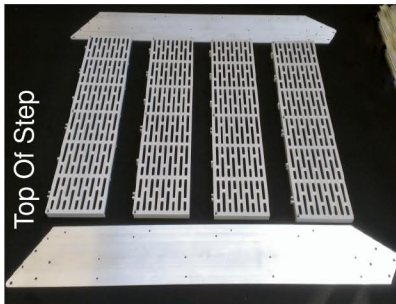
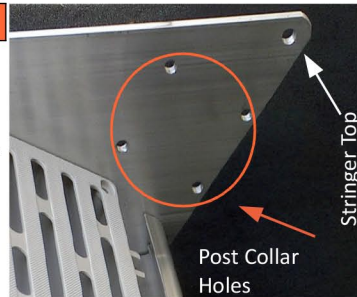


Stair Assembly Instructions - Page 2



Step One

Layout the side step stringers and the ThruFlow Tread on a flat surface. The stringers should both have the step mounting bracket holes facing towards the top of the stair. The tabbed edge of the tread panels should also face the top of the stringer.



Extra Views Step 1

This shows the top of the stringer this top edge will eventually go against dock. The top hole will be used for the step mounting brackets attachment when step is completely built. This picture also shows where post collars will be installed later in the step building process.



Step Two

Starting at the bottom of the step start installing bull-nose extrusion to step stringer using the $\frac{1}{4}$ x 20 x 1" stainless steel button head bolts. Use your $\frac{9}{64}$ " Allen head wrench. Do not tighten them all the way until all bull-nose and ThruFlow tread panels are in place.



Extra Views Step 2

The top photo shows the inside stringer view of the $\frac{1}{4}$ x 20 x 1" S.S. Button head bolt starting into the step bull-nose. Leave loose until you have inserted all the ThruFlow tread panels. The inset picture shows how the treads fit inside the bull-nose. The cut portion of tread should face you as you insert treads into bull-nose.



Step Three

After you install the first bull-nose extrusion for each step, then slide tread into position. Once panel is in place then cap the exposed end of panel with the front bull-nose extrusion and bolt into place. Remember do not tighten bolts until all bull-nose have been installed Repeat this process until you reach the top step.



Extra Views Step 3

After all bull-nose are attached you then can go ahead and tighten all the $\frac{1}{4}$ x 20 x 1" button head machine bolts in the step side stringer. Inset pictures shows bull-nose bolts after being tightened into stringer side. You are now ready to attach the stringer collars.



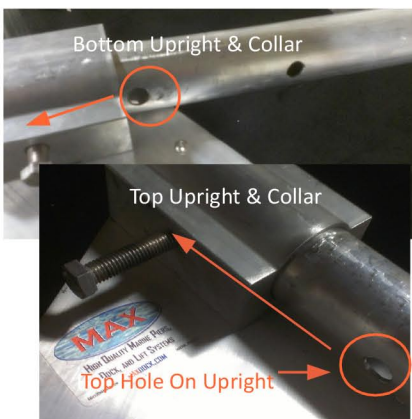
Step Four

Install the stringer collars onto the step using the $\frac{3}{8}$ x 1" S.S. allen head bolts using your $\frac{5}{32}$ " allen head wrench. Pictured to the left is the lower right collar install. Note the threaded $\frac{1}{2}$ " handrail upright attachment hole on side of collar should face inward, or towards the top of step, and would be near installers index finger, so it is not visible in photo.



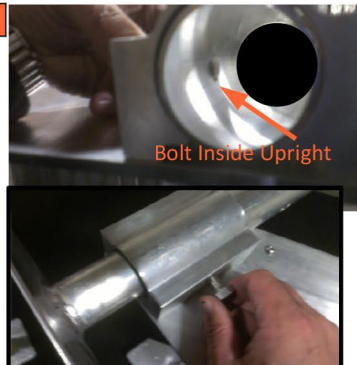
Extra Views Step 4

Here the final collar is being installed and tightened. You can see the hand rail bolt hole is facing toward the bottom of the step or inward. This hole will take the $\frac{1}{2}$ x 1- $\frac{1}{2}$ " S.S. handrail bolt. You can now start this bolt on bottom right rail collar (bolt placement is pictured in inset collar photo).



Step Five

You can now install the top and bottom handrail post. The bottom handrail post should use the bottom of the two $\frac{5}{8}$ " holes in the upright. The top hand rail post should use the top $\frac{5}{8}$ " hole drilled in the upright. On Bottom upright Align the $\frac{5}{8}$ " hole with the $1-\frac{1}{2}$ x $\frac{1}{2}$ " bolt on side of collar and tighten until bolt just clears the inside of upright tube. This will allow bottom leg to slide in freely. On Top upright use the $\frac{1}{2}$ x 3" bolt, after bent handrails are installed you will tighten bolt until it hits back of upright post and pinches against collar.



Extra Views Step 5

The top picture shows aligning hole in hand rail upright inside of collar. Do not over tighten or you will not be able to easily slide leg into collar. Once leg is in place you can slide leg into position and lock leg in place by tightening bolt. Do not over tighten this bolt, it should be tight enough to hold bottom leg at desired height. The bolt is actually pinching leg against handrail upright. Final height adjustment should be made in the water.