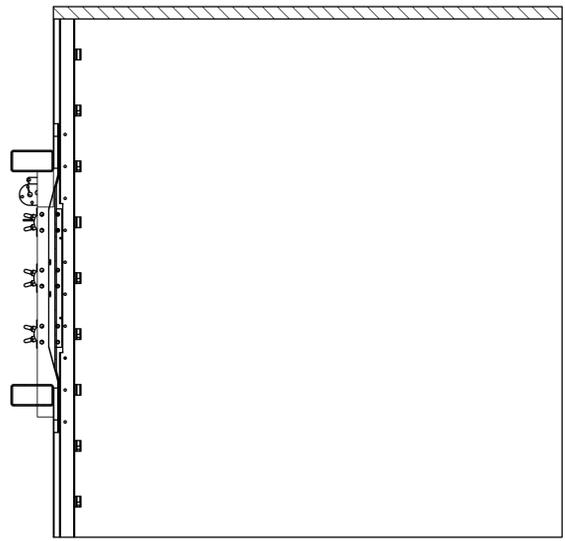
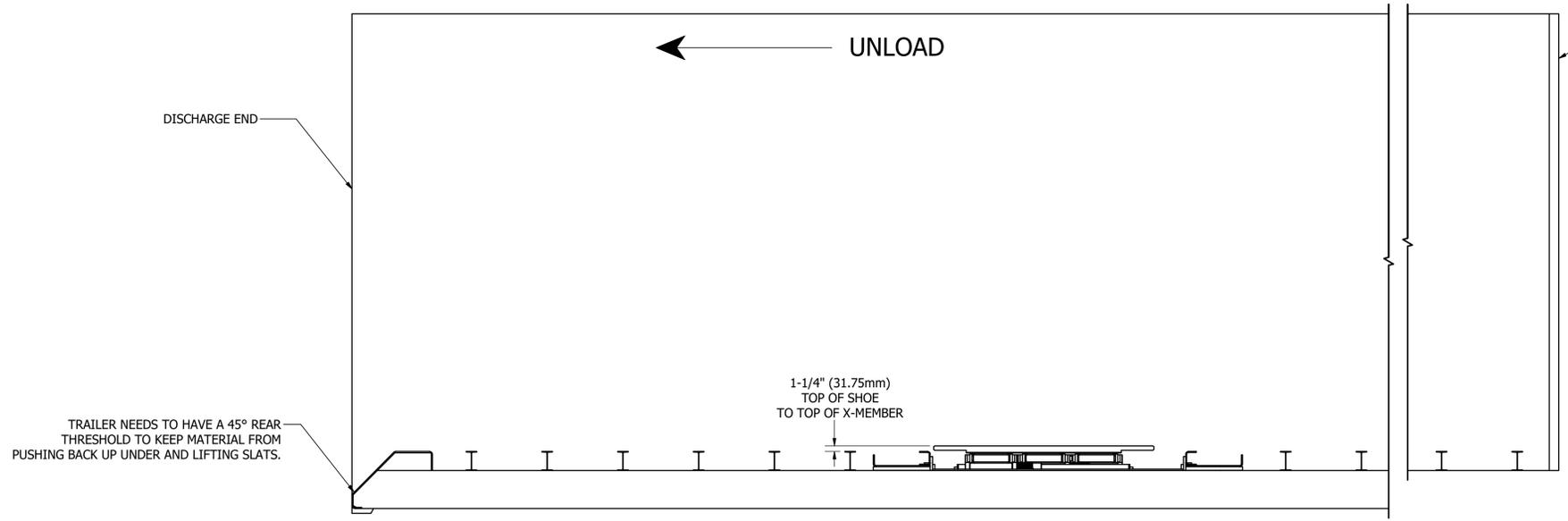
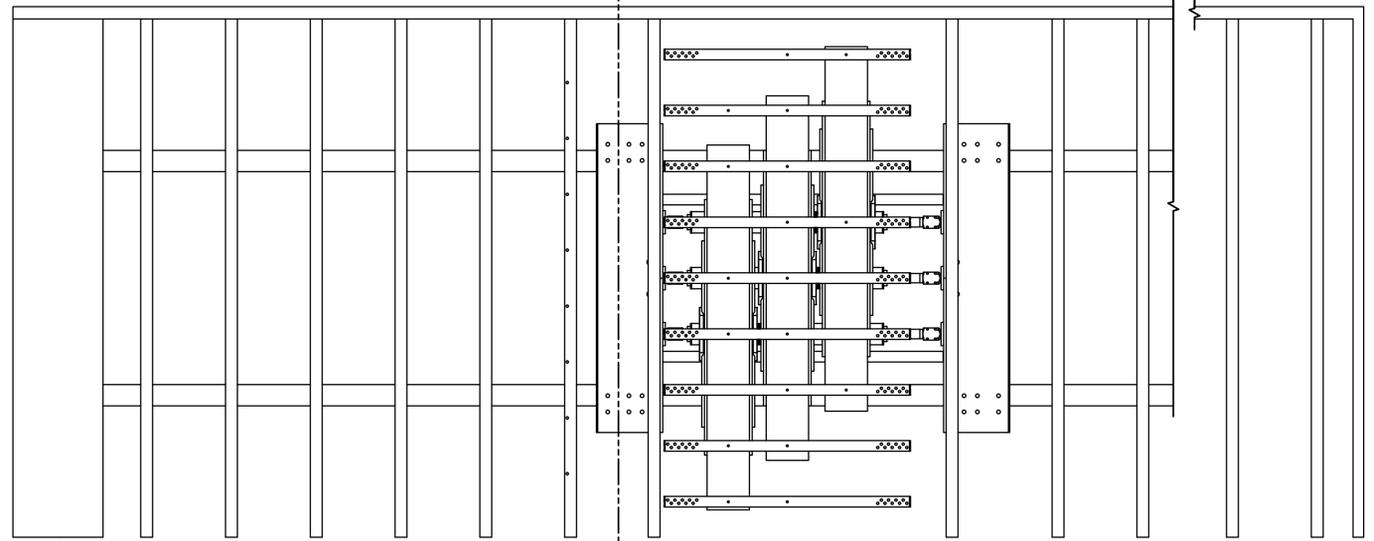


1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35

B C D E F G H I J K L M N O P Q R S T U V W



SECTION A-A
SCALE 1 / 16



INSTRUCTIONS:

1) INSTALL V-FLOOR DRIVE THE SAME AS A STANDARD KEITH RUNNING FLOOR II DRIVE UNIT. MAKE SURE DRIVE X-MEMBER HEIGHT IS FLUSH WITH THE TRAILER X-MEMBER HEIGHT. IF NEEDED, SHIM DRIVE UNIT TO THE CORRECT HEIGHT.

FOR SAE ASPHALT SYSTEMS USE 4" CROSSMEMBER HEIGHT KRFII DRIVES.

FOR METRIC ASPHALT SYSTEMS USE 100MM CROSSMEMBER HEIGHT BUILD IN DRIVES.

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

2) COLLAPSE ALL CYLINDERS TO THE DISCHARGE END.

NOTES:

1. TRAILER WALLS NEED TO BE STRAIGHT OR TAPERED SO THAT THE TRAILER IS WIDER AT DISCHARGE END.

2. THERE SHOULD BE NO RESTRICTIONS AT THE DOOR OR CROSS TIES TO RESTRICT FLOW OF MATERIAL.

3. TRAILER NEEDS TO HAVE A 45° REAR THRESHOLD TO KEEP MATERIAL FROM PUSHING BACK UP UNDER AND LIFTING SLATS.

ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
	D	6	ADD WEIGHT OVER DRIVE UNIT WHILD TACKING DRIVE CHANNEL, SHEET 6	JC	9/15/18
	C	5	ADDED NOTE ON SIDE SEAL INSTALLATION, SHEET 5	EW	4/7/15
	C	4	ADDED NOTE ON J-BEARINGS, SHEET 3	EW	4/7/15
	B	3	ADDED METRIC DIMENSIONS, ALL SHEETS	EW	2/26/15
	B	2	UPDATED INSTRUCTIONS AND NOTES, ALL SHEETS	EW	2/26/15
	A	1	CHANGED METHOD FOR SECURING J-BEARING TO BOLTED, SHEET 4	IC	7/1/14

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED		
TOLERANCES UNLESS OTHERWISE NOTED		
FRACTIONS	DECIMALS	MATERIAL:
± 1/32	XX = ± .010 XXX = ± .005 XXXX = ± .0005	QUANTITY:
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SCALE: 1=16 SHEET 1 OF 8 DRAWN BY: JD

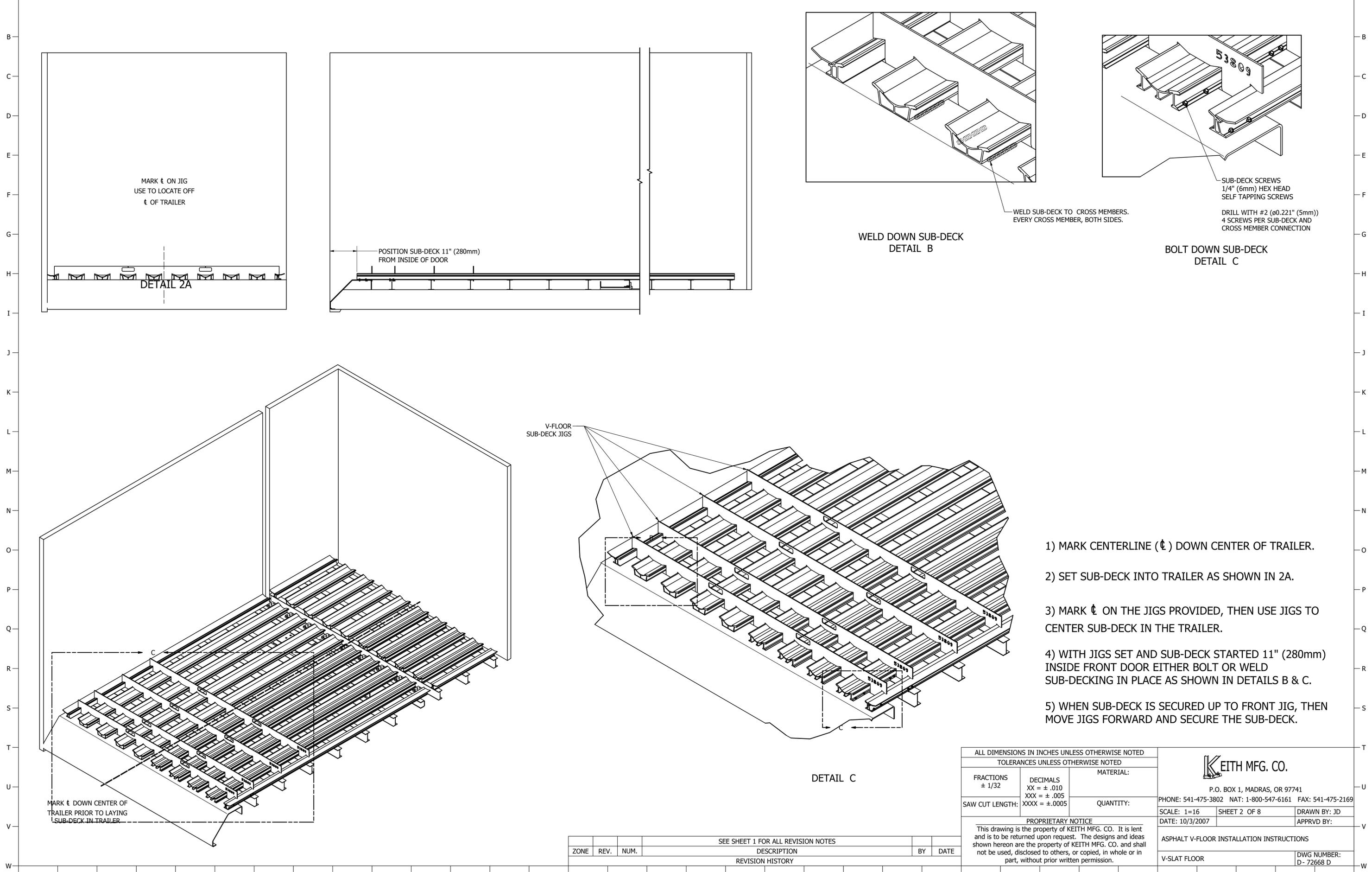
DATE: 10/3/2007 APPRVD BY:

ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS

V-SLAT FLOOR DWG NUMBER: D-72668 D

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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



MARK ϵ ON JIG
USE TO LOCATE OFF
 ϵ OF TRAILER

DETAIL 2A

POSITION SUB-DECK 11" (280mm)
FROM INSIDE OF DOOR

WELD DOWN SUB-DECK
DETAIL B

BOLT DOWN SUB-DECK
DETAIL C

WELD SUB-DECK TO CROSS MEMBERS.
EVERY CROSS MEMBER, BOTH SIDES.

SUB-DECK SCREWS
1/4" (6mm) HEX HEAD
SELF TAPPING SCREWS

DRILL WITH #2 ($\phi 0.221$ " (5mm))
4 SCREWS PER SUB-DECK AND
CROSS MEMBER CONNECTION

V-FLOOR
SUB-DECK JIGS

DETAIL C

MARK ϵ DOWN CENTER OF
TRAILER PRIOR TO LAYING
SUB-DECK IN TRAILER

- 1) MARK CENTERLINE (ϵ) DOWN CENTER OF TRAILER.
- 2) SET SUB-DECK INTO TRAILER AS SHOWN IN 2A.
- 3) MARK ϵ ON THE JIGS PROVIDED, THEN USE JIGS TO CENTER SUB-DECK IN THE TRAILER.
- 4) WITH JIGS SET AND SUB-DECK STARTED 11" (280mm) INSIDE FRONT DOOR EITHER BOLT OR WELD SUB-DECKING IN PLACE AS SHOWN IN DETAILS B & C.
- 5) WHEN SUB-DECK IS SECURED UP TO FRONT JIG, THEN MOVE JIGS FORWARD AND SECURE THE SUB-DECK.

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED
TOLERANCES UNLESS OTHERWISE NOTED

FRACTIONS $\pm 1/32$	DECIMALS XX = $\pm .010$ XXX = $\pm .005$ XXXX = $\pm .0005$	MATERIAL:
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SCALE: 1=16 SHEET 2 OF 8 DRAWN BY: JD
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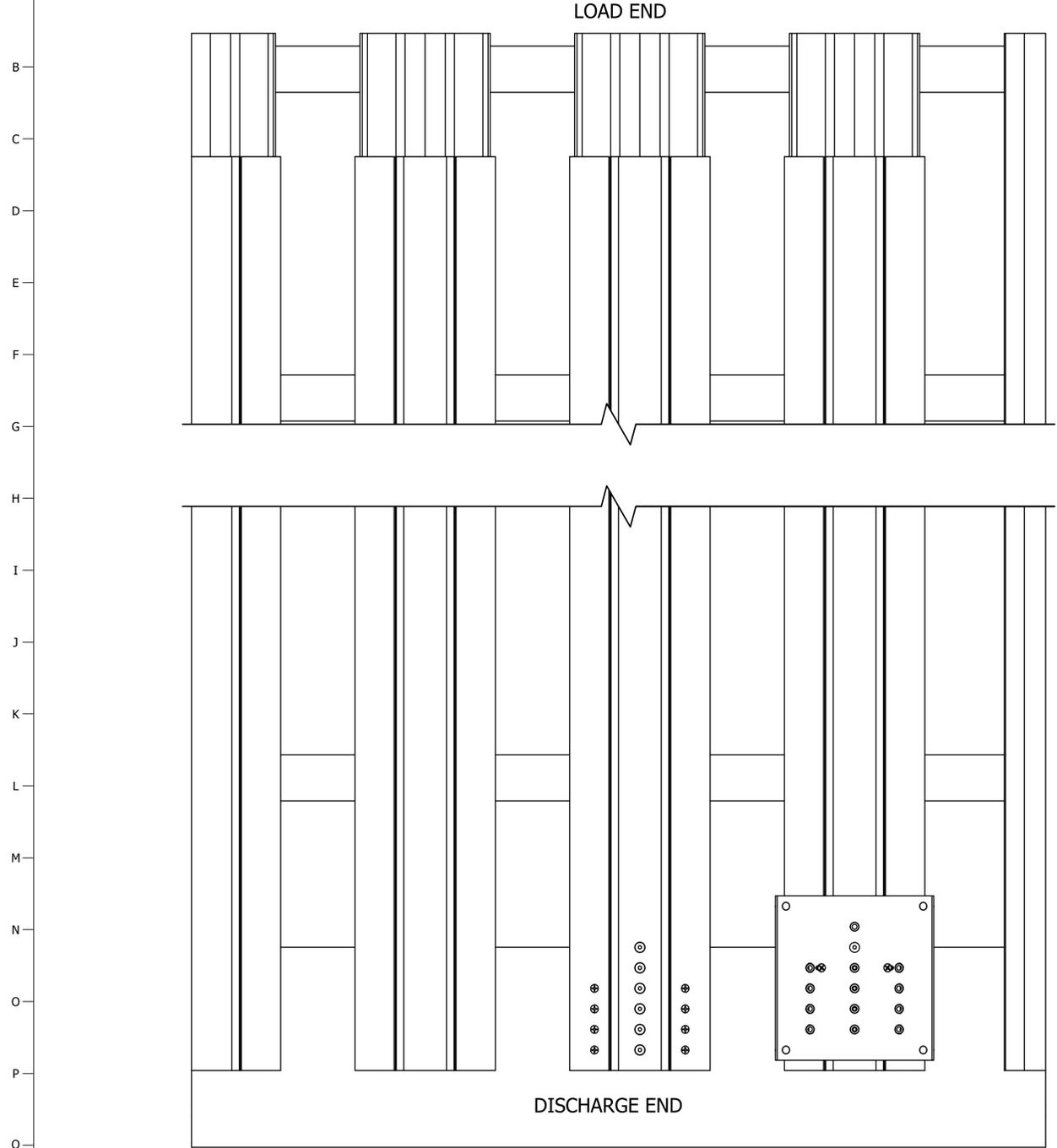
ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS

V-SLAT FLOOR DWG NUMBER:
D- 72668 D

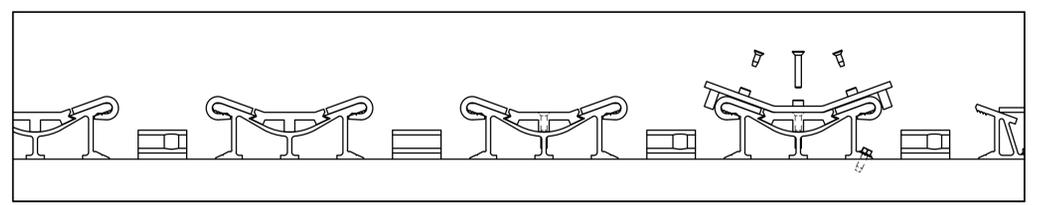
SEE SHEET 1 FOR ALL REVISION NOTES					
ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY					

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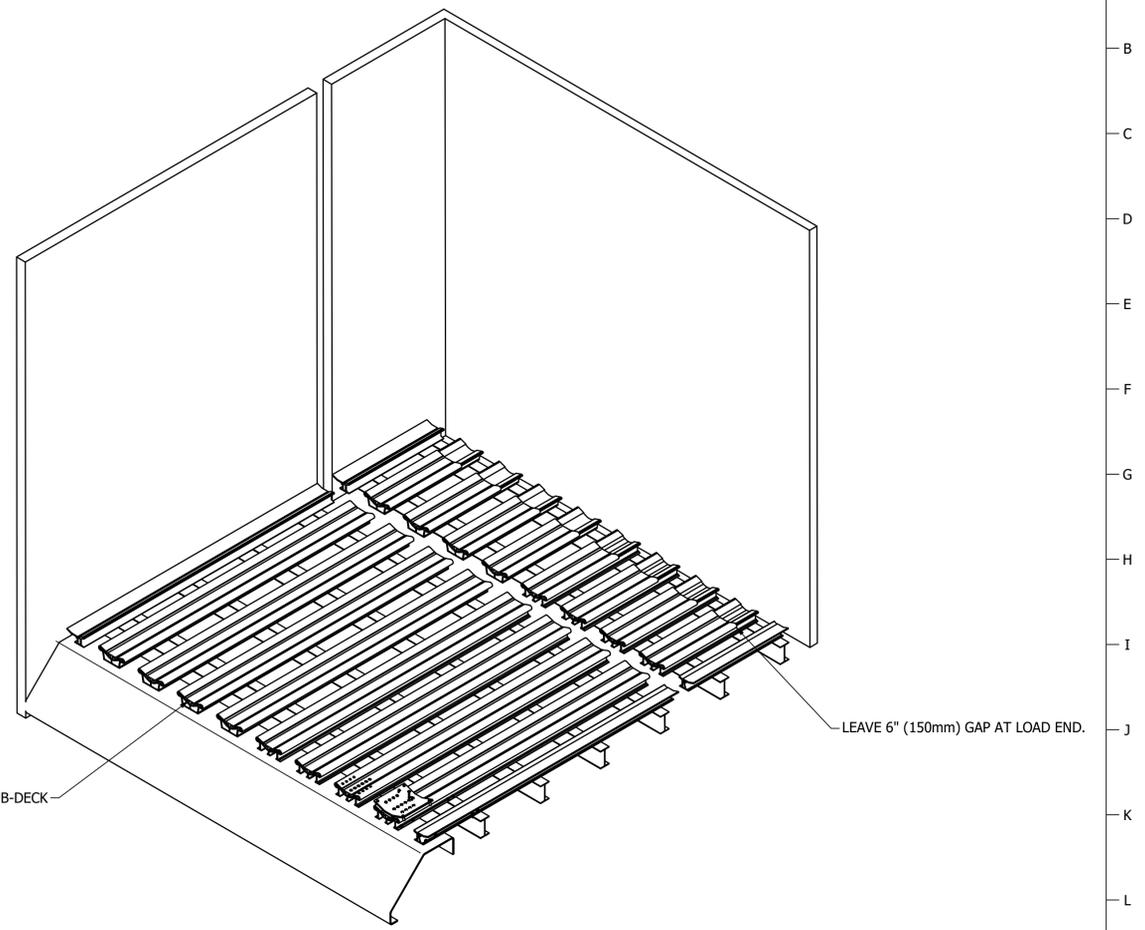
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DETAIL B



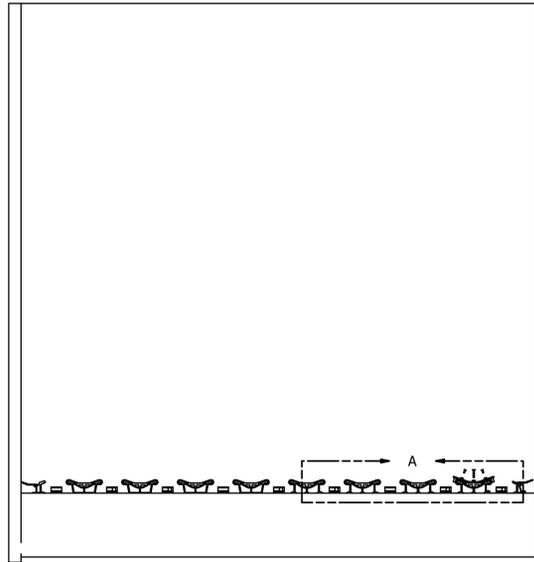
DETAIL A



FLUSH BEARINGS WITH DISCHARGE END OF SUB-DECK

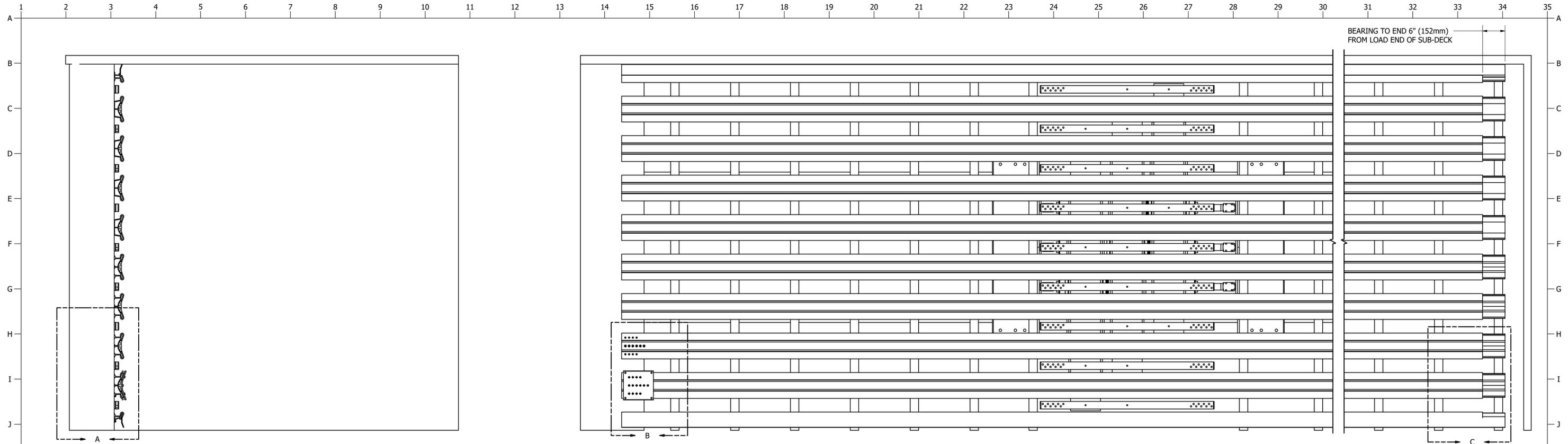
LEAVE 6" (150mm) GAP AT LOAD END.

- 1) SLIDE TROUGH BEARING INSERT INTO DOVE TAIL IN SUB-DECK. AS SHOWN IN DETAIL A.
NOTE: BEARINGS SHOULD BE FLUSH WITH DISCHARGE END OF SUB-DECK AND END 6" (150mm) SHORT OF LOAD END OF SUB-DECK
- 2) INSTALL J-BEARING ONTO SUB-DECK. START FLUSH AGAINST END OF SUB-DECK ON DISCHARGE END AND END 6" (150mm) FROM FRONT OF SUB-DECK.
NOTE: USE J-BEARING INSTALLATION TOOL (P/N 05704501)



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ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY					
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SCALE: 1=16		SHEET 3 OF 8		DRAWN BY: JD	
DATE: 10/3/2007		APPRVD BY:			
ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS					
V-SLAT FLOOR				DWG NUMBER: D- 72668 D	

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



DISCHARGE END OF TRAILER

LOAD END OF TRAILER

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 LAY OUT (2) J-BEARING PIECES, (1) ON EACH SIDE OF THE SUB-DECKING. THE J-BEARING NEEDS TO END 6" (150mm) 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 CAP.

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.

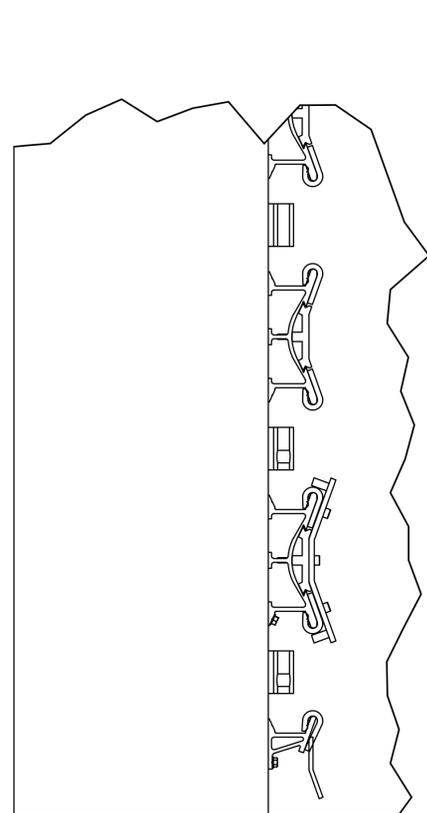
2) CONTINUE TO INSTALL J-BEARING PIECES ON EACH PIECE OF SUB-DECKING. THE TWO OUTSIDE MOST PIECES ON THE SIDE SEAL SUB-DECK WILL NEED TO BE INSTALLED FULL LENGTH BY HAMMERING ON EACH PIECE WITH A RUBBER Mallet.

3) CLAMP THE DRILL JIG (P/N 8270302) IN PLACE AND DRILL PILOT HOLES (4 PER SIDE) THROUGH THE J-BEARING AND SUB-DECK USING THE DRILL TEMPLATE JIG AND A 15/64" (5.95mm) DRILL BIT. DRILL CENTER HOLES (6) ONLY IF USING THE #2468 QUICKSILVER TROUGH BEARING. REMOVE THE JIG AND COUNTERSINK THESE HOLES WITH AN 82° BIT.

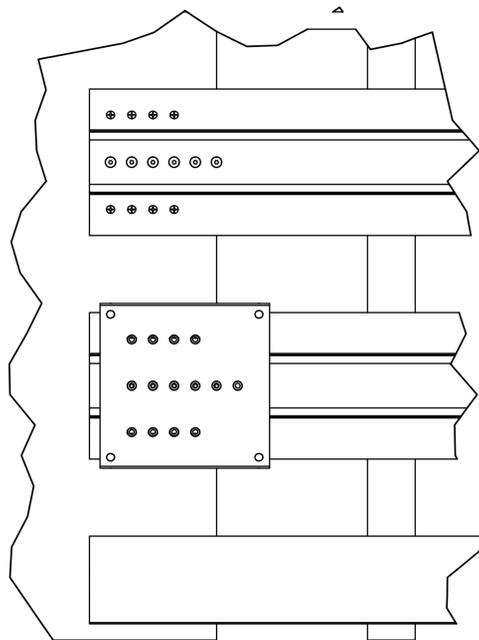
NOTE: LUBRICATING THE DRILL BIT WITH ALUMINUM CUTTING OIL BETWEEN DRILLING HOLES WILL MINIMIZE BROKEN BITS.

4) INSTALL (4) 1/4x 5/8 FHCS TORX F ZINK" COUNTERSUNK FH ROLOK SCREWS (KEITH P/N 87701592) AT THE DISCHARGE END OF EACH PIECE OF J-BEARING. IF USING TROUGH BEARING, INSTALL (6) 1/4x1-1/4 FHCS TORX F ZINK" COUNTERSUNK FH ROLOK SCREWS (KEITH P/N 87701593) AT THE DISCHARGE END OF TROUGH 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.

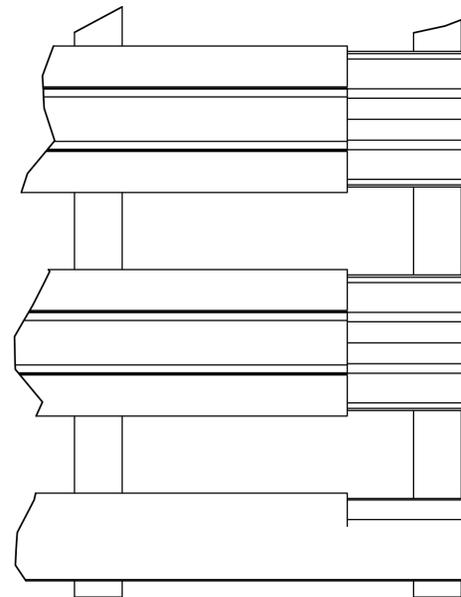
5) WELD END CAPS ONTO THE DISCHARGE END OF SUB-DECK AND SIDE SEAL SUB-DECK (SEE WELD DETAIL). THESE CAPS PLUG THE SUB-DECK CAVITIES AND ENSURE THE BEARING CAN'T SLIDE OUT THE REAR OF THE TRAILER. MAKE SURE NO WELD IS HIGHER THAN THE TOP SURFACE OF J-BEARING.



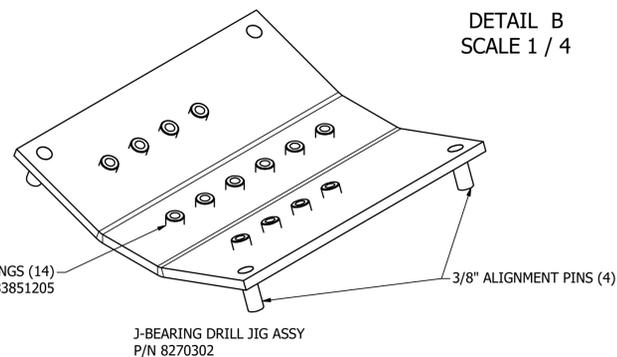
DETAIL A
SCALE 1 / 4



DETAIL B
SCALE 1 / 4



DETAIL C
SCALE 1 / 4



3/16" DRILL BUSHINGS (14)
P/N 83851205

J-BEARING DRILL JIG ASSY
P/N 8270302

3/8" ALIGNMENT PINS (4)

SEE SHEET 1 FOR ALL REVISION NOTES					
ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY					

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TOLERANCES UNLESS OTHERWISE NOTED		
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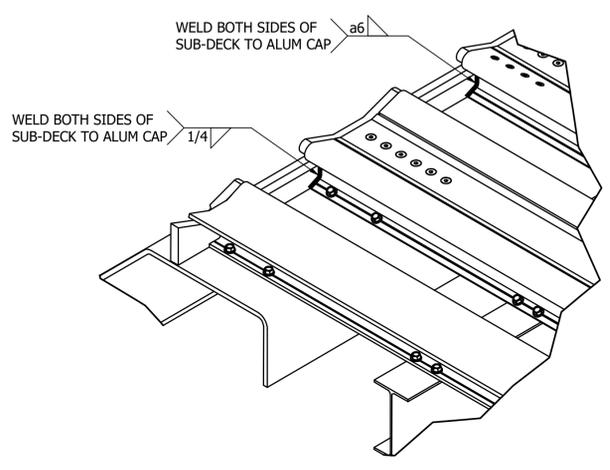
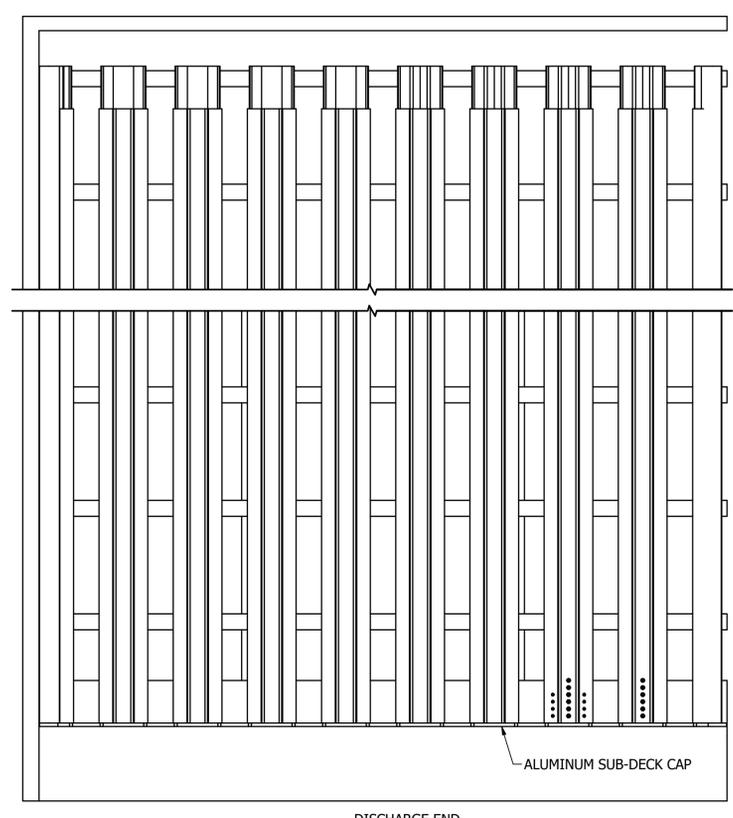
SCALE: SHEET 4 OF 8 DRAWN BY: JD
DATE: 10/3/2007 APPRVD BY:

ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS

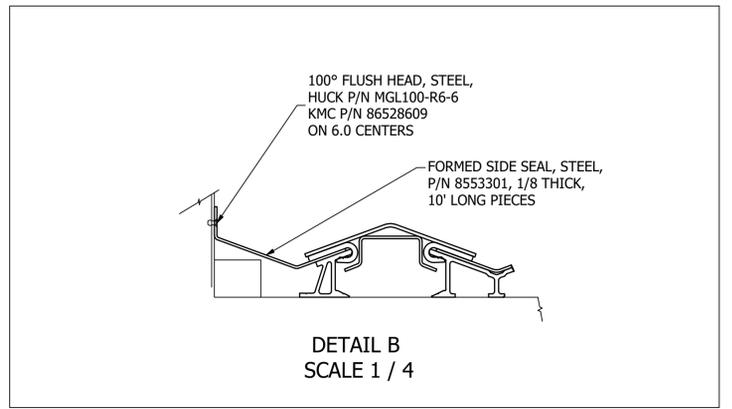
V-SLAT FLOOR DWG NUMBER:
D- 72668 D

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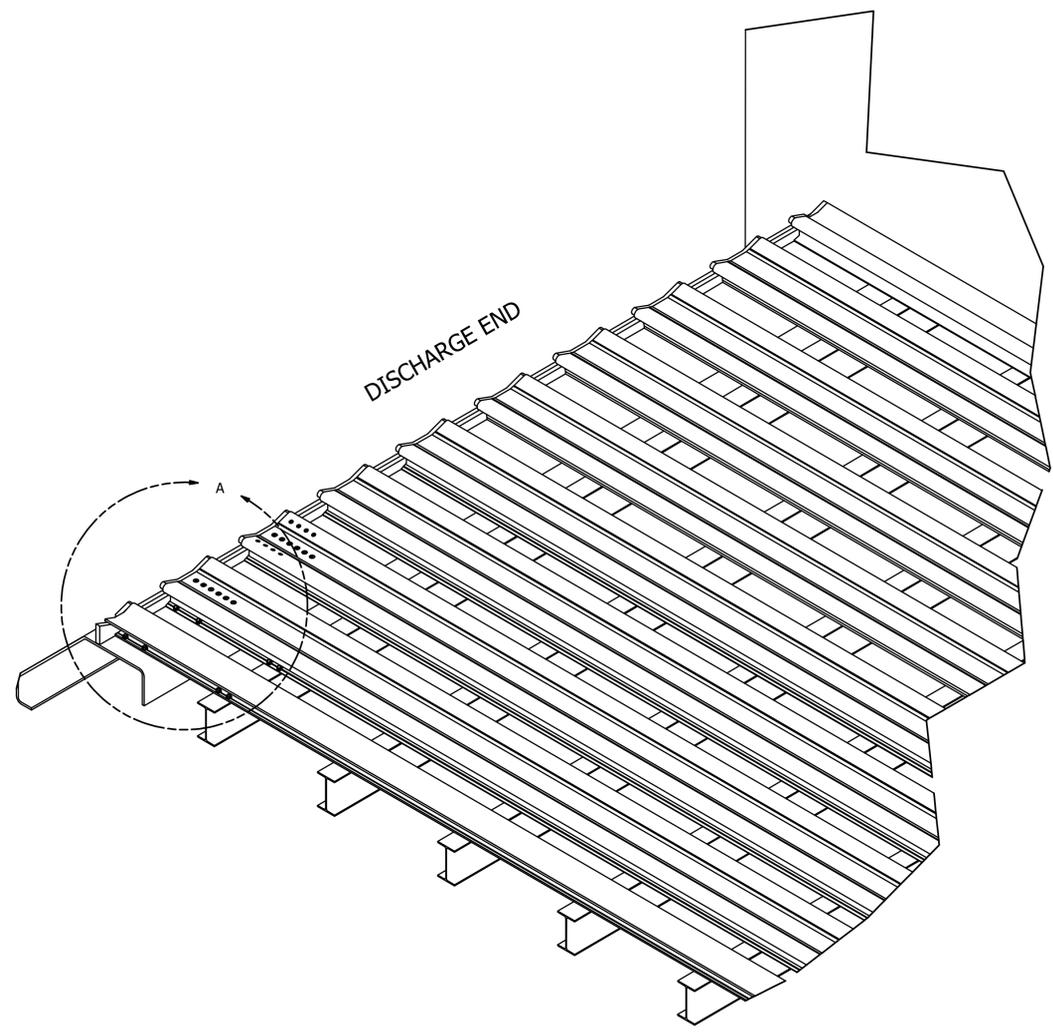
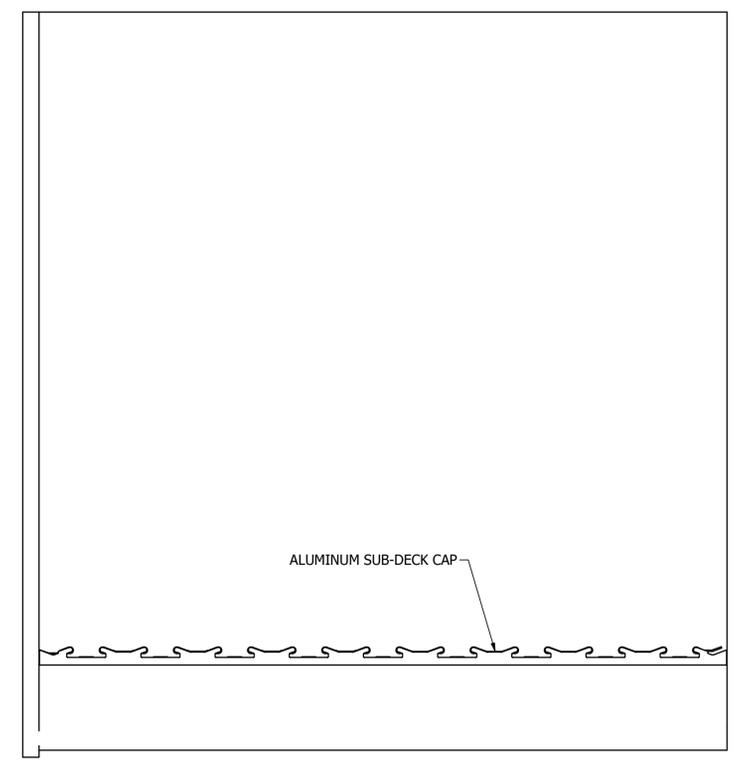
A B C D E F G H I J K L M N O P Q R S T U V W



DETAIL A
SCALE 1 / 4



DETAIL B
SCALE 1 / 4



- 1) PLACE SIDE SEAL IN TRAILER, NO LESS THAN 3/16" FROM EDGE OF SUB-DECK. RIVET STEEL SIDE SEAL FULL LENGTH EVERY 6" (150mm). SEE DETAIL B.
- 2) INSTALL J-BEARING ALONG SIDE SEAL SUB-DECK PIECES WITH A DEAD BLOW HAMMER. USE 2506 J-BEARING FOR SIDE SEAL SUB-DECK IF POSSIBLE (UNAVAILABLE IN EUROPE).
- 3) PLACE 1/2" (13mm) ALUMINUM SUB-DECK CAP ONTO DISCHARGE END OF SUB-DECK. THE CAP IS DESIGNED TO HOLD THE BEARING IN PLACE AND ALSO COVER THE CAVITIES IN THE END OF THE SUB-DECK.
- 4) WELD ALUMINUM SUB-DECK CAP AS SHOWN IN DETAIL A. THE CAP NEEDS TO BE WELDED TO EACH PIECE OF SUB-DECK.

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED		
TOLERANCES UNLESS OTHERWISE NOTED		
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:
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DATE: 10/3/2007		APPRVD BY:

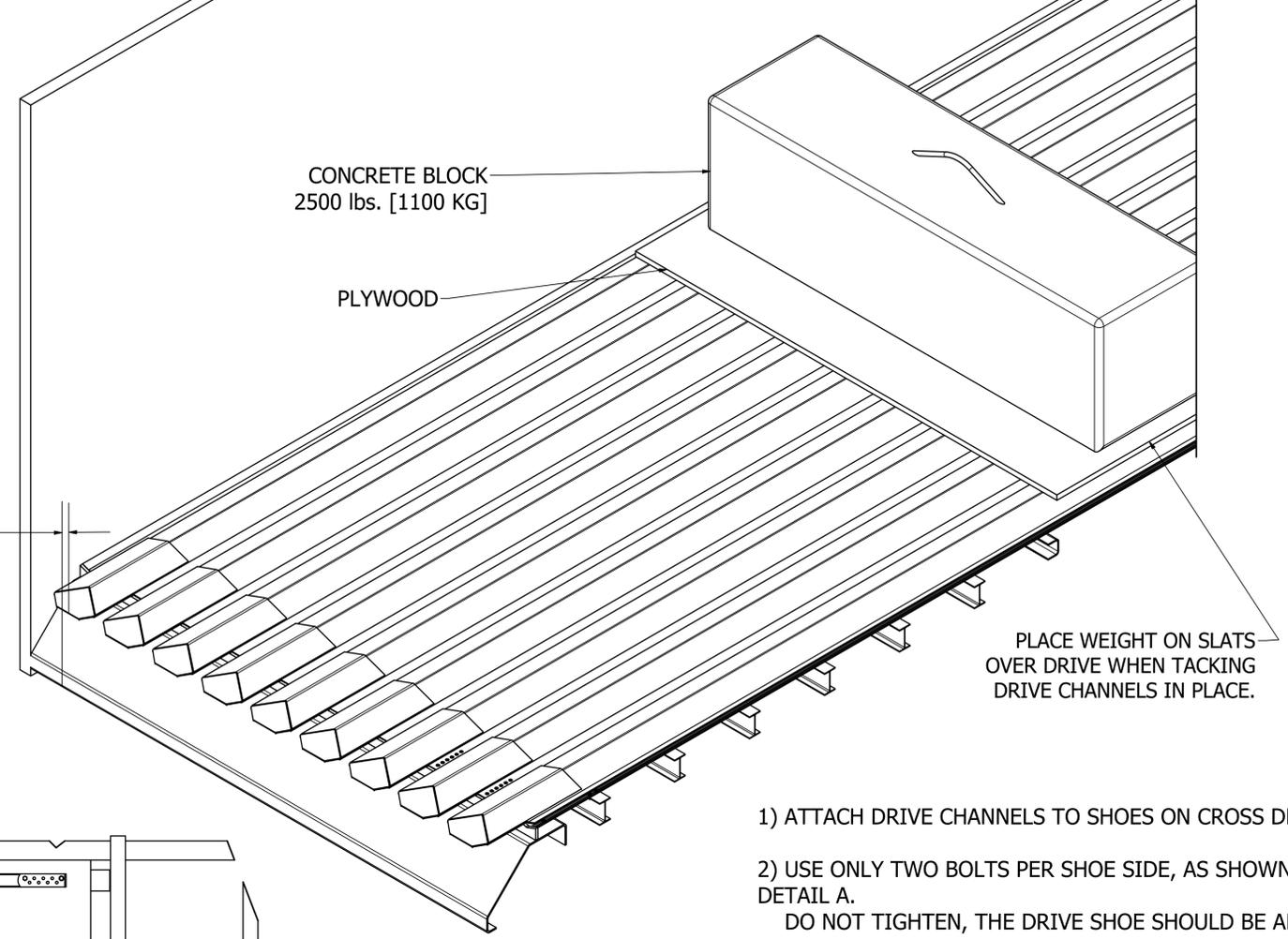
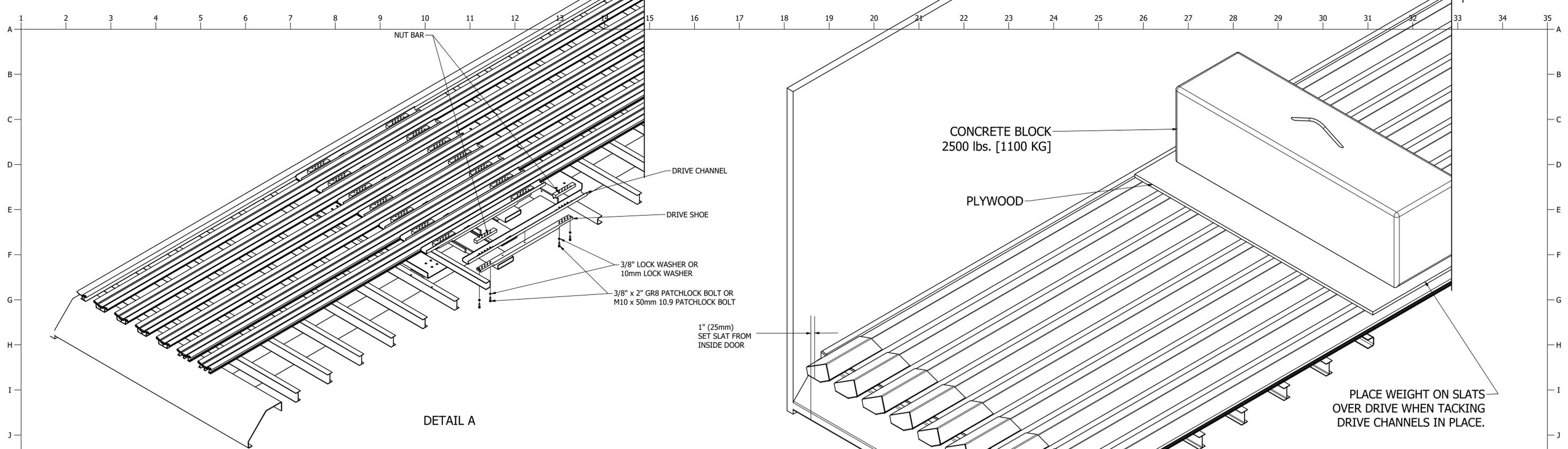
ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS

V-SLAT FLOOR	DWG NUMBER: D- 72668 D
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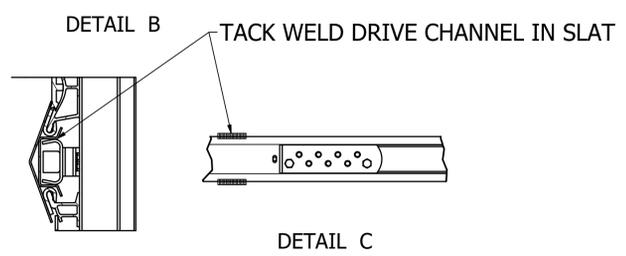
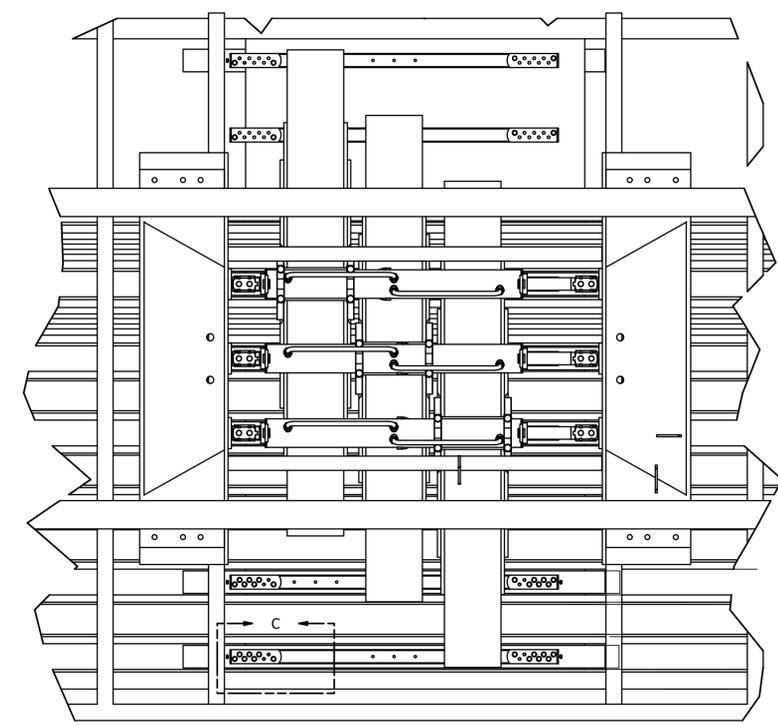
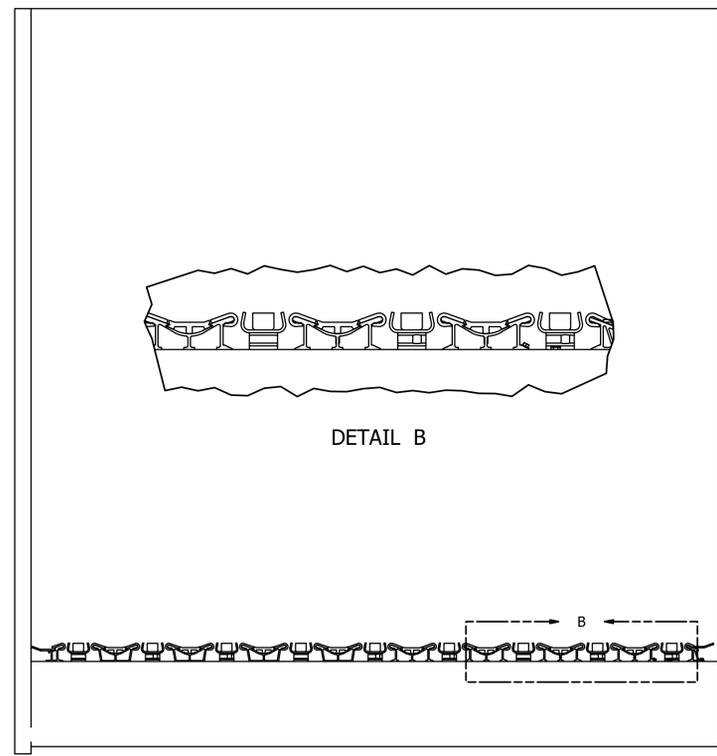
SEE SHEET 1 FOR ALL REVISION NOTES					
ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY					

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A B C D E F G H I J K L M N O P Q R S T U V W

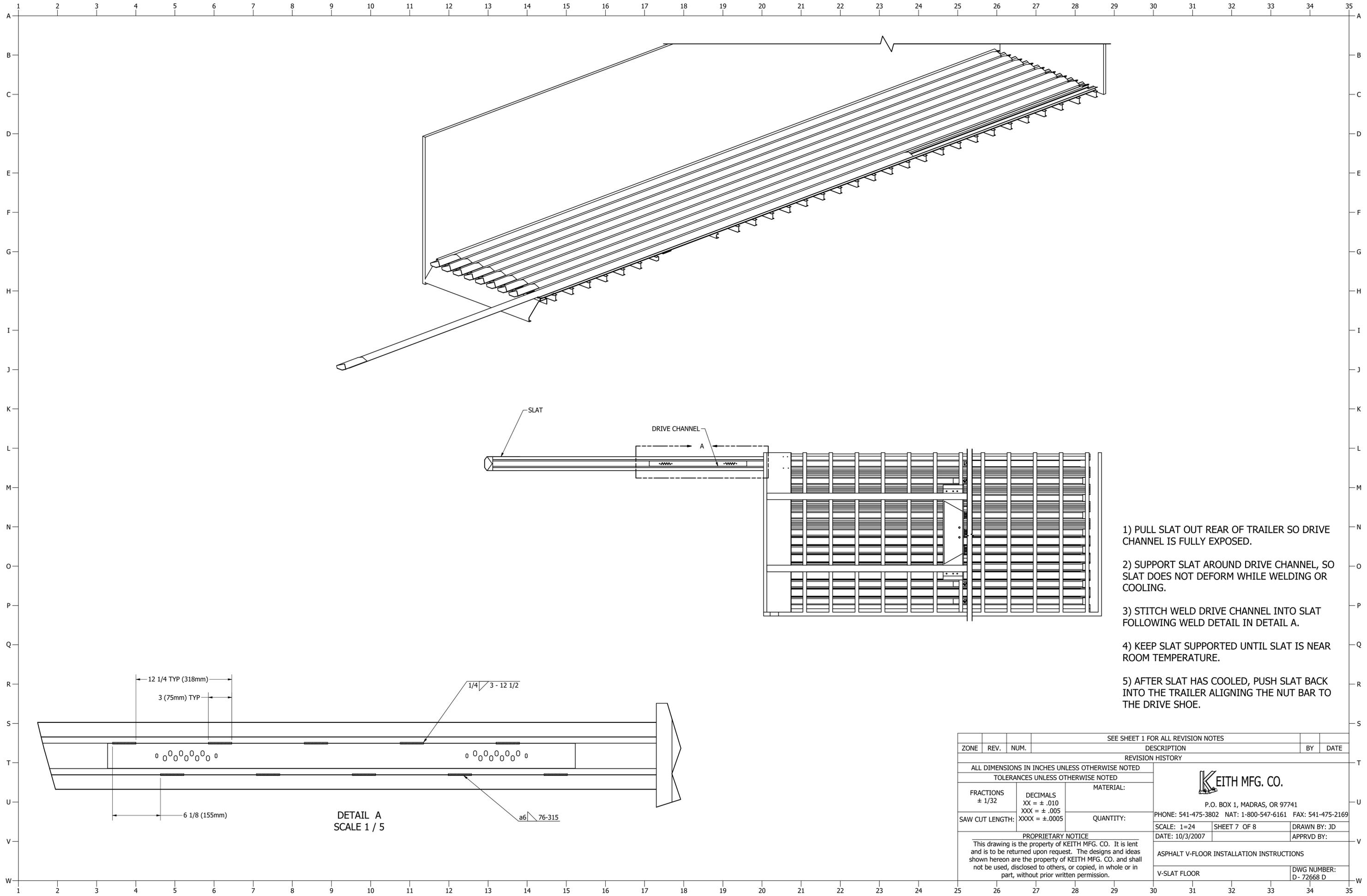


- 1) ATTACH DRIVE CHANNELS TO SHOES ON CROSS DRIVE.
- 2) USE ONLY TWO BOLTS PER SHOE SIDE, AS SHOWN IN DETAIL A.
DO NOT TIGHTEN, THE DRIVE SHOE SHOULD BE ABLE TO SLIDE SIDE TO SIDE IN THE SLOTS.
- 3) SLIDE SLATS INTO TRAILER. MAKE SURE THE CYLINDERS ARE COLLAPSED TO THE DISCHARGE END OF THE TRAILER.
- 4) SLATS SHOULD END MINIMUM 1" (25mm) INSIDE OF DOOR.
- 5) PLACE A WEIGHT OF APPROXIMITLY 2500 lbs. [1100 kgs.] EVENLY DISTRIBUTED OVER ALL SLATS. A CONCRETE BLOCK ON PLYWOOD WORKS GOOD.
- 6) TACK WELD DRIVE CHANNELS TO CORRESPONDING SLATS, AS SHOWN IN DETAIL C.
NOTE: MAKE SURE TO PLACE COVERS OVER CHROME RODS ON THE CYLINDERS TO PROTECT FROM WELD SPLATTER. TACK WELD IN PLACES WITH EASY ACCESS.
- 7) REMOVE 3/8" BOLTS FROM DRIVE SHOE TO FREE SLAT.



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TOLERANCES UNLESS OTHERWISE NOTED					
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SEE SHEET 1 FOR ALL REVISION NOTES			ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS		
ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY			V-SLAT FLOOR		
SECTION B-B SCALE 1 / 6			DWG NUMBER: D- 72668 D		

ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
REVISION HISTORY			V-SLAT FLOOR		

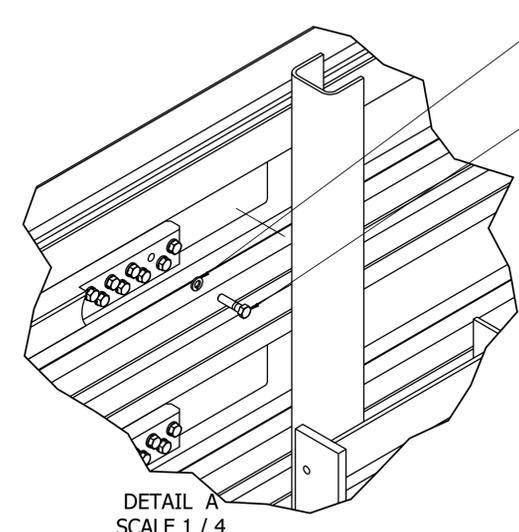
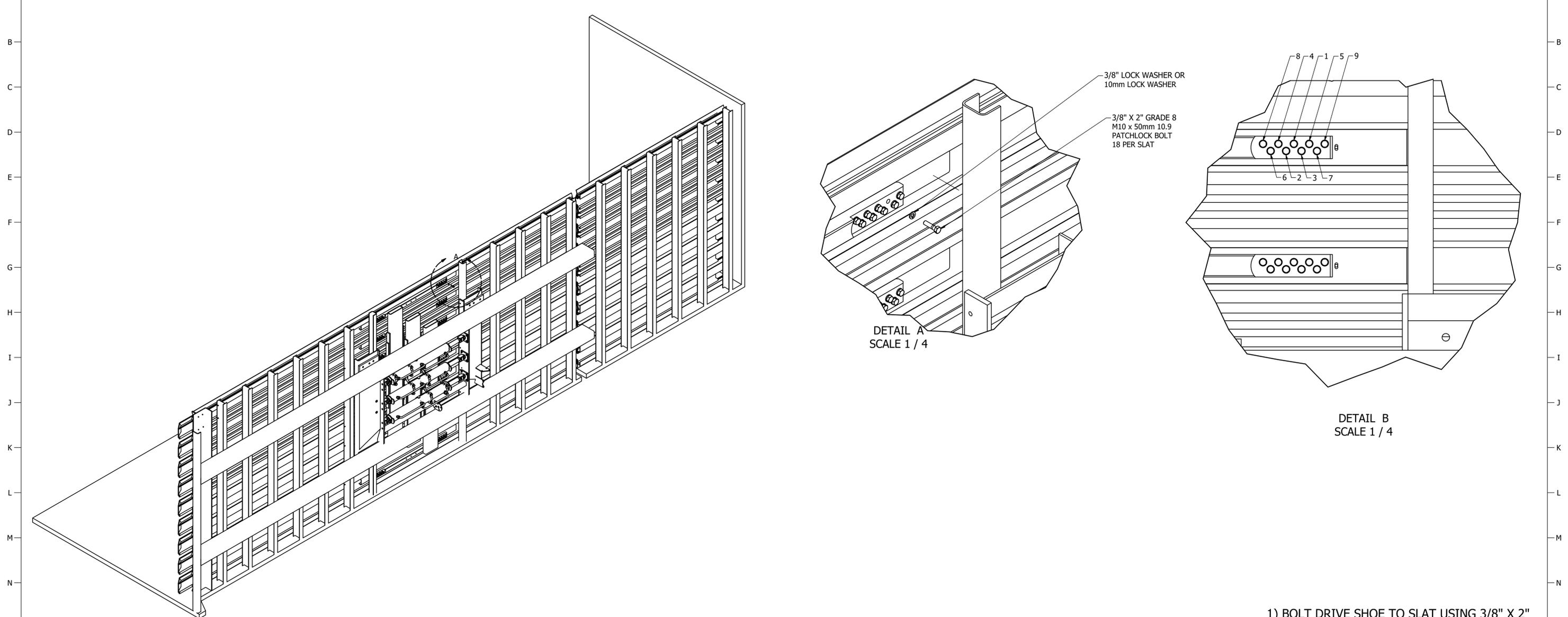


- 1) PULL SLAT OUT REAR OF TRAILER SO DRIVE CHANNEL IS FULLY EXPOSED.
- 2) SUPPORT SLAT AROUND DRIVE CHANNEL, SO SLAT DOES NOT DEFORM WHILE WELDING OR COOLING.
- 3) STITCH WELD DRIVE CHANNEL INTO SLAT FOLLOWING WELD DETAIL IN DETAIL A.
- 4) KEEP SLAT SUPPORTED UNTIL SLAT IS NEAR ROOM TEMPERATURE.
- 5) AFTER SLAT HAS COOLED, PUSH SLAT BACK INTO THE TRAILER ALIGNING THE NUT BAR TO THE DRIVE SHOE.

DETAIL A
SCALE 1 / 5

SEE SHEET 1 FOR ALL REVISION NOTES				BY	DATE
ZONE	REV.	NUM.	DESCRIPTION		
REVISION HISTORY					
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SCALE: 1=24		SHEET 7 OF 8		DRAWN BY: JD	
DATE: 10/3/2007		APPRVD BY:			
ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS					
V-SLAT FLOOR				DWG NUMBER: D- 72668 D	

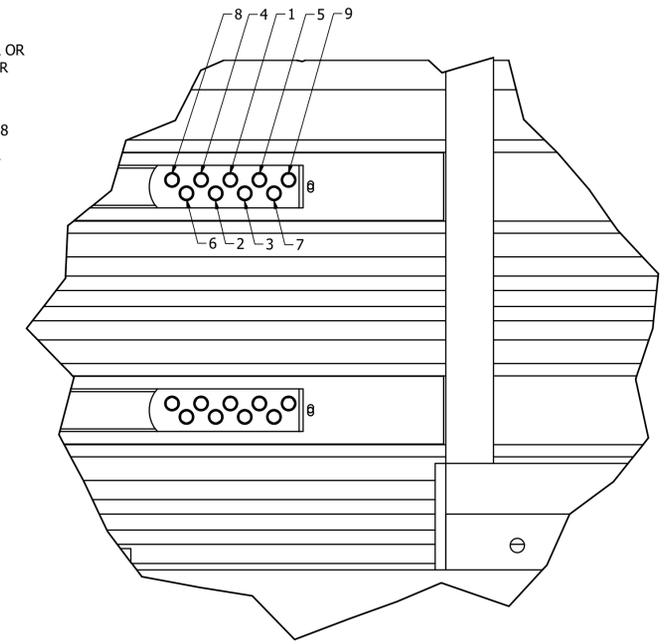
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DETAIL A
SCALE 1 / 4

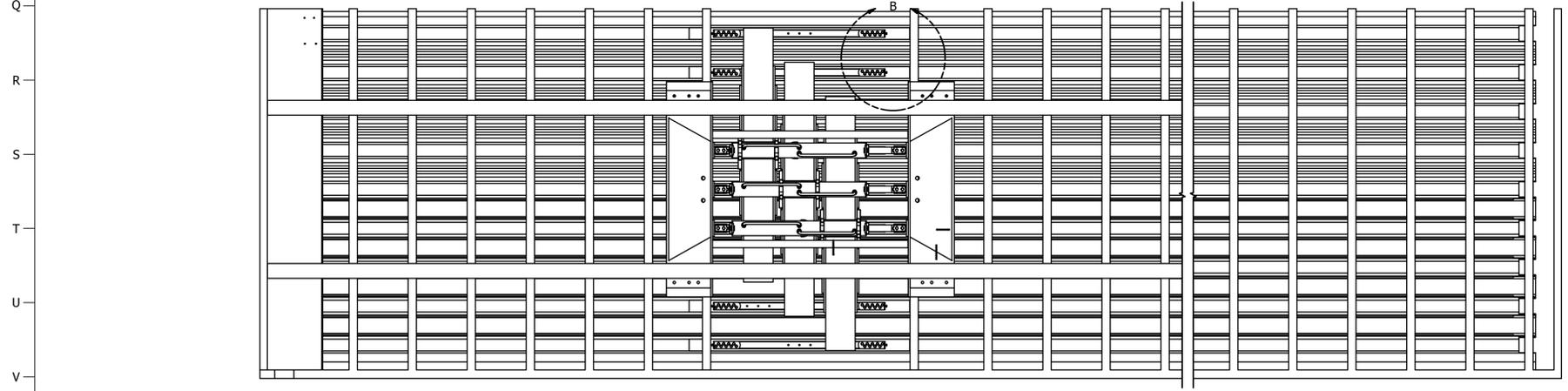
3/8" LOCK WASHER OR
10mm LOCK WASHER

3/8" X 2" GRADE 8
M10 x 50mm 10.9
PATCHLOCK BOLT
18 PER SLAT



DETAIL B
SCALE 1 / 4

- 1) BOLT DRIVE SHOE TO SLAT USING 3/8" X 2" HEX BOLTS AND LOCK WASHERS.
- 2) TORQUE BOLTS TO 45 FT-LBS. (61 Nm)
- 3) IF THERE IS LIMITED ACCESS TO BOLTS, CYCLE DRIVE TOWARD LOAD END OF TRAILER TO GAIN ACCESS.
- 4) TIGHTEN BOLTS IN SEQUENCE 1,2,3.....9. CYCLE THROUGH TIGHTENING 2 TIMES. (SEE DETAIL 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

SEE SHEET 1 FOR ALL REVISION NOTES				
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:	SHEET 8 OF 8	DRAWN BY: JD		
DATE: 10/3/2007	APPRVD BY:			
ASPHALT V-FLOOR INSTALLATION INSTRUCTIONS				
V-SLAT FLOOR				DWG NUMBER: D- 72668 D