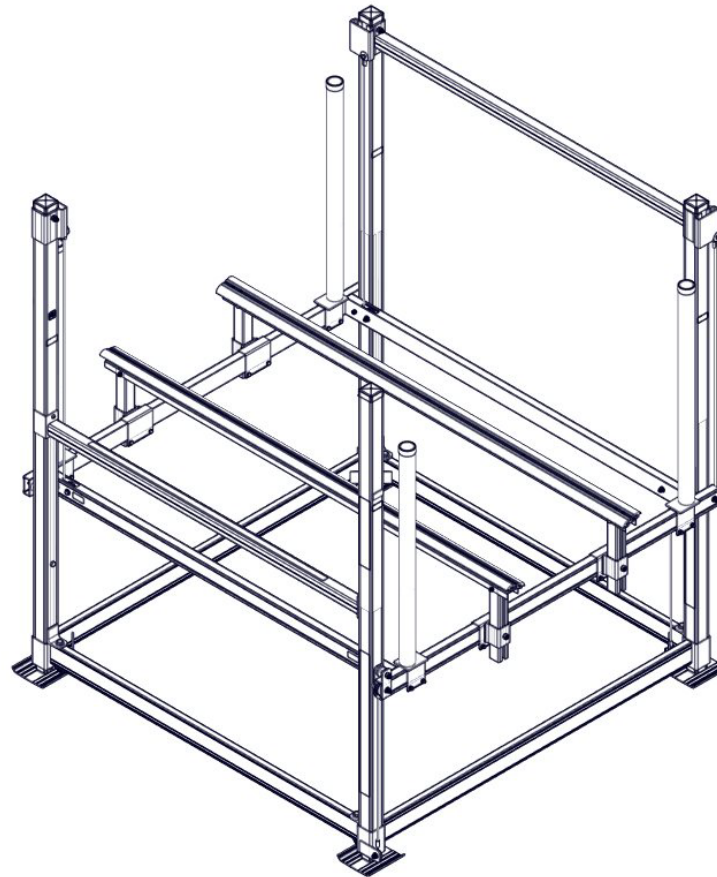


FLOE V1600 PWC LIFT FRAME

P/N 511-16080-00

ASSEMBLY INSTRUCTIONS



TOOLS REQUIRED

- 7/32" HEX BIT SOCKET
- 5/16" HEX BIT SOCKET
- (2) 9/16" SOCKETS/WRENCHES
- (2) 3/4" SOCKETS/WRENCHES
- TORQUE WRENCH
- TAPE MEASURE
- LEVEL

WARNING!!!

IT IS THE INSTALLER'S RESPONSIBILITY TO ENSURE THAT THE GUIDE-IN SYSTEM IS PROPERLY SET UP SUCH THAT NO PART OF THE GUIDE-INS CAN COME IN CONTACT WITH ANY PART OF THE LIFT, MOTOR, CANOPY RAILS, CANOPY HOOPS, OR CANOPY FABRIC WHILE THE LIFT IS IN OPERATION. FAILURE TO COMPLY WITH THIS WARNING MAY RESULT IN SEVERE DAMAGE TO THE LIFT AND/OR ACCESSORIES.

Instruction P/N 611-16075-00
Issued 12/15/23

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

TIPS

- Torque nuts to specification, not bolts.
- Place parts and fasteners in designated locations prior to each step.
- Before tightening fasteners to specified torque, ensure that the lift is square.
- Measure from corner to corner (A to C/B to D) to verify that the lift is square.
- Measure distance between corner posts (A to B, B to C, C to D, A to D) above frame beam and at the top of the corner post to verify that the lift is square.
- Use a marker to denote fasteners which have been tightened to the specified torque.
- Read instructions and understand them before attempting assembly.

Card Contents (511-04208-00)

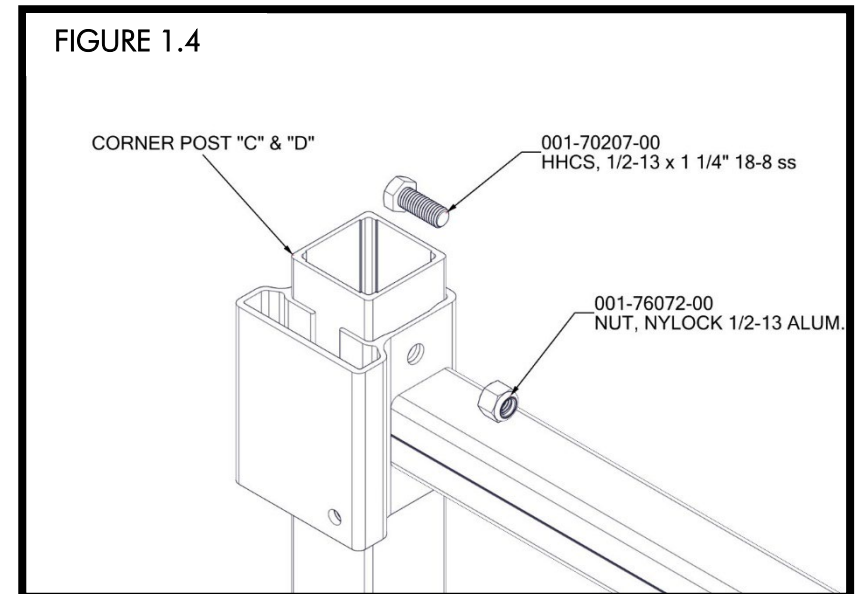
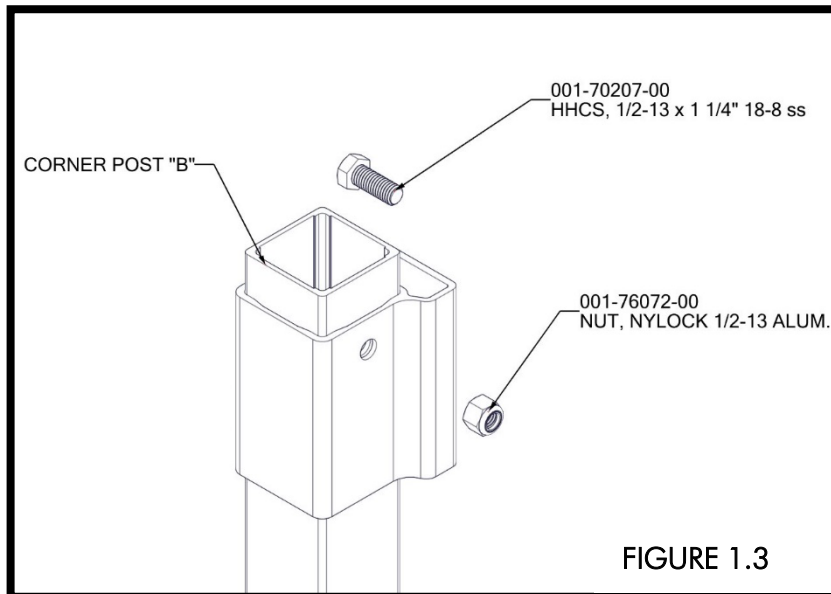
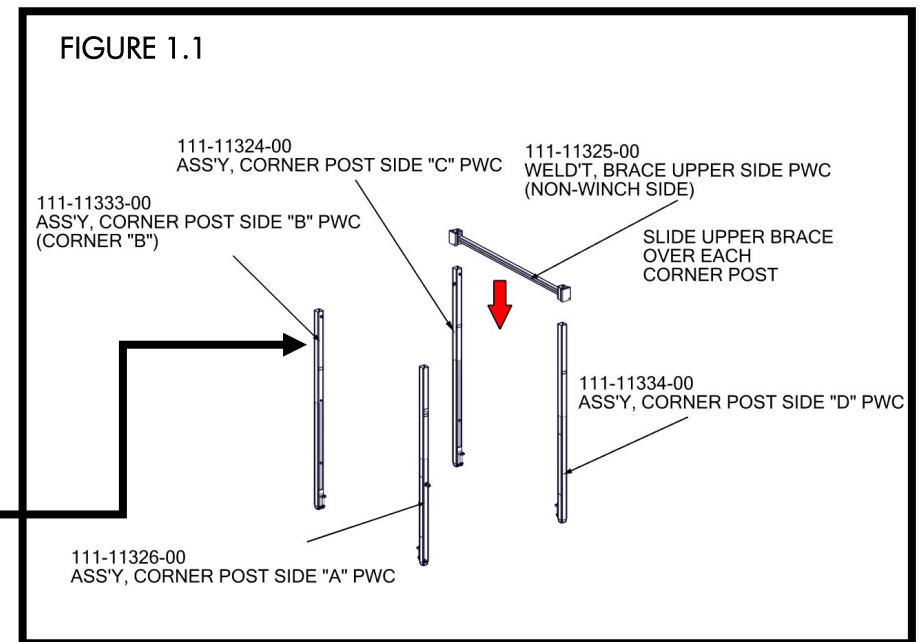
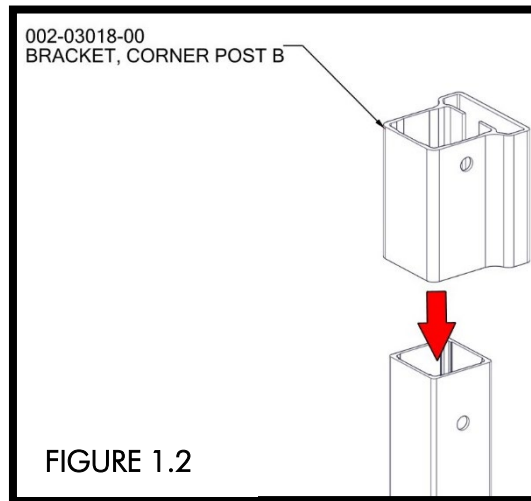
Step	Part Numbers	QTY	Descriptions	Torque
1	001-70207-00	3	HHCS, 1/2-13 x 1 1/4" ss 18-8	20 ft. lbs.
	001-76072-00	3	NUT, NYLOCK 1/2-13 ALUMINUM	
2	001-70223-00	4	HHCS, 1/2-13 x 5" 18-8 ss	40 ft. lbs.
	001-71021-00	8	FLAT WASHER, 1/2" 18-8 ss	
	001-76072-00	4	NUT, NYLOCK 1/2-13 ALUM.	
3	001-73834-00	4	BHCS, 1/2-13 x 1" 18-8 ss	20 ft. lbs.
4	001-73823-00	2	BHCS, 3/8-16 x 1.25" ss W/PATCH	15 ft. lbs.
	**001-70207-00	1	HHCS, 1/2-13 x 1 1/4" ss 18-8	20 ft. lbs.
	**001-76072-00	1	NUT, NYLOCK 1/2-13 ALUMINUM	
5	001-70105-00	6	HHCS, 3/8-16 x 1" 18-8 ss	10 ft. lbs.
	001-71017-00	6	FLAT WASHER, 3/8" SAE ss 18-8	
	001-71217-00	6	WASHER, 3/8" x 1.5" FENDER ss	
	001-76071-00	6	NUT, NYLOCK 3/8-16 ALUM.	
6	001-70213-00	1	HHCS, 1/2-13 x 2 1/2" 18-8 ss	25 ft. lbs.
	001-76072-00	1	NUT, NYLOCK 1/2-13 ALUM.	
	007-05355-00	1	FLATWASHER, 1/2" x .25" NYLON	
7*	001-70112-00 (GI)	8	HHCS, 3/8-16 x 2 1/4" 18-8 ss	35 ft. lbs.
	001-76349-00 (GI)	8	NUT, 3/8-16 ALUM.	
	001-70112-00 (B)	8	HHCS, 3/8-16 x 2 1/4" 18-8 ss	35 ft. lbs.
	001-76349-00 (B)	8	NUT, 3/8-16 ALUM.	
	001-70205-00 (B)	4	HHCS, 1/2-13 x 4 SS 18-8	70 ft. lbs.
	001-71022-00 (B)	4	FLATWASHER, 1/2" USS ss 18-8	
	001-76350-00 (B)	4	NUT, 1/2-13 ALUM.	
	001-70114-00 (B)	8	HHCS, 3/8-16 x 2 3/4" 18-8 ss	35 ft. lbs.
	001-76349-00 (B)	8	NUT, 3/8-16 ALUM.	

***FASTENERS IN STEP 7 ARE INCLUDED WITH BUNK AND GUIDE-IN KITS. (B: BUNK, GI: GUIDE-INS)**

****USED FOR ATTACHING WINCH. REFER TO WINCH INSTRUCTIONS (P/N 611-11329-00)**

STEP 1

- SLIDE UPPER BRACE OVER CORNER POSTS "C" & "D" AND NOTE ORIENTATION (FIGURE 1.1). SLIDE BRACKET OVER CORNER POST "B" (FIGURE 1.2). ATTACH BRACE AND BRACKET USING (1) 1/2" x 3/4" BOLT AND (1) 1/2" NUT PER CORNER POST (FIGURE 1.3 & 1.4).



STEP 1

- TORQUE NUTS ON BRACE AND BRACKET TO 20 FT-LBS (FIGURE 1.5 & 1.6).

FIGURE 1.6

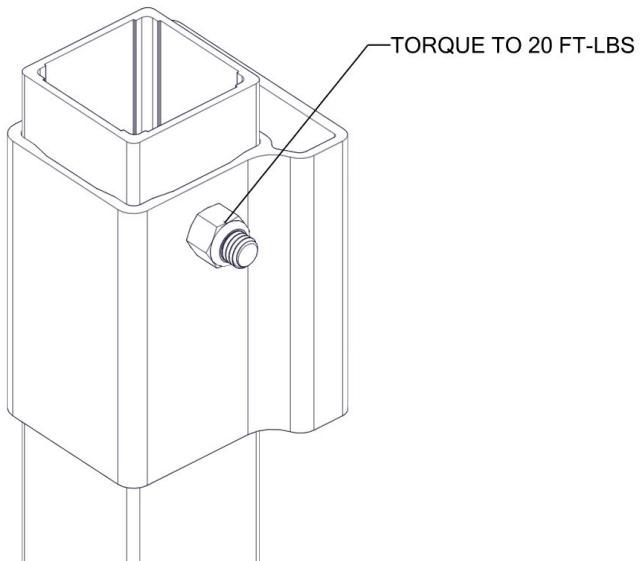
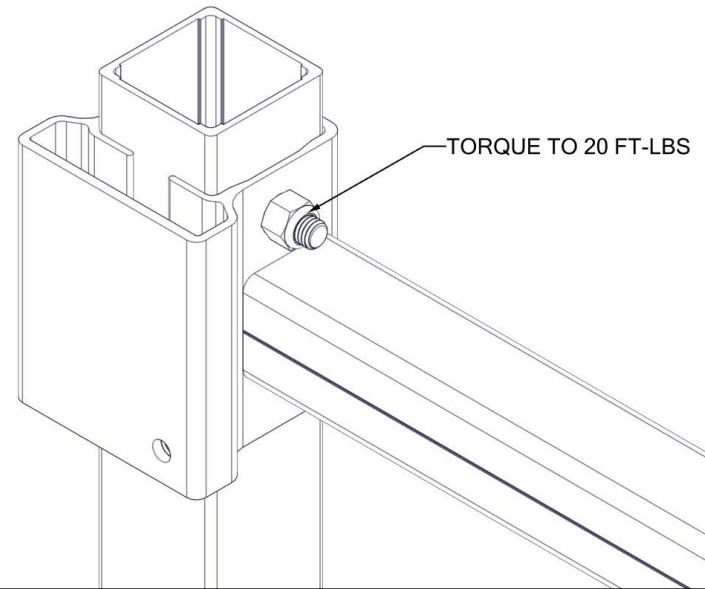


FIGURE 1.5

2x



STEP 2

- FIRST, PLACE FRAME BEAM ASSEMBLY ONTO BUCKETS OR EQUIVALENT (MIN. 12" HEIGHT). INSERT CORNER POSTS THROUGH FRAME BEAM ASSEMBLY. NOTE THAT CORNER POST "A" IS PLACED IN POCKET WITH TAB (FIGURE 2.1). ATTACH USING (1) ½" x 5" BOLT, (2) ½" WASHERS, AND (1) ½" NYLOCK NUT PER CORNER (FIGURE 2.2).
- TORQUE TO 40 FT-LBS (FIGURE 2.3).

FIGURE 2.1

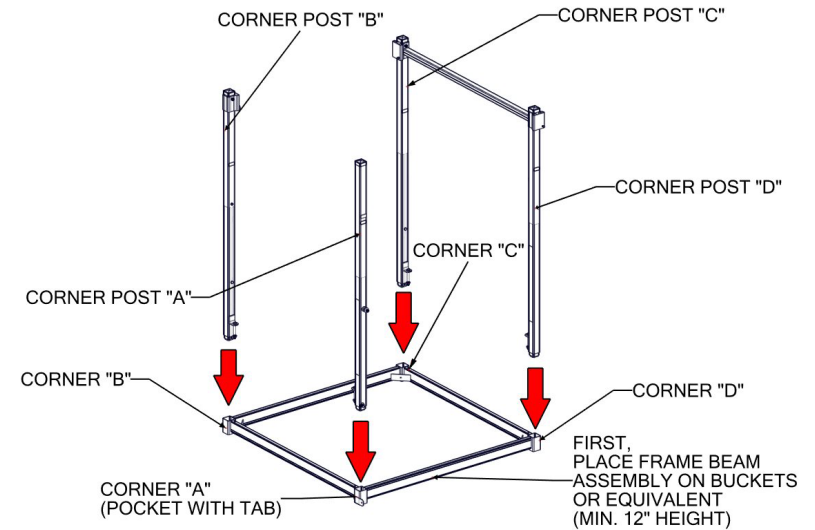


FIGURE 2.2

4x

001-70223-00
HHCS, 1/2-13 x 5" 18-8 ss

001-71021-00
FLAT WASHER, 1/2" 18-8 SS

001-76072-00
NUT, NYLOCK 1/2-13 ALUM.

4X

FIGURE 2.3

TORQUE TO 40 FT-LBS

STEP 3

- ATTACH SAND PADS ONTO EACH CORNER POST USING (1) $\frac{1}{2}$ " x 1" BOLT PER CORNER (FIGURE 3.1).
- TORQUE TO 20 FT-LBS (FIGURE 3.2).
- TO LEVEL LIFT, LOOSEN $\frac{1}{2}$ " BOLT ON EACH CORNER POST. WHILE USING A BUBBLE LEVEL ON EACH FRAME BEAM, SET EACH CORNER POST HEIGHT UNTIL ALL FOUR FRAME BEAMS ARE LEVEL. TIGHTEN BOLTS WHEN ADJUSTMENTS ARE FINALIZED, BUT DO NOT TORQUE FULLY. FURTHER ADJUSTMENT MAY HAVE TO BE MADE IN WATER (FIGURE 3.3).

THE SAME FOUR BOLTS ARE USED IN SETTING THE LIFT HEIGHT WHEN THE LIFT IS IN THE WATER. LOOSEN $\frac{1}{2}$ " BOLTS TO SET HEIGHT OF CORNER POSTS AND TORQUE TO 40 FT-LBS WHEN DONE.

4x

002-03025-00
SANDPAD, V1600 PWC

001-73834-00
BHCS, 1/2-13 x 1" 18-8 SS

FIGURE 3.1

4x

TORQUE TO 20 FT-LBS

FIGURE 3.2

4x

NOTE:

FOR LEVELING, DO NOT TORQUE FULLY. FOR HEIGHT ADJUSTMENT IN WATER, TORQUE TO 40 FT-LBS WHEN DONE.

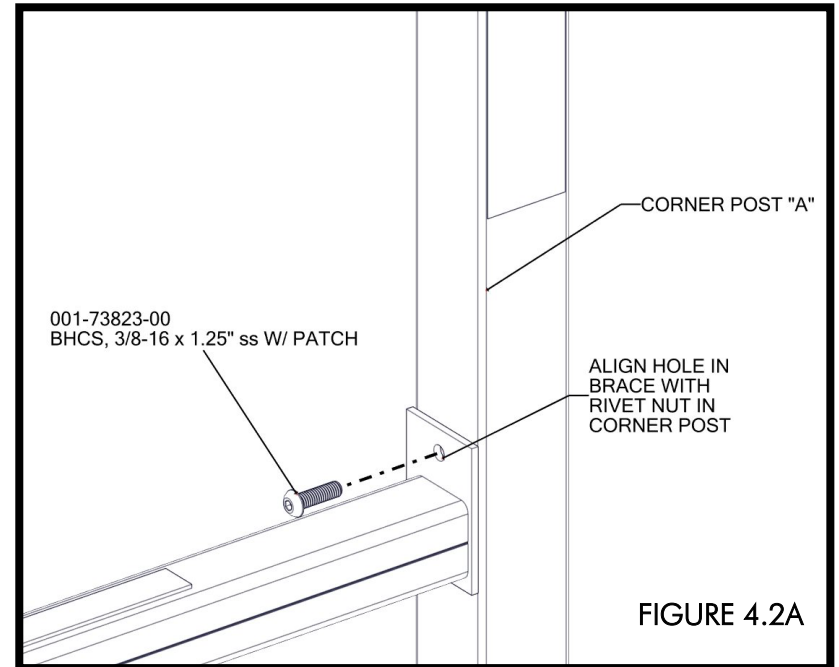
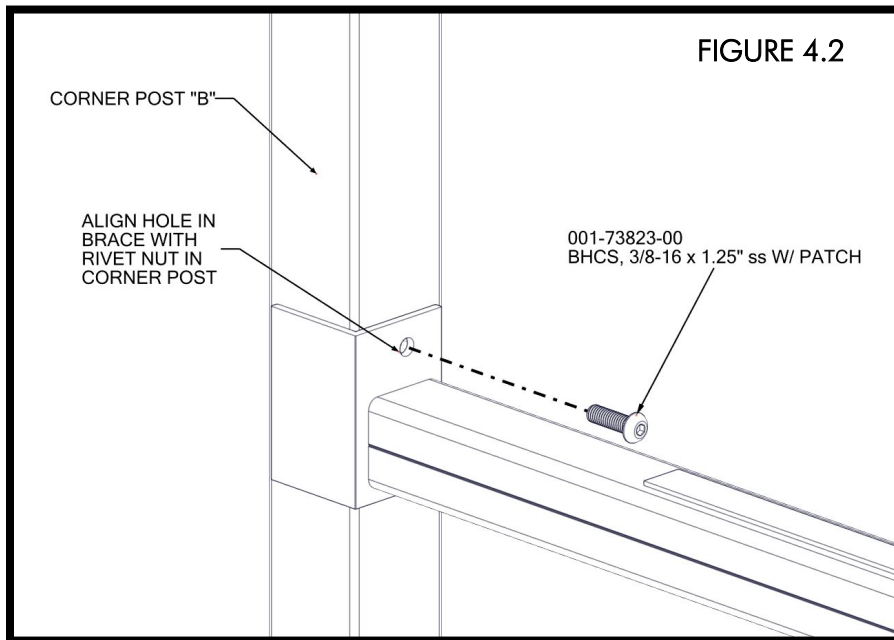
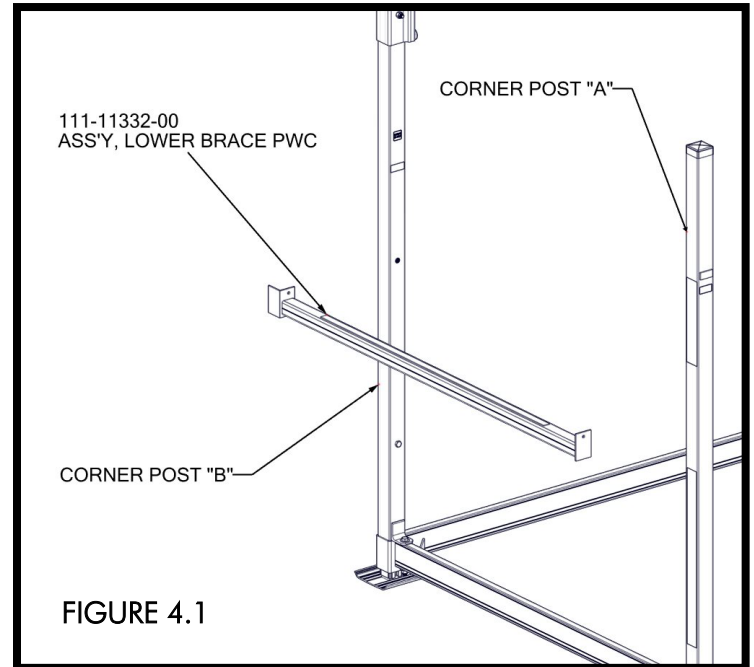
NOTE:
LEVEL LIFT USING FRAME BEAM

1/2" BOLT ON EACH CORNER POST IS LOOSENED TO RAISE OR LOWER LEG
SET HEIGHT WHEN LIFT IS IN WATER WHILE USING DEPTH DECAL ON EACH POST

FIGURE 3.3

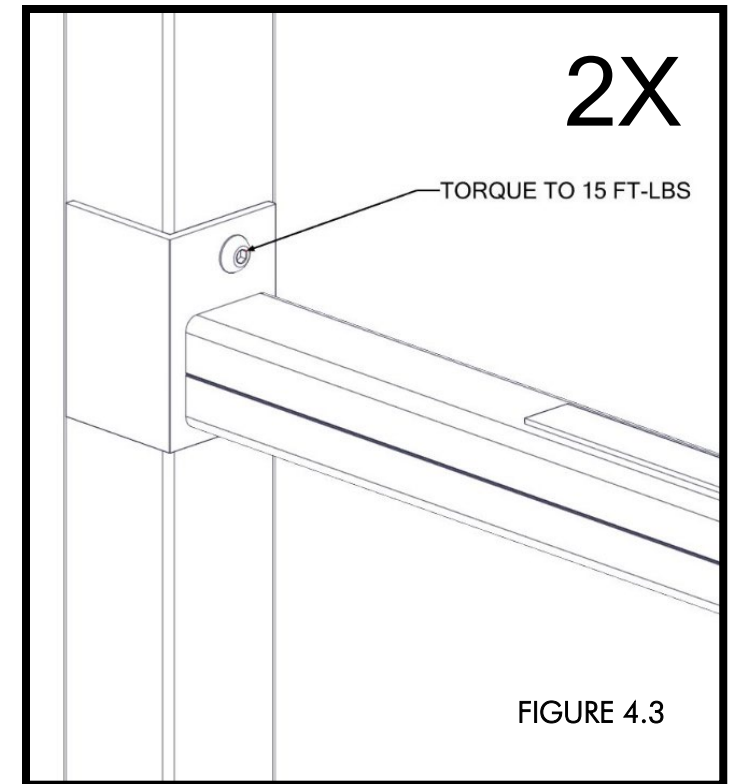
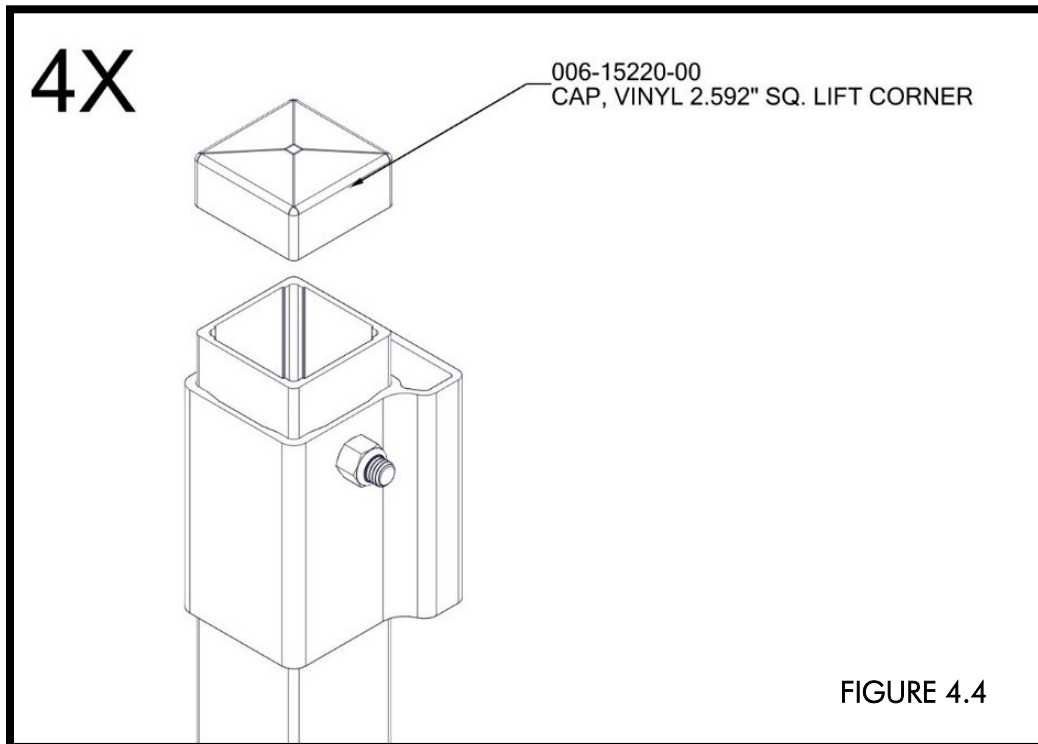
STEP 4

- LOWER BRACE IS PLACED BETWEEN CORNER POSTS "A" & "B" (FIGURE 4.1).
- ATTACH BRACE TO CORNER POSTS WITH 3/8" x 1.25" BUTTON HEAD BOLT (FIGURES 4.2 & 4.2A).
- TORQUE TO 15 FT-LBS (FIGURE 4.3).



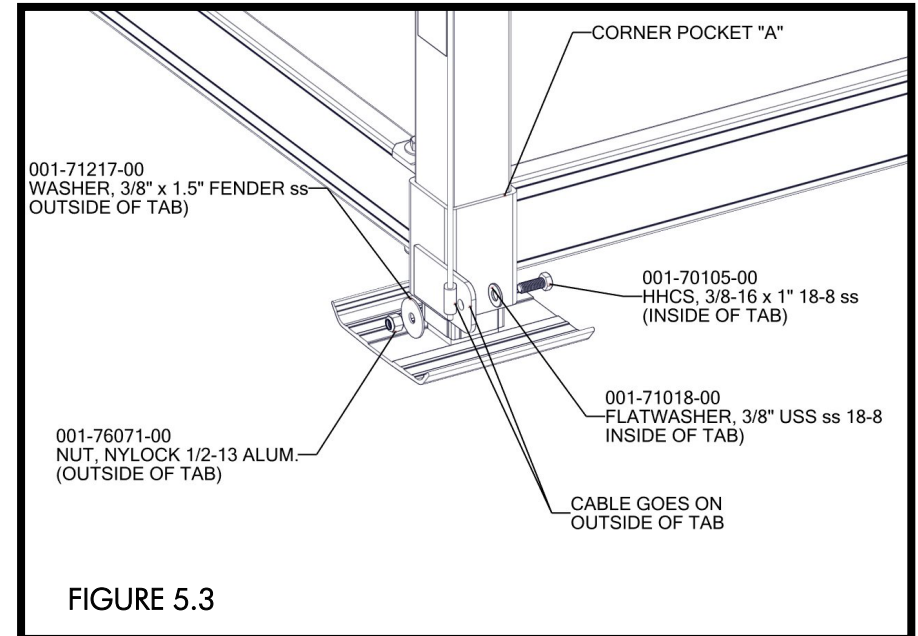
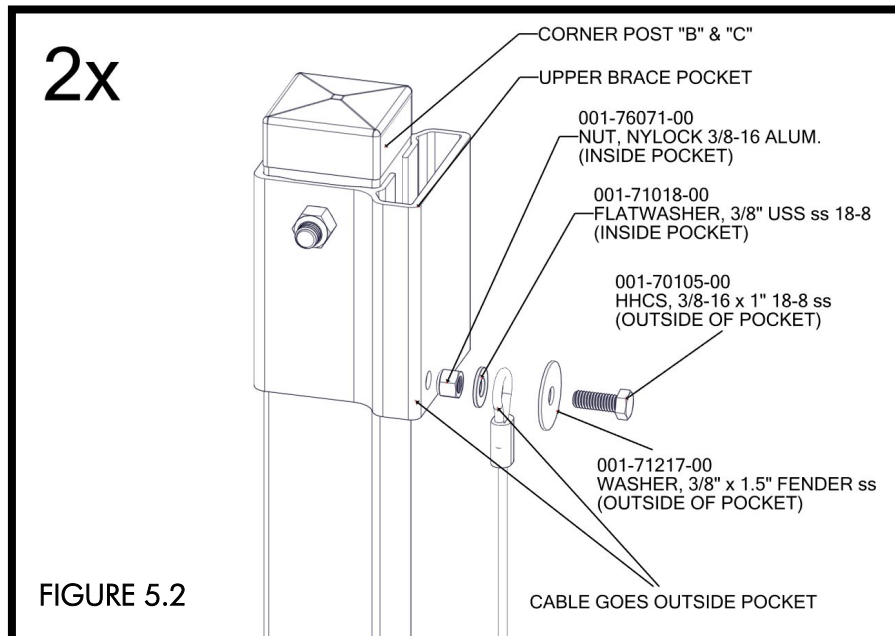
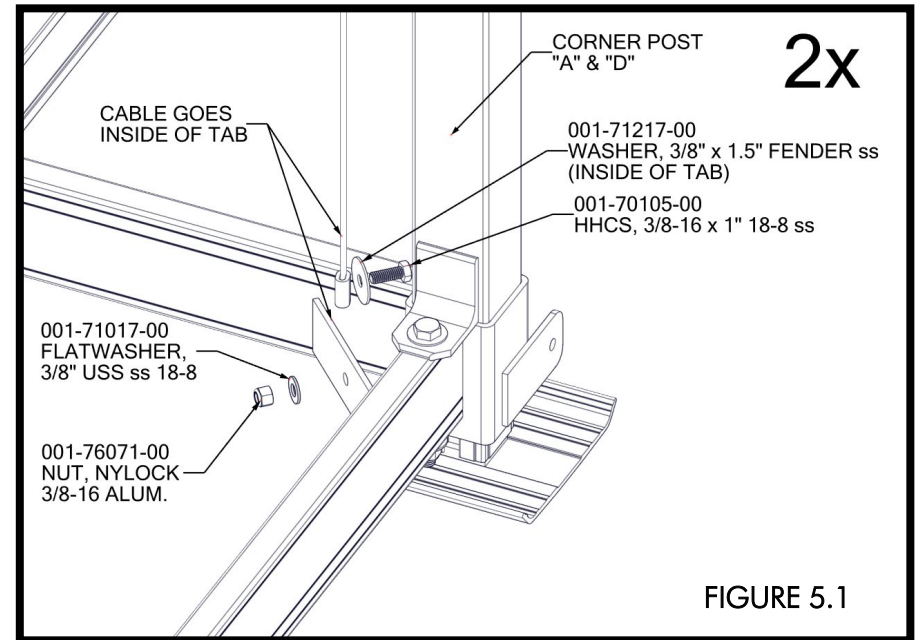
STEP 4

- TORQUE BOTH BOLTS TO 15 FT-LBS (FIGURE 4.3).
- PLACE VINYL CAPS ON EACH CORNER POST (FIGURE 4.4).
- NOTE: USE 1/2" X 1-1/4" BOLT AND 1/2" NYLOCK NUT TO ATTACH MANUAL WINCH OR DC WINCH TO CORNER POST "A". REFER TO WINCH INSTRUCTIONS FOR FURTHER DETAILS.



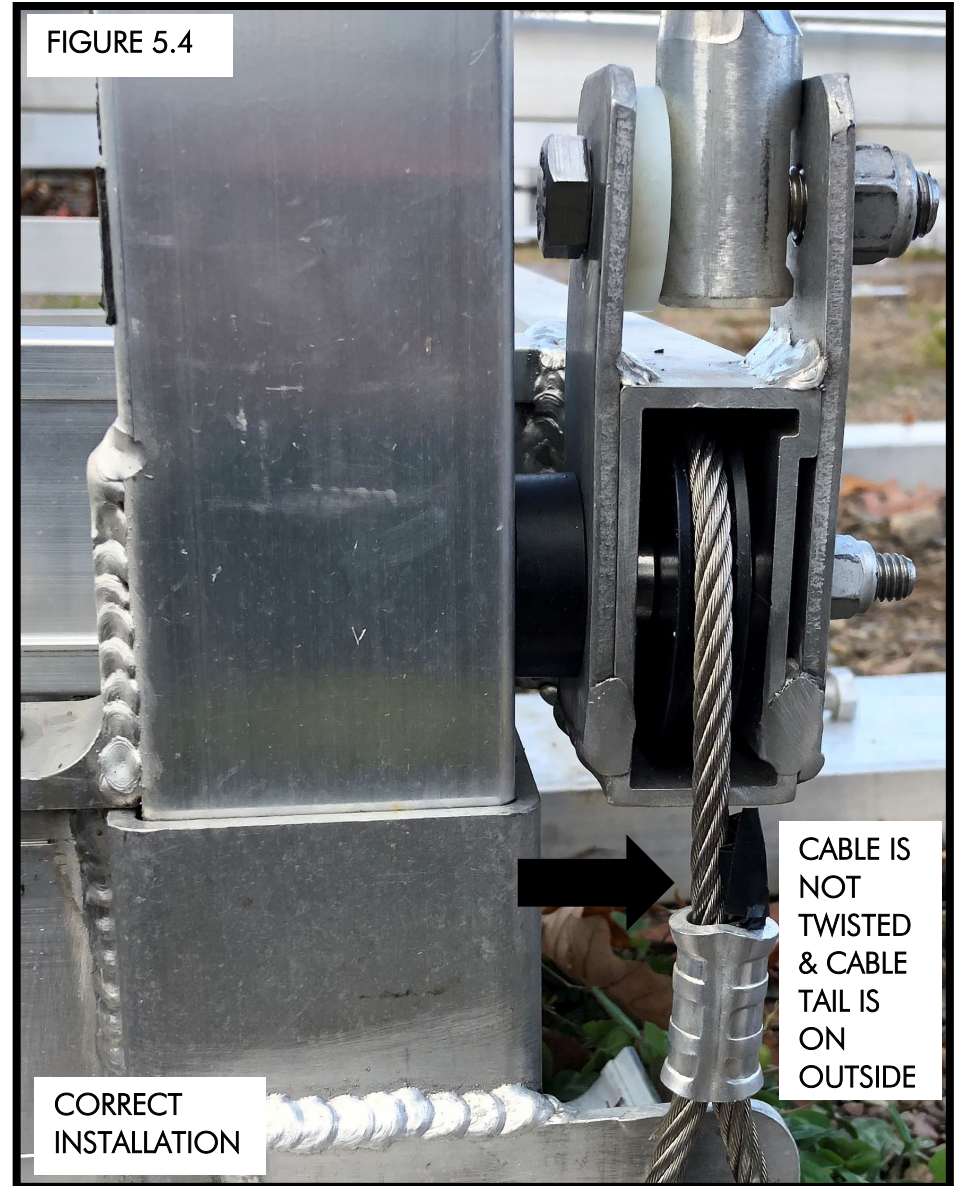
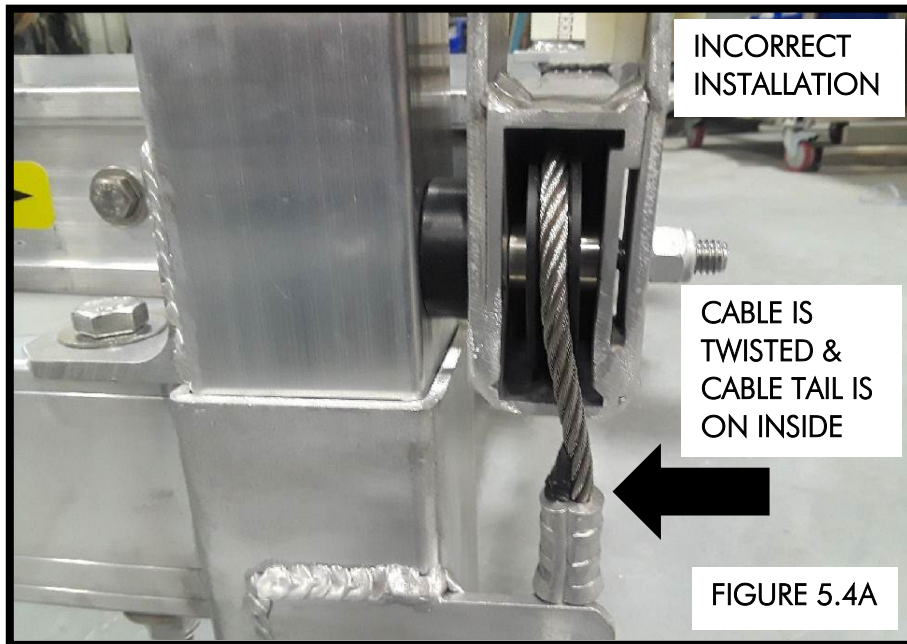
STEP 5

- ATTACH SIDE LEVELING CABLES TO FRAME BEAM ASSEMBLY AT CORNERS "A" AND "D" USING (1) 3/8" x 1" BOLT, (1) 3/8" FENDER WASHER, (1) 3/8" WASHER, AND (1) 3/8" NYLOCK NUT PER CABLE END. NOTE ORIENTATION (FIGURE 5.1).
- ATTACH SIDE LEVELING CABLES TO UPPER BRACES AT CORNERS "B" AND "C" USING (1) 3/8" x 1" BOLT, (1) 3/8" FENDER WASHER, (1) 3/8" WASHER, AND (1) 3/8" NYLOCK NUT PER CABLE END. NOTE ORIENTATION (FIGURE 5.2). NOTE THAT CORNER "B" ONLY HAS A BRACKET AND CORNER "C" HAS A BRACE.
- ATTACH FRONT LEVELING CABLE TO TAB ON CORNER POCKET "A" OF FRAME ASSEMBLY USING (1) 3/8" x 1" BOLT, (1) 3/8" FENDER WASHER, (1) 3/8" WASHER, AND (1) 3/8" NYLOCK NUT. NOTE ORIENTATION (FIGURE 5.3).



STEP 5

- NOTE ORIENTATION OF CABLE END. CABLE MUST BE INSTALLED IN THIS MANNER FOR PROPER CABLE ALIGNMENT (FIGURE 5.4). INCORRECT INSTALLATION WILL RESULT IN POOR CABLE ALIGNMENT (FIGURE 5.4A).



STEP 5

- ATTACH FRONT LEVELING CABLE TO UPPER BRACE ON CORNER POST "D" USING (1) 3/8" x 1" BOLT, (1) 3/8" FENDER WASHER, (1) 3/8" WASHER, AND (1) 3/8" NYLOCK NUT. NOTE ORIENTATION (FIGURE 5.5).
- TORQUE TO 10 FT-LBS (FIGURE 5.6 & 5.7).

FIGURE 5.5

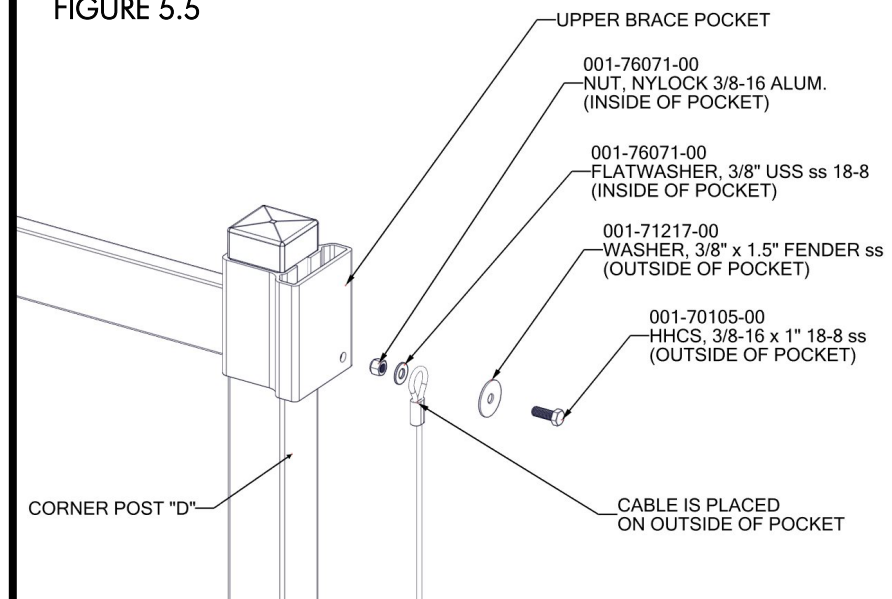


FIGURE 5.6

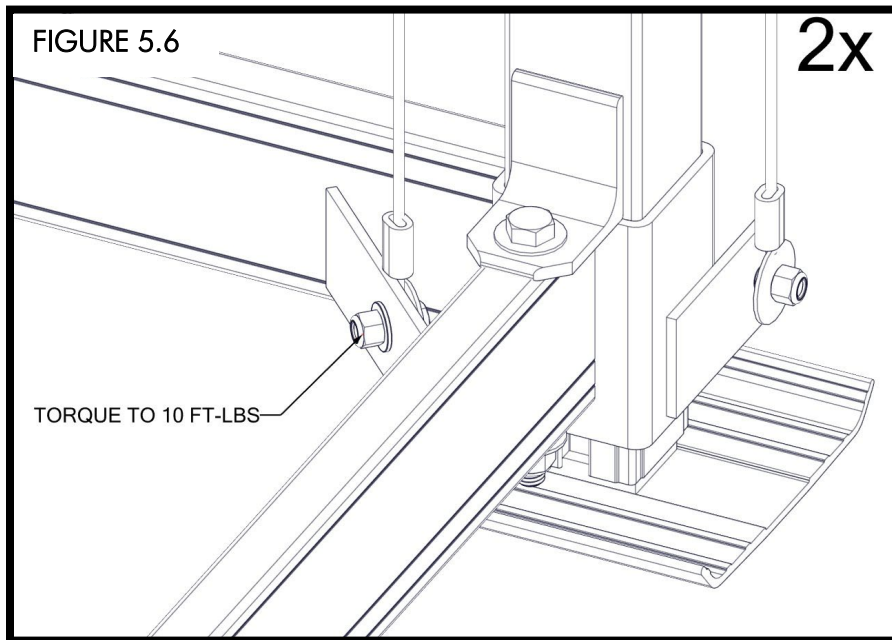
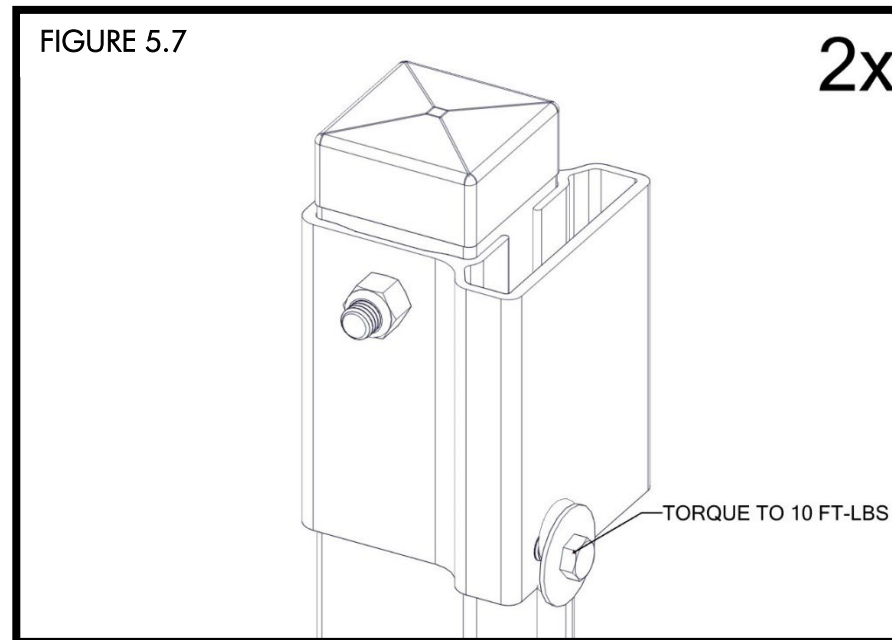
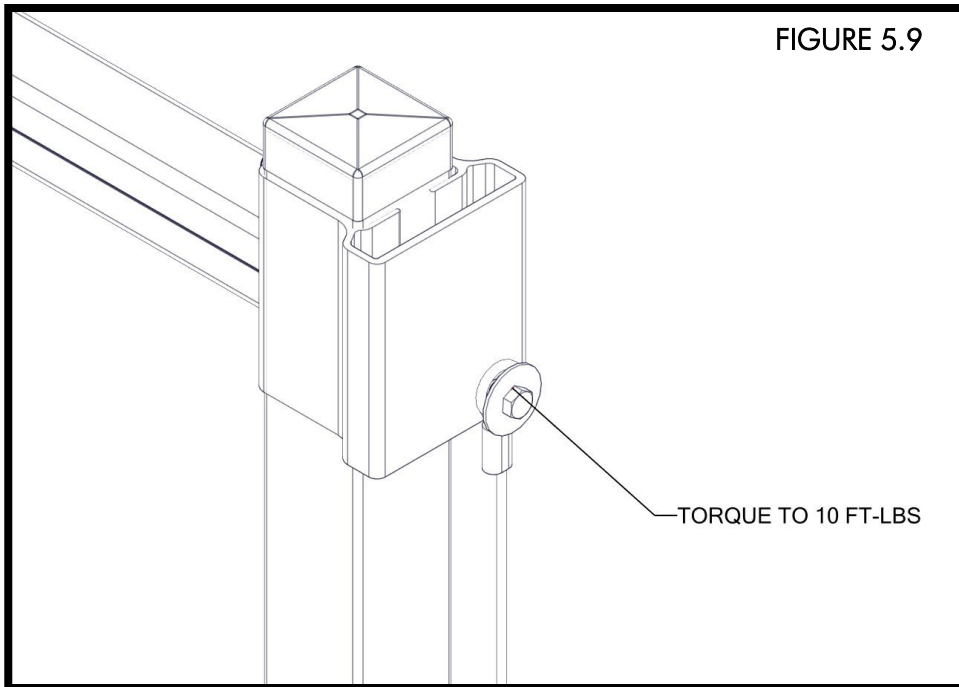
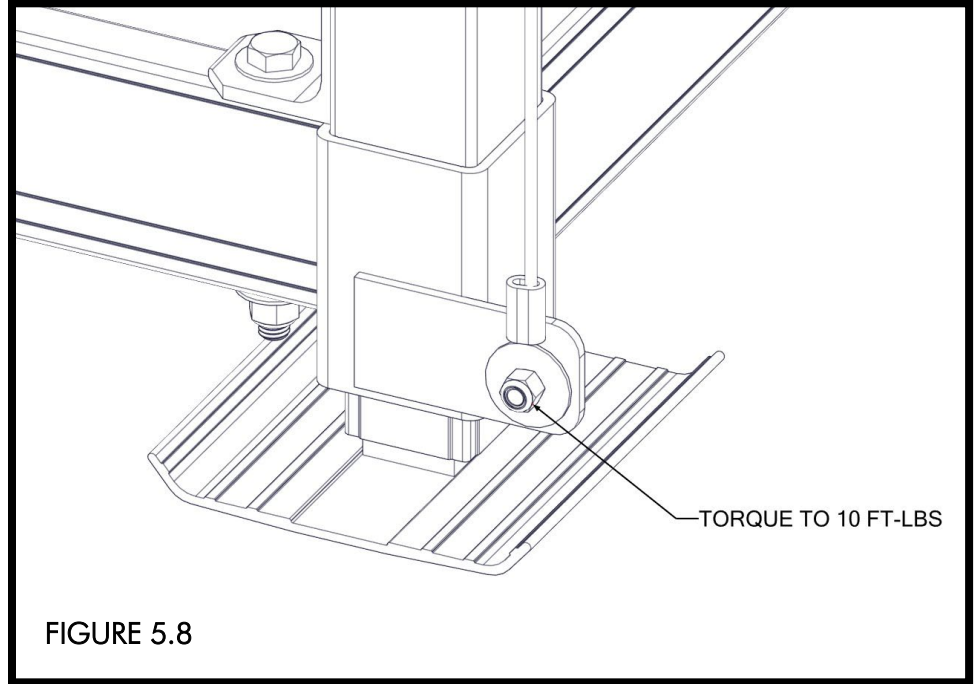


FIGURE 5.7



STEP 5

- TORQUE TO 10 FT-LBS (FIGURE 5.8 & 5.9).



STEP 6

- PUSH UP ON CRADLE ON SIDE OPPOSITE OF THE LIFTING POST TO ALLOW FOR BOLTS, WASHERS, AND LIFTING CABLE TO BE INSERTED BETWEEN TABS (FIGURE 6.1).
- ATTACH LIFTING CABLE TO TABS ON CRADLE BEAM USING (1) 1/2" x 2 1/2" BOLT, (1) 1/2" NYLON WASHERS, AND (1) 1/2" NYLOCK NUT. NOTE ORIENTATION (FIGURE 6.2).
- TORQUE NUT TO 25 FT-LBS (FIGURE 6.3).

FIGURE 6.1

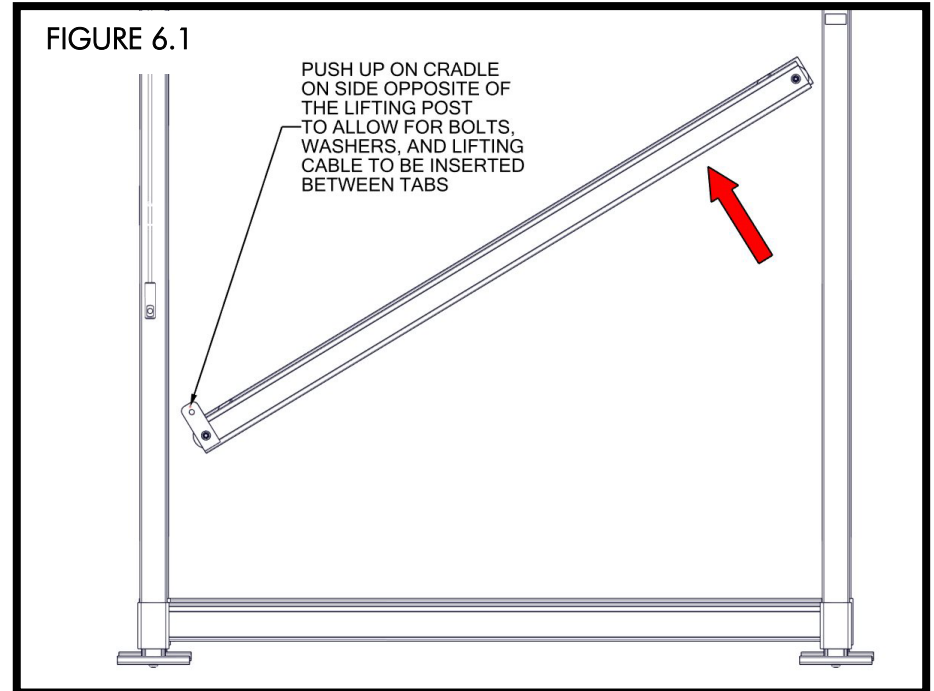


FIGURE 6.2

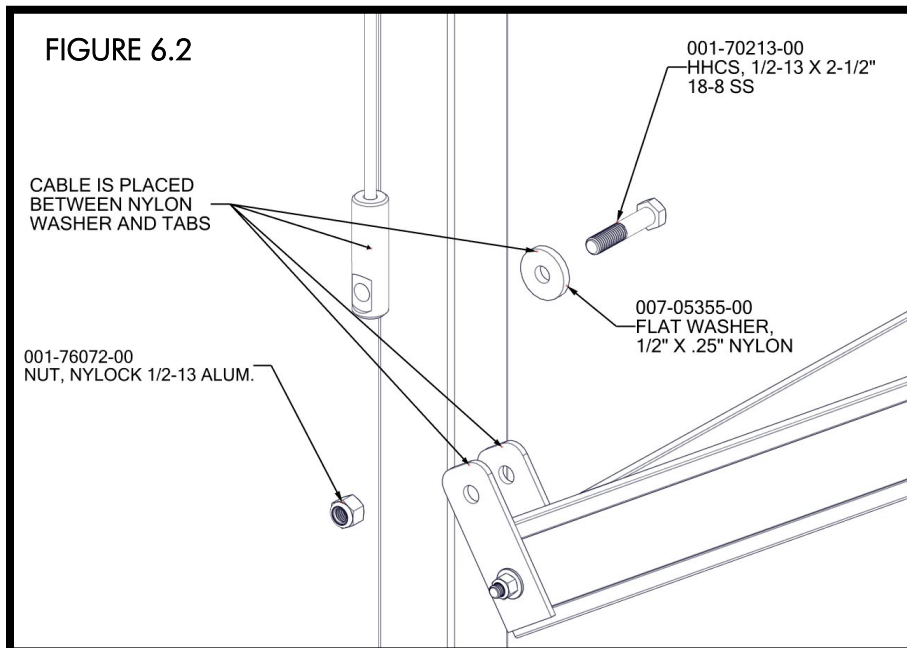
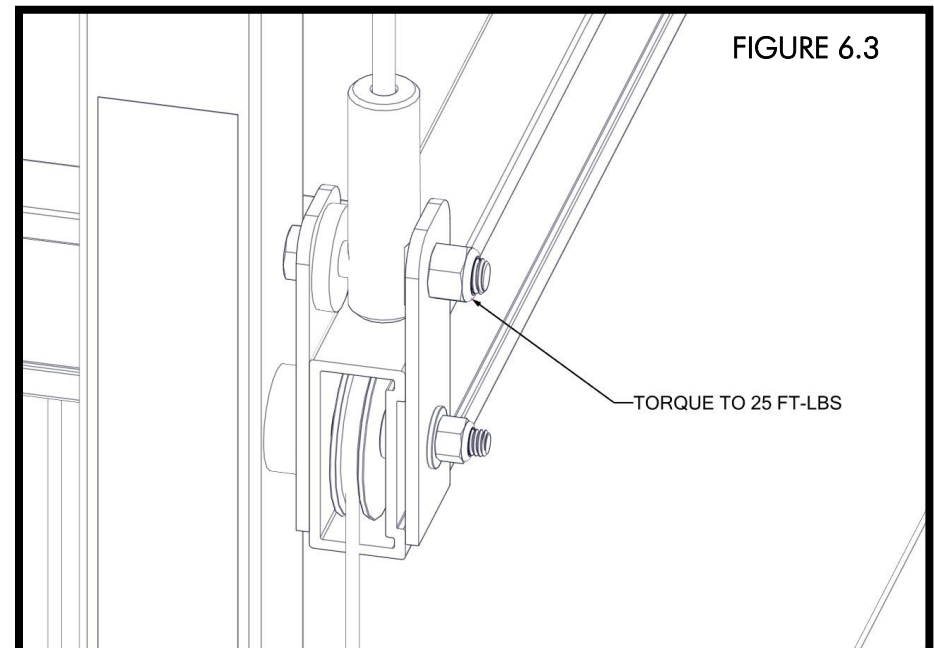
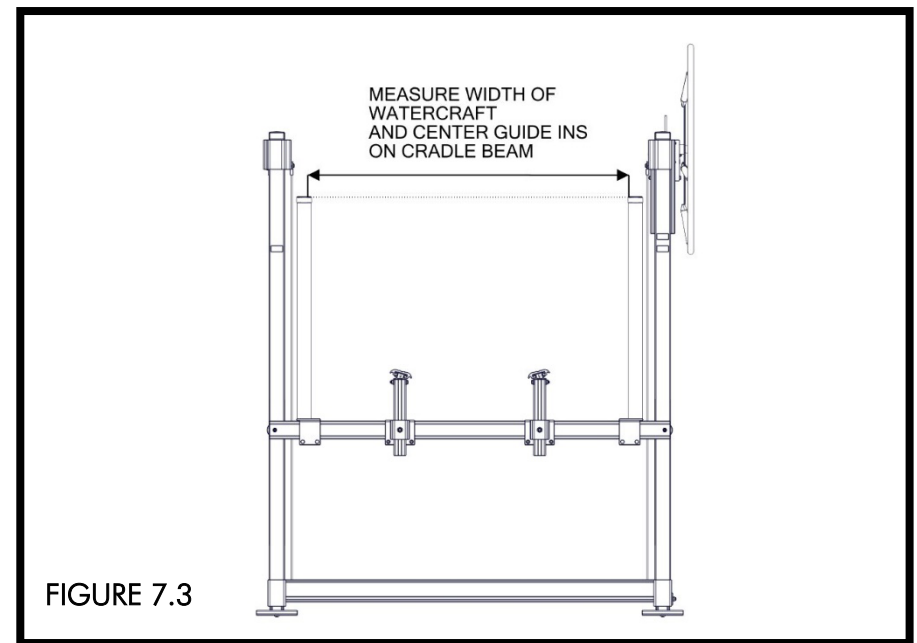
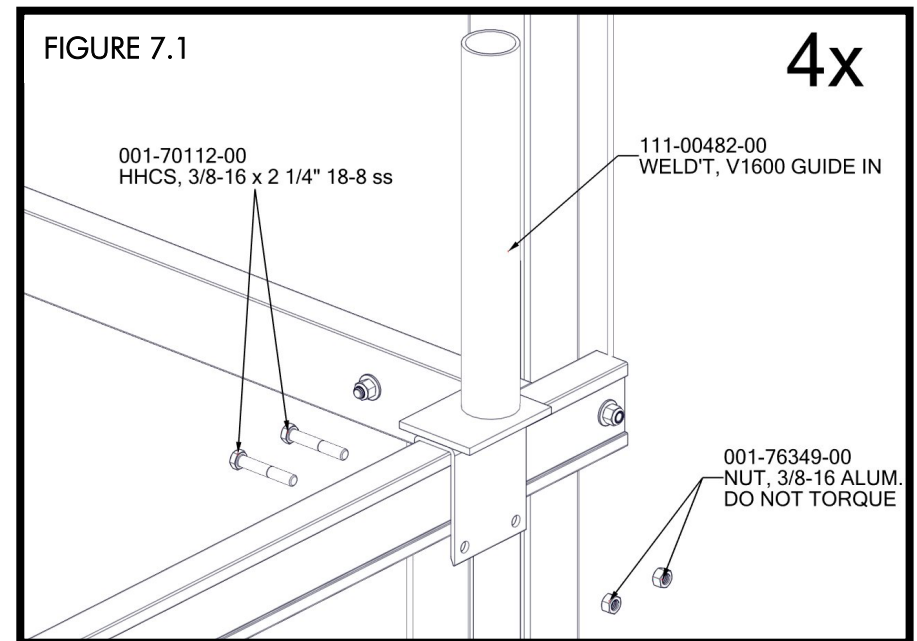
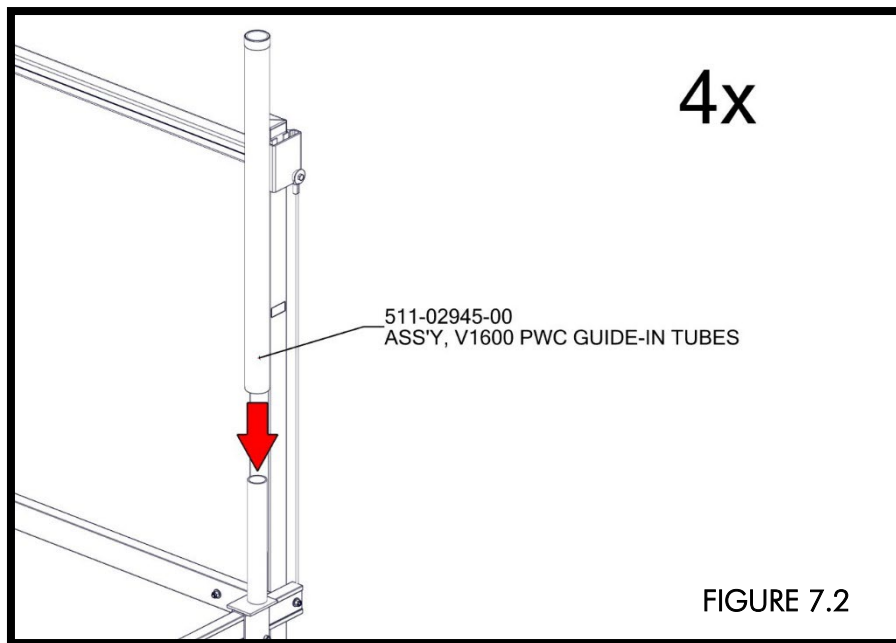


FIGURE 6.3



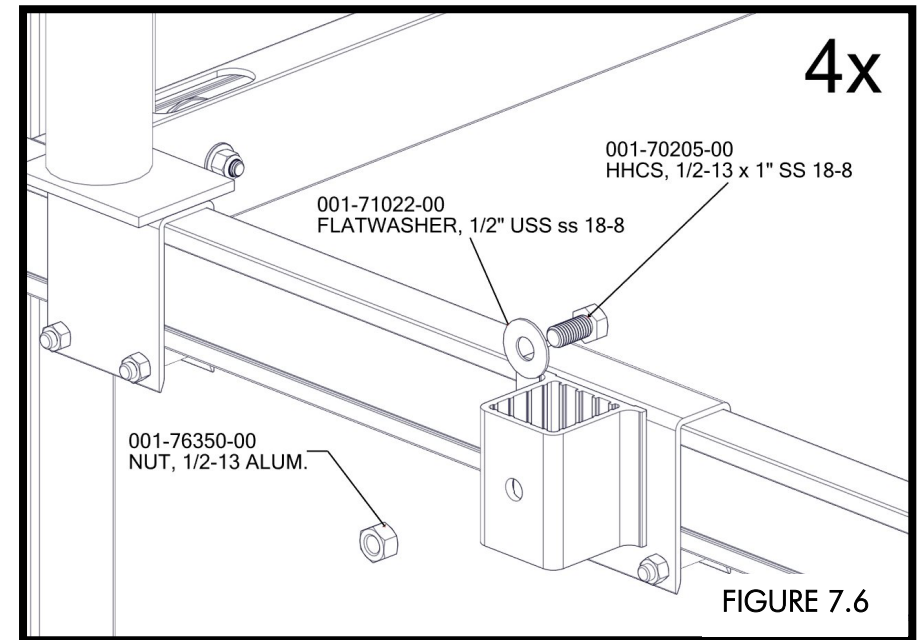
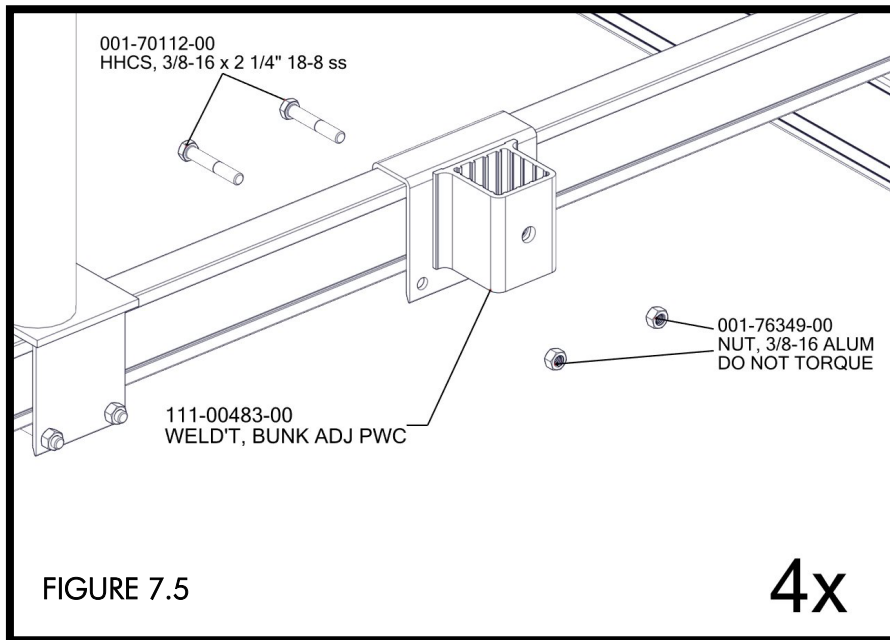
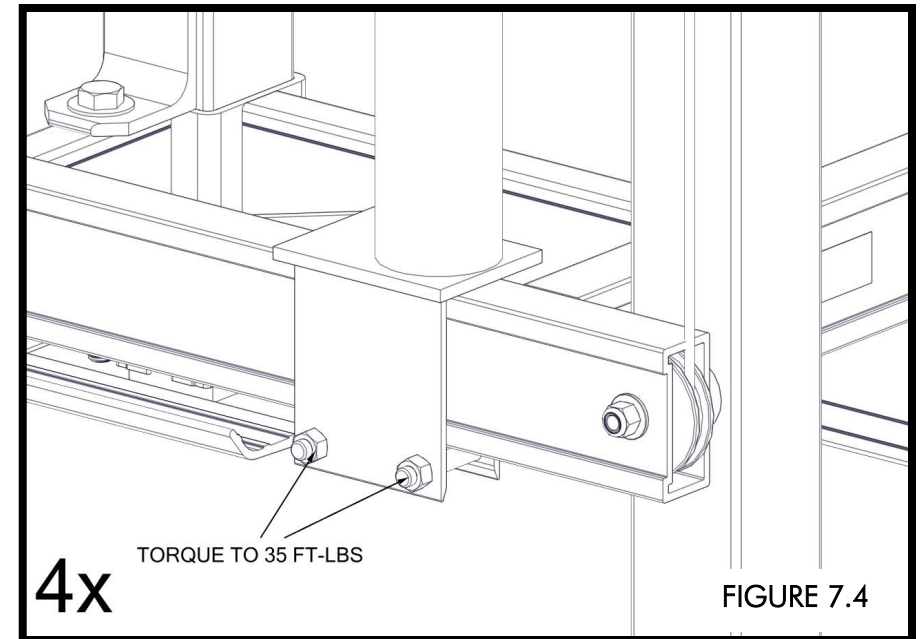
STEP 7

- PLACE A VERTICAL GUIDE UPRIGHT BY EACH CORNER POST AND ATTACH USING (2) 3/8" x 2 1/4" BOLTS AND 3/8" NUTS PER UPRIGHT. DO NOT TORQUE (FIGURE 7.1).
- SLIDE PVC WITH VINYL CAPS ONTO VERTICAL GUIDE UPRIGHTS (FIGURE 7.2).
- FIND WIDTH OF WATERCRAFT AND USE DIMENSION TO SET GUIDE INS ON CRADLE BEAM WHILE MAINTAINING SYMMENTRY (FIGURE 7.3).



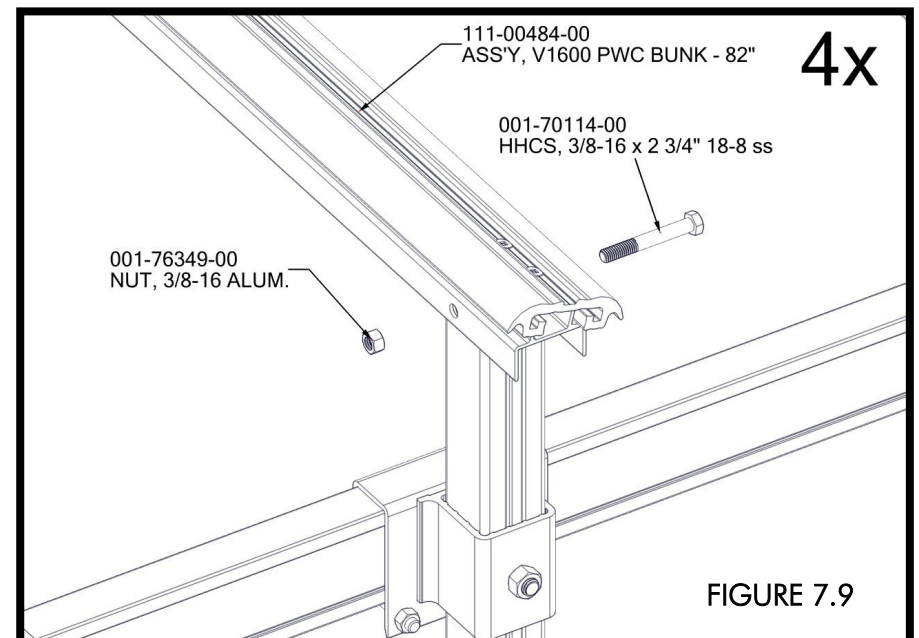
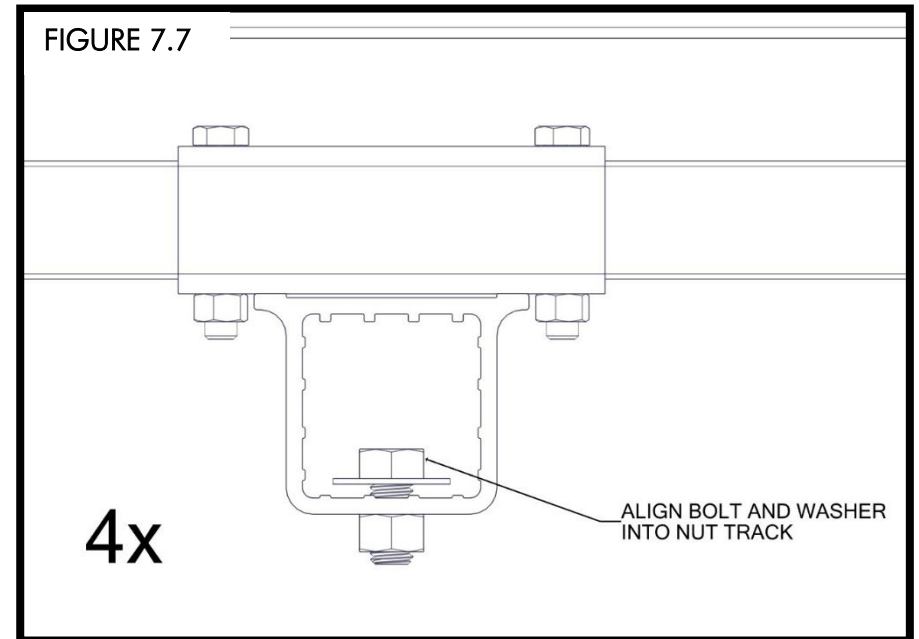
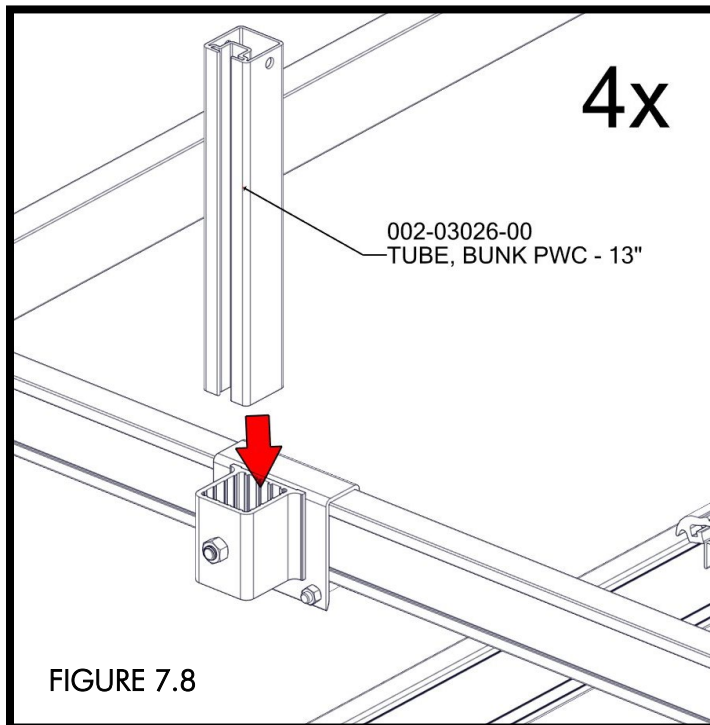
STEP 7

- TORQUE NUTS TO 35 FT-LBS (FIGURE 7.4).
- PLACE THE BUNK TUBE POCKETS ON THE CRADLE BEAM AND ATTACH USING (2) 3/8" x 2 1/4" BOLTS AND (2) 3/8" NUTS PER UPRIGHT. DO NOT TORQUE (FIGURE 7.5).
- BUNK TUBES ARE ATTACHED TO POCKETS USING (1) 1/2" x 1" BOLT, 1/2" WASHER, AND 1/2" NUT (FIGURE 7.6).



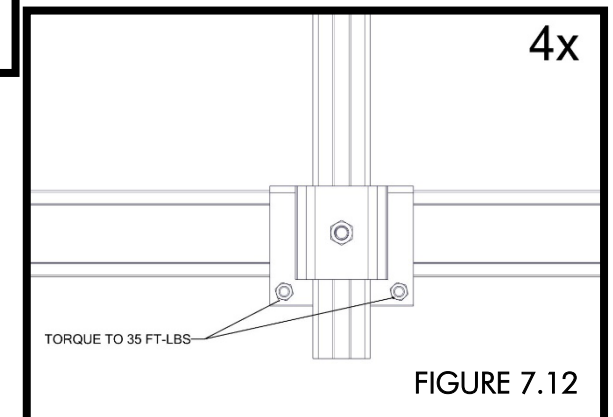
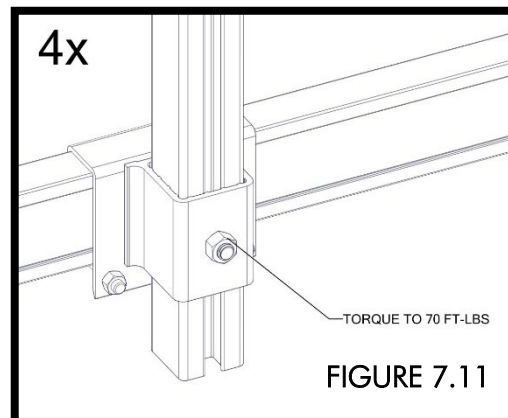
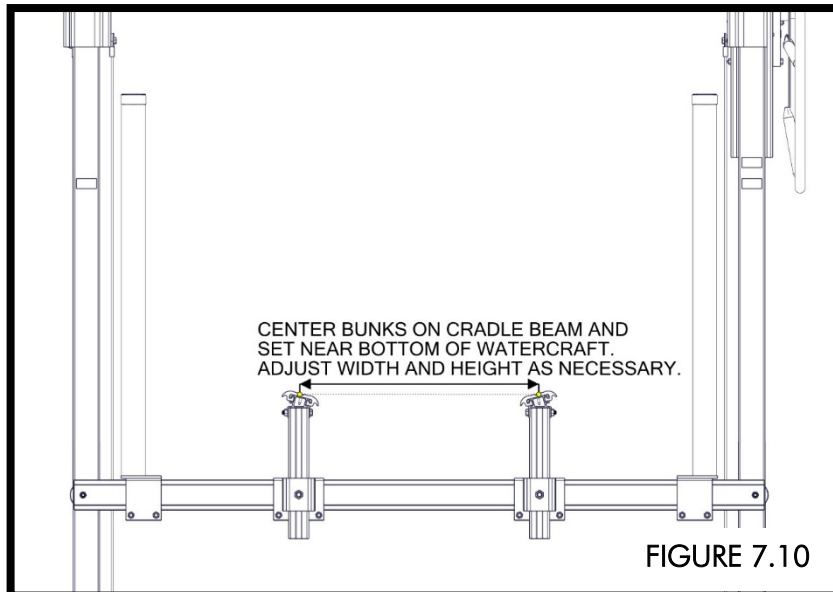
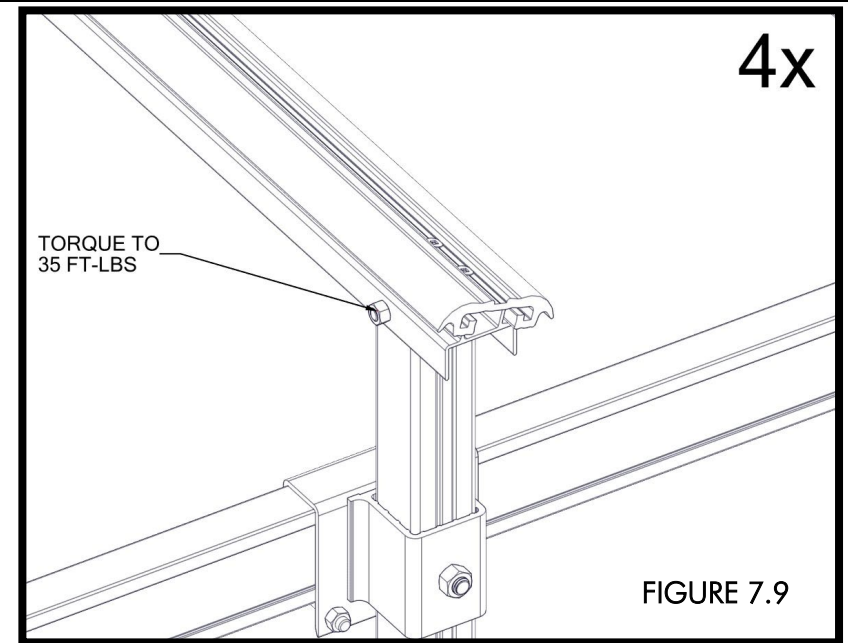
STEP 7

- ALIGN FASTENERS AS SHOWN (FIGURE 7.7).
- SLIDE BUNK TUBE INTO POCKET AND BOLT/WASHER INTO NUT TRACK (FIGURE 7.8).
- ATTACH BUNKS TO UPRIGHTS USING (1) 3/8" x 2 3/4" BOLT AND (1) 3/8" NUT PER UPRIGHT (FIGURE 7.9).



STEP 7

- TORQUE NUTS TO 35 FT-LBS (FIGURE 7.9).
- SET BUNK WIDTH BY FINDING WIDTH OF HULL AND PLACE THEM NEAR BOTTOM OF WATERCRAFT (FIGURE 7.10).
- TORQUE BUNK UPRIGHT NUTS TO 70 FT-LBS (FIGURE 7.11) AND BUNK POCKET NUTS TO 35 FT-LBS (FIGURE 7.12)



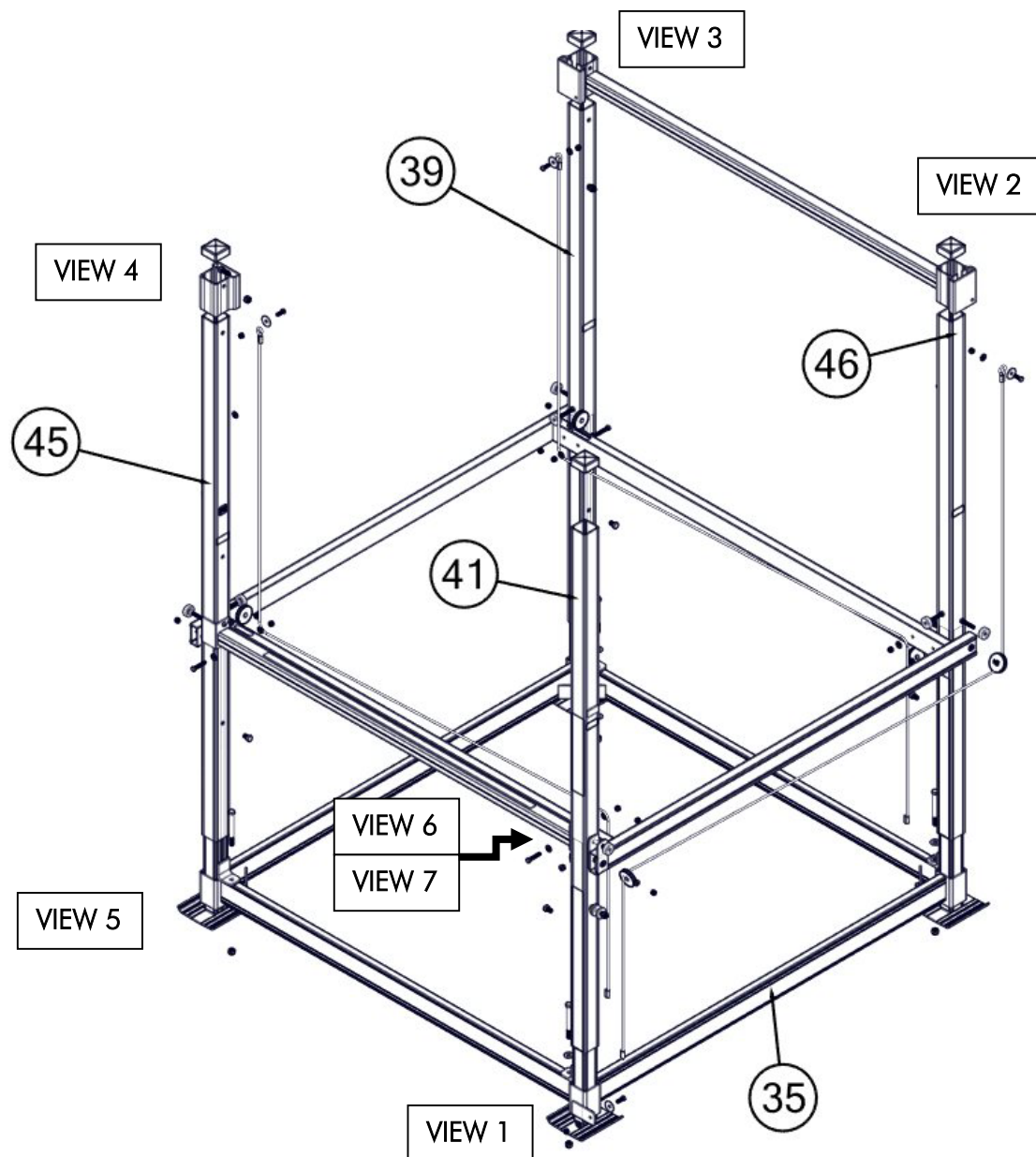
V1600 PWC LIFT FRAME BILL OF MATERIALS

LIFT P/N 511-16080-00

NO.	PART NUMBER	DESCRIPTION	QTY.
1	001-70105-00	HHCS, 3/8-16 x 1" 18-8 ss	9
2	001-70111-00	HHCS, 3/8-16 x 2" 18-8 ss	11
3	001-70112-00	HHCS, 3/8-16 x 2 1/4" 18-8 ss	17
4	001-70114-00	HHCS, 3/8-16 x 2 3/4" 18-8 ss	5
5	001-70203-00	HHCS, 1/2-13 x 3/4" 18-8 ss	4
6	001-70205-00	HHCS, 1/2-13 x 1" SS 18-8	4
7	001-70207-00	HHCS, 1/2-13 x 1 1/4" 18-8 ss	4
8	001-70213-00	HHCS, 1/2-13 x 2 1/2" 18-8 ss	1
9	001-70223-00	HHCS, 1/2-13 x 5" 18-8 ss	4
10	001-71017-00	Flat Washer, 3/8" SAE ss 18-8	30
11	001-71021-00	FLAT WASHER, 1/2" 18-8 SS	8
12	001-71022-00	Flat Washer, 1/2" USS ss	4
13	001-71217-00	WASHER, 3/8" X 1.5" Fender ss	6
14	001-73823-00	BHCS, 3/8-16 x 1.25" SS W/Patch	2
15	001-73834-00	BHCS, 1/2-13 x 1" SS W/Patch	4
16	001-76071-00	NUT, NYLOCK 3/8-16 ALUM.	22
17	001-76072-00	NUT, NYLOCK 1/2-13 ALUM.	9
18	001-76349-00	NUT, 3/8-16 ALUM.	21
19	001-76350-00	NUT, 1/2-13 ALUM.	8
20	002-03018-00	Bracket, Corner Post B	1
21	002-03025-00	Sand Pad, V1600 PWC	4
22	002-03026-00	Tube, Bunk PWC - 13"	4
23	006-15018-00	Cap, Vinyl - 2.375" ID x 1" L	4
24	006-15220-00	Cap, Vinyl 2.592" Sq. Lift Corner	4
25	007-00025-00	Sheave, PWC 2-1/2"	6
26	007-00030-00	Guide support PWC	8
27	007-05355-00	FLAT WASHER, 1/2" x .25" NYLON	1
28	007-07715-00	Spacer, V1600 Pulley	12
29	007-09400-00	Cable, Front Leveling	1
30	007-09401-00	Cable, Side Leveling V1600	2
31	011-01703-00	Pipe, 2" Schedule 40 PVC x 38"	4
32	111-00482-00	Weld't, V1600 Guide In	4
33	111-00483-00	Weld't, Bunk ADJ PWC	4
34	111-00484-00	Ass'y, V1600 PWC Bunk - 82"	2
35	111-11320-00	Weld't, Frame PWC	1
36	111-11321-00	Weld't, Corner Post "B" V1600 PWC	1
37	111-11322-00	Weld't, Inner Leg V1600 PWC	4
38	111-11323-00	Weld't, Cradle Beam PWC	1
39	111-11324-00	Ass'y, Corner Post Side "C" PWC (INCLUDES 6, 43, 50)	1
40	111-11325-00	Weld't, Brace Upper Side PWC	1
41	111-11326-00	Ass'y, Corner Post Side "A" PWC (7, 45, 57)	1
42	111-11327-00	Ass'y, Cradle Beam PWC (INCLUDES 2, 4, 11, 17, 26, 27, 33, 35, 36, 44)	1
43	111-11330-00	Weld't, Corner Post "C & D" V1600 PWC	2
44	111-11332-00	Ass'y, Brace Lower PWC	1
45	111-11333-00	Ass'y, Corner Post Side "B" PWC (INCLUDES 6, 42, 43)	1
46	111-11334-00	Ass'y, Corner Post Side "D" PWC (INCLUDES 6, 43, 50)	1
47	111-11335-00	Weld't, Corner Post "A" V1600 PWC	1
48	511-02762-00	Ass'y, Bunk Clamps V1600 PWC (3, 4, 7, 13, 19, 20, 23, 39)	1
49	511-02763-00	Ass'y, V1600 PWC Full Bunk (INCLUDES 40)	1
50	511-02945-00	Ass'y, V1600 PWC Guide-In Tubes (INCLUDES 24, 37)	1
51	511-02946-00	Ass'y, Single V1600 Guide-In Clamps (INCLUDES 3, 19, 38)	2

V1600 PWC LIFT FRAME EXPLODED VIEW MAIN 1

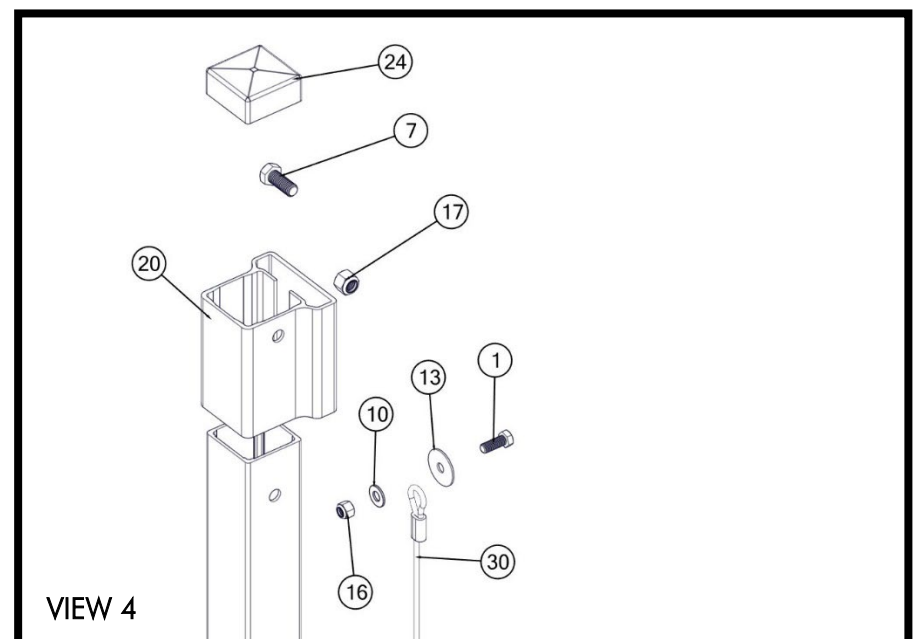
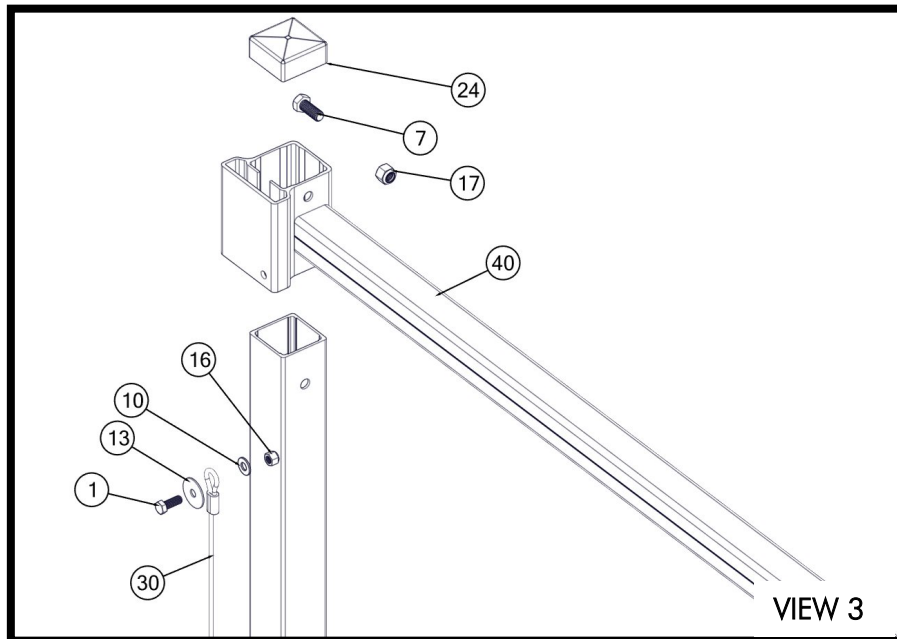
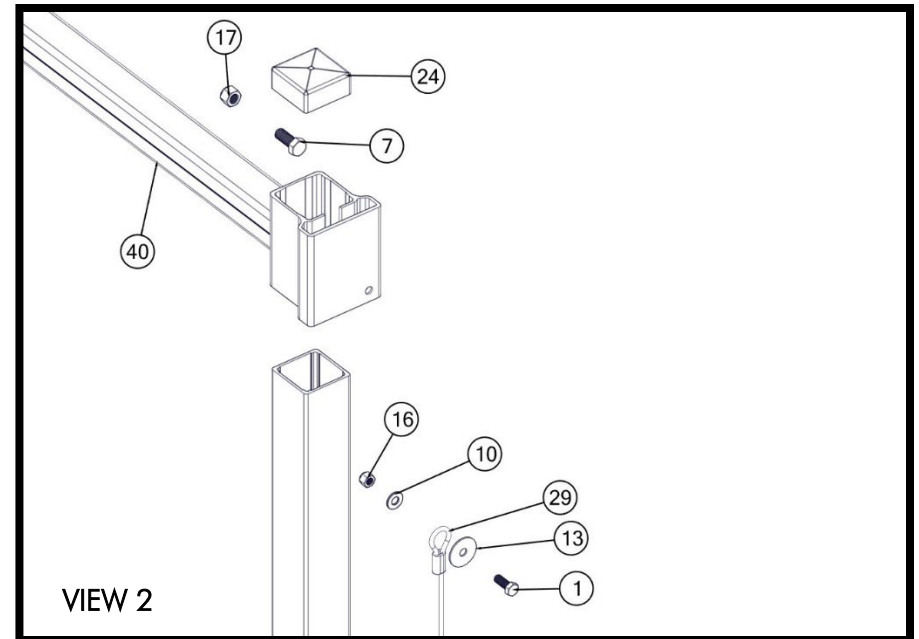
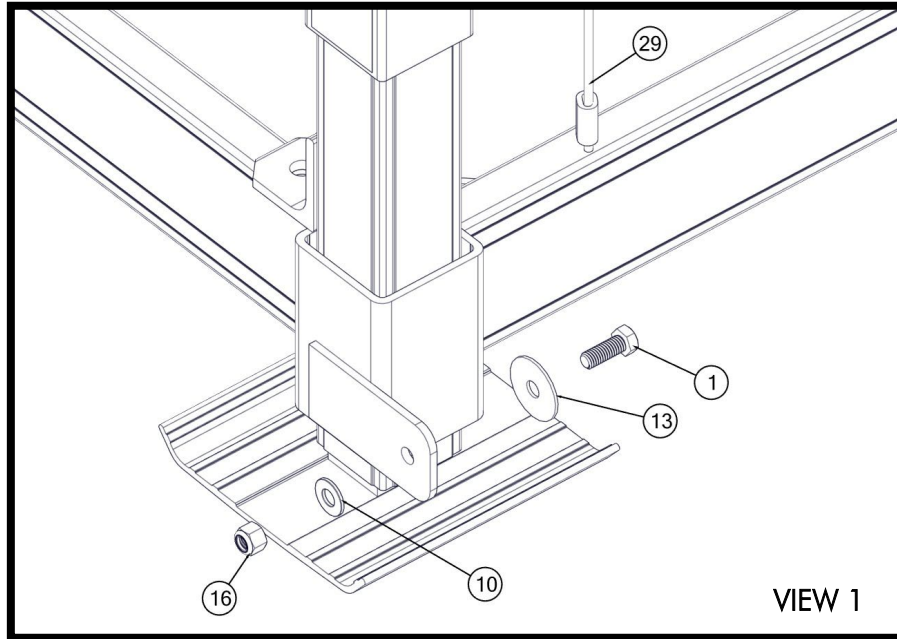
LIFT P/N 511-16080-00



NOTE:
ADDITIONAL VIEWS
ON PAGES 20 & 21

V1600 PWC LIFT FRAME EXPLODED VIEWS 1-4

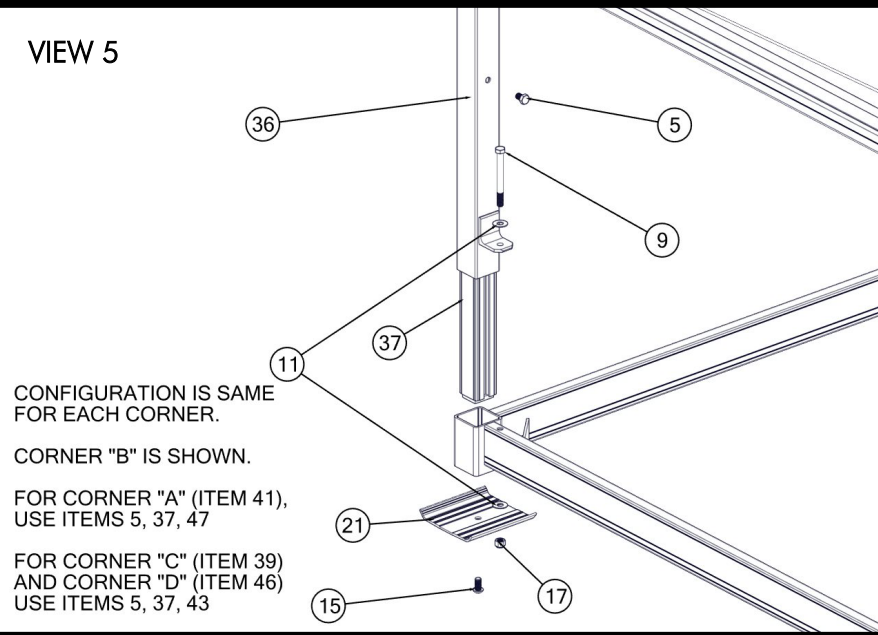
LIFT P/N 511-16080-00



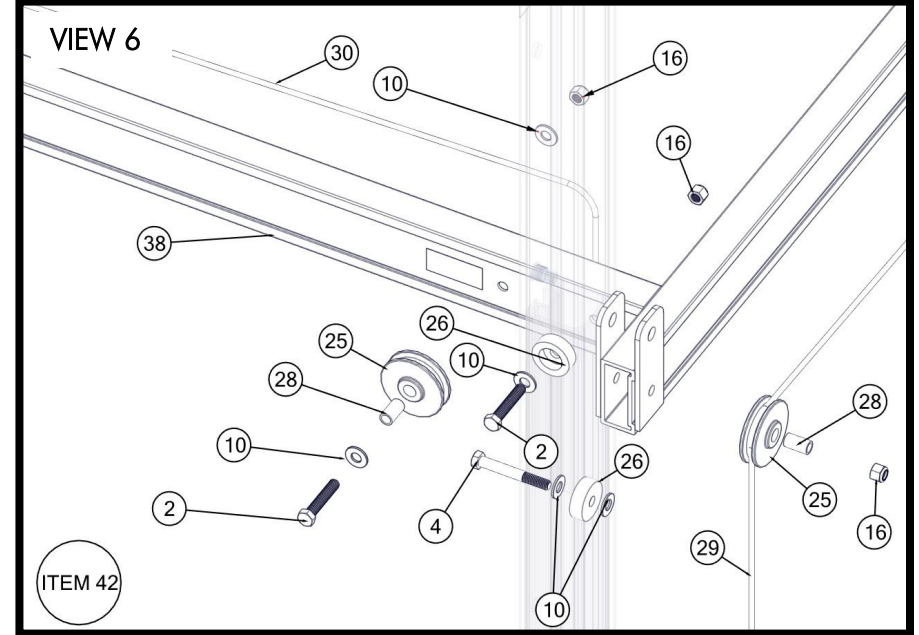
V1600 PWC LIFT FRAME EXPLODED VIEWS 5-7

LIFT P/N 511-16080-00

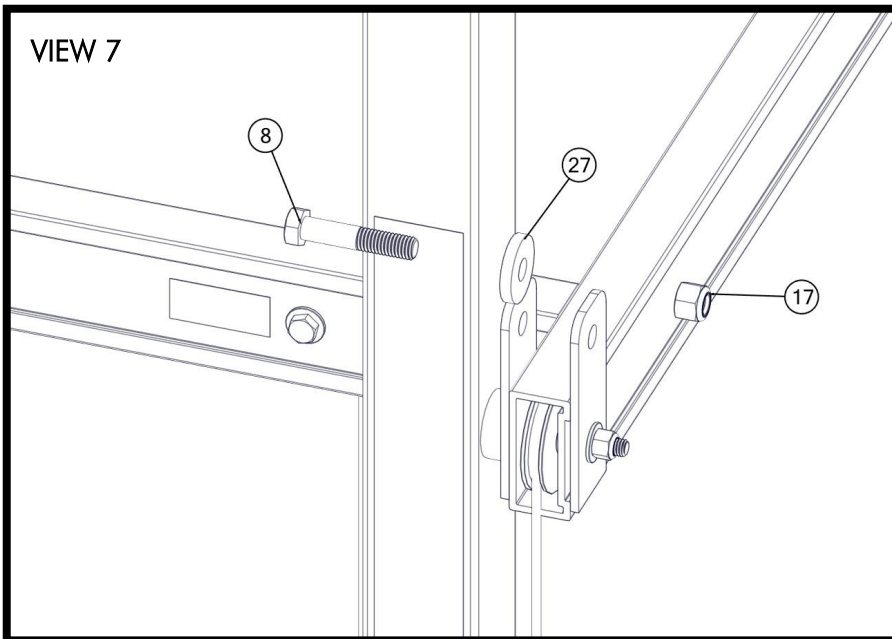
VIEW 5



VIEW 6

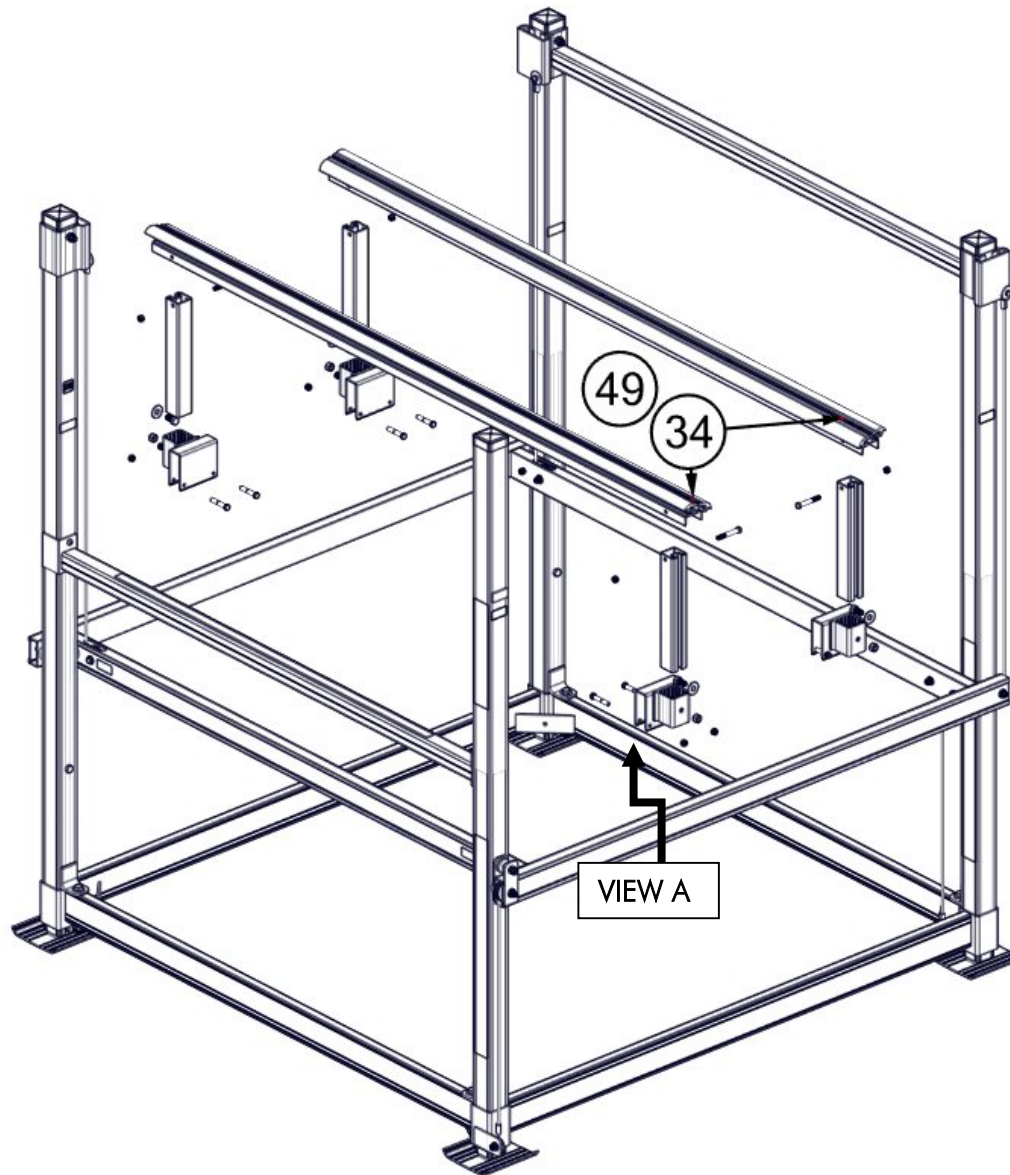


VIEW 7



V1600 PWC LIFT FRAME EXPLODED VIEW MAIN 2

LIFT P/N 511-16080-00

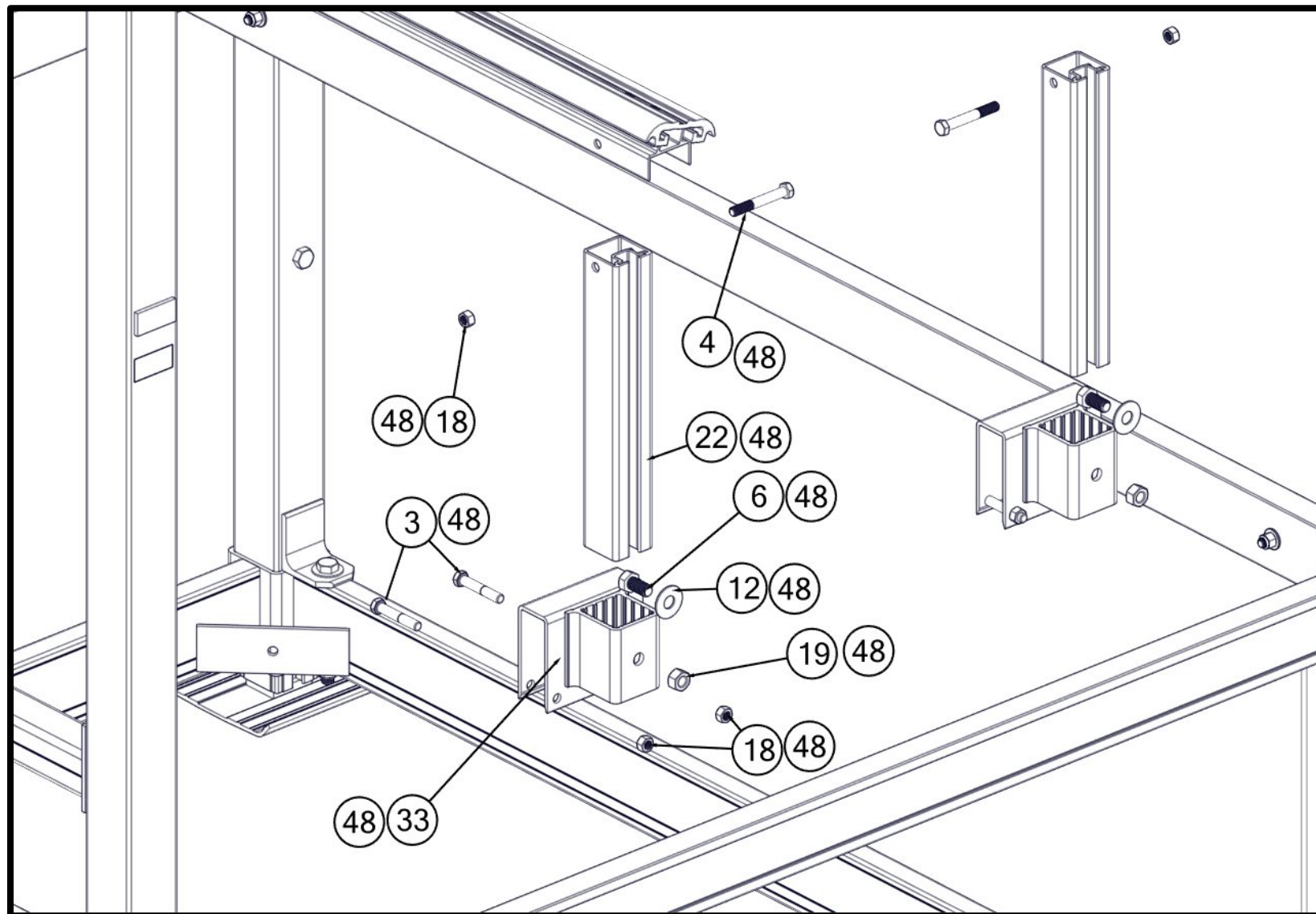


NOTE:

ADDITIONAL VIEW
ON PAGE 23

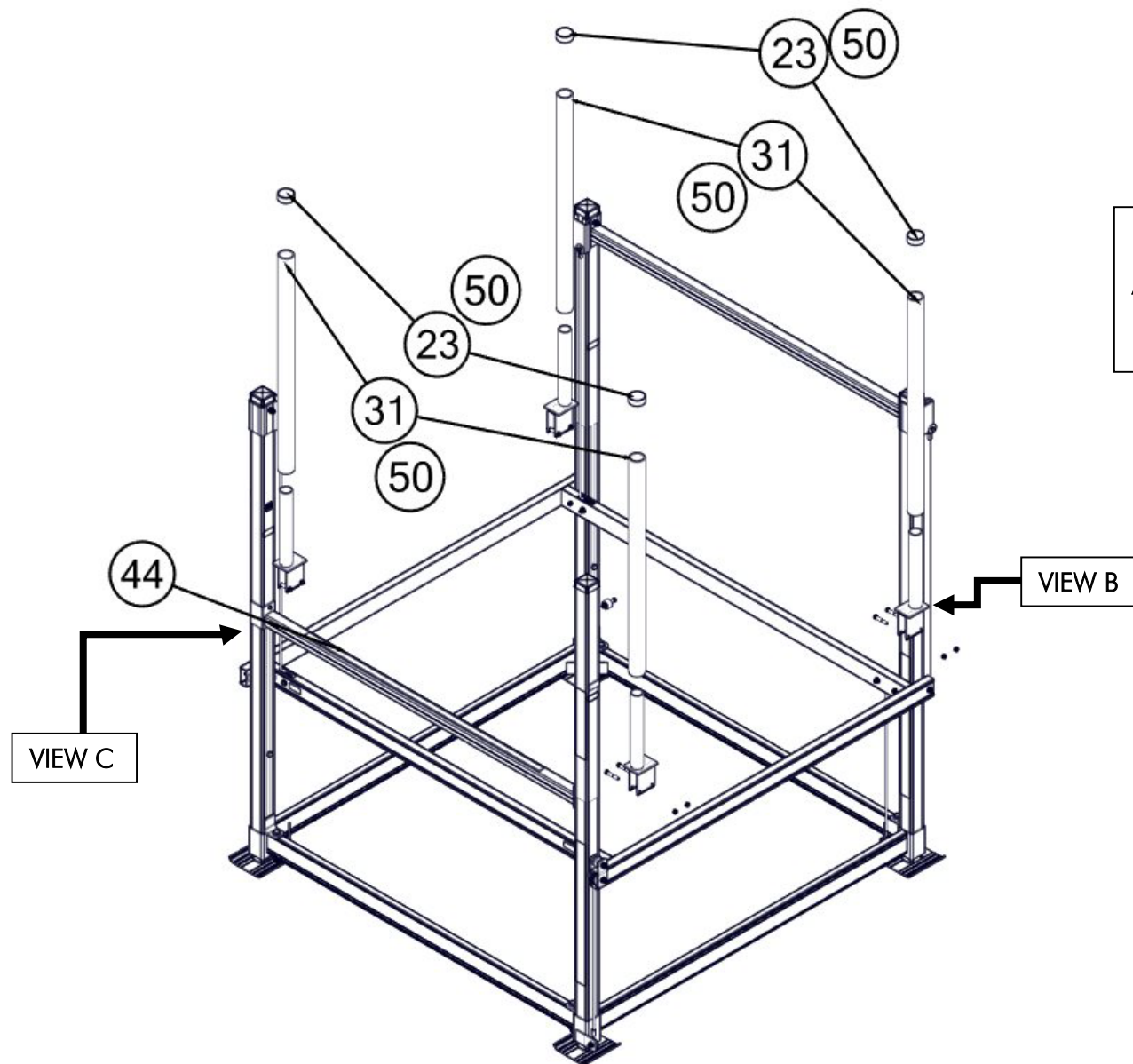
V1600 PWC LIFT FRAME EXPLODED VIEW A

LIFT P/N 511-16080-00



V1600 PWC LIFT FRAME EXPLODED VIEW MAIN 3

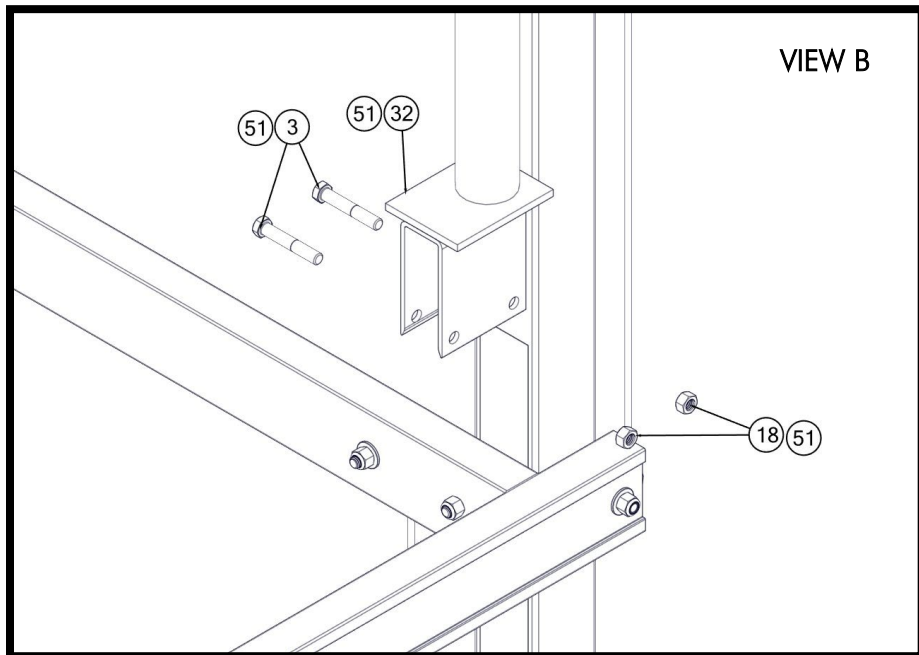
LIFT P/N 511-16080-00



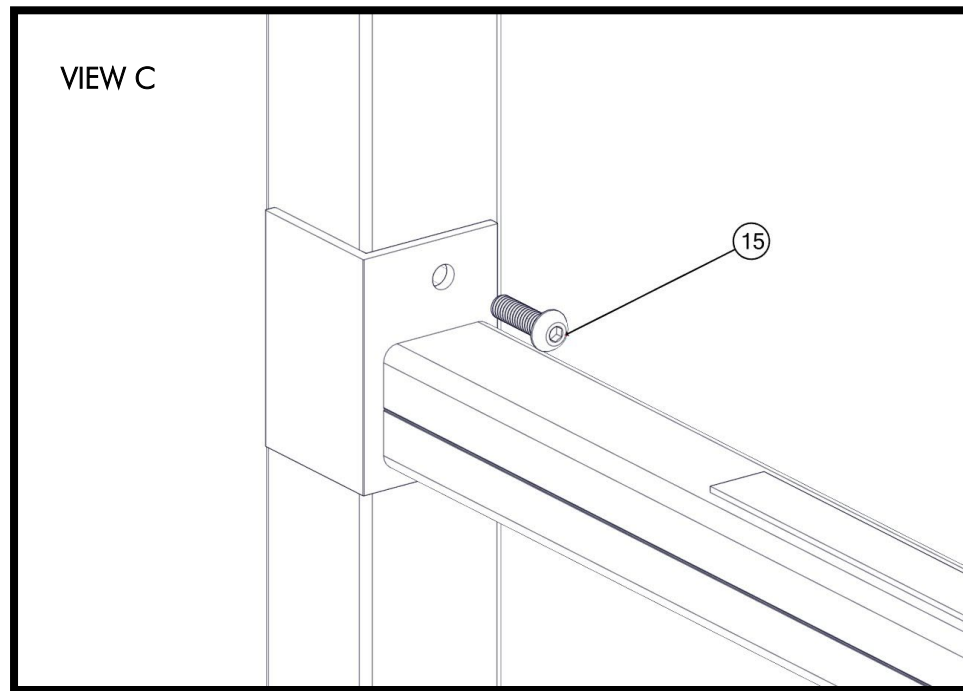
V1600 PWC LIFT FRAME EXPLODED VIEW B & C

LIFT P/N 511-16080-00

VIEW B



VIEW C



NOTES

