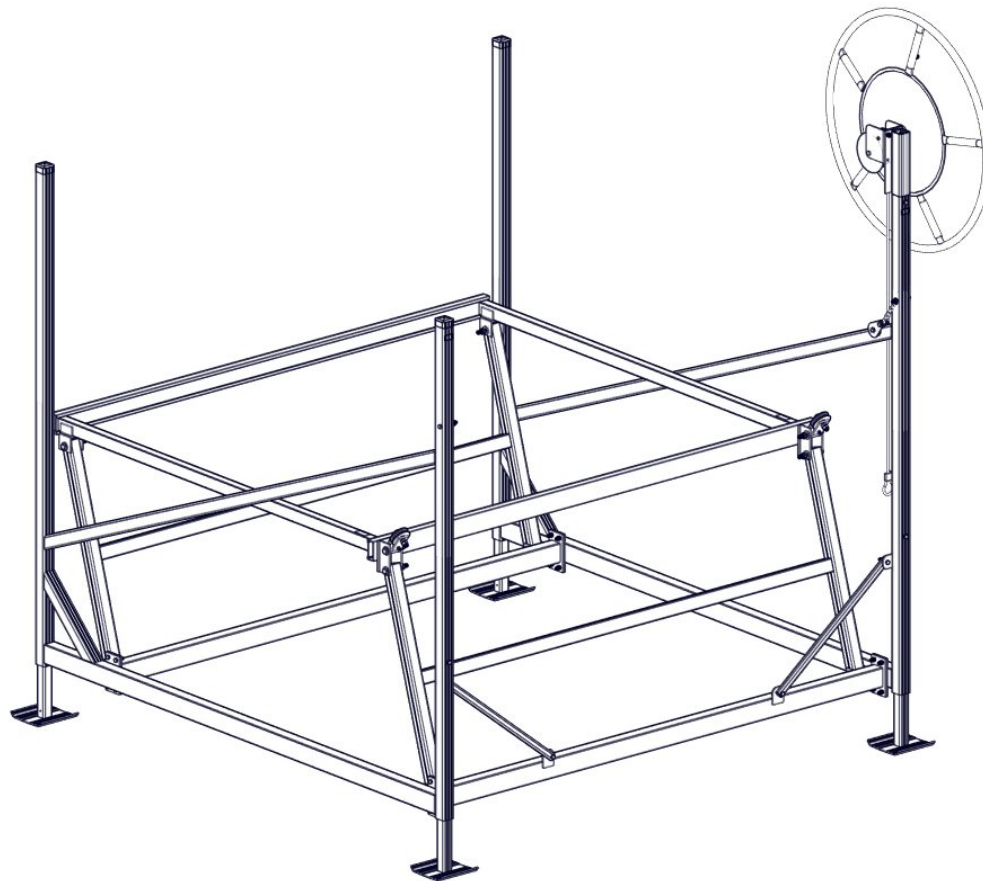


FLOE P1600 LIFT

P/N 511-16001-00

WITH PATENTED EASY LEVEL LEG SYSTEM
ASSEMBLY INSTRUCTIONS



TOOLS REQUIRED

- (2) 7/16" SOCKETS/WRENCHES
- (2) 9/16" SOCKETS/WRENCHES
- (2) 3/4" SOCKETS/WRENCHES
- TORQUE WRENCH

**IMPORTANT:
DO NOT USE IMPACT
WRENCH**

Instructions P/N 611-16001-00
Issued 11/15/21

© Manufactured by:
Floe International Inc.
48473 State Hwy. 65
McGregor, MN 55760
www.floeintl.com

IMPORTANT NOTES:

- WATERCRAFT MUST FLOAT FREELY OVER BUNKS BEFORE LIFTING. THE WEIGHT OF THE WATERCRAFT MUST NEVER BE ON THE LIFT WHEN IT IS IN ITS LOWEST POSITION. FAILURE TO FOLLOW THIS PROCEDURE MAY RESULT IN SEVERE DAMAGE TO YOUR LIFT AND/OR WATERCRAFT AND WILL VOID YOUR WARRANTY.
- THE LIFT SHOULD BE INSTALLED WITH 6" OF WATER ABOVE THE TOP OF THE BUNKS WHILE THE LIFT IS IN THE LOWERED POSITION. THIS WILL PROVIDE ADEQUATE CLEARANCE FOR LAUNCHING AND DOCKING OF YOUR WATERCRAFT AND ALSO HELP PREVENT FLOAT OFF IN THE RAISED POSITION DURING HIGH WAVE CONDITIONS.

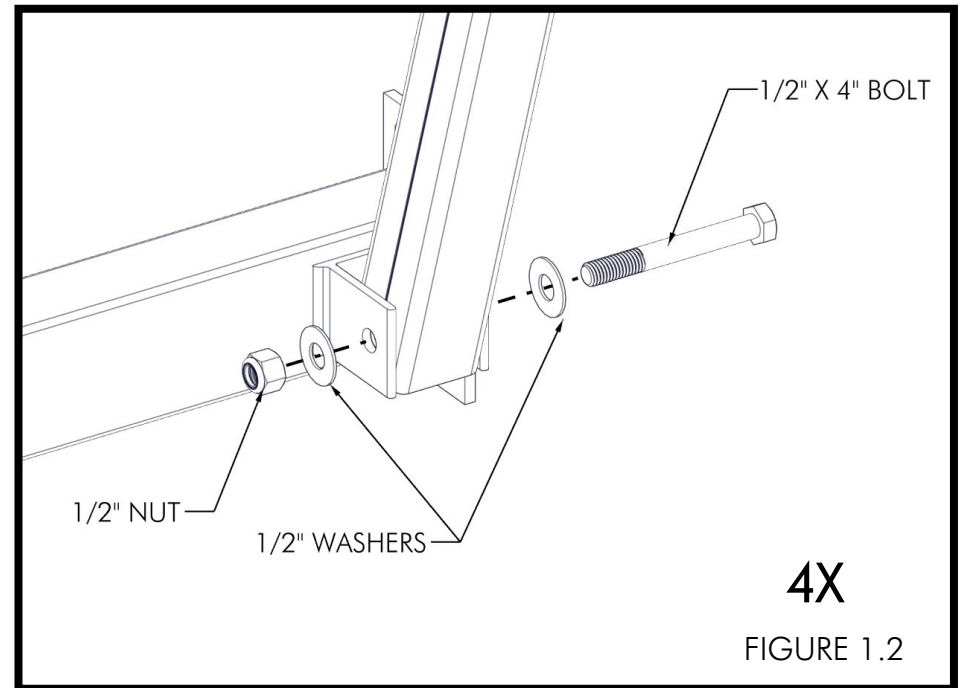
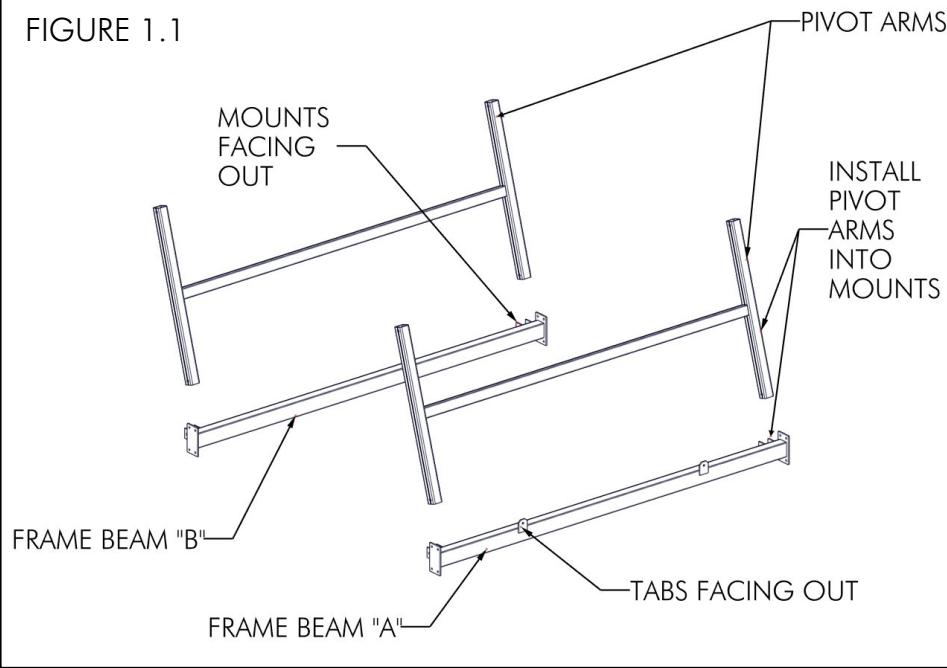
Hardware Card Contents (511-04238-00)

Step	Part Numbers	QTY	Descriptions
1	001-70219-00	4	HHCS, 1/2-13 X 4" 18-8 SS
	001-71021-00	8	FLAT WASHER, 1/2" 18-8 SS
	001-76072-00	4	NUT, NYLOCK 1/2-13 ALUMINUM
2	001-70107-00	16	HHCS, 3/8-16 x 1-1/4" 18-8 SS
	001-70110-00	4	HHCS, 3/8-16 x 1-3/4" 18-8 SS
	001-76071-00	20	NUT, NYLOCK 3/8-16 ALUMINUM
3	001-70219-00	4	HHCS, 1/2-13 X 4" 18-8 SS
	001-71021-00	8	FLAT WASHER, 1/2" 18-8 SS
	001-76072-00	4	NUT, NYLOCK 1/2-13 ALUMINUM
4	001-70010-00	2	HHCS, 1/4-20 X 1-3/4" 18-8 SS
	001-70103-00	1	HHCS, 3/8-16 X 3/4" 18-8 SS
	001-70115-00	2	HHCS, 3/8-16 X 3" 18-8 SS
	001-71017-00	3	FLAT WASHER, 3/8" SS 18-8 SS
	001-75001-00	2	NUT, NYLOCK 1/4-20 ALUMINUM
	001-76071-00	2	NUT, NYLOCK 3/8-16 ALUMINUM
	001-76349-00	1	NUT, 3/8-16 ALUMINUM

STEP 1

- POSITION THE PIVOT ARMS INTO THE FRAME BEAMS AS SHOWN (FIGURE 1.1).
- MOUNT THE PIVOT ARMS TO THE FRAME BEAMS USING (2) 1/4" X 4" BOLTS, (4) 1/2" WASHERS, AND (2) 1/2" NYLOCK NUTS PER PIVOT ARM (FIGURE 1.2).

FIGURE 1.1



STEP 1

- REMOVE THE 3/8" X 3/4" BOLT FROM EACH OF THE LEVELING LEGS (FIGURE 1.3). LAY SIDE FRAMES ON SIDE (FIGURE 1.4).
- INSERT LEVELING LEGS INTO CORNER POSTS WHILE MAKING SURE THAT THE NUT TRACK LINES UP WITH THE LOWER HOLE IN THE CORNER POST (FIGURE 1.5).

FIGURE 1.3

4X

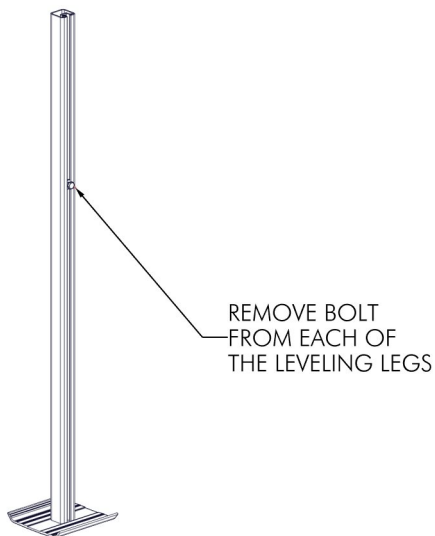


FIGURE 1.4

2X

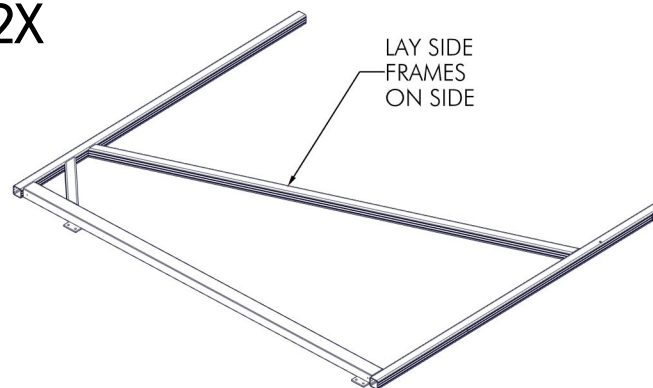
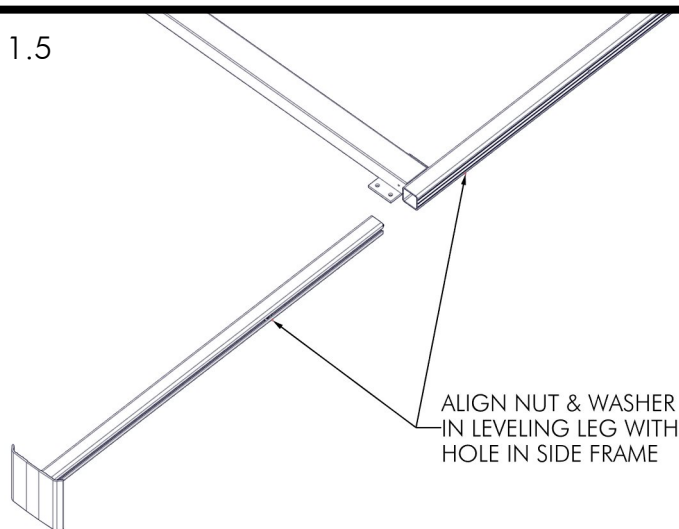


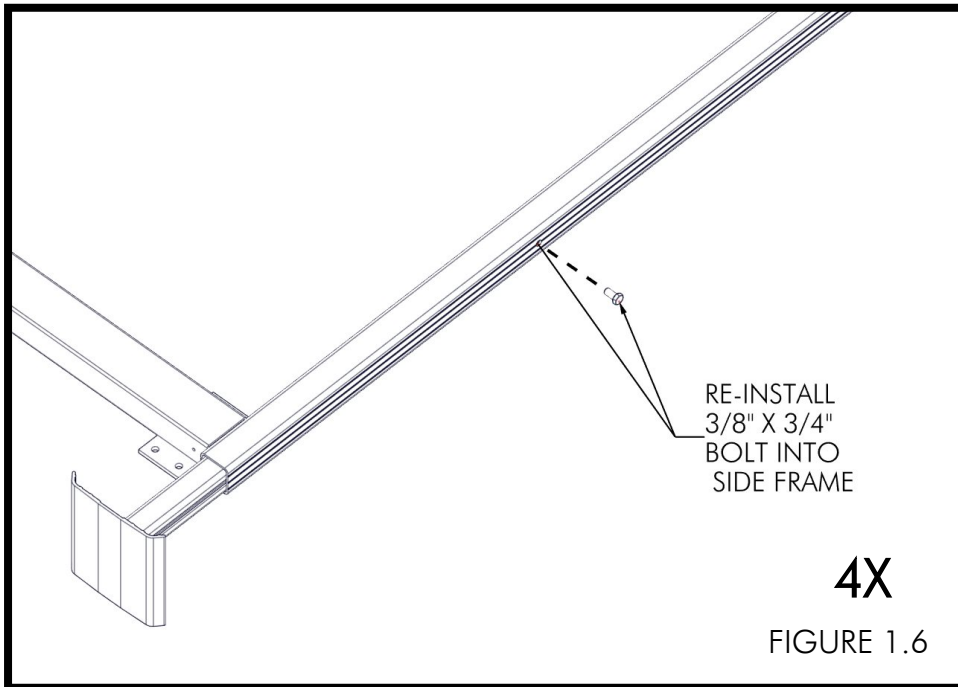
FIGURE 1.5

4X

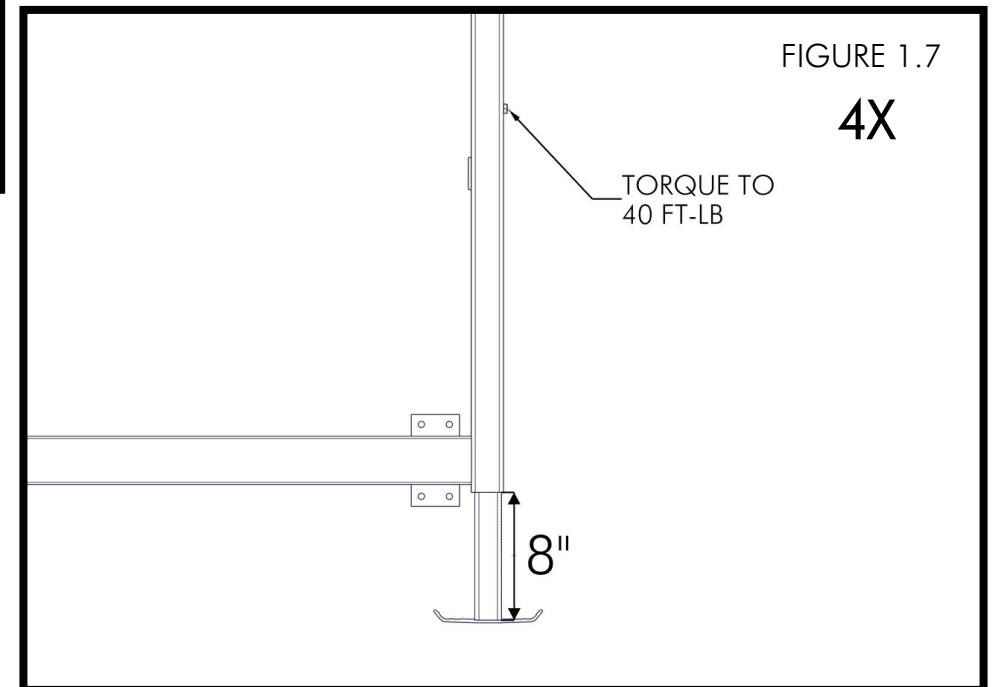


STEP 1

- LINE UP THE NUT AND WASHER WITH THE HOLE IN THE CORNER POST AND FASTEN WITH THE 3/8" X 3/4" BOLT THAT WAS REMOVED FROM EACH OF THE LEVELING LEGS (FIGURE 1.6).
- LEAVE LEVELING LEG EXTENDED OUT 8" AND TORQUE TO 40 FT-LB (FIGURE 1.7).

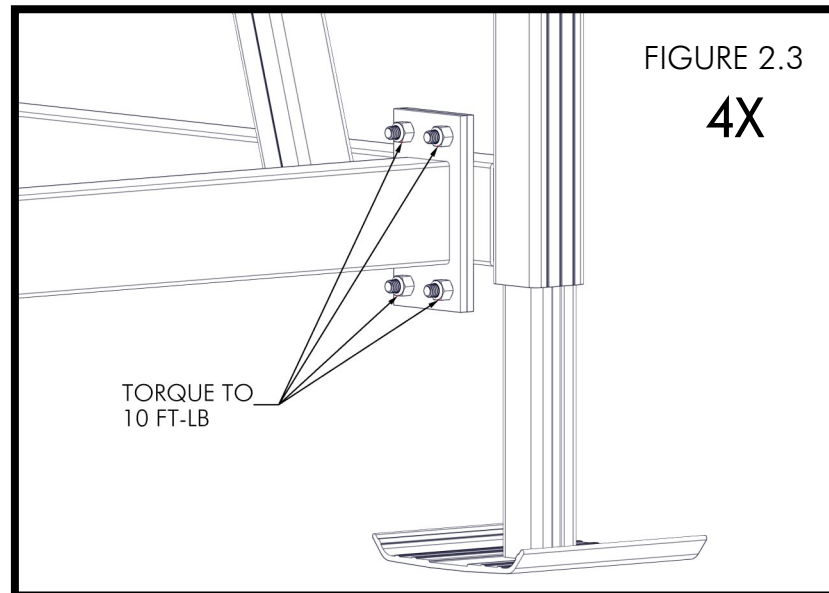
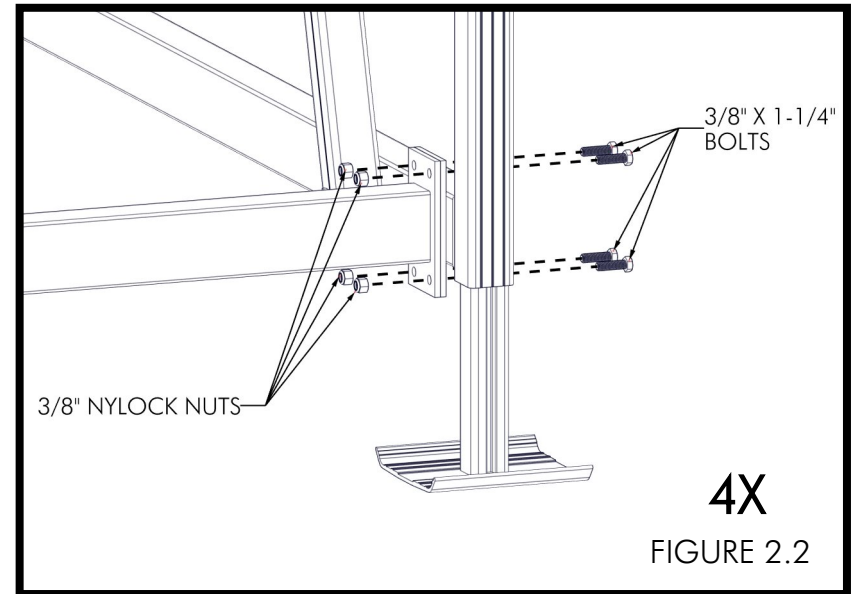
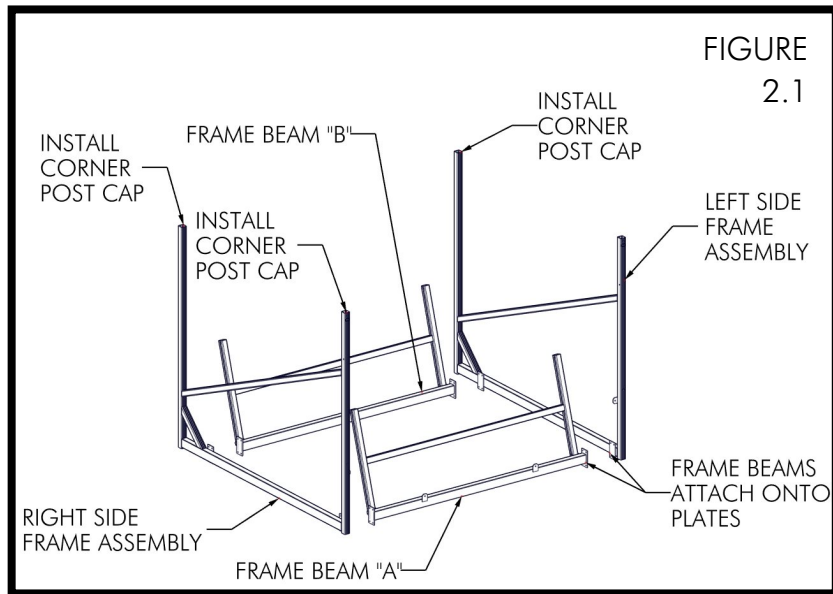


IMPORTANT:
BE SURE THAT THE DRAINAGE
HOLES IN THE FRAME BEAMS ARE
ON THE BOTTOM AT TIME OF
INSTALLATION



STEP 2

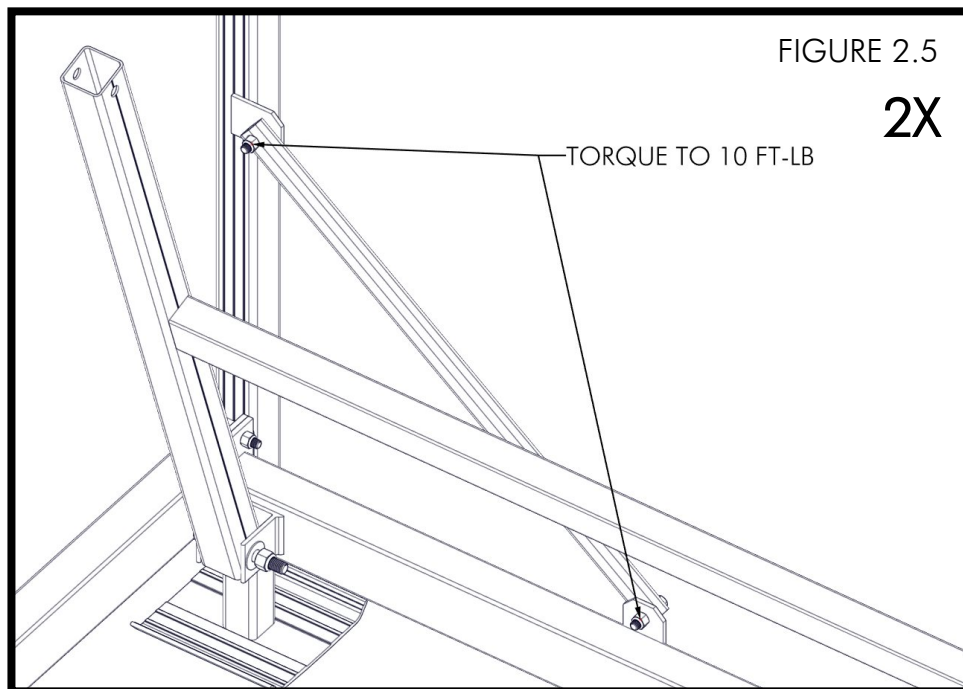
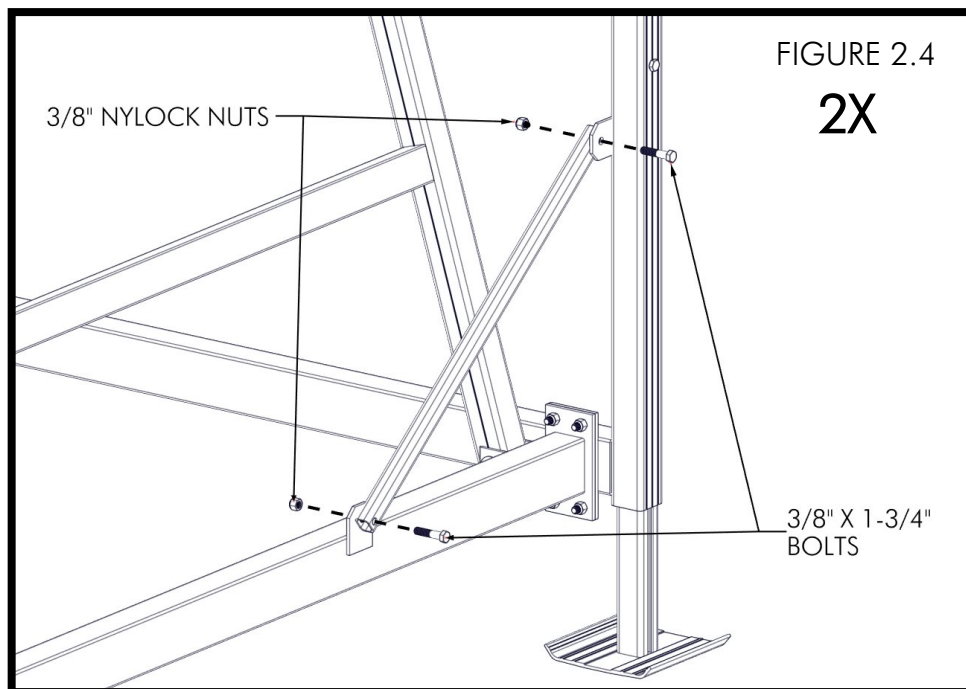
- POSITION THE FRAME BEAMS WITH THE SIDE FRAMES AS SHOWN. INSTALL THE VINYL CAPS ONTO EACH OF THE DENOTED CORNER POSTS (FIGURE 2.1).
- ATTACH THE FRAME BEAMS TO THE SIDE FRAMES USING (8) 3/8" X 1-1/4" BOLTS AND (8) 3/8" NYLOCK NUTS PER FRAME BEAM (FIGURE 2.2). TORQUE TO 10 FT-LB (FIGURE 2.3).



IMPORTANT:
BE SURE THAT THE
DRAINAGE HOLES IN THE
FRAME BEAMS ARE ON
THE BOTTOM AT TIME OF
INSTALLATION

STEP 2

- ATTACH THE FRONT BRACES TO THE MOUNTING TABS USING (2) 3/8" X 1-3/4" BOLTS AND (2) 3/8" NYLOCK NUTS PER BRACE (FIGURE 2.4). TORQUE TO 10 FT-LB (FIGURE 2.5).



STEP 3

- PLACE CRADLE ASSEMBLY ONTO THE PIVOT ARMS AS SHOWN (FIGURE 3.1).
- ATTACH THE CRADLE TO THE FRONT AND REAR PIVOT ARMS USING (1) 1/2" X 4" BOLT, (2) 1/2" WASHERS, AND (1) 1/2" NYLOCK NUT ON EACH PIVOT ARM. DO NOT OVERTIGHTEN (FIGURE 3.2).

FIGURE 3.1

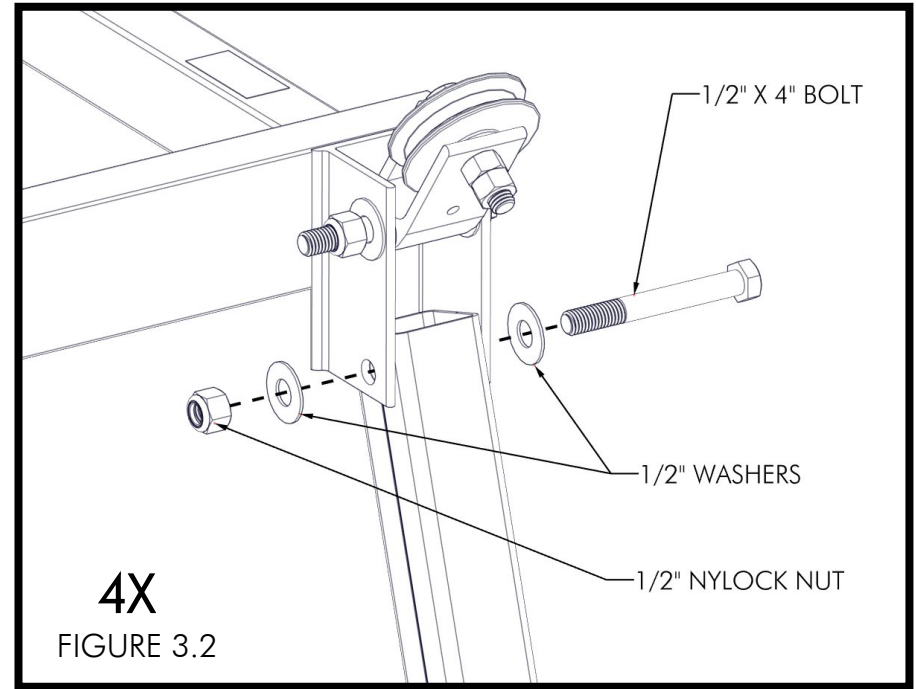
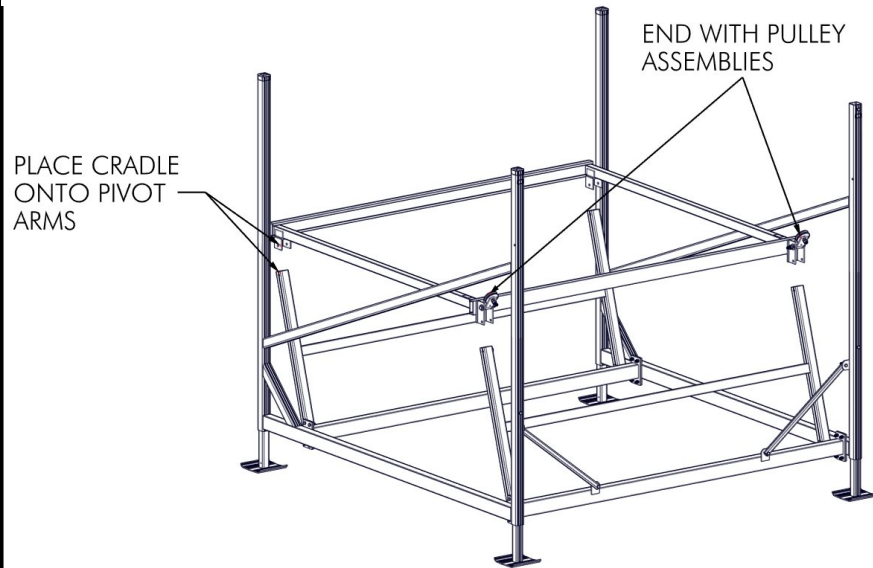
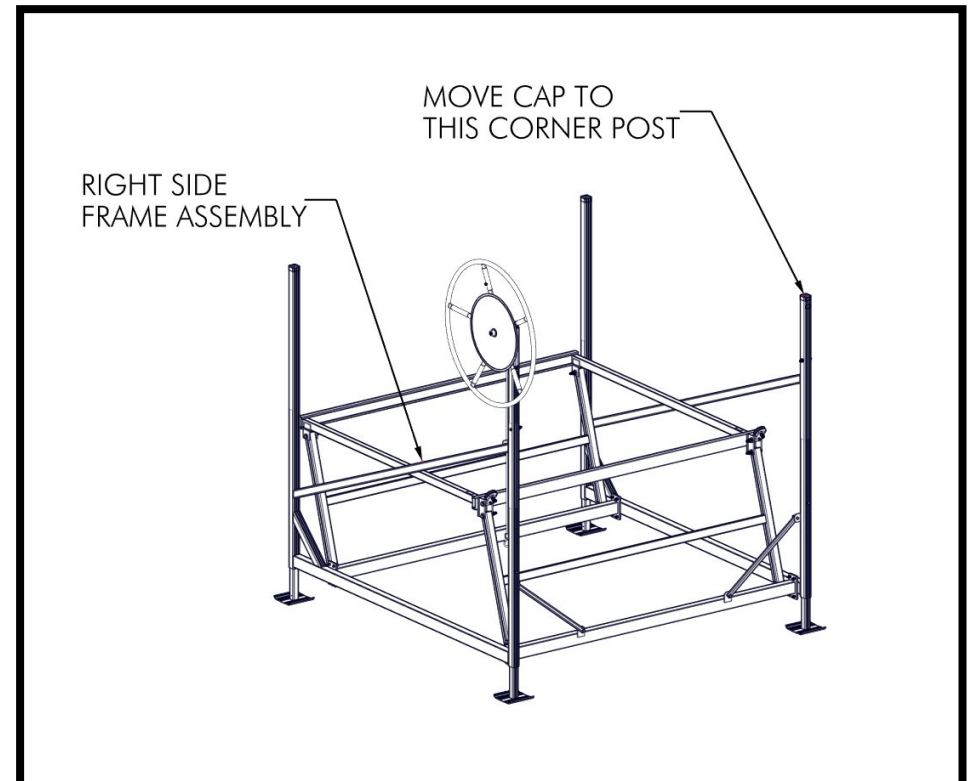
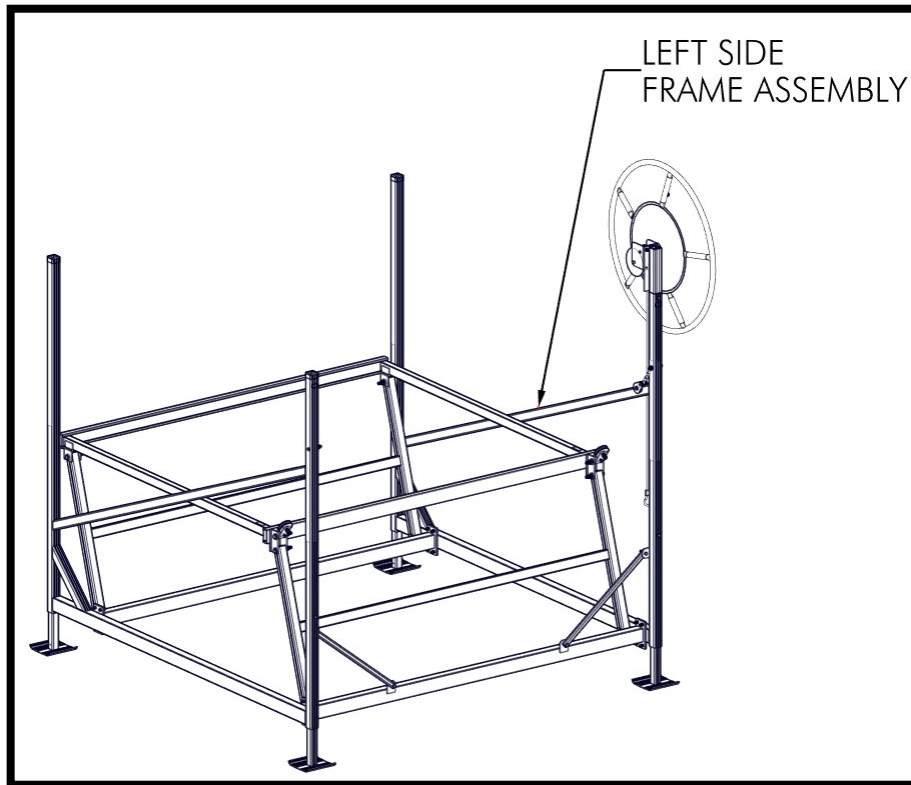


FIGURE 3.2

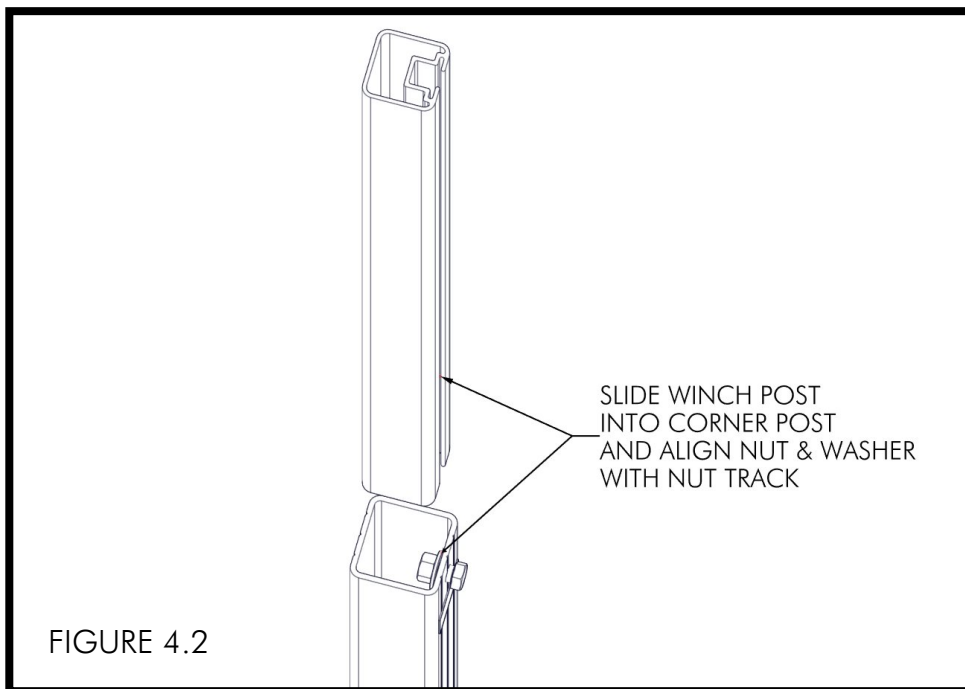
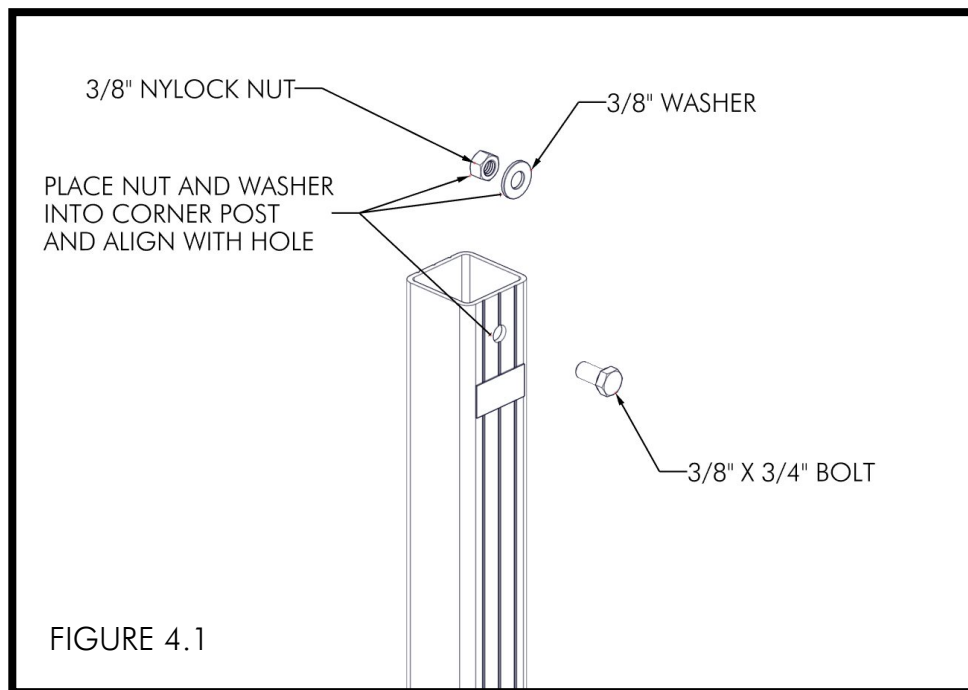
STEP 4, WINCH MOUNTING POSITIONS

- THE MANUAL WINCH CAN BE MOUNTED ON EITHER THE RIGHT SIDE FRAME OR THE LEFT SIDE FRAME AS SHOWN. THE STEP-BY-STEP PROCESS WILL INSTRUCT ON HOW TO ATTACH TO THE LEFT SIDE FRAME. THE SAME INSTALLATION PROCESS APPLIES WHEN INSTALLING THE WINCH TO THE RIGHT SIDE OF THE LIFT.



STEP 4

- PLACE THE 3/8" NUT AND A 3/8" WASHER INTO THE CORNER POST AND ALIGN THEM WITH THE HOLE, THEN START A 3/8" X 3/4" BOLT INTO THE NUT (FIGURE 4.1).
- INSERT WINCH POST INTO THE FRONT LEG OF THE LEFT SIDE FRAME WELDMENT (FIGURE 4.2).



STEP 4

- WHILE LEAVING 9-1/2" OF THE WINCH POST OUT OF THE TOP OF THE CORNER POST, TORQUE THE BOLT TO 35 FT-LB (FIGURE 4.3).
- INSTALL MANUAL WINCH WITH THE CRANK SPINDLE ON THE TOP AND THE CABLE OUT THE BOTTOM (FIGURE 4.4).

FIGURE 4.3

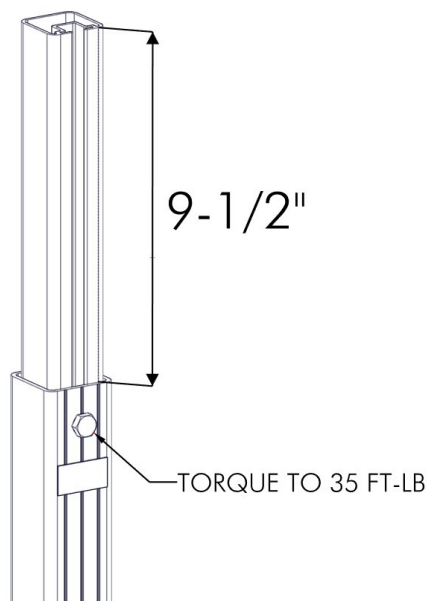
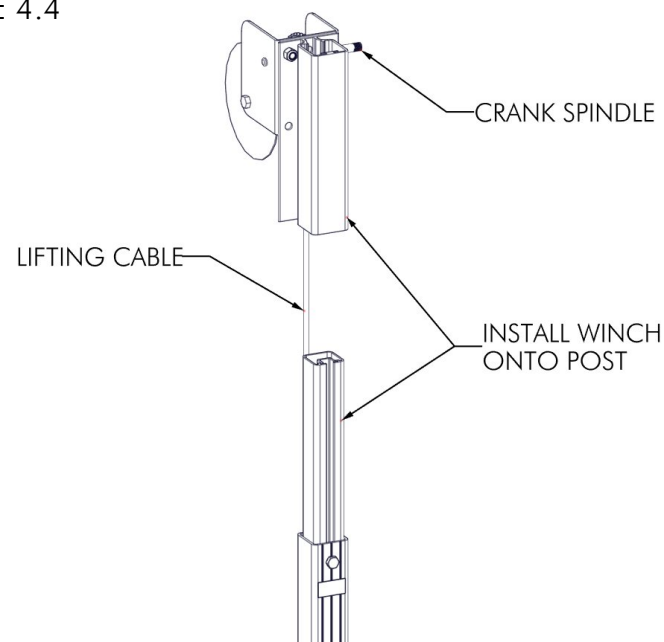


FIGURE 4.4



STEP 4

- LOOSEN AND REMOVE THE NUT, BOLT, AND WASHERS (END WITHOUT CHAIN ATTACHED) ON THE 2" PULLEY ASSEMBLY (FIGURE 4.5). INSERT THE CABLE AND REPLACE HARDWARE. TIGHTEN TO REMOVE EXCESS PLAY IN PULLEY (FIGURE 4.6).

FIGURE 4.5

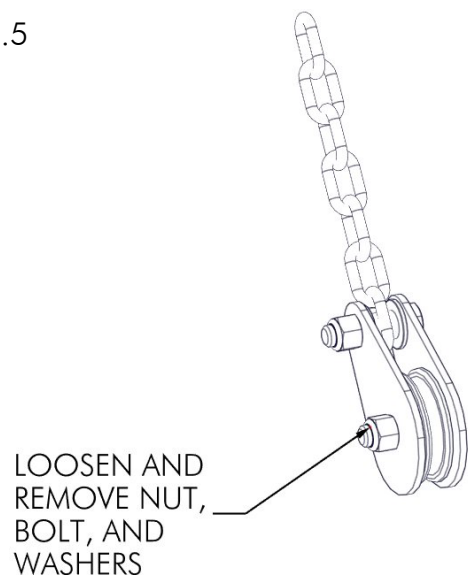
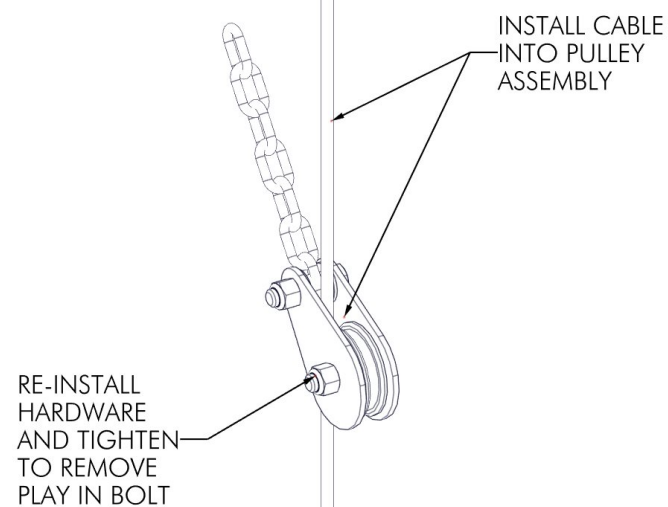


FIGURE 4.6



STEP 4

- ATTACH 2" PULLEY ASSEMBLY TO THE LEFT SIDE FRAME BEAM WELDMENT WITH (1) 3/8" X 3" BOLT, (1) 3/8" WASHER, AND (1) 3/8" NUT (FIGURE 4.7). TORQUE TO 10 FT-LB (FIGURE 4.8).

FIGURE 4.7

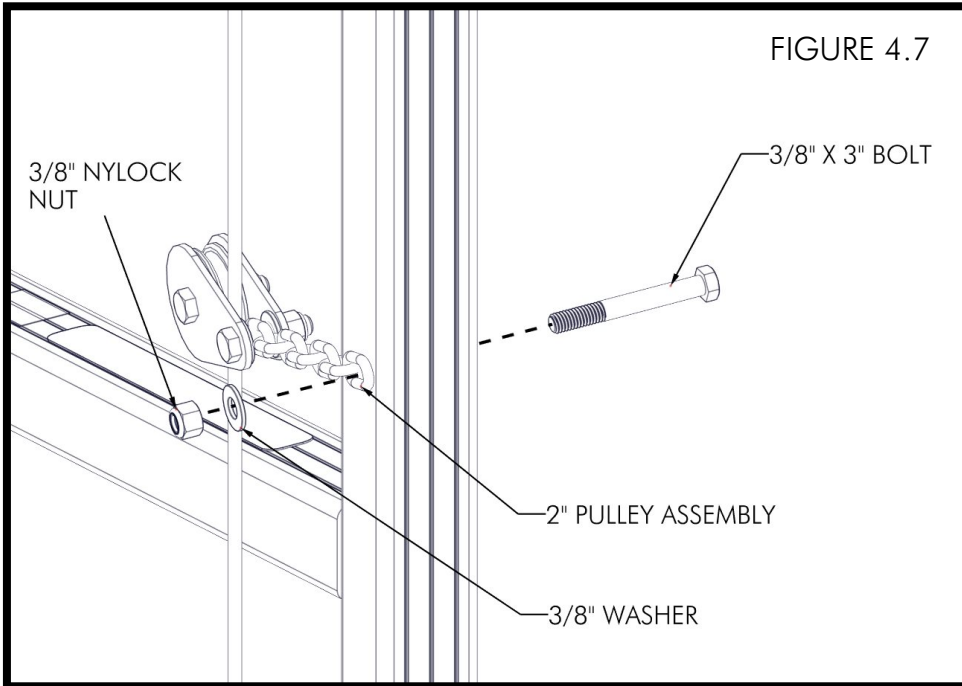
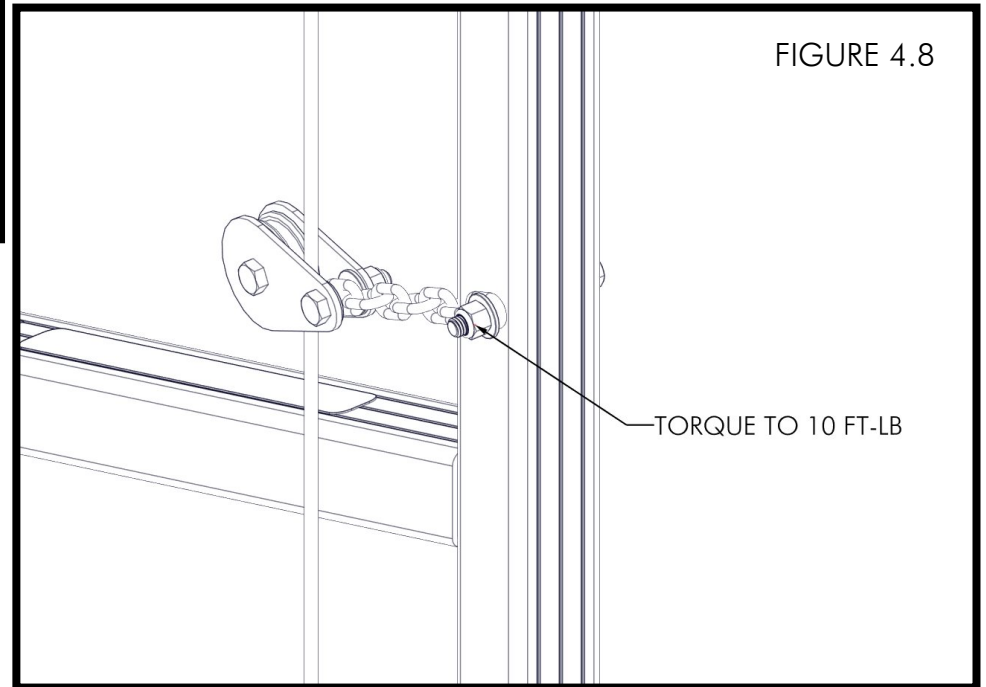
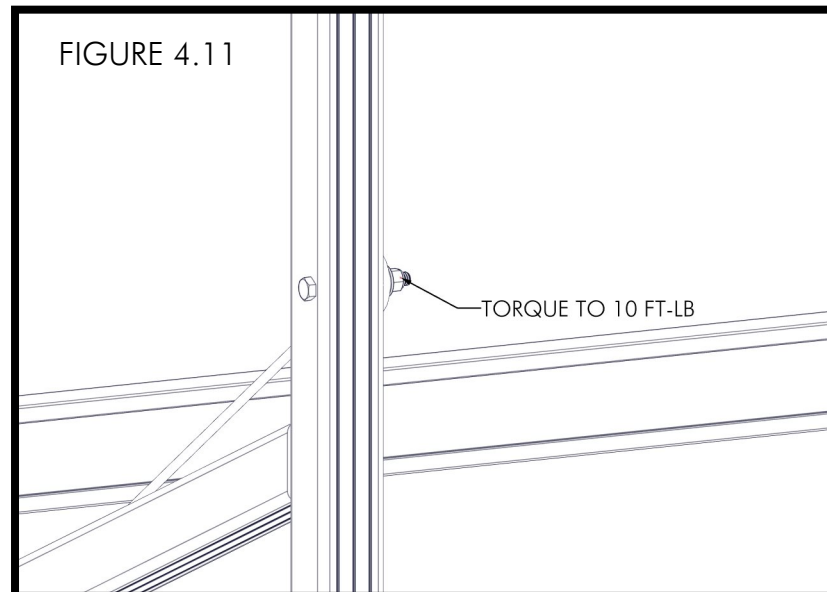
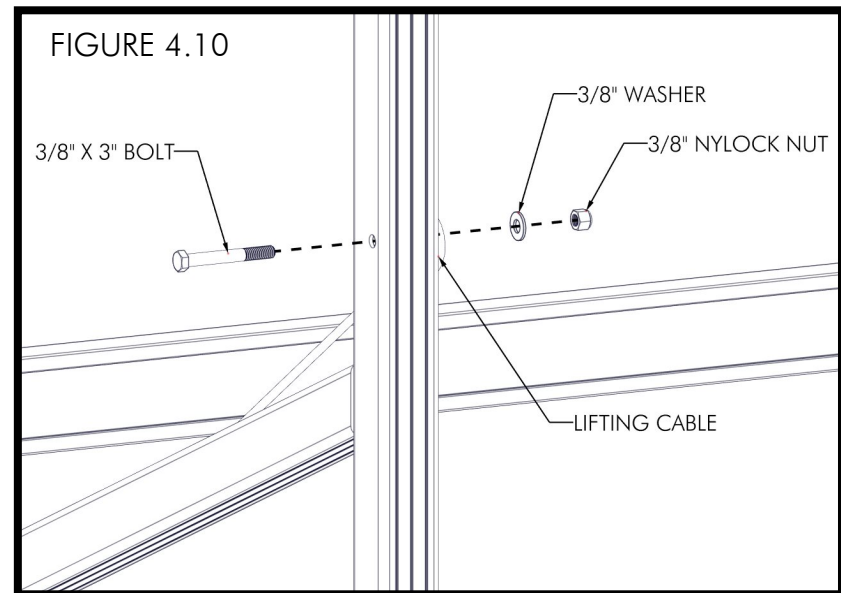
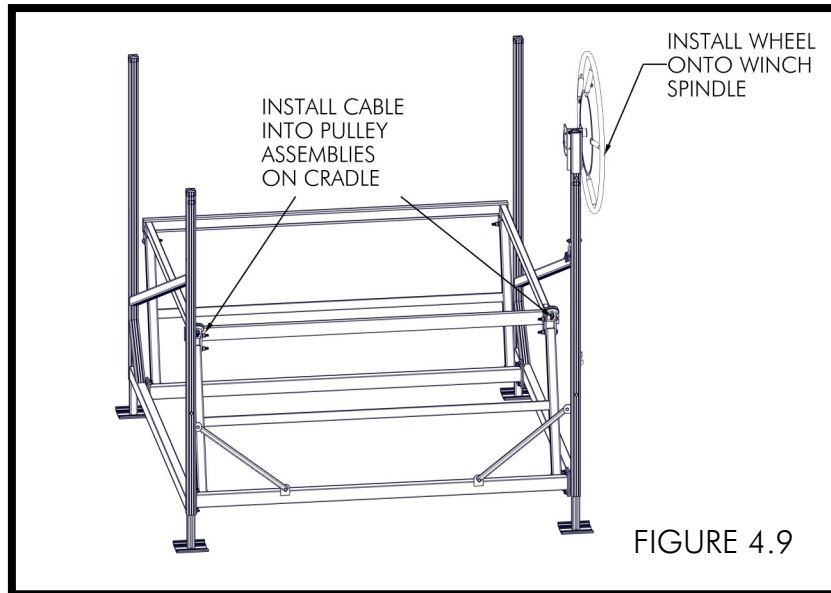


FIGURE 4.8



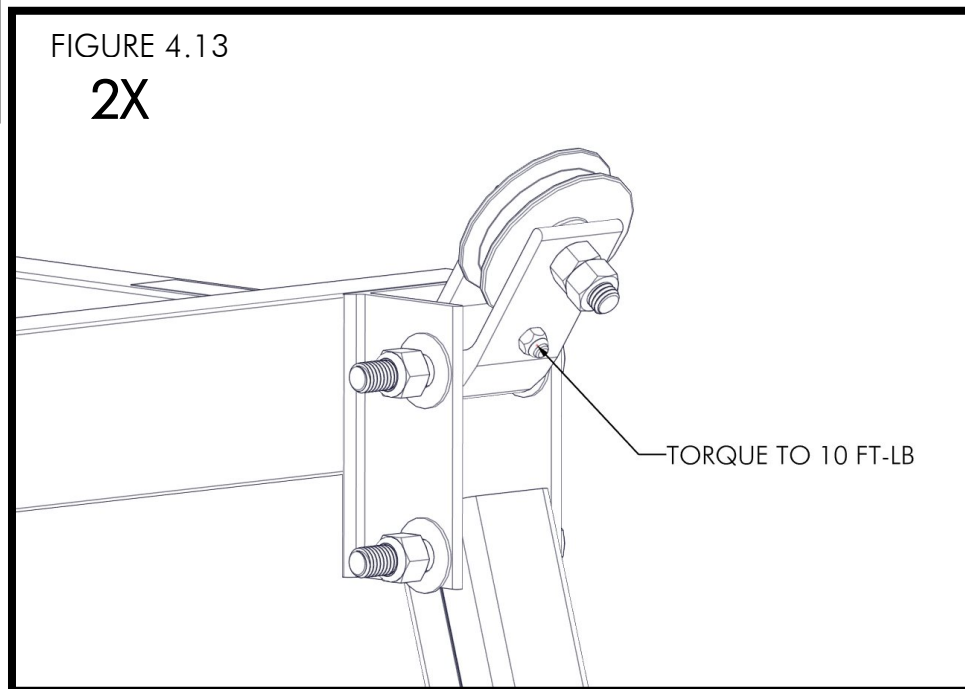
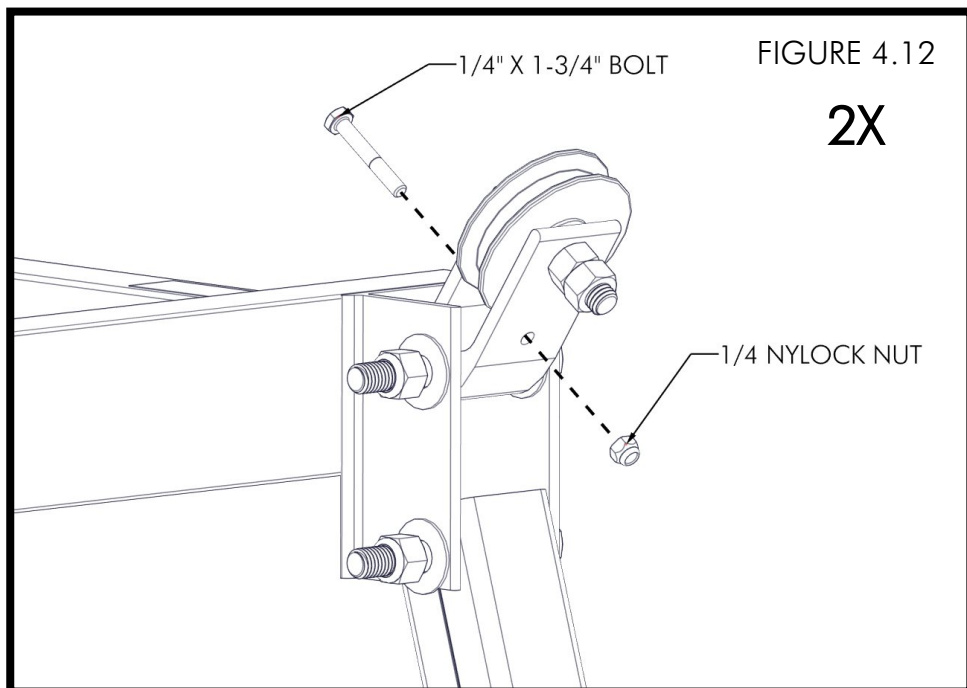
STEP 4

- INSTALL THE WINCH WHEEL (REFER TO INCLUDED INSTRUCTIONS WITH WINCH). INSTALL THE OTHER END OF THE CABLE THROUGH THE (2) 3" CRADLE PULLEY ASSEMBLIES (FIGURE 4.9).
- ATTACH THE SWEDGED END OF THE CABLE TO THE RIGHT SIDE WELDMENT WITH (1) 3/8" X 3", (1) 3/8" WASHER, AND (1) 3/8" NUT (FIGURE 4.10). TORQUE TO 10 FT-LB (FIGURE 4.11).



STEP 4

- INSTALL (1) 1/4" X 1-3/4" BOLTS AND (1) 1/4" NYLOCK NUTS THROUGH EACH OF THE 3" PULLEY ASSEMBLIES (FIGURE 4.12). TORQUE TO 10 FT-LB (FIGURE 4.13).



P1600 BILL OF MATERIALS

511-16001-00	LIFT, PIVOT P1600		
<u>NO.</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>	<u>QTY</u>
1	002-02088-00	TUBE, .875" X 1.063" X 26"	2
2	006-15210-00	CAP, VINYL 2" SQ. LIFT CORNER	3
3	111-00274-00	WELD'T, FRAME BEAM "A"	1
4	111-00275-00	WELD'T, FRAME BEAM "B"	1
5	111-00276-00	WELD'T, PIVOT ARM	2
6	111-00277-00	ASS'Y, P1600 WINCH	1
7	111-00293-00	ASS'Y, 2" PULLEY BLOCK W/ 7 LINKS	1
8	111-00294-00	ASS'Y, P1600 SIDE FRAME (R)	1
9	111-00295-00	ASS'Y, P1600 SIDE FRAME (L)	1
10	111-00296-00	ASS'Y, P1600 CRADLE	1
11	111-00554-00	ASS'Y, ADJUSTABLE LEG – 48"	4
12	511-01900-00	WHEEL, 36"	1
13	511-04238-00	FASTENERS, P1600 LIFT	1
14	911-01204-00	POST, WINCH – 24"	1

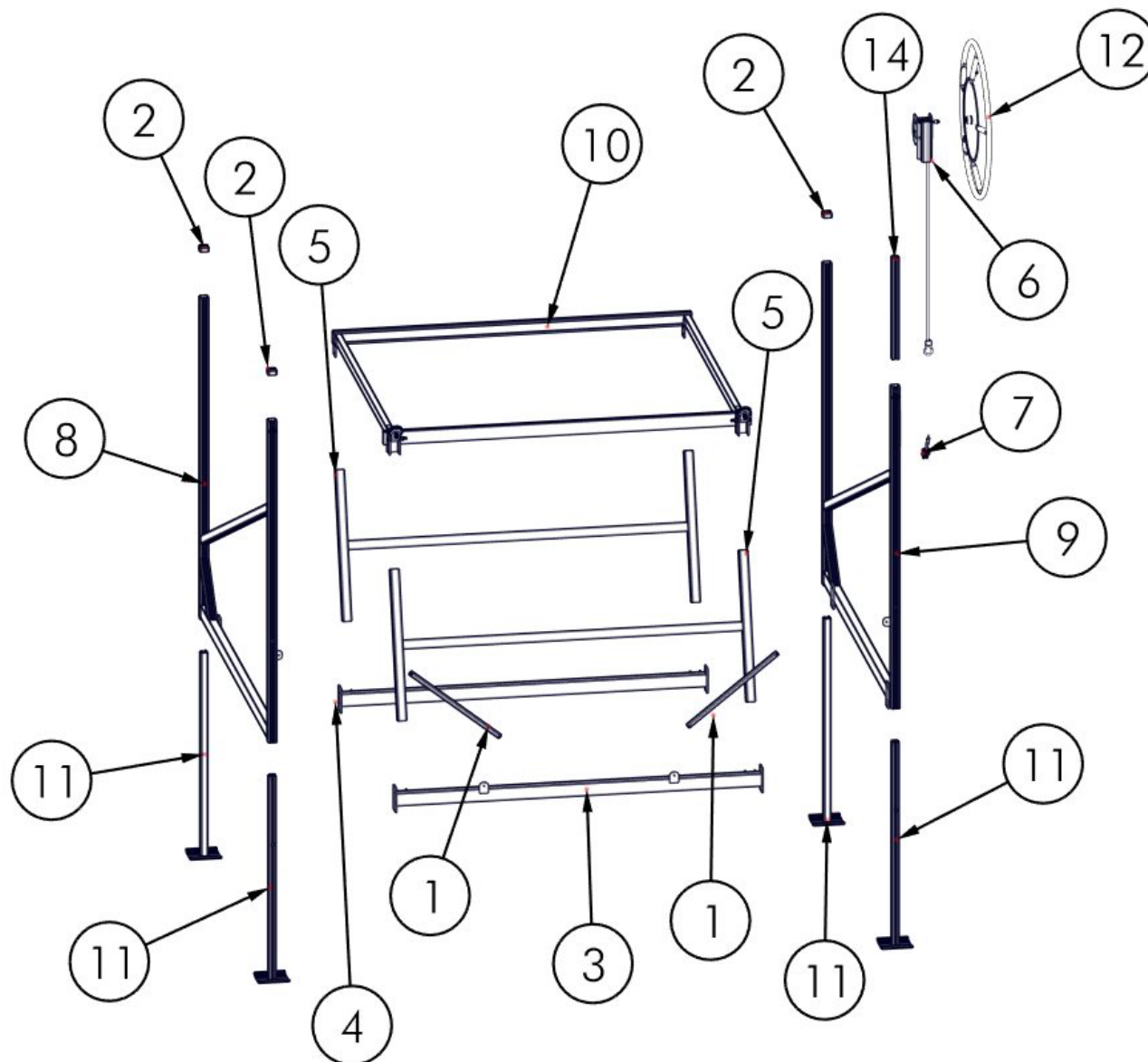
P1600 SUB-ASSEMBLIES

<u>NO.</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>	<u>QTY</u>
6	111-00277-00	ASS'Y, P1600 WINCH	1
	001-70103-00	HHCS, 3/8-16 X 3/4" 18-8 SS	2
	001-70105-00	HHCS, 3/8-16 X 1" 18-8 SS	1
	001-71017-00	FLAT WASHER, 3/8" SAE SS 18-8	3
	001-76071-00	NUT, NYLOCK 3/8-16 ALUM.	3
	002-03327-00	MOUNT, WINCH – 9.5"	1
	007-00100-00	WINCH, MANUAL	1
	111-00278-00	ASS'Y, CABLE P1600	1
	911-10808-00	TUBE, .72 OD X .065 – 0.594"	1

<u>NO.</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>	<u>QTY</u>
10	111-00296-00	ASS'Y, P1600 CRADLE	1
	001-70219-00	HHCS, 1/2-13 X 4" 18-8 SS	2
	001-71021-00	FLAT WASHER, 1/2" 18-8 SS	8
	001-76072-00	NUT, NYLOCK 1/2-13 ALUM.	2
	111-00042-00	ASS'Y, 3" PULLEY	2
	111-00303-00	WELD'T, P1600 CRADLE	1

P1600 Frame Exploded View A

LIFT P/N 511-16001-00



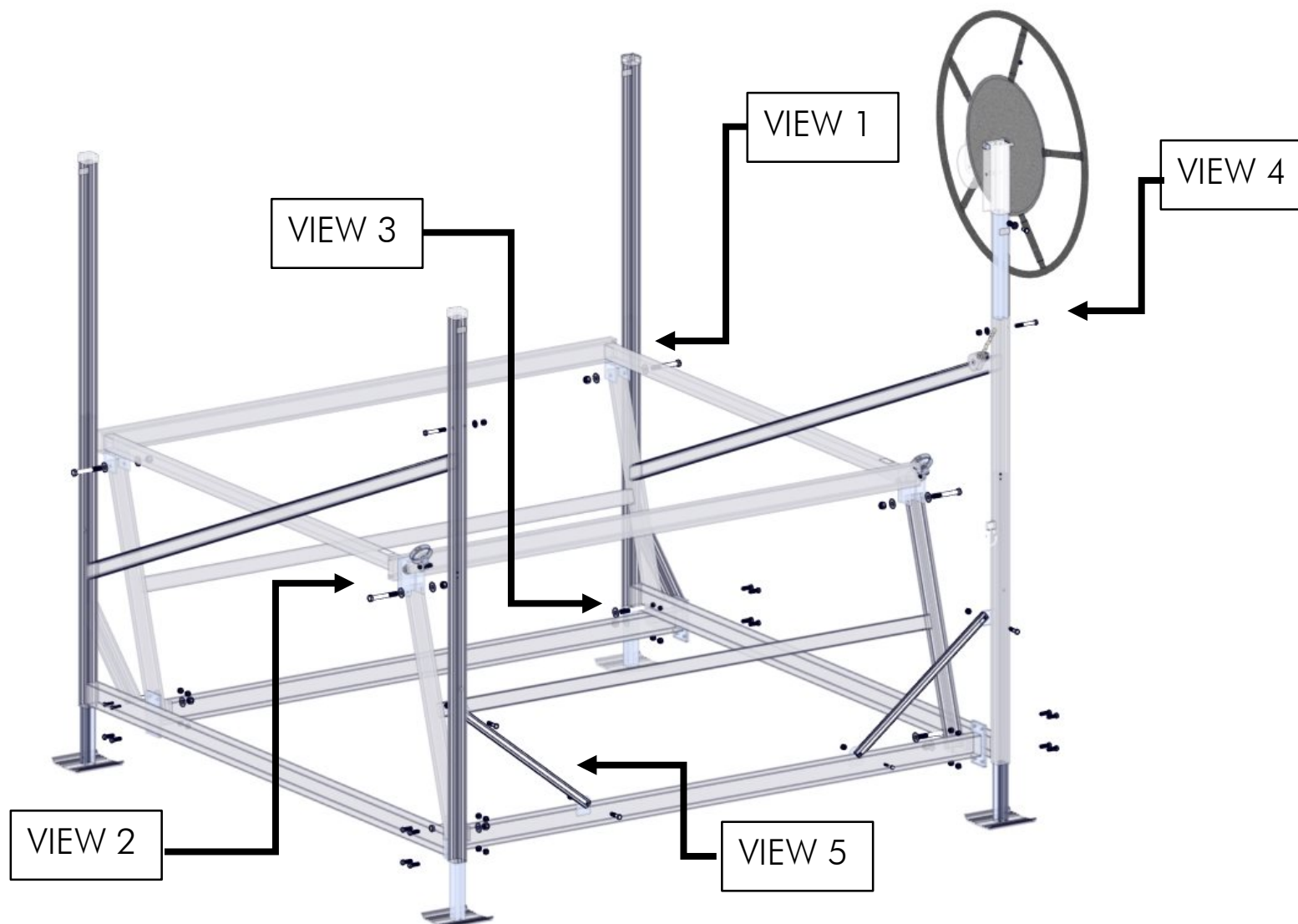
P1600 FASTENERS

NO.	PART NUMBER	DESCRIPTION	QTY
13	511-04206-00	FASTENERS, P1600 LIFT	1
13A	001-70010-00	HHCS, 1/4-20 X 1-3/4" 18-8 SS	2
13B	001-70103-00	HHCS, 3/8-16 X 3/4" 18-8 SS	1
13C	001-70107-00	HHCS, 3/8-16 X 1-1/4" 18-8 SS	16
13D	001-70110-00	HHCS, 3/8-16 X 1-3/4" 18-8 SS	4
13E	001-70115-00	HHCS, 3/8-16 X 3" 18-8 SS	2
13F	001-70219-00	HHCS, 1/2-13 X 4" 18-8 SS	8
13G	001-71017-00	FLAT WASHER, 3/8" SAE SS 18-8	3
13H	001-71021-00	FLAT WASHER, 1/2" 18-8 SS	16
13I	001-75001-00	NUT, NYLOCK 1/4-20 ALUM.	2
13J	001-76071-00	NUT, NYLOCK 3/8-16 ALUM.	22
13K	001-76072-00	NUT, NYLOCK 1/2-13 ALUM.	8
13L	001-76349-00	NUT, 3/8-16 ALUM.	1

P1600 Frame Exploded View B

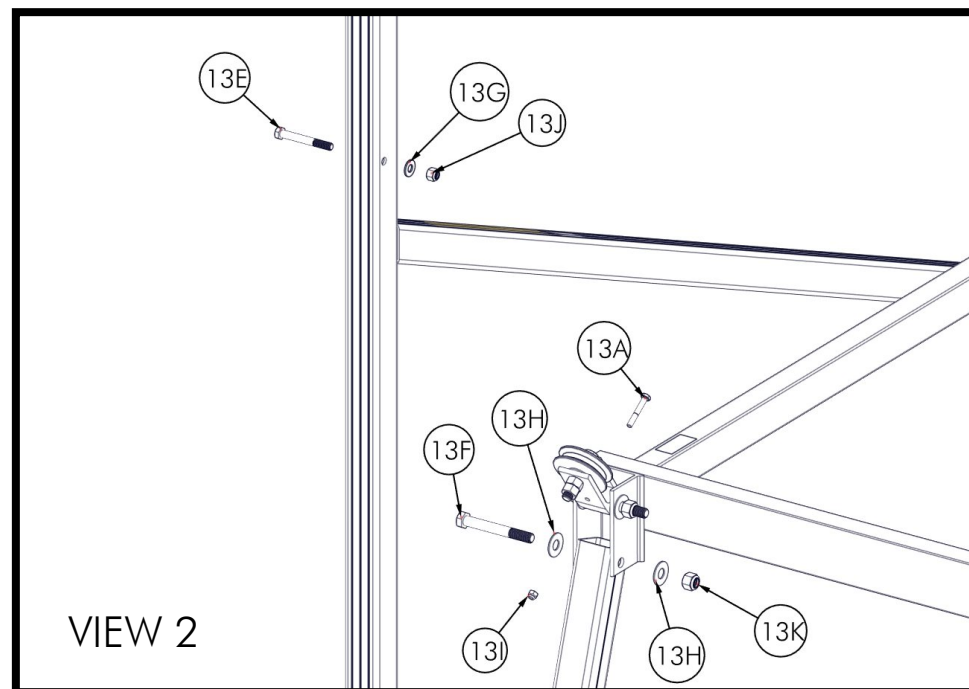
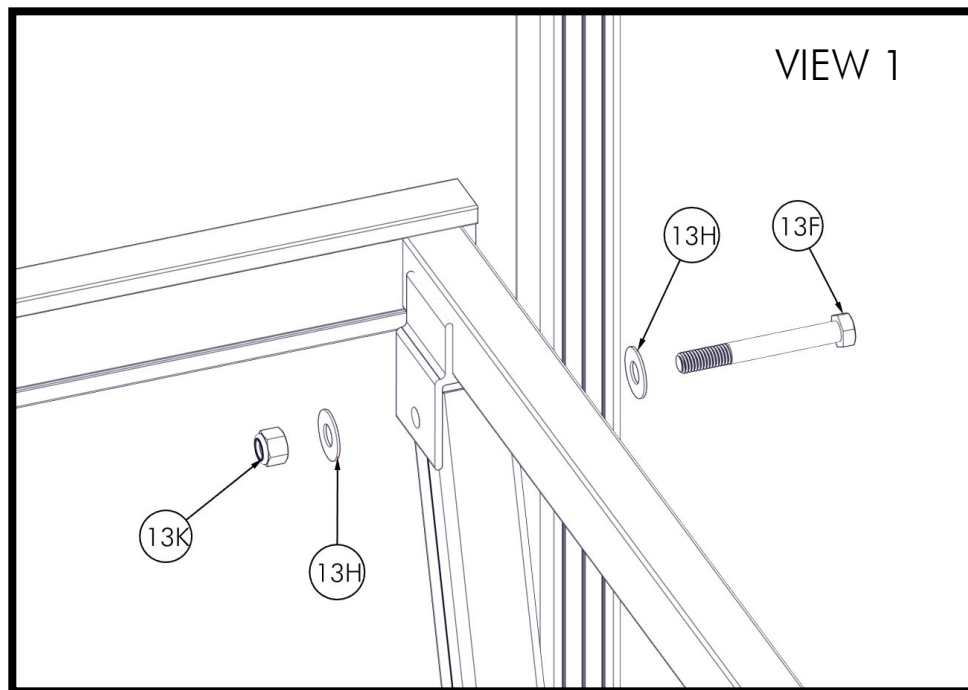
LIFT P/N 511-16001-00

NOTE:
ADDITIONAL VIEWS ON
FOLLOWING PAGES



P1600 Frame Exploded Views 1 & 2

LIFT P/N 511-16001-00



P1600 Frame Exploded Views 3-5

LIFT P/N 511-16001-00

