTION BOX, AND PRESS FIRMLY INTO PLACE.



REAR PANEL ASSY
ITEM #2



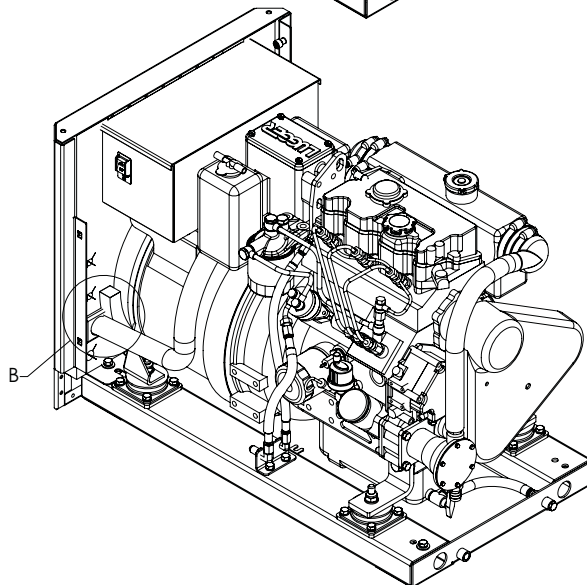
DETAIL A

STEP 2.

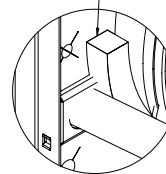
INSTALL REAR PANEL ASSY (ITEM #2)
VERIFY THAT SNORKEL HOSE ALIGN WITH THE SNORKEL PORT. FEED SNORKEL HOSE UNTIL IT HITS THE STOP.
MOUNT REAR PANEL TO THE BASE FRAME WITH M8 HEX HEAD CAP SCREW (ITEM #13), M8 LOCK WASHER (ITEM #14), AND M8 FLAT WASHER (ITEM #15).

You may encounter some resistance as the rear panel comes into contact with the air intake snorkel hose. Note that the rear panel has a small hole in the vicinity of the intake snorkel (Snorkel port). Guide this hose so that it is inserted within the panel hole. Ensure that the hose does not go too far into the rear panel so that the hose end is blocked. Generally this hose will install without adjustment at the retaining clamp.

When making the intake air hose connection, it is important to ensure that the hose is not kinked or bent in such a way as to restrict the engine's intake airflow. The arrangement is designed to allow the hose to follow it's natural path when properly installed into the rear panel. Some adjustment is possible by loosening either bolt of the snorkel hose's supporting bracket. Be sure to retighten any loosened bolts.



RECEIVER SEAL (ITEM #17)



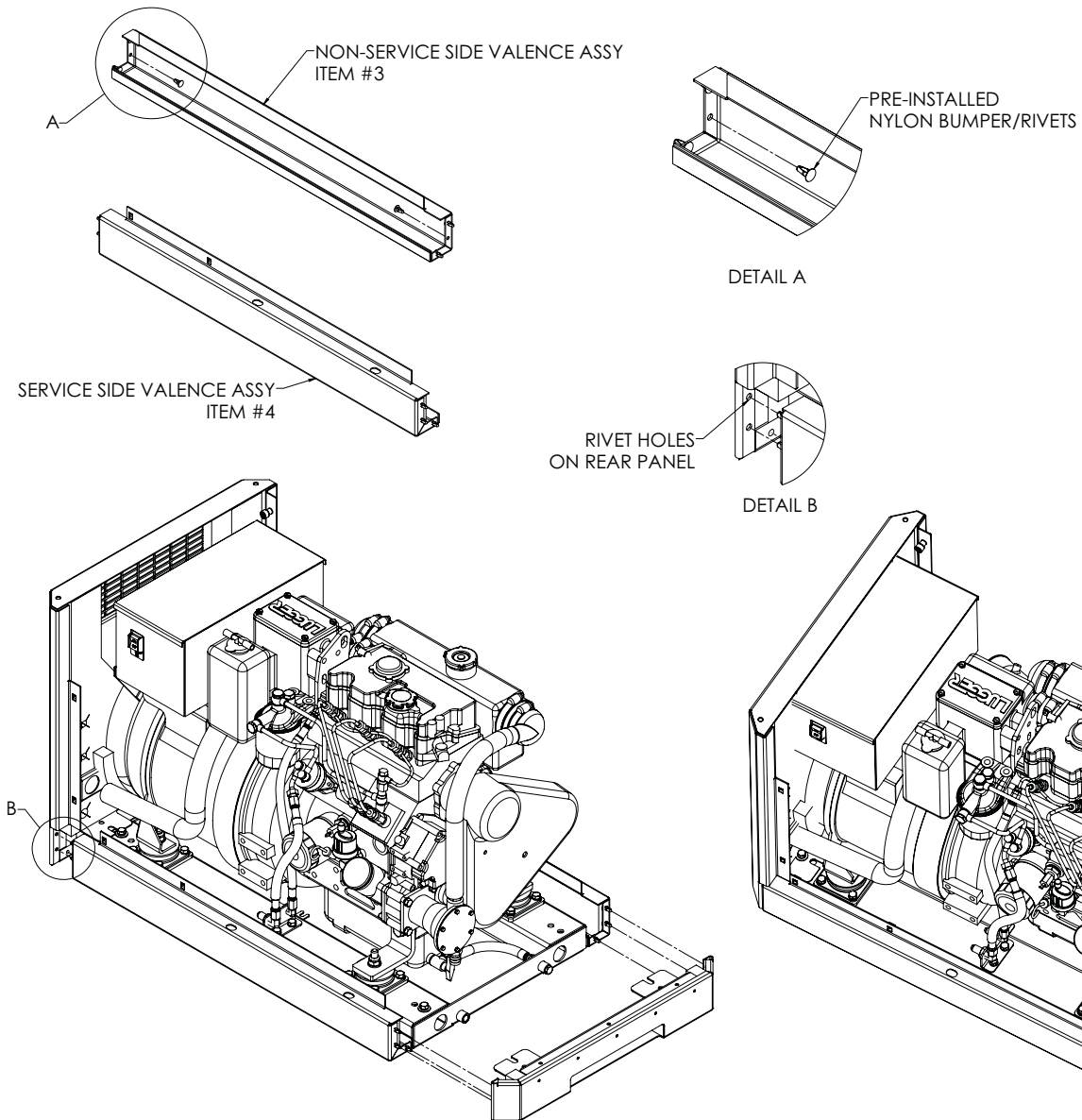
DETAIL B

STEP 3.

INSTALL RECEIVER SEAL (ITEM #17).
REMOVE BACKING PAPER FROM RECEIVER SEAL. ATTACH THE ADHESIVE SIDE TO REAR PANEL AS SHOWN, ENSURE FIT IS SNUG TO GENERATOR BARREL.

NOTES:

- FOR GENERATOR CONNECTION TO THE VESSEL, SEE PAGE #11.

**STEP 4.**

INSTALL LOWER SIDE VALENCES (ITEM #3 & #4). GUIDE PRE-INSTALLED NYLON BUMPER/RIVETS INTO CORRESPONDING HOLES IN REAR PANEL. PUSH FIRMLY TO SNAP INTO PLACE.

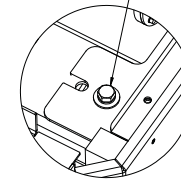
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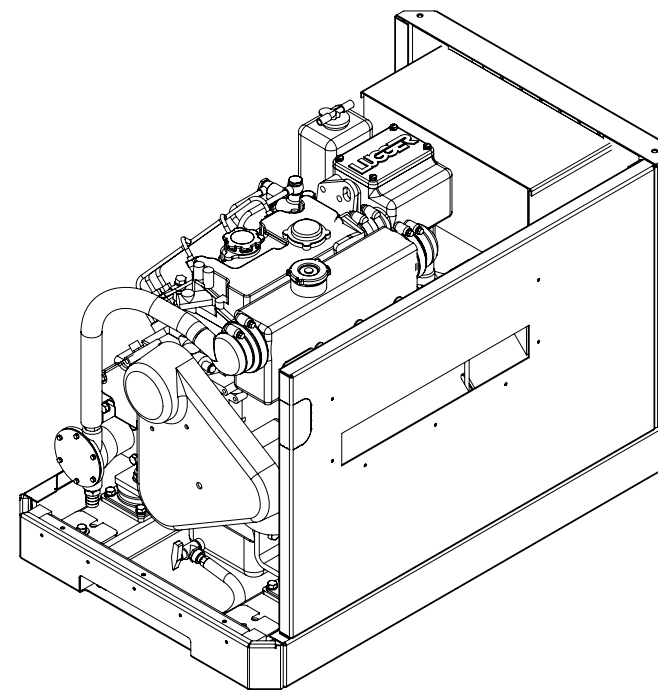
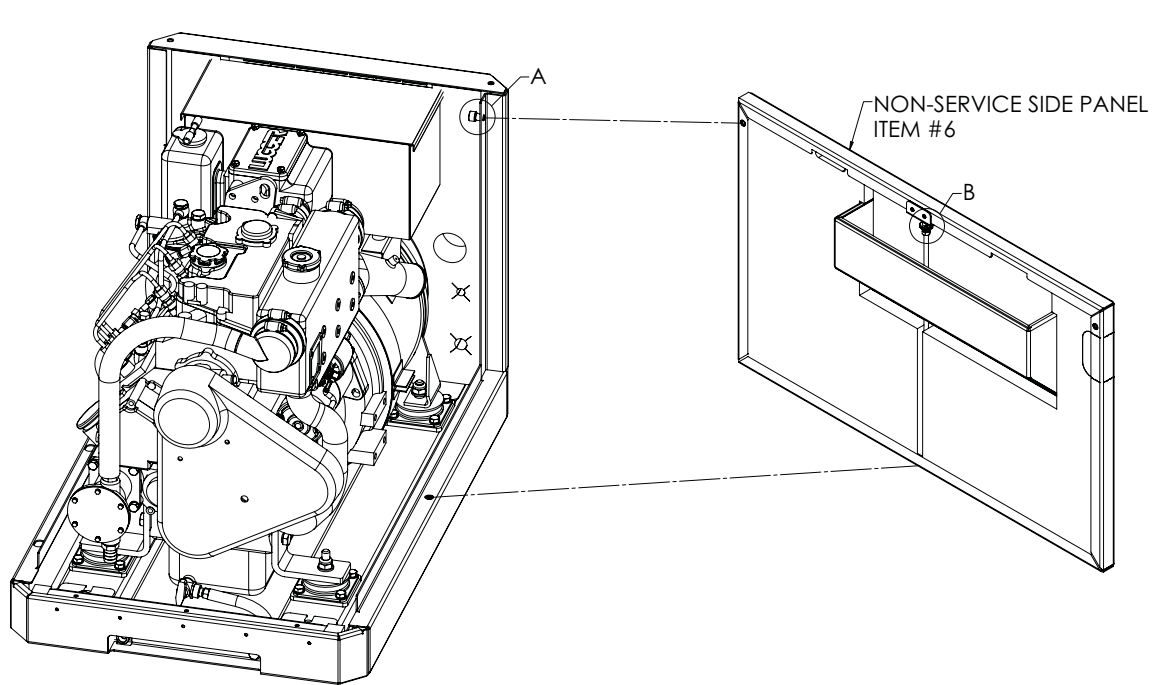
IF NYLON RIVETS DISPLACE, USE A LONG SCREWDRIVER WITH WIDE FLAT BLADE AGAINST RIVET HEAD AND PUSH BACK INTO POSITION.

STEP 5.

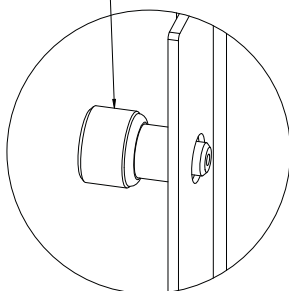
INSTALL FRONT LOWER VALENCE (ITEM #5). ALIGN NYLON RIVETS IN BOTH LOWER SIDE VALENCES TO CORRESPONDING HOLES IN FRONT LOWER VALENCE AND PUSH TOGETHER. SECURE WITH M8 HEX CAPSCREW (ITEM #13), M8 LOCKWASHER (ITEM #14) AND M8 FLAT WASHER (ITEM #15) TO THE TOP OF THE BASE FRAME.

M8 HEX HEAD CAP SCREW
(ITEM #13)
M8 LOCK WASHER (ITEM #14)
M8 FLAT WASHER (ITEM #15)
QTY: 2 EACH

**DETAIL C**

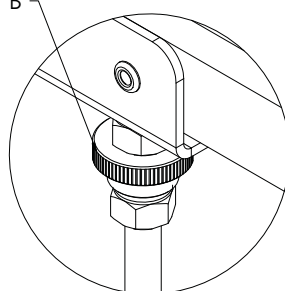


THUMBSCREW "A"



DETAIL A

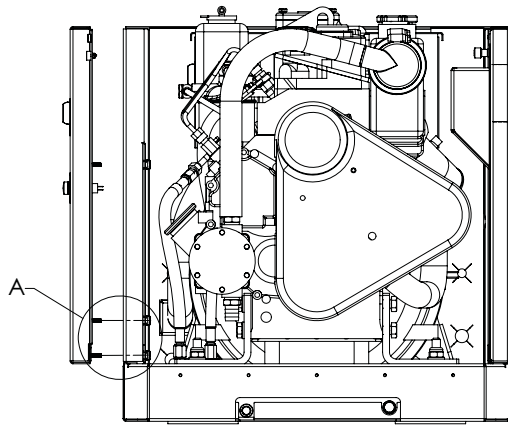
THUMBSCREW "B"



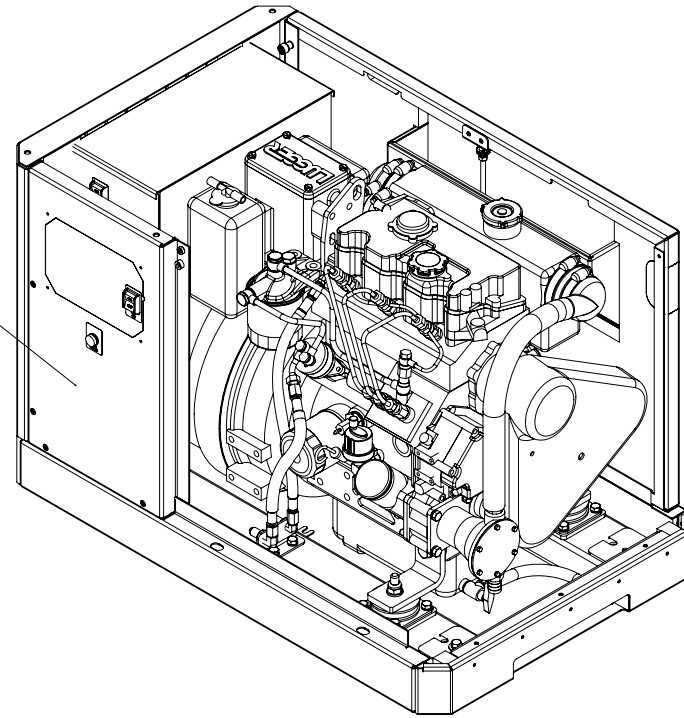
DETAIL B

STEP 6.

INSTALL NON-SERVICE SIDE PANEL (ITEM #6). NON-SERVICE SIDE PANEL ATTACHES TO REAR PANEL AND LOWER VALENCE WITH THUMBS "A" AND "B". WITH PANEL IN PLACE, USE THUMB SCREW "A" TO RETAIN SIDE PANEL, APPLY DOWNWARD PRESSURE AS YOU TURN THUMB SCREW "B" TO ENGAGE THE CAPTIVE NUTS INSIDE THE LOWER VALENCE.

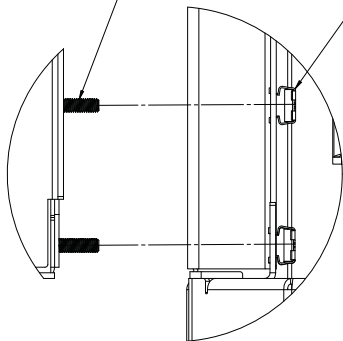


SERVICE SIDE AFT PANEL
ITEM #7



#10-32 MACHINE SCREW

CAGED NUT



DETAIL A

STEP 7.

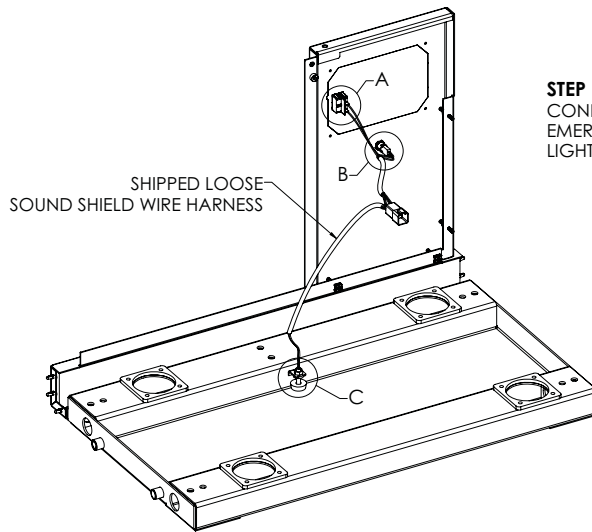
INSTALL SERVICE SIDE AFT PANEL (ITEM #7).

ALIGN #10-32 MACHINE SCREWS (PRE-INSTALLED) ON SERVICE SIDE AFT PANEL WITH CAGED NUT (PRE-INSTALLED) LOCATED ON REAR PANEL, AND LOWER SIDE VALENCE. TIGHTEN WITH HAND TOOLS. USE OF POWER TOOLS MAY CAUSE DAMAGE TO HARDWARE.

NOTES:

REFER TO THE WIRE HARNESS INSTALLATION INSTRUCTIONS ON PAGE 7

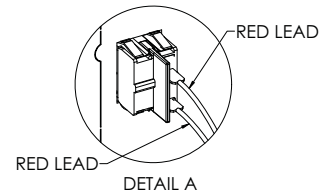
SOUND SHIELD WIRE HARNESS INSTALLATION



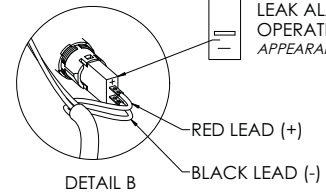
STEP 1

CONNECT SOUND SHIELD WIRE HARNESS TO EMERGENCY STOP SWITCH AND LEAK ALARM LIGHT AS SHOWN IN DETAIL A AND DETAIL B.

PRE-INSTALLED EMERGENCY STOP SWITCH



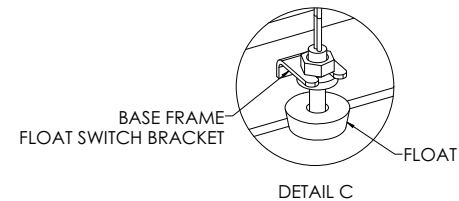
SHIPPED LOOSE LEAK ALARM LIGHT



NOTES:
LEAK ALARM LIGHT WILL NOT OPERATE IF POLARITY IS SWITCHED.
APPEARANCE MAY VARY.

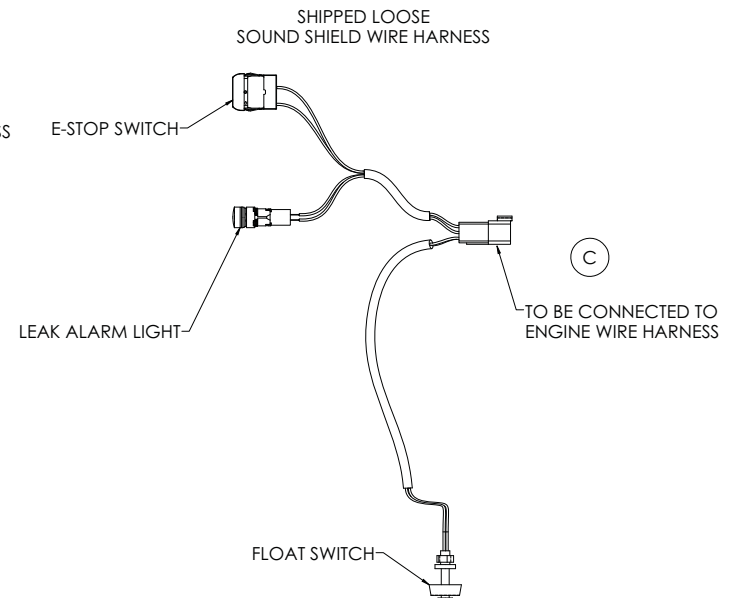
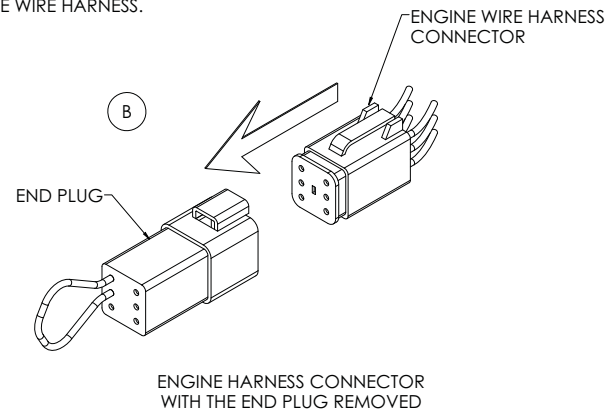
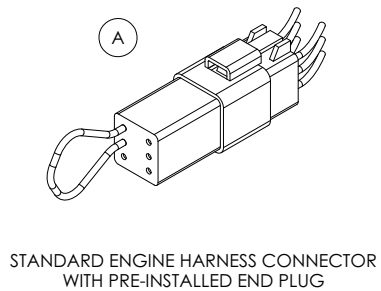
STEP 2

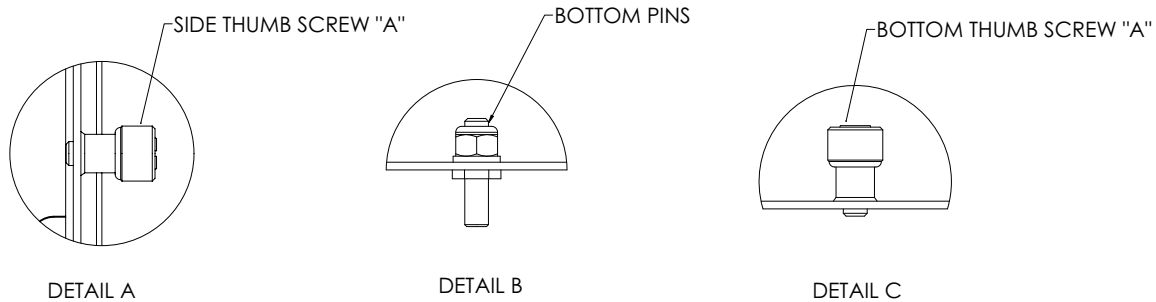
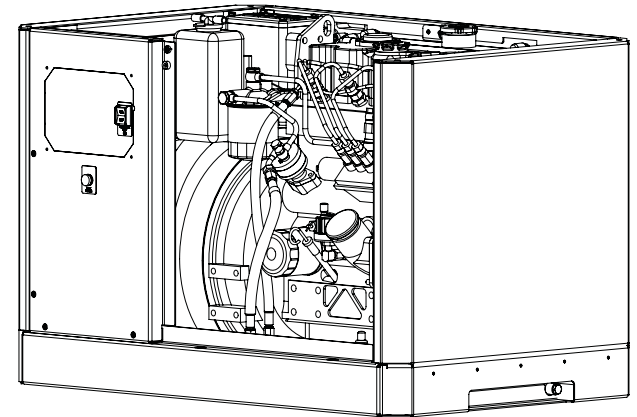
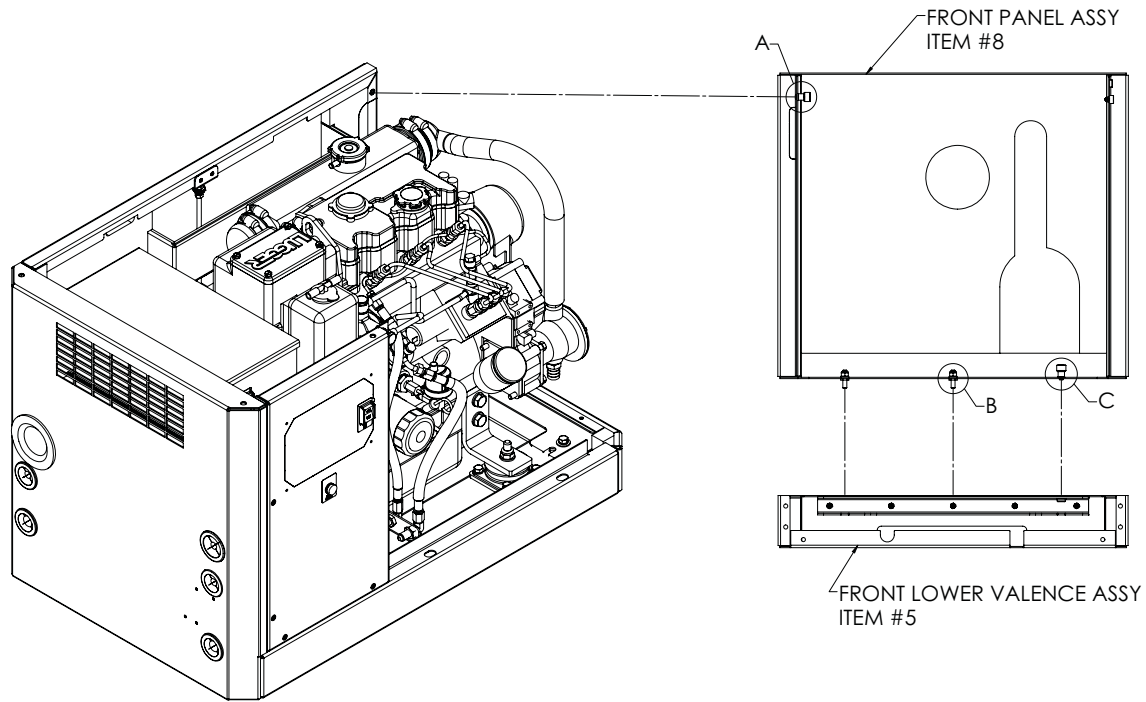
INSTALL FLOAT SWITCH TO THE CORRESPONDING BRACKET ON THE BASE FRAME. BE SURE TO CHECK THE LEAK ALARM LIGHT BY LIFTING UP THE FLOAT AFTER GENERATOR SET IS CONNECTED TO STARTER BATTERY.



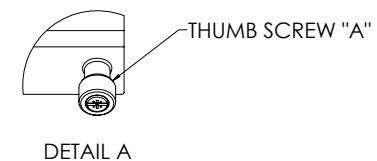
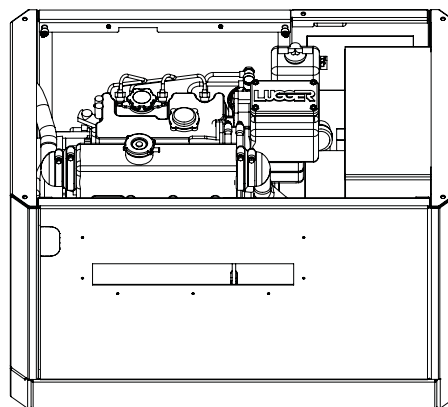
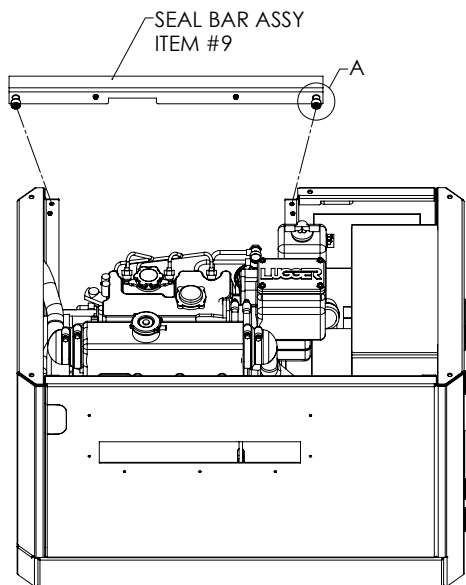
STEP 3

- LOCATE AND IDENTIFY THE ENGINE WIRE HARNESS.
- REMOVE THE ENGINE WIRE HARNESS END PLUG.
- CONNECT SOUND SHIELD WIRE HARNESS TO THE ENGINE WIRE HARNESS.



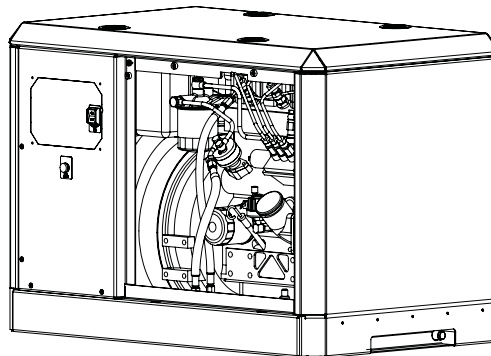
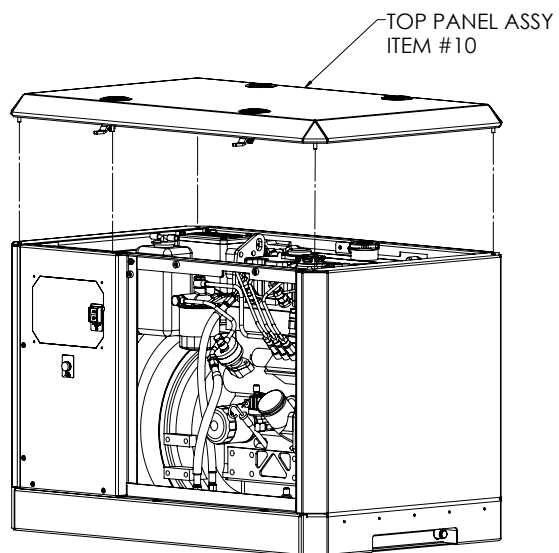


STEP 8.
INSTALL FRONT PANEL ASSEMBLY (ITEM #8).
POSITION FRONT PANEL ON TOP OF FRONT LOWER
VALENCE. NOTE THE PINS IN THE BOTTOM OF THE FRONT
PANEL ALIGN TO HOLES IN THE LOWER VALENCE. ENGAGE
AND SECURE WITH THUMB SCREW "A" ON THE SIDE AND ON
THE BOTTOM.



STEP 9.

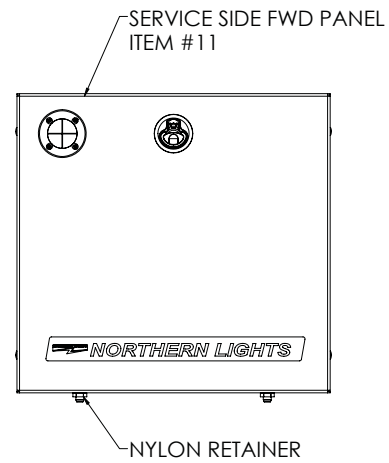
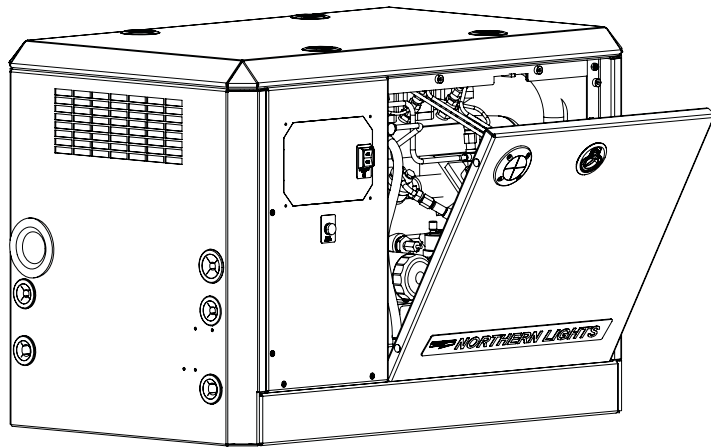
INSTALL SEAL BAR ASSEMBLY (ITEM #9).
LOCATE SEAL BAR TO CORRESPONDING HOLES
AND SECURE WITH THUMB SCREW "A". HAND
TIGHTEN FIRM AND DO NOT USE TOOLS.



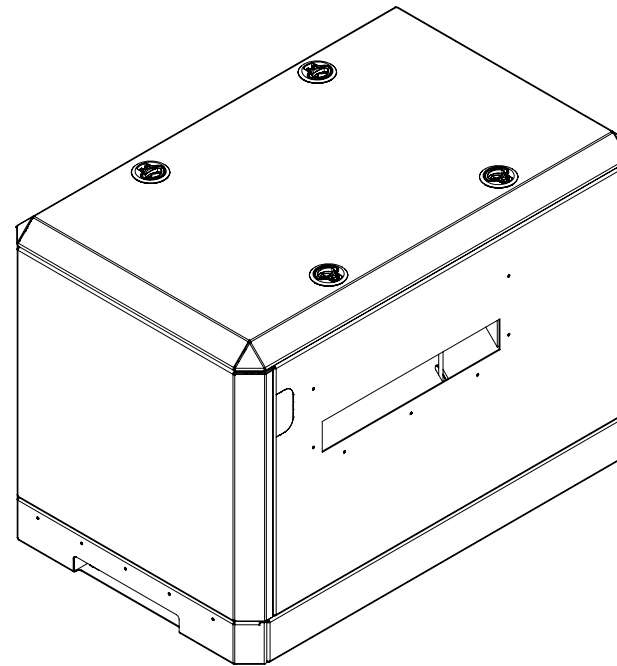
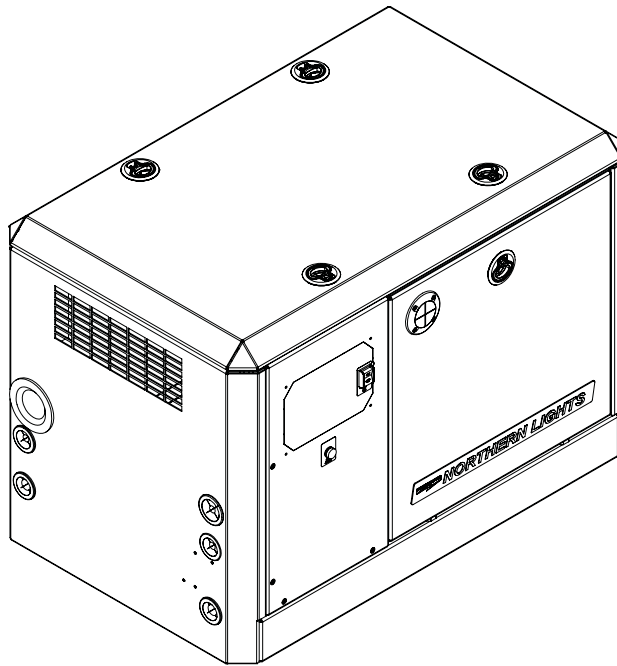
STEP 10.

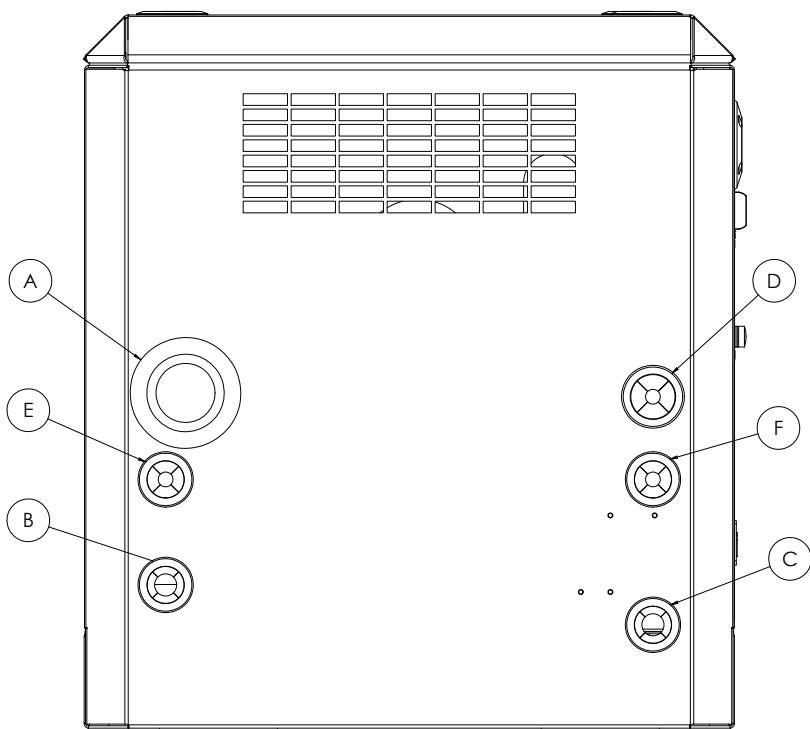
INSTALL THE TOP PANEL ASSEMBLY (ITEM #10).
NOTE THAT THE PANEL HAS LOCATING PINS PRE-INSTALLED.
ALIGN THESE WITH THE CORRESPONDING HOLES ON THE TOP
OF THE FRONT AND REAR PANEL ASSEMBLIES. RETAIN IN PLACE
BY TURNING LATCHES TO CLOSED POSITION.

NOTES:
OPEN LATCHES BY TURNING THE LEVER 90 BEFORE MOUNTING
TO SOUND SHIELD. THE RING LATCHES ARE FACTORY PRE-SET
BUT OCCASIONALLY REQUIRE SOME ADJUSTMENT. SEE LATCH
ADJUSTMENT SECTION (PAGE 13) FOR DETAIL.



STEP 11.
INSTALL THE SERVICE SIDE PANEL ASSY (ITEM #11).
GUIDE THE NYLON RETAINER INTO THE
CORRESPONDING SLOTS ON LOWER VALENCE.
RETAIN IN PLACE BY TURNING LATCH TO CLOSED
POSITION.





GENERATOR CONNECTIONS

Install connections for exhaust, AC power leads, DC control panel leads, battery and water through holes in the rear panel as shown and described below:

- A. Connect the generator set 2" exhaust outlet to the exhaust system of the vessel through hole A.
- B. Connect the sea water pump to the vessel's water inlet. Push a 3/4" hose from the vessel's sea water strainer through hole B to the sea water pump inlet fitting.
- C. Connect the vessel's fuel lines using Coast Guard approved rubber fuel hoses to the fuel manifold located on the service side valence (Section F). The forward fitting is 5/16" 37T JIC fuel suction and the aft fitting is 5/16" 37T JIC fuel return.
- D. Connect the DC control harness to the engine harness plug. Pass the harness and plug through hole D.
- E. Connect the battery leads to the generator set through hole E.
- F. Connect the AC output leads from the generator set to the vessel's power distribution panel through hole F.

FOR APPLICATIONS WITH A SIPHON BREAK:

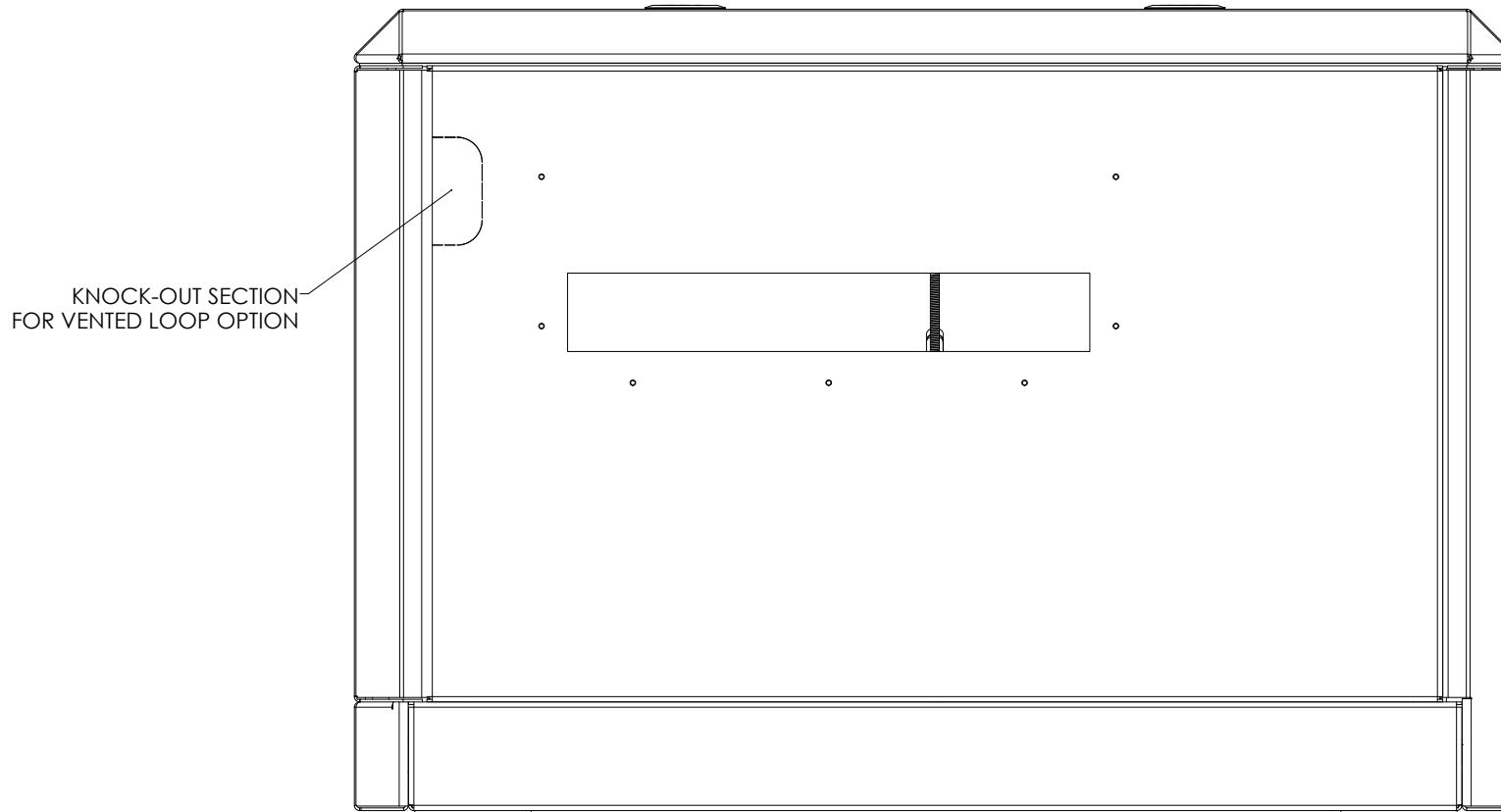
Reference the plumbing diagram in the mounting and exhaust sections of the IM1000 installation manual.

Knock-out the marked section as shown below prior to installing Non-Service Side Panel Assy (ITEM #6) and Front Panel Assy (ITEM #8) . Install the Grommet Edging (ITEM #16) on the knocked out perimeter.

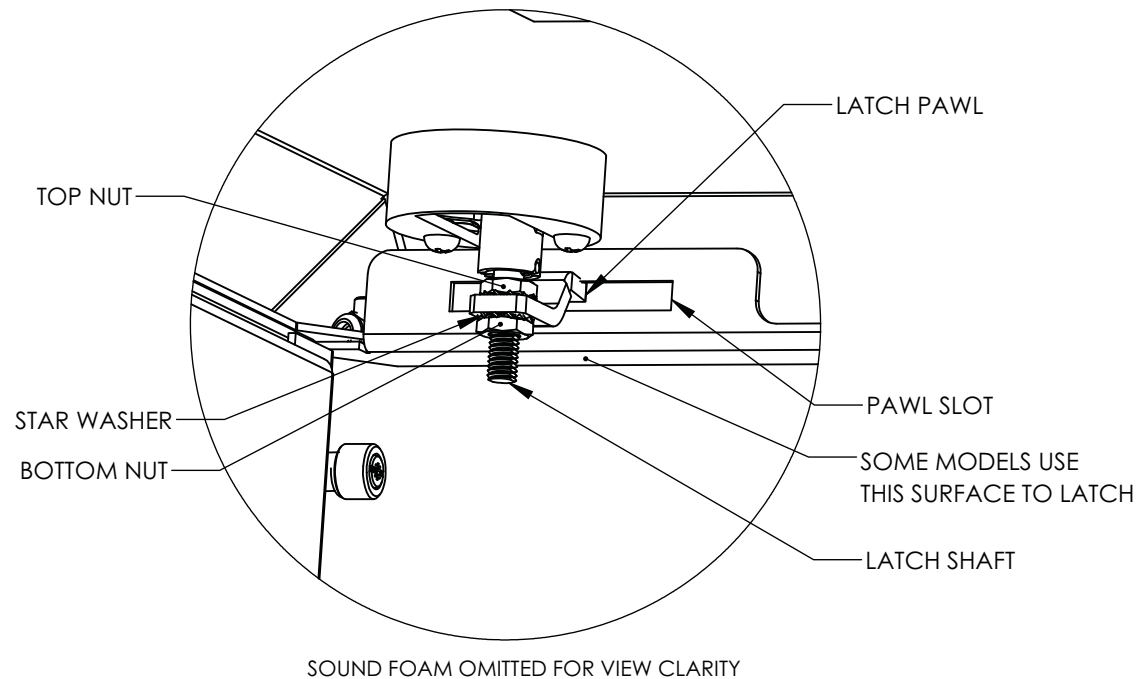
GENERATOR SETS WITH WET EXHAUST THAT ARE INSTALLED NEAR OR BELOW THE VESSEL'S WATER LINE MUST USE A SIPHON BREAK TO PREVENT BACKFLOW OF WATER INTO THE ENGINE. THIS BACKFLOW CAN RUIN AN ENGINE AND POSSIBLY SINK THE VESSEL.

1. Disconnect the hose from seawater pump output and from the rubber elbow on the expansion tank. Install two lengths of 3/4" hose.
2. Pass the seawater pump output hose through the knock-out section. The hose from expansion tank must be located above the other hose in the same knock-out section.
3. For more information, see the "Exhaust" section of the IM 1000. Installation manual is included with the generator set.

Start the generator set and run under load to check for leaks of fuel, water, or exhaust gas.



RING LATCH GRIP ADJUSTMENT INSTRUCTIONS

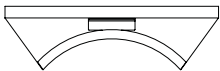


ALL LATCHES ARE PRE-ADJUSTED FROM FACTORY. IN THE EVENT A LATCH REQUIRES ADJUSTMENT, FOLLOW THESE STEPS:

1. NOTE THE INTERFERENCE, OR REASON WHY THE LATCH PAWL WILL NOT ENGAGE THE PAWL SLOT. IF PAWL HITS SLOT BRACKET OR SHELF IT MUST BE MOVED TO ALLOW PAWL TO ROTATE INSIDE SLOT.
2. LATCH PAWL SHOULD OPERATE WITHIN SLOT FREELY WHEN LATCH HANDLE ROTATES ON REMOVAL.
3. WITH LATCH IN CLOSED POSITION, (LATCH PAWL POINTING TOWARDS SLOT, LOOSEN THE BOTTOM NUT. TURN TOP NUT TO CHANGE POSITION OF PAWL AND THEN RE-TIGHTEN THE BOTTOM NUT. ENSURE THE NUT IS FULLY TIGHT BEFORE OPERATING THE LATCH.
4. AN IDEAL LATCH CONDITION IS WHEN THE PAWL SWINGS INTO POSITION ON CLOSING, PULLS UP AND ENGAGES THE TOP OF THE SLOT WITH INCREASING RESISTANCE. WHEN THE LATCH RING IS FULLY DEPRESSED THERE SHOULD BE FIRM COMPRESSION OF PANEL PERIMETER SEAL.
5. IF YOU CAN LIFT UP A CORNER OF THE TOP PANEL AND SEE A SPACE, THE LATCH IS NOT TIGHT ENOUGH.

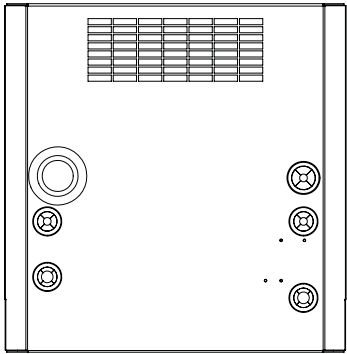
PACKING LIST

ITEM #1



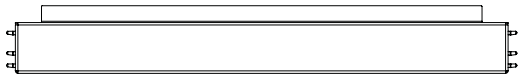
JUNCTION BRIDGE COVER ASSY
06-78632, QTY: 1

ITEM #2



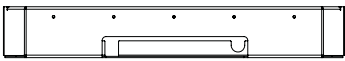
REAR PANEL ASSY
06-78662 QTY: 1

ITEM #3



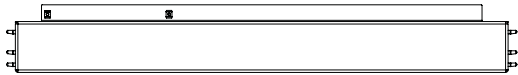
NON-SERVICE SIDE VALENCE ASSY
06-78637, QTY: 1

ITEM #5



FRONT VALENCE ASSY
06-78633, QTY: 1

ITEM #4



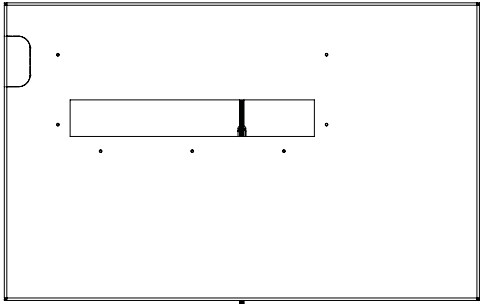
SERVICE SIDE VALENCE ASSY
06-78635, QTY: 1

ITEM #9



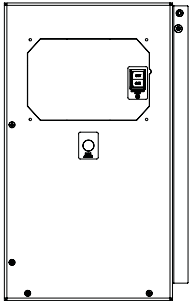
SEAL BAR ASSY
06-78659, QTY: 1

ITEM #6



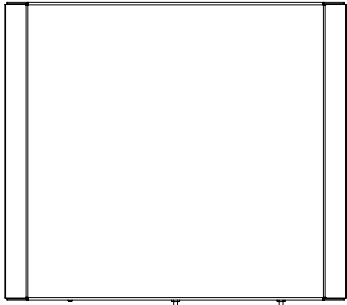
NON-SERVICE SIDE PANEL ASSY
06-78636, QTY: 1

ITEM #7



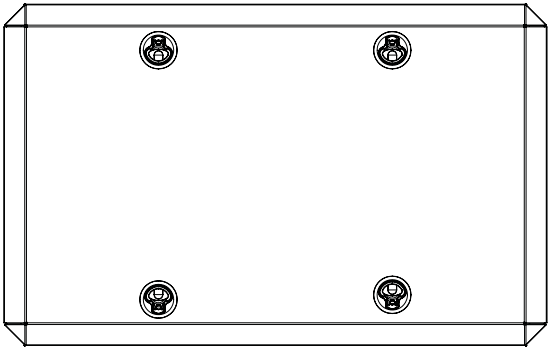
SERVICE SIDE AFT PANEL ASSY
06-78658, QTY: 1

ITEM #8



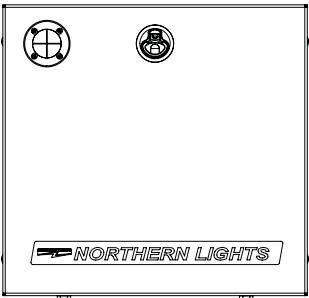
FRONT PANEL ASSY
06-78651, QTY: 1

ITEM #10



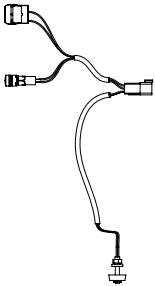
TOP PANEL ASSY
06-78656, QTY: 1

ITEM #11



SERVICE SIDE FWD ASSY
06-78603, QTY: 1

ITEM #12



SOUND SHIELD WIRE HARNESS
22-72026, QTY: 1

ITEMS IN THIS BOX ARE ENLARGED FOR DETAIL

ITEM #13



M8 HEX CAPSCREW
12-00776, QTY: 4

ITEM #14



M8 LOCK WASHER
15-00705, QTY: 4

ITEM #17



SOUND FOAM SNORKEL RECEIVER
55-78676, QTY: 1

ITEM #15



M8 FLAT WASHER
15-11000, QTY: 4

ITEM #16



VENTED LOOP GROMMET EDGING
44-70034 QTY: 15"

Packed By : _____

Date : _____