

## INSTALLATION INSTRUCTIONS

Original Issue Date: 4/90

Model: 20/30 kW

Market: Industrial

Subject: **Silencer and Silencer Mounting Kits PA-254494, PA-254495, PA-333026-SD, PA-333027-SD, PA-327114, PA-327115, PA-324099-SD, PA-324100-SD**

Kits	Industrial	Critical
Mounting Kits 20 kW (Ford)	PA-254494 PA-333026-SD	PA-254495 PA-333027-SD
Mounting Kits 20 kW (Perkins)	PA-327115 PA-324100-SD	PA-327114 PA-324099-SD
Silencer Kits	PA-255346 PA-255346-SD	PA-255347 PA-255347-SD

The silencer and exhaust mounting kits are used to install silencers on housed generator sets. Exhaust mounting kits do not include silencers. Order silencer kits separately. Observe the following safety precautions when installing the kit.

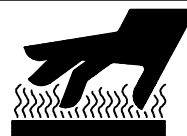


**Accidental starting.**  
**Can cause severe injury or death.**

Disconnect battery cables before working on generator set (disconnect negative lead first and reconnect it last).

**Disabling generator set. Accidental starting can cause severe injury or death.** Turn generator set master switch to OFF position, disconnect power to battery charger, and remove battery cables (remove negative lead first and reconnect it last) to disable generator set before working on the generator set or connected equipment. The generator set can be started by an automatic transfer switch or remote start/stop switch unless these precautions are followed.

### ⚠ WARNING



**Hot engine and exhaust system.**  
**Can cause severe injury or death.**

Do not work on generator set until it is allowed to cool.

**Servicing exhaust system. Hot parts can cause severe injury or death.** Do not touch hot engine parts. An engine becomes hot while running and exhaust system components become extremely hot.

## Installation

- Place the generator set master switch in the OFF position.
- Disconnect the generator set engine starting battery(ies), negative lead first.

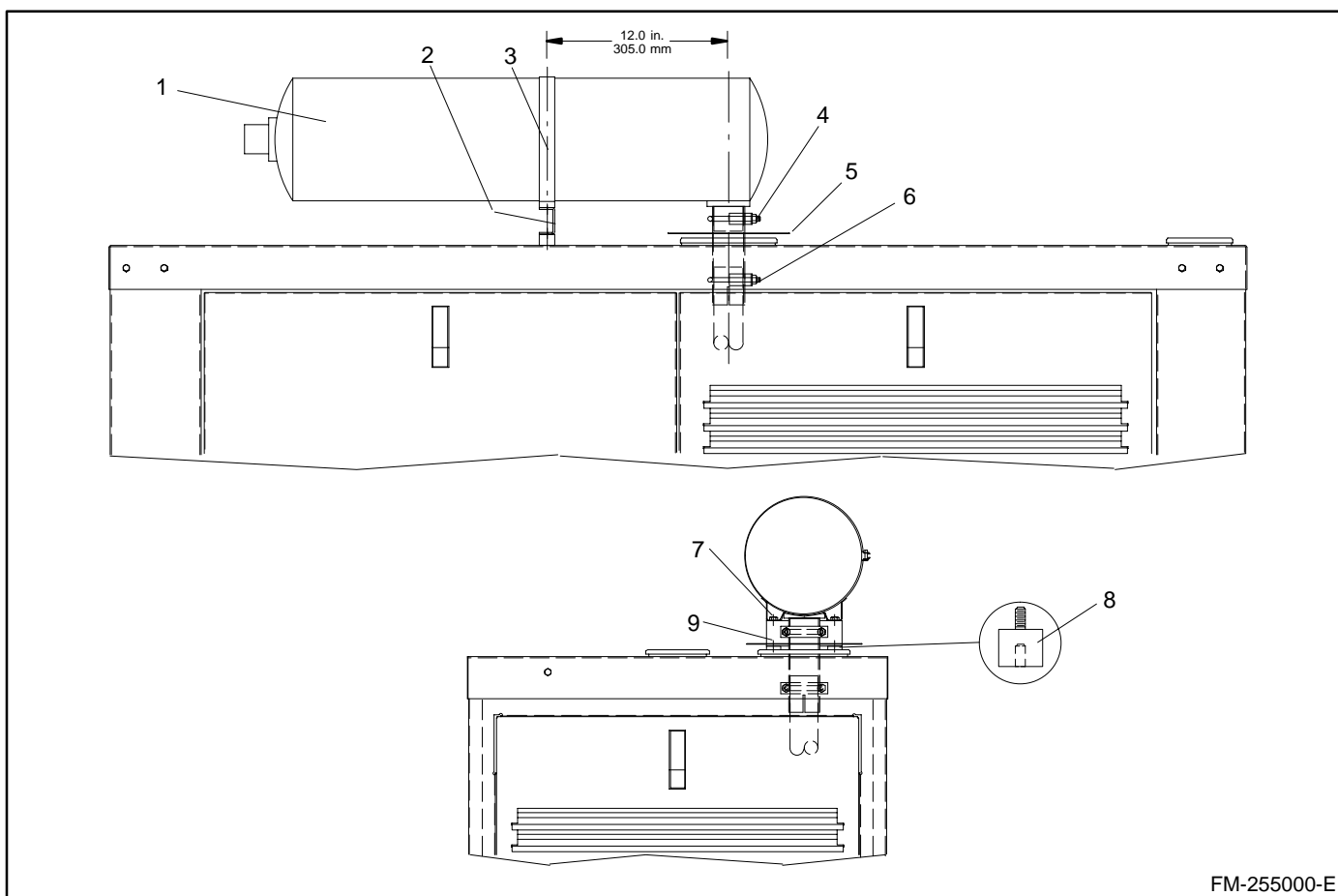
### NOTE

Hand-tighten all components until preliminary installation is complete. Final-tighten kit components after entire silencer and mounting kit is installed and correctly positioned.

- Remove housing doors to expose generator set.

- Attach exhaust adapter (254496 or 324088) to engine exhaust manifold and secure with muffler clamp (277706 or X-722-5). Overlap exhaust adapter a minimum of 1.0 in. (25.4 mm).
- Slide silencer mount (255329 or 279380) over silencer approximately 12 in. (304.80 mm) from center of exhaust inlet tube.
- Replace bolt supplied with mounting bracket with screw (230578) supplied in the kit.

7. Attach silencer bracket to silencer mount with screws (X-465-6), washers (X-25-40), and nuts (X-6210-2). See Figure 1.
8. Position silencer on housing roof over exhaust adapter.
9. Place vibromounts (259632) between the support bracket and housing roof.
10. Use the support bracket as a template and mark the location of the of the mounting holes on the housing roof.
11. Remove silencer and vibromounts.
12. Drill two 9/32 dia. holes in the housing roof in the locations marked in step 10.
13. Position silencer on housing roof. Place the vibro mounts under the support bracket and align them with the holes drilled in step 12.
14. Secure vibro mounts to housing roof with screws (X-465-6).
15. Secure vibro mounts to support bracket with nuts (X-6210-2).
16. Secure silencer inlet to exhaust adapter with 2 in. clamp (X-722-5). Overlap exhaust adapter a minimum of 1.0 in. (25.40 mm).
17. Final-tighten clamps on silencer and exhaust adapter. Final-tighten screw on silencer mount and all silencer mounting hardware.
18. Check that the generator set master switch is in the OFF position.
19. Reconnect generator set engine starting battery(ies), negative (-) lead last.



FM-255000-E

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|---|---|
| 1. Silencer, industrial or critical                     | 6. Exhaust clamp  |
| 2. Support bracket                                      | 7. Screws (X-465-6), washers (X-25-40), nuts (X-6210-2) |
| 3. Silencer mount (255329 or 279380) and screw (230578) | 8. Vibro mount (259632)                                 |
| 4. Exhaust clamp  | 9. Screws (X-465-6) and nuts (X-6210-2)                 |
| 5. Exhaust adapter                                      |   |

**Figure 1. Silencer Mounting Kit Installation**

## Silencer Mounting Kits

Parts List						
Kits: PA-254494, PA-254495, PA-333026-SD, PA-333027-SD			Unique Parts			
Qty.	Description	Common Parts	PA-254494	PA-254495	PA-333026-SD	PA-333027-SD
6	Washer, plain	X-25-40				
4	Screw, 1/4-20 x 0.50	X-465-6				
1	Clamp, U	X-722-5				
4	Nut, whiz 1/4-20	X-6210-2				
1	Screw, H.C. 5/16-18 x 2.25	230578				
1	Adapter, exhaust	254496				
1	Bracket, silencer	254499				
1	Mount, silencer		255329	279380	255329	279380
2	Bumper	259632				
1	Clamp, muffler	277706				

## Silencer Mounting Kits

Parts List						
Kits: PA-324099-SD, PA-324100-SD, PA-327114, PA-327115			Unique Parts			
Qty.	Description	Common Parts	PA-324099-SD	PA-324100-SD	PA-327114	PA-327115
1	Washer, plain	X-25-40				
4	Screw, 1/4-20 x 0.50	X-465-6				
2	Clamp, U	X-722-5				
4	Nut, whiz 1/4-20	X-6210-2				
1	Screw, H.C. 5/16-18 x 2.25	230578				
1	Adapter, exhaust	324088				
1	Bracket, silencer	254499				
1	Mount, silencer		279380	255329	279380	255329
2	Bumper	259632				