

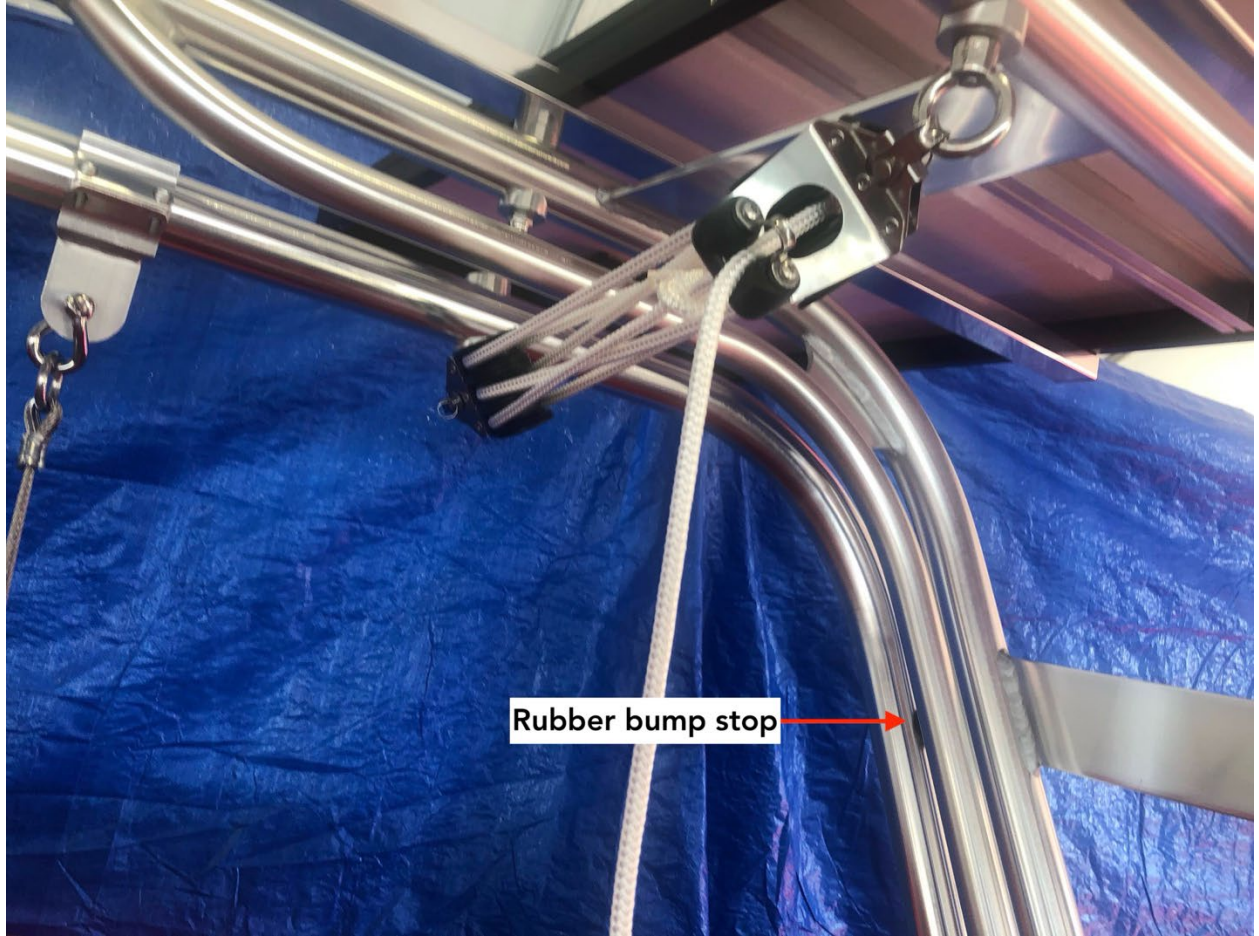
### Assembly and Install Guidance

Layout parts, you are going to adjust size of the lifting frame to fit to your arch. a) Choose the mounting point for the articulated base. You are going to assemble the lifting frame to be 4-5” wider at the base than the beam between the mounting points and then squeeze it together to “pre-load” just like the arch. b) Determine the overall height from the articulated base, the top of the lifting frame loop should come close to matching the top of the arch, but not higher than...

1. Joining the lifting Frame in the center... There are two tubes to make the splice, the smaller one fits inside the pipe of the frame, the smaller fits outside (be sure to slip the outside tube on one side before joining with the inside tube.. epoxy can be used on the inside tube) The outside tube is thru bolted like the arch bridge assembly. Very wide tender lifts will have a long inner tube, a center section of schedule 80 pipe to extend the beam of the lifting frame, and a longer outside tube
2. Squeeze the lifting frame together and install on the articulated bases with epoxy and ¼-20 machine screws in the same manner as M100s
3. Installing eyenuts for the tackle.... The eyenuts should be installed a little outboard of the lifting points on the tender. Orient the eyes fore/aft.
4. The tackle is installed with the cam cleat blocks secured to the arch. The cam cleats are to facilitate lifting. **DO NOT RELAY ON CAM CLEATS TO SECURE THE TENDER FOR PASSAGE. THE TAIL END OF LINES SHOULD BE SECURED TO A CLEAT**
5. Install the Lifting Eyes to the Tender Lift directly over the lifting points on the tender.
6. Install the rubber bumpers on the sides of the arch just below the bend







Rubber bump stop →



