

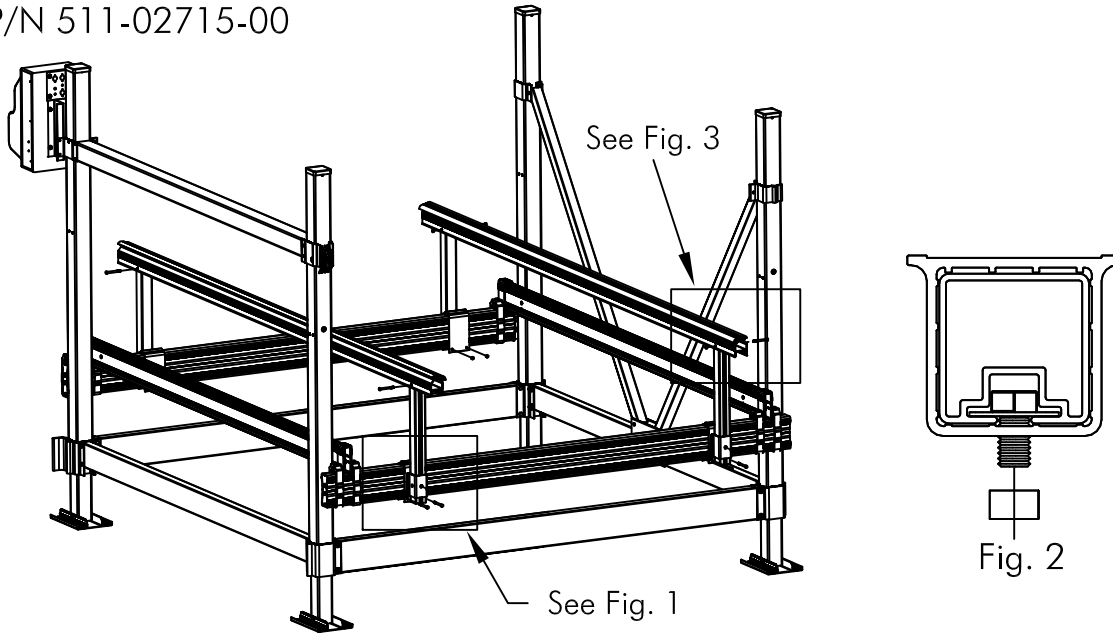
FLOE INTERNATIONAL INC.

ASSEMBLY INSTRUCTIONS FOR

VSD 6000-7500 FULL LENGTH BUNKS

KIT P/N 511-02715-00

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1. Insert a 5/8" x 1" bolt and flat washer thru the inside of each of the support tube pockets. Slide the support tubes into the pockets so the bolt head and flat washer slide into the track of the support tube as shown in Fig. 2. Adjust height and torque to 70 ft. lbs. See Fig. 1.
2. Attach the tube clamp bracket to the cradle beam using the 3/8" x 4" bolts and nuts. See Fig. 1. Once you have placed the brackets in their final location, torque bolts to 35 ft. lbs.
3. Clamp the bunks to the tubes using the 3/8" x 3 3/4" bolts and nuts. See Fig. 3. Torque to 35 ft. lbs.
4. Adjust bunk location and height as required and re-torque all bolts.

After the correct adjustment, support tube may need to be cut to allow ground clearance in shallow water.

