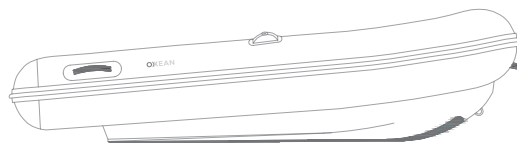




Owner's Manual



OXEAN™

Owner's Manual

CONTENTS

	Index
Prologue	4
General Arrangements	5
Declaration of conformity	8
Certification.....	9
Marine Safety.....	10
Boating Terminology.....	12
HIN.....	13
General.....	14
Assembly.....	15
Inflating Instructions.....	16
Fitting the rowing seat.....	21
Fitting and assembly of oars.....	22
Hull drain plug.....	23
Maintenance.....	25
Storage.....	28
Repair of the hull.....	28
Repair of the tube.....	29

	Index
Use and Performance.....	33
Operation.....	37
Boaters check list.....	38
Towing.....	39
Davit Lifting.....	41
Transport by road.....	42
Electrical installation.....	44
Color code.....	51
Maintenance.....	52
Frequently asked questions.....	52
Recommendations.....	53
Electrical diagrams.....	55
Electrical installation Alumax 290 to 350 ALX.....	56
Troubleshooting chart.....	57
Warranty.....	58

ABOUT US

OXXEAN™ Inflatables is dedicated to the manufacture of high quality PVC rigid inflatable boats. We are committed to exceed customer expectations and provide an international service network.

OXXEAN™ is a mixture of the best aluminum hull construction and the best PVC fabric in the market today. Each OXXEAN™ is built with the highest standards worldwide to deliver an exceptional value. Our ISO 9001 certification provided by Bureau Veritas, CE certification and ISO 6185 demonstrate our commitment to deliver the most reliable rigid inflatable boats.

Our philosophy is not just about building inflatable boats; it is about being passionate while doing it. We invite you to discover the OXXEAN™ way.

Reasons for choosing Oxxean Inflatables

Materials. We use the most reliable materials to build every OXXEAN™. Every aluminum boat is made with marine grade aluminum (5000 Series) and the well-recognized Valmex® PVC tubes from the German Company Mehler Technologies.

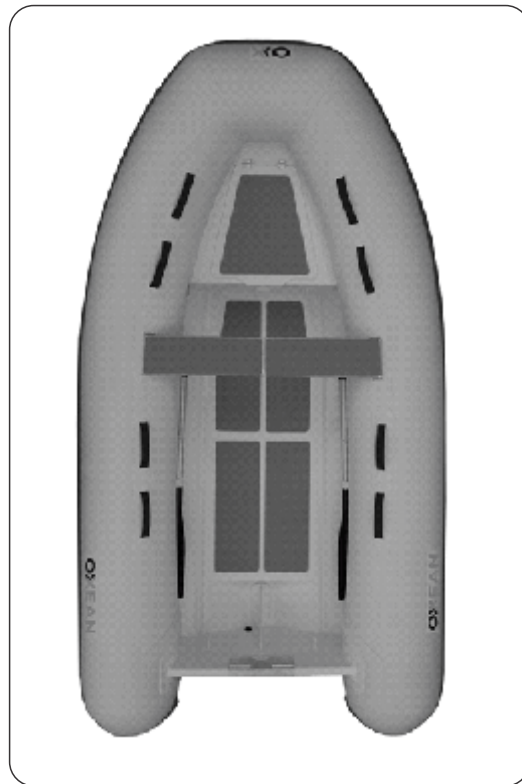
Quality. Our production process is certified with the highest industry standards. At OXXEAN™, we receive third party audits periodically to guarantee the quality we deliver on each of our aluminum inflatable boats. We also invest in all our manufacturing team to assure that the best practices are followed when building every OXXEAN™. As an example, our welders are certified according to the American Welding Society (AWS) standards to achieve superior quality in every single unit.

Powder Coating: At OXXEAN™, we use an **eco-friendly** advanced powder coating technology (ROHS Compliant) on all our aluminum boats to reach durable and high quality finishes. This advanced technology also allows us to increase protection against corrosion according to several researches and studies of the **American Society for Testing Materials (ASTM) International Standards**.

Environment. We care about the environment and understand our responsibility to help create a better future. For this reason, our materials and manufacturing processes are eco-friendly alternatives not only for the community but for our OXXEAN™ teammates. We demonstrate this by being compliant with regulations and beyond, using superior technologies and adjusting our manufacturing processes, all driven by a continuous improvement culture.

Service. OXXEAN™ inflatables is proud to have a first-class international dealer network with the technical capabilities and commitment to serve you throughout the life of your OXXEAN™ boat. To find your local partner please check the **Where to Buy** section or contact us at info@oxxeaninflatables.com

GENERAL ARRANGMENT



DECLARATION OF CONFORMITY

Application of EU Recreational Craft and Personal Watercraft Directive 2013/53/EU, Module A1

Applicable Standards

ISO 6185-2

ISO 6185-3

Desing Category

"C" inshore: craft designed for use in coastal waters, bays, lakes and rivers where weather conditions are wind forces of 6 in the Beaufort scale and waves with 2 meters (6,56 ft.) height.

Manufacturer

BOATING INTERNATIONAL

Manufacturers Address

Calle 1E # 2-15, Bodega # 9, Zona Franca de Barranquilla, Colombia. Phone +57 5 379.51.32

Certifying Body

HPI Verification Services Ltd.

EU Notified Body number: 1521

The Manor House, Howbery Park, Wallingford, OX 108BA
United Kingdom

Website: www.hpivs.com

Email: enquires@hpivs.com

Thanks to the CE mark we as manufacturer can issue a Declaration of conformity per every boat when is needed. For any further information please contact us.

Type of boat: Inflatable Recreational Craft

Serial Number type

Year of manufacture

Boating International, as the manufacturer, declare that the equipment specified above is compliant with the Standards.

CERTIFICATION

	Models	HPI 2016 Certification	CE CAT	ISO 6185	Type
1	ULTRA 260	HPIVS/R1088-113-I-02	C	1	II
2	ULTRA 275	HPIVS/R1088-114-I-02	C	2	V
3	ULTRA 320	HPIVS/R1088-115-I-02	C	2	V
4	ALUMA 260	HPIVS/R1088-100-I-02	C	1	II
5	ALUMA 275	HPIVS/R1088-101-I-02	C	2	V
6	ALUMA 290	HPIVS/R1088-102-I-02	C	2	V
7	ALUMA 320	HPIVS/R1088-103-I-02	C	2	V
8	ALUMA 350	HPIVS/R1088-104-I-02	C	2	V
9	ALUMAX 290	HPIVS/R1088-116-I-02	C	2	V
10	ALUMAX 320	HPIVS/R1088-117-I-02	C	3	VII
11	ALUMAX 350	HPIVS/R1088-118-I-02	C	3	VII



MARINE SAFETY

This Manual is not intended to provide complete training on all aspect of boat operation; we recommend seeking additional information on boat handling and safety.

Safety requirements are different from country to country, from state to state and whether you are within coastal waters or inland waters. For detailed information please check with the local authorities.

Your OXXEAN™ inflatable boat is a safe device, due to its air chambers, but the law also requires at least one type I, II or III personal flotation device or PFD for each person on board or towed on water skis; and in addition, one throwable type IV PFD. As the owner, obtaining PFD's and other necessary safety equipment is your responsibility.

PFD's are intended to help you save your own life; you and your passengers should wear a PFD whenever boating. Many countries/states require children, age 18 or younger, to wear PFD's at all time. It is especially important that children or non-swimmer wear PFD's. Make certain you know how to use PFD's. Try it on and make adjustment for a comfortable fit. Show the children how to properly use a PFD.

SAFETY MESSAGE



NOTICE

Special PFD's are available for skiing and other water sports. These PFD's are constructed with material suitable for high impact falls into the water.



DANGER

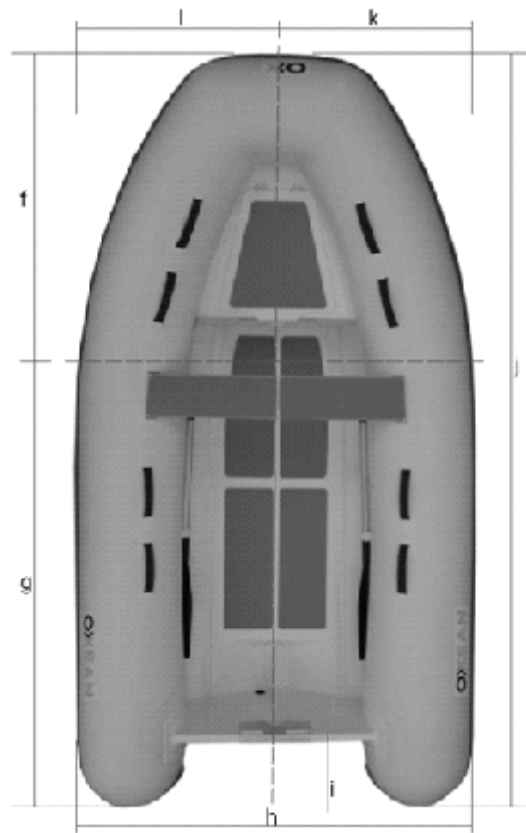
*Occupants must avoid standing up or seating on the gunwale when the boat is in operation.
*Shut off the engine before reboarding from water.

RECOMMENDATIONS

Carry on your boat all or as many you can, of the following items:

Anchor and anchor line	Mooring lines
Bailer	Oars / Paddles
Batteries	PFD's
Bellows	Portable Marine fire extinguisher
Charts	Portable radio with weather band
Engine tools	Spare keys
Extra fuel	Sunscreen lotion
First aid Kit	Tool kit
Flares	VHF
Fresh water	Waterproof flashlight
Maintenance kit	

- a. Stern
- b. Waterline
- c. Freeboard
- d. Bow
- e. Keel
- f. Forward
- g. Aft
- h. Beam
- i. Transom
- j. Overall length
- k. Starboard
- l. Port



HULL IDENTIFICATION NUMBER (HIN)

You should safeguard the information about your boat by recording the hull identification number (HIN) and model of your boat. The HIN is located on the upper starboard corner of the transom. This number is very important, in case of theft, damage, warranty claims, etc., report this number to the local authorities, your insurance agent and your dealer.

GENERAL

Hull

The air chamber is “U” shaped PVC with rounded airtight cones in the same material, and ensures complete safety at every ride. OXXEAN™ inflatable boats have large tubes for each boat size to maximize payload capabilities and offer a dry ride.

The bottom of your OXXEAN™ inflatable is made of aluminum, providing the customer a perfect seaworthiness.



Caution

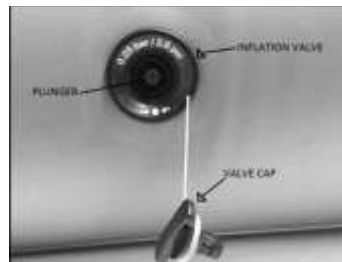
Do not drill holes on deck deeper than 1,27 cm (1/2"). (Only for ALUMA and ALUMAX), the ULTRA models can't be drilled at all or water will flow into the boat.

ASSEMBLY

Your OXXEAN™ inflatable needs a quick preparation before use. You must inflate the buoyancy chambers, attach the engine and get it ready. Fit any removable accessories and the safety equipment. For detailed info please read the Marine safety chapter of this manual. Also make sure the drain plug is in its position and tightened before launching the boat.

INFLATING INSTRUCTIONS

Inflation valves: The valves are made of plastic, non-corrosive and sealed for safety. The valve is divided in two pieces, one is located on the inner side of the buoyancy chamber, and the other is screwed to the aforementioned piece from the outside of the buoyancy chamber. This last piece is a one-way check valve, a diaphragm and a cap. This screw on system enables you to remove and replace a damaged valve in an easy way.



To Inflate: To Inflate: Push the end of the hose with the correct valve connector into place on the valve as far as possible and turn clockwise until the valve connector locks in place. Compress the hand pump gently and unhurriedly. When inflated, screw the plastic cap onto the valve until it is fully seated.



NOTICE

DO NOT use a gasoline service station or a high compression pump to inflate your boat; it could damage the buoyancy collar.

Air tightness is obtained partly by means of the plunger one-way check valve that is set in the base of the valve insert; complete air tightness is ensured by the properly fitted valve cap. Before

screwing on the cap, check that the valve is clean, free from sand weeds or other debris.

Deflation: to deflate the chambers remove the cap and with a finger, push down the spring loaded plunger in the center of the valve. To deflate totally you may want to lock the plunger down.

Hand Pump: To inflate your OXXEAN™, plug a connector appropriate for the valve. Put in an upright position and step onto the tongues, located at the bottom of the pump. The hand pump is a double action one. Each time you lift and push the handle, 4lts (1 gallon) of air will enter the buoyancy chambers. The hand pump has two configurations, one for inflation the other for deflation.

Buoyancy Chambers: depending on the model; it will have two or more air chambers. The more chambers it has, the safer it will be. Each chamber is divided from the other by a special baffle system that keeps our multiple air chambers completely sealed off from one another, while working to equalize air pressure between compartments. You must inflate your boat properly and check the pressure frequently. The pressure should be maintained at 0,02 bar (3 Psi) in the buoyancy chambers. (A pressure gauge is not included with the boat).

A good rule of thumb is: When you cannot depress the tube more than 1 Cm (1/2") with the pressure of your finger, you have then reached approximate working pressure.

Note: to inflate the air chambers, start for the aft chambers first, and then those towards the bow. When the inflatable buoyancy chambers have been inflated, screw the cap on the valve properly in order to secure final air tightness. To guarantee the performance of

the OXXEAN™ boats, the buoyancy tubes must be inflated to the recommended pressure. When the buoyancy tube cannot be depressed by finger pressure, the approximate working pressure has been reached.



NOTICE

The pressure in the air chambers fluctuates with the change of the temperature; after prolonged exposure to the sun the pressure increases and it falls when there is no sunlight or when the boat is launched. It is the normal behavior of the air chambers; don't worry if you note this.

INFLATING INSTRUCTIONS

If your OXXEAN™ boat was fully inflated in the cool of morning, then don't allow it to be in direct sunlight. The buoyancy pressure will rise very fast with the temperature and could strain or cause serious damage to the buoyancy tube.

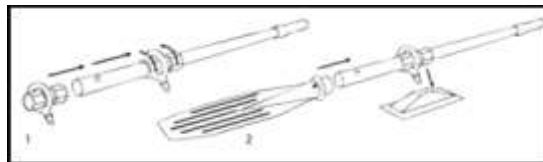


FITTING THE ROWING SEAT

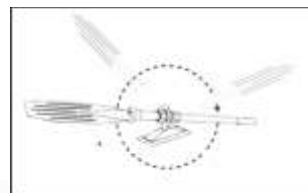


THE REMOVABLE SEAT IS EASIER TO FIT IF THE BUOYANCY CHAMBER IS SLIGHTLY DEFLATED.

FITTING AND ASSEMBLY OF OARS



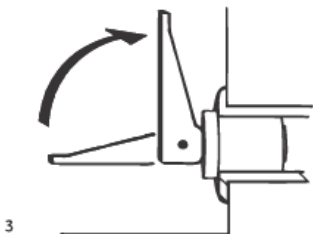
The pin type oarlock has to be fitted to permanently attached oarlock bases as shown in the illustration: fully seat the oarlock into the sleeve portion of the base by aligning the flat part of the oarlock pin, and the fixed pin within the sleeve of the base. When fully seated on the base, rotate the oar assembly 180 degrees to lock the oar into position, after the correct assembly, the oar and the oarlock pin type won't pull out of the oarlock base. To disassembly the oar and oarlock you must perform in the reverse order.



HULL DRAIN PLUG



1. Expanding Drain Plug.
2. Thru hull fitting.



3. To fit the drain plug, push the plug into the thru hull fitting located in the transom and lift the handle 90 degrees as shown in the figure 3 to lock.



Caution

Before launching the boat, make sure plug is secured into the thru hull fitting.

HULL DRAIN PLUG

Note: If leaving the boat on davits or storing it out of the water. Remove the drain plug so rain water may drain.



CAUTION

Before launch the boat make sure the drain plug is in position.



DANGER

DO NOT remove the drain plug while afloat.

MAINTENANCE

Making a periodic cleaning is the best way to keep your OXXEAN™ inflatable looking great. Keeping your OXXEAN™ inflatable clean and in good shape is easy. Follow these instructions after each use and more often when used in salt water.

Open Tender

- Remove the outboard engine, seat and oars or paddle.
- Inflate the boat up to working pressure.
- When dry, vacuum clean or brush it in order to get any sand, gravel rubbish or debris off the floor.
- If necessary, remove all tar or sea particles with toluene.
- Clean all over with ordinary soap and water rinse thoroughly with fresh water.
- Check the inflation valves, clean them and remove any sand or debris.

Console tenders

- Clean as afore mentioned.
- If you can lift the boat out of the water, remove the transom drain plug, if not use your bilge pump.
- Wash the hull and floor with mild detergent and fresh water.



CAUTION

DO NOT spray on the tubes any solvent or greasy solution, this can contaminate the materials and repairs must become necessary.



NOTICE

DO NOT use any abrasive cleaners, solvents, ammonia or chlorine as these will damage the tube surface. Use special cleaners to remove marine growth from the hull. (Scum, algae). Try to use as few cleaners as possible; do not discharge waste into the water.

Aluminum Care

Wax the painted surfaces of the boat twice a season. Use boat or automotive wax.

Aluminum corrosion

Under certain conditions aluminum boats are subject to corrosion. There are different kinds of corrosion to happen, among others: galvanic, stray current and poultice. All these types of corrosion result in metal eaten away and if not stopped can cause severe damage to your boat. Although these types of corrosion can occur in fresh water; salt, brackish, polluted and high mineral content water will greatly accelerate corrosion.

There are various variables which foster corrosion as salinity of the water, temperature, organic material in the water, electrical activity nearby, presence of other metal, among others.

Corrosion is a common occurrence, but the deterioration process is usually slow with ample but subtle time to take corrective actions. Boaters should protect the boat against corrosion in the best feasible manner and be disciplined in looking for it.

Always watch for corrosion near bolt holes, chipped paint, behind peeling paint and any place the aluminum has been scratched or dented. Edges, cracks places that trap salt water and debris are more susceptible for corrosion. Avoid build-up of organic material, plant growth, algae or barnacles.

For corrosion in general, routine cleaning and maintenance is the best hand you can give to your boat, specially in areas of difficult access such as the space between the tube and the hull, where different types of residues or organic material can cumulate and create an environment for corrosion.

Poultice corrosion may occur when bare aluminum surfaces are covered by absorbent materials, dirt and debris trapping moisture against the unprotected metal surface. A way to prevent the poultice corrosion is to repair scratches and dents as soon as they occur, also to coat all bare metal surfaces, but the most important, coated or not, you must keep the aluminum clean and dry.

Additionally, boats used in afore-said water should be properly protected with antifouling paint or a similar protectant, but it is best to remove the boat from the water when not in use. It is important to consider that antifouling products must be suitable for aluminum. It must not be based on a dissimilar metal, copper is particularly problematic.

In some cases, it is also advisable to add extra zinc anodes securely attached with clean and tight connections. Never paint or coat zinc anodes and replace if they are eroded to 50% or more.

Isolate the hull from electrical current. Make sure your battery is grounded to your engine and do not ground electrical devices to the aluminum hull.

Except for sacrificial anodes, do not place any metal to the hull other than aluminum or high quality stainless steel. If you use fasteners they should be plastic or stainless, not zinc, brass, copper or iron based. Inside the boat, do not let any metal sit in the same spot in the bilge for long time.



NOTICE

Sacrificial zinc anodes can protect the hardware that is exposed to the water. Electrolysis attacks the softest metal first, the zinc will decomposed first than other metal on your boat. The zinc anode usually is attached to the engine. For further information check the engine owner's manual.



WARNING

Do not cover the boat with a canvas until completely dry, as this could damage the tissue of the tubes due to the mildew and water stains.



CAUTION

Certain household, industrial and automotive cleaners can cause damage and discoloration. Whenever using a product for first time, be sure to test it in an inconspicuous area first.

Upholstery

Regular washing with mild detergent and warm water, or automotive vinyl cleaners is sufficient to keep the cushions, canopy top and vinyl coverings in good conditions. Keep the cushions from becoming soaked, and dry them off thoroughly after washing to prevent mildew accumulation when the boat is covered. Prop the cushions up in the boat when covered to allow air circulation, and spray with mildew repellent. Periodically, lubricate canopy to snaps with petroleum jelly and lubricate zippers with paraffin wax.

STORAGE

After you have cleaned the boat and it has dried completely, deflate it, cover it with a canvas and store it on top of chokes or trailer under a roof or shade.



NOTICE

The tube can be deflated with the hand pump by changing the connection to the deflation position.



WARNING

Protect your OXXEAN inflatables against rodents and other vermin that can feed the fabric of the boat.

REPAIR OF THE HULL

Aluminum hulls have strength and durability, for this reason they tend to suffer less than fiberglass hulls. In case of perforations, dents, ruptures or fractures please take your OXXEAN™ inflatable to an authorized service center specialized in aluminum welding. If the hull has not received the proper care specified in the maintenance chapter it could be victim of corrosion, depending the grade of the corrosion it could be repaired in the specialized center mentioned above.

REPAIR OF THE TUBE

Your OXXEAN™ inflatable is supplied with a maintenance kit for patching minor punctures, this kit is composed for patches of PVC fabric material, brush, glue, catalyst and sanding paper, which are the same as those used by the manufacturer of boats.

If your OXXEAN™ inflatable has suffered a major accident that compromises the tube, please refers to an authorized service center in your area. Get in touch with the closest OXXEAN™ inflatables dealer for assistance.

If your OXXEAN™ inflatable is leaking, run a test of 5 hours long to have a good estimate, but one should stabilize the pressure at 0.2 bar (3 psi) during the first half hour. Any change in temperature can cause modifications ranging from 0.003 bar (0.045 psi) per one Celsius degree (34 F°). It is impractical to look for leaks which do not lower the pressure beyond 0.003 bar (0.045 psi) per hour.



WARNING

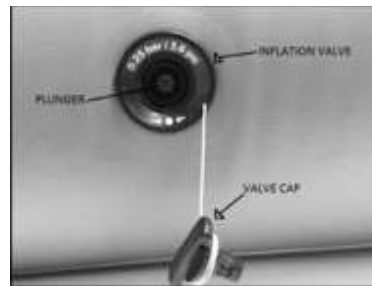
Any important fall of pressure must be checked immediately.

First you have to determine where the air is leaking from, to do this follow these instructions:

- Confirm that the air valve is free of sand or any debris.
- Make sure the valve gasket is right in place.
- Inflate the buoyancy chamber.
- Close the cap on all the valves.

- Rinse the tube with soapy water, including the perimeter of the valves.
- Wherever bubbles appear, that is the location of the leaking for repairing.
- Mark the area with a pencil, not a pen or a marker, as they will stain the tissue.
- If the leak is in the buoyancy chamber, read the section of repairing a perforation or puncture.
- If the bubbles appear around the valves, then the valves are loose.
- The valves are a nut and bolt system. Deflate the tube, hold the back of the valve trough the fabric and tighten the front, you can do this either using your hands or you may use a plier and turn clockwise.

Note: USE MODERATE STRENGTH.



- If there are no bubbles either on the fabric or around the valve when the tubes is inflated, then cover the closed cap of the valve with soapy water, if bubbles appear you must change the valve.

- With the buoyancy chamber deflated, unscrew the front of the valve and replace it with a new one.
- If none of the above applies, please contact your closest OXXEAN™ inflatables dealer.

REPAIR OF THE TUBE

Repairing a perforation or puncture

Repairs should be carried out on deflated or partially deflated boats.

Repairing a detached accessory

Repairs should be carried out on completely inflated boats.

REPAIRING THE TUBE

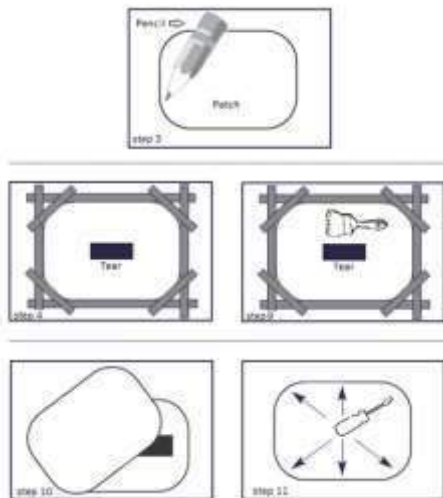
Preparation of the work place:

Is very important to have a right work area to ensure nothing goes wrong with the repair. The ideal area must be ventilated, dry (less than 60% humidity), and between 18-25 C°. In humid, cold or wet weather the glue may dry slowly so it may be necessary to use an electric hair dryer until the glue dries to tacky state.

To repair a Minor tear please follow the next instructions (for large tears please take your OXXEAN™ to an authorized service center):

1. Clean the surface around the tear to keep the area free of any particle or debris.
2. Choose a PVC patch that is at least 5 cm (2 in) gap around each edge of the hole.
3. Place the patch over the tear area and contour the patch with a pencil to leave a mark in the area.
4. Tape on the outside area marked with pencil, use masking tape.
5. Prepare the glue as follows: 10 parts of glue + 1 part of catalyst (10:1). Mix both in a clean glass or metallic container using a clean metal or wooden stick.
6. Clean both areas with solvent, then ensure is dry and spread a thin layer of glue in both areas.
7. Use a brush to apply the mix of glue and catalyst to both surfaces in a thinly manner, the surfaces should look wet, allow the surfaces to dry for 15 minutes until dry. Apply the second coat of glue and let it dry for 5 to 10 minutes.
8. Heat both areas with a hot air gun to re-activate the glue.
9. Put the two parts together, start by affixing one side of the patch and move slowly to the other side by pressing the surfaces together. This will place the air bubbles out.
10. Use the backside of a screwdriver and press it over the two parts already glued together, always from the center to outwards so as to press out any air bubbles.
11. Remove the masking tape and clean any excess of adhesive, if the adhesive is left on it will turn brown.
12. Leave it for dry at least twenty four (24) hours before applying air to the tube.
13. The full cure takes forty eight (48) hours.

REPAIR OF THE TUBE



USE AND PERFORMANCE

Your OXXEAN™ inflatable can be used in many ways and give you endless satisfaction. Nevertheless, its maintenance and its performance depend on a number of factors that are important to you, the owner and which are respectively:

- Proper balanced inflation is the principal factor of controlling the correct operation of the boat. Is important to know that the buoyancy chamber should be inflated to a pressure of about 0,2 bar (3 Psi) and the inflation varies with the temperature 1 degree more or less will cause the pressure to vary by about 0,003 bar (0,045 psi). This pressure variation takes place as a result of temperature changes, without the air tightness of the buoyancy chambers being at fault. Furthermore, the pressure will drop when the boat is launched. It is therefore advisable to reinstate the correct pressure with the hand pump after the boat has been launched or after it has been used for a few minutes.
- As a general rule, the load of a boat should be distributed along the center line and rather towards the rear of the boat. Remember this in connection with fuel tanks, diving's bottles and other heavy items. Small items and light equipment will normally be stowed towards the aft. In the case of a rigid hull inflatable, within the boat hatch.

Water skis or spear guns should be place against the buoyancy chambers or fixed to them. Once again if your inflatable is a R.I.B. then stow these items in any of the compartments designed for storage. Remember to protect the material from sharp object, roughness or rubbing (Sand is an excellent abrasive).

In heavy seas and brisk winds, the load should be moved forward. In calm waters the load should be moved further aft.

Depending the loads and the engines the boat may remain bow high, this is a result of a critical speed of the outboard engine which should be overcome by accelerating smoothly and evenly in order to avoid excessive strain on the stringers and the transom. The driver and/or passenger may also move forward in order to get the boat on plane, and then return to their original seating position. Once the boat is planning the speed can be reduced slowly.

Beware of overloading the bow of the boat which will result in loss of speed. In rough weather a slight overloading at the bow will ease the motion of the craft. Please check the load capacity of your OXXEAN™ inflatable either on the capacity plate located in the transom of your boat.

- It is the owner's responsibility to decide on the proposed use of the boat before selecting the size of the outboard on your OXXEAN™ inflatable. In order to retain maneuverability and the best performance of your OXXEAN™ install an outboard that doesn't exceed the recommended limits to guarantee a safe boating.

We make the following recommendations with regard to the use of the outboard in your OXXEAN™ inflatable:

- Read the engine owner's manual before installing and/or operating.
- In the case of smaller dinghies, the clamps of the engine must be checked after 15 minutes underway.

- The engine must be in the center of the transom.
- To prevent an accident and the loss of the engine, should it fall to the transom, attach the engine to a secure line connected to the boat, you can use an existing stern eye or a lifting ring as an attachment point near the stern.
- Before tilting your engine or before drawing the boat out of the water, disconnect the fuel line and allow the engine run until the carburettor is dry, so that when the engine is tilted no fuel is discharged into the boat.

Adjustment of the outboard engine

- The angle of the engine in relation to the transom is very important to ensure the correct performance of the boat.
- As a general rule, the axis of the propeller must be parallel with the surface of the water when the boat is on plane. If the outboard is too far of the transom, the boat will depress in the stern when you start off, and if the engine is too close to the transom the boat will ride nose down. This adjustment may vary on the same outboard depending on the weight and position of the load and the condition of the sea.
- The height of the outboard engine will equally affect the performance of the boat, making water getting in form of spray behind the transom, alteration of center of thrust and speed. Most of the outboards can be fitted directly on to the transom mounting plate. When used for some purposes (speed, heavy loads, etc.) a wooden batten of a thickness of between 0.5 and 2 cms (3/16" and 7/8") may be placed on top of the transom in order to raise the engine in relation to the transom. For more information

consult the engine operator's manual.



NOTICE

An outboard engine which is installed too high will tend to cavitate, especially on sharp turns, and will run the risk of exceeding its normal operating conditions.

An outboard engine which is installed too low may cause the water to enter over the transom between the clamps.

OPERATION

Before starting:

- Check the pressure in the buoyancy chambers 0,2 bar (3 psi).
- Secure de valves cap.
- Check the oars/paddles are properly secured.
- Ensure the outboard engine clamps are properly tightened.
- Check the fuel lines, vent hoses and drain hoses are in good condition.
- Be sure there's enough fuel for the boating trip.
- Do not forget the boat's papers and license.
- Do not forget the required equipment at sea.
- The tool kit might be needed, as well repair kit and air pump; make sure these are onboard.
- Avoid making noise and wake in the vicinity of other users and respect the speed limitations.
- Please check the chapter on marine safety and with local authorities on the safety requirements which must be followed.

BOATER'S CHECK LIST

To enjoy your ride in a safe way.

Before launching:

- Read and understand the owner's manual.
- Drain plug (Securely in place).
- Steering system (Working smoothly and properly?).
- Propeller conditions (prop nut tight and secure, not cracked or bent blades).
- Battery (Fully charged, cable terminal clean and tight).
- Check weather forecast before departing the dock
- Fuel system (Adequate fuel? Leaks? Fumes? Enough for trip?).

- Hoses and connectors (No leaks or damage).
- Electrical equipment (Lights, bilge pump, radio VHF, etc.).
- Be sure to carry all emergency and safety equipment (fire extinguisher, anchor, signaling devices, tool kit, mooring lines, first aid kit and owner's manual).
- Float plan.

Before starting the engine:

- Fuel (Sufficient for trip; check bilge area for odor).
- Engine (Control in neutral?).
- Capacity plate (Are you overloaded?).
- Life saving devices (One for every person on board).
- Seating (Everyone in proper place).
- No one in water near boat.
- Lanyard stop switch (Operational and securely fastened).
- Keep a firm and continuous grip on the steering wheel.
- Check bilge for fuel or water contamination.

TOWING YOUR OXXEAN

There are different ways to tow your OXXEAN™ inflatable, as manufacturer we recommend to tow the boats by the tow eye. Your OXXEAN™ inflatable is fitted with lateral tube tow rings, these help maintain a stable direction of the boat while being towed. The performance of the boat while being towed will depend on the speed, sea conditions, distance between boats and wind. Leave at least two lengths between boats to have an adequate distance.



WARNING

- Never tow a boat with people on board.
- Towing or being towed stresses the boats, hardware and lines. Failure of any part can serious injure people or damage the boats.
- Never use three-stand twisted nylon; it has too much elasticity and can snap back dangerously. Because of the tremendous stress caused by towing, use a tow line that is rated at least 4 times the gross weight of the boat being towed.



CAUTION

- Do not Attach the towing line to the bow grab handle or any other accessory not designed for that purpose.
- Tow ropes must always be in good condition, free of any cuts or abrasions.
- When attaching the tow line to a fitting, be sure the fitting is fastened securely and trough-bolted.
- Keep the towing boat and the inflatables tender on the crest or in the trough of the waves at the same time.
- In protected, calm waters, shorten the line for better handling. Never attempt to tow a much larger or grounded vessel.
- Always tow at moderate speed so as to prevent sudden strain on slack line.
- Keep lines all clear of propellers.
- Keep hands and feet clear of the other boat.
- Never hold a towline after it is pulled taut.
- The boat structure can be damaged by excessive pulling strain.
- Be ready to cast loose or cut the line if the towing situation becomes hazardous.



DANGER

Do not allow anyone to be in line with the rope. If the rope should break or pull free, dangerous recoil could occur which may cause serious injury or death.

DAVIT LIFTING

The OXXEAN™ inflatables have davit lifting rings installed from factory.

Depending on the davits installed on the main vessel, you may lift your tender in two different ways: single point or dual point. Please see diagram.



DAVIT LIFTING

1. SINGLE POINT DAVIT LIFTING
2. DUAL POINT DAMT LIFTING

TOWING

1. ADDITIONAL TOW LINE FOR BACKUP. ...
2. TOWING LINE WITH BRIDLE.
3. TUBE TOWING RINGS.



NOTICE

Always pump the water from the bilge before lifting the boat.



CAUTION

Do not hoist the boat with people on board. Lifting attachments are designed for hosting the boat, engine and standard equipment only.



WARNING

- Keep the bow slightly higher than the Stern. Remove the drain plugs when stowing the boat.
- Never attach lifting cables to grab handles, lifelines, cleats or any other accessory not intended for lifting purposes. Attach only to the lifting rings in the transom and bow.



CAUTION

When transporting the OXXEAN™ inflatable at the roof, we recommend to stop every hour to check the security of the boat and its lashings.

TRANSPORTING BY ROAD

To transport your OXXEAN™ inflatable you can choose between carrying the boat upside-down on the roof of the car or carrying the boat on a trailer.

Carrying the boat on the roof of a car: the roof of the car must be in proportion to the length of the boat being carried, a special roof rack is the best way to avoid any damage to the boat and to the car. Stow the boat upside-down on the roof where its shape will offer less resistance to the wind, if you want to carry the boat right way up, there is a risk if rains and the boat collects water. Remember to remove the drain plug.



WARNING

- Beware of chafing. If any lines securing the boat to the car roof or rack rub against the tube, insert a piece of carpeting (soft side against the tube) so as to avoid damage.
- Beware of chafing when deflated. Do not transport your inflatable upside-down.

Carrying the boat on a trailer: there are several types of trailers available; however, the trailer must match the boat's weight, the hull and the load. The towing vehicle must have the capability of pulling the load. Pulling a load that exceeds the vehicle's towing capacity may cause loss of control.

- When choosing your trailer consult your OXXEAN™ dealer.
- Always read the trailer owner's manual carefully before towing.
- Check country, state or local regulations and requirements.

ELECTRICAL INSTALLATION

- General Description
- Standard Equipment
- Electrical System Operation
- Color Code
- Maintenance
- FAQs
- Recommendations

General Description

Read the recommendations below, before launching your boat. Be sure to understand the information given in this manual, any improper operation could jeopardize the operation of the equipment in the boat.

The following equipment description includes only the elements which are installed at the factory as standard equipment. For any additional information please contact your local dealer.

Each system and its equipment were carefully selected and designed so that it meets with the requirements settled by the ABYC and ISO standards. Also, this equipment is certified for marine use, which guarantees durability under the conditions of humidity and salinity of marine environment.

Boats are delivered with a basic electrical installation that includes some or all of the following elements:

- Bilge Pump 500 GPH
- Navigation Lights
- Anchor Lights
- Battery Switch
- Battery box
- Fiber Carbon Switch board
- Steering System
- Steering wheel

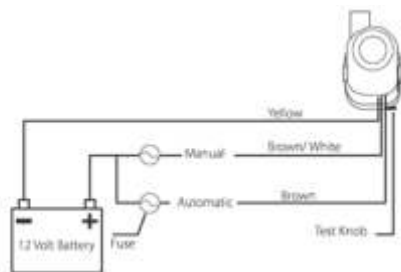
Standard Equipment

Bilge Pump Bilge Switch

The bilge pump is installed on a base located in the stern. The function of this device is to evacuate the water that accumulates on the boat because of waves or rain. The bilge pump has a dual operation start system, both automatic and manual. The pump has the possibility of a remote start by using the manual switch “BILGE PUMP” installed on the switch board located on the console. To protect the boat from the weather conditions, this equipment will work even when the “BILGE PUMP” switch is turned off; because the pump is connected directly to battery. Thus, the automatic float system will work even if the user is not there to assist the evacuation of water.

Bilge Pump Technical Features

Model	S500
Amp	1.5
Fuse (A)	3A
GPH/Oft	500

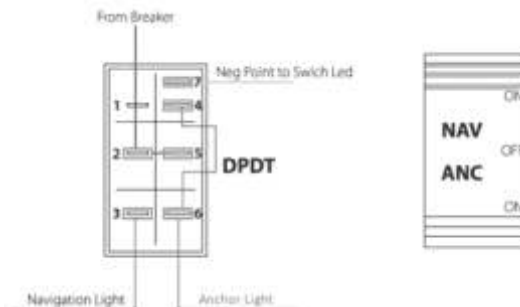


NOTE: See the bilge pump installation instructions attached in your owner manual package.

Navigation and Anchor Light

NAV/ANC Switch

The standard equipment on all models includes the anchor light (white) and the navigation light (red/green) which work with the NAV/ANC Switch located on the console switchboard. These lights should be turned on during the operation of the boat at night. When the boat is moving, the boater should turn on both navigation and anchor light; this is done by pressing the switch to the up position. When the boat is anchored the boater should only turn on the position light; this is one by pressing the switch to the low position. Both lights will be off in the central switch position.



The anchor light consists in a foldable pole with a Led light at its end. To make it work, install the folding pole into the plug-in base located behind the stern seat. Insert the pole matching the pin male orientation at the plug-in base with the female holes of the pole.

The boat comes with 3 storage clips under the stern seat, where the pole light can be kept while is not in use.

Battery Switch ON/OFF 300 Amp

The battery switch is the main ignition control unit for the boat energy. Through this device the energy from battery is transferred to the electrical systems. When battery switch is placed in the OFF position any device except the bilge pump is de-energized. The engine, indicators, lights and other accessories or equipment only will be operating when the battery switch is in the ON position. Use the battery switch in the OFF position in case of fire emergencies to cut off the power supply when an overcurrent event happens and to prevent battery discharge while the boat is not in use.



ELECTRICAL SYSTEM OPERATION

Your OXXEAN™ inflatable is equipped with a 12-volt direct current electrical system. The positive (+) red large gauge cable is connected between the (+) battery terminal and the battery switch. The negative (-) yellow large gauge cable is connected to a common post ground, where all negative wires of the boat devices are connected. To start your engine turn ON the battery switch.

When the boat is in operation, the battery will be permanently fed by the engine alternator.



WARNING

Do not place the battery switch in the off position, while the engine is running.

Breakers and Fuses

Each electrical circuit has been designed to meet the standards set in ABYC. E-11. OXXEAN™ has made emphasis in the selection of the circuit protection and automatic cutting devices.

Breakers: each one of the electrical circuits that feeds a certain load is protected by an automatic breaker, this is usually placed at the fiber carbon switchboard on the main console, above the switches of the circuits it protects. If an overcurrent event happens, the breaker will act and the circuit will be opened to avoid damage to the wires.

Fuses: are installed to protect the general circuits (Panel feed wire/circuit). When an overall damage occurs, the fuse will burn out and protect the circuit.



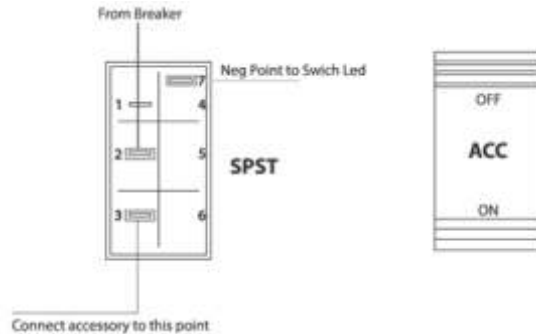
NOTICE

See the troubleshooting chart.

Additional Circuits

ACC Switches

The additional circuit for accessories are rated with an over current protection of 5 amps, so please consider this information when you select the additional devices to install.



COLOR CODE

Wire color selection is based on the ABYC standard E-11, Table XIV and XV.

Description/ Device	Color
Ground Wire	Green
Positive Conductors	Red
Negative Conductors	Yellow
Bilge/Fresh Water/Pumps	Brown
Ignition Wire	Purple
Fuel Level Sender	Pink
Instruments Lights	Blue
Navigation and Position Lights	Gray

MAINTENANCE

Despite having an excellent equipment line, the moisture and saltiness permanently present on marine environment can effect in long-term the components and may cause failures if they don't receive proper maintenance.

- Regularly review the status of the fuel hose connections to ensure there are no leaks.
- Perform regular maintenance for electrical equipment.
- Seek an electrical marine technician in case of repairs.

FREQUENTLY ASKED QUESTIONS

Troubleshooting chart

1. If the lights do not get on.

- Check the battery connection.
- Make sure the battery switch is placed in the ON position.
- Check the connections in the NAV/ANC Switch.
- Make sure the lights are in good condition.
- Check that fuses are not burned.

2. The Bilge pump doesn't work in automatic position.

The floating sensor allows the bilge pump to work in the automatic mode. Sometimes sediment or debris can accumulate blocking the float switch or the impeller. Remove the pump housing from the mounting base and clean the float switch and impeller so that it can have free movement.

3. No device turns on even when the battery switch is in the ON position.

- This may happen if the main fuse has burned. Check the fuses in the fuse holder; if necessary replace the fuses with the same capacity as indicated on it.

RECOMMENDATIONS

- If possible, do not keep turned on all the electrical devices simultaneously for long.
- Disconnect the battery when the boat is being transported by road (trailer) and make sure to remove the drain plug.
- Always keep in, your maintenance kit and spare fuses.
- Remember to turn OFF your battery switch, whenever the boat won't be used for long time. This will prevent a battery load loss if an electrical device is left on accidentally.



CAUTION

Never:

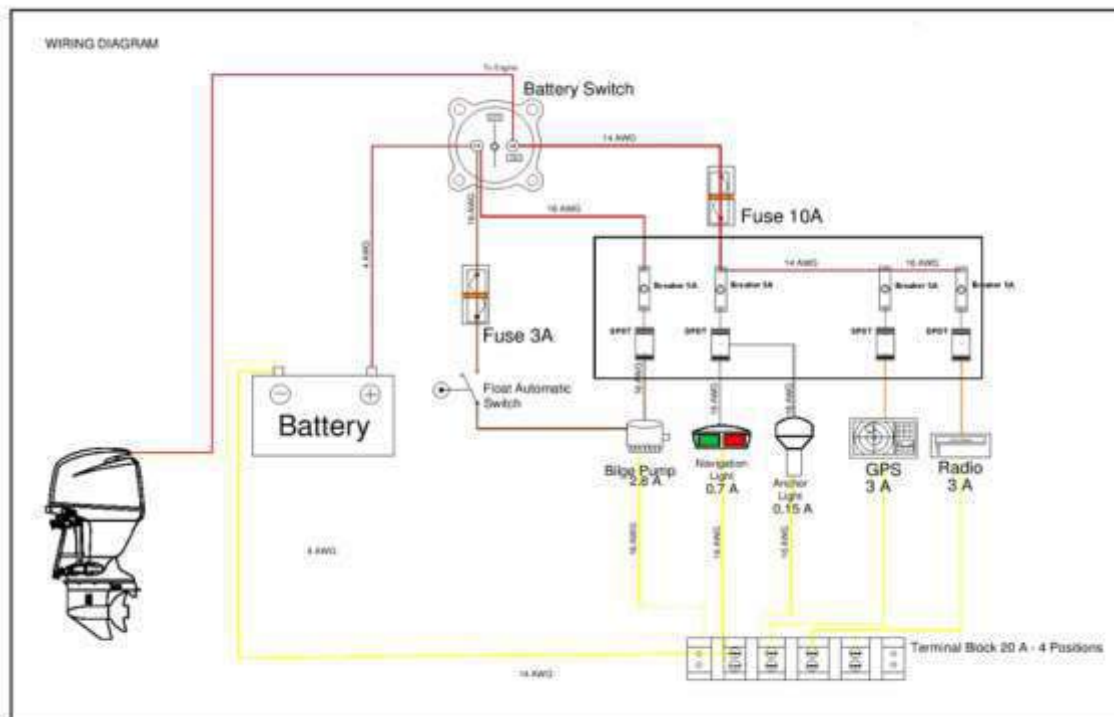
- Work on the electrical installation while the system is energized;
- Modify the craft's electrical system or relevant drawings: installation, alterations and maintenance should be performed by a competent marine electrical technician;
- Alter or modify the rated current amperage of over current protective devices;
- Install or replace electrical appliances or devices with components exceeding the rated current amperage of the circuit;
- Leave the craft unattended with the electrical system energized, except automatic bilge-pump, fire protection and alarm circuits.



ELECTRICAL DIAGRAMS

Please refer to these electrical diagrams when you want to make modifications, repairs or maintenance to the electrical power system of the boat.

ELECTRICAL INSTALLATIONS - ALUMAX 290 to 350 ALX



TROUBLESHOOTING CHART

The most common problems are listed in the charts below; please follow the instructions according each case otherwise consult your authorized OXXEAN™ dealer.

Problem	Possible reasons	Possible solutions
Buoyancy chamber losses air		Pressure increase after prolonged exposure to sun and falls when the boat is launched and when in darkness. Don't worry about this.
	Rise or drop of temperature	
	Plastic Valve cap has not been fitted	The valve is divided in two pieces, one is located on the inner side of the buoyancy chamber, the other is screwed to the afore-mentioned piece from outside of the buoyancy chamber. Please verify they are fitted.
	Loose valve	Check the "repair of the tube" section.
	Puncture	
Boat does not get on plane	Load is not distributed correctly	The load of a boat should be distributed along the center line and rather towards the rear of the boat. Small items and light equipment will normally be stowed towards the aft. Check capacity plate and ensure you are not overloaded.
	Boat is overloaded	
	Hull is out of water	Frequently remove the hull drain plug when boat is out of the water.

OXXEAN LIMITED WARRANTY

Routine maintenance indicated in the Owner's manual must be performed properly and timely in order to maintain warranty coverage. If the user performs this maintenance directly, OXXEAN Inflatables reserves the right to make future warranty coverage contingent on proof of proper maintenance.

1. WHAT IS COVERED

Every registered OXXEAN™ Inflatable boat and its parts and accessories is warranted by the OXXEAN™ DISTRIBUTOR under conditions of normal purchase as specified and limited below, with respect to items as follows from the date of original purchase:

A. Fabric: The Valmex® fabric is warranted for a period of five (5) years against porosity deterioration affecting serviceability according to the ability of the fabric to hold air according to ISO 6185 (airtightness test). This warranty does not include discoloration, puncture, fading, tearing, ripping, cracking, abrasion, chaffing, negligence, accident or ordinary wear and tear.

B. Valves and tube seams: The inflation valves and tube seams are warranted for two (2) years against defects in materials and workmanship. This warranty does not include ordinary wear and tear, negligence, or damage by improper inflation techniques.

C. Aluminum Hull: The aluminum hull for non-commercial use are warranted for five (5) years against structural defects in materials and workmanship. This warranty does not include the surface finish or any damage due to misuse, negligence or ordinary wear. This warranty is cancelled if the boat is

operated with an outboard motor which exceeds the maximum horsepower rating listed on the serial plate attached to the transom. Although we only use marine grade aluminum of the best manufacture, corrosion is not covered under our warranty. After every use, it is recommended to wash the boat with fresh water in order to avoid any build up. We also recommend that scratches and dents are repaired as soon as they occur.

D. Accessories: The oars, handles, seats, rings, moorings, cushions, steering systems and cables, hydraulic hoses and fittings, fuel systems, associated hoses, fittings, tanks, hardware and electrical cables, are warranted for one (1) year against defects in material and workmanship, with the exception of bilge pumps and water pumps. This warranty does not include any painted or finished surfaces.

2. WHAT IS NOT COVERED

A. Any damage to OXXEAN™ Inflatable boat due to negligence, accident, misuse, alteration, improper operation, improper tailoring, collision, fire, theft, vandalism, riot, explosion, or objects striking the boat, operation of the boat without the proper inflation, use of an outboard motor in excess of the maximum horsepower listed on the data plate fastened to the transom, or improper maintenance or storage.

B. Any damage resulting from towing OXXEAN™ inflatable boat, or any damage resulting from lifting an OXXEAN™ inflatable boat, except when the lifting eyes attached to the inflatable boat are properly utilized in connection with an OXXEAN™ approved lifting harness.

C. Surface finish is not covered by our warranty, ensure that your surfaces are rinsed with fresh water after every use and are cleaned immediately of any substances that may stick to

the paint surface and cause discoloration or damage. We recommend scratches and dents to be repaired as soon as possible after they occur.

D. Although we only use marine grade aluminum of the best manufacture, Galvanic Corrosion is not covered under our warranty. After every use, it is recommended to wash the boat with fresh water in order to avoid any build up. We also recommend that scratches and dents are repaired as soon as they occur.

E. Tubes exposed to harsh or corrosive chemicals.

F. Parts installed by anyone other than OXXEAN™ DEALER authorized personnel.

G. Any damage caused by aftermarket parts.

H. OXXEAN™ Inflatable boats purchased for racing or other competitive events; as well as charter, rental, commercial or governmental use.

I. Any work done on an OXXEAN™ inflatable boat at an unauthorized service station and/or without OXXEAN™ DISTRIBUTOR prior approval, will void the remainder of the warranty for that product.

J. Expenses related to haul-out, launch, storage, transportation, telephone, rental, inconveniences, slip fees, insurance coverage, loan payments, loss of time, loss of income, or any other type of incidental or consequential damages are not covered by this warranty.

K. Equipment installed on OXXEAN™ inflatable boat (such as electronics) carries their own individual warranties provided by their respective manufacturers. In such cases, any warranty claims regarding those parts must be directed to those manufactures and not to OXXEAN™ DEALER or DISTRIBUTOR.

L. OXXEAN™ inflatable boat which is used in a manner contrary to the instructions indicated in the Owner's Manual.

3. COMMERCIAL USE.

Warranty for any OXXEAN™ inflatable boat purchased for commercial and/or governmental use will be covered as follows:

A. Fabric: The Valmex® fabric is warranted for a period of one (1) year against porosity deterioration affecting serviceability according to the ability of the fabric to hold air according to ISO 6185 (airtightness test). This warranty does not include discoloration, puncture, fading, tearing, ripping, cracking, abrasion, chaffing, negligence, accident or ordinary wear and tear.

B. Aluminum Hull: The aluminum hulls are warranted for one (1) year against structural defects in materials and workmanship. This warranty does not include the surface finish or any damage due to misuse, negligence or ordinary wear. This warranty is cancelled, if the boat is operated with an outboard motor which exceeds the maximum horsepower rating, listed on the serial plate attached to the transom.

C. Accessories: The oars, handles, seats, rings, moorings, cushions, steering systems and cables, hydraulic hoses and fittings, fuel systems, associated hoses, fittings, tanks, hardware, electrical cables, switches and fuse panels are warranted for one hundred and twenty (120) days against defects in material and workmanship, with the exception of bilge pumps and water pumps. This warranty does not include any painted or finished surfaces.

4. TRANSFERABILITY.

This warranty is transferable to another owner within one (1) year of original effective date of sale; provided that an original

warranty card is on file with THE OXXEAN™ DISTRIBUTOR. The warranty transferred to a new owner is prorated in time with respect to the time of original purchase. This does not apply if the vessel is used for commercial use.

5. EFFECTIVE DATES AND CONDITIONS.

This warranty shall become effective on the date of sale provided that the warranty registration card is properly completed and mailed by the retail purchaser and received by the OXXEAN™ DISTRIBUTOR, within sixty (60) days from date of purchase.


6. MISCELLANEOUS.

This warranty shall not apply if the OXXEAN™ inflatable boat is subject to negligence, accident, improper operation or trailering, improper maintenance or storage, commercial or abnormal use or application, or to damage by circumstances beyond OXXEAN™ DISTRIBUTOR control, including but not limited to, puncture, tearing, ripping, abrasion, ordinary wear and tear. This warranty applies only to those parts and components manufactured by OXXEAN™ and installed by factory personnel.

THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER EXPRESSED OR IMPLIED WARRANTIES, THIS WARRANTY EXPRESSLY EXCLUDES IMPLIED WARRANTIES, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE, EXCEPT AS SPECIFICALLY SET FORTH WITHIN THIS WARRANTY. OXXEAN™ DISTRIBUTOR SOLE OBLIGATION, AND YOUR EXCLUSIVE REMEDY UNDER THIS WARRANTY, IS LIMITED TO REPAIR OR REPLACEMENT, AT OXXEAN™ DISTRIBUTOR OPTION, FOR PARTS FOUND TO BE DEFECTIVE. IN THE EVENT EXACT REPLACEMENT PARTS OR BOATS ARE NOT AVAILABLE AT THE

TIME OF THE WARRANTY CLAIM, OXXEAN™ DISTRIBUTOR MAY SUBSTITUTE PARTS OR BOATS OF THE SAME OR BETTER QUALITY AND THE CUSTOMER HEREBY AGREES TO ACCEPT SUCH REPLACEMENT IN SATISFACTION OF THE WARRANTY SET FORTH HEREIN. OXXEAN™ DISTRIBUTOR SHALL NOT BE LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL OR CONTINGENT DAMAGES WHATSOEVER, SOME STATES DO NOT ALLOW (A) LIMITATIONS ON HOW LONG APPLIED WARRANTIES LAST, OR (B) THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSIONS MAY NOT APPLY TO YOU. THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS, AND YOU MAY ALSO HAVE OTHER RIGHTS, WHICH VARY, FROM STATE TO STATE.

All warranty claims must be made through an authorized OXXEAN™ repair station within thirty (30) days of discovery of defect and submitted on the warranty claim form available from the dealer together with proof of purchase. Photographs illustrating damage, if any, must accompany the claim. An authorized OXXEAN™ DISTRIBUTOR representative may make an inspection within a reasonable time after receipt of the claim. Freight and transport charges, where applicable, incurred in shipping a boat to be repaired or replaced, are to be paid by consumer purchaser. OXXEAN™ DISTRIBUTOR reserves the right to make changes in the design and materials of its inflatable boats without incurring any obligation to incorporate such changes in units already completed or in hands of dealers or consumers. The entire obligation of OXXEAN™ DISTRIBUTOR regarding the sale of its inflatable boats is stated within this warranty. OXXEAN™ DISTRIBUTOR does not authorize its dealers, repair stations or any other person to assume for it any other liability in connection with the sale of its inflatable boats, the Federal Safety Act of 1971 provides for defect notification to the first



purchaser. Failure to register your purchase with the manufacturer constitutes waiver of the right to defect notification. Demand that the dealer completes your own registration form and send it to the manufacturer. If you are unable to locate an authorized OXXEAN™ dealer, please contact: OXXEAN™ Inflatables at info@oxxeainflatables.com.

