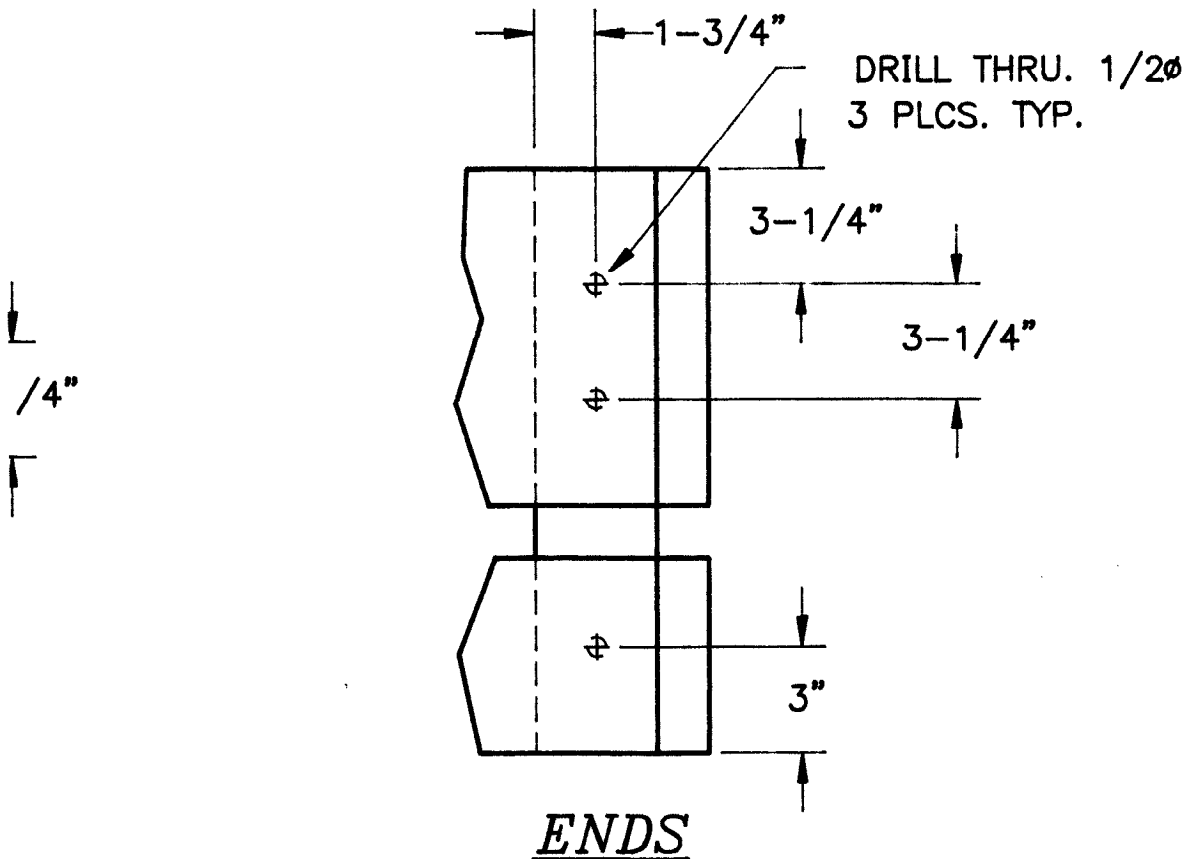


ITEM	QUAN.	DESCRIPTION	SIZE
1	4	SIDE FRAME	2" x 10" x 20'-0"
2	12	END AND CROSS FRAME	2" x 10" x 3'-9"
3	4	DIAGONAL BRACES	2" x 10" x 5'-6"
4	4	SIDE SKIRTS	2" x 6" x 20'-0"
5	4	END SKIRTS	2" x 6" x 3'-9"
6	8	BILLET SUPPORTS	2" x 6" x 5'-0"
7	80	DECKING	2" x 6" x 4'-0"
8	4	SKID BOARDS	2" x 6" x 20'-0"
9	8	CORNER POSTS	4" x 4" x 1'-4 1/2"
10	3	SIDE SKIRT SUPPORTS	4" x 4" x 1'-4 1/2"
11	2	CONNECTION POSTS	4" x 4" x 1'-4 1/2"
12	16	THREADED ROD	1/2"-20UNC x 16"long
13	6	THREADED ROD	1/2"-20UNC x 12"long
14	77	CARRIAGE BOLTS	1/2"-20UNC x 6"long
15	121	NUTS AND FLAT WASHERS	1/2"
16	536	NAILS (12 lbs.)	16 d
17	8	STYROFOAM* BRAND BUOYANCY BILLETS	10" x 20" x 8'-0"

NOTES

1. ALL LUMBER ITEMS 1 THRU 11 TO BE SOUTHERN YELLOW PINE TREATED WITH CHROMATED COPPER ARSENATE OR OTHER WATER BORN ARSENICALS.
2. ALL HARDWARE ITEMS 12 THRU 16 TO BE GALVANIZED STEEL.
3. STYROFOAM* BRAND BUOYANCY BILLETS WILL GIVE APPROXIMATELY 2773 LBS. AVAILABLE LIVELOAD.
4. APPROXIMATE DOCK WEIGHT 2294 LBS. (INCLUDING BILLETS).



LAYOUT

LEFTS & RIGHTS - NOT TO SCALE

x 20' TEE DOCK-ASSEMBLY SUGGESTIONS

WILL BE ASSEMBLED UPSIDE DOWN UNTIL TIME TO INSTALL THE DECKING. PARTS SHOULD BE BUILT SEPARATELY AND ASSEMBLED AFTER THEY ARE PUT IN

PLACES. WHETHER THE 2" x 10" MAIN FRAME SIDES, ENDS AND CROSS FRAMES, PARTS #1

AND CLOSELY CUT ENDS FOR DIAGONAL CROSS BRACES, PART #3. THIS SHOULD FIT IN VERY SNUGLY AND BE MITERED INTO THE 90 DEGREE CORNER.

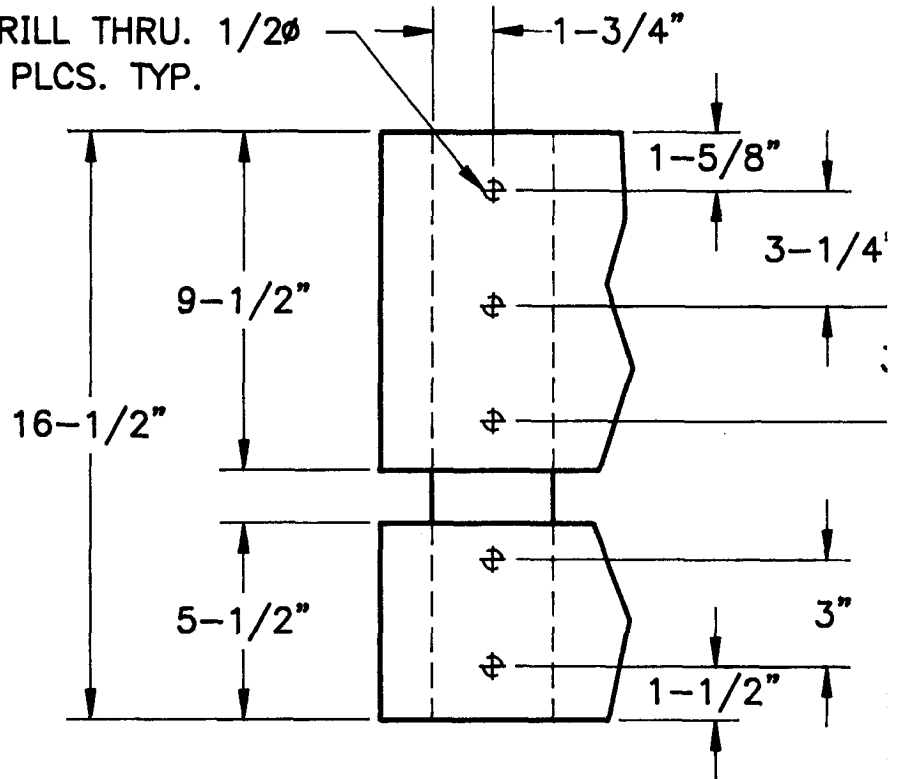
INSTALL 4" x 4" POSTS, #9, #10, AND #11, IN PLACE. NOTE, THAT HOLE PATTERN ON SKIRTS IS RIGHT SIDE UP AND YOU ARE WORKING UPSIDE DOWN. THEN DRILL HOLES IN 2" x 10" AND 4" x 4" POST AT THE SAME TIME. INSTALL 1/2" CARRIAGE BOLTS AS BOLTS ARE DRILLED. DRILLED HOLES SHOULD BE AS SMALL AS POSSIBLE TO ALLOW BOLTS TO ENTER. A TIGHT FIT BETWEEN BOLT AND HOLE IS DESIRED.

INSTALL SUPPORTS, #6, WITH THREE NAILS ON EACH END. CUT OFF PROTRUDING ENDS OF SKIRTS AFTER NAILING IN PLACE.

INSTALL SKIRT PARTS, #4 AND #5, AT ENDS.

INSTALL SKIRTS TO 4" x 4" POSTS AND DRILL HOLES THRU SKIRTS AND POST INSTALLING BOLTS AS HOLES ARE DRILLED. AGAIN REMEMBER THAT HOLE PATTERN ON

DRILL THRU. $1/2\phi$
5 PLCS. TYP.

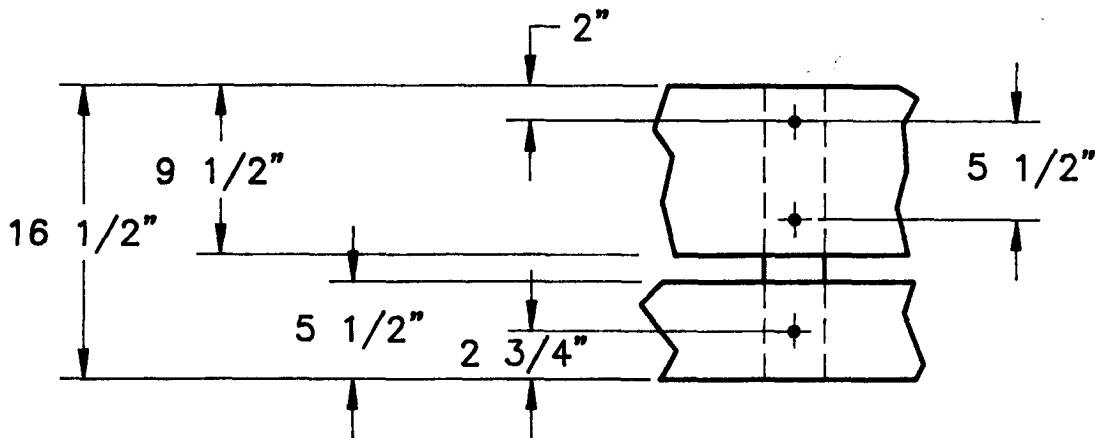


SIDES

HOL

#11 & #9-CORNER F

2



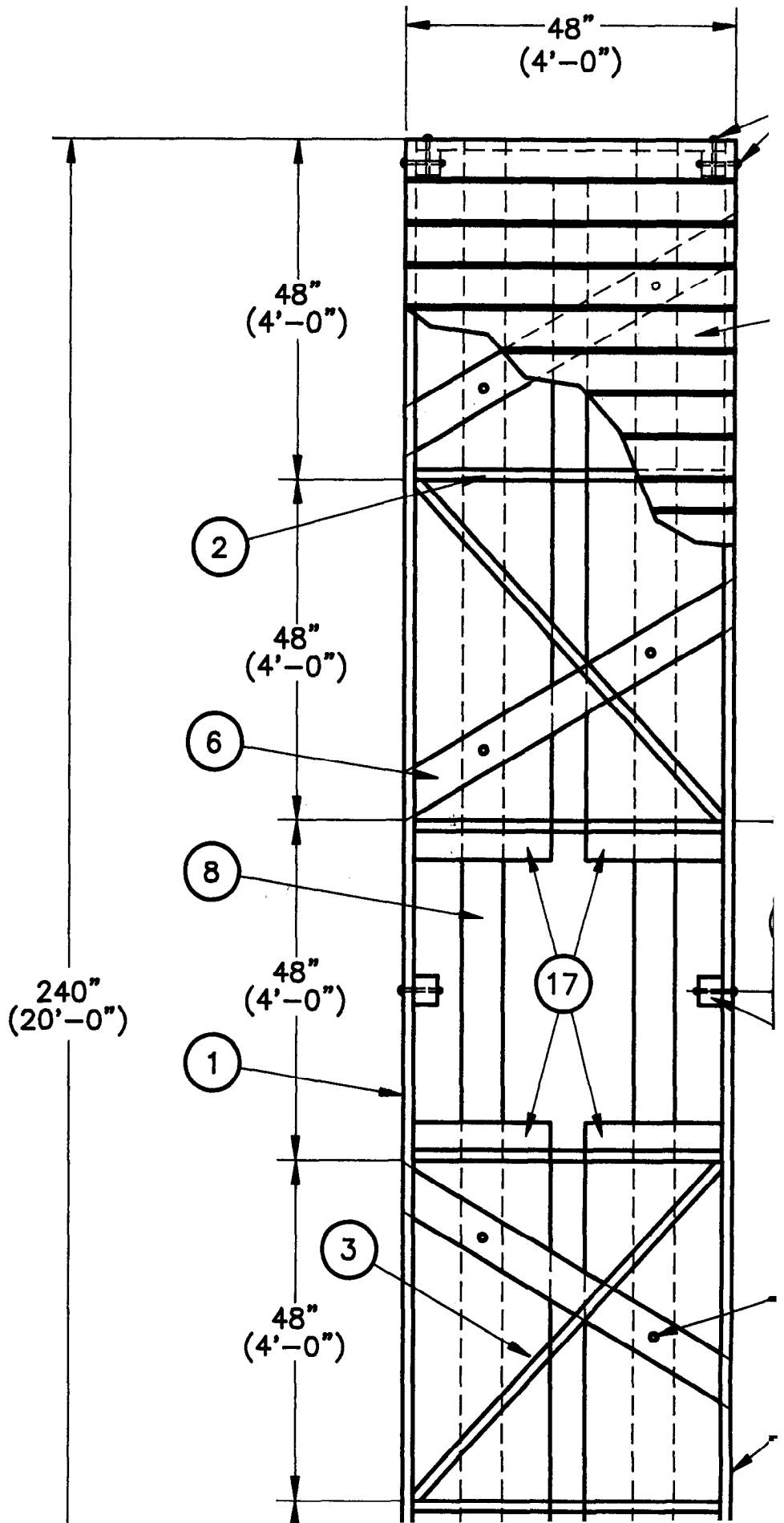
HOLE LAYOUT

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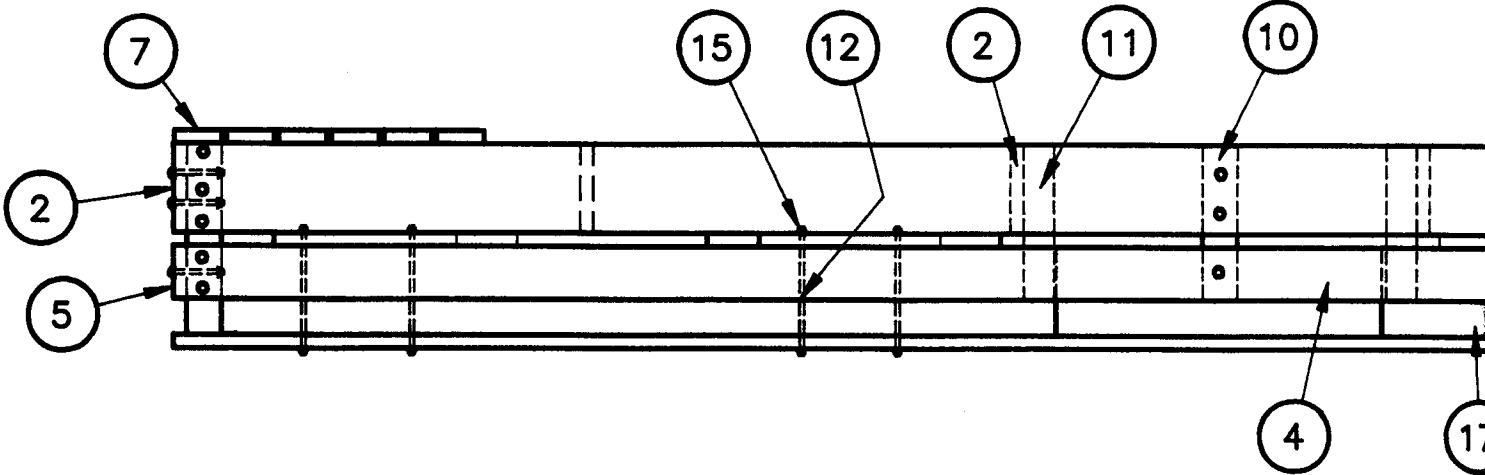
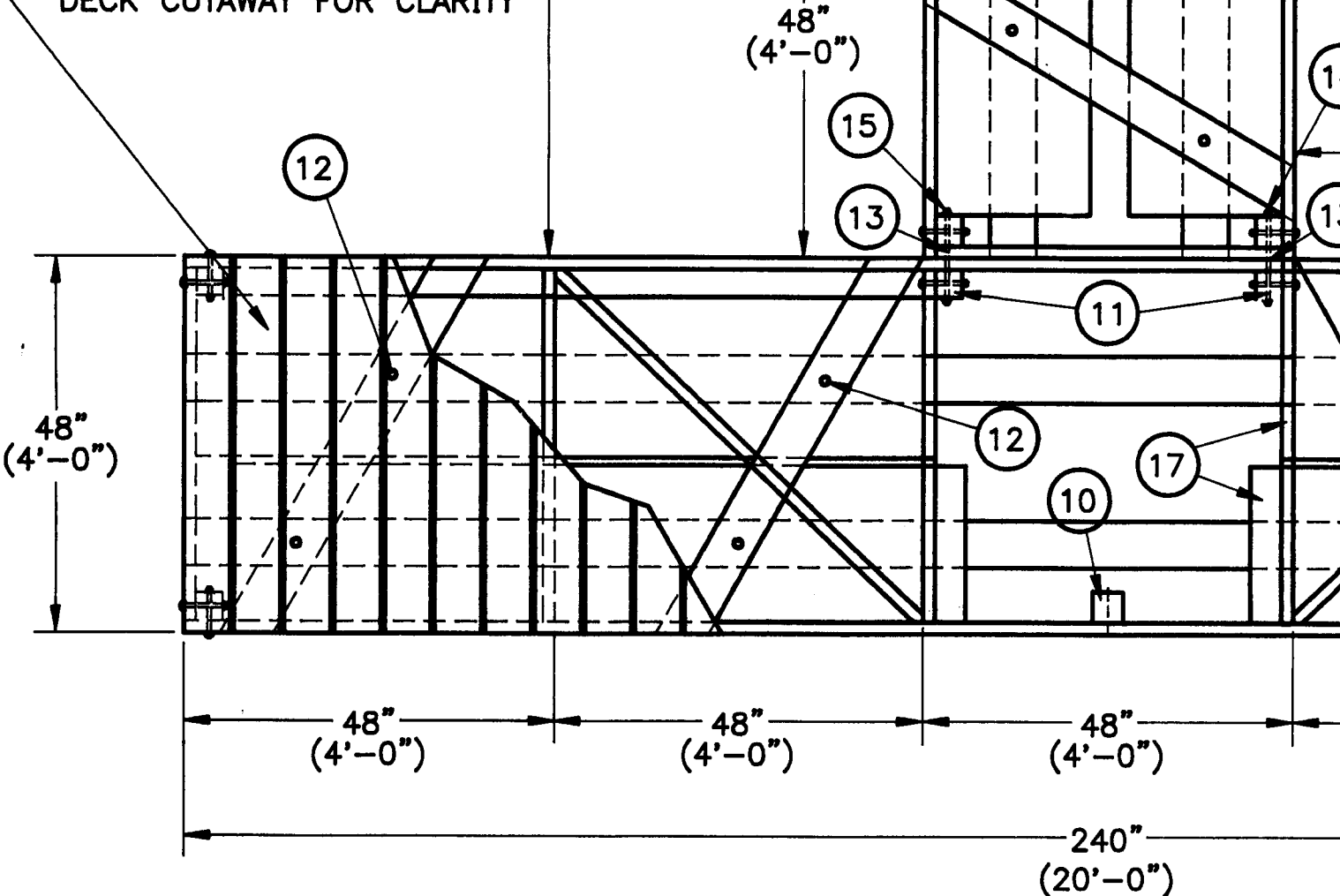
1. NAIL AND
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1/2"
4. NAIL
OF BC
5. NAIL
6. CLAMP
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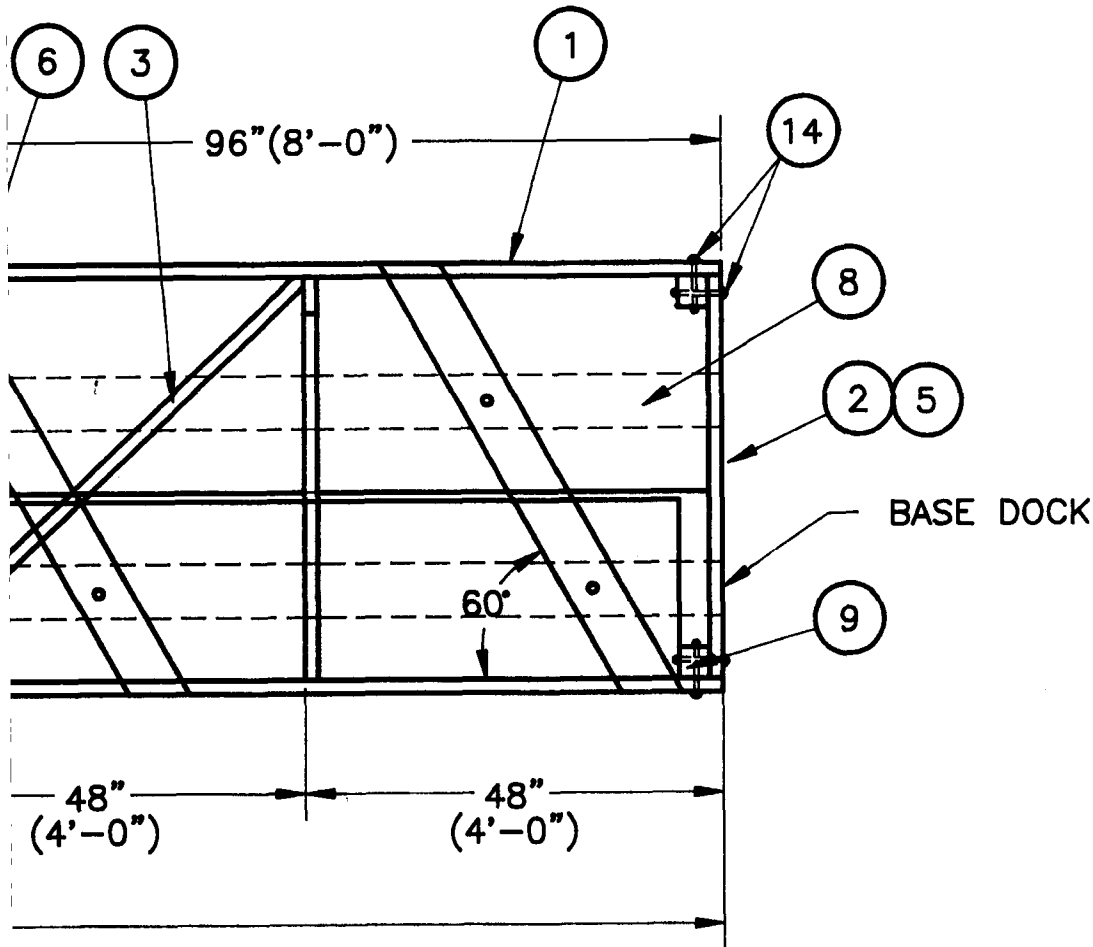
#10-SIDE SKIRT SUPPORTS-NOT TO SCALE

- FINGER DOCK



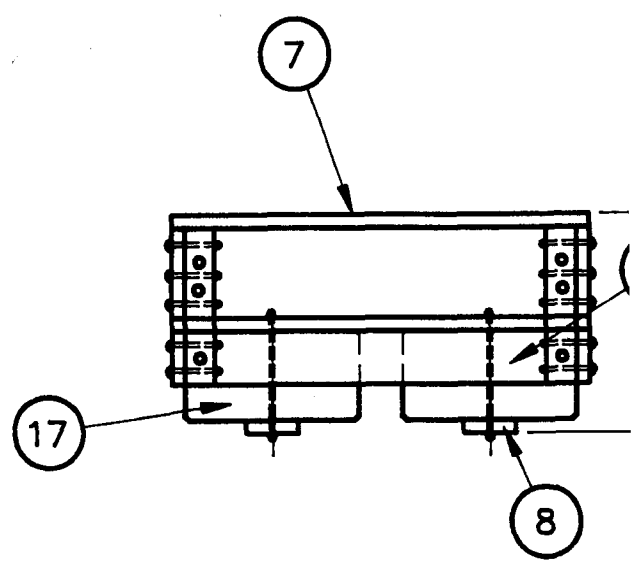
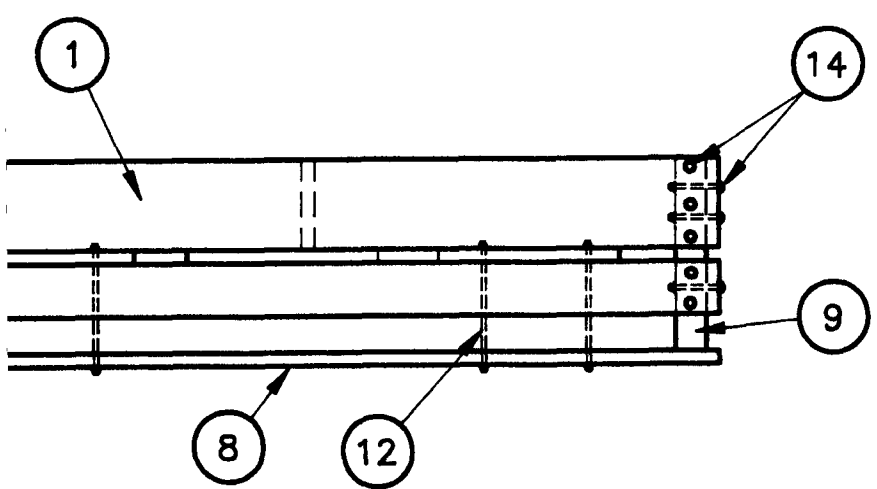
DECK CUTAWAY FOR CLARITY





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END VIEW - FINGER D

IS UPSIDE DOWN TO THE WAY YOU ARE WORKING.

TWO THREADED RODS, #13, THRU CONNECTOR CORNER POST, IN SKIRT ONLY, NUTS AND WASHERS ON END FINGER DOCK.

ALL CARRIAGE BOLT NUTS FOR TIGHTNESS BEFORE PROCEEDING FURTHER.

EIGHT FOAM BILLETS, #17, IN PLACE AS SHOWN ON DRAWING. NOTE, LAYOUT IS DIFFERENT FOR FINGER DOCK THAN BASE DOCK. AGAIN, REMEMBER YOU ARE WORKING UPSIDE DOWN.

BOARD, #8, DOWN CENTERS OF FOAM BILLETS.

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

INSTALL THREADED RODS, #12, AND SECURE WITH FLAT WASHERS AND NUTS. AFTER TIGHTENING NUTS DAMAGE THREADS SO NUTS CANNOT WORK LOOSE. NOTE, THAT SOME NUTS INSIDE MAY HAVE TO BE INSTALLED AFTER TURNING DOCK OVER.

TURN INDIVIDUAL DOCKS OVER AND FINISH INSTALLING NUTS ON THREADED RODS THRU

DECK BOARDS, #7, WITH BOARDS CENTERED ON 6" CENTERS STARTING 3" FROM EDGE. THIS WILL LEAVE A GAP OF ABOUT 1/2" BETWEEN BOARDS. LEAVE OFF DECK BOARDS WHERE THE TWO DOCKS WILL BE FASTENED TOGETHER.

TURN DOCKS < UNITS IN WATER.

FASTEN DOCKS TOGETHER AND THREAD THE TWO RODS FROM FINGER DOCK INTO POSTS, AND THE OTHER FOUR THREADED RODS THRU POST AND TIGHTEN NUTS. THEN TIGHTEN NUTS ON THE FIRST TWO RODS.

INSTALL REMAINING DECK BOARDS.

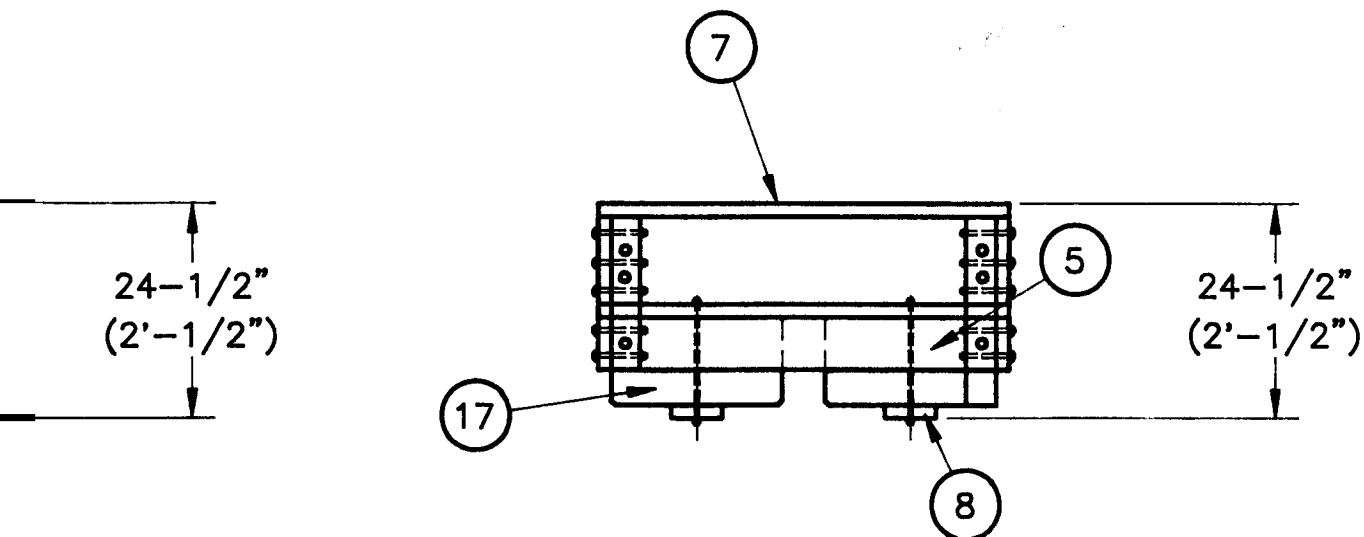
TURN DOCK AND ENJOY!

CONTACT A LOCAL CONSULTANT FOR ANCHORING INSTRUCTIONS 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. Bevel the end of the 2" x 6" skids. Beveling the skids will facilitate moving the dock(s) out of the water.

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



END VIEW - BASE DOCK

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 cfc's.
- **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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Published June 1997

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	THE DOW CHEMICAL COMPANY Construction Materials Midland, MI 1-800-441-4369	
20' x 20' TEE DOCK		
Cost per print: US \$2.00	SCALE 3/64"=1"	FORM NUMBER 1794277