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ITEM	QUAN	DESCRIPTION	SIZE
1	4	FINGER SIDE FRAMES	2" x 10" x 20'-0"
2	2	BASE SIDE FRAMES	2" x 10" x 18'-0"
3	19	END AND CROSS FRAMES	2" x 10" x 3'-9"
4	4	FINGER DIAGONAL BRACES	2" x 10" x 5'-6"
5	2	BASE DIAGONAL BRACES	2" x 10" x 4'-6"
6	4	FINGER SIDE SKIRTS	2" x 6" x 20'-0"
7	2	BASE SIDE SKIRTS	2" x 6" x 18'-0"
8	6	END SKIRTS	2" x 6" x 3'-9"
9	14	BILLET SUPPORTS	2" x 6" x 4'-0"
10	4	FINGER SKID BOARDS	2" x 6" x 20'-0"
11	2	BASE SKID BOARDS	2" x 6" x 18'-0"
12	10	SKIRT SUPPORTS	2" x 6" x 1'-4 1/2"
13	29	DECKING	2" x 6" x 18'-0"
14	8	FINGER CORNER POSTS	4" x 4" x 1'-4 1/2"
15	2	BASE OUTSIDE POSTS	4" x 4" x 1'-4 1/2"
16	4	BASE CONNECTING POSTS	4" x 4" x 1'-4 1/2"
17	28	THREADED ROD	1/2"-20UNC x 16"long
18	12	THREADED ROD	1/2"-20UNC x 12"long
19	88	CARRIAGE BOLTS	1/2"-20UNC x 6"long
20	168	NUTS AND FLAT WASHERS	1/2"
21	808	NAILS (18 lbs.)	16 d
22	13	STYROFOAM* BRAND BUOYANCY BILLETS	10" x 20" x 8'-0"

NOTES

1. ALL LUMBER ITEMS 1 THRU 16 TO BE SOUTHERN YELLOW PINE TREATED WITH CHROMATED COPPER ARSENATE OR OTHER WATER BORN ARSENICALS.
2. ALL HARDWARE ITEMS 17 THRU 21 TO BE GALVANIZED STEEL.
3. STYROFOAM* BRAND BUOYANCY BILLETS WILL GIVE APPROXIMATELY 4707 LBS. AVAILABLE LIVELOAD.
4. APPROXIMATE DOCK WEIGHT 3239 LBS. (INCLUDING BILLETS).
5. THE DESIGN OF THIS FLOATING STRUCTURE ALLOWS FOR THE ADDITION OF METAL FRAME/CANVAS ROOF COVER WHICH CAN BE DESIGNED BY A LOCAL CANVAS/AWNING CONTRACTOR.

18' x 24' "U" DOCK-ASSEMBLY SUGGESTIONS

THE THREE DOCKS WILL BE ASSEMBLED UPSIDE DOWN UNTIL TIME TO ASSEMBLE IN THE WATER. DECKING WILL BE INSTALLED AFTER DOCKS ARE ASSEMBLED IN THE WATER.

FIRST FINGER DOCK:

NAIL TOGETHER THE 2" x 10" MAIN FRAME SIDES, ENDS & CROSS FRAMES, PARTS #1 AND #3.

CAREFULLY AND CLOSELY CUT ENDS FOR DIAGONAL CROSS BRACES, PART #4. THIS PIECE SHOULD FIT IN VERY SNUGLY AND BE MITERED INTO THE 90° CORNER.

CLAMP 4" x 4" POSTS, #14, IN PLACE. NOTE THAT HOLE PATTERN ON DRAWING IS RIGHT SIDE UP AND YOU ARE WORKING UPSIDE DOWN. THEN DRILL HOLES THRU 10" AND 4" x 4" POST AT SAME TIME. INSTALL 1/2" CARRIAGE BOLTS AS THE HOLES ARE DRILLED. DRILLED HOLES SHOULD BE AS SMALL AS POSSIBLE TO ALLOW 1/2" BOLTS TO ENTER. A TIGHT FIT BETWEEN BOLT AND HOLE IS DESIRED.

NAIL ON BILLET SUPPORTS, #9, WITH TWO NAILS ON EACH END.

NAIL SKIRT PARTS, #7 AND #8, AT ENDS.

CLAMP SKIRTS TO 4" x 4" POSTS AND DRILL HOLES THRU SKIRTS AND POST INSTALLING CARRIAGE BOLTS AS HOLES ARE DRILLED. AGAIN REMEMBER THAT HOLE PATTERN ON DRAWING IS UPSIDE DOWN TO THE WAY YOU ARE WORKING.

INSTALL TWO THREADED RODS, #18, THRU CONNECTOR CORNER POST IN SKIRT ONLY, AND PUT NUTS AND WASHERS ON EACH END IN FINGER DOCK.

CHECK ALL CARRIAGE BOLT NUTS FOR TIGHTNESS BEFORE PROCEEDING FURTHER. CUT, WITH A HAND SAW, ONE OF THE 10" x 20" x 8' FOAM BILLETS INTO FOUR EQUAL LENGTHS OF 2' EACH.

LAY FOUR FULL LENGTHS AND TWO 2' LONG BILLETS, #22, IN PLACE AS SHOWN IN THE DRAWING. AT CORNER POST WHERE CONNECTION TO NEXT DOCK WILL BE MADE, LEAVE ENOUGH ROOM TO GET A WRENCH ON THE NUT.

NAIL FOUR SKIRT SUPPORTS, #12, BETWEEN THE 8' AND 2' LENGTHS OF BILLET ALONG SIDE.

LAY SKID BOARDS, #10, DOWN CENTERS OF FOAM BILLETS.

LINE UP HOLE LOCATION WHICH WILL GO THRU SKID BOARD, FOAM BILLETS AND SUPPORTS. DRILL A HOLE ALL THE WAY THRU, 5/8" DIAMETER.

INSTALL THREADED RODS, #17, AND SECURE WITH FLAT WASHER AND NUTS. AFTER TIGHTENING NUTS DAMAGE THREADS SO NUTS CANNOT WORK LOOSE. NOTE, THAT SOME NUTS ON INSIDE MAY HAVE TO BE INSTALLED AFTER TURNING DOCK OVER. TURN FINGER DOCK OVER AND FINISH INSTALLING NUTS ON FOAM THREADED RODS THRU FOAM.

DO NOT INSTALL DECKING AT THIS TIME.

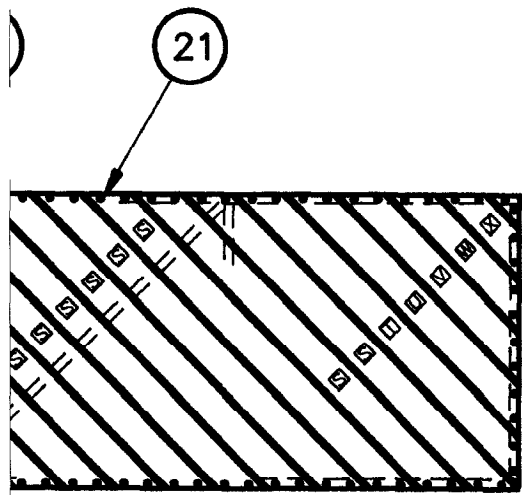
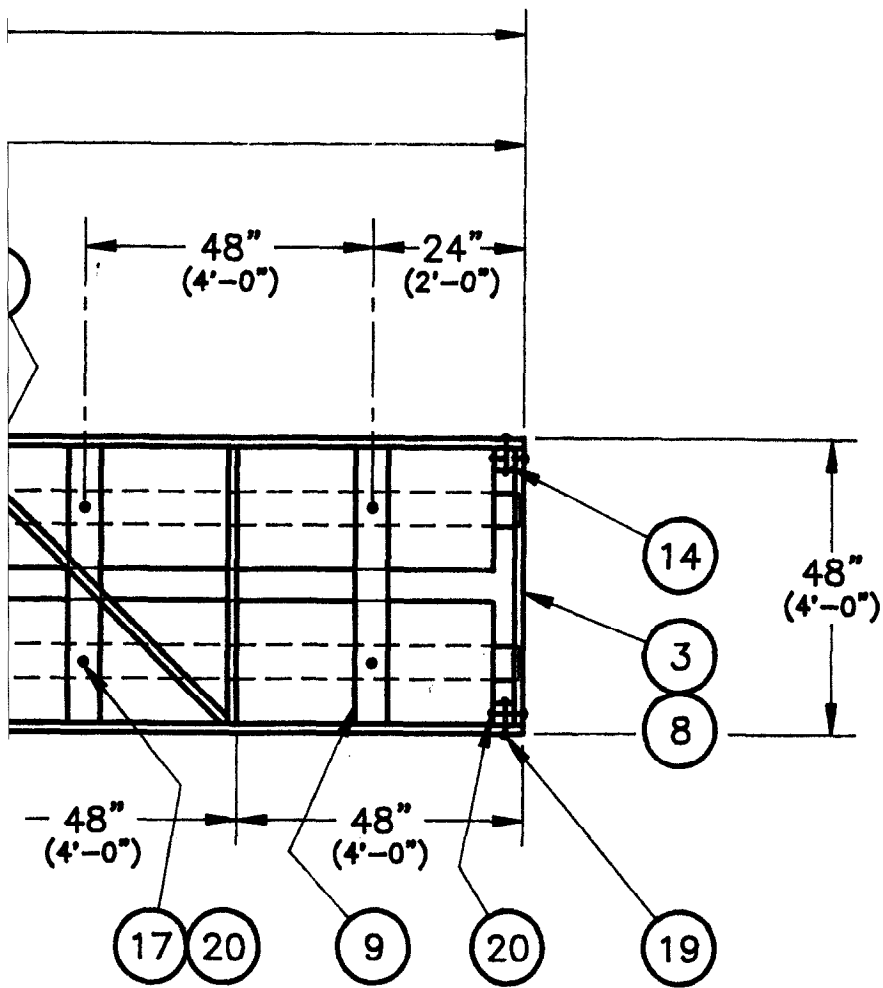
SECOND FINGER DOCK:

FOLLOW SAME PROCEDURE AS FOR FIRST DOCK. THE ONLY DIFFERENCE BEING THAT THE DIAGONAL FRAME BRACES, #4, ARE INSTALLED IN OPPOSITE DIRECTIONS AS SHOWN BY DASHED LINES UNDER DECKING IN PLAN VIEW.

BASE DOCK:

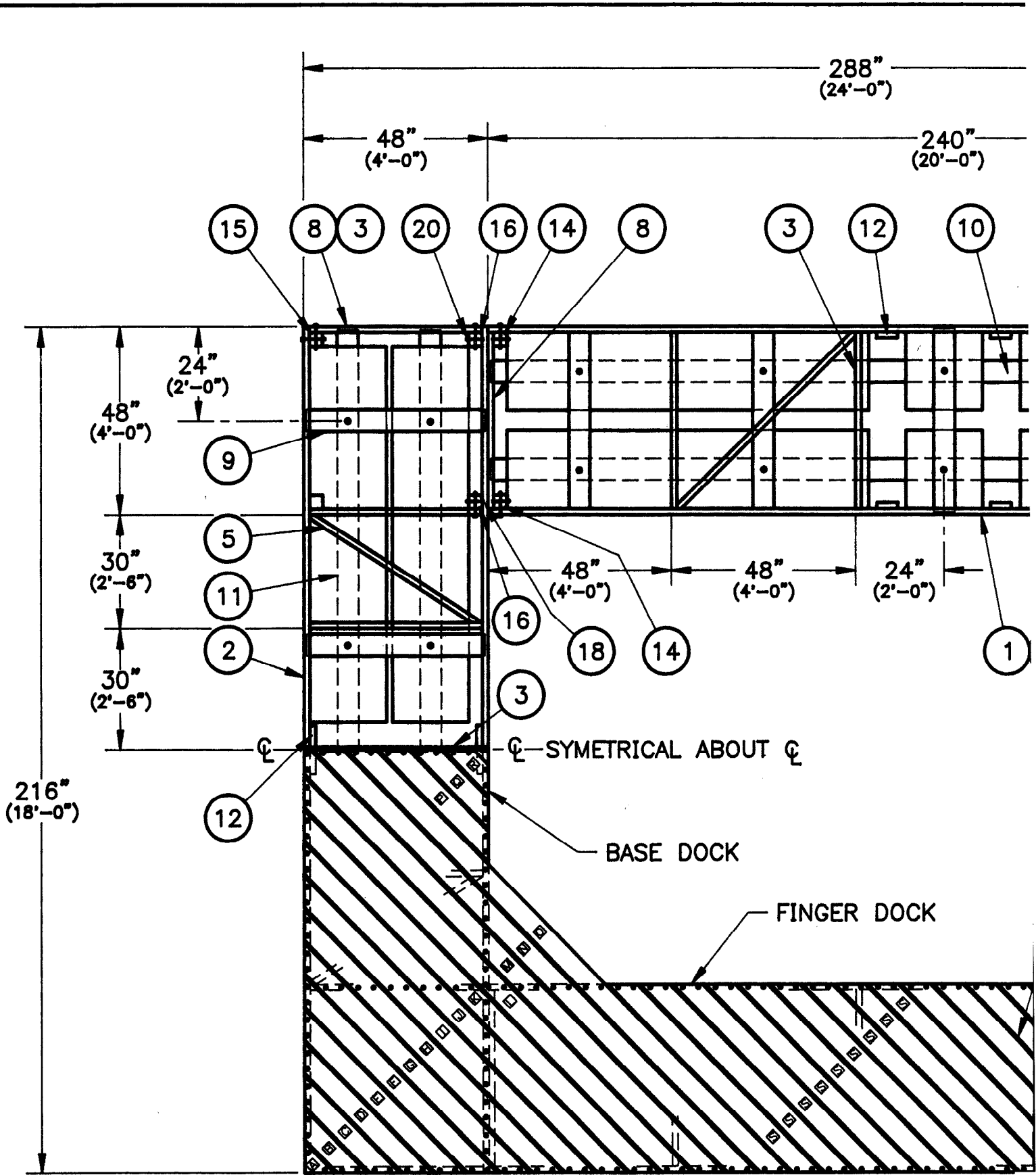
NAIL TOGETHER THE 2" x 10" MAIN FRAME SIDES, ENDS, AND CROSS FRAMES, PARTS #2 AND #3.

CAREFULLY AND CLOSELY CUT ENDS FOR DIAGONAL CROSS BRACES, PART #5. THIS PIECE SHOULD FIT IN VERY SNUGLY AND BE MITERED INTO THE 90° CORNER.

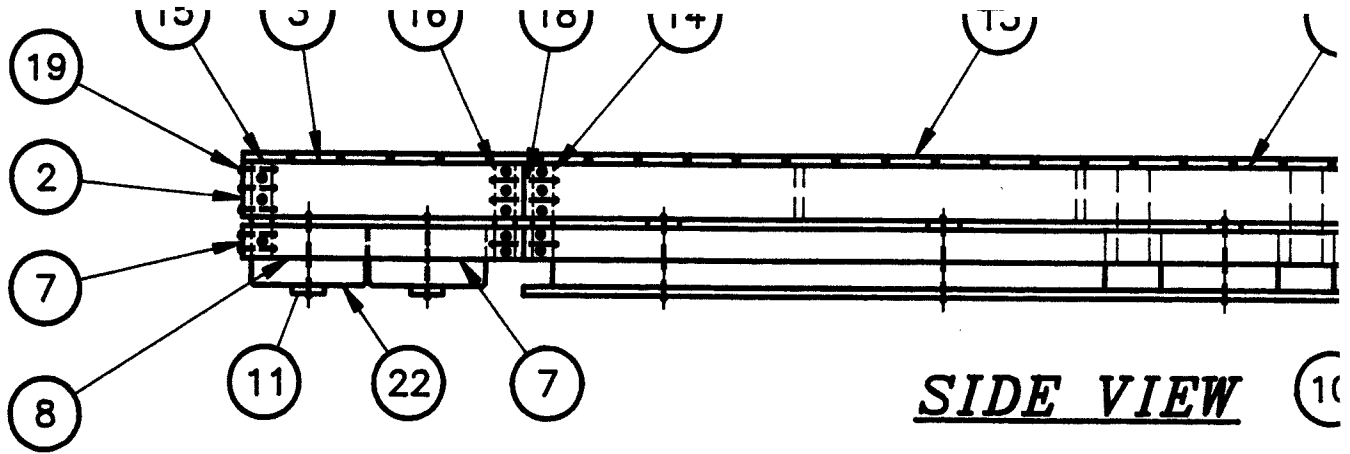


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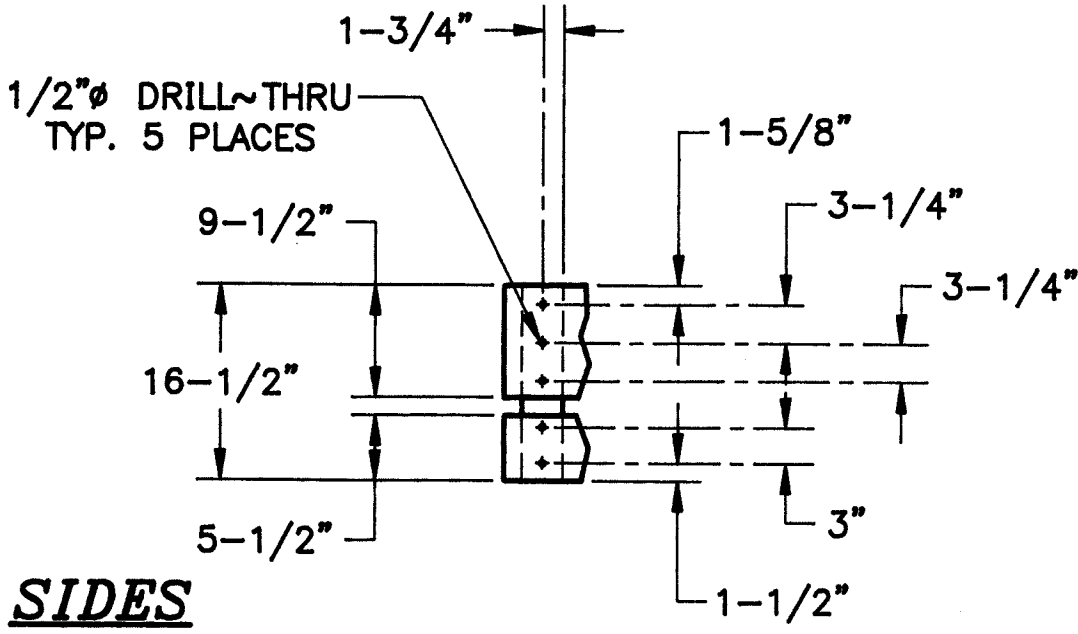
- A. FIRS
- 1. NAIL #1 /
- 2. CARE PIEC
- 3. CLAM RIGH 10" ARE BOLI
- 4. NAIL
- 5. NAIL
- 6. CLAM INST PATI
- 7. INST ONLY
- 8. CHEE
- 9. CUT, EQU
- 10. LAY IN T MAD
- 11. NAIL ALO
- 12. LAY
- 13. LINE SUP
- 14. INST TIGH SOM
- 15. TUR THR
- 16. DO
- B. SEC FOL THE SHO
- C. BAS
- 1. NAI



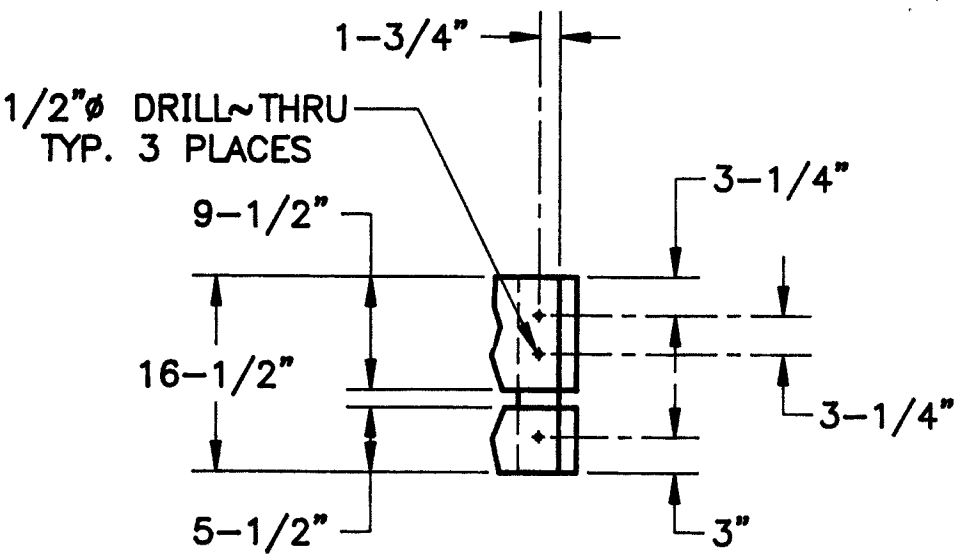
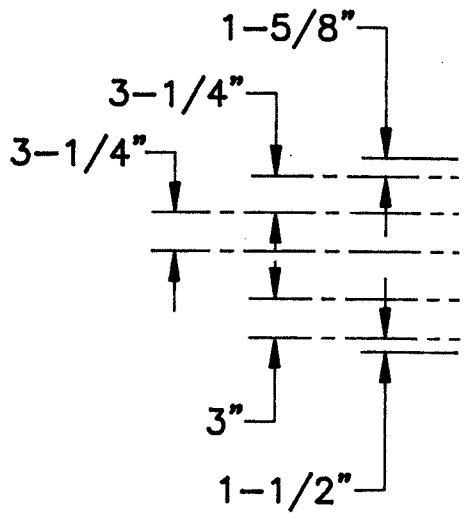
PLAN VIEW



SIDE VIEW (10)



SIDES



END

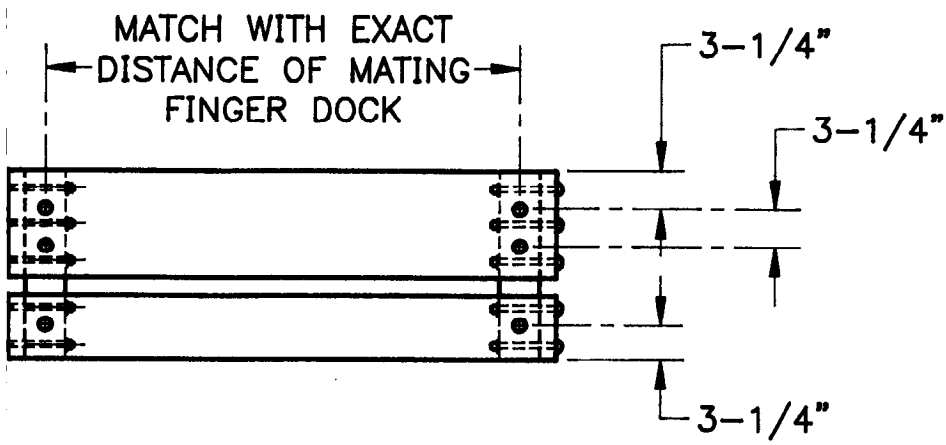
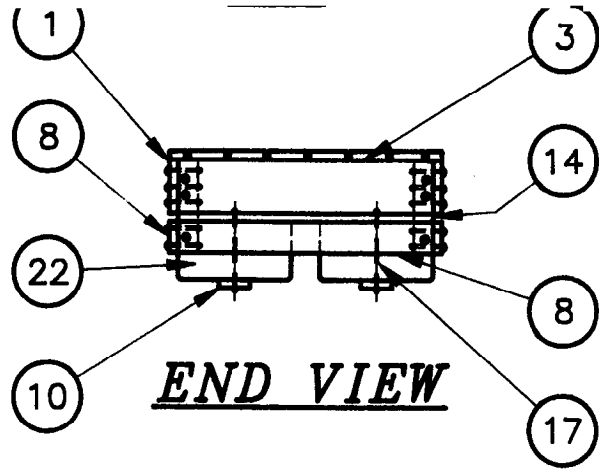
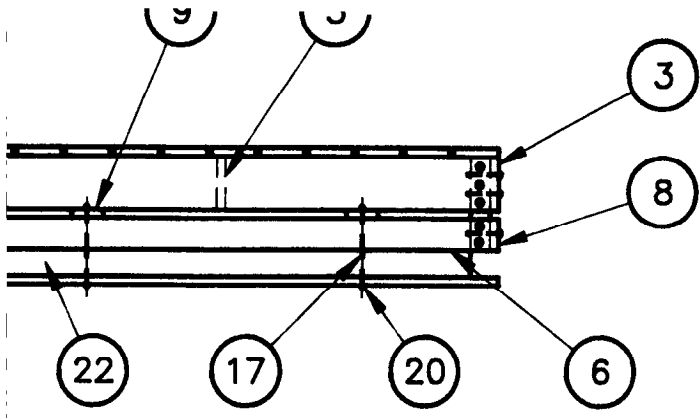
DECKING

29 PIECES 2"

QUANT. CUT FR

1	I	⊙108"
2	J	⊙120"
2	K	⊙132"
2	L	⊙144"
2	M	⊙156"
2	N	⊙158"
2	N	⊙158"
1	T	⊙66"
1	U	⊙48"
1	V	⊙42"
13	S	SEE C

REF #13



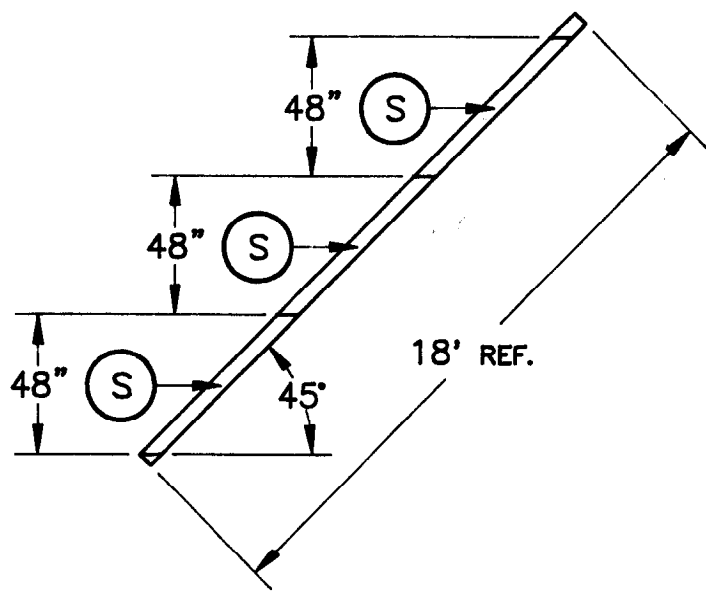
HOLE LAYOUT OF BASE DOCK WHERE FINGER K ATTACH-#16 NOT TO SCALE

INSTALLATION LIST

216" LG. BOARDS

- @108"
- @96"
- @84"
- @72"
- @60"
- @30" R @16"
- @12" C @36"
- @66" P @42" P @42"
- @48" W @30" W @30" B @24" B @24"
- @42" D @48" D @48" X @18" X @18"

INSTALLATION DIAGRAM, 3 PIECES PER 18' LENGTH.



3. CLAM DRAW SPEC HOLE BOLTS TO ALL
4. NAIL
5. NAIL
6. CLAM INSTA PATTE #16
7. CHECK
8. LAY A LAYOUT REME TOWA
9. NAIL
10. LAY S
11. LINE SUPP
12. INSTA TIGHT SOME
13. TURN
14. DO N
- D. FINAL
1. PUT (
- MATCH
2. WORK #18, DOCK
3. PUT I
4. PUT !
5. INSTA DOCK
6. CHECK
7. INSTA SIDES LEAVE CUTTI
8. ANCH TIONS
- Always
- Bevel in an
- A was threa

4" x 4" POST, #15 AND #16, IN PLACE. NOTE, THAT HOLE PATTERN ON IG IS RIGHT SIDE UP AND YOU ARE WORKING UPSIDE DOWN. ALSO NOTE L HOLE PATTERN FOR POST, #16, WHERE DOCKS CONNECT. THEN DRILL THRU 2" x 10" AND 4" x 4" POST AT SAME TIME. INSTALL 1/2" CARRIAGE AS HOLES ARE DRILLED. DRILLED HOLES SHOULD BE AS SMALL AS POSSIBLE OW 1/2" BOLTS TO ENTER. A TIGHT FIT BETWEEN BOLT AND HOLE IS DESIRED. N SUPPORTS, #9, WITH TWO NAILS ON EACH END. KIRT, #7 AND #8, AT BOTH ENDS.

SKIRTS TO 4" x 4" POSTS AND DRILL HOLES THRU SKIRTS AND POST LING CARRIAGE BOLTS AS HOLES ARE DRILLED. AGAIN REMEMBER THAT HOLE N ON DRAWING IS UPSIDE DOWN TO THE WAY YOU ARE WORKING AND POSTS RE DIFFERENT.

ALL CARRIAGE BOLTS FOR TIGHTNESS BEFORE PROCEEDING FURTHER. L FOUR FOAM BILLETS, #22, IN PLACE AS SHOWN ON DRAWINGS. NOTE, PATTERN IS DIFFERENT FOR FINGER DOCK THAN BASE DOCK. AGAIN, BER YOU ARE WORKING UPSIDE DOWN. NOTCH OUT FOAM BY POST #16, O CENTER SO NUT ON CONNECTING THREADED ROD CAN BE REACHED. HE TWO SKIRTS SUPPORTS, #12, IN PLACE.

ID BOARDS, #11, DOWN CENTERS OF FOAM BILLETS. P HOLE LOCATION WHICH WILL GO THRU SKID BOARD, FOAM BILLETS AND RTS AND DRILL A HOLE ALL THE WAY THRU, 5/8" DIAMETER.

L THREADED RODS, #17, AND SECURE WITH FLAT WASHERS AND NUTS, AFTER NING NUTS DAMAGE THREADS SO NUTS CANNOT WORK LOOSE. NOTE, THAT NUTS ON INSIDE MAY HAVE TO BE INSTALLED AFTER TURNING DOCK OVER. DOCK OVER AND FINISH INSTALLING NUTS ON FOAM THREADED RODS. T INSTALL DECKING AT THIS TIME.

ASSEMBLY:

VE FINGER AND BASE DOCK IN SHALLOW WATER AND MOVE FINGER DOCK INTO NG POSITION.

NG IN WATER, NOT FROM TOP OF DOCKS, SLIDE THE TWO THREADED RODS, HICH ARE ALREADY INSTALLED IN FINGERS, INTO MATCHING HOLES IN BASE POST #16.

AT WASHER AND NUTS ON THREADED ROD AND TIGHTEN.

ECOND FINGER DOCK IN WATER AND FOLLOW ABOVE STEPS UNTIL SECURE.

L REMAINING EIGHT THREADED RODS, #18, BETWEEN FINGER DOCKS AND BASE

NUTS ON THREADED CONNECTOR RODS FOR TIGHTNESS BEFORE PROCEEDING. L DECKING. START WITH BOARD "A" AND PROCEED THRU ALPHABET FOR BOTH FOLLOWING CUTTING PATTERN GIVEN IN CHART FOR EFFICIENT USE OF LUMBER. 1/2" BETWEEN BOARDS. CUTS ARE AT 45°, LENGTHS ARE ADEQUATE FOR G AFTER INSTALLATION.

R DOCK AND ENJOY! CONTACT A LOCAL CONSULTANT FOR ANCHORING INSTRUC- BEST SUITED FOR LOCATION AND USAGE.

CONSTRUCTION HINTS:

leave about 1/2" of space between the billet and the skirt so they will not rub. each end of the 2" x 6" skids. Beveling the skids will facilitate moving the dock(s) out of the water.

er and nut hammered into the 2" x 6" skid will sink them flush and bend the s enough to lock the nut onto the rod.

FEATURES OF STYROFOAM* BRAND BUOYANCY BILLETS

- **CFC FREE**
Produced with a blowing agent that provides a 94% reduction in ozone depletion potential compared to that of standard cfcs.
- **APPROVED BY THE ARMY CORPS OF ENGINEERS**
- **EFFICIENT SIZE**
The 7" x 20" x 8", 10" x 20" x 8', and 10" x 24" x 8' standard sizes are ideal for a variety of buoyancy applications.
- **LIGHTWEIGHT**
A 10" x 20" x 8' STYROFOAM brand buoyancy billet weighs 22 pounds for easy handling.
- **EASY TO WORK**
Fast easy construction.
- **RUGGED**
Not destroyed by punctures.
- **DURABLE**
Will not rot, water-log, rust, or corrode.
- **QUIET**
There is no echoing drum sound from waves.
- **MAINTENANCE FREE (1)**
The billet itself requires practically no maintenance.
- **BLUE* COLOR**
The distinctive color Blue* of STYROFOAM brand buoyancy billets is also aesthetically pleasing in the water.

(1) NOTE: The foam is subject to attack by some solvents including concentrated quantities of gasoline and oil. In case of extreme solvent exposure, reaction of the foam should be checked prior to construction. Additional protection – such as polyurethane coatings – in such extreme exposure cases may be required. Skirt boards will protect foam from mechanical damage and ultraviolet light degradation.

Blueprints of the "TEE" DOCK, "U" DOCK, and SWIM RAFT may be obtained from the Customer Information Center, Midland, Michigan. For sales information, call 1-800-441-4369.

NOTICE: STYROFOAM brand insulation is **combustible** and should be protected from flame and other high heat sources. It should be installed with code-acceptable thermal barriers or used in approved alternative constructions. For more information, contact Dow (1-800-441-4DOW).

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THE DOW CHEMICAL COMPANY
Construction Materials Midland, MI 1-800-441-4369

18' x 24' "U" DOCK

Cost per print: US \$2.00

SCALE 1/32"=1"

FORM NUMBER 1794276