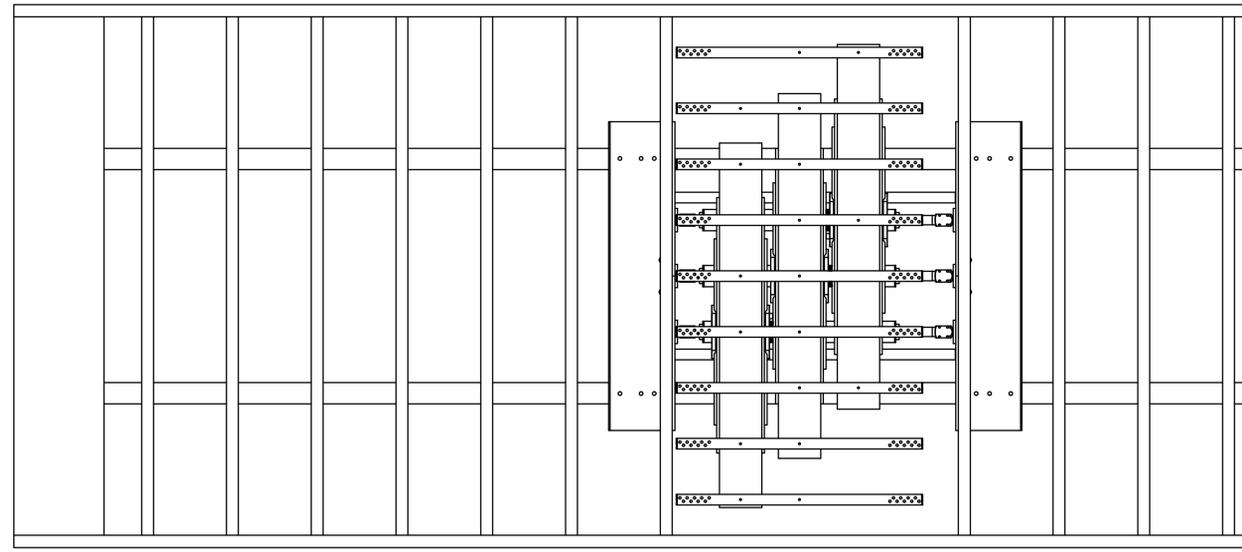
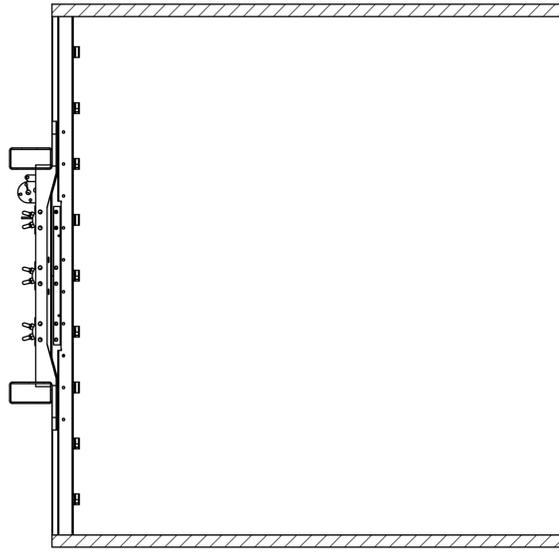
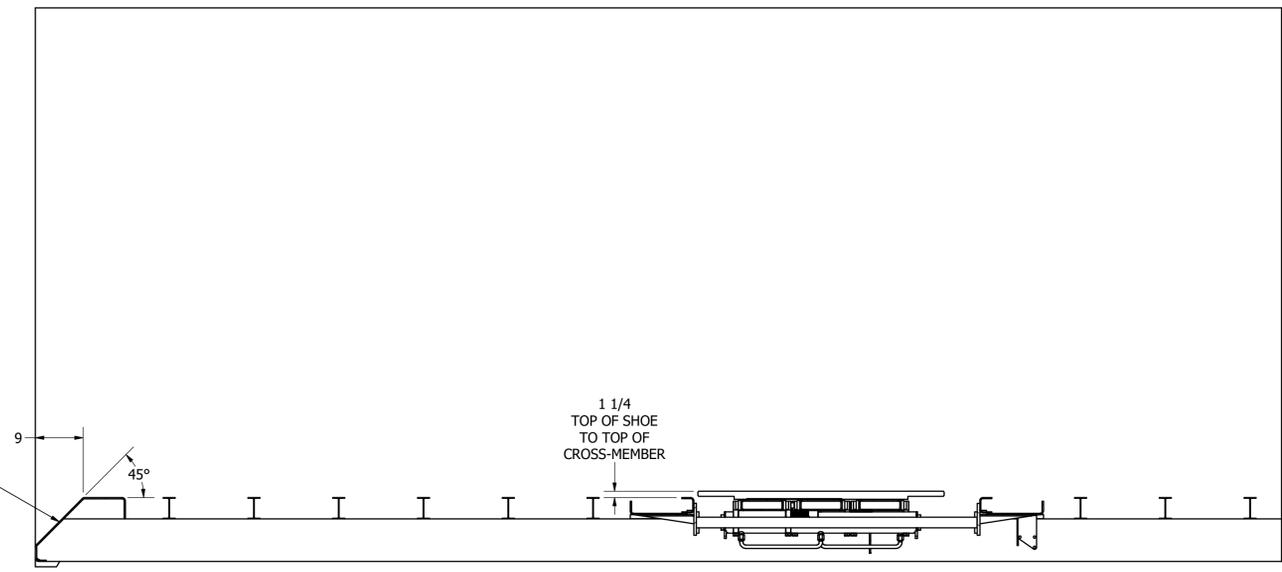


1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35

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



ANGLED THRESHOLD REQUIRED.
THE ANGLED THRESHOLD PREVENTS
MATERIAL BUILD-UP BELOW THE SLATS.
MATERIAL BELOW THE SLATS WILL CAUSE
THE SLATS TO LIFT.



1) INSTALL V-FLOOR DRIVE AS NORMAL 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.

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

2) COLLAPSE ALL CYLINDERS TO THE DISCHARGE END.

NOTE: TRAILER WALLS NEED TO BE STRAIGHT OR TAPERED SO THAT THE TRAILER IS WIDER AT DISCHARGE END. THERE SHOULD BE NO RESTRICTIONS AT THE DOOR OR CROSS TIES TO RESTRICT FLOW OF MATERIAL.

ZONE	REV.	NUM.	DESCRIPTION	BY	DATE
		I	10	ADDED CORROSION BARRIER NOTE TO PAGE 3	CE 12/3/21
		H	9	ADD WEIGHT OVER DRIVE UNIT WHILE TACKING DRIVE CHANNEL, SHEET 5	JC 9/17/18
		G	8	UPDATED NOTES, PG 4	IP 10/17/17
		F	7	UPDATED NOTES, PG 4	EW 2/5/15
		E	6	UPDATED NOTES, PG 4	IC 11/29/14
		D	5	EDITED DETAIL D, CORRECT JIG REPRESENTATION, PG 4	VCM 11/22/14
		C	4	ADDED STEEL SUBDECK DRILL INSTRUCTION, PG 4	VCM 9/11/14
		C	3	CHANGED DRILL BIT TO 15/64" DIA, PG 4	VCM 9/11/14
		B	2	ALTERED J-BEARING SECURE METHOD TO BOLTS, PG 4	IC 7/1/14
		A	1	3" WELDS WERE 2" WELDS, PG 6	JD 10/1/08
				REVISION HISTORY	

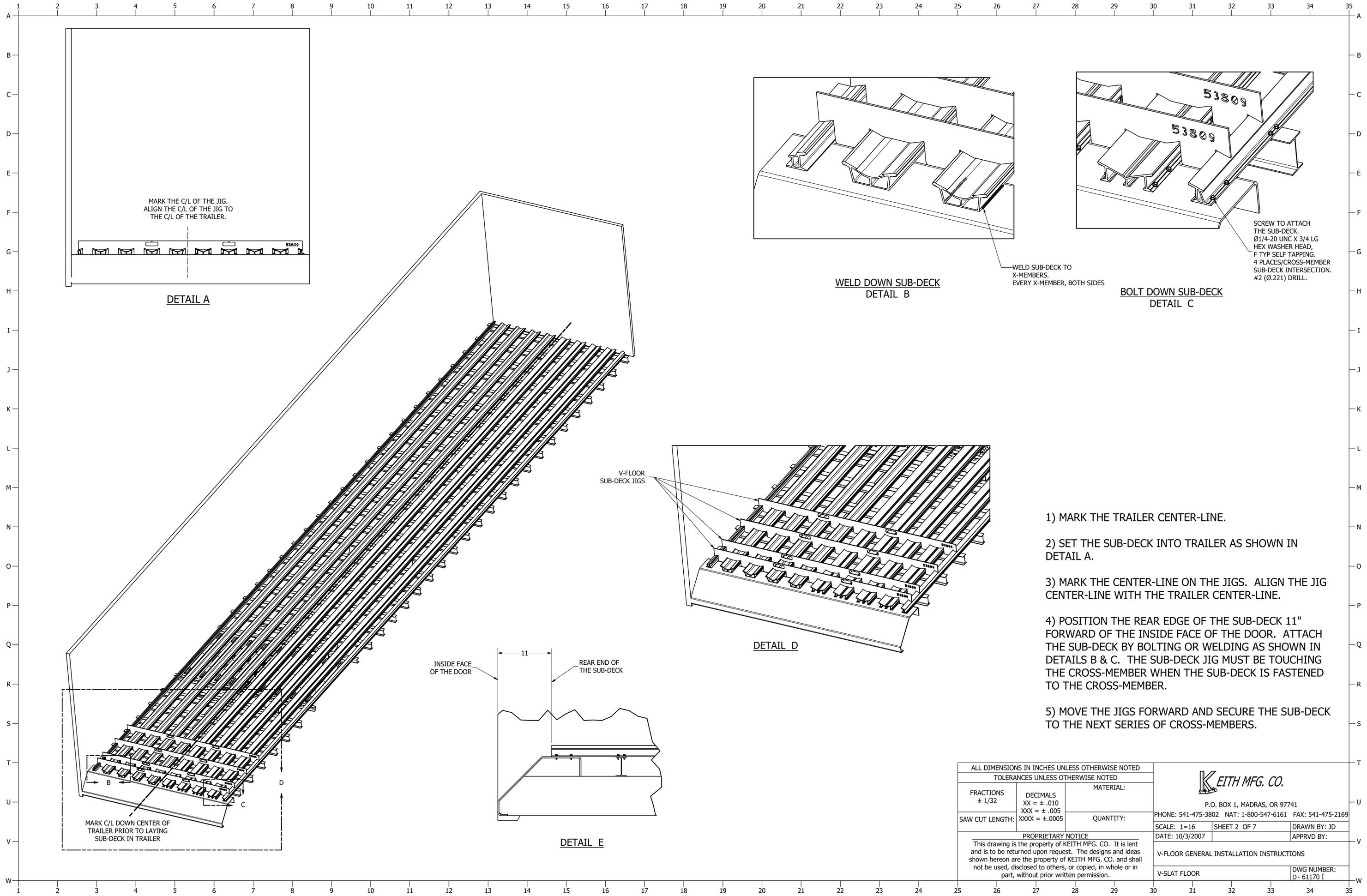
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED
TOLERANCES UNLESS OTHERWISE NOTED
FRACTIONS ± 1/32
DECIMALS XX = ± .010
XXX = ± .005
XXXX = ± .0005
SAW CUT LENGTH:
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SCALE: 1=16 SHEET 1 OF 7 DRAWN BY: JD
DATE: 10/3/2007 APPRVD BY:

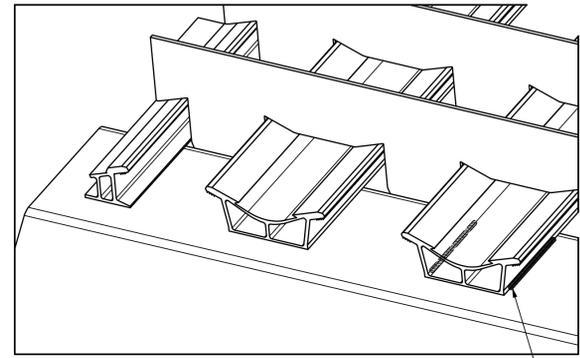
V-FLOOR GENERAL INSTALLATION INSTRUCTIONS
V-SLAT FLOOR DWG NUMBER: D- 61170 I

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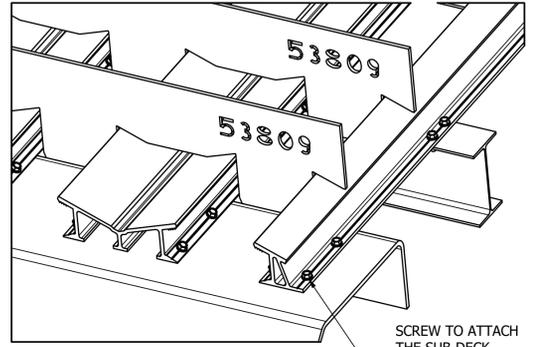


MARK THE C/L OF THE JIG.
ALIGN THE C/L OF THE JIG TO
THE C/L OF THE TRAILER.

DETAIL A



**WELD DOWN SUB-DECK
DETAIL B**

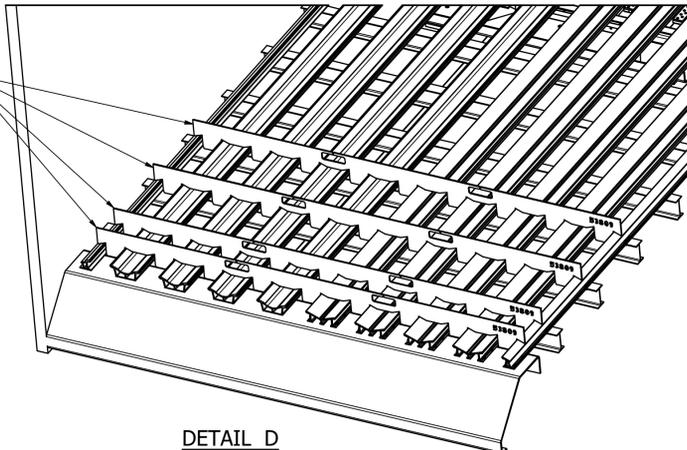


**BOLT DOWN SUB-DECK
DETAIL C**

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

SCREW TO ATTACH
THE SUB-DECK.
Ø1/4-20 UNC X 3/4 LG
HEX WASHER HEAD,
F TYP SELF TAPPING.
4 PLACES/CROSS-MEMBER
SUB-DECK INTERSECTION.
#2 (Ø.221) DRILL.

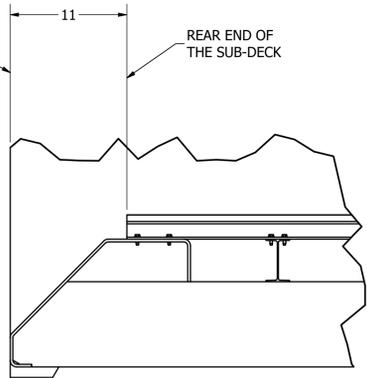
V-FLOOR
SUB-DECK JIGS



DETAIL D

INSIDE FACE
OF THE DOOR

REAR END OF
THE SUB-DECK



DETAIL E

- 1) MARK THE TRAILER CENTER-LINE.
- 2) SET THE SUB-DECK INTO TRAILER AS SHOWN IN
DETAIL A.
- 3) MARK THE CENTER-LINE ON THE JIGS. ALIGN THE JIG
CENTER-LINE WITH THE TRAILER CENTER-LINE.
- 4) POSITION THE REAR EDGE OF THE SUB-DECK 11"
FORWARD OF THE INSIDE FACE OF THE DOOR. ATTACH
THE SUB-DECK BY BOLTING OR WELDING AS SHOWN IN
DETAILS B & C. THE SUB-DECK JIG MUST BE TOUCHING
THE CROSS-MEMBER WHEN THE SUB-DECK IS FASTENED
TO THE CROSS-MEMBER.
- 5) MOVE THE JIGS FORWARD AND SECURE THE SUB-DECK
TO THE NEXT SERIES OF CROSS-MEMBERS.

MARK C/L DOWN CENTER OF
TRAILER PRIOR TO LAYING
SUB-DECK IN TRAILER

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:
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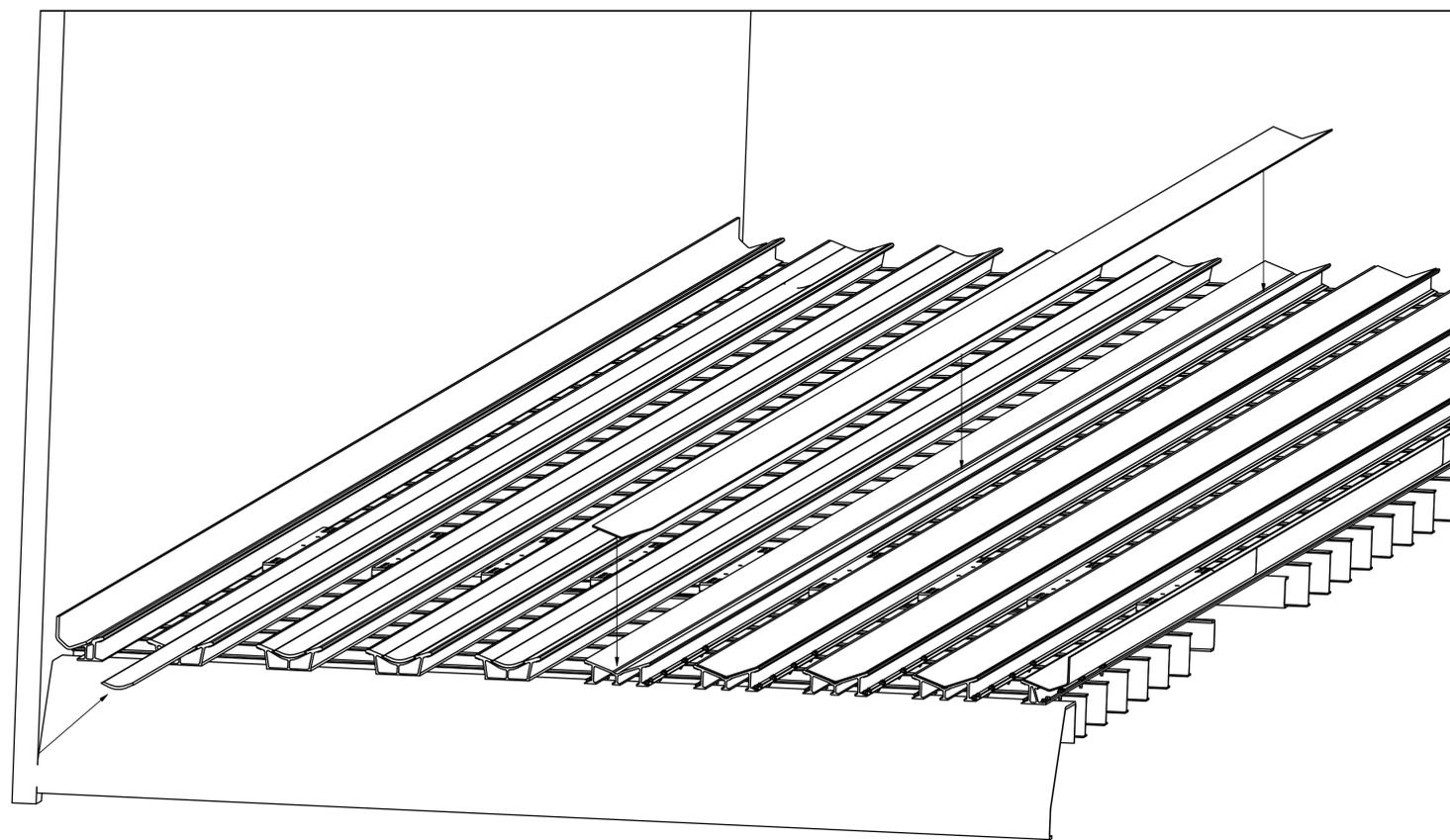
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SCALE: 1=16 SHEET 2 OF 7 DRAWN BY: JD
DATE: 10/3/2007 APPRVD BY:

V-FLOOR GENERAL INSTALLATION INSTRUCTIONS

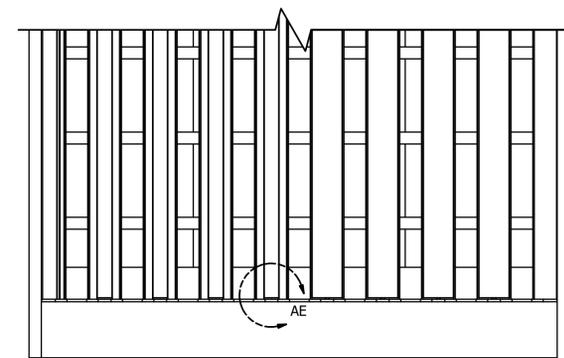
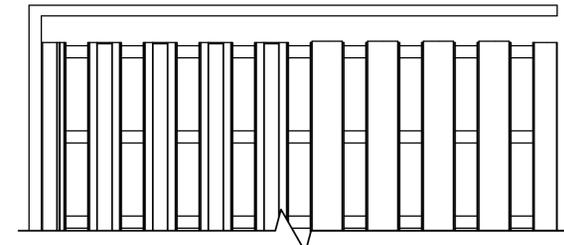
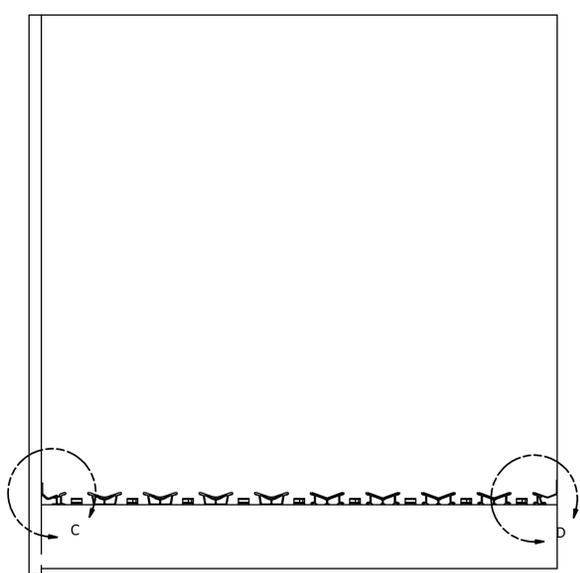
V-SLAT FLOOR DWG NUMBER:
D- 61170 I

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

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

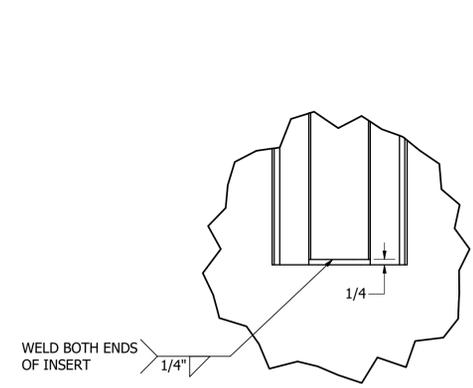


DETAIL A

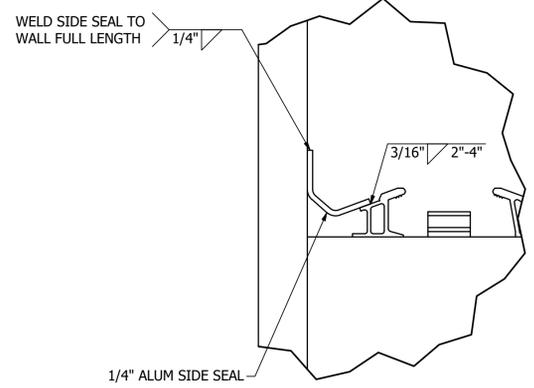


- 1) AFTER SUB-DECK IS SECURED, PLACE BOTTOM V-PAN ON TOP OF SUB-DECK OR IF USING AN ALUMINUM INSERT, SLIDE INSERT INTO DOVE TAIL IN SUB-DECK. AS SHOWN IN DETAIL A.
- 2) STEEL V-PAN SHOULD BE THE SAME LENGTH AS THE SUB-DECK. ALUMINUM INSERT WILL BE 1/2" SHORTER. CENTER THE ALUMINUM INSERT 1/4" FROM EACH END OF THE SUB-DECK AND WELD AS SHOWN IN DETAIL B.
- 3) PLACE SIDE SEAL IN TRAILER. STEEL SIDE SEAL SHOULD BE NO LESS THAN 3/16" FROM EDGE OF SUB-DECK. EITHER WELD OR BOLT SIDE SEAL TO OUTSIDE PIECE OF SUB-DECK AS SHOWN IN DETAILS C & D.
NOTE: MAKE SURE SIDE SEAL SUB-DECK CAPS ARE WELDED ON BEFORE ATTACHING SIDE SEAL. SEE PAGE 3 FOR DETAILS.
- 4) WELD SIDE SEAL TO WALL FULL LENGTH. THIS SHOULD BE DONE WITH SEVERAL SKIP WELDS TO KEEP FROM CONCENTRATING THE HEAT IN ONE AREA.

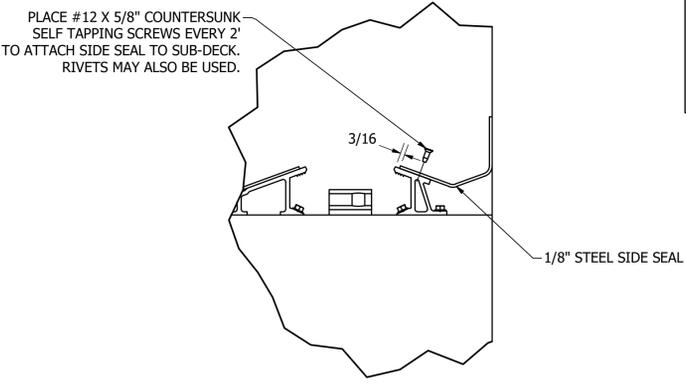
****NOTE****
ANYWHERE THERE IS STEEL IN CONTACT WITH ALUMINUM A CORROSION BARRIER (e.g. MYLAR TAPE, SILICONE PAINT, ANYTHING THAT IS AN ELECTRICAL INSULATOR) SHOULD BE APPLIED.



ALUM SUB-DECK INSERT
DETAIL B



ALUM SIDE SEAL
DETAIL C



STEEL SIDE SEAL
DETAIL D

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED		
TOLERANCES UNLESS OTHERWISE NOTED		
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL: Welded Aluminum-6061
SAW CUT LENGTH:		QUANTITY:
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SCALE: 1=16 SHEET 3 OF 7 DRAWN BY: JD
DATE: 10/3/2007 APPRVD BY:

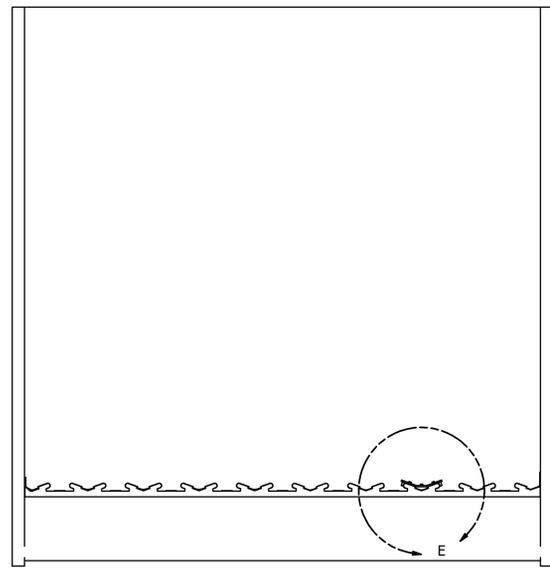
V-FLOOR GENERAL INSTALLATION INSTRUCTIONS
V-SLAT FLOOR DWG NUMBER: D-61170 I

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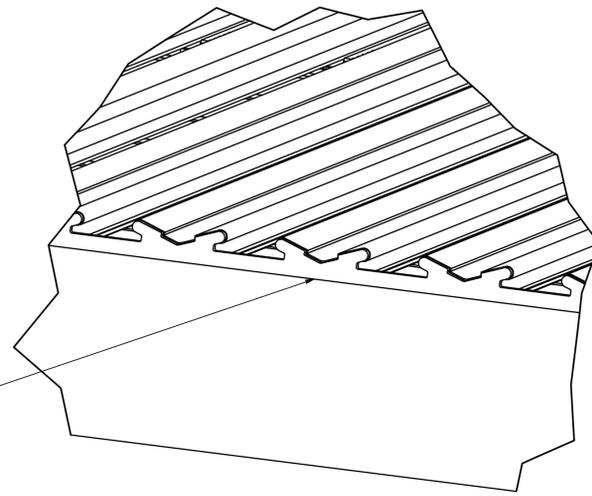
A B C D E F G H I J K L M N O P Q R S T U V W

1 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

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

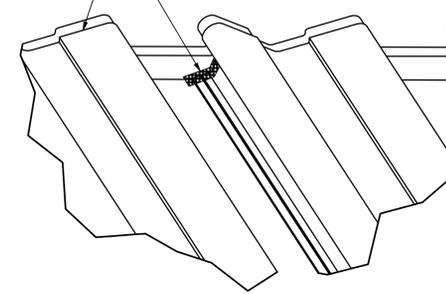


ALUMINUM SUB-DECK END CAP

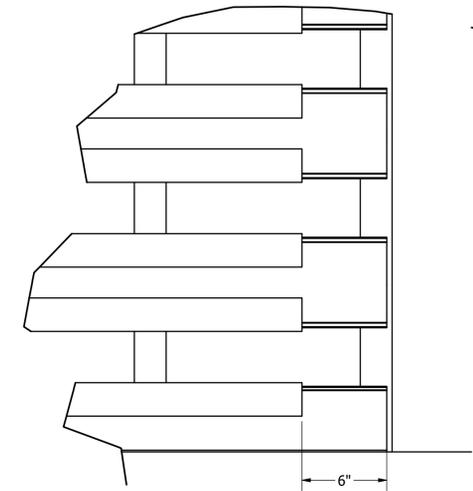


DETAIL A
SCALE 1 / 6

FILLET WELD END CAP TO ALL SUB-DECK PIECES, BOTH SIDES



DETAIL B
SCALE 1 / 3



LOAD END
DETAIL C

1) PLACE 1/2" ALUMINUM END CAP ONTO END OF SUB-DECK ON DISCHARGE END OF TRAILER. THIS NEEDS TO BE PLACED AS SHOWN IN DETAIL A.

2) WELD ALUMINUM END CAP TO SUB-DECK (SEE DETAIL B).

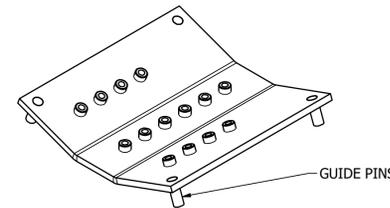
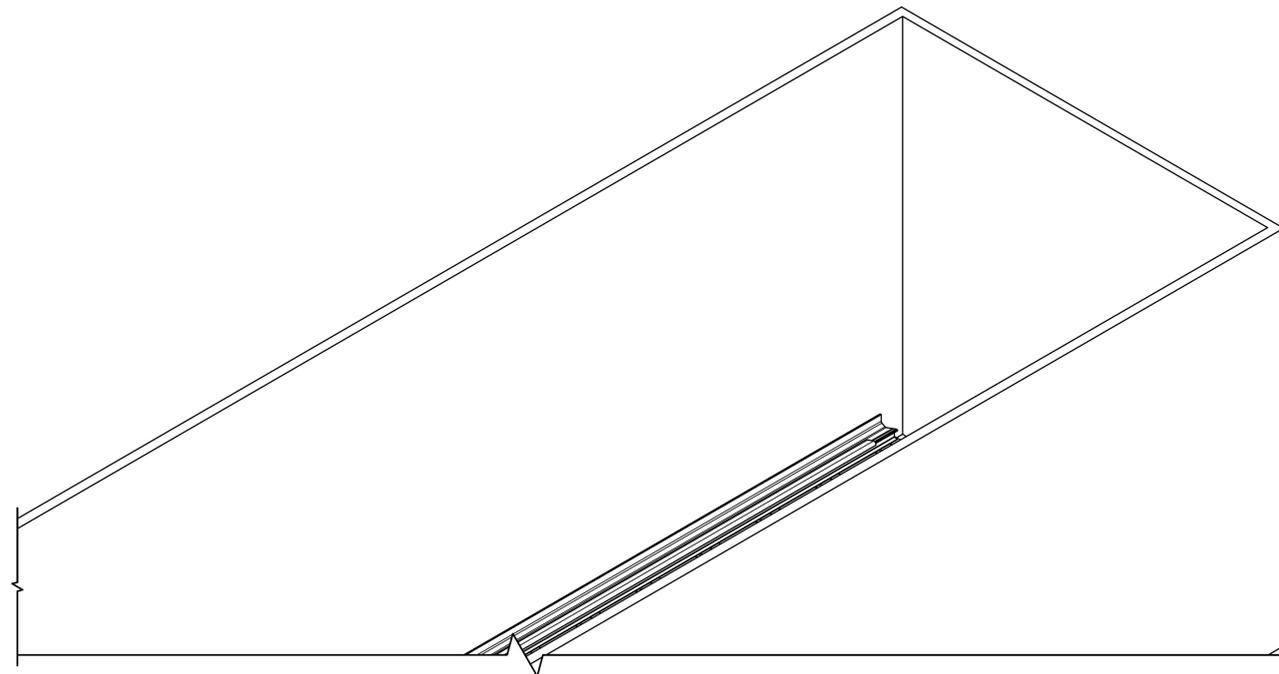
NOTE: ALUMINUM END CAP HOLDS J-BEARING FROM SLIDING OUT DISCHARGE END OF TRAILER.

3) PLACE J-BEARING OVER SUB-DECK AND BOTTOM V-PAN OR INSERT. START FLUSH AGAINST SUB-DECK ON DISCHARGE END AND END 6" FROM FRONT OF SUB-DECK AS SEEN IN DETAIL C.

4) CLAMP THE DRILL JIG (P/N 8270302) IN PLACE AS SHOWN IN DETAILS D AND E. DRILL PILOT HOLES THROUGH THE J-BEARING AND SUB-DECK USING THE DRILL TEMPLATE JIG AND A 15/64" (5.95 mm) 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.

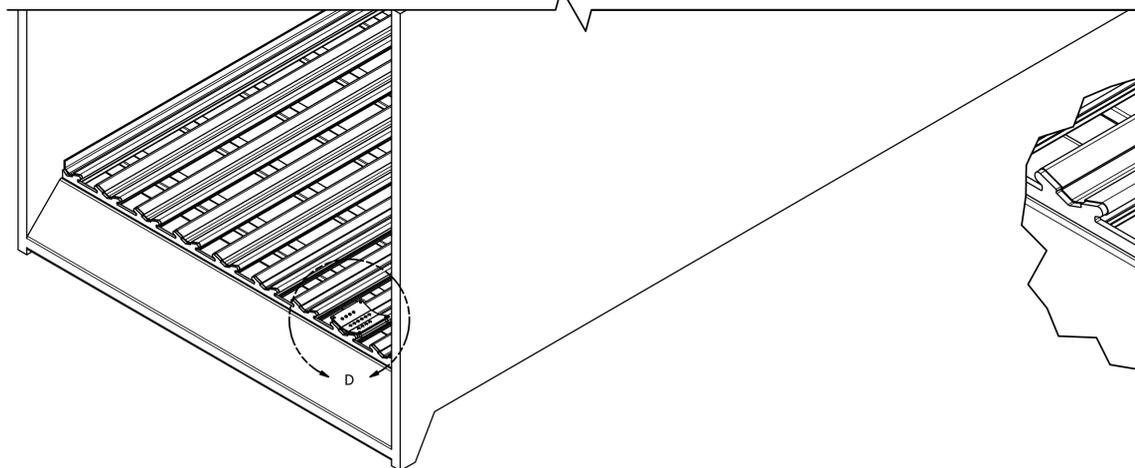
INSTALL (4) 1/4 x 5/8 FHCS TORX F TYPE, ZINC SCREWS (KEITH P/N 87701592) AT THE DISCHARGE END OF EACH PIECE OF J-BEARING. IN ALL CASES, USE LOCTITE THREAD RETAINER #243 OR EQUIVALENT. BE SURE THE SCREW HEADS ARE .04-.06 BELOW FLUSH W/ THE SURFACE OF THE BEARING. THIS SECURES THE BEARING IN PLACE.

*NOTE FOR SYSTEMS W/ STEEL TROUGH LINER #2460: THE STEEL USED FOR THE TROUGH LINER WILL WORK-HARDEN. TO PREVENT WORK-HARDENING USE A REDUCED RPM DRILLING SPEED W/ CUTTING OIL WHILE APPLYING A STEADY, CONTINUOUS PRESSURE. STEEL TROUGH LINER DOES NOT REQUIRE CENTER ROW OF PRE-DRILLED HOLES.

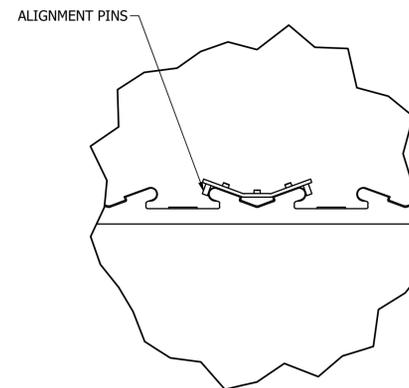


DRILL JIG (P/N 8270302)

MIDDLE ROW OF HOLES IN DRILL JIG FOR OTHER PARTS.



DETAIL D
SCALE 1 / 6



DETAIL E
SCALE 1 / 6

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:

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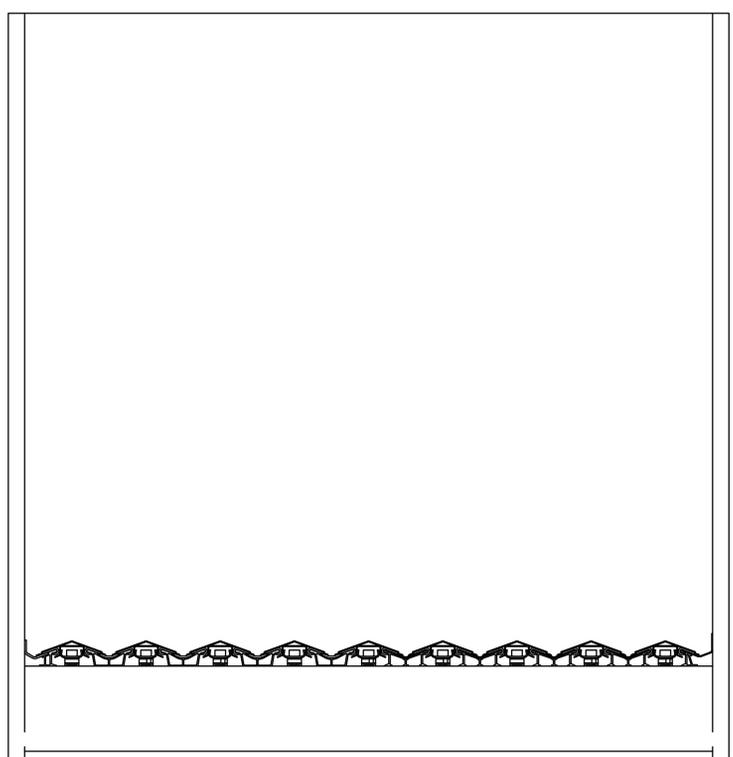
V-FLOOR GENERAL INSTALLATION INSTRUCTIONS
V-SLAT FLOOR DWG NUMBER:
D- 61170 1

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

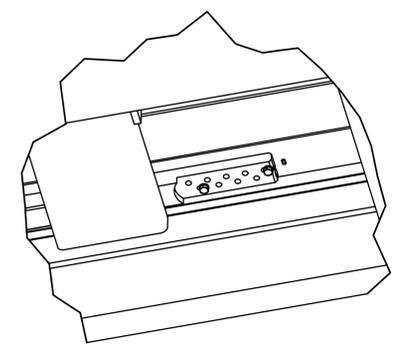
A B C D E F G H I J K L M N O P Q R S T U V W

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

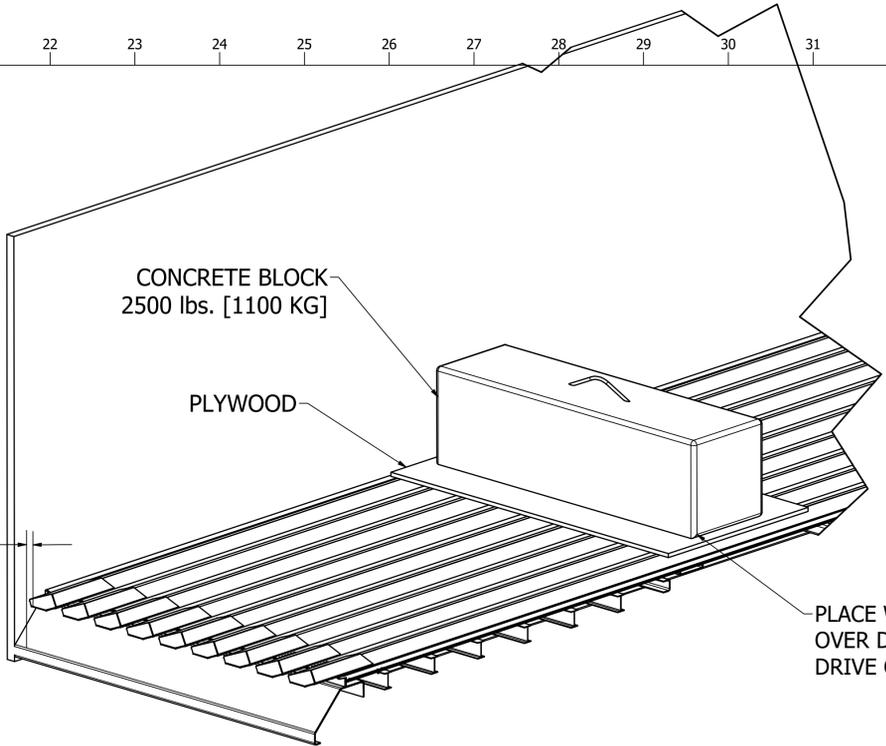
A B C D E F G H I J K L M N O P Q R S T U V W



1/2" ALUMINUM END CAP NOT SHOWN FOR CLARITY



BOLT DIAGRAM
DETAIL A



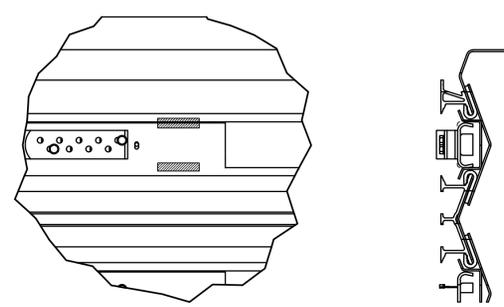
CONCRETE BLOCK
2500 lbs. [1100 KG]

PLYWOOD

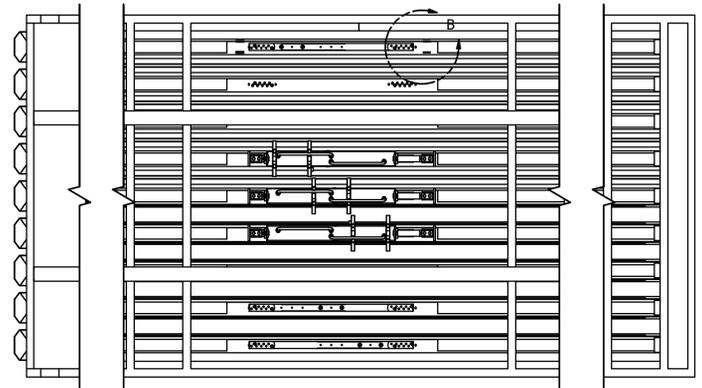
1"
SLAT TO INSIDE
OF DOOR

PLACE WEIGHT ON SLATS
OVER DRIVE WHEN TACKING
DRIVE CHANNELS IN PLACE.

DETAIL AH
SCALE 1 / 20



DETAIL B
SCALE 1 / 6

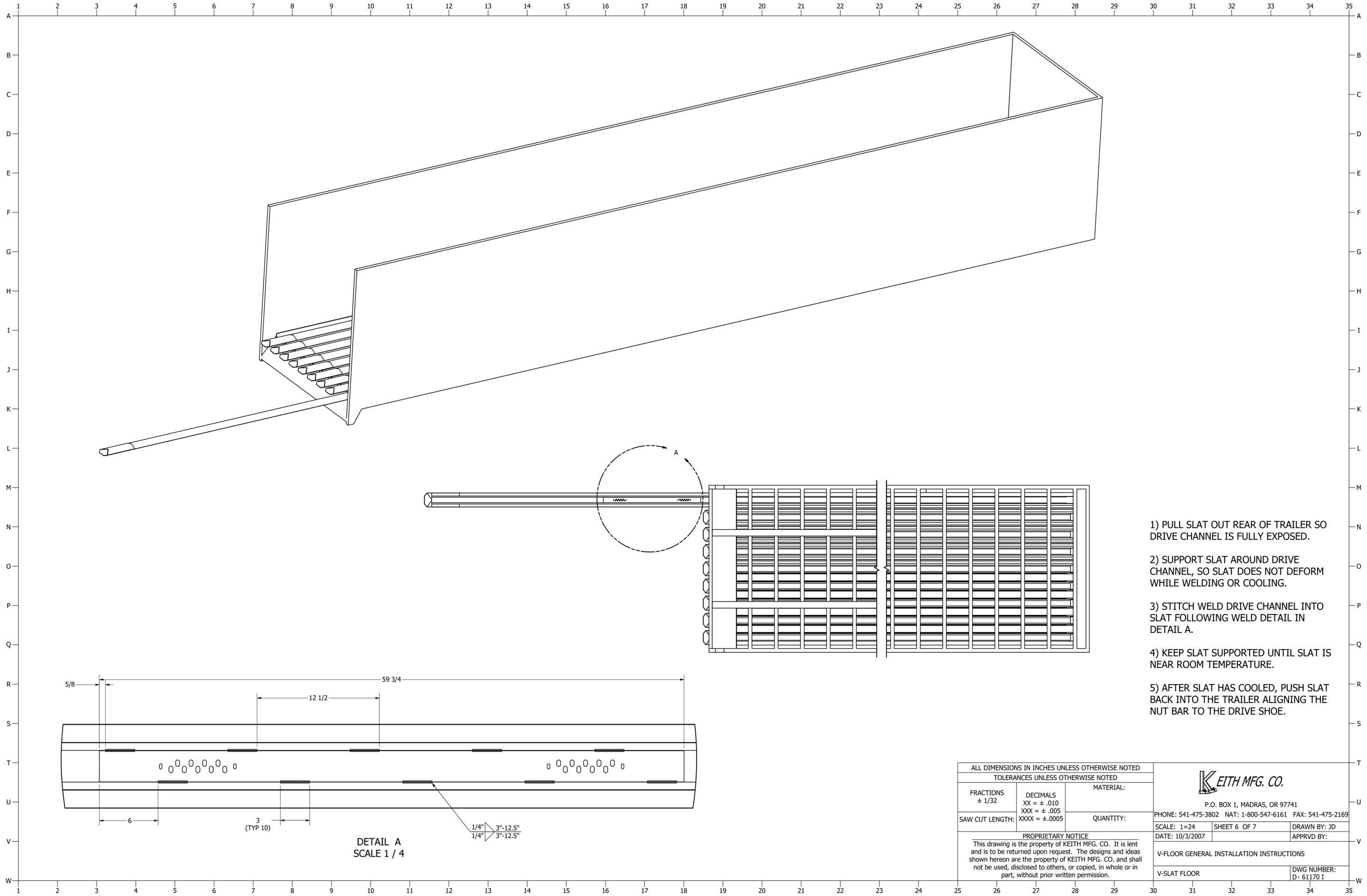


- 1) ATTACH DRIVE CHANNELS TO SHOES ON X-DRIVE.
- 2) USE ONLY TWO BOLTS PER SHOE SIDE, AS SHOWN IN
DETAIL A.
DO NOT TIGHTEN, THE DRIVE SHOE SHOULD BE ABLE
TO SLIDE SIDE TO SIDE IN THE SLOTS.
- 3) SLIDE SLATS INTO TRAILER. MAKE SURE THE
CYLINDERS ARE COLLAPSED TO THE DISCHARGE END OF
THE TRAILER.
- 4) SLATS SHOULD END 1" 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 B.
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.

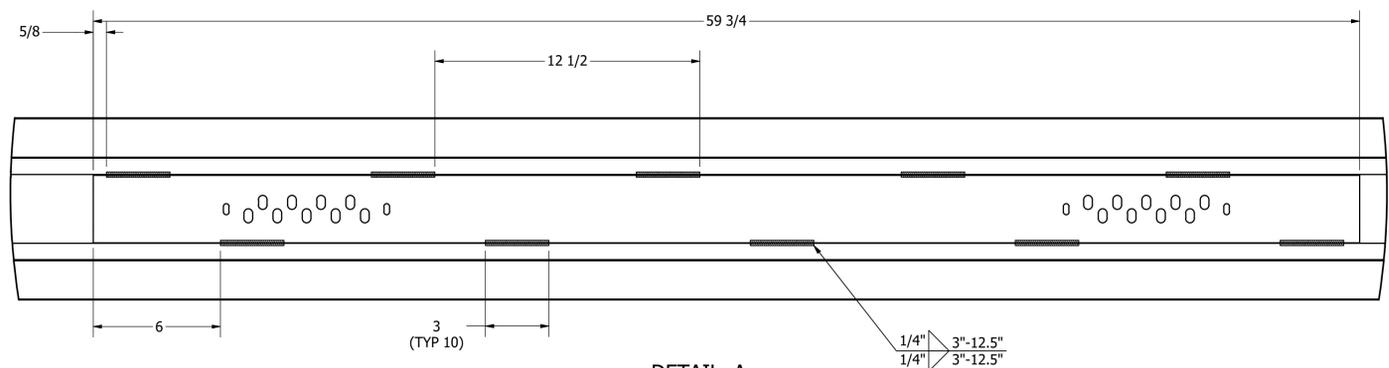
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED			KEITH MFG. CO. P.O. BOX 1, MADRAS, OR 97741 PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169		
TOLERANCES UNLESS OTHERWISE NOTED					
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:	SCALE:	SHEET 5 OF 7	DRAWN BY: JD
SAW CUT LENGTH:		QUANTITY:	DATE: 10/3/2007		APPRVD BY:
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			DWG NUMBER: D- 61170 I		

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

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



- 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.

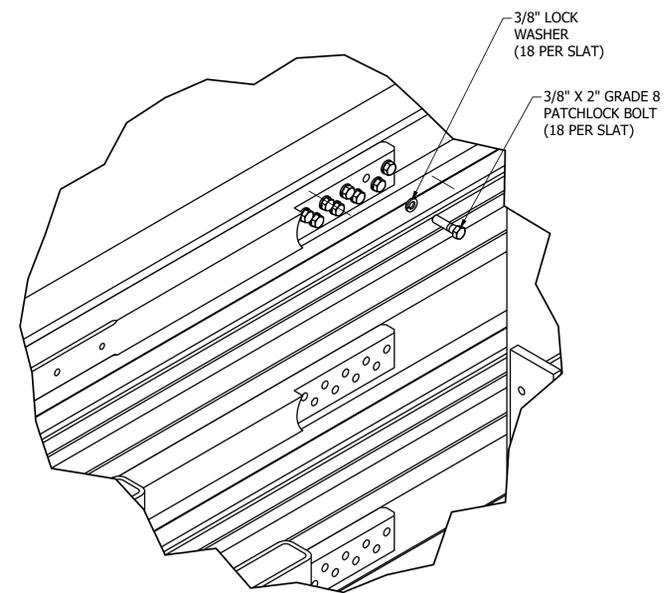
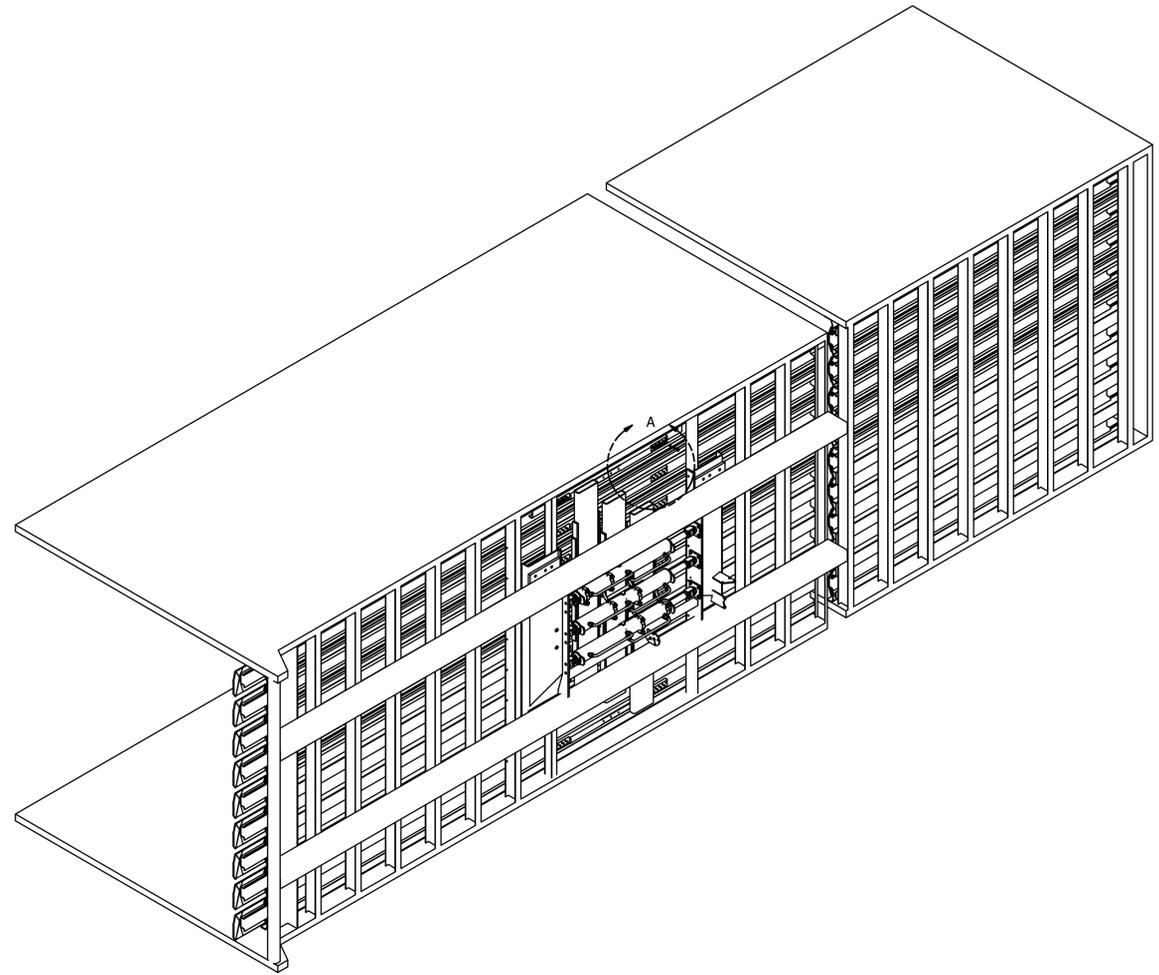


DETAIL A
SCALE 1 / 4

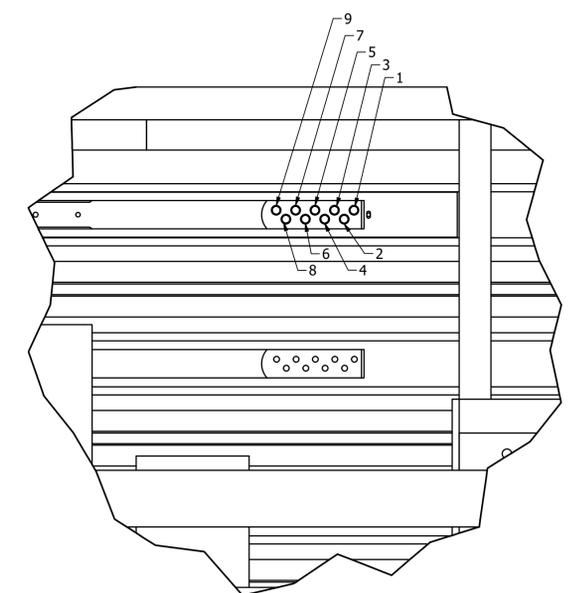
ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED			 P.O. BOX 1, MADRAS, OR 97741 PHONE: 541-475-3802 NAT: 1-800-547-6161 FAX: 541-475-2169		
TOLERANCES UNLESS OTHERWISE NOTED					
FRACTIONS ± 1/32	DECIMALS XX = ± .010 XXX = ± .005 XXXX = ± .0005	MATERIAL:	QUANTITY:		
SAW CUT LENGTH:			DATE: 10/3/2007		
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			APPRVD BY:		
			V-FLOOR GENERAL INSTALLATION INSTRUCTIONS		
			V-SLAT FLOOR		
			DWG NUMBER: D- 61170 1		

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

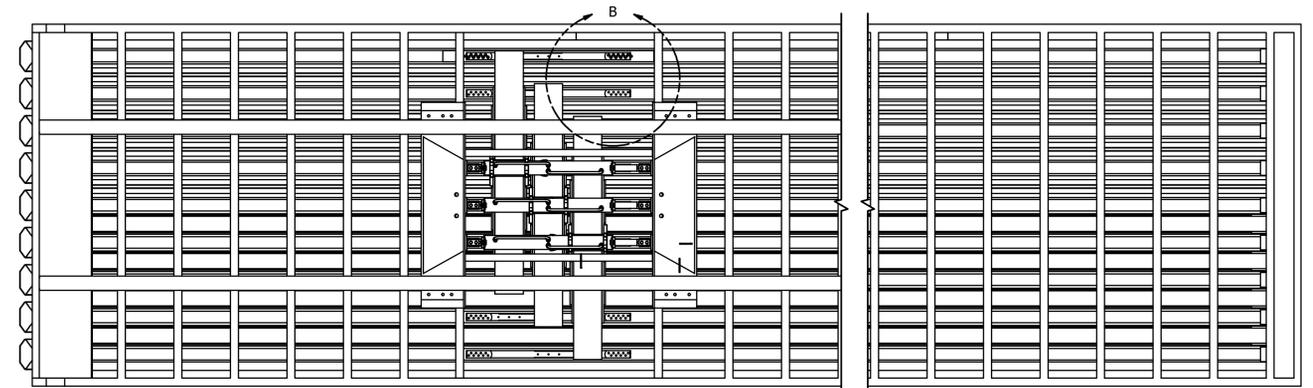
A B C D E F G H I J K L M N O P Q R S T U V W



DETAIL A



DETAIL B



- 1) BOLT DRIVE SHOE TO SLAT USING 3/8" X 2" HEX BOLTS AND LOCK WASHERS.
- 2) TORQUE BOLTS TO 45 FT-LBS.
- 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)

ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED			KEITH MFG. CO. 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 7 OF 7		
SAW CUT LENGTH:		QUANTITY:	DATE: 10/3/2007	DRAWN BY: JD APPRVD BY:	
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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