



INSTALLATION INSTRUCTIONS FOR WELD WASHERS

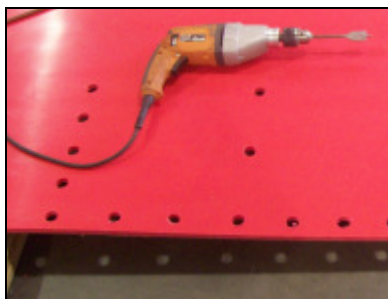
At any time, if you have any questions regarding an installation please contact Horn Plastics Inc.

Fargo, ND: 701-282-7447 WI Dells, WI: 608-253-6848 Boise, ID: 208-376-2221
Toll Free: 800-373-7448 Toll Free: 800-772-6146 Toll Free: 877-735-2221

Before you start, you will need the following items to complete the installation:

Marker	Wood Blocks	Drill
1" Spade Bit	Counter Bore Tool	Weld Washers
Welder	Screwdriver	Mallet
Liner Plugs		

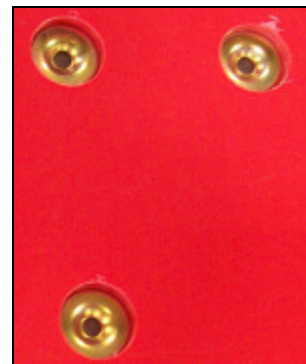
1. Set the plastic on the floor, and copy the bolt pattern on the plastic with a marker.
2. Place the wood blocks under the plastic. With the 1" Spade Bit, drill a pilot hole all the way through the plastic at the marked spots. See Picture 1 below.
3. Remove the wood blocks so the plastic lays flat on the floor. Use the counter bore tool to drill out the holes until the flat part of the bit hits the floor. **Be sure to leave a lip on the inside of the holes.** See Picture 2 below.
4. Put the liner in place for the install, and set the weld washers in the holes. See Picture 3.
5. Use a welder to weld the washers to the bed. Weld from the center of the plastic towards the edges to help prevent any ripples or high spots. If the liner is at an angle, use a screwdriver to hold the weld washers in place.
6. Allow the welds to cool. With the mallet, pound the liner plugs into the holes.



Picture 1



Picture 2



Picture 3