



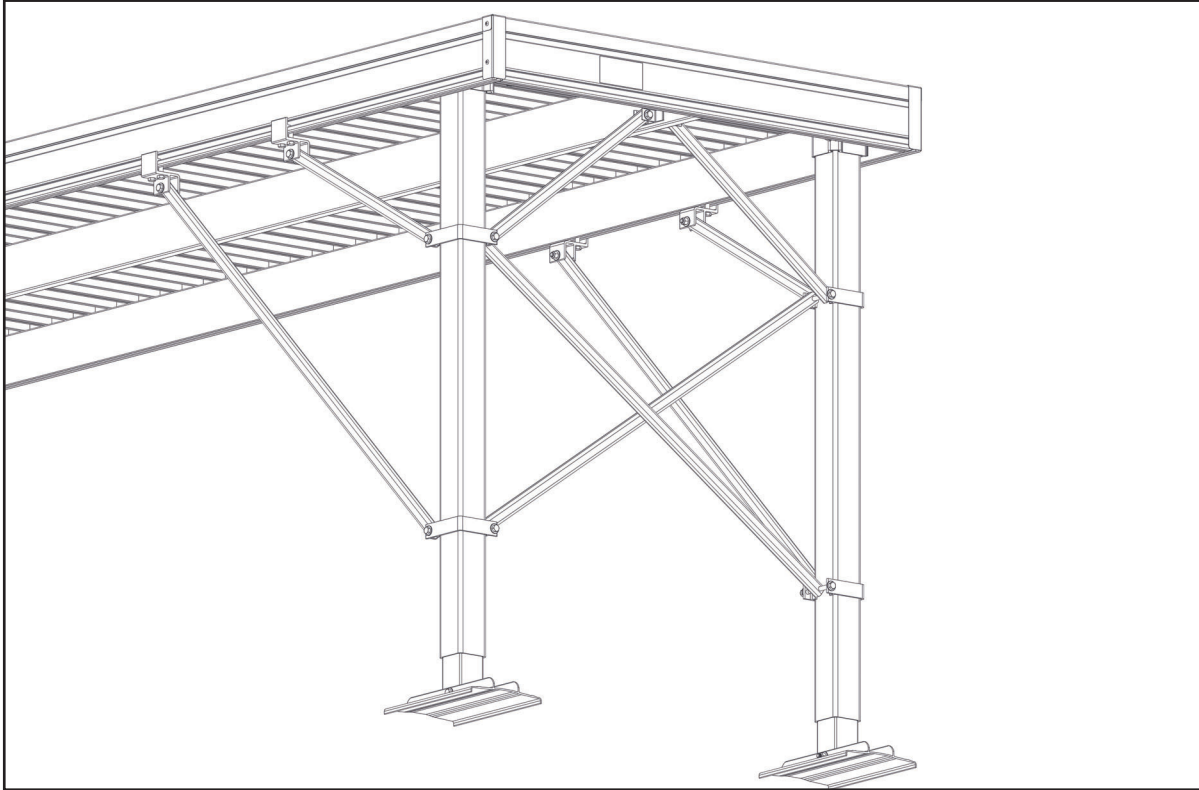
ASSEMBLY INSTRUCTIONS

DEEP LEG STABILIZING BRACE KIT

QUICK ATTACH SECTIONAL DOCKS

4' & 6' WIDE

P/N 510-02531-00



For more information, go to the owner support tab on the FLOE website

*DOCK AND LEG KIT NOT INCLUDED

TOOLS REQUIRED

- (2) 9/16" SOCKETS/WRENCHES
 - TORQUE WRENCH
 - TAPE MEASURE
- DEEP SECTIONAL DOCK LEG KIT
- SECTIONAL DOCK LEG INSTRUCTIONS

IN ADDITION, IF INSTALLING LEGS ALONG THE LENGTH OF THE DOCK

- CORDLESS DRILL
- 13/32" DRILL BIT
- CENTER PUNCH
 - HAMMER
 - MARKER

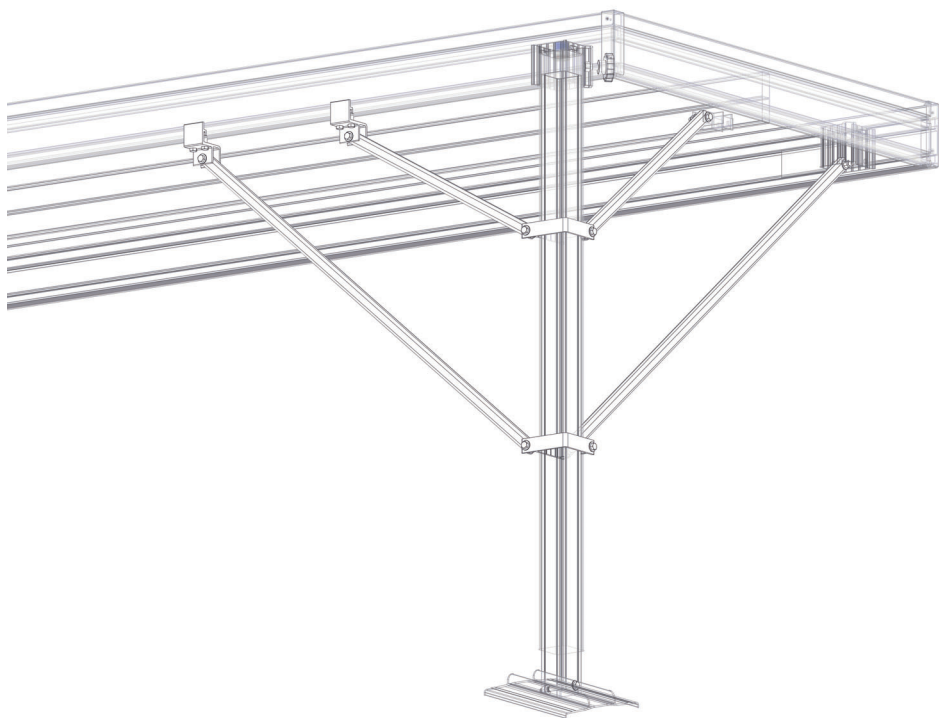
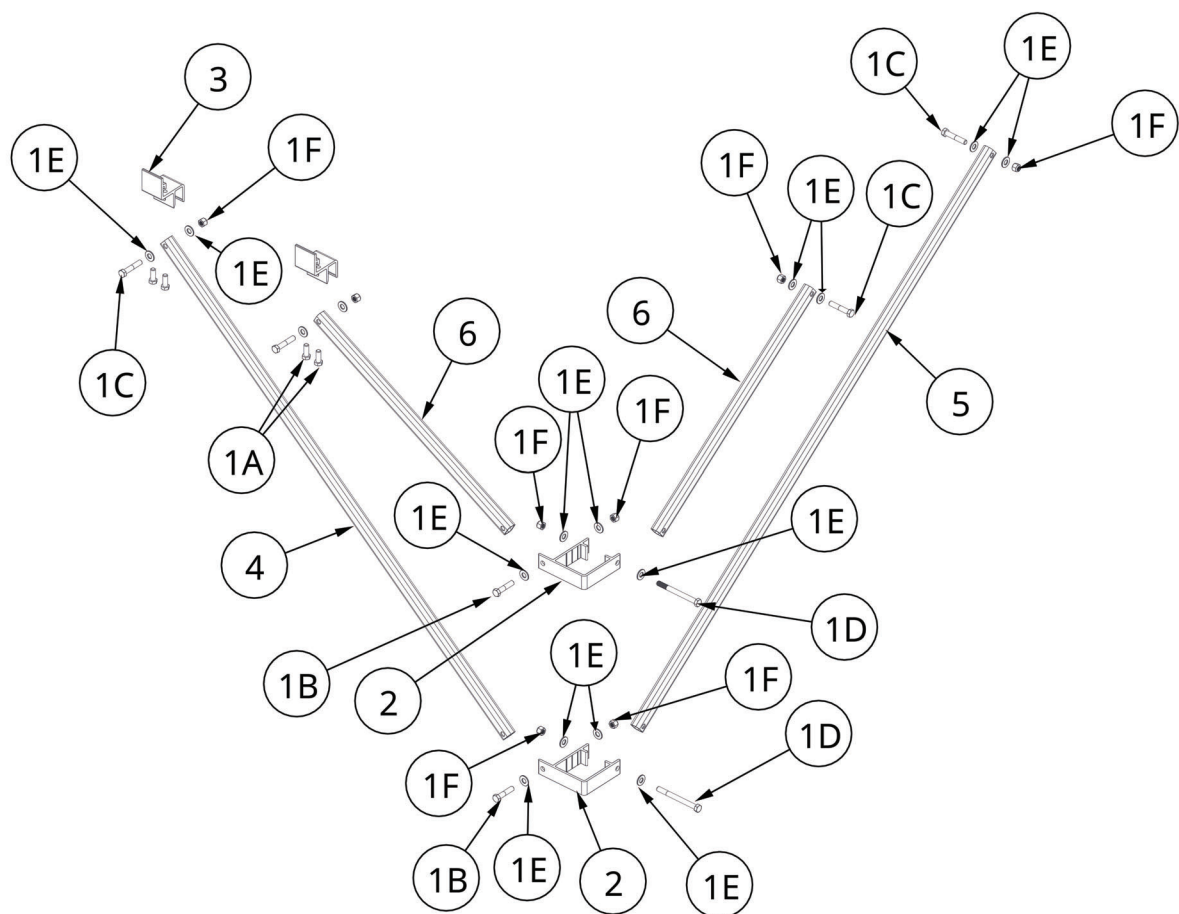
BILL OF MATERIALS

P/N 510-02531-00	BRACE KIT, QA SECTIONAL DEEP LEG STABILIZING		
NUMBER	PART NUMBER	QTY.	DESCRIPTION
*1	001-02531-00	1	FASTENERS, BRACE KIT QA SECT. DEEP LEG STABILIZING
1A	001-70105-00	8	HHCS, 3/8-16 X 1" 18-8 SS
1B	001-70110-00	2	HHCS, 3/8-16 X 1-3/4" 18-8 SS
1C	001-70111-00	8	HHCS, 3/8-16 X 2" 18-8 SS
1D	001-70119-00	2	HHCS, 3/8-16 X 4" 18-8 SS
1E	001-71017-00	24	FLAT WASHER, 3/8" SAE SS 18-8
1F	001-76071-00	12	NUT, NYLOCK 3/8-16 ALUM.
2	002-00064-00	2	BRACKET, W/K BRACE - 1.125"
3	002-00285-00	4	BRACKET, QA DOCK SIDE BRACE
4	002-02087-00	2	BRACE, WHEEL KIT - 46.5"
5	002-02089-00	2	BRACE, WHEEL KIT - 52.75"
6	002-03305-00	2	BRACE, SCTN'L. - 22.5"

*FASTENERS FROM THE SECTIONAL DOCK LEG KIT WILL BE USED IN ADDITION TO THE ONES INCLUDED WITH THIS KIT. REFER TO THOSE INSTRUCTIONS.

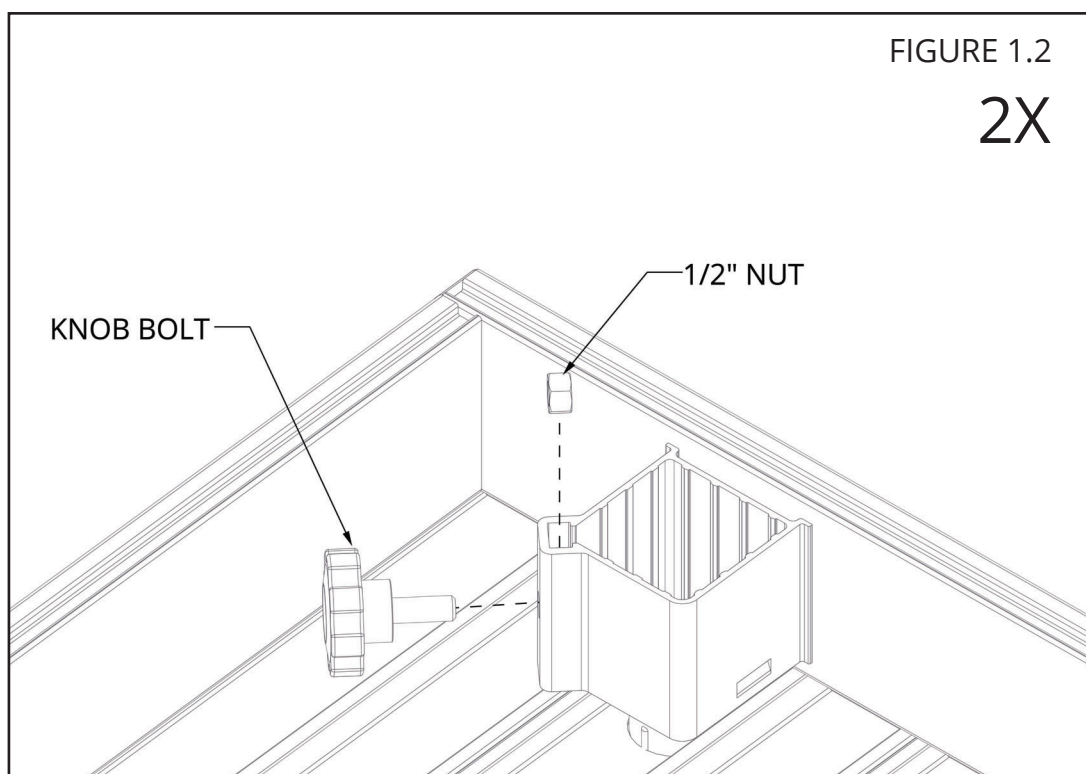
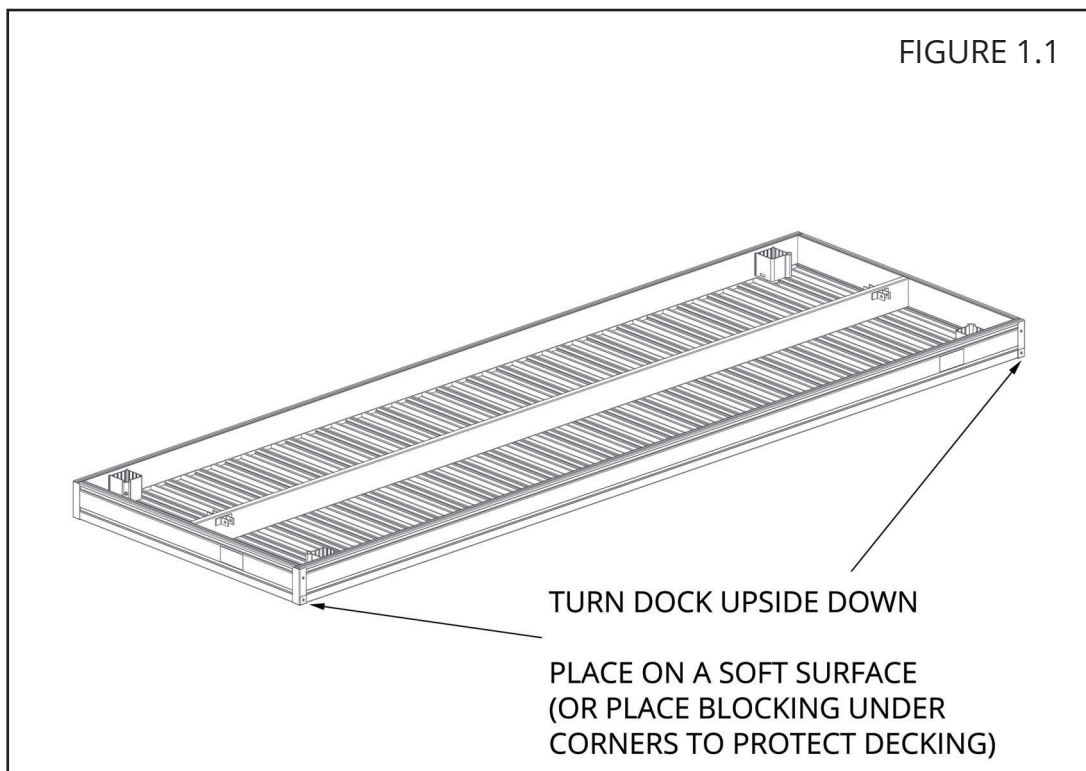
SOME PARTS FROM THE SECTIONAL DOCK LEG KIT WILL ALSO BE USED IN ADDITION TO THE ONES INCLUDED WITH THIS KIT.

EXPLODED VIEW

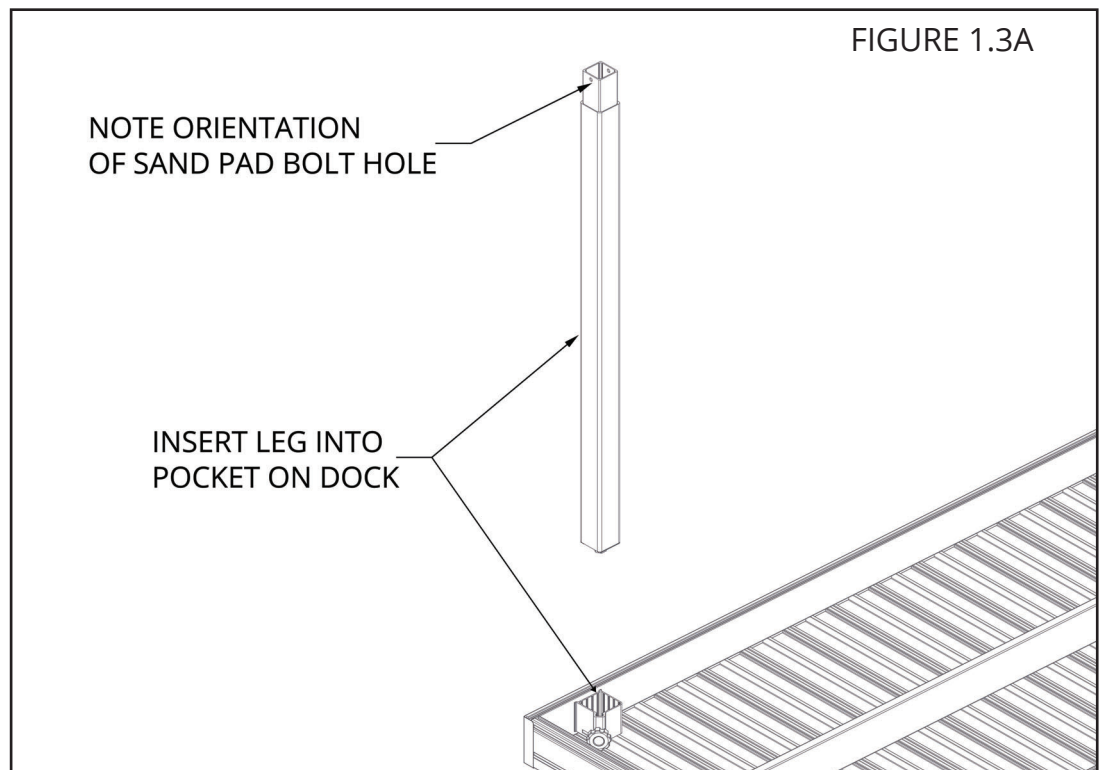
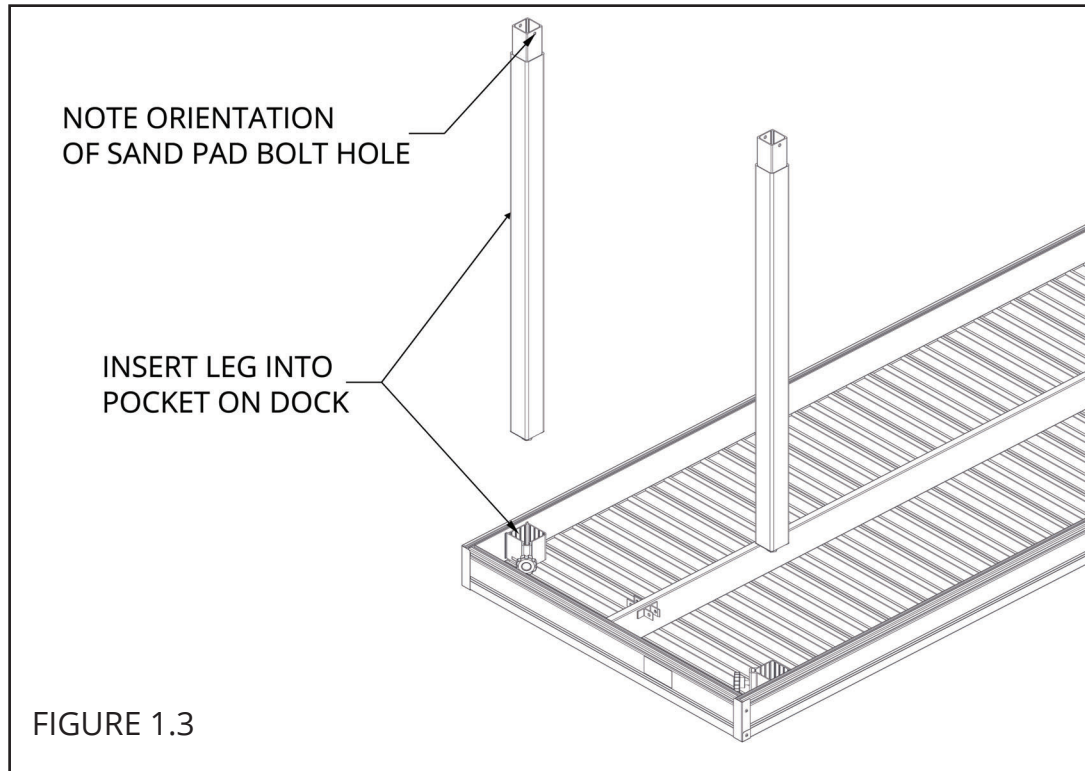


ASSEMBLY

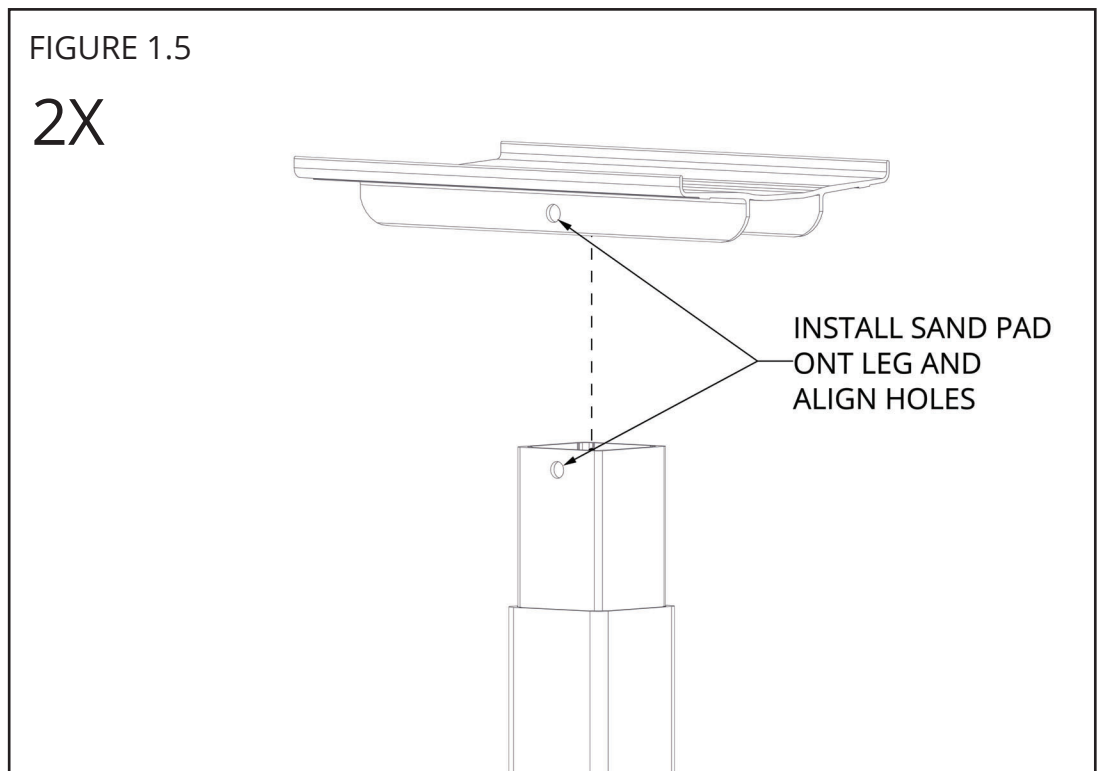
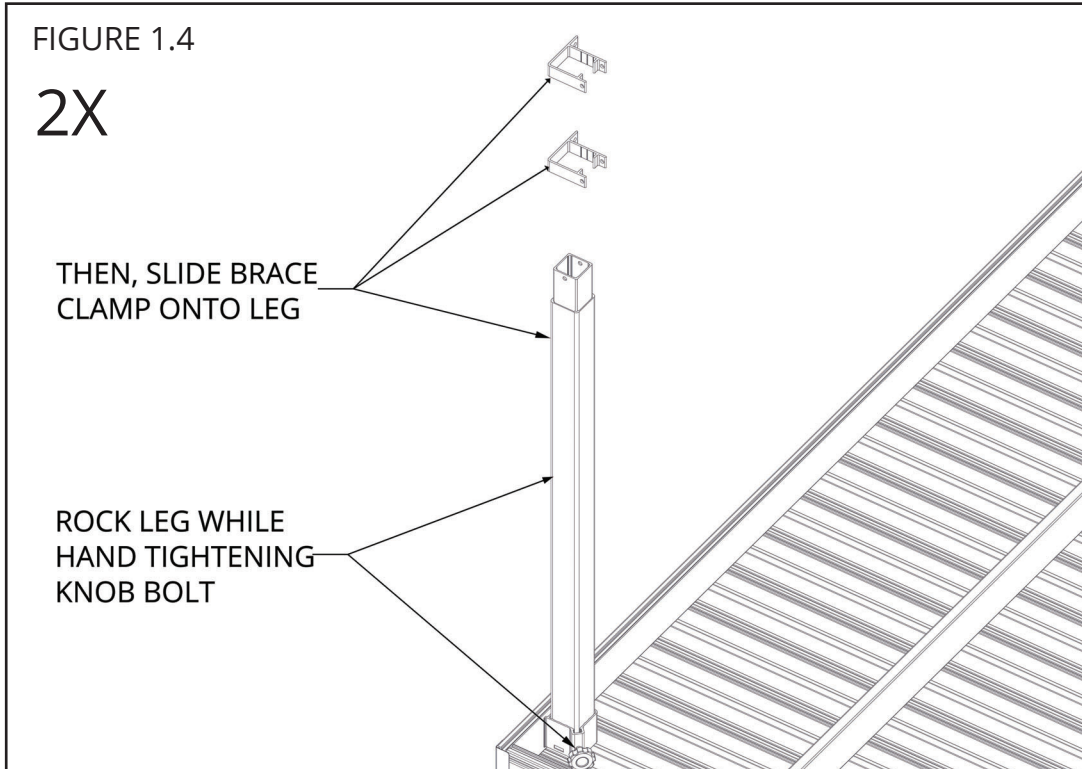
TURN DOCK UPSIDE DOWN ONTO A SOFT SURFACE (OR USE BLOCKING MATERIAL) TO PROTECT THE DECK SURFACE (FIGURE 1.1). SLIDE A 1/2" ALUMINUM NUT INTO THE TRACK OF EACH LEG POCKET (INCLUDED WITH SECTIONAL DOCK LEG KIT), THEN THREAD A 1/2" KNOB BOLT (INCLUDED WITH SECTIONAL DOCK LEG KIT) IN THROUGH THE LEG POCKET AND INTO THE NUT. DO NOT FULLY TIGHTEN KNOB BOLT AT THIS TIME (FIGURE 1.2).



INSERT A LEG INTO EACH LEG POCKET (INCLUDED WITH SECTIONAL DOCK LEG KIT) AS SHOWN. **NOTE THE ORIENTATION OF THE SAND PAD MOUNTING BOLT HOLE. THE LEG CAN BE INSTALLED TO ORIENT THE LONG SIDE OF THE SAND PAD PARALELL TO THE LONG SIDE OF THE DOCK (WHEN INSTALLING THE LEGS AT THE END OF THE DOCK, FIGURE 1.3) OR PARALLEL TO THE END OF THE DOCK (FOR INSTALLING LEGS ALONG THE LONG SIDE OF THE DOCK, FIGURE 1.3A).**



ROCKING THE LEG ASSEMBLY WHILE HAND TIGHTENING THE KNOB BOLT WILL HELP ENSURE THAT THE LEG IS SEATED AND THE KNOB BOLT IS ADEQUATELY TIGHTENED. **NOTE: IF THE LEG MOVES IN THE POCKET, THE KNOB BOLT NEEDS TO BE TIGHTENED FURTHER. DO NOT USE ANY TOOLS ON THE KNOB BOLT.** SLIDE THE BRACE CLAMPS OVER THE LEG IN THE ORIENTATION SHOWN. **NOTE: TWO BRACE CLAMPS ARE USED FROM THE SECTIONAL DOCK LEG KIT (FIGURE 1.4). PLACE A SAND PAD ONTO EACH LEG (INCLUDED WITH SECTIONAL DOCK LEG KIT) (FIGURE 1.5).**



ATTACH SAND PADS TO THE DOCK LEGS USING (1) 3/8" X 3-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER LEG (**FASTENERS INCLUDED WITH SECTIONAL DOCK LEG KIT**) (FIGURE 1.6). TORQUE TO 5 FT-LB (FIGURE 1.7).

FIGURE 1.6

2X

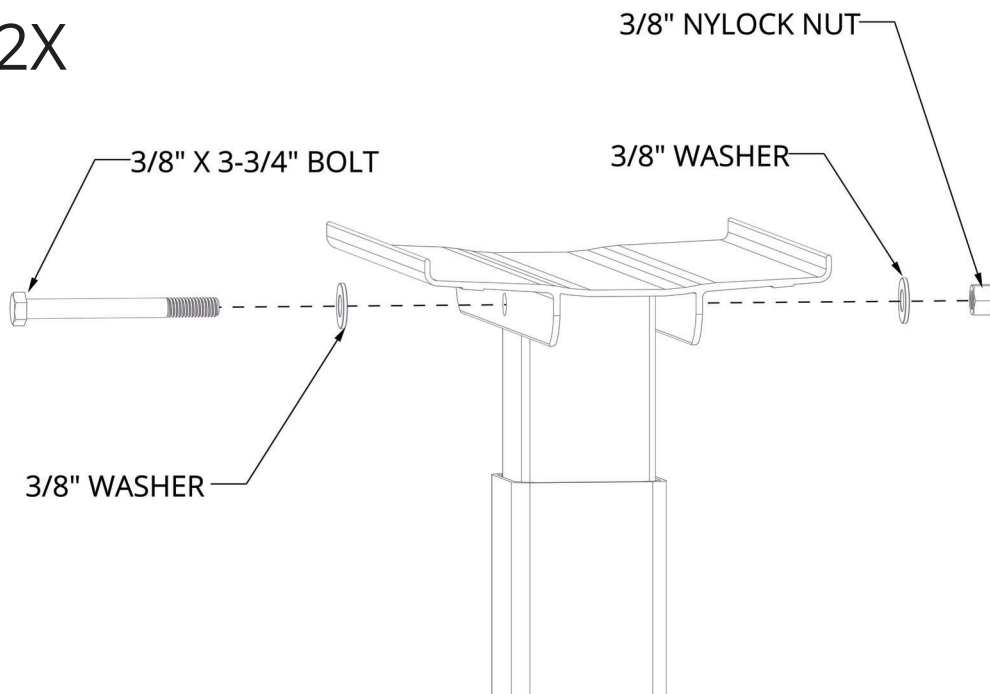
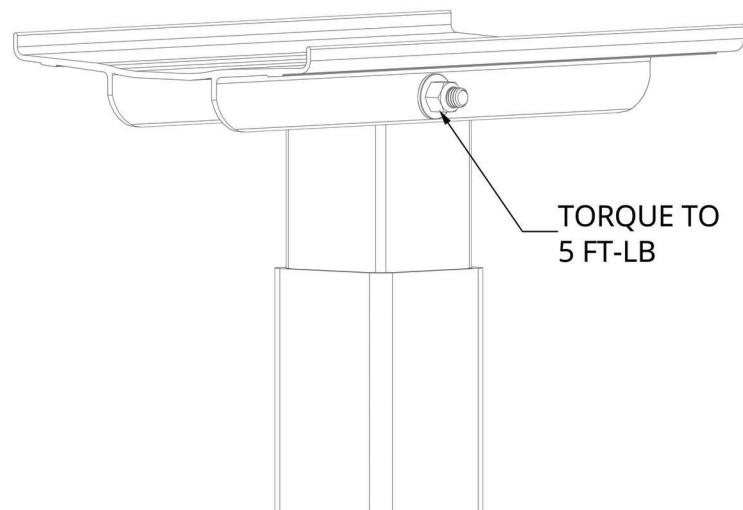
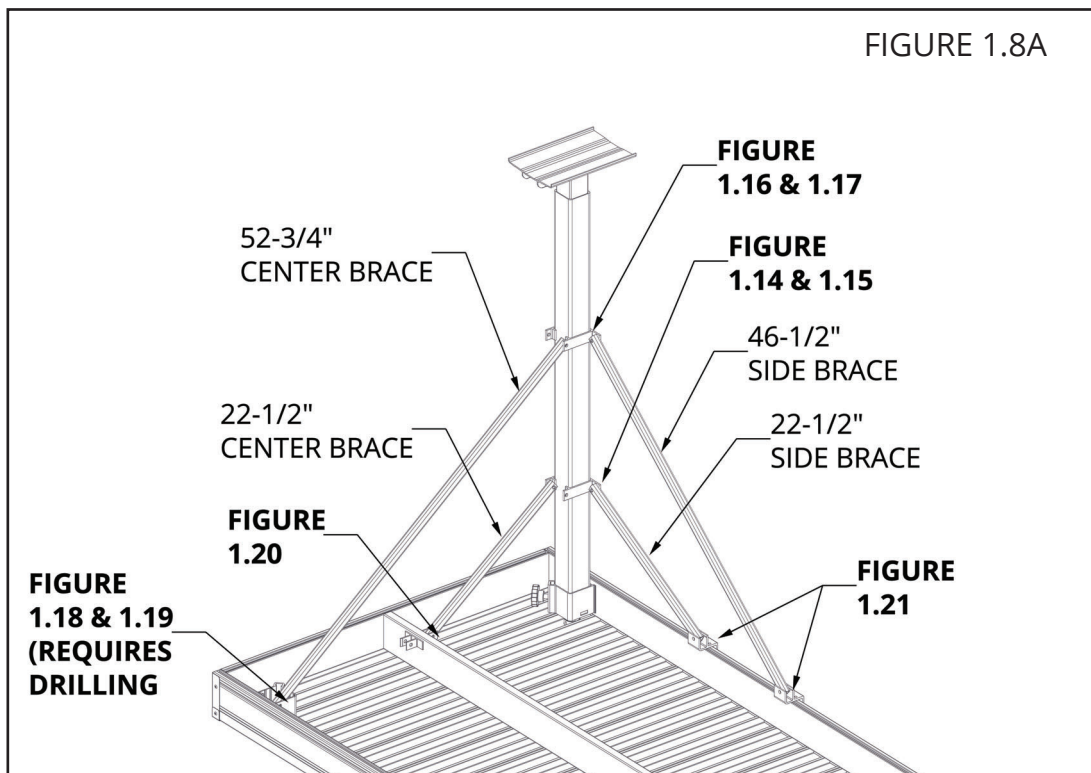
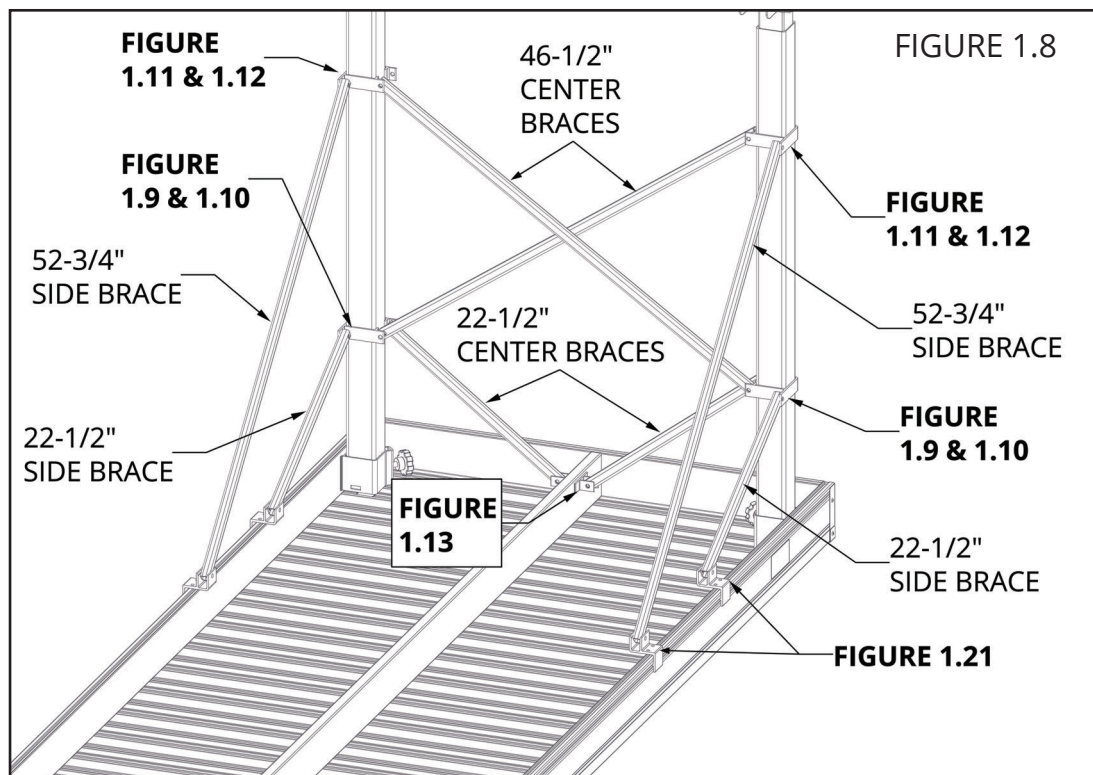


FIGURE 1.7

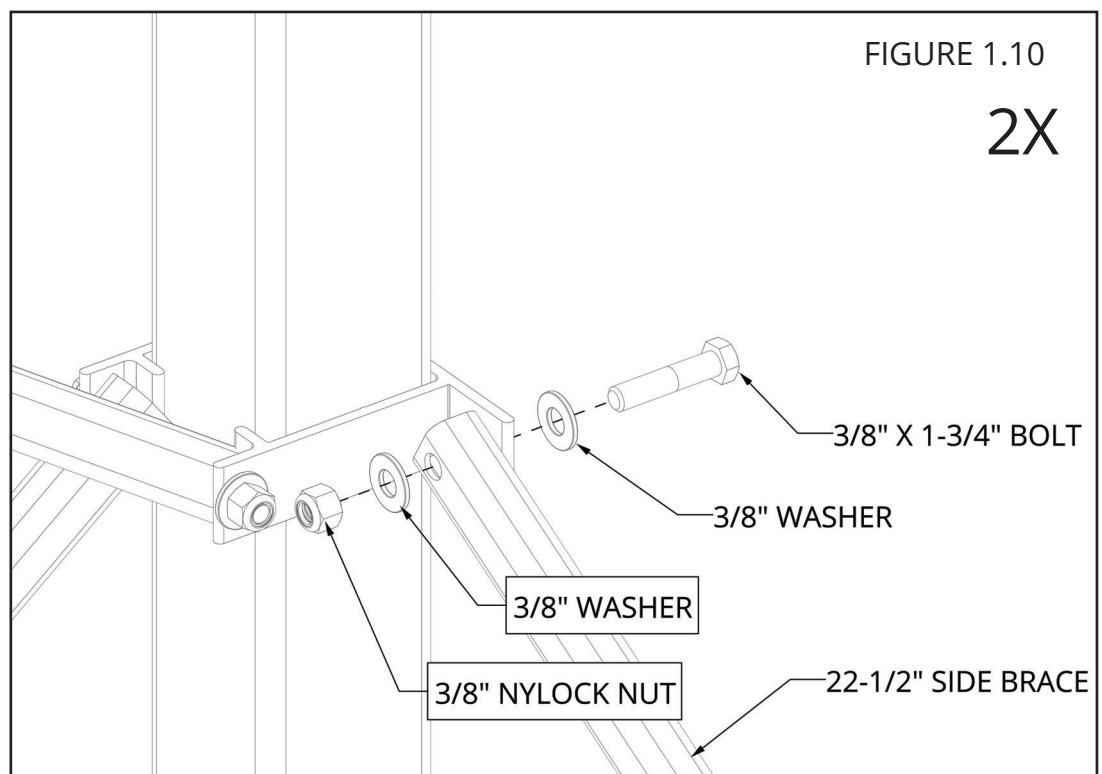
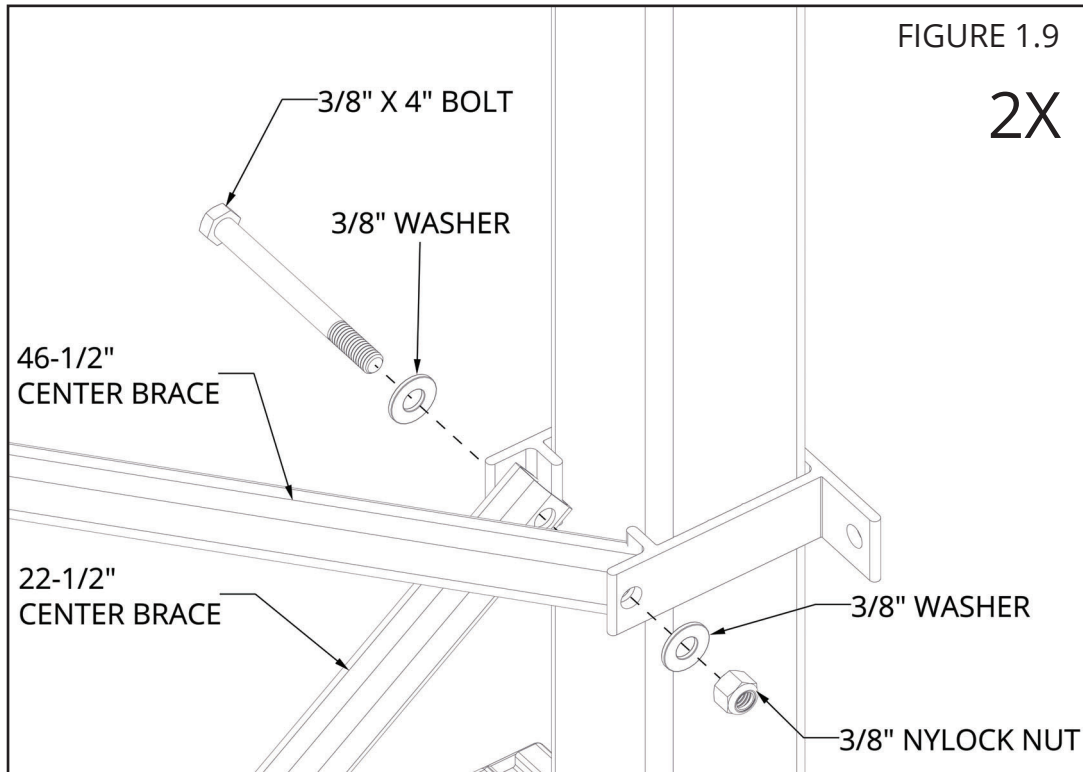
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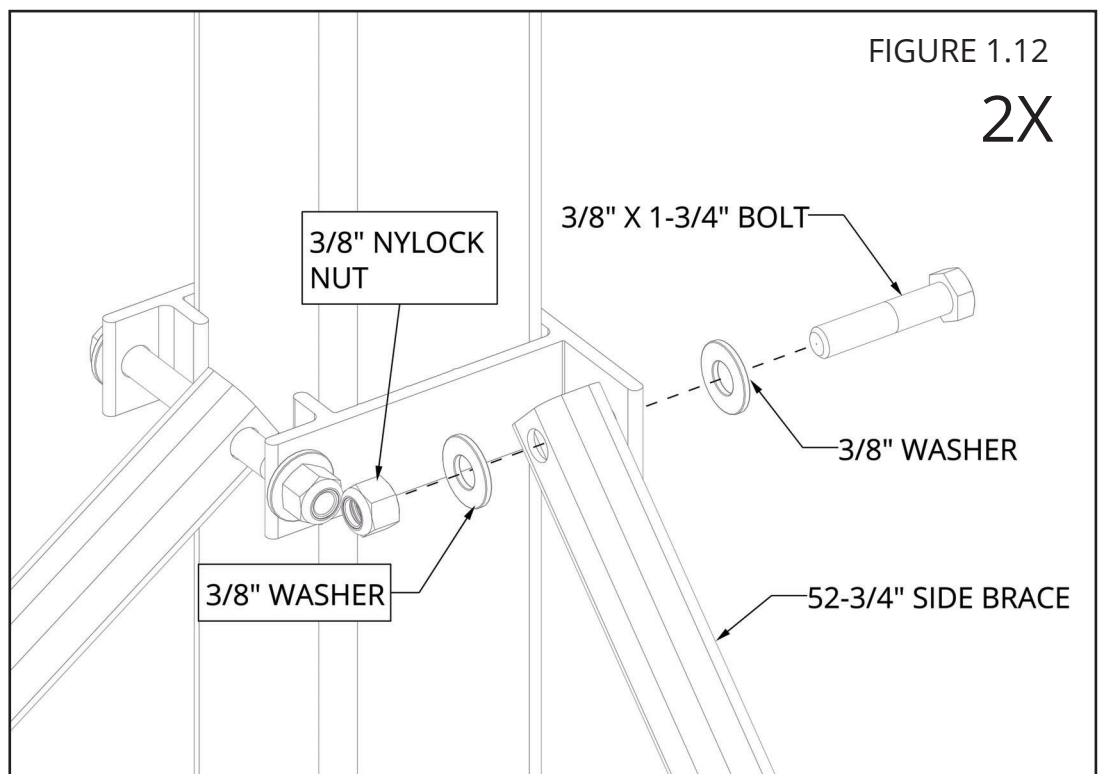
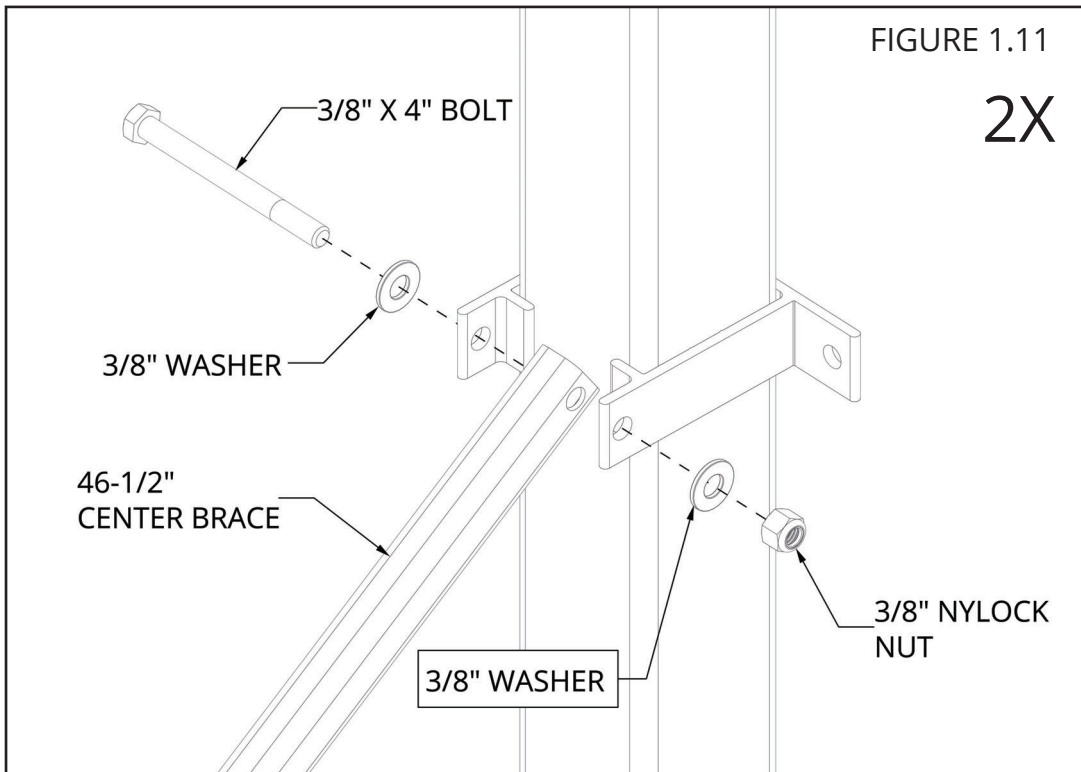
FOR BRACE PLACEMENT ON 4' WIDE DOCKS, REFER TO FIGURES 1.8 (LEGS AT THE END OF THE DOCK, FIGURES 1.9-1.13 & 1.21) AND 1.8A (LEGS ALONG THE LONG SIDE OF THE DOCK, FIGURES 1.14-1.17, 1.20, & 1.21). **FOR 6' WIDE DOCKS, SKIP TO STEP 2 (PAGE 20). NOTE: PARTS AND FASTENERS FROM THE SECTIONAL DOCK LEG KIT WILL BE USED FOR INSTALLATION IN ADDITION TO THE PARTS AND FASTENERS INCLUDED WITH THIS KIT.**



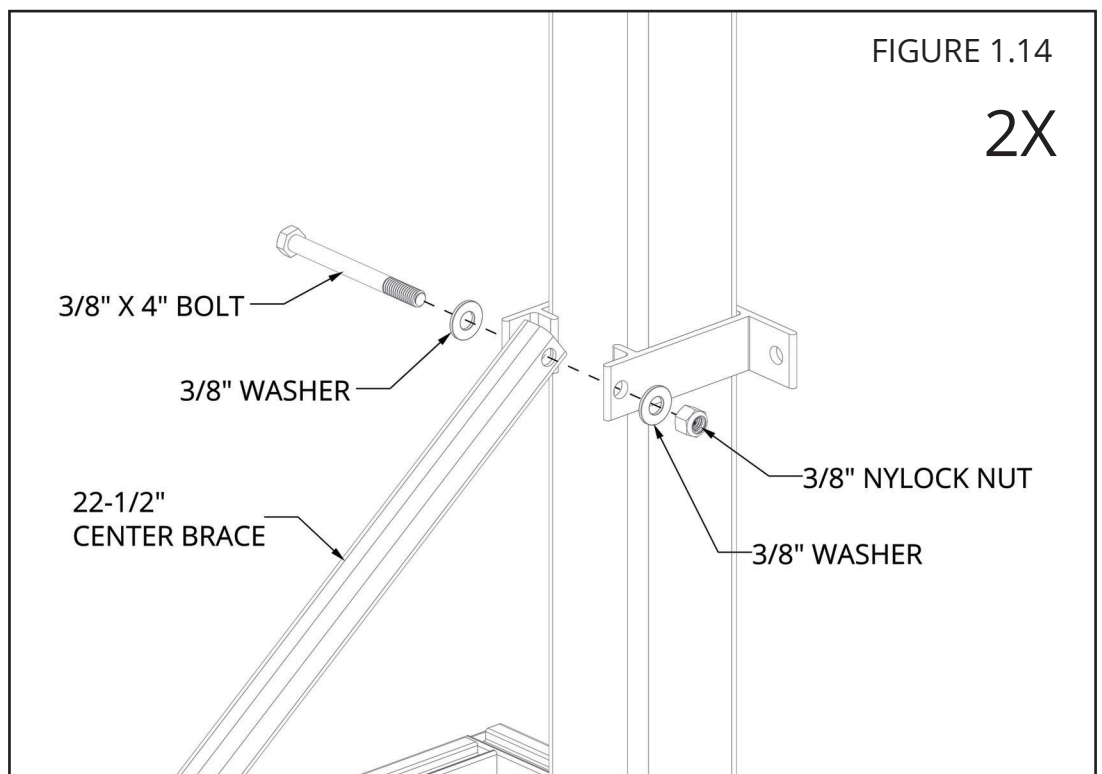
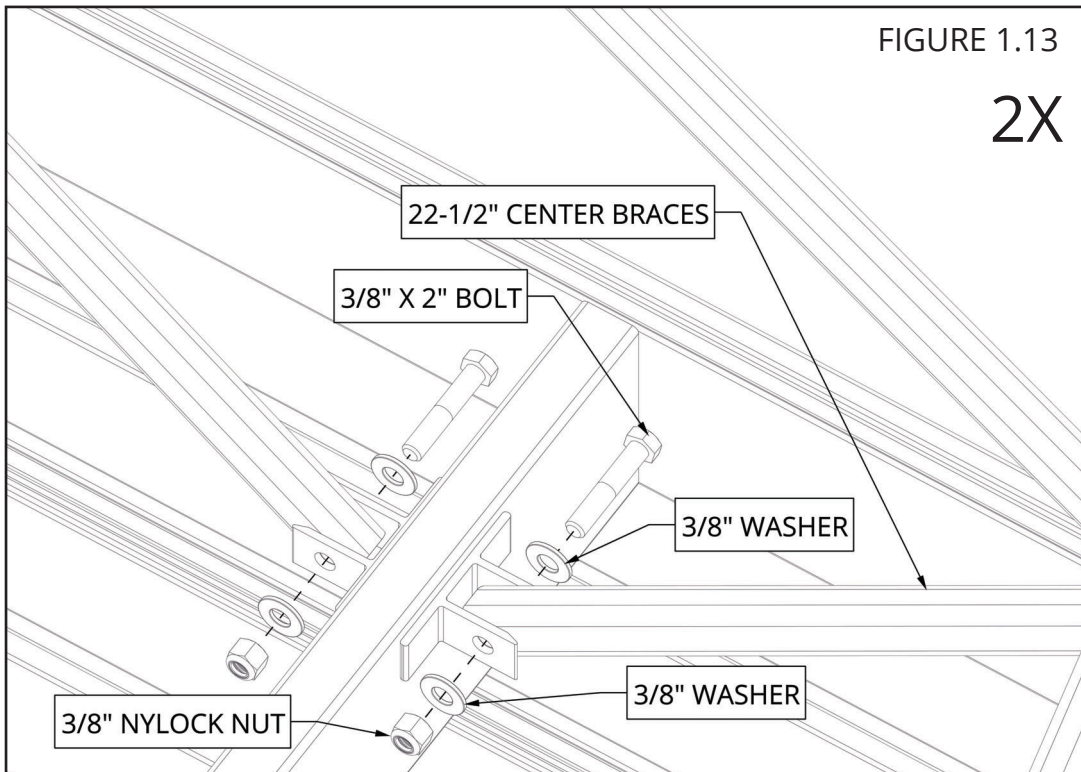
ATTACH THE 22-1/2" AND 46-1/2" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.9). ATTACH THE 22-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.10).



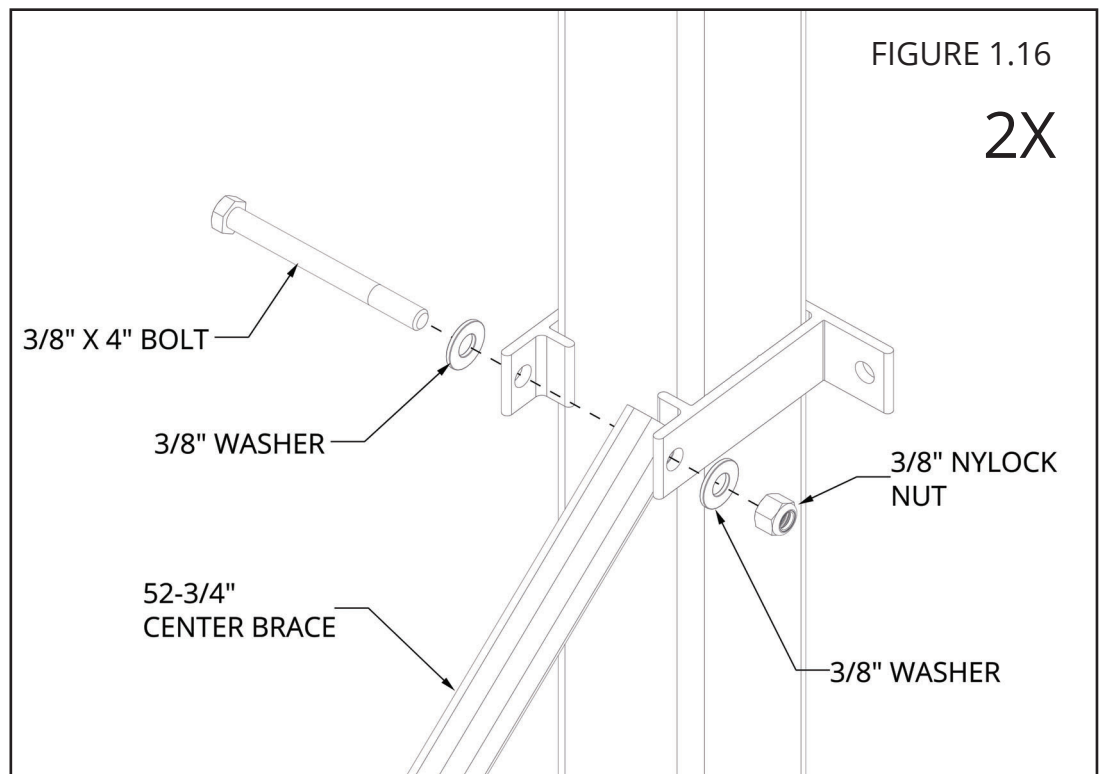
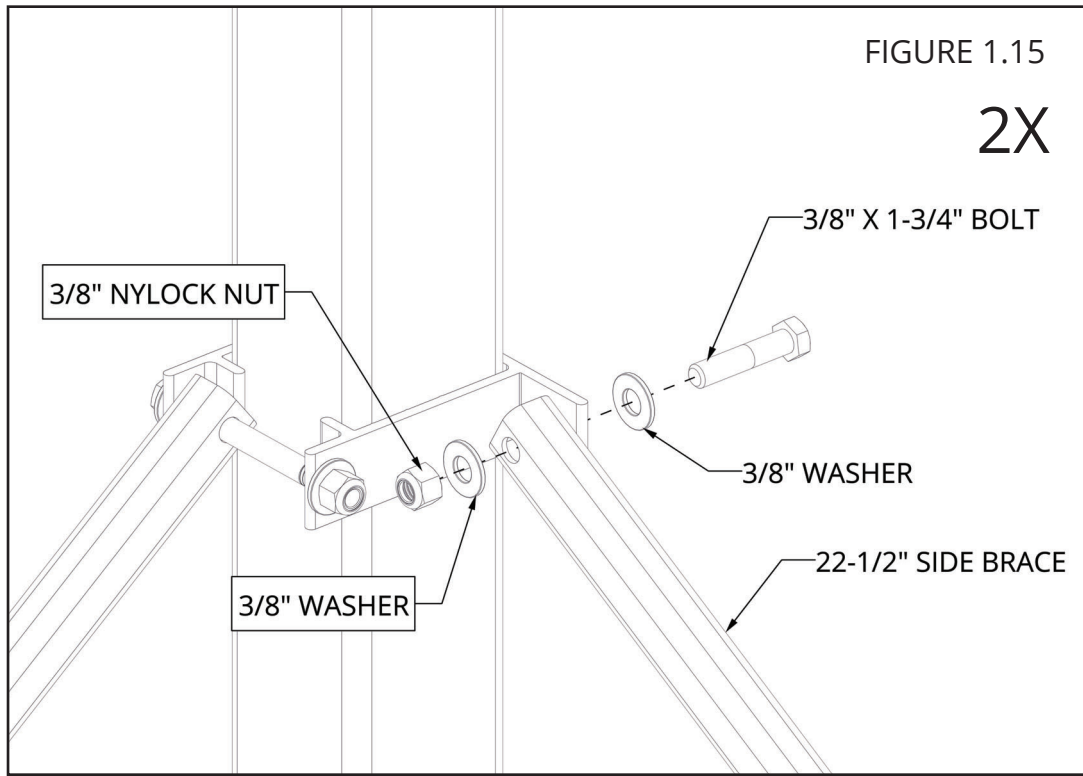
ATTACH THE OTHER END OF THE 46-1/2" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.11). ATTACH THE 52-3/4" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.12).



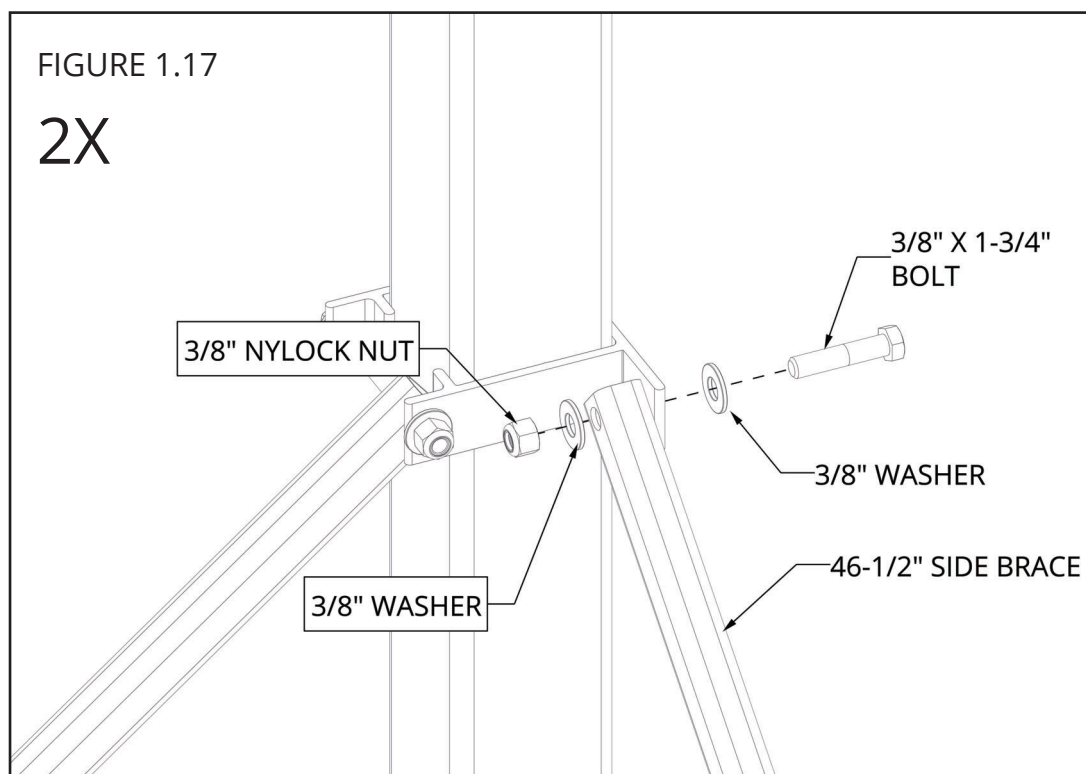
ATTACH THE 22-1/2" CENTER BRACES TO THE BRACKETS WELDED ON THE DOCK USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE (FIGURE 1.13). ATTACH THE 22-1/2" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.14).



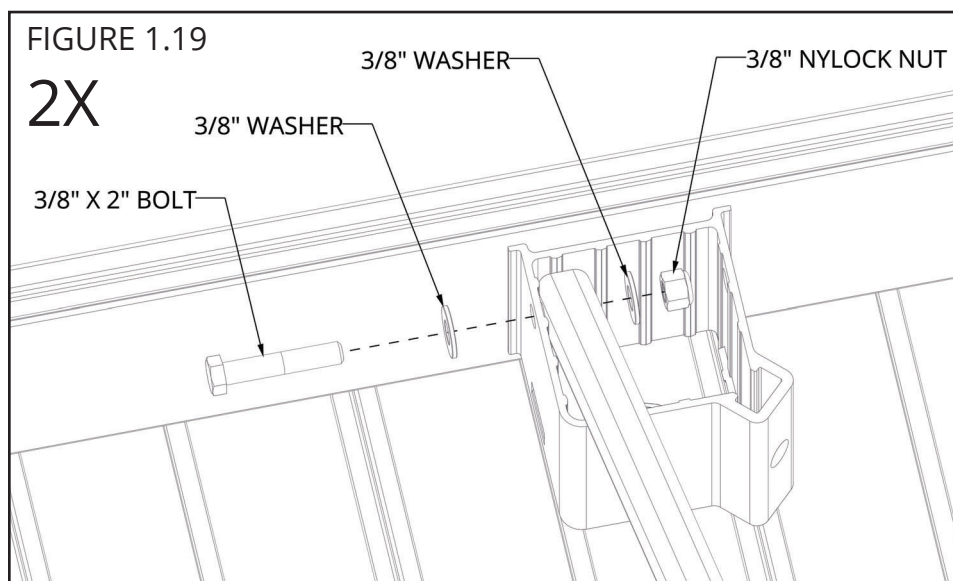
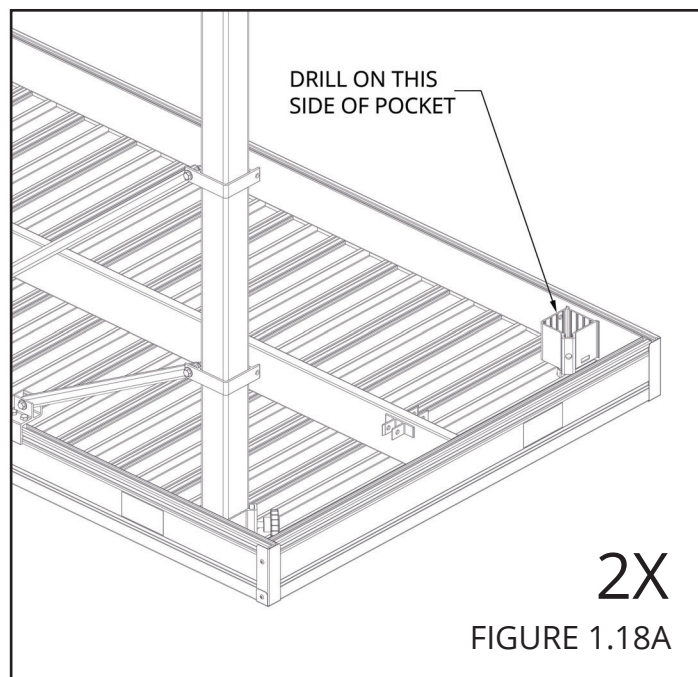
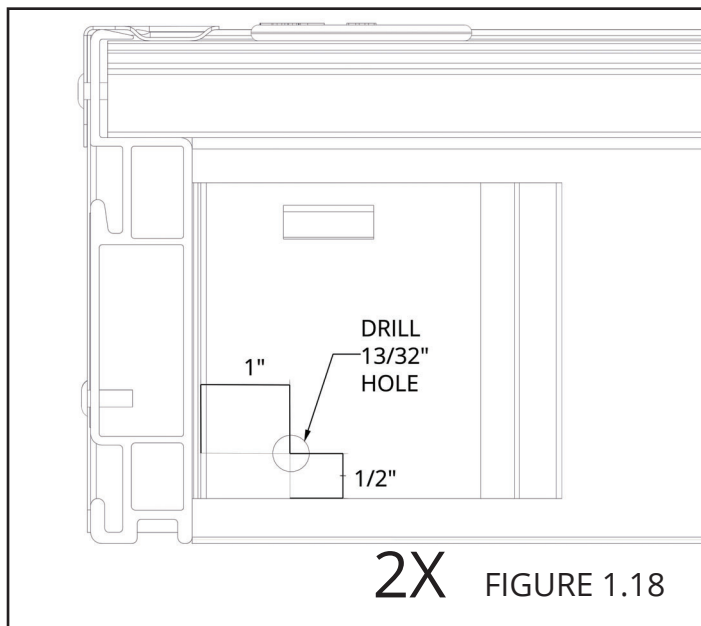
ATTACH THE 22-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.15). ATTACH THE 52-3/4" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.16).



ATTACH THE 46-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 1.17).



DRILL A HOLE INTO THE LEG POCKET ON THE OPPOSITE SIDE OF THE DOCK USING A 13/32" DRILL BIT AS SHOWN (FIGURE 1.18 & 1.18A). ATTACH THE END OF THE 52-3/4" BRACE USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT (FIGURE 1.18).



ATTACH THE 22-1/2" CENTER BRACES TO THE BRACKETS WELDED ON THE DOCK USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE (FIGURE 1.20). ATTACH THE SIDE BRACES TO THE DOCK SIDE BRACE BRACKETS USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT (FIGURE 1.21).

FIGURE 1.20

2X

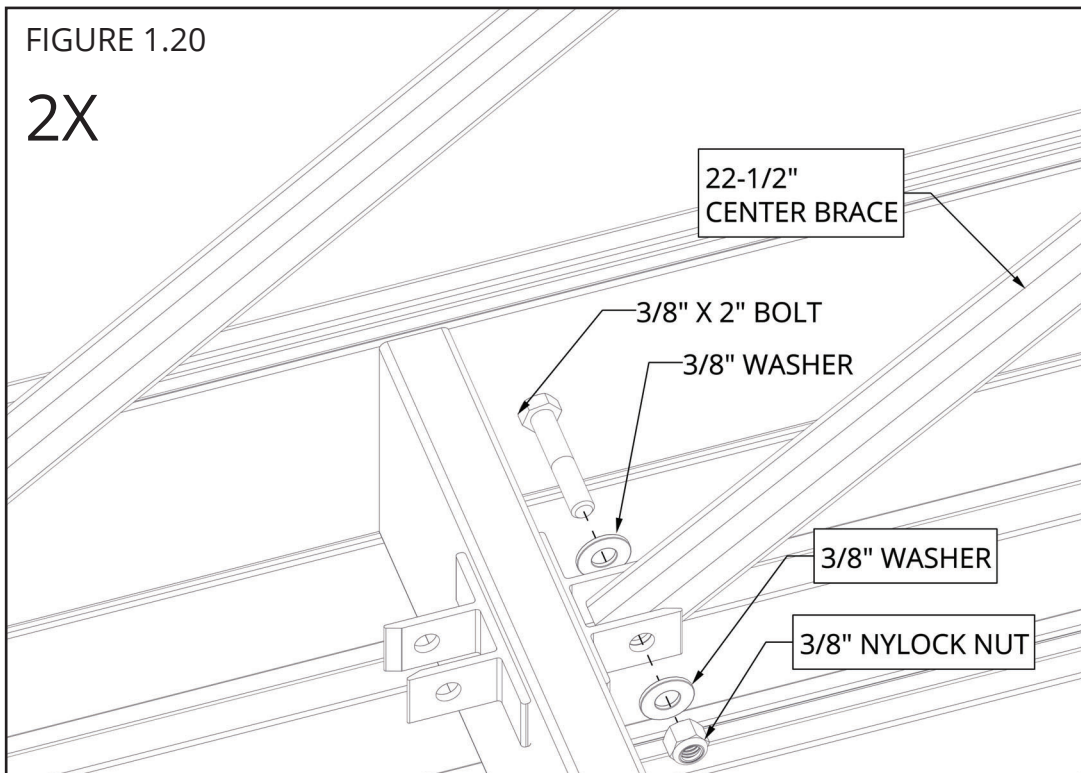
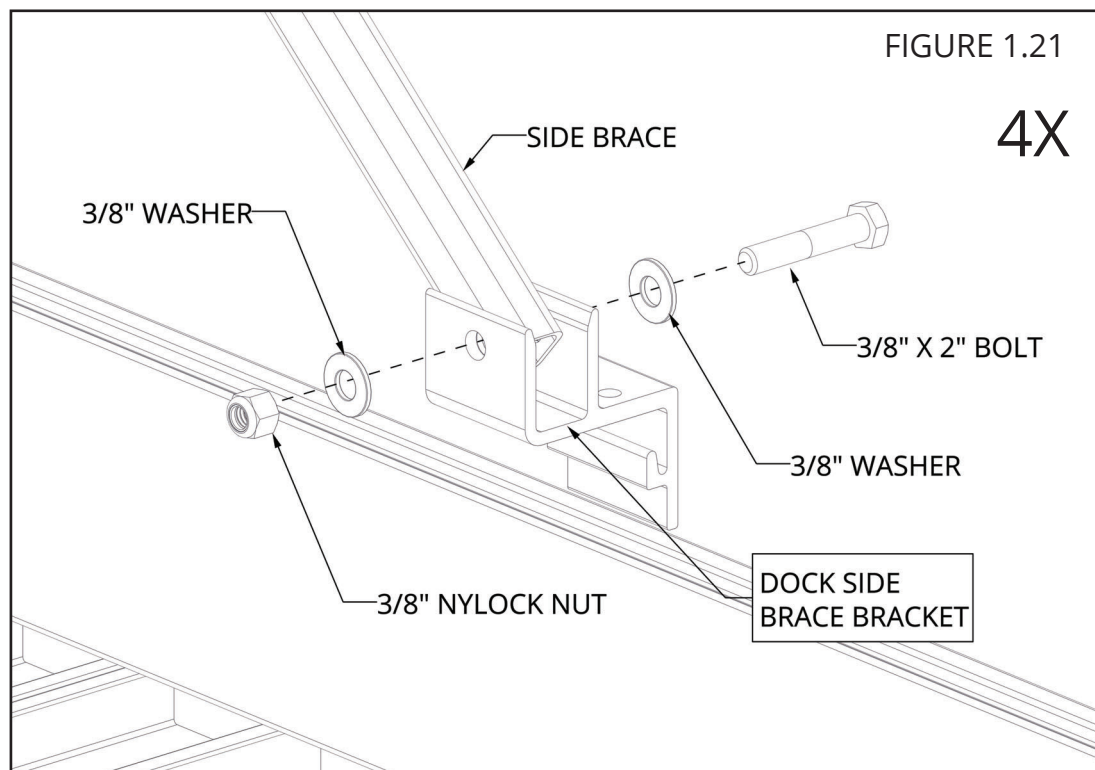
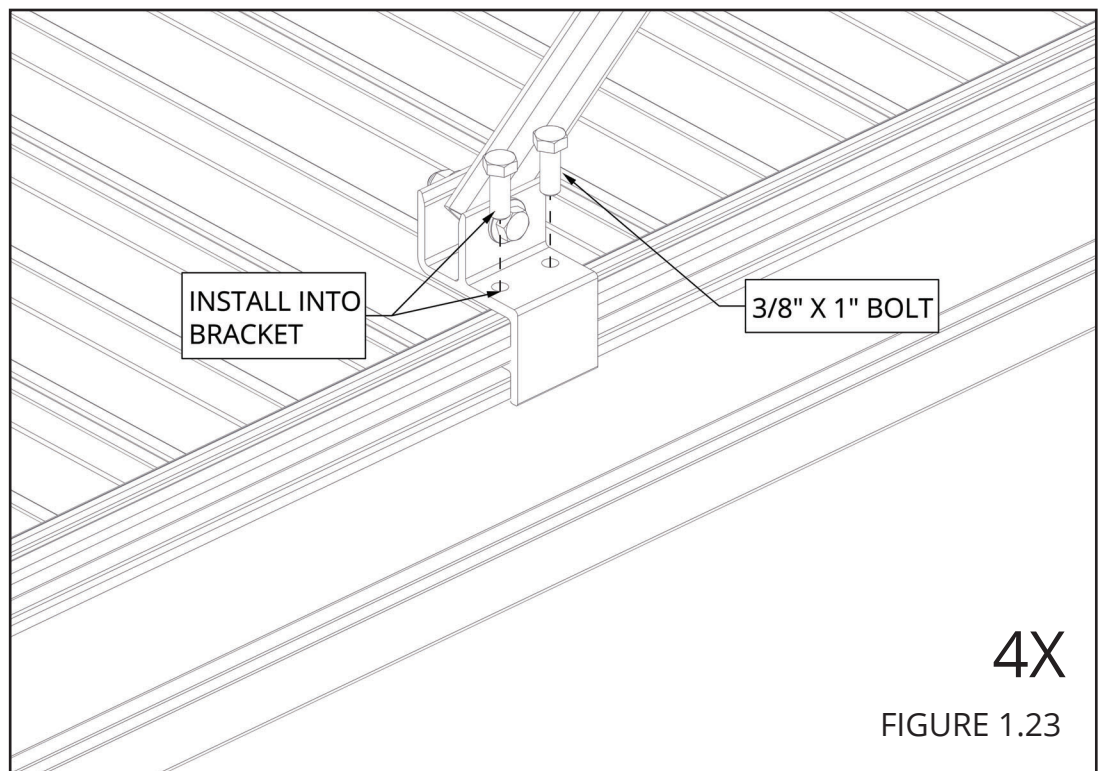
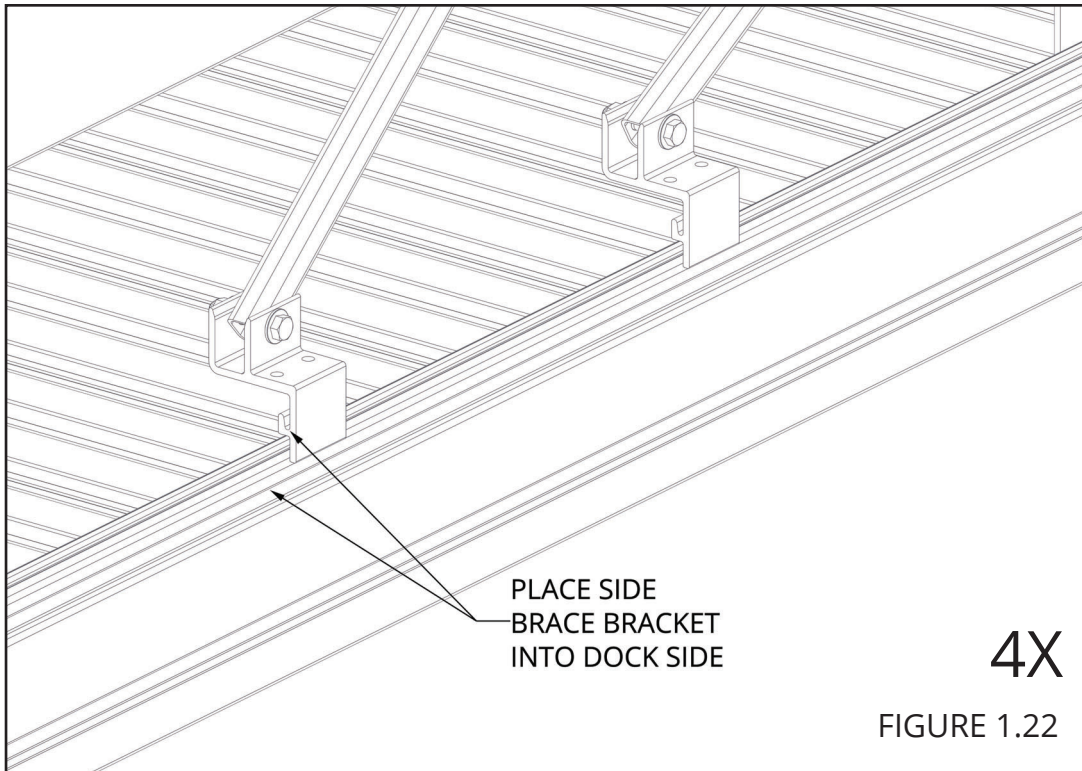


FIGURE 1.21

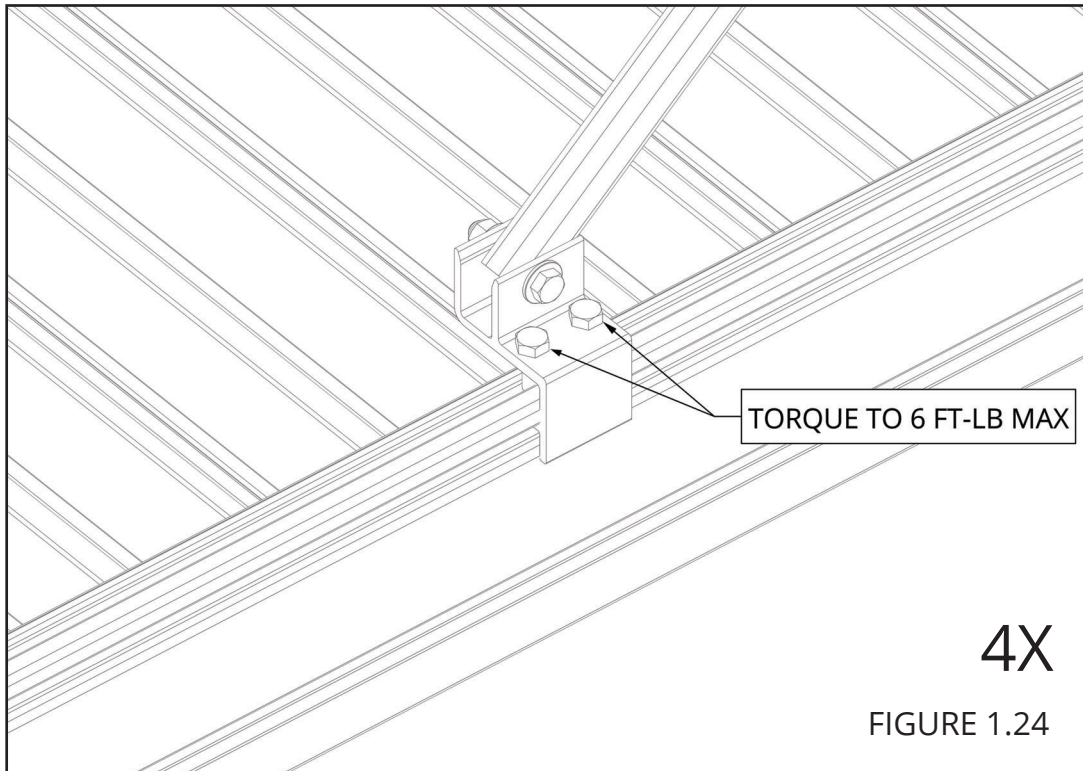
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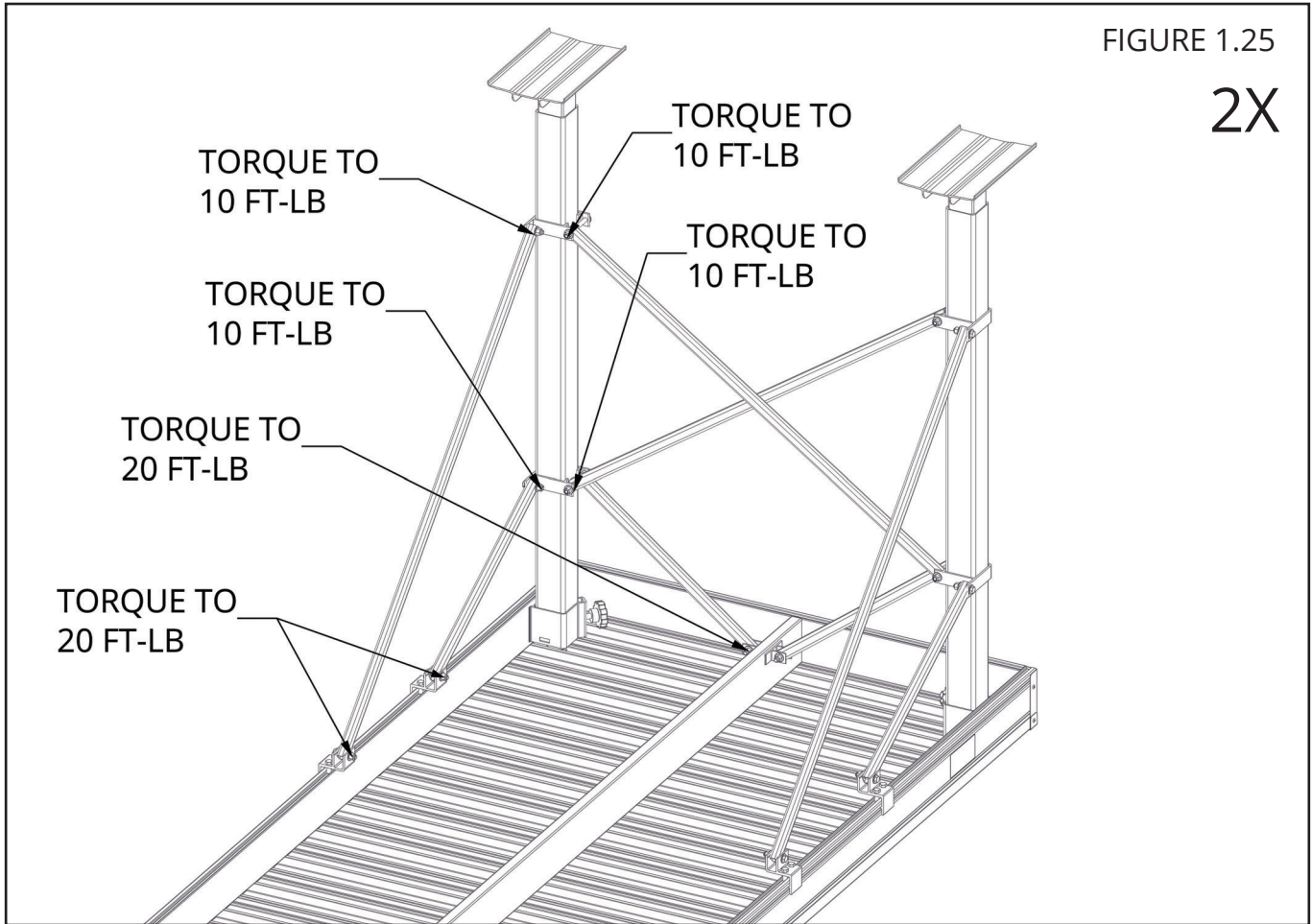
PLACE EACH SIDE BRACE BRACKET INTO THE DOCK SIDE (FIGURE 1.22). INSTALL (2) 3/8" X 1" BOLTS INTO THE BOTTOM OF EACH DOCK SIDE BRACE BRACKET (FIGURE 1.23).



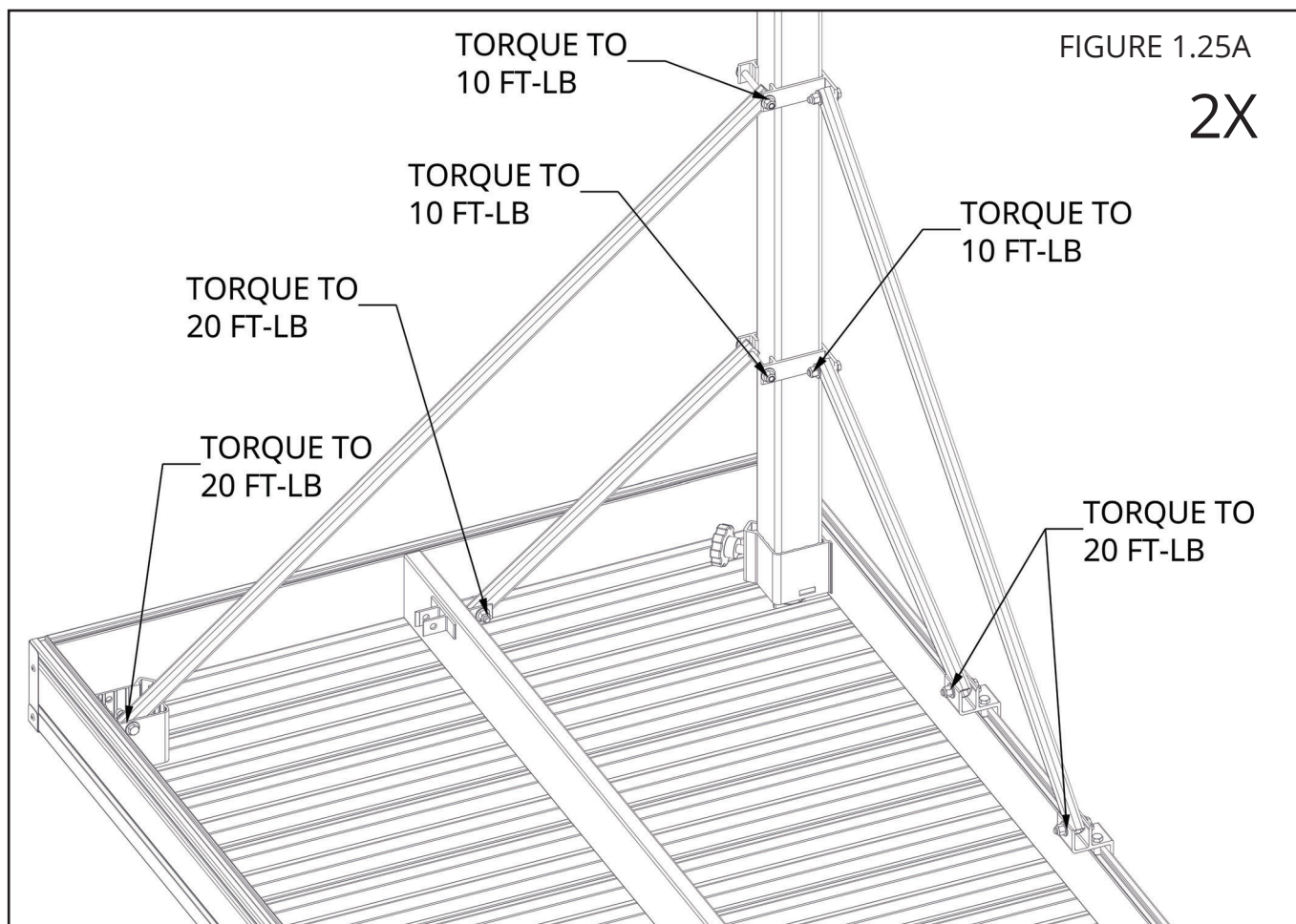
TORQUE BOLTS TO 6 FT-LB MAXIMUM (FIGURE 1.24).



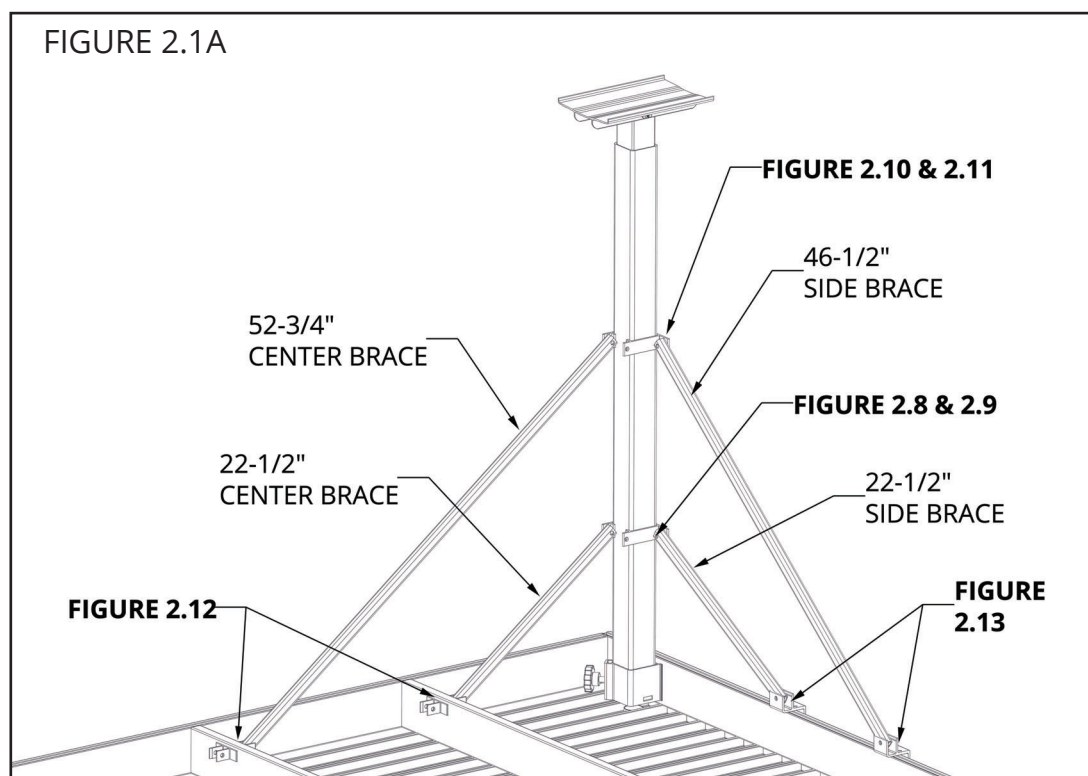
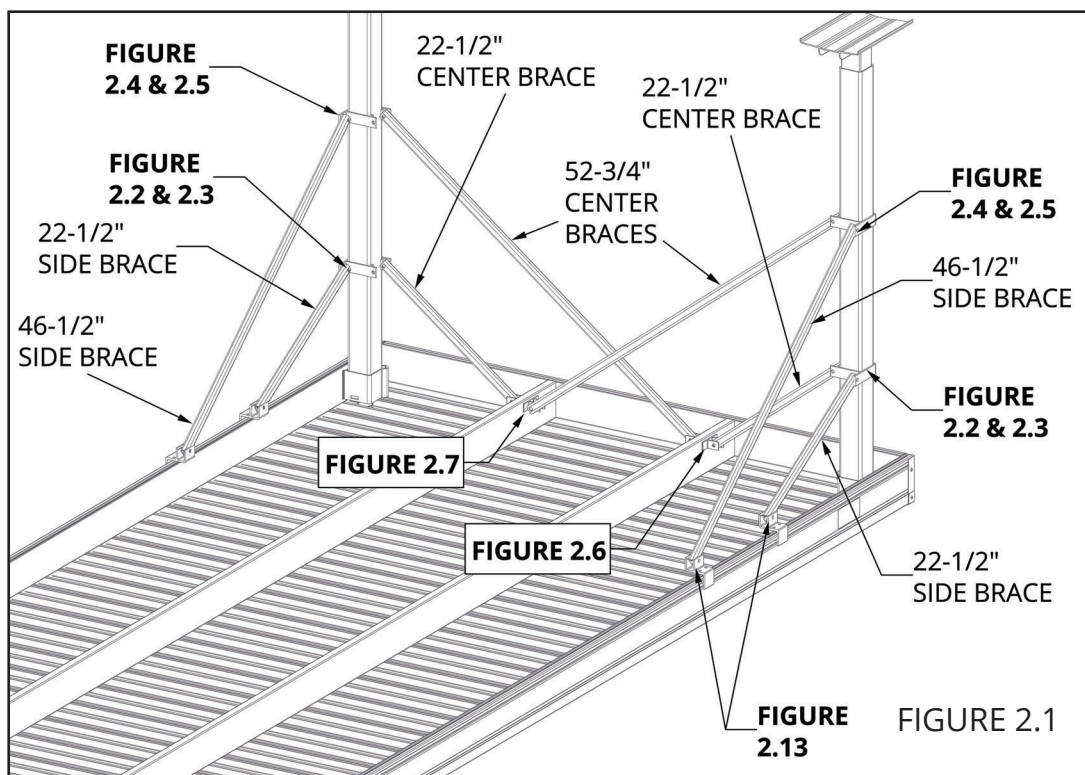
TORQUE ALL FASTENERS TO THE SPECIFICATIONS SHOWN. **IMPORTANT: OVERTIGHTENING WILL CRUSH THE BRACES** (FIGURE 1.25).



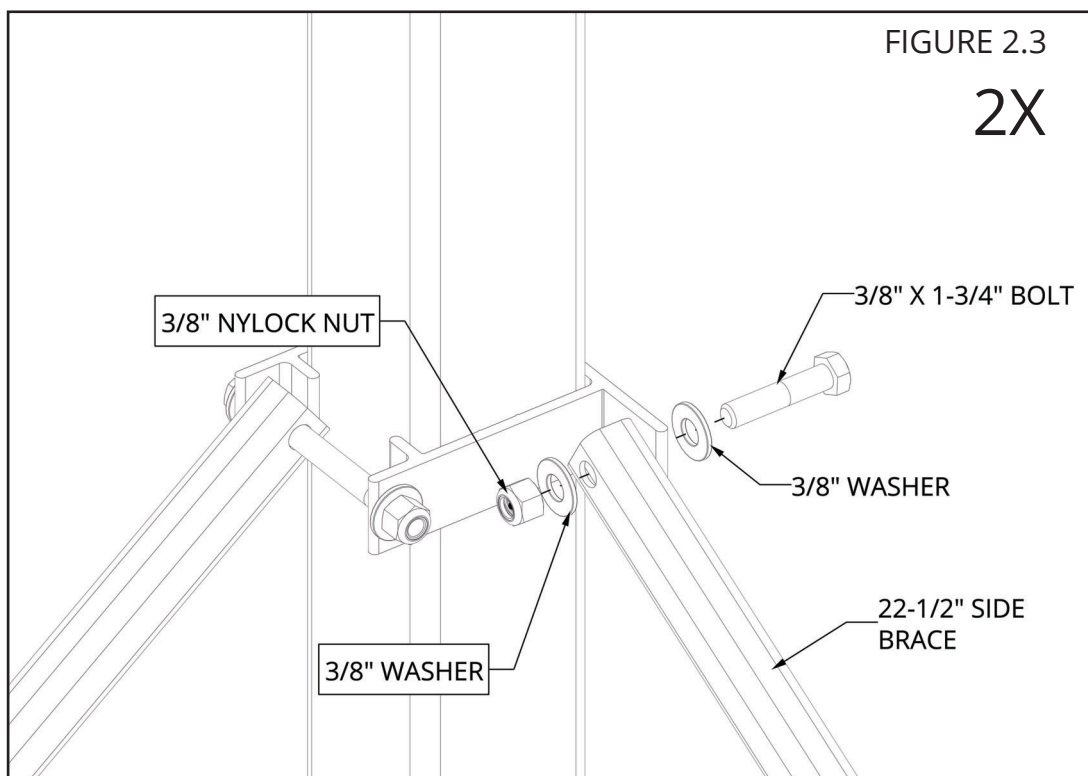
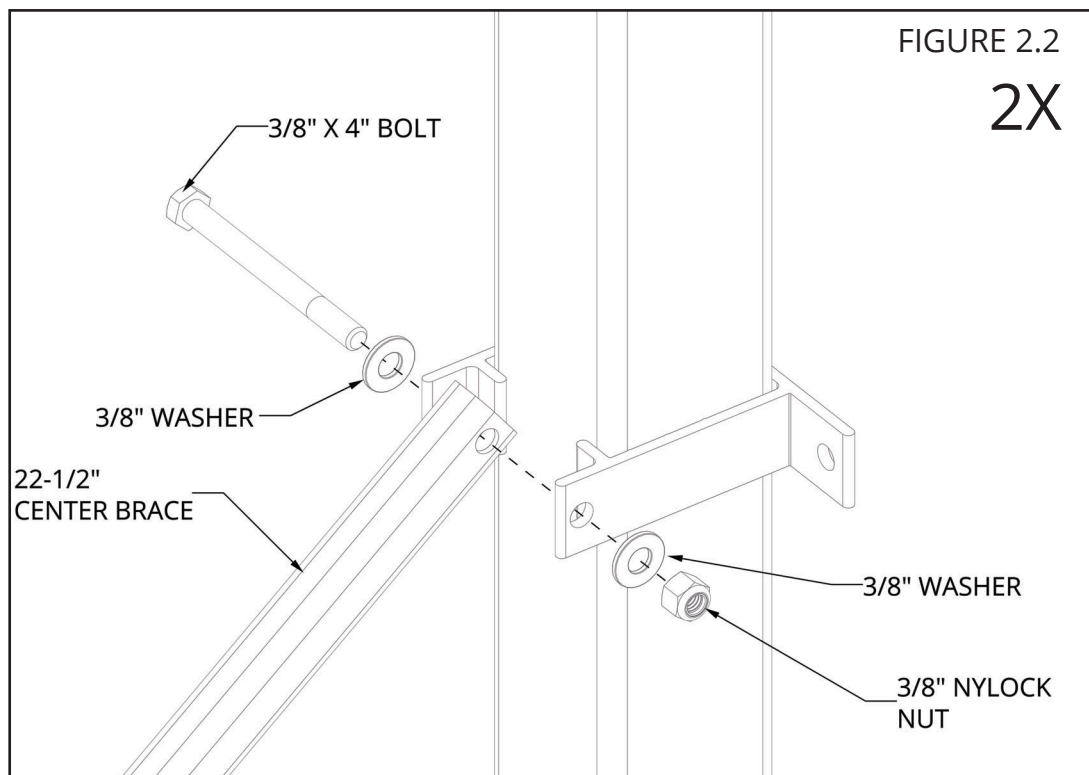
TORQUE ALL FASTENERS TO THE SPECIFICATIONS SHOWN. **IMPORTANT: OVERTIGHTENING WILL CRUSH THE BRACES** (FIGURE 1.25A).



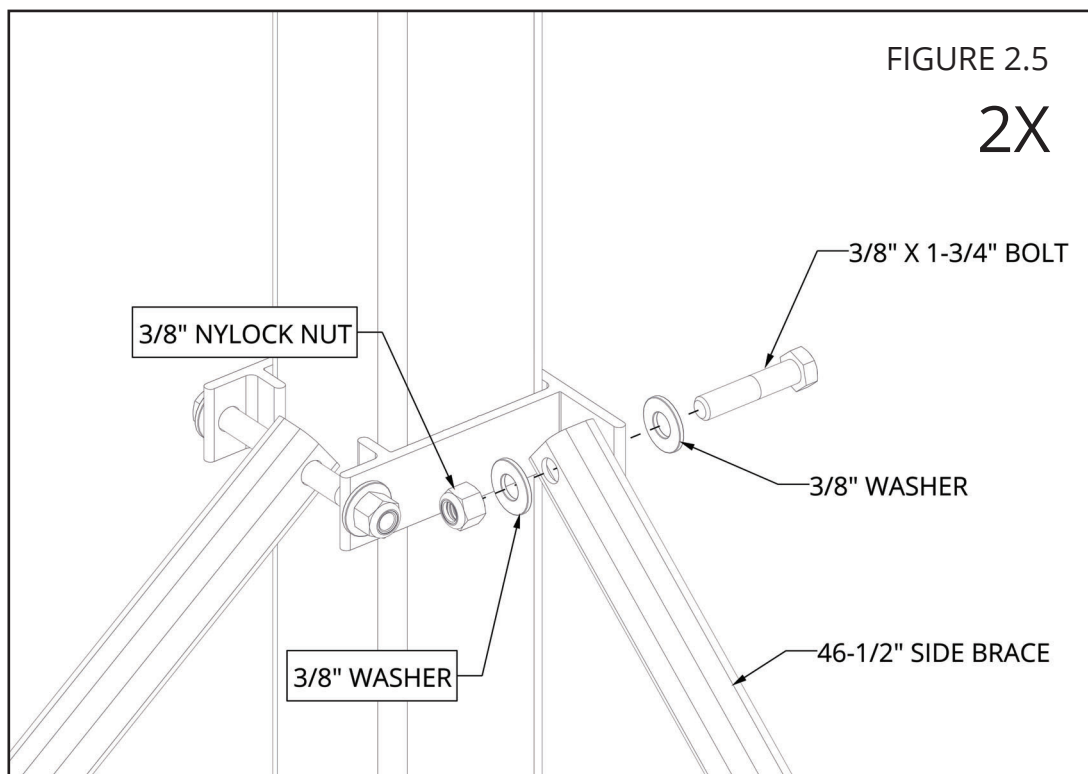
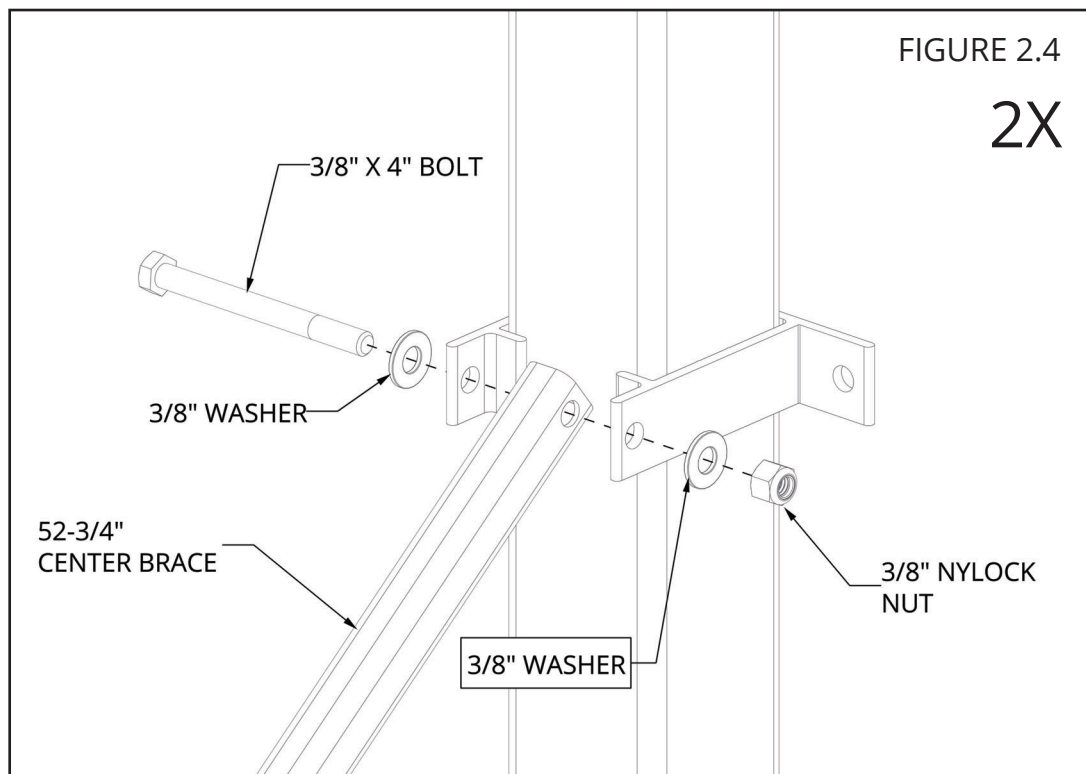
FOR BRACE PLACEMENT ON 6' WIDE DOCKS, REFER TO FIGURES 2.1 (LEGS AT THE END OF THE DOCK, FIGURES 2.2-2.7, 2.13) AND 2.1A (LEGS ALONG THE LONG SIDE OF THE DOCK, FIGURES 2.8-2.13). **NOTE: PARTS AND FASTENERS FROM THE SECTIONAL DOCK LEG KIT WILL BE USED FOR INSTALLATION IN ADDITION TO THE PARTS AND FASTENERS INCLUDED WITH THIS KIT.**



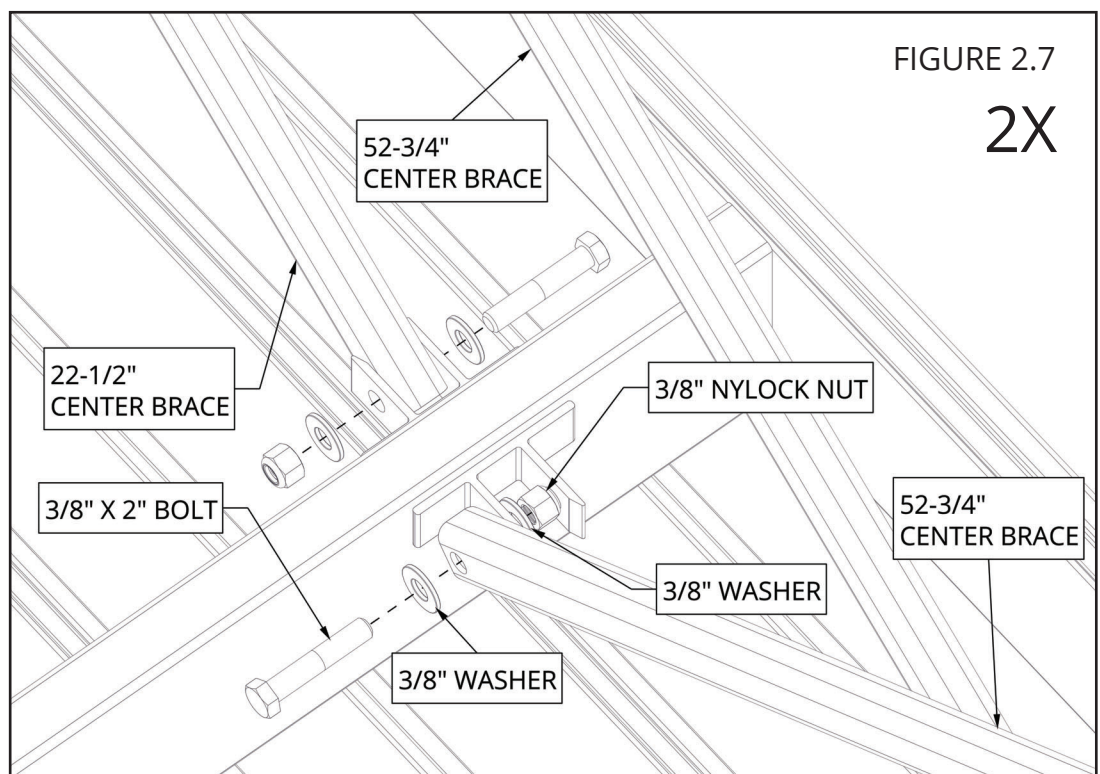
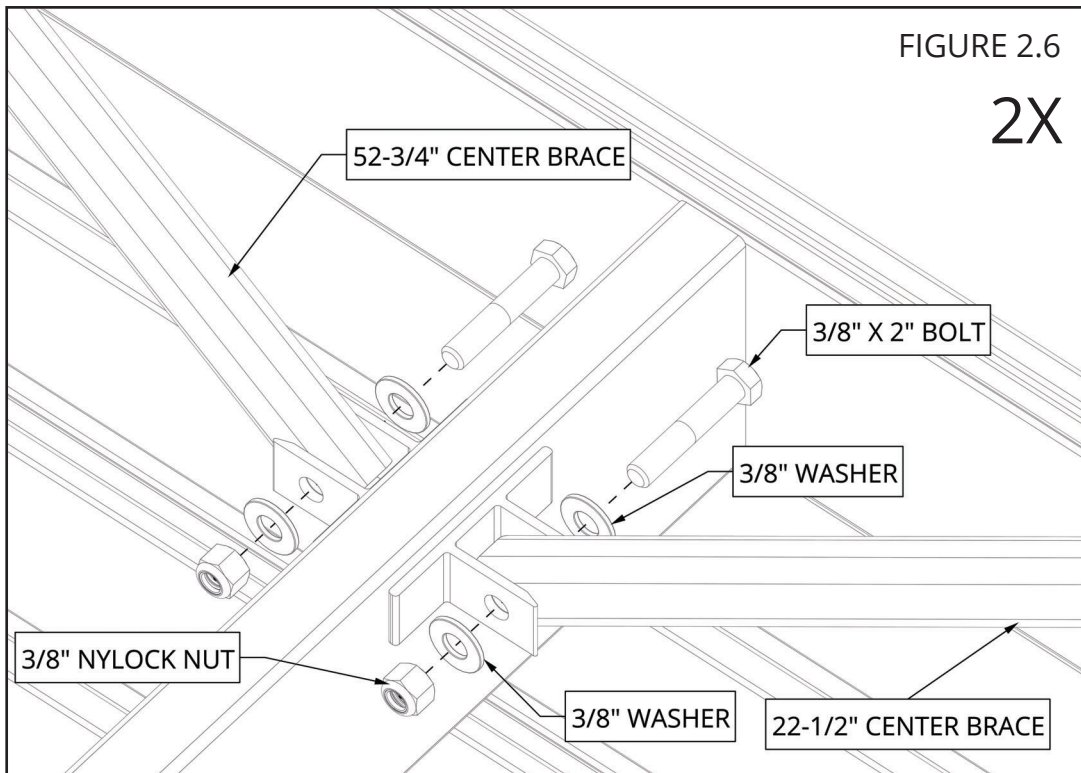
ATTACH THE 22-1/2" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.2). ATTACH THE 22-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.3).



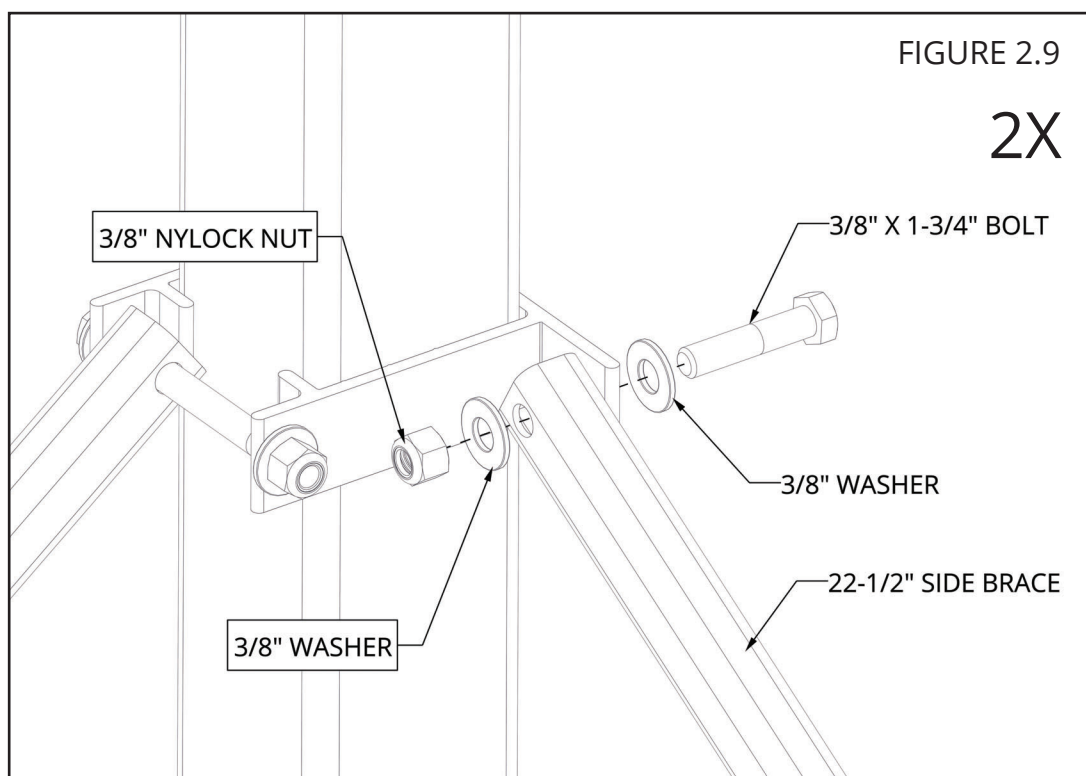
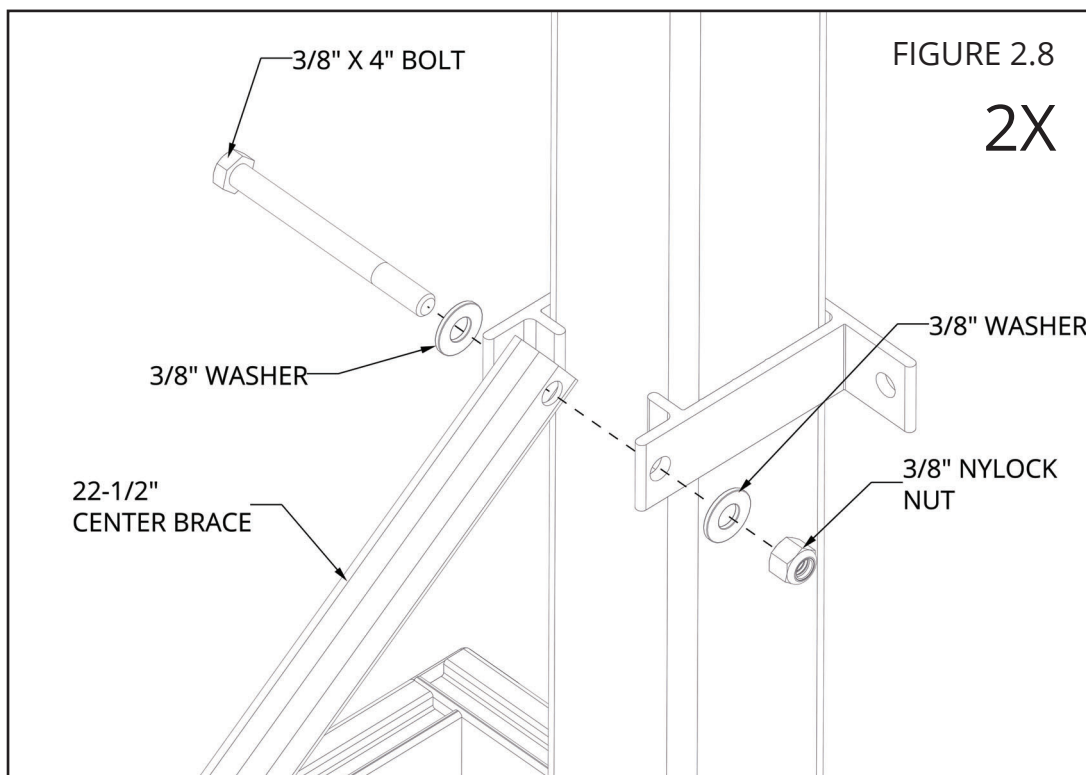
ATTACH THE 52-3/4" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.4). ATTACH THE 46-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.5).



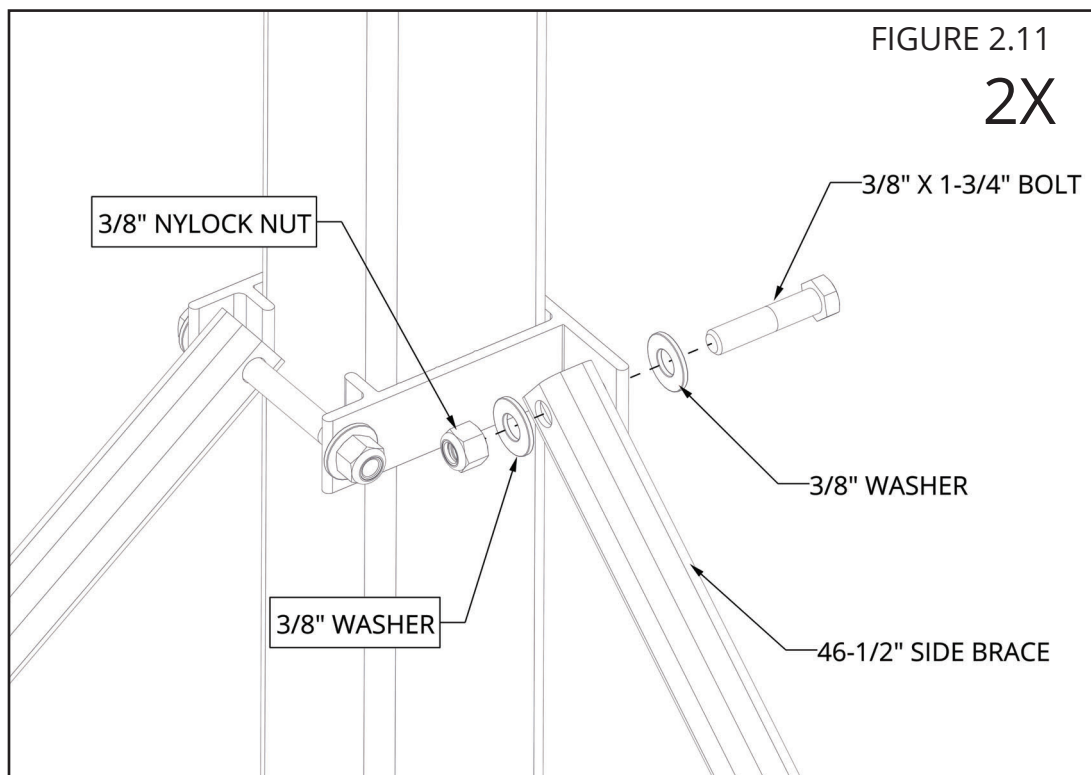
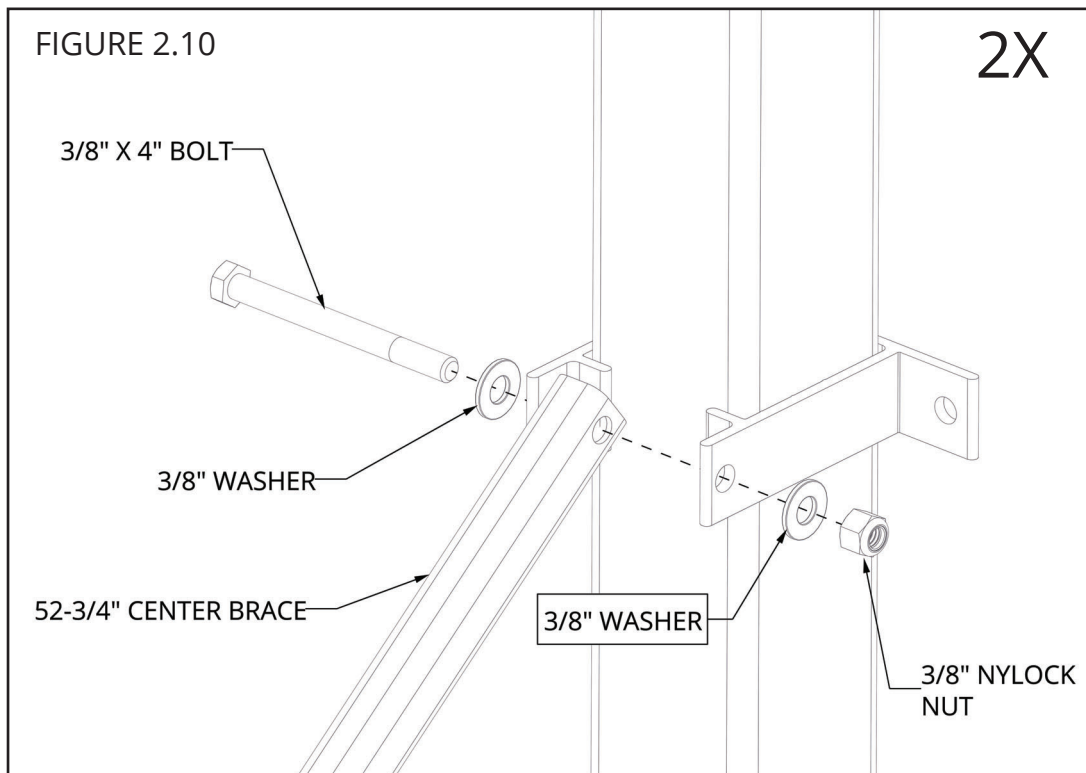
ATTACH THE 22-1/2" & 52-3/4" CENTER BRACES TO THE BRACKETS WELDED ON THE DOCK USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE (FIGURE 2.6). ATTACH THE 22-1/2" & 52-3/4" CENTER BRACES TO THE BRACKETS WELDED ON THE DOCK USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE. NOTE THE PLACEMENT OF THE 52-3/4" CENTER BRACE AND FASTENERS (FIGURE 2.7).



ATTACH THE 22-1/2" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.8). ATTACH THE 22-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.9).



ATTACH THE 52-3/4" CENTER BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.10). ATTACH THE 46-1/2" SIDE BRACES TO THE BRACE BRACKETS USING (1) 3/8" X 1-3/4" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE BRACKET (FIGURE 2.11).



ATTACH THE 22-1/2" & 52-3/4" CENTER BRACES TO THE BRACKETS WELDED ON THE DOCK USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT PER BRACE (FIGURE 2.12). ATTACH THE SIDE BRACES TO THE DOCK SIDE BRACE BRACKETS USING (1) 3/8" X 2" BOLT, (2) 3/8" WASHERS, AND (1) 3/8" NYLOCK NUT (FIGURE 2.13).

FIGURE 2.12

2X

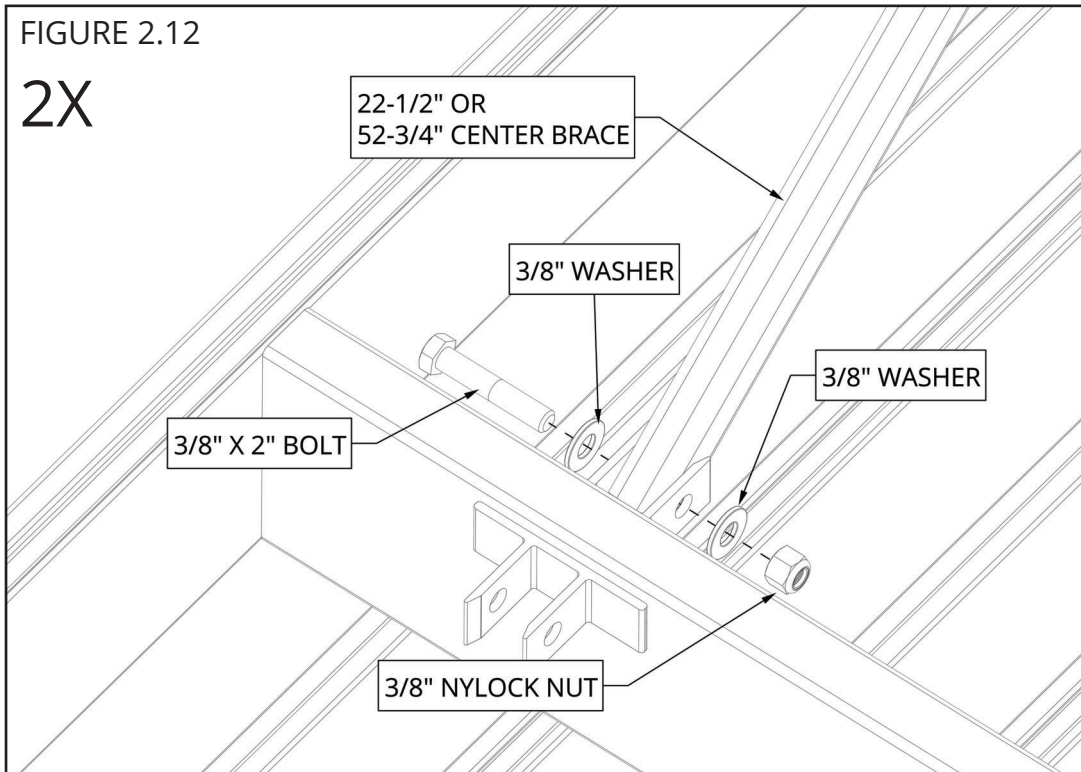
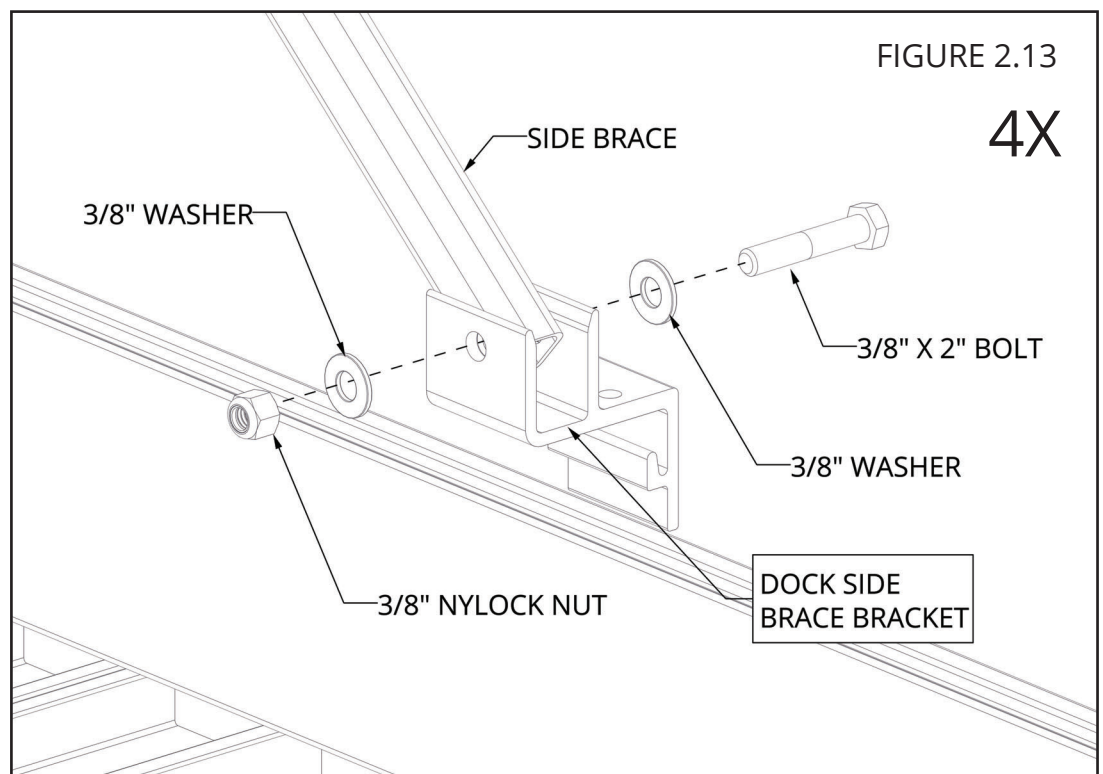
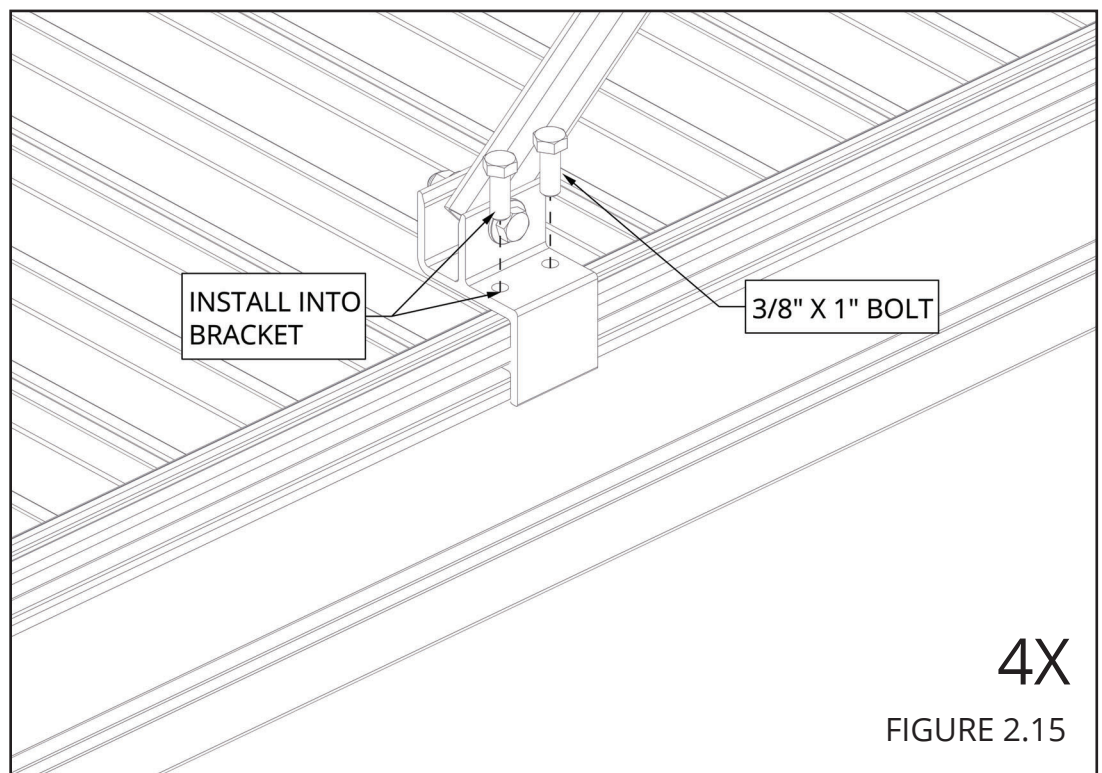
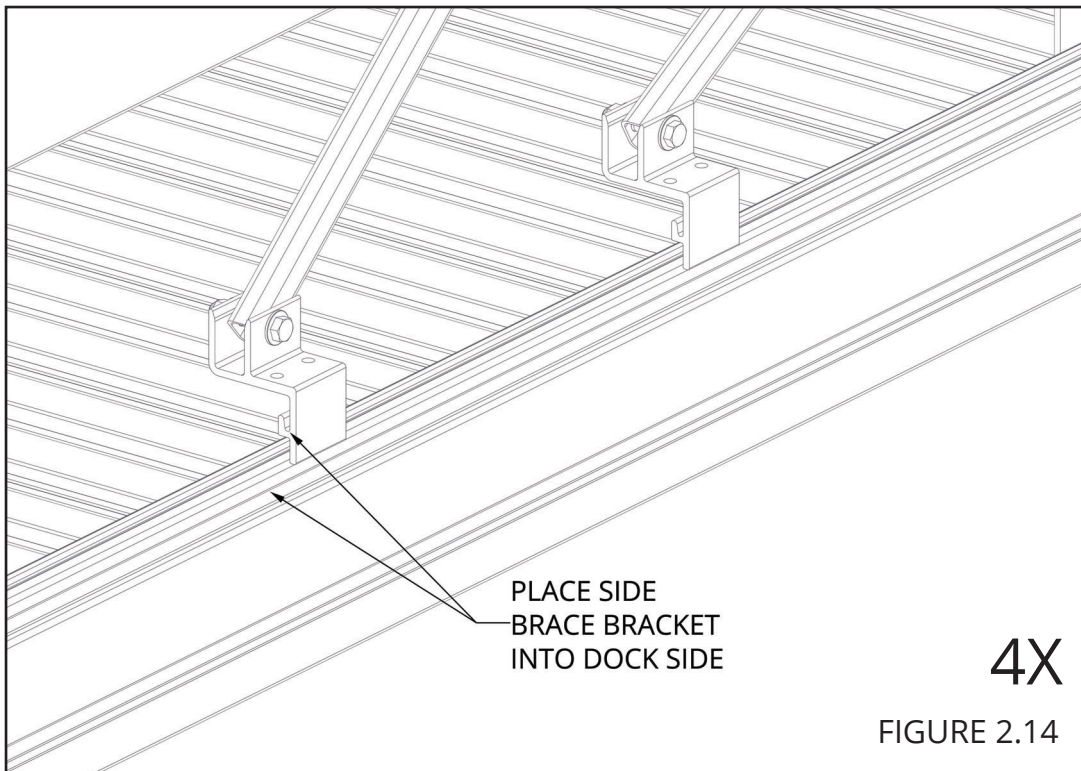


FIGURE 2.13

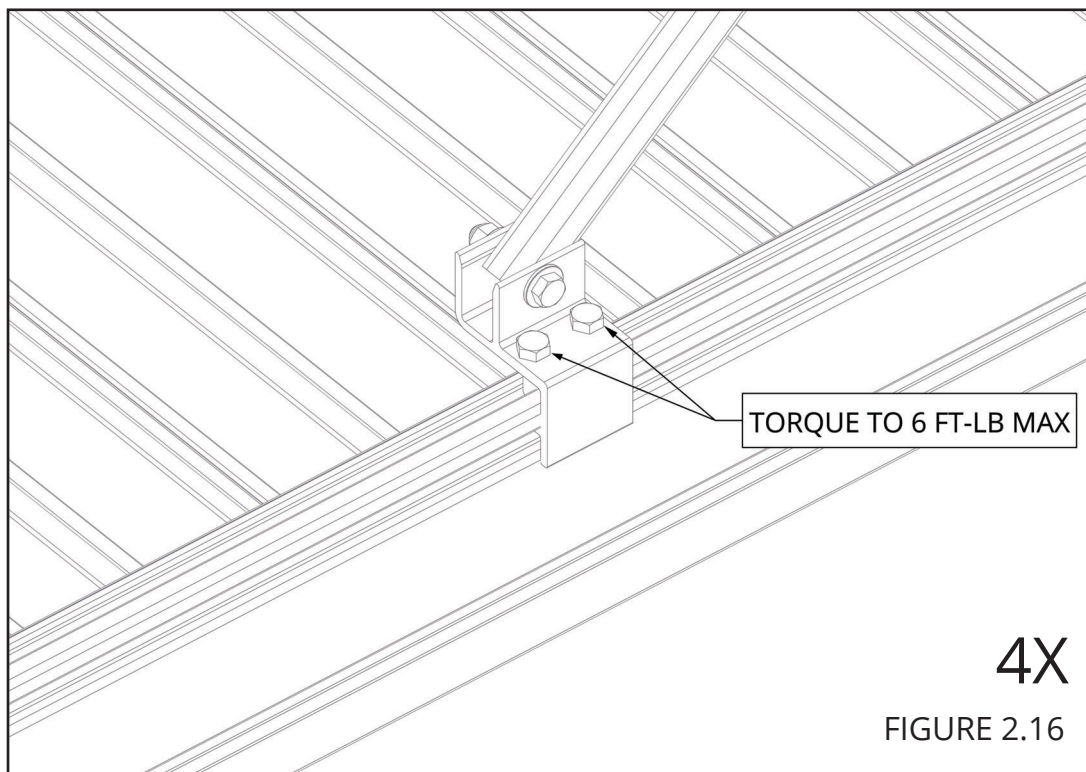
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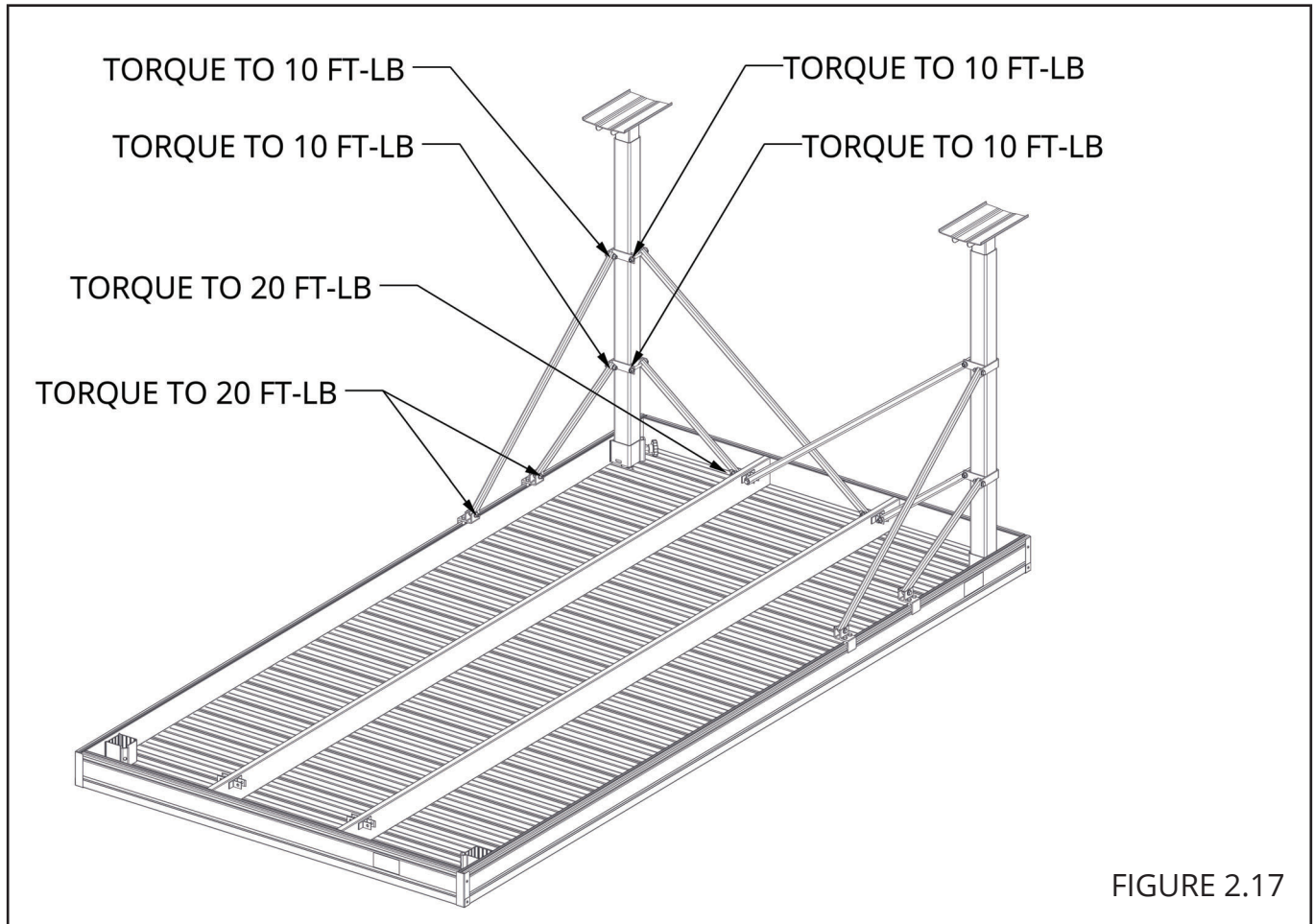
PLACE EACH SIDE BRACE BRACKET INTO THE DOCK SIDE (FIGURE 2.14). INSTALL (2) 3/8" X 1" BOLTS INTO THE BOTTOM OF EACH DOCK SIDE BRACE BRACKET (FIGURE 2.15).



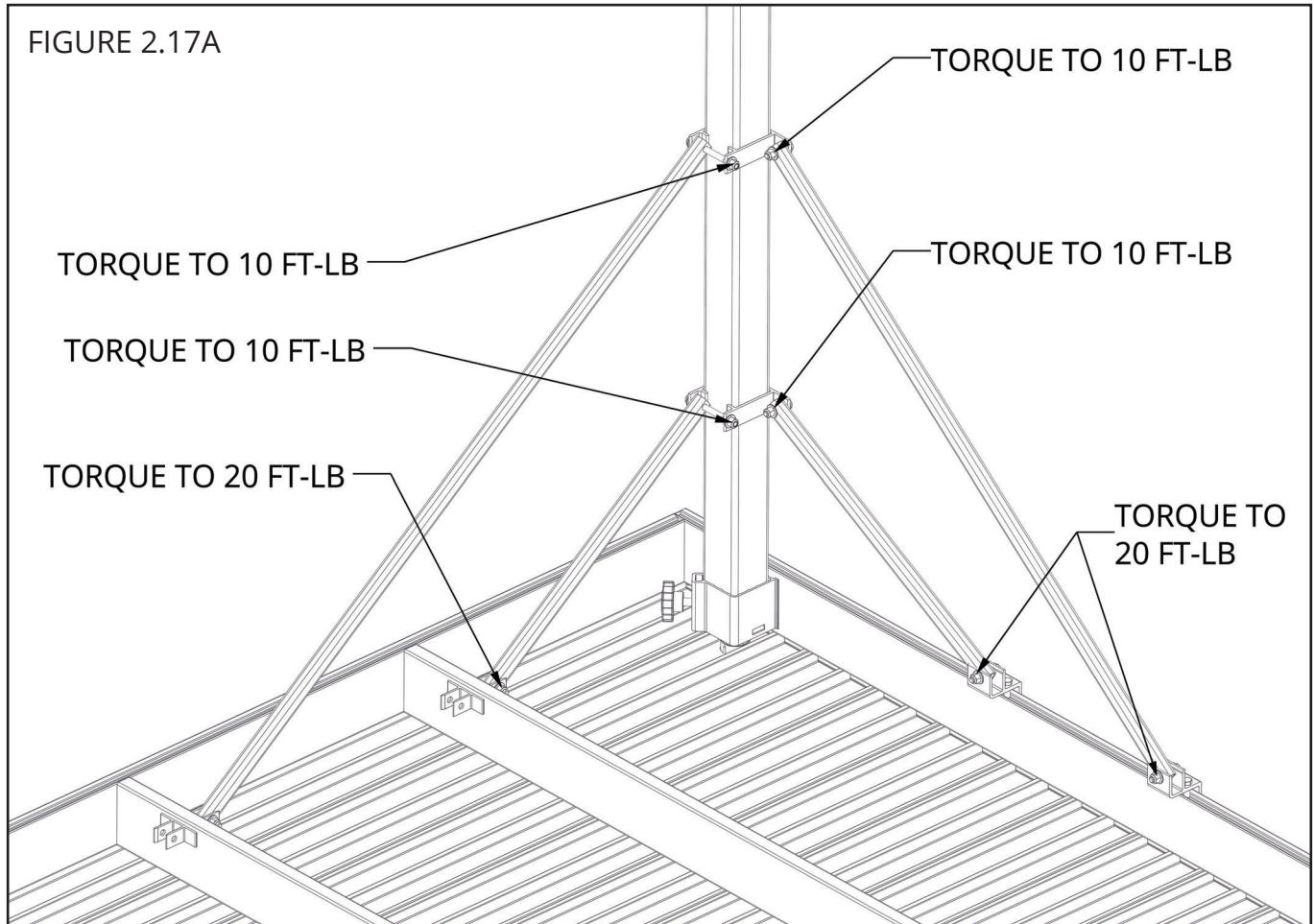
TORQUE BOLTS TO 6 FT-LB MAXIMUM (FIGURE 2.16).



TORQUE ALL FASTENERS TO THE SPECIFICATIONS SHOWN. **IMPORTANT: OVERTIGHTENING WILL CRUSH THE BRACES** (FIGURE 2.17).



TORQUE ALL FASTENERS TO THE SPECIFICATIONS SHOWN. **IMPORTANT: OVERTIGHTENING WILL CRUSH THE BRACES** (FIGURE 2.17A).



NOTES



FLOE INTERNATIONAL, INC.
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www.floeintl.com

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