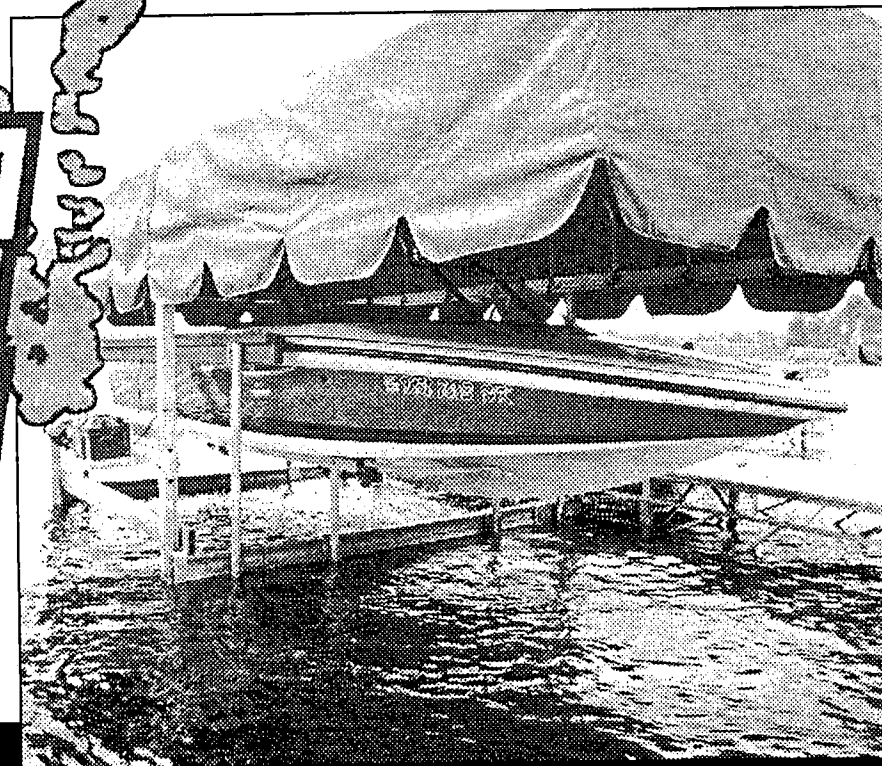
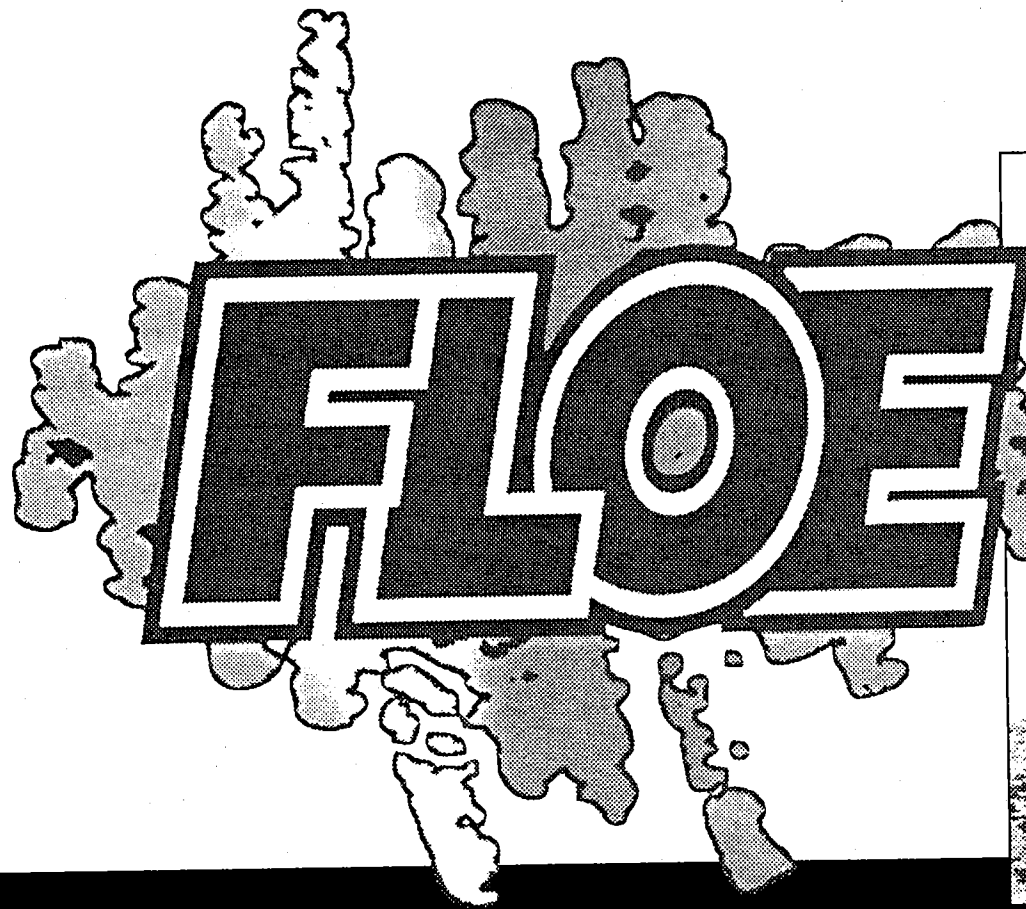


Assembly Instructions for

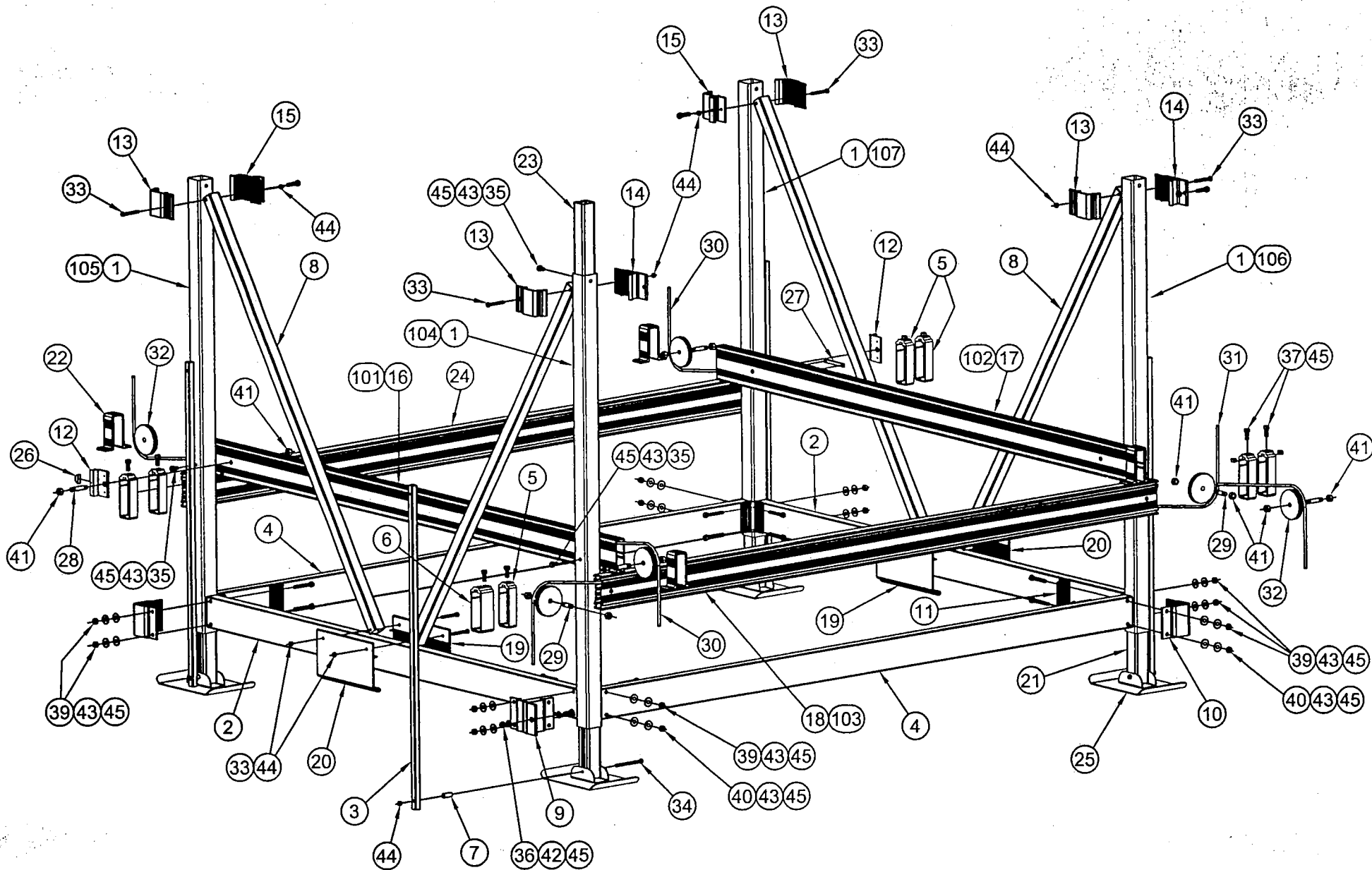


Vertical Boat Lift System ***V-3000***

V-3000 EXPLODED VIEW

LIFT P/N 511-30000-00

FLOE INTERNATIONAL INC.



V-3000 EXPLODED VIEW

LIFT P/N 511-30000-00

FLOE INTERNATIONAL INC.

INSTRUCTION
STEP NO.

SUB-ASSEMBLIES

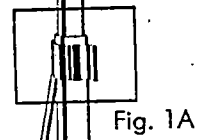
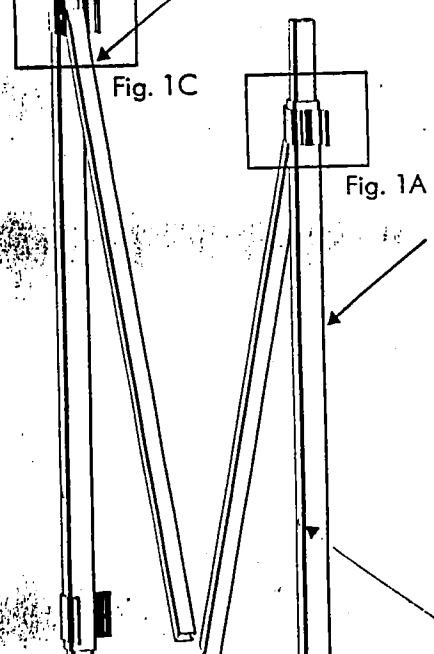
NO.	PART NO.	QTY.	DESCRIPTION	INSTRUCTION STEP NO.	SUB-ASSEMBLIES
1	002-04005-00	4	CORNER POST 74" (.125)	1	101 --- 111-00045-00 --- SIDE CRADLE ASSEMBLY (RIGHT) INCLUDES ITEMS 12,16,26,27,28,32,41
2	002-04012-00	2	SIDE FRAME BEAM 96" (.100)	2	
3	002-04013-00	4	LIFTING HANDLE (SAND PAD)	6	
4	002-04018-00	2	F/R FRAME BEAM 108" (.125)	2	102 --- 111-00046-00 --- SIDE CRADLE ASSEMBLY (LEFT) INCLUDES ITEMS 12,17,26,27,28,32,41
5	002-04015-00	7	CRADLE CLAMP 1.5"	4	
6	002-04017-00	1	CRADLE LIFT CLAMP 2.5"	4	
7	002-04019-00	4	LIFTING HANDLE STAND OFF	6	
8	002-04022-00	4	V-BRACE 77"	3	103 --- 111-00048-00 --- FRONT CRADLE ASSEMBLY (.125) INCLUDES ITEMS 18,29,32,41
9	002-04026-00	1	FRAME BEAM WINCH CLAMP	2	
10	002-04028-00	3	FRAME BEAM CLAMP (OUTER)	2	
11	002-04030-00	4	FRAME BEAM CLAMP (INNER)	2	104 --- 111-00079-00 --- V3000 CORNER POST ASSY (RF) INCLUDES ITEMS 1,8,9,13,14,21,23, 33,35,43,44 & 45
12	002-04033-00	4	CRADLE GUIDE	4	
13	002-04034-00	4	UPPER CLAMP 1	1	
14	002-04036-00	2	UPPER CLAMP 3	1	
15	002-04038-00	2	UPPER CLAMP 2	1	105 --- 111-00080-00 --- V3000 CORNER POST ASSY (RR) INCLUDES ITEMS 1,8,10,13,15,21,33, 35,43,44 & 45
16	002-04040-00	1	SIDE CRADLE (RIGHT) 109"	4	
17	002-04042-00	1	SIDE CRADLE (LEFT) 109"	4	
18	002-04046-00	1	FRONT CRADLE BEAM 113" (.125)	4	
19	002-04064-00	2	V-BRACE CLAMP (FEMALE)	3	
20	002-04066-00	2	V-BRACE CLAMP (MALE)	3	106 --- 111-00081-00 --- V3000 CORNER POST ASSY (LF) INCLUDES ITEMS 1,8,10,13,14,21,33, 35,43,44 & 45
21	002-04067-00	4	ADJUSTABLE LEG 54"(.100)	1	
22	911-00301-00	4	CRADLE U-CLAMP 2.125"	4	
23	911-04201-00	1	ADJUSTABLE LEG 38" (.125")	1	
24	911-04801-00	1	REAR CRADLE BEAM 113" (.125)	4	107 --- 111-00082-00 --- V3000 CORNER POST ASSY (LR) INCLUDES ITEMS 1,8,10,13,15,21,33, 35,43,44 & 45
25	111-00000-00	4	SAND PAD	1	
26	006-10201-00	4	CRADLE GUIDE PUCK	4	
27	006-11001-00	4	LEXAN - 3/16" x 1/2" x 5" LG.	4	
28	007-05600-00	4	5/8 SIDE CRADLE SHEAVE PIN - 3.20"	4	
29	007-05800-00	2	5/8 END CRADLE SHEAVE PIN - 2.25"	4	
30	007-09000-00	2	SIDE LEVELING CABLE - 166.875"	5	
31	007-09200-00	1	FRONT LEVELING CABLE - 183"	5	
32	111-00106-00	6	5" SHEAVE W/BUSHING	4	
33	001-70115-00	8	HHCS, 3/8-16 x 3" ss 18-8	1,3	
34	001-70123-00	4	HHCS, 3/8-16 x 5" ss 18-8	1	
35	001-70203-00	5	HHCS, 1/2-13 x 3/4" ss 18-8	1	
36	001-70205-00	1	HHCS, 1/2-13 x 1" ss 18-8	6	
37	001-70207-00	8	HHCS, 1/2-13 x 1 1/4" ss 18-8	4	
38	001-70210-00	3	HHCS, 1/2-13 x 1 3/4" ss 18-8	5	
39	001-70216-00	14	HHCS, 1/2-13 x 3 1/4" ss 18-8	2	
40	001-70219-00	2	HHCS, 1/2-13 x 4" ss 18-8	2	
41	001-70816-00	12	NUT, JAM 5/8-11 ss 18-8	4	
42	001-71021-00	2	1/2" FLAT WASHER SAE ss 18-8	5,6	
43	001-71022-00	37	1/2" FLAT WASHER USS ss 18-8	2,6	
44	001-76349-00	12	NUT, 3/8-16 ALUM.	1,3	
45	001-76350-00	33	NUT, 1/2-13 ALUM.	2,5,6	



STEP 1

- ❑ Loosen leg adjustment bolts and slide inner legs out approx. 10 inches. (Re-tighten)
- ❑ Attach sand pads with 3/8 X 5" bolts & nuts. Do not torque nuts at this time. Fig 1E. Hand tighten only.
- ❑ Arrange corner posts as shown on the left.

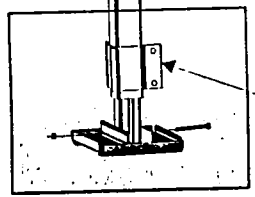
Right rear corner post assembly



Right front corner post assembly

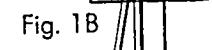
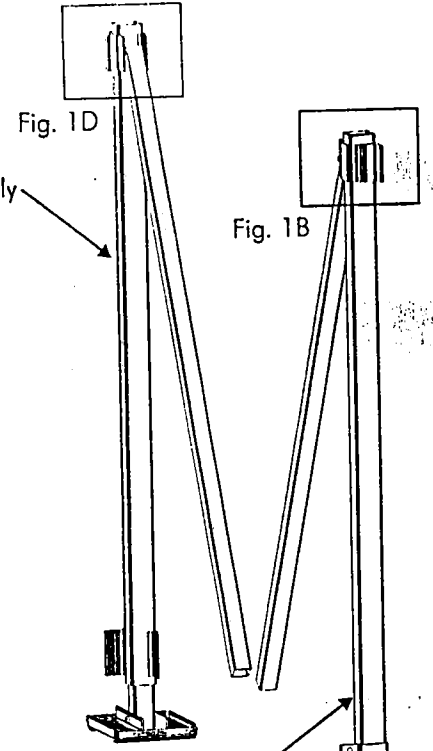
Important:
Make sure clamps are
1" from the bottom
on all corner posts.

Leg adjustment bolts



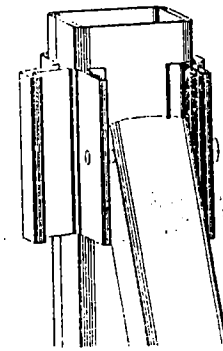
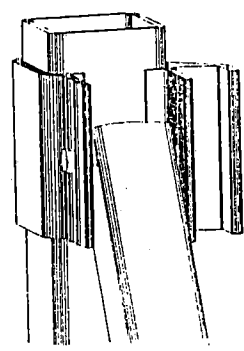
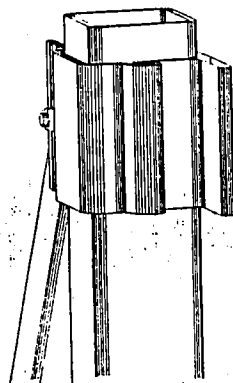
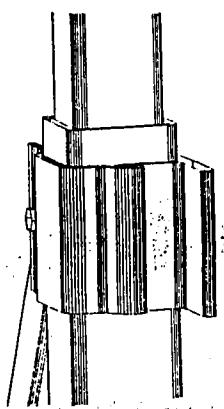
Frame beam clamp
with slotted hole

Left rear corner post assembly

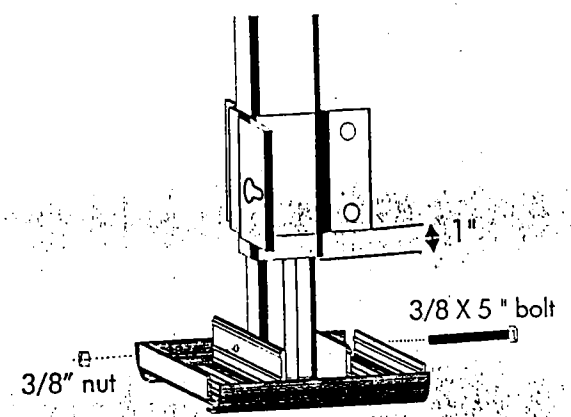


Left front corner post assembly

Sand pad



Note the difference in the upper clamps.
See Fig. 1A, 1B, 1C and 1D.





STEP 2

- Frames are attached as shown in Fig. 2A and 2B
- To help keep the frame square while assembling, gradually tighten each bolt a little at a time and alternating between each side of the clamp. Use a rubber hammer to snug clamp to corner post while tightening.

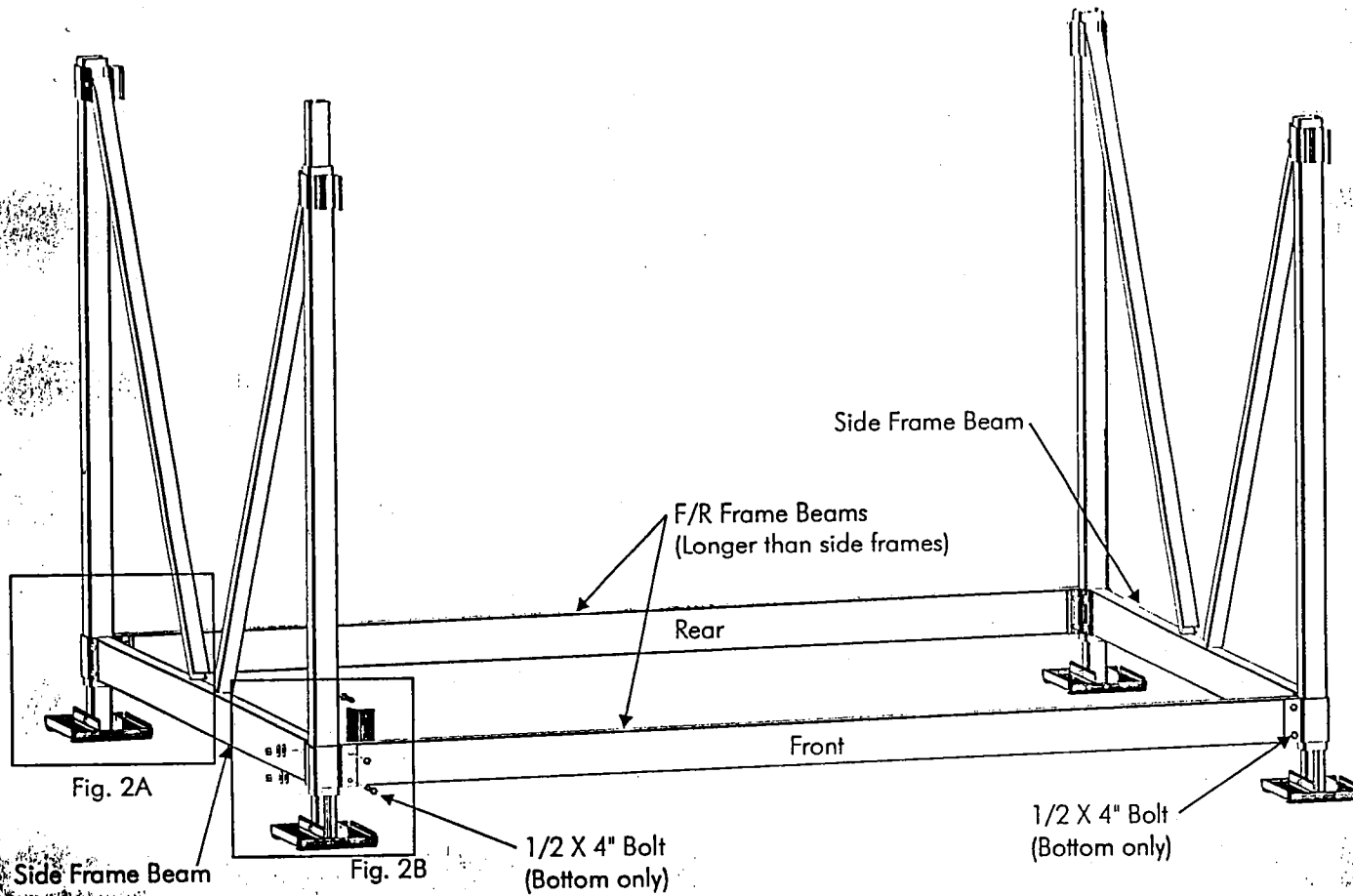


Fig. 2A

Side Frame Beam

Fig. 2B

1/2 X 4" Bolt
(Bottom only)

1/2 X 4" Bolt
(Bottom only)

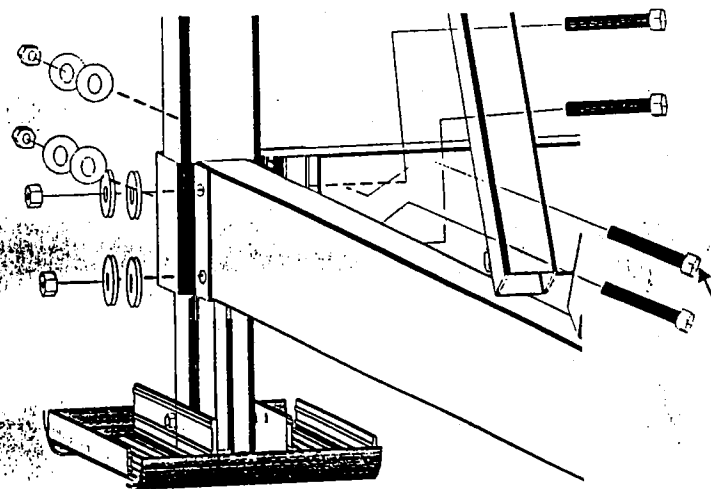


Fig. 2A

1/2 x 3 1/4" Bolt on the front is installed from the inside of the lift to the outside.
Torque to 100 ft lbs

1/2 X 3 1/4" Bolts, washers and nuts.
Torque to 100 ft lbs

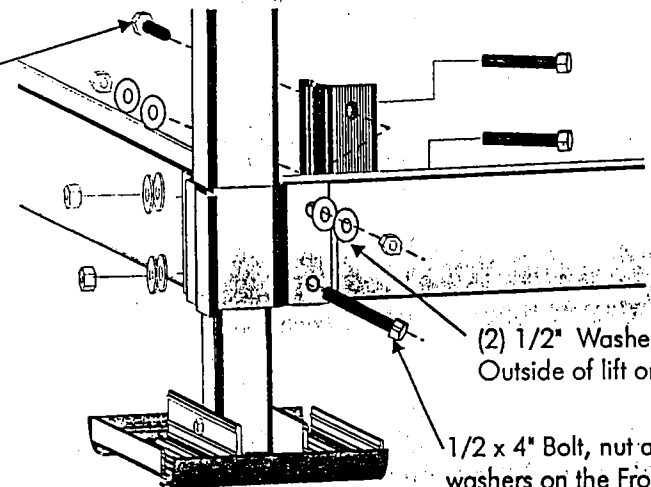


Fig. 2B

(2) 1/2" Washers.
Outside of lift only.

1/2 x 4" Bolt, nut and washers on the Front Frame Beam Bottom. Do not tighten the nut at this time.



STEP 3

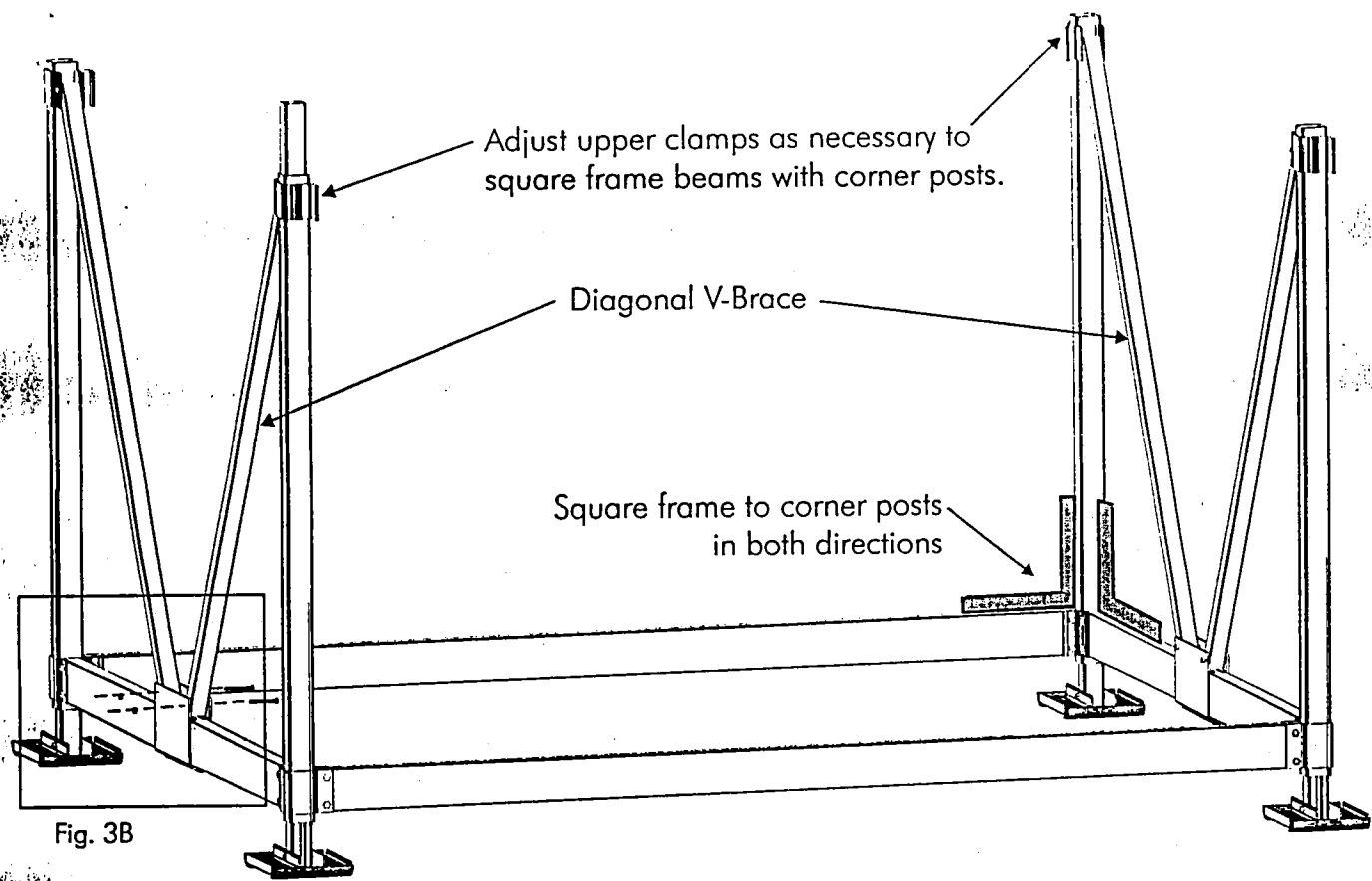


Fig. 3B

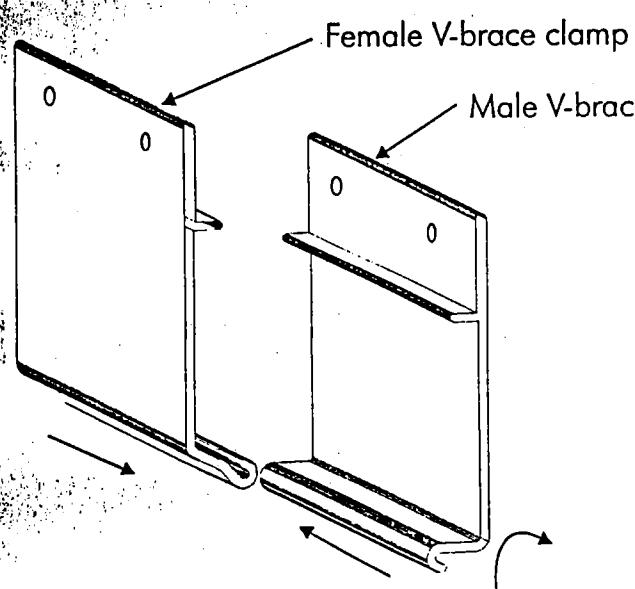


Fig. 3A

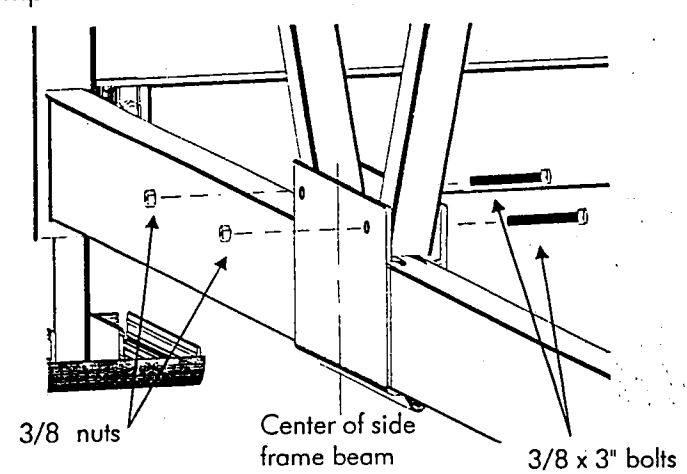
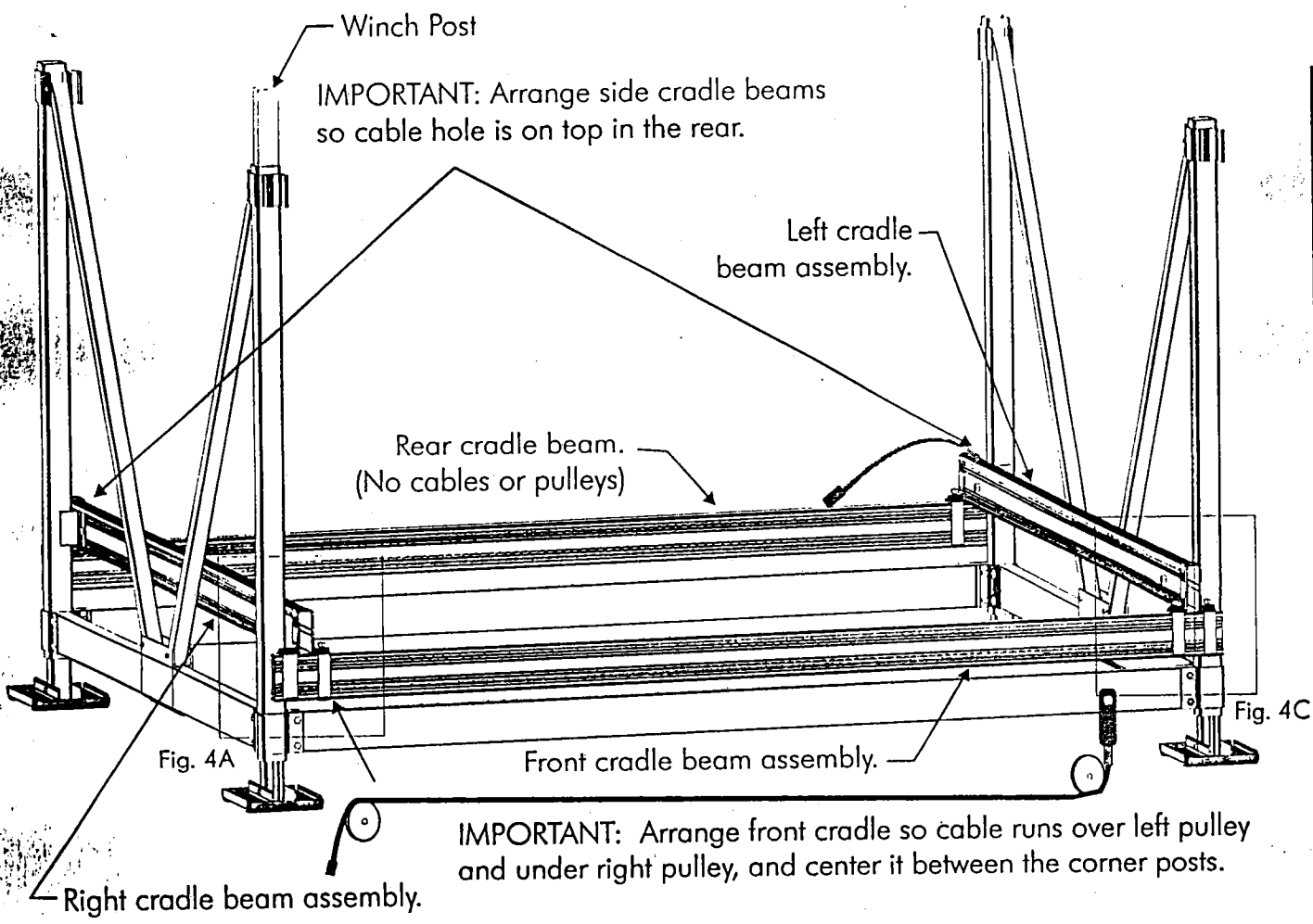


Fig. 3B

- ❑ Slide the two v-brace clamps together and center on the Side Frame Beam. (Fig 3A).
- ❑ Attach diagonal v-braces to v-brace clamp as shown in fig. 3B.
- ❑ Square frames to corner posts by adjusting the upper clamps.
- ❑ Torque to 40 ft lbs
- ❑ If lift is to be equipped with either adjustable cradle pads or a pontoon kit, see the instructions supplied with the bunk kit before proceeding to the next step.

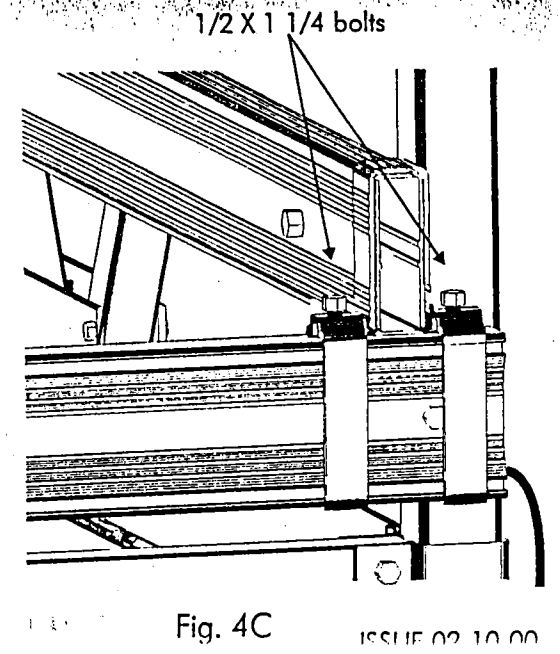
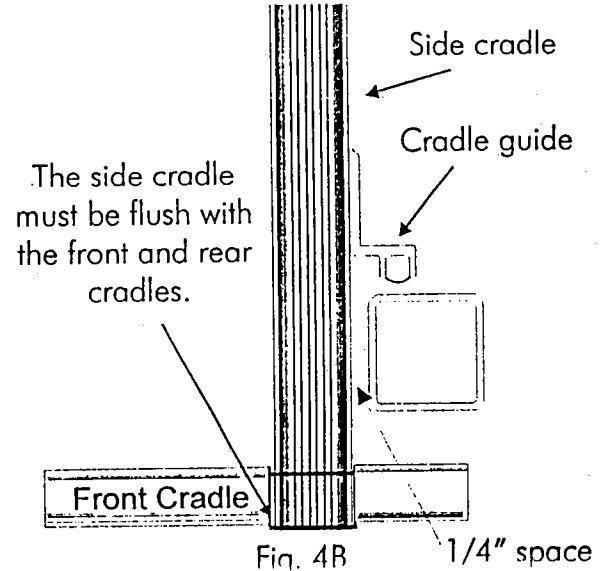
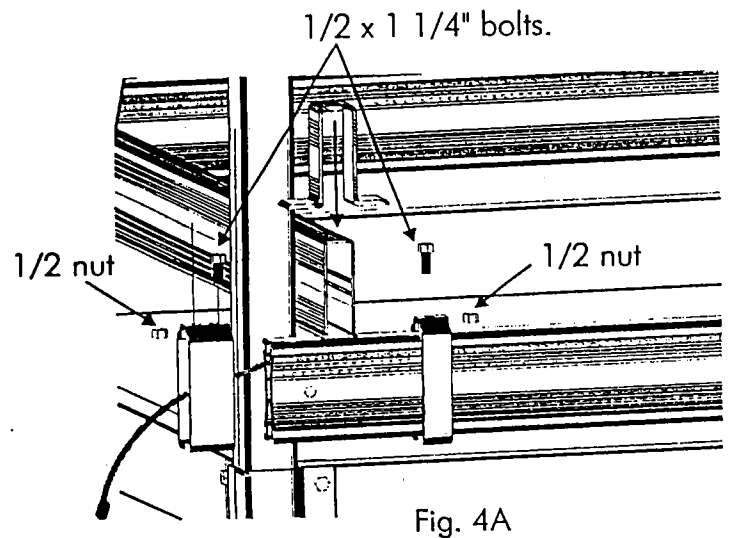


STEP 4






IMPORTANT: Arrange front cradle so cable runs over left pulley and under right pulley, and center it between the corner posts.

- ▣ Front and side cradles must be placed as shown. Front cradle has a cable that runs over the pulley on the winch side, the side cradles have a cable hole on the top rear.
- ▣ Cradle beams are joined as shown below. See Fig 4A, 4B and 4C. Allow 1/4" between the side cradle and corner posts. See Fig. 4B.
- ▣ Torque to 100 ft lbs





STEP 5

- 
 Insert the cable button end thru the large hole in the lower clamp and slide it into the slot. Insert 1/2" x 1" bolt, washers and nut as shown in Fig. 5A.
- 
 Attach the other end of the cable by lifting the opposite side of the front cradle and fastening with a 1/2" x 1 3/4" bolt and nut. (See Fig. 5B)
- 
 Fasten the side cables to the lower frame clamps as shown in Fig. 5C. Check front corner posts for squareness before tightening. Attach the other end of the cable to the rear upper clamps by lifting up the rear cradle. See Fig. 5D.

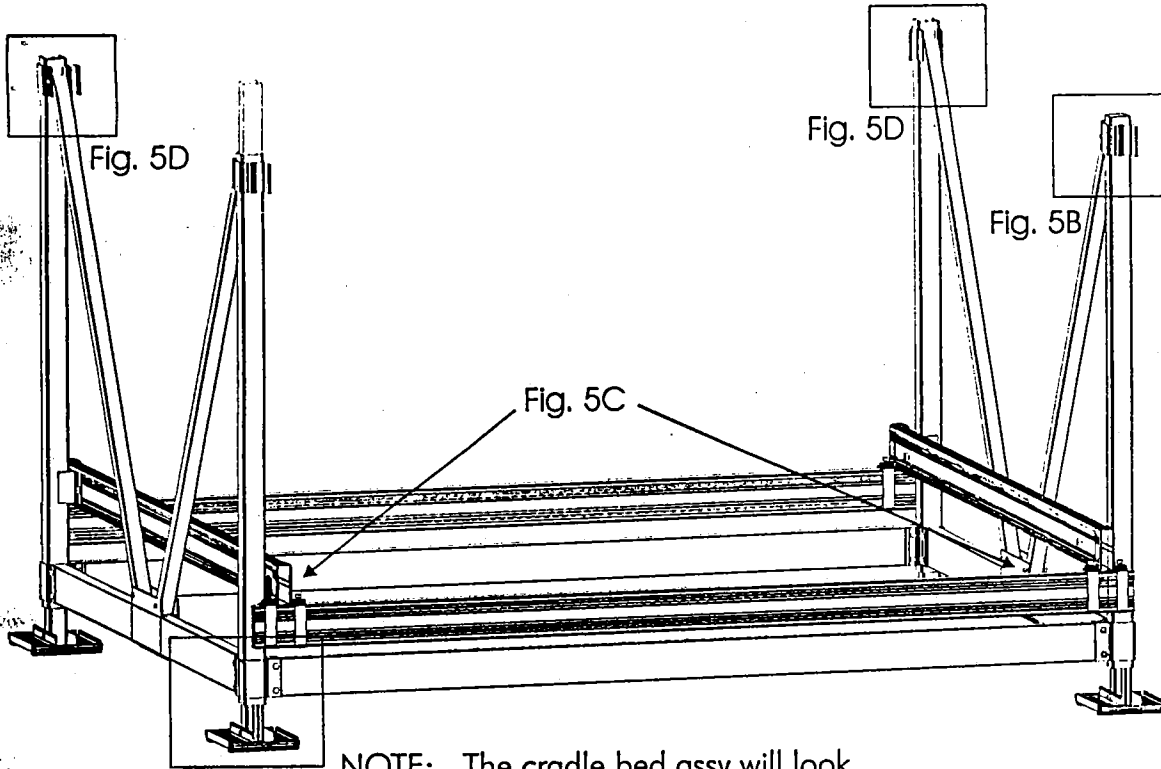


Fig. 5A NOTE: The cradle bed assy will look uneven when not loaded

1/2 x 1 bolt, (2)
washers and nut
Torque to 50 ft lbs

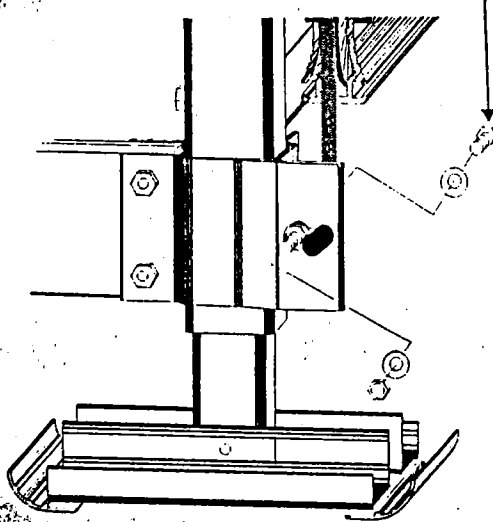


Fig. 5A

1/2 X 1 3/4" bolt and nut
Torque to 50 ft lbs

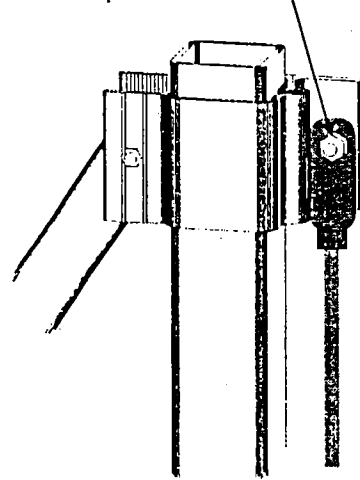


Fig. 5B

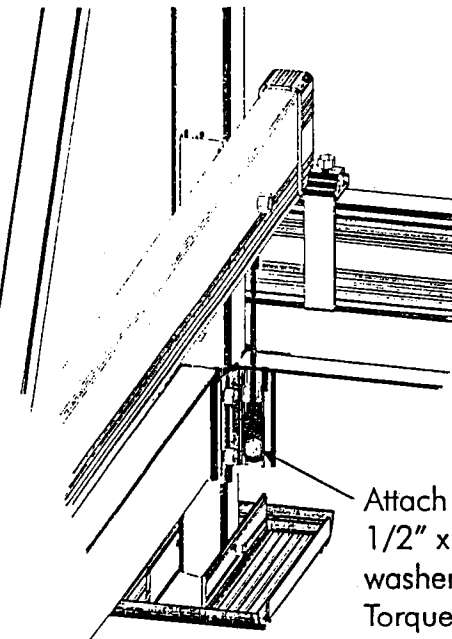


Fig. 5C

Attach to frame with
1/2" x 4" bolt,
washers and nut
Torque to 100 ft lbs

1/2 X 1 3/4" bolt and nut
Torque to 50 ft lbs

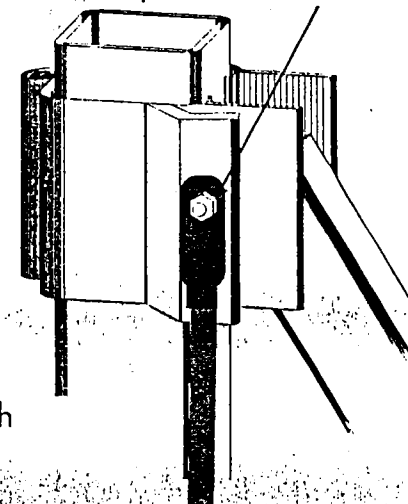


Fig. 5D



STEP 6

- ▣ Slide winch over winch mount and run lifting cable as shown in Fig. 6A and 6B.
- ▣ Remove the lower pulley stud and install winch cable as shown in Fig. 6B.
- ▣ Attach eye bolt to the cradle lift clamp. Torque jam nut to 50 ft lbs. (See Fig. 6B)
- ▣ Place lower pulley stud thru the eye bolt and re-assemble the pulley. Torque to 50 ft lbs. (See Fig. 6B)
- ▣ Install adjustable leg handles on to the pre-installed 3/8 x 5" bolt. The stand-off tube slides into the large hole in the handle. (See Fig. 6C). Torque to 25 ft lbs.

