

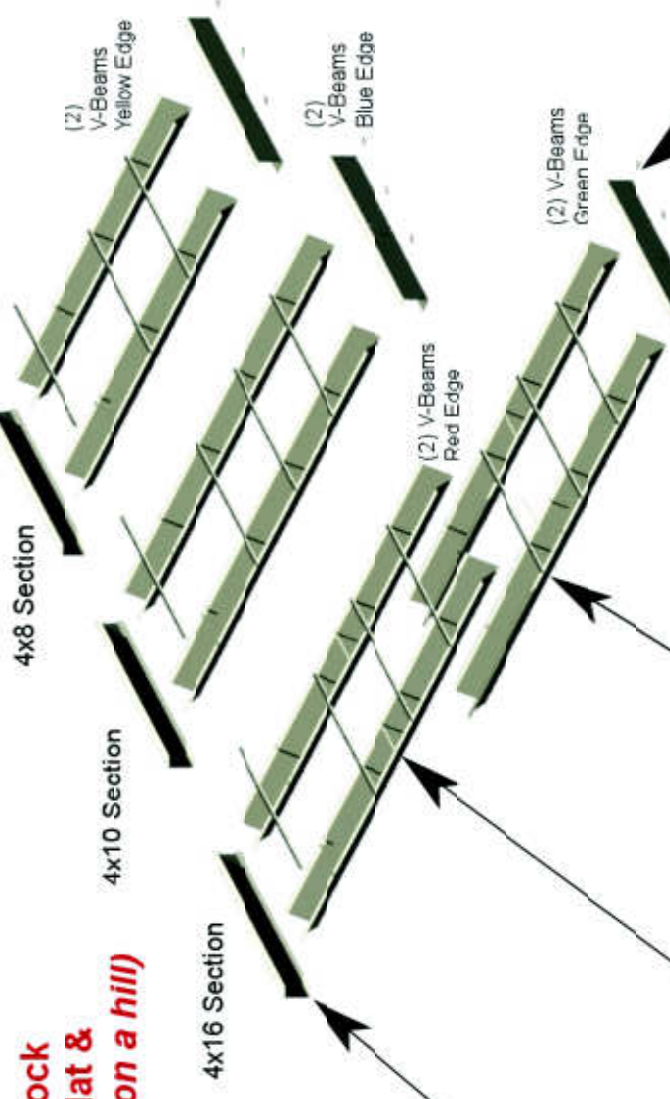


Assembly of the dock needs to be on a flat & level surface (not on a hill)

Main Frame Assembly Instructions

Tools Needed:

- 3 or 4 Saw Horses
- Impact Wrench (at least 18 volt or a pneumatic)
- 7/16" socket
- 1/2" socket
- Socket wrench
- 1/2" open-ended wrench
- 20' Tape measure
- 2 Small "C" clamps
- Drill

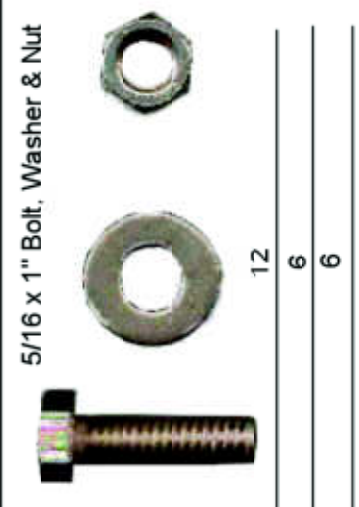


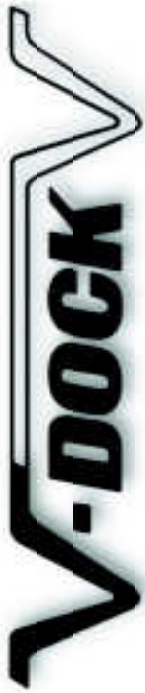
V-Dock Package Break-Down

Shore End Channel	1	4	7	1	3
End Clips	1	2	4	1	3
Lake End Channel	1	0	3	1	3
End Clips	1	4	7	1	3
End Clips	1	2	4	1	3
End Clips	1	0	3	1	3

4'x16' Dock	1	4	7	1	3
4'x10' Dock	1	2	4	1	3
4'x8' Dock	1	0	3	1	3

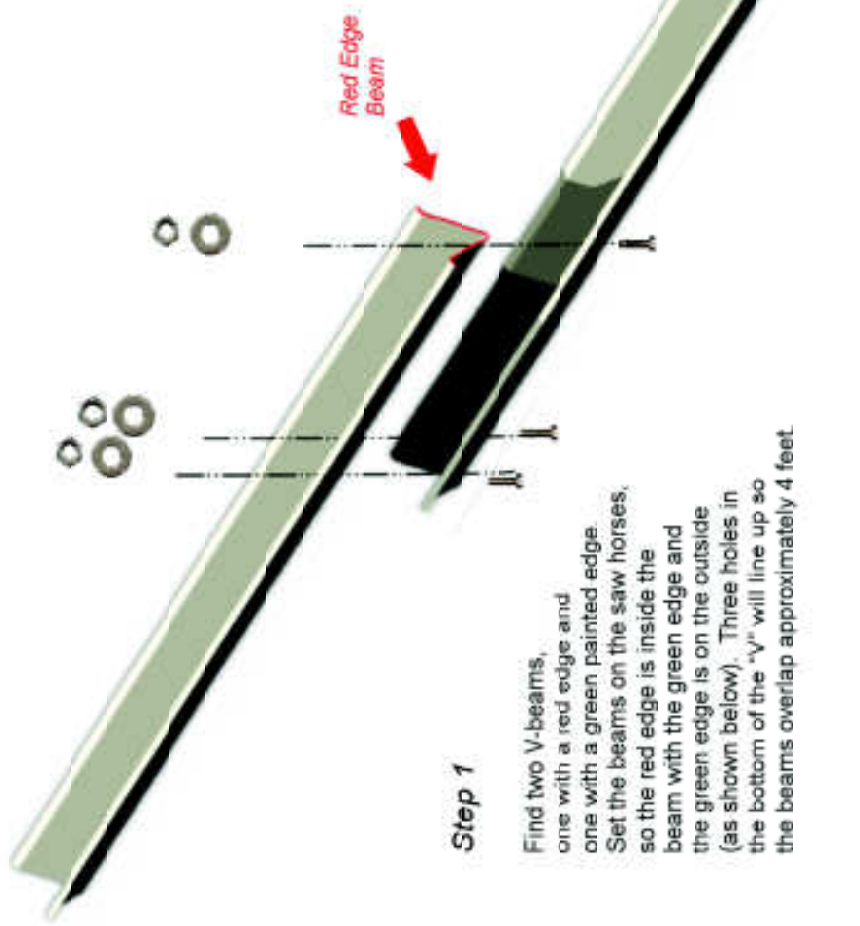
4'x16' Dock	48	2	11	12
4'x10' Dock	16	2	11	6
4'x8' Dock	12	2	11	6





Main Frame Assembly Instructions "Making 16' V-Beams"

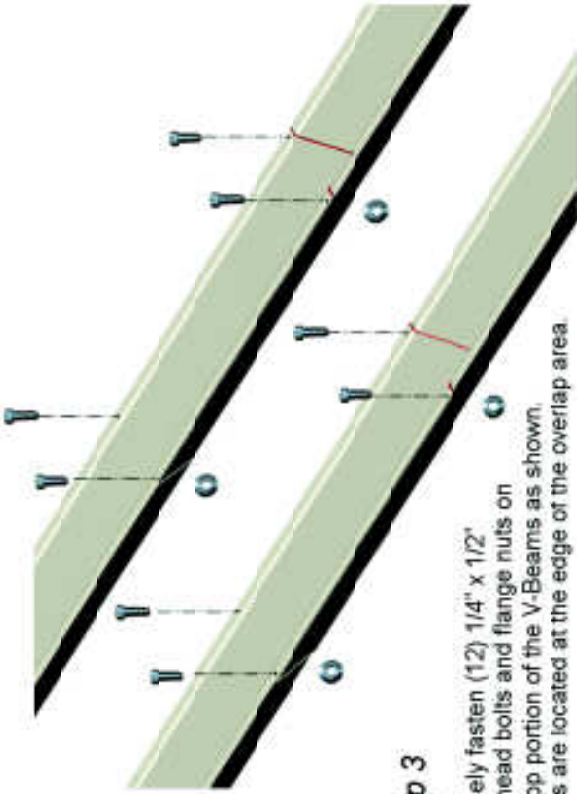
** For 8' and 10' sections skip steps 1-3 **



Step 1

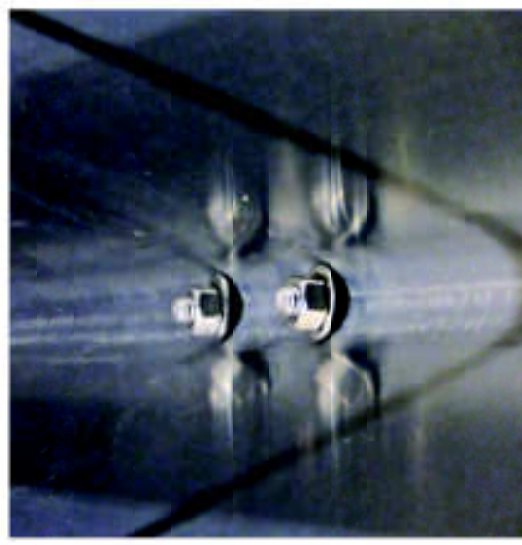
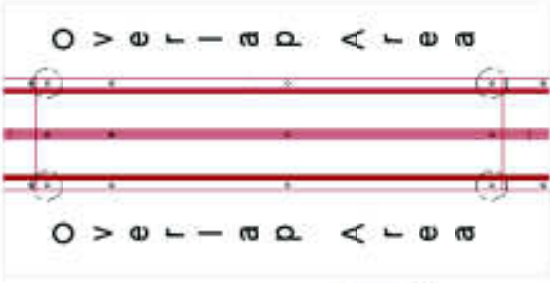
Find two V-beams, one with a red edge and one with a green painted edge. Set the beams on the saw horses, so the red edge is inside the beam with the green edge and the green edge is on the outside (as shown below). Three holes in the bottom of the "V" will line up so the beams overlap approximately 4 feet.

Don't Tighten Bolts Yet!



Step 3

Loosely fasten (12) 1/4" x 1/2" hex head bolts and flange nuts on the top portion of the V-Beams as shown. Holes are located at the edge of the overlap area.



Step 2

Using (3) 5/16" x 1" hex head bolts, washers & nuts. **Loosely** fasten the two beams together as shown (do not tighten yet). Repeat this step with another set of red and green beams.



Main Frame Assembly Instructions

"Tying V-Beams Together to Make a Section"

Step 4

Set two V-Beams, of the same length, side-by-side on the saw horses, making sure that the colored edges are on the same end.
Find the cross members and cross tabs in your crate. A cross member is a 40" x 1" "L" shaped of aluminum & the cross tabs are 10" x 1/2" flat strip of aluminum.

Step 5

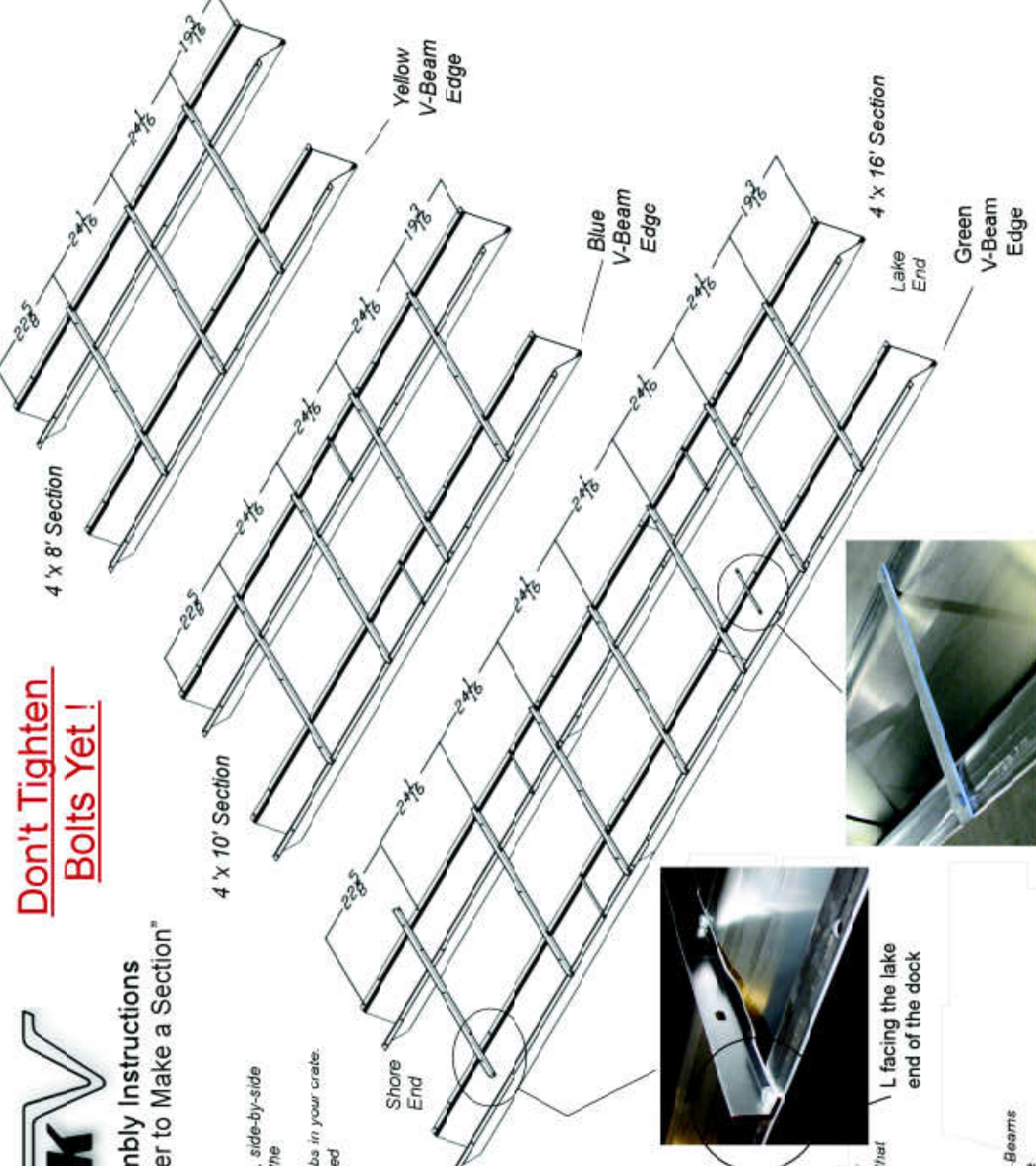
Starting with one V-Beam, locate the two holes in the lip of the V-Beam at the spacing shown in the diagram. The "L" shaped cross member must face the colored end of the section. Using two 1/4" x 1/2" hex head bolts and flange nuts, loosely attach each cross members along the first V-Beam. Put the bolt down thru the cross member and the hole in the V-Beam with the nut under the lip of the V-Beam. After you have attached all the cross members to one beam, stand both beams on point, so the cross members are horizontal. Line the two V-beams up so you can install two bolts on the other end of each cross member, tying the two V-Beams together. (Warning, there will be other holes along the top lip of the V-Beam that you will use in step 6, so following the spacing indicated.)

Step 6

Loosely fasten the cross tabs to the V-Beams in the remaining holes on the lip of the V-Beams with two 1/4" x 1/2" hex head bolts & flange nuts.

This refers to know how many cross tabs are required for the size section you are assembling.

Don't Tighten Bolts Yet!



- Green edges = 16' beams and needs 7 cross members & 4 cross tabs
- Blue edges = 10' beams and needs 4 cross members & 2 cross tabs
- Yellow edges = 8' beams and needs 3 cross members & no cross tabs



Main Frame Assembly Instructions "Installing End Channels"

**Don't Tighten
Bolts Yet!**

Step 7

The Shore End Channel will go on the non-color coded end of the V-Beams. The Lake End Channel looks similar to the Shore End Channel but has an extra bend in it and this will go on any color coded ends.

Shore End Channel



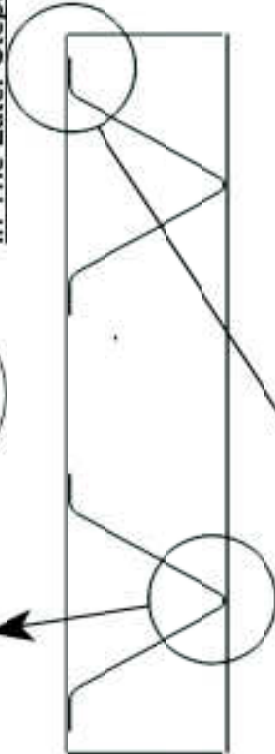
View A

VIEW A

1st

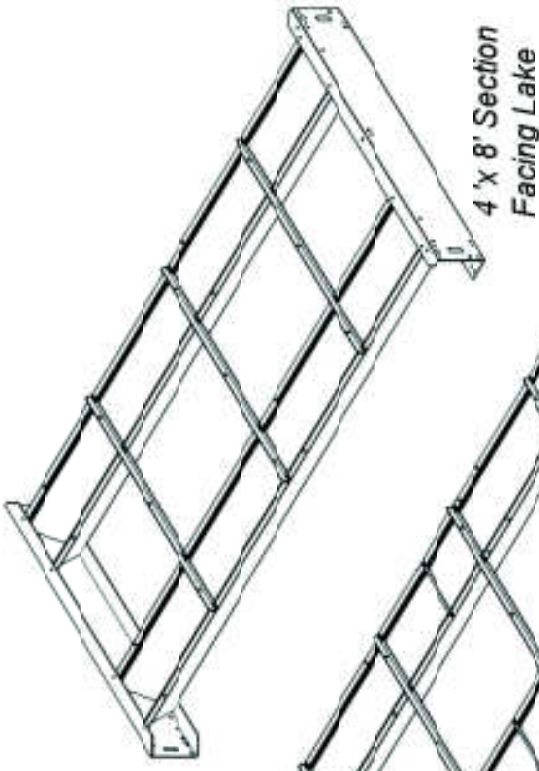
Loosely fasten the bottom of the End Channels to the V-Beams with six 5/16" x 1" hex head bolts, washers and hex nuts.

Note: the washers conform to a radius when tightened **In The Later Steps.**

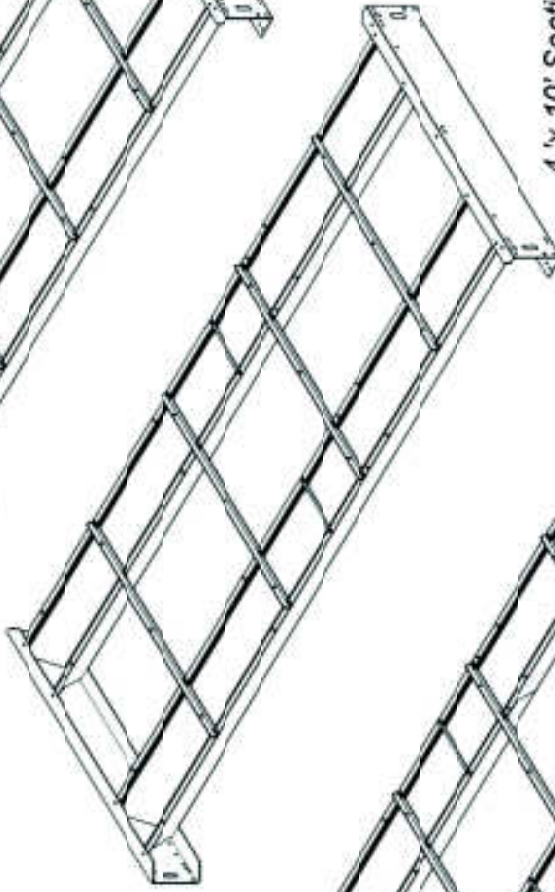


2nd

Loosely fasten the top of the End Channels to the V-Beams with eight 5/16" x 3/4" hex head bolts & flange nuts.



4 x 8' Section Facing Lake



4 x 10' Section Facing Lake

Color Coded Ends

Lake End Channel

4 x 16' Section Facing Lake



Main Frame Assembly Instructions "Installing End Clips & Stop Bolts"

Step 8

Fasten two 5/16" x 1/2" hex head bolts & castle head nuts in the holes outside edge of the beams on the Shore End ONLY of every section of framework. The bolt comes up under the lip and the anchor nut goes on the top of the V-Beam. This is necessary to hold the last section decking in place.

Shore End Channel

4' x 8' Section

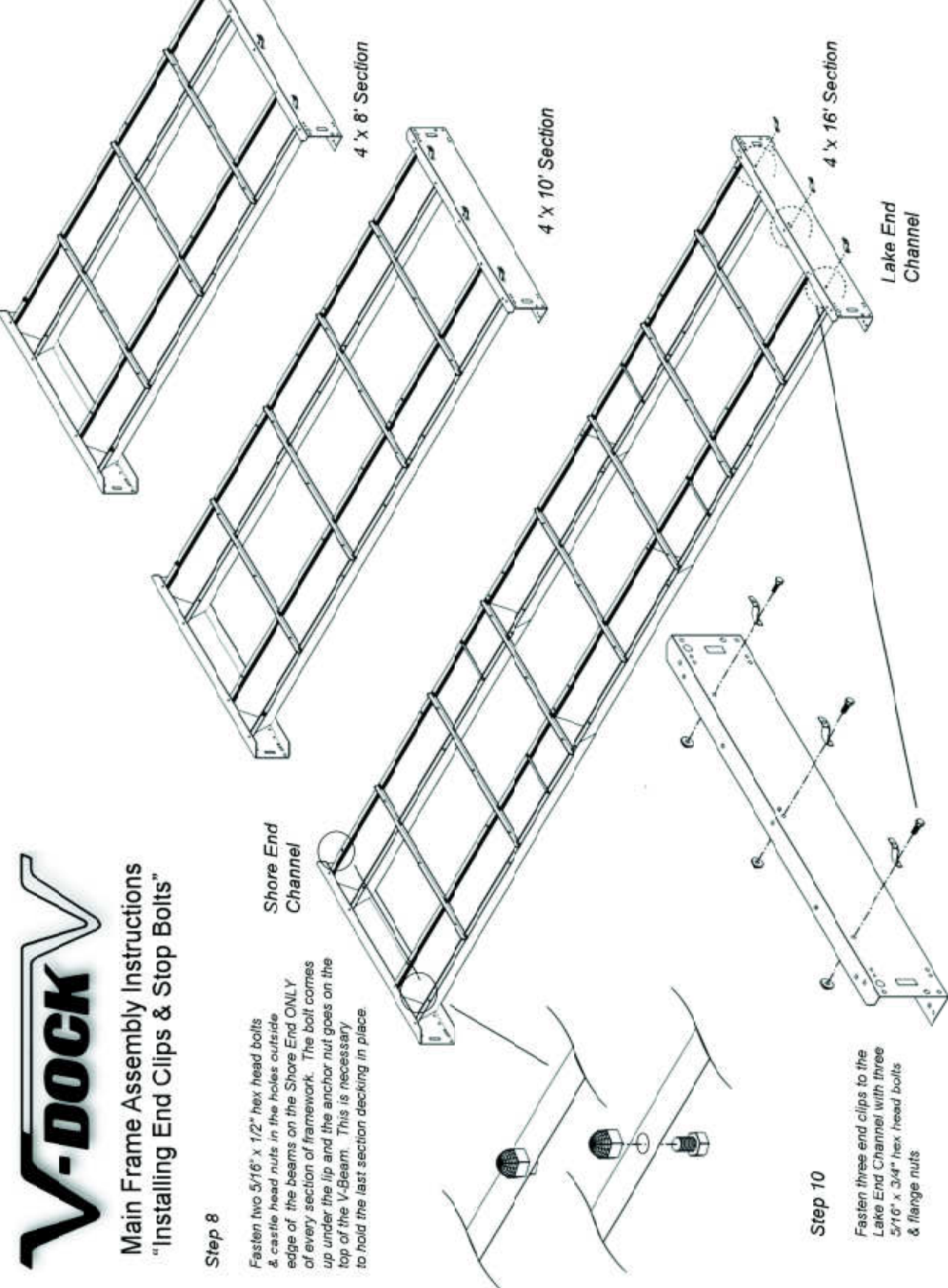
4' x 10' Section

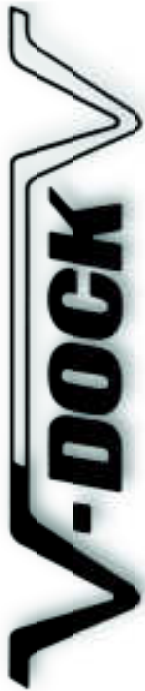
4' x 16' Section

Lake End Channel

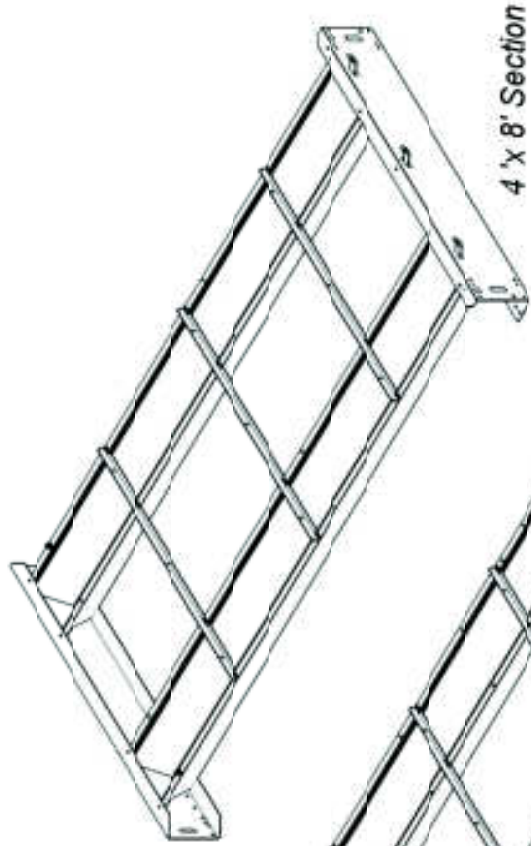
Step 10

Fasten three end clips to the Lake End Channel with three 5/16" x 3/4" hex head bolts & flange nuts

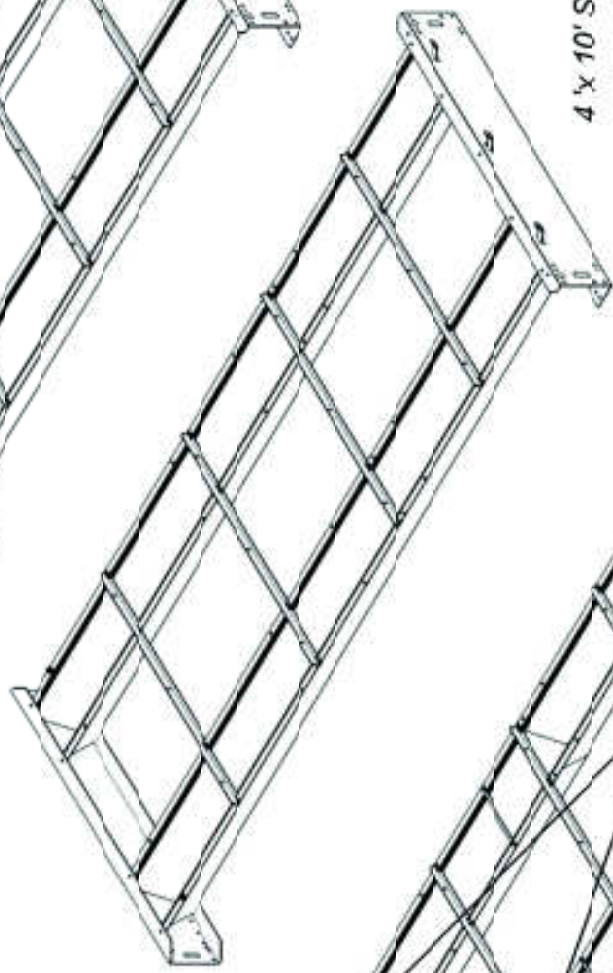




Main Frame Assembly Instructions "Squaring up Frames and Tighten Bolts"



4' x 8' Section



4' x 10' Section

Corner A

Corner B

Corner B

Corner A

4' x 16' Section



Step 10

To square up the frame, take a tape measure & measure from "Corner A" to "Corner A" & "Corner B" to "Corner B" these two dimensions should be the same.

If not you may need to tap it on the corners a little until the measurements are the same.

Step 12

Next with two 1/2" wrenches, tighten all the bolt on the bottom of the V-Beam 1st. Then using a 7/16 wrench tighten the (8) 1/4" and bolts and nuts that are located on top of the V-Beams



Note: when tightening the bolts located on the bottom of the V-Beam the washers should conform to a radius (Shown Above) Then finish by tighten the rest of the bolts securely!

Step 11

When the Frame is squared up. Start tightening the bolts with the eight of the bolts on both End Channels.

Tighten These First