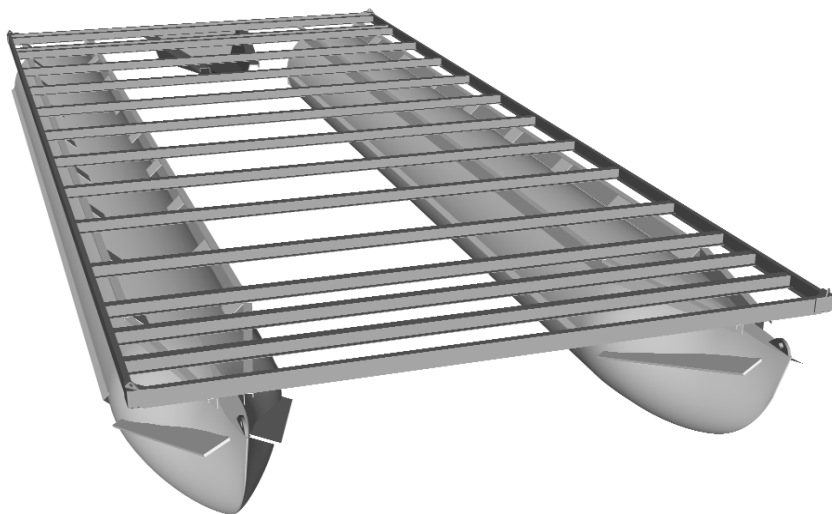


**Pontoon Boat Kit
from
U-Fab Boats**

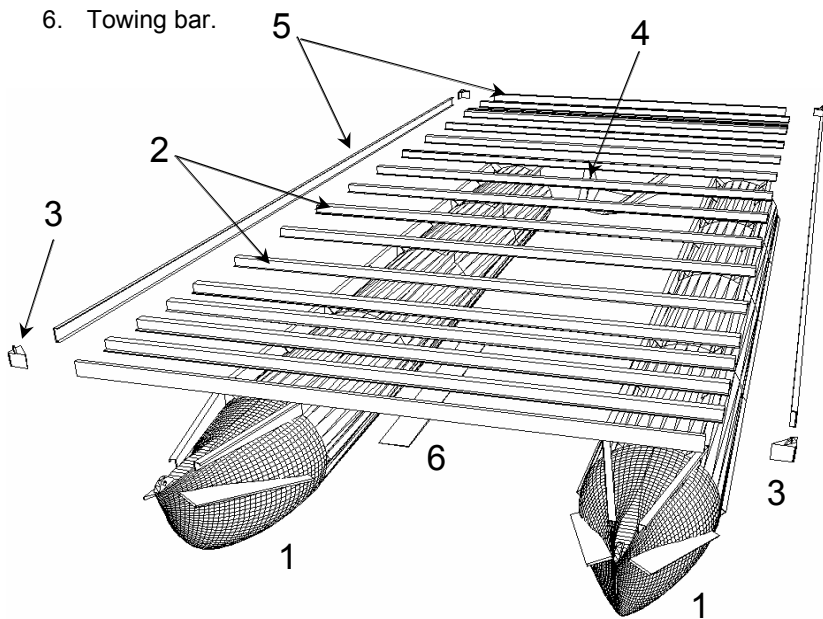
**24" dia. x 20' x 8'
Pontoon Boat Kit
Assembly**



24" dia. x 20' x 8' Pontoon Boat Kit Assembly

Each Pontoon Boat Kit Contains:

1. 2 aluminum pontoons, each with side and under keels, front water deflectors, U-bar cross member supports every 16 inches, sealed chambers at 5 ft. lengths, front eyes, and rear mounting bracket for fish finder or speedometer.
2. U-bar cross members 8 ft. long x 2 in. high. Additional bars for reinforcement at motor mount and bow. Fasteners for joists and edging included.
3. 4 aluminum corners c/w mooring eyes.
4. Aluminum motor support (20 inch transom).
5. 3 in. wide aluminum edging for complete perimeter and motor box cutout.
6. Towing bar.

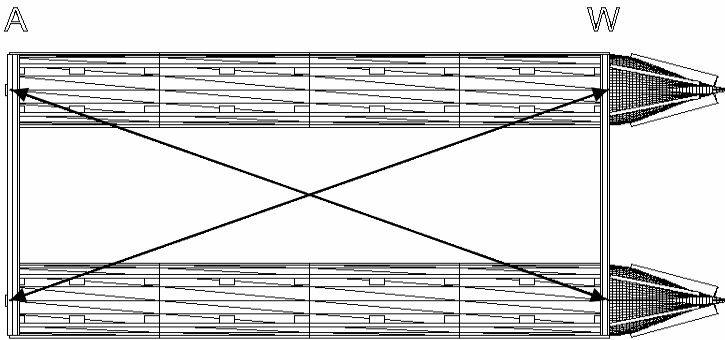
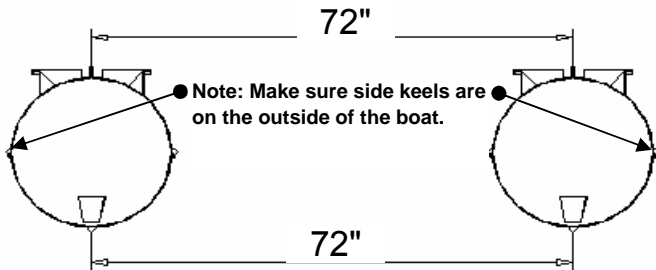


- **Tools Required:** Power Hand Drill & drills (1/8", 3/16", 5/16", 3/8", & 5/32"), Drill Drive Bits (for flooring screws), Ratchet Wrench (with 1/4" & 3/8" attachments and same size spanners), Pop Rivet Gun, 25' Measuring Tape, 50 ft. of string, pencil or fine point marker.

N.B. 24" dia. x 20' x 8' kits are designed with a 3/4 in. opening for the flooring.

Step No. 1

Place the 2 pontoons level on the ground, making sure they are parallel and 72 inches apart. See diagram.

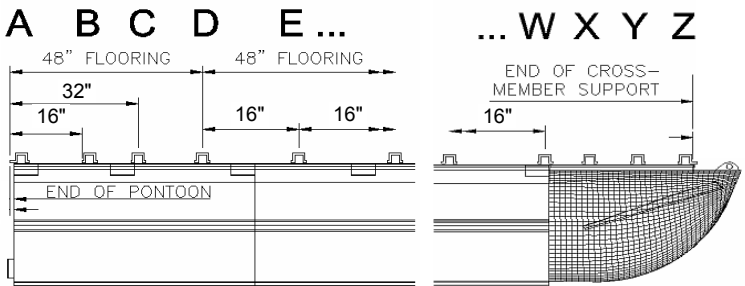
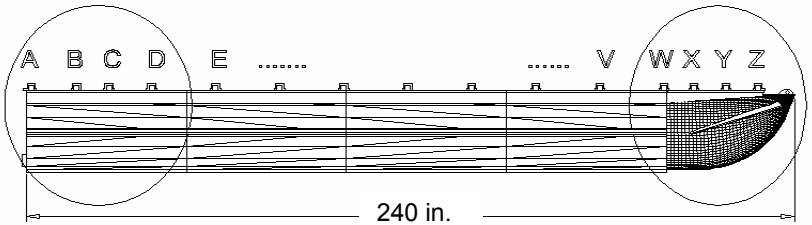


N.B.:

- Place the first U-bar #A (stern) after measuring diagonally across the pontoons as shown in the diagram. The diagonal measurements should be equal to assure that the pontoons are parallel.
- Install U-bar #W (near bow, see Step 2 diagram), re-checking for proper alignment first. Install remaining U-bars and line up the ends of the U-bars using a piece of string from #A to #W. See Step No. 2.

Step No. 2

Place the U- bar cross members at 16in. centres.
See diagram below and Step No. 3 about #B U-bar behind the motor box central support.



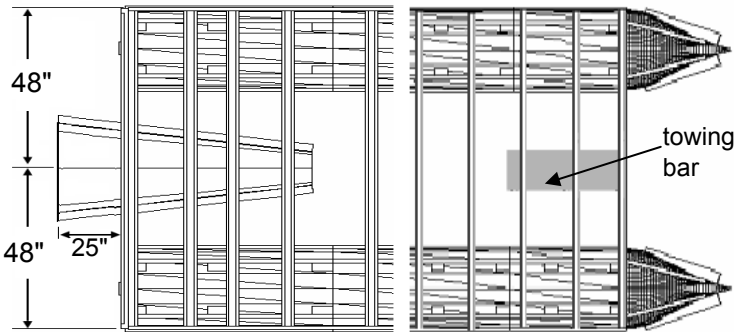
- The first two U-bars should be positioned as above for #A and #Z.
- Bolt each U-bar cross member to the supports on the pontoons, using 8 x 5/16" bolts, nuts & washers for each bar. Drill holes as necessary.
- U-bar cross member #Y is for extra reinforcement.
- U-bar cross members #A and #Z are installed so that the lip is in line with the end of the risers.

Step No. 3

- Align and center the motor support under U-bars.
- Attach the assembled motor support as shown below.
- Install the motor support 25" behind the last U- bar.
- Use 3/8" x 1 1/4" bolts, then lock washers and nuts.
- U- bars #B, #C, and #D: position as shown in diagram, Step 2. Place U-bars #E through #W at nominal spacing.
- Attach towing bar lengthwise with bolts, nuts and lock washers, centered under U-bars, starting from and flush with front bar #Z "see below picture under step 4"
- A U-bolt can be installed at front centre for winching the boat onto a trailer, but it is not supplied.

Step No. 4

- Install your plywood / composite sheets on the cross members starting from the rear and working forward.
- Pre-drill before installing screws. A drill hole every 12", starting 6" from the edge of the plywood / composite sheets is suggested. Use a 5/32" drill bit.
- Attach the plywood / composite sheets with #10 x 1 1/4" screws, supplied with the kit.
- Use paintable silicone where the sheets of plywood / composite sheets meet.



- If $\frac{3}{4}$ " plywood and carpeting is used, the outside perimeter needs routing 1" wide x $\frac{1}{8}$ " deep.

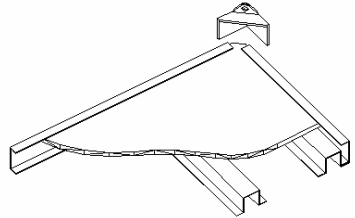
Step No. 5

- Install the carpet (if required). Spread the carpet glue over a 3' or 4' wide section, according to the glue manufacturer's instructions and install the carpet. Continue spreading the glue over the next 3' or 4' wide sections until completed.

Step No. 6

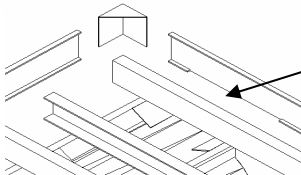
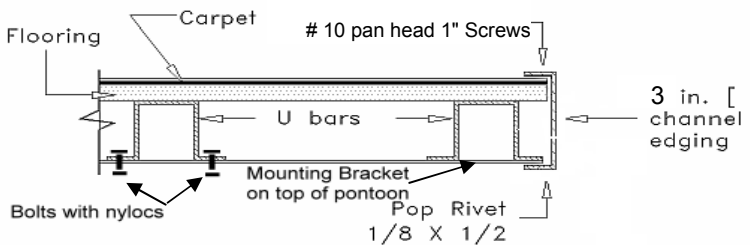
- Install the 3" wide outside edging all around the floor.

Cut this edging 1" less than the length and width of the floor so that you can install the aluminum corners.



Cut the corners of your flooring sheet. See diagram.

- Pop rivet the 3" wide edging to the bottom flange of U- bar. Use $\frac{3}{16}$ " pop rivets.



- The front and rear edging require that the bottom lip must be slotted or cut in some areas.

Step No. 7

- Install the 4 aluminum corners, using 6 3/16" pop rivets or screws: 2 on top, 2 on each side.

Railing Installation (Optional):

1. Position the railing on the deck without the flashing installed using c-clamps to hold it in position. Leave about an extra 3/8" - 1/2" opening at the gate areas to allow for the hinges.
2. Once the railing is positioned on the deck the way you want it, drill the necessary 1/4" holes through the bottom horizontal square tube. There are 1/4" thick clear acrylic spacers that also need to get drilled (1/4") and they act as spacers to make the deck a self bailing deck.
3. Remove the c-clamps. Cut the white aluminium flashing to the lengths required. To cut the flashing, use a straight edge and a utility knife to score the surface and you may have to the cut a couple of times. Then bend the flashing at the cut and it will break easily. Use sandpaper etc. to remove any burrs on the edges.
4. Use the 1/8" pop rivets supplied (about every 6")
5. Then take the railing with the flashing attached and position it on the deck and match up the holes. Install the bolts etc.
6. Install the bolts to attach the railing. Install the gate braces.
7. Inspect the gate latches and you will notice that there is a "R" and "L" marking on each latch. This is to accommodate having the gate to swing from one side or the other. The hinge should be installed on the forward piece of railing so that the wind will not catch it when the boat gets transported.
8. Attach the gate hinges to the vertical railing uprights. They get pop riveted on (3/16' pop rivets). Then install the hinges to the gates themselves and since the gates are slightly shorter than the railing height, there will be an opening along the bottom of each gate.

U-FAB BOATS TWO YEAR WARRANTY

U-Fab Boats warrants the welds on the pontoons, subject to the conditions set forth below, that should the welds on the pontoons be defective by reason of improper workmanship or material during the specified warranty period, **U-Fab Boats** will repair or have repaired the same effecting all necessary welding and / or parts replacement(s), without charge for either parts or labour. Packaging, shipping, or freight charges are not included. The **warranty period** will be **two years** from the date of original purchase from **U-Fab Boats** or a **U-Fab Boats** dealer.

Conditions: The welds must not have been previously altered, modified or repaired and must not have been subject to accident, misuse or abuse during use, storage or trailering. The opinion of **U-Fab Boats** with respect to this matter shall be final.

U-Fab Boats

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