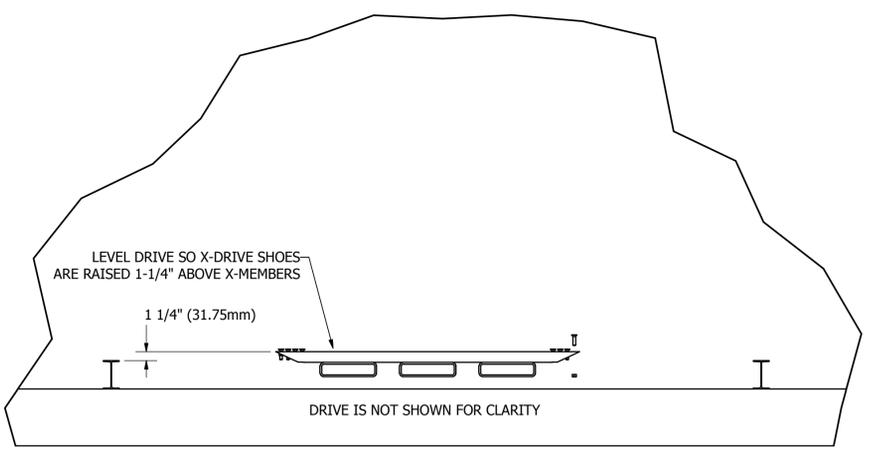


DETAIL A
SCALE 1 / 8



DETAIL B
SCALE 1 / 12

1) INSTALL HYDRAULIC DRIVE AS TYPICAL KRFII OR KFD DRIVE UNIT. MAKE SURE TOP OF SHOE IS 1-1/4" (31.75mm) ABOVE TOP OF X-MEMBER. IF NEEDED SHIM DRIVE TO THE CORRECT HEIGHT.

NOTE: DRIVE INSTALLATION INSTRUCTIONS CAN BE VIEWED AT WWW.KEITHWALKINGFLOOR.COM.

2) COLLAPSE ALL CYLINDERS TO THE DISCHARGE END OF TRAILER.

NOTE: TRAILER WALLS NEED TO BE EITHER STRAIGHT OR TAPERED SO THAT THE TRAILER IS WIDER AT THE DISCHARGE END. THERE SHOULD BE NO RESTRICTIONS THAT MAY HINDER THE FLOW OF MATERIAL.

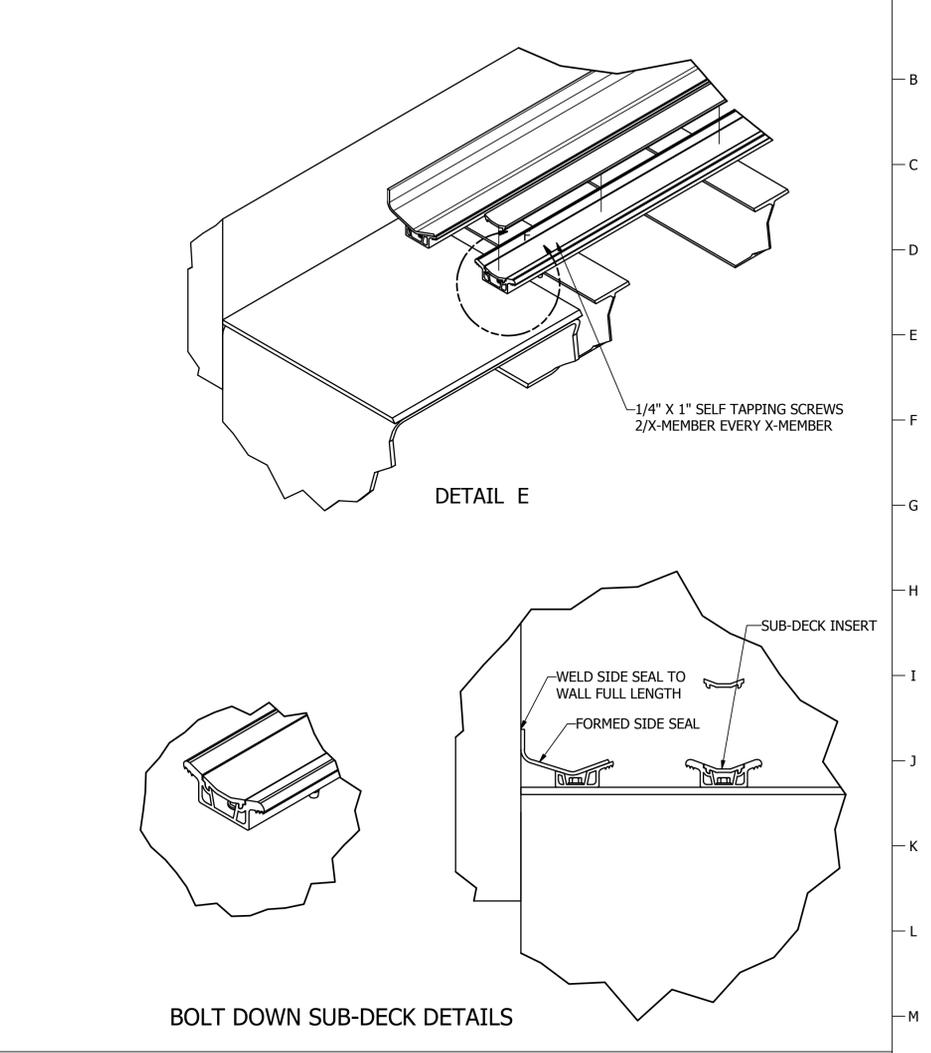
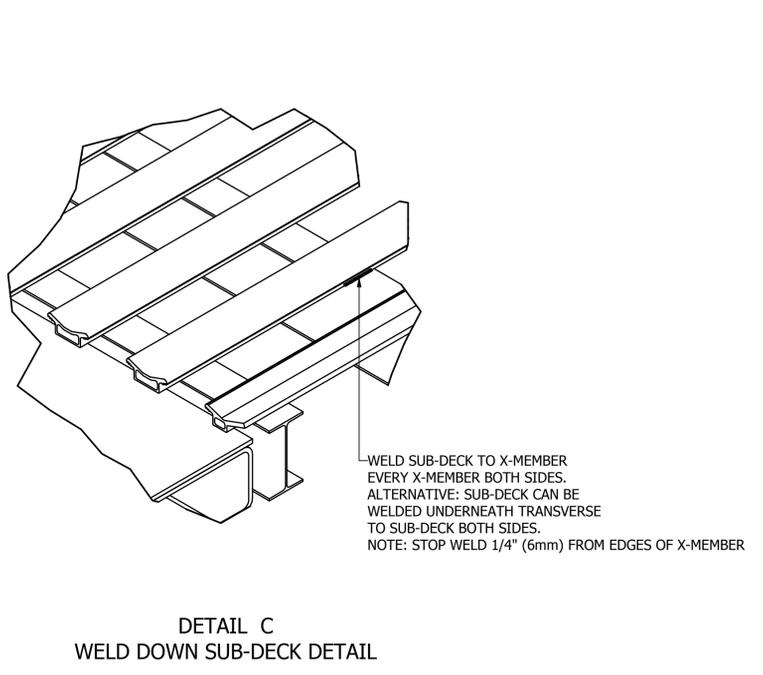
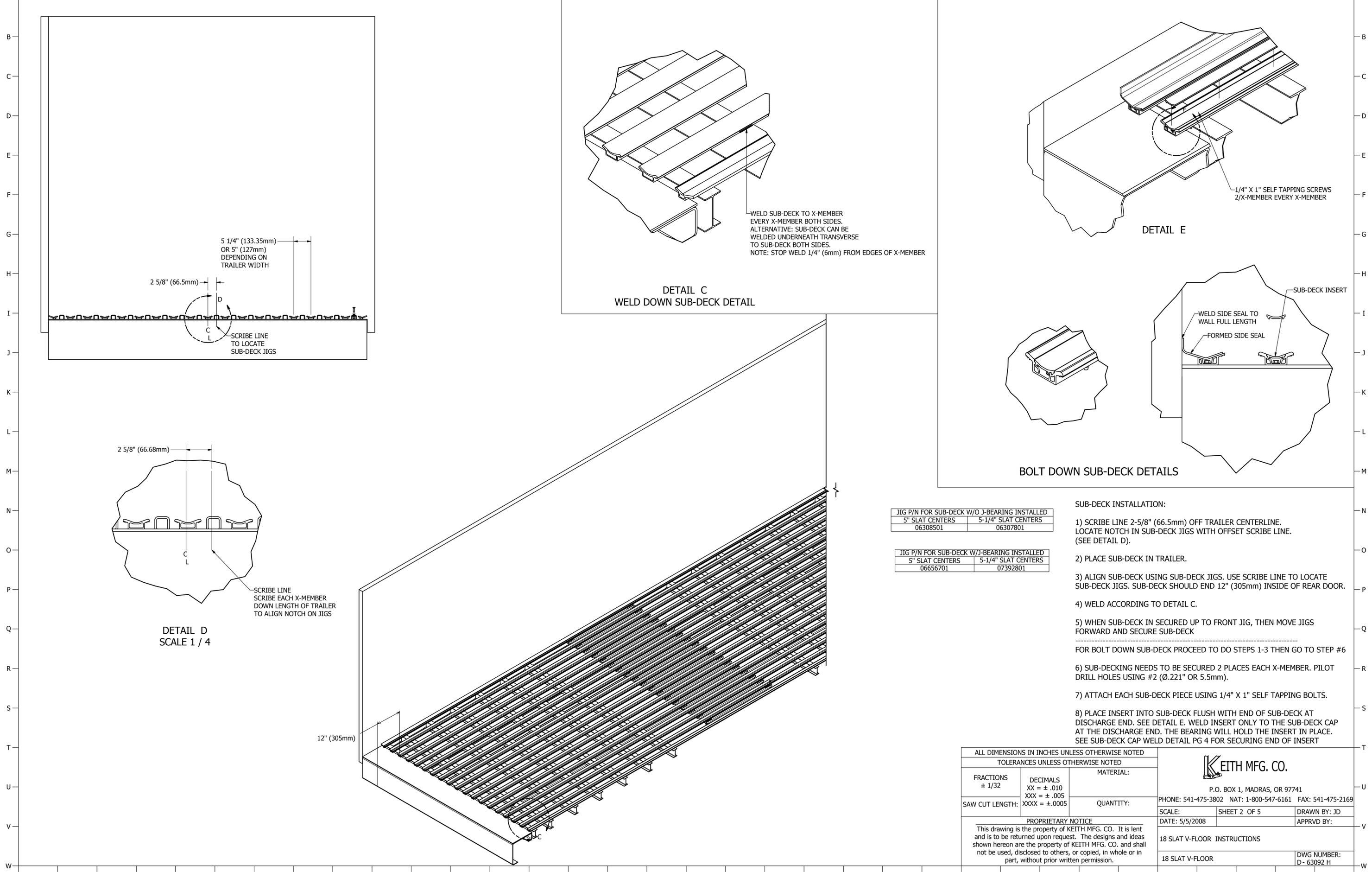
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED		
TOLERANCES UNLESS OTHERWISE NOTED		
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:
SAW CUT LENGTH:		QUANTITY:
<p>PROPRIETARY NOTICE This drawing is the property of KEITH MFG. CO. It is lent and is to be returned upon request. The designs and ideas shown hereon are the property of KEITH MFG. CO. and shall not be used, disclosed to others, or copied, in whole or in part, without prior written permission.</p>		

KEITH MFG. CO.
P.O. BOX 1, MADRAS, OR 97741
PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169

SCALE:	SHEET 1 OF 5	DRAWN BY: JD
DATE: 5/5/2008		APPRVD BY:

18 SLAT V-FLOOR INSTRUCTIONS
18 SLAT V-FLOOR DWG NUMBER: D- 63092 H

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

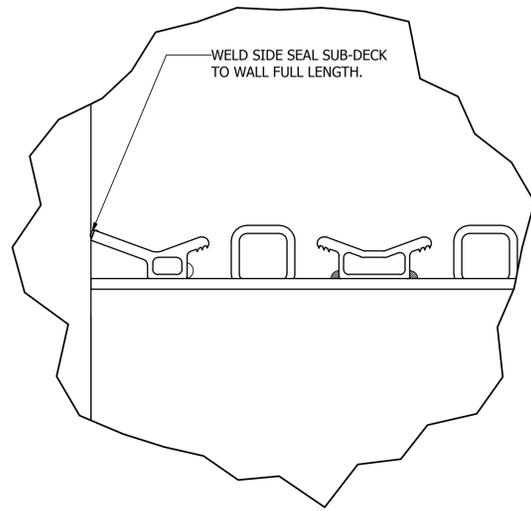


JIG P/N FOR SUB-DECK W/O J-BEARING INSTALLED	
5\"/>	

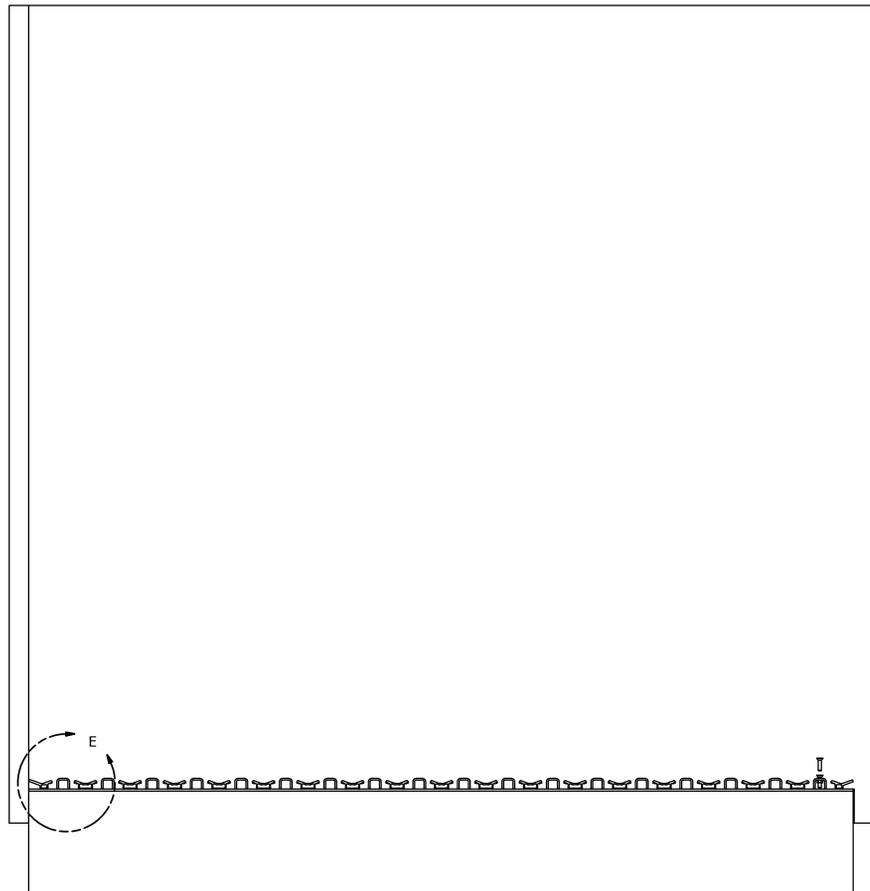
- SUB-DECK INSTALLATION:**
- 1) SCRIBE LINE 2-5/8\"/>

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED			<p>P.O. BOX 1, MADRAS, OR 97741 PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169</p>		
TOLERANCES UNLESS OTHERWISE NOTED					
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:	SCALE:	SHEET 2 OF 5	DRAWN BY: JD
SAW CUT LENGTH:		QUANTITY:	DATE: 5/5/2008		APPRVD BY:
PROPRIETARY NOTICE This drawing is the property of KEITH MFG. CO. It is lent and is to be returned upon request. The designs and ideas shown hereon are the property of KEITH MFG. CO. and shall not be used, disclosed to others, or copied, in whole or in part, without prior written permission.			18 SLAT V-FLOOR INSTRUCTIONS DWG NUMBER: D-63092 H		

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



DETAIL E
SCALE 1 / 2



DISCHARGE END DETAIL

1) FOR ALUMINUM THRESHOLD, WEAR PLATE MUST BE INSTALLED ON TOP OF THRESHOLD. IF WEAR PLATE IS BOLTED, SECURELY FASTEN WITH COUNTERSUNK BOLTS JUST BELOW FLUSH AND BETWEEN THE SLAT RUNNING AREAS. IF BOLT HEADS ARE ABOVE WEAR PLATE OR IN THE SLAT TRAVEL PATH, PREMATURE WEAR AND FAILURE OF SLATS AND PLUG BEARING WILL RESULT.

2) IF THRESHOLD WEAR PLATE IS WELDED, PROVIDE ENOUGH WELDS TO PREVENT WARPING, AND PROVIDE A SMOOTH AREA FOR THE SLAT BEARING PLUGS TO RIDE. SAND WELDS SMOOTH THAT MAY COME IN CONTACT WITH THE MOVING SLAT OR PLUG BEARING.

3) WELD SIDE SEAL SUB-DECKING TO WALL. THIS SHOULD BE DONE WITH SEVERAL STITCH WELDS TO KEEP FROM CONCENTRATING THE HEAT IN ONE AREA.

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:

KEITH MFG. CO.

P.O. BOX 1, MADRAS, OR 97741

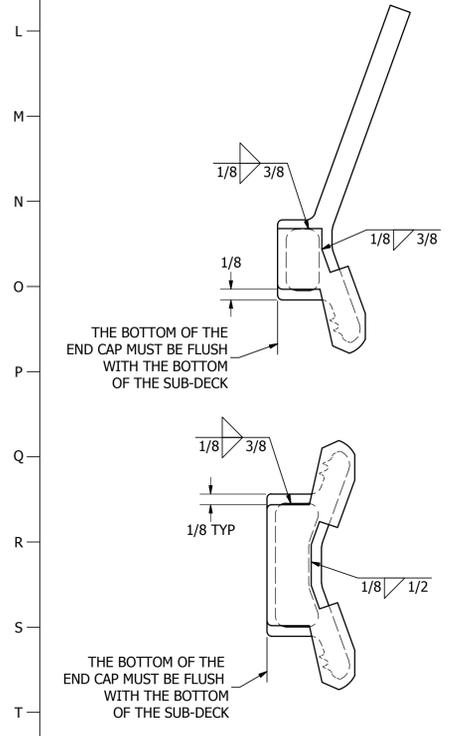
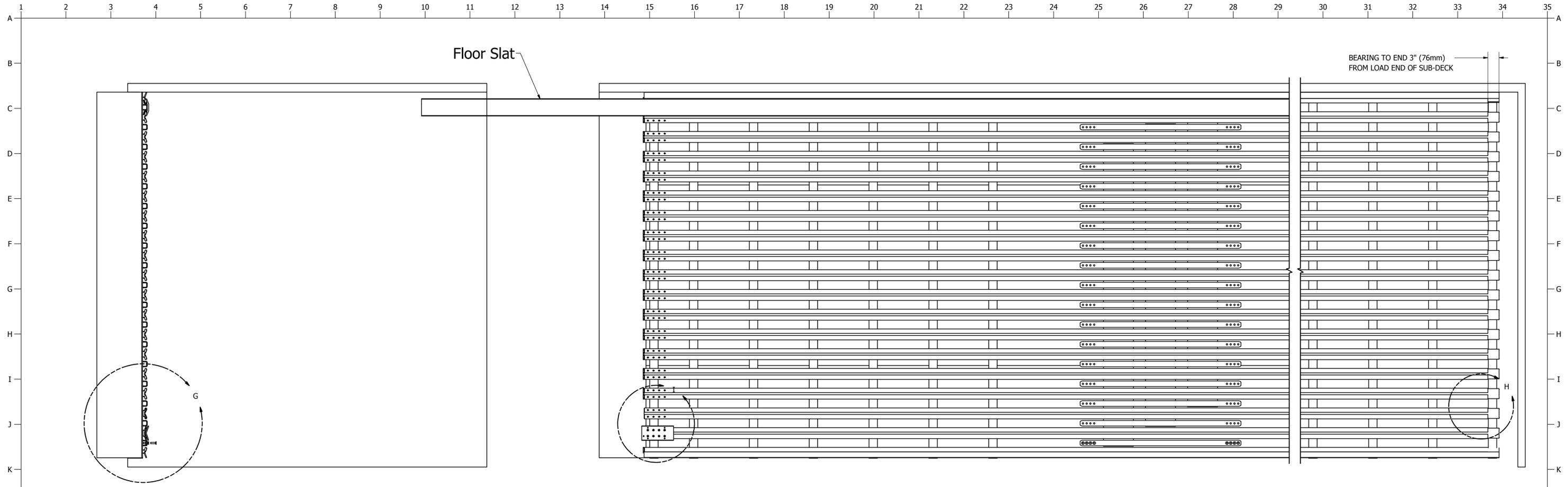
PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169

SCALE:	SHEET 3 OF 5	DRAWN BY: JD
DATE: 5/5/2008		APPRVD BY:

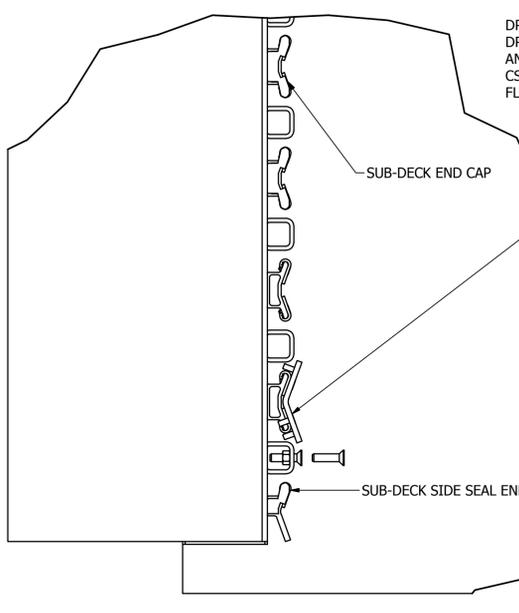
PROPRIETARY NOTICE
This drawing is the property of KEITH MFG. CO. It is lent and is to be returned upon request. The designs and ideas shown hereon are the property of KEITH MFG. CO. and shall not be used, disclosed to others, or copied, in whole or in part, without prior written permission.

18 SLAT V-FLOOR INSTRUCTIONS

18 SLAT V-FLOOR	DWG NUMBER: D- 63092 H
-----------------	---------------------------

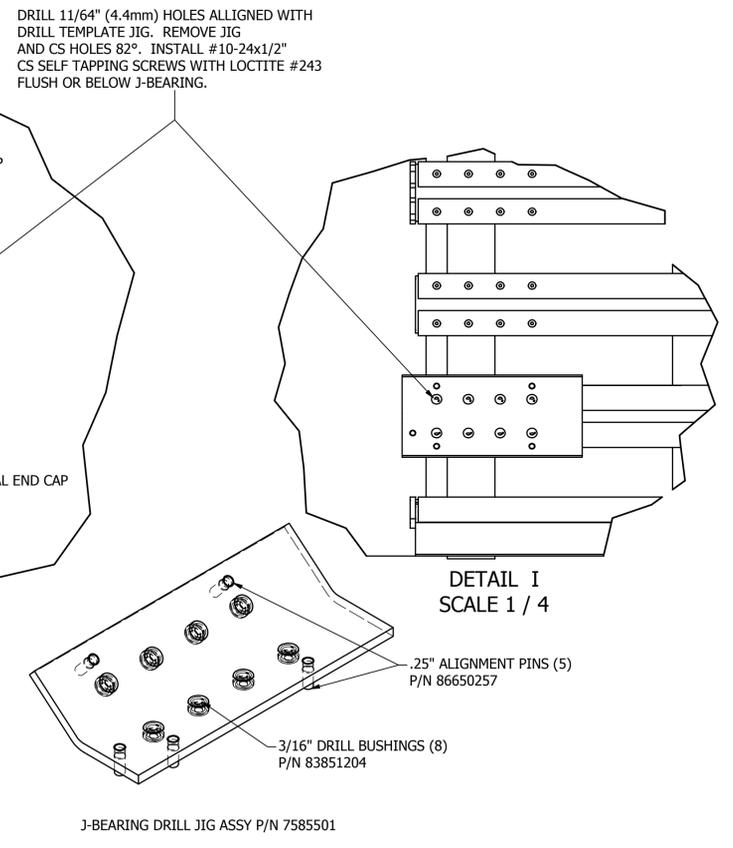


DISCHARGE END OF TRAILER



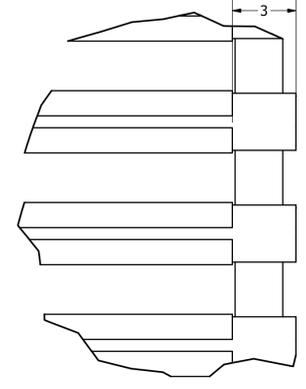
DETAIL G
SCALE 1 / 4

DISCHARGE END OF TRAILER



DETAIL I
SCALE 1 / 4

LOAD END OF TRAILER



DETAIL H
SCALE 1 / 4

FOR SLATS WITH J-BEARING ALREADY INSTALLED SKIP STEPS 1 - 3.

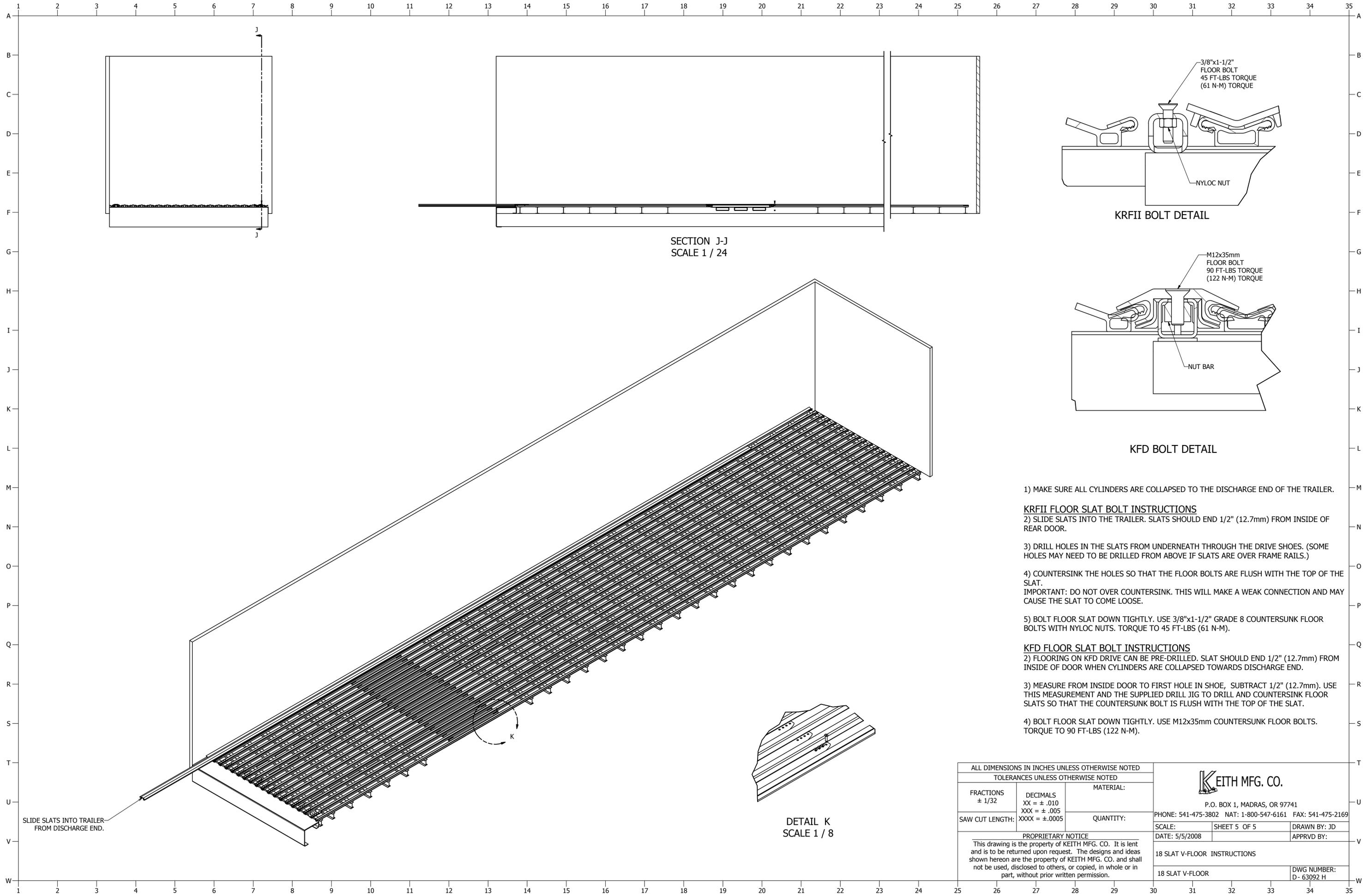
- 1) UNCOIL AND LAY J-BEARING FLAT IN A WARM ROOM AT LEAST 24 HOURS PRIOR TO INSTALLATION. TO INSTALL THE J-BEARING ONTO THE SUB-DECK, START AT THE LOAD END OF THE TRAILER AND POSITION (2) J-BEARING PIECES (1) ON EACH SIDE OF THE SUB-DECKING. THE J-BEARING NEEDS TO END 3"(50mm) FROM THE LOAD END OF THE SUB-DECK TO ALLOW FOR EXPANSION AND CONTRACTION WITH TEMPERATURE DIFFERENCES. HAMMER ON THE BEARING 2' (600mm) TO GET EACH PIECE STARTED. USE INSTALLER TOOL P/N 63484 TO FULLY INSTALL THE BEARING PULLING FROM LOAD TO DISCHARGE END. J-BEARING MAY NOT EXTEND PAST THE DISCHARGE END TO ALLOW ROOM TO WELD ON END CAPS. NOTE: MAKE SURE BEARING IS MATED TO SUB-DECK. IF BEARING IS NOT ALL OF THE WAY ON, IT MAY CAUSE PROBLEMS WHEN INSTALLING SLATS.
- 2) CONTINUE TO INSTALL J-BEARING PIECES ON EACH PIECE OF SUB-DECKING. THE TWO OUTSIDE MOST PIECES ON THE SIDE SEAL SUB-DECK WILL NEED TO BE INSTALLED FULL LENGTH BY HAMMERING ON EACH PIECE WITH A RUBBER Mallet.
- 3) CLAMP THE DRILL JIG IN PLACE AND DRILL PILOT HOLES THROUGH THE J-BEARING AND SUB-DECK USING THE DRILL TEMPLATE JIG AND A 11/64" (4.4mm) DRILL BIT. LUBRICATING THE DRILL BIT WITH ALUMINUM CUTTING OIL BETWEEN DRILLING HOLES WILL MINIMIZE BROKEN BITS. REMOVE THE JIG AND COUNTERSINK THESE HOLES WITH A 82 ° BIT. INSTALL (4) #10-24x1/2" COUNTERSUNK FH ROLOK SCREWS (KEITH P/N 86404410) AT THE DISCHARGE END OF EACH PIECE OF J-BEARING. USE LOCTITE THREAD RETAINER #243 OR EQUIVALENT. BE SURE THE HEADS OF THE SCREWS ARE FLUSH OR JUST BELOW THE SURFACE OF THE BEARING. THIS SECURES THE BEARING IN PLACE.
- 4) WELD END CAPS ONTO THE DISCHARGE END OF SUB-DECK AND SIDE SEAL SUB-DECK(SEE WELD DETAIL). THESE CAPS PLUG THE SUB-DECK CAVITIES AND ENSURE THE BEARING CAN'T SLIDE OUT THE REAR OF THE TRAILER. MAKE SURE NO WELD IS HIGHER THAN THE TOP SURFACE OF J-BEARING.

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 This drawing is the property of KEITH MFG. CO. It is lent and is to be returned upon request. The designs and ideas shown hereon are the property of KEITH MFG. CO. and shall not be used, disclosed to others, or copied, in whole or in part, without prior written permission.		

KEITH MFG. CO.
P.O. BOX 1, MADRAS, OR 97741
PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169

SCALE:	SHEET 4 OF 5	DRAWN BY: JD
DATE: 5/5/2008		APPRVD BY:

18 SLAT V-FLOOR INSTRUCTIONS
18 SLAT V-FLOOR DWG NUMBER: D- 63092 H



SECTION J-J
SCALE 1 / 24

KRFII BOLT DETAIL

KFD BOLT DETAIL

DETAIL K
SCALE 1 / 8

- 1) MAKE SURE ALL CYLINDERS ARE COLLAPSED TO THE DISCHARGE END OF THE TRAILER.

KRFII FLOOR SLAT BOLT INSTRUCTIONS

- 2) SLIDE SLATS INTO THE TRAILER. SLATS SHOULD END 1/2" (12.7mm) FROM INSIDE OF REAR DOOR.
- 3) DRILL HOLES IN THE SLATS FROM UNDERNEATH THROUGH THE DRIVE SHOES. (SOME HOLES MAY NEED TO BE DRILLED FROM ABOVE IF SLATS ARE OVER FRAME RAILS.)
- 4) COUNTERSINK THE HOLES SO THAT THE FLOOR BOLTS ARE FLUSH WITH THE TOP OF THE SLAT. IMPORTANT: DO NOT OVER COUNTERSINK. THIS WILL MAKE A WEAK CONNECTION AND MAY CAUSE THE SLAT TO COME LOOSE.
- 5) BOLT FLOOR SLAT DOWN TIGHTLY. USE 3/8"x1-1/2" GRADE 8 COUNTERSUNK FLOOR BOLTS WITH NYLOC NUTS. TORQUE TO 45 FT-LBS (61 N-M).

KFD FLOOR SLAT BOLT INSTRUCTIONS

- 2) FLOORING ON KFD DRIVE CAN BE PRE-DRILLED. SLAT SHOULD END 1/2" (12.7mm) FROM INSIDE OF DOOR WHEN CYLINDERS ARE COLLAPSED TOWARDS DISCHARGE END.
- 3) MEASURE FROM INSIDE DOOR TO FIRST HOLE IN SHOE, SUBTRACT 1/2" (12.7mm). USE THIS MEASUREMENT AND THE SUPPLIED DRILL JIG TO DRILL AND COUNTERSINK FLOOR SLATS SO THAT THE COUNTERSUNK BOLT IS FLUSH WITH THE TOP OF THE SLAT.
- 4) BOLT FLOOR SLAT DOWN TIGHTLY. USE M12x35mm COUNTERSUNK FLOOR BOLTS. TORQUE TO 90 FT-LBS (122 N-M).

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED			 P.O. BOX 1, MADRAS, OR 97741 PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169		
TOLERANCES UNLESS OTHERWISE NOTED					
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:	SCALE:	SHEET 5 OF 5	DRAWN BY: JD
SAW CUT LENGTH:		QUANTITY:	DATE: 5/5/2008		APPRVD BY:
PROPRIETARY NOTICE This drawing is the property of KEITH MFG. CO. It is lent and is to be returned upon request. The designs and ideas shown hereon are the property of KEITH MFG. CO. and shall not be used, disclosed to others, or copied, in whole or in part, without prior written permission.			18 SLAT V-FLOOR INSTRUCTIONS 18 SLAT V-FLOOR		
				DWG NUMBER: D- 63092 H	