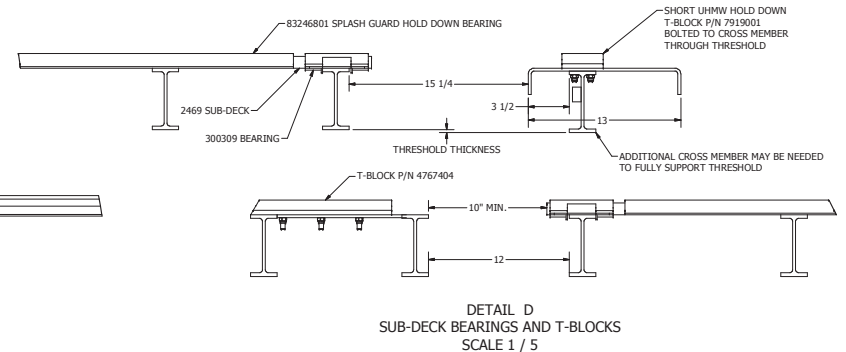
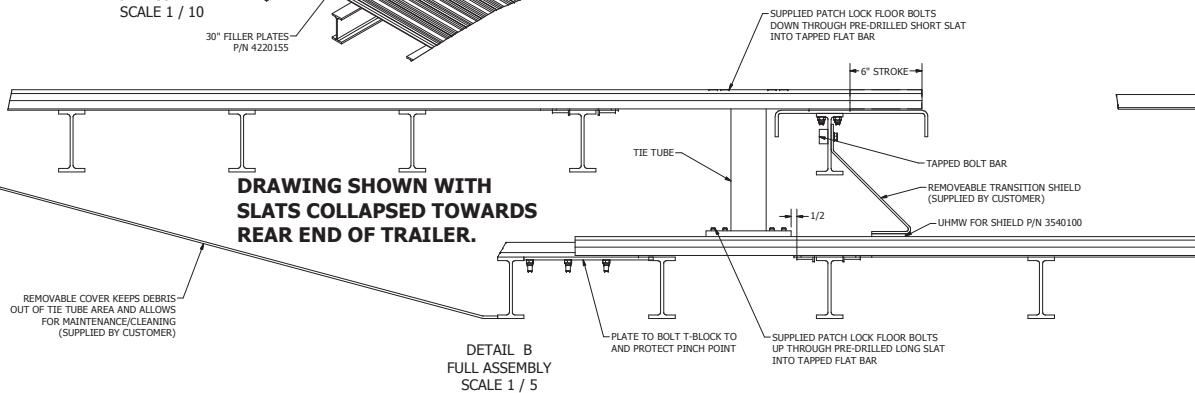
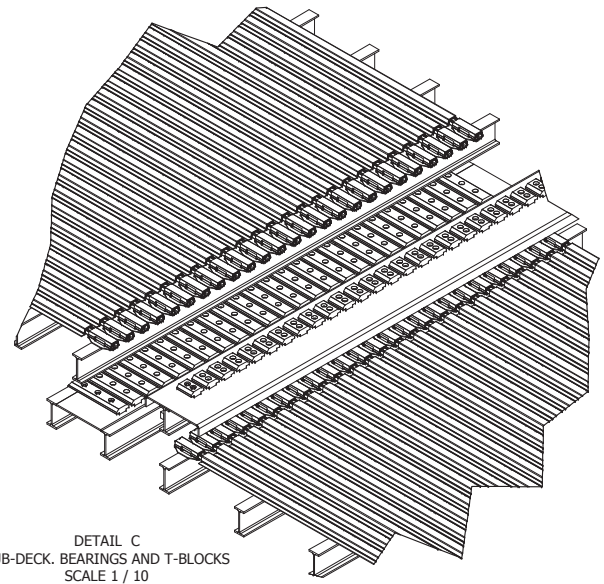
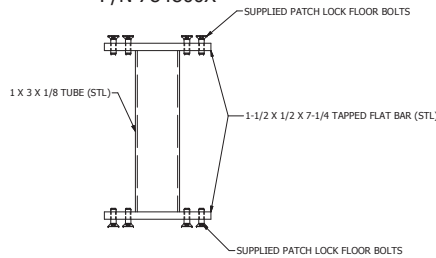
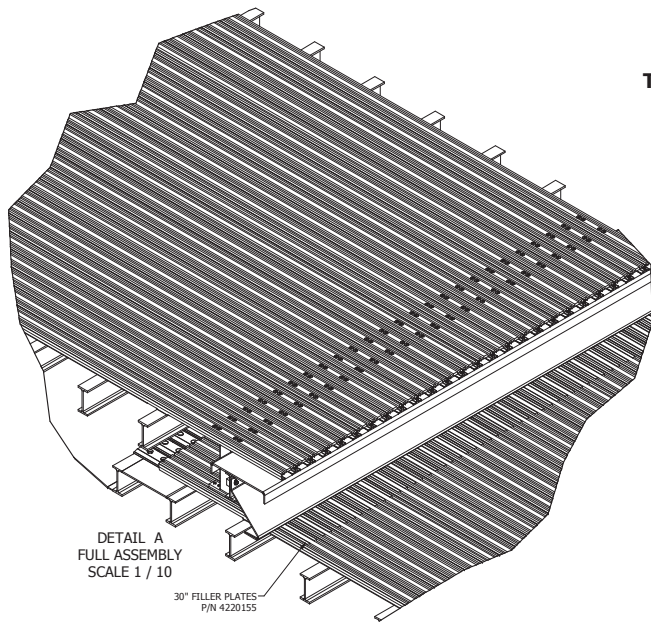


**STANDARD 3.5" FLOORING DROP DECK  
FLOOR SLATS COME PRE-DRILLED  
TO MATCH TAPPED HOLES IN TIE TUBE ASSEMBLY  
FLOOR INSTALLATION FOR A 6" STROKE  
SUB-DECK ALIGNMENT IS CRITICAL**

THIS SHOULD BE CHECKED WITH A PLUMB BOB OR LASER LEVEL.

**TIE TUBE ASSEMBLY  
COMES FULLY WELDED AND PAINTED  
WITH TAPPED HOLES FOR PATCH LOCK BOLTS  
P/N 784800X**



**INSTALLATION INSTRUCTIONS (SEE KEITH KRFII INSTALLATION MANUAL FOR ADDITIONAL INFORMATION):**

1. FABRICATE A BOLT BAR AND THRESHOLD TO WELD TO THE LAST UPPER CROSS MEMBER IN THE TRANSITION AREA. DRILL CROSS MEMBER ALIGNED WITH THE BOLT BAR FOR SHIELD.
2. INSTALL CROSS MEMBERS AND THRESHOLD AS SHOWN IN DETAIL D. LEAVE A GAP FOR THE TIE TUBE AND STROKE. UPPER CROSS MEMBERS AND THRESHOLD ARE ATTACHED TO THE WALLS WITH SUPPORTS.
3. INSTALL THE SUB-DECK, T-BLOCKS AND BEARINGS LEAVING THE SAME GAP FOR THE TIE TUBE AND STROKE.
4. INSTALL LOWER SLATS WITH PRE-DRILLED HOLES TOWARDS THE FRONT END OF THE TRAILER. DO NOT DRILL OR ATTACH SLATS TO DRIVE SHOES YET.
5. BOLT TIE TUBES TO LOWER SLATS THROUGH TAPPED HOLES WITH PATCH LOCK FLOOR BOLTS. TORQUE BOLTS.
6. ATTACH LOWER SLATS TO DRIVE SHOES (KRFII INSTALLATION MANUAL). LEAVE 1/2" GAP BETWEEN END OF LOWER FLAT BAR AND 300309 BEARING.
7. INSTALL UPPER LEVEL SLATS WITH HOLES OVER THE TRANSITION OF TRAILER. UPPER SLATS EXTEND AT LEAST 6" PAST THE END OF SHORT T-BLOCKS.
8. LOOK THROUGH PRE-DRILLED SLAT HOLES AND CHECK THAT FLAT BAR HOLES ARE ALIGNED WITH THE SLAT HOLES.
9. BOLT UPPER SLATS TO FLAT BAR WITH PATCH LOCK FLOOR BOLTS. TORQUE BOLTS.
10. FABRICATE A REMOVABLE TRANSITION SHIELD THAT BOLTS INTO THE BOLT BAR ON THE LAST CROSS MEMBER.
11. FABRICATE A REMOVABLE COVER TO KEEP DEBRIS OUT OF THE TIE TUBE AREA AND ALLOW ACCESS FOR MAINTENANCE.

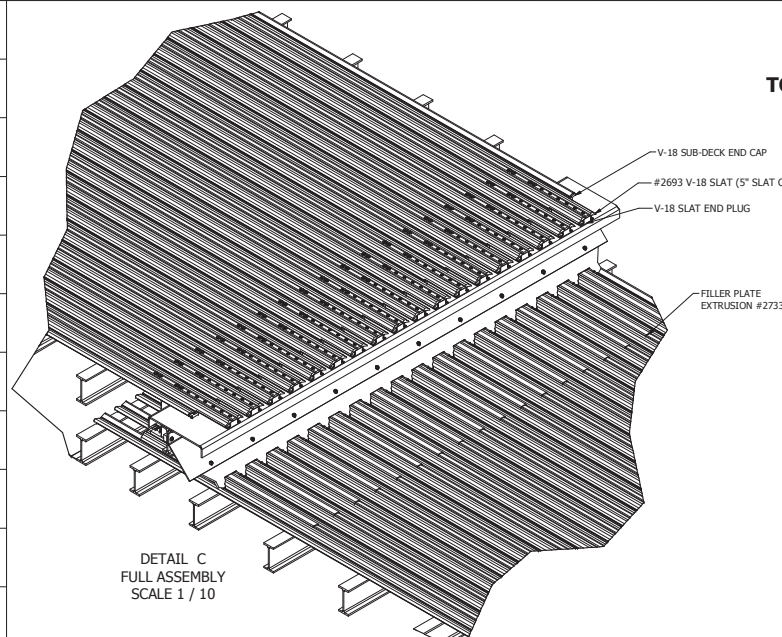
ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
C	3		UPDATED NOTES FOR PATCH LOCK BOLTS	BCN	9/9/14
B	2		ADDED THRESHOLD AND LOWERED X-MEM UNDER IT	BCN	8/9/13

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED		TOLERANCES UNLESS OTHERWISE NOTED		REVISION HISTORY	
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:			
SAW CUT LENGTH:	QUANTITY:	P.O. BOX 1, MADRAS, OR 97741 PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169		SCALE: SHEET 1 OF 1 DATE: 3/25/2013 DRAWN BY: BCN APPROVD BY:	
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1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35

**V-18 DROP DECK FLOORING  
FLOOR SLATS COME PRE-DRILLED  
TO MATCH TAPPED HOLES IN TIE TUBE ASSEMBLY  
INSTALLATION (6" STROKE)  
SUB-DECK ALIGNMENT IS CRITICAL**

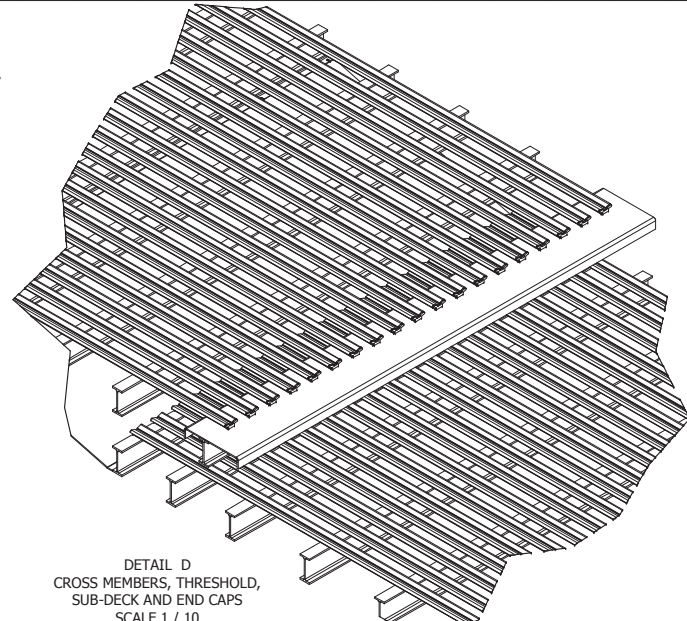
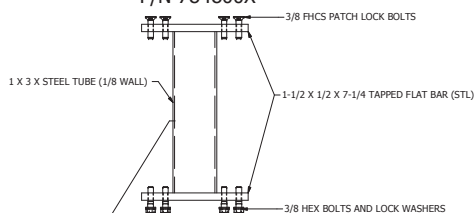
THIS SHOULD BE CHECKED WITH A PLUMB BOB OR LASER LEVEL.



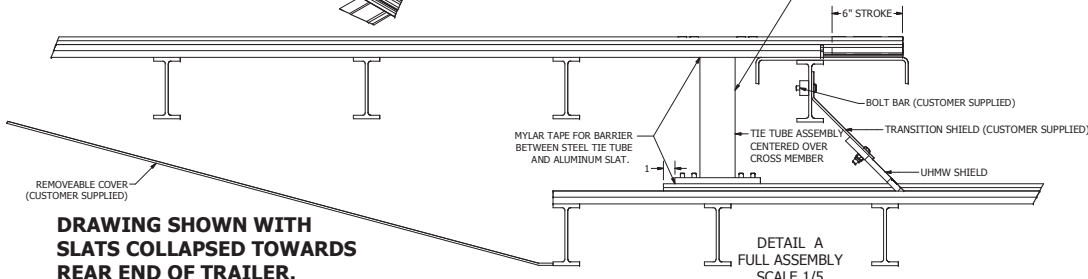
DETAIL C  
FULL ASSEMBLY  
SCALE 1 / 10

**TIE TUBE ASSEMBLY  
COMES FULLY WELDED AND PAINTED  
WITH TAPPED HOLES FOR BOLTS**

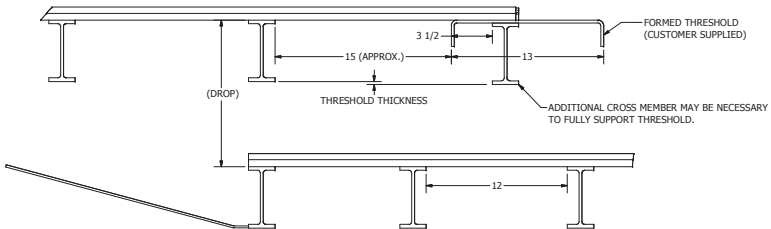
P/N 784800X



DETAIL D  
CROSS MEMBERS, THRESHOLD,  
SUB-DECK AND END CAPS  
SCALE 1 / 10



DETAIL A  
FULL ASSEMBLY  
SCALE 1/5



DETAIL B  
CROSS MEMBERS, THRESHOLD  
SUB-DECK AND J-BEARINGS  
SCALE 1 / 5

**DRAWING SHOWN WITH  
SLATS COLLAPSED TOWARDS  
REAR END OF TRAILER.**

**INSTALLATION INSTRUCTIONS (SEE KEITH KRFII INSTALLATION MANUAL AND V-18 INSTALLATION DRAWINGS FOR ADDITIONAL INFORMATION)**

1. FABRICATE A THRESHOLD THAT WELDS TO THE WALLS AND LAST CROSS MEMBER ON THE UPPER LEVEL.
2. INSTALL CROSS MEMBERS AND THRESHOLD AS SHOWN IN DETAIL B LEAVING A GAP FOR THE TIE TUBE AND STROKE.
- THE CROSS MEMBER UNDER THE THRESHOLD MUST BE LOW ENOUGH SO THE TOP OF THE THRESHOLD IS FLUSH WITH THE OTHER UPPER CROSS MEMBERS.**
3. INSTALL THE SUB-DECK AND SUB-DECK END CAPS.
4. INSTALL LOWER SLATS WITH PRE-DRILLED HOLES TOWARDS THE FRONT END OF THE TRAILER. DO NOT DRILL OR ATTACH SLATS TO DRIVE SHOES YET.
5. USE 3/8 HEX BOLTS AND LOCK WASHERS TO BOLT TIE TUBES TO LOWER SLATS WITH TAPE BARRIER BETWEEN. TORQUE TO 45 FT. LBS.
6. ATTACH LOWER SLATS TO DRIVE SHOES (KRFII INSTALLATION MANUAL). CENTER TIE TUBE OVER X-MEMBER FOR BOLT ACCESS.
7. INSTALL UPPER LEVEL SLATS WITH HOLES OVER THE TRANSITION AREA. UPPER SLATS EXTEND 7" PAST THE END OF THE SUB-DECK.
8. LOOK THROUGH PRE-DRILLED SLAT HOLES AND CHECK THAT THE TAPPED FB HOLES LINE UP WITH THE SLAT HOLES.
9. BOLT UPPER SLAT TO TIE TUBE WITH PATCH LOCK BOLTS AND TAPE BARRIER BETWEEN SLAT AND TIE TUBE. TORQUE TO 45 FT. LBS.
10. FABRICATE A REMOVABLE SHIELD AND A BOLT BAR TO BOLT TO THE LAST CROSS MEMBER.
11. FABRICATE A REMOVABLE COVER TO KEEP DEBRIS OUT OF THE TIE TUBE AREA AND ALLOW ACCESS FOR MAINTENANCE.

B	2	UPDATED NOTES FOR PATCH LOCK BOLTS		BCN	9/9/14
A	1	CHANGED THRESHOLD AND SHIELD TO MATCH STANDARD FLOORING		BCN	8/9/13
ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY					
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED					
TOLERANCES UNLESS OTHERWISE NOTED					
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:			
SAW CUT LENGTH:	QUANTITY:				
PROPRIETARY NOTICE					
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SCALE:	DATE: 7/12/2013	SHEET 1 OF 1	DRAWN BY: BCN		
INSTALLATION DRAWING FOR DROP DECK FLOORING WITH TIE TUBE			APPROVD BY:		
V-18 DROP DECK					DWG NUMBER: D-80245 B

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35