



ASSEMBLY INSTRUCTIONS FOR

GRX 420

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February 2019

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Assembly Instructions for GRX420

- Remove the OBM from the transom of the boat. Then off load the boat from the trailer and place it on a flat smooth surface that will not damage the underside of the boat. Deflate the pontoons and hijackers completely. Once the boat is completely deflated (including the Hijackers) raise the stringer between the third and fourth boards by pulling it up (As per the photo) Ensure the floorboard retaining rubbers are not damaged in the process. **Tip:** Pulling the tubes to the side (away from each other) during this process will allow for easier removal of the floor boards.



Stringer between
third and fourth
boards.

- Remove all the boards and stringers. Taken note of the position of the boards and stringers for the assembly process. Clean the boat thoroughly with water to remove all sand and dirt. Once cleaned wash it with clean water and let it dry out completely. Wash down the floorboards and stringers as well and let it dry completely before starting the assembly of the boat.
- **Pls Note:**
- Inspect the floorboards and stringers for any damage. Replace any damaged parts with new parts. Also inspect the inside of the boat for any damage. Report if any damage is found.

- When thoroughly cleaned and dry, begin assembly with aft board (Fifth board) and the first and second bow boards. Make sure the aft floorboard fits snugly under the transom lip and it is under the floor board retaining rubber on the sides. Make sure the bow boards are fitted with the stringer in between the two boards and are underneath the floor board retaining rubber and it also fits snugly into the bow. **Pls Note, Stringers are always fitted with rounded side facing up and flat side to the bottom, and make sure that the correct stringers are put back in the correct position.**



Aft floorboard (fifth floorboard) fitted snugly at transom and underneath the retaining rubbers.



Bow boards fitted with stringer in between and under the floor board retaining rubber. Stringer is the right way up.

- Next, fit the stringer on the aft floorboard, and fit the fourth floorboard in the boat. Ensure that the fourth floorboard fits underneath the floor board retaining rubber on the one side and then work the other side of the floorboard underneath the retaining rubber on the opposite side.



One side of board fitted underneath retaining rubber, then work the other side of the board underneath the rubber on the other side.

- Push the fourth floorboard back so that it fits snugly in to the stringer of the aft floorboard.



Fourth floorboard worked underneath retaining rubber and moved backwards into aft floorboard stringer. Tip : once again pull the tubes away from each other to get the boards into the boat.

- Next, fit the stringer to the fourth floorboard, and the stringer to the second floorboard.



Stringers fitted to fourth and second floorboards.

- Fit the third floorboard in to the stringer of the second floorboard. Raise the fourth floorboard up so that the stringer between the fourth floorboard and third floorboard align, and they both fit correctly into the stringer. This is referred to as building a "bridge" **Make sure the stringers are all centered in the boat and on the floorboards.**



- Once satisfied that the stringers and boards are centered and fitting properly, push down on the “Bridge” and ensure that the boards goes all the way down to the floor of the boat. One person might have to stand on the boards to keep them in position. **Pls Note:** The assembly process must only be done on a flat smooth surface.



Floorboards pushed down into boat.

- Once satisfied that the floorboards are fitted properly, and the stringers are correctly located work the boards underneath the floor board retaining rubber on both sides.



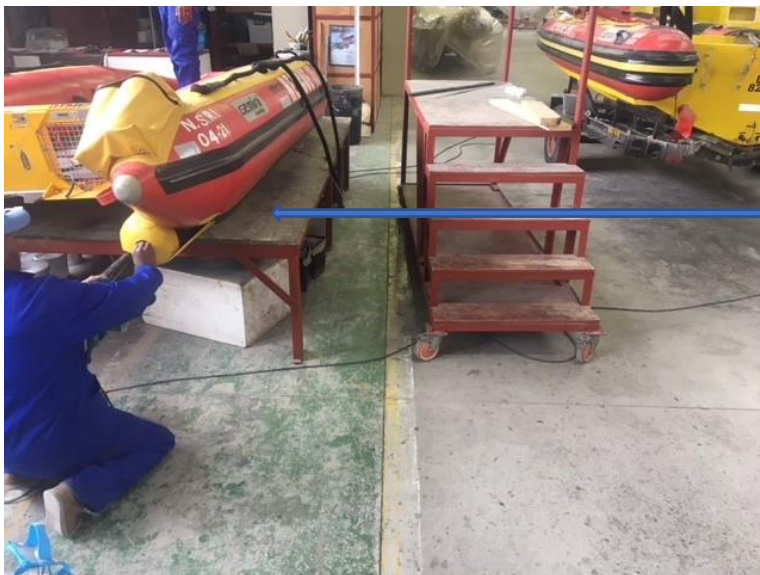
Floorboards being worked underneath retaining rubber using a metal bone.

- Once satisfied that the floorboards are fitting properly, inflate the boat starting with Port and Stb sides: Inflate to two thirds of the correct pressure. While doing this ensure the floorboards stay in the correct positions. Then inflate the bow section to two thirds of the correct pressure. It is advised that a person stand in the boat – as per the photo below – to ensure that the floorboards do not “pop “out during the inflation process.
- Make sure that the floorboard retaining rubbers are over the floorboards all the way from the front to the back of the boat.



Tubes inflated to two thirds full pressure.

- Inflate the hijackers fully to correct pressure. Then check the inflation on all the tubes, so that they are at 0.25 bar pressure.



Hijackers inflated to correct pressure of 0.50 Bar.



Fully inflated boat with floorboards and stringers fitted correctly.