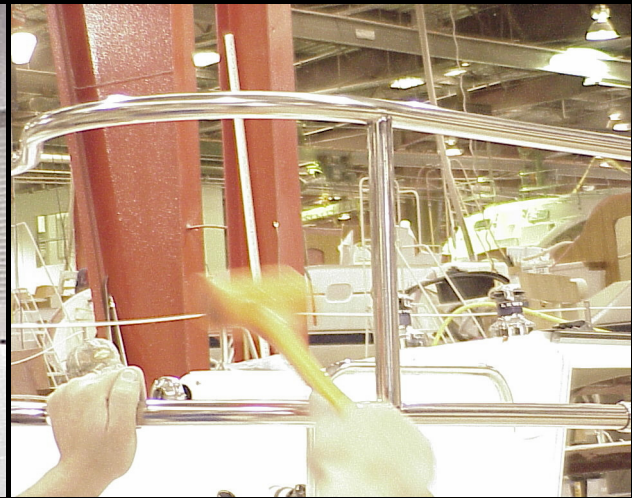


356 SOP STERN RAIL PORT AND STBD INSTALLATION



SLIDE STERN RAIL TUBES INTO ARCH TUBES

STERN RAIL MAY NEED TO BE PERSUADED TO SLIDE INTO ARCH TUBES WITH A RUBBER Mallet. STRIKE THE RAIL NEAR THE TOP OR THE BOTTOM WELDED JOINT TO MINIMIZE THE POSSIBILITY OF BENDING THE TUBE.

#	#Ea.	Description	Size	Part #	#	#Ea.	Description	Size	Part #
1	1	Stern Rail Port			3	20	Washer Fender	1/4"	
1	1	Stern Rail Stbd.			4	20	Lock Washer	1/4"	
2	20	Stern Rail Fasteners	1/4-20 x 1 1/2" P/H		5	20	Nut Hex	1/4-20	

1. After the arch has been installed the stern rails can be installed. Slip the ends of the stern rails into the tubes on the back of the arch and slide the stern rail into the arch, the stern rail may need to be persuaded with a rubber mallet. NOTE: Use caution and strike the rail near the top or bottom welded joint to minimize the possibility of bending the tube.
2. On the inboard end of the stern rail (where the two mounting bases are) center the bases up and down on the deck embossment. Mark the mounting hole location onto the deck and without letting the stern rail move also mark the mounting hole locations on the outboard base.
3. Remove the stern rail, again this may need some extra persuasion from a rubber mallet and use the same caution as before.
4. Drill the marked mounting hole locations using a 13/64" drill bit then tap the holes using a 1/4-20 tap.
5. In the center of where the lower-inboard base on the starboard side will mount, drill a stern light chase wire hole thru the deck using a 3/8" drill bit.
6. Clean the surface and hardware using alcohol .
7. Caulk all the mounting holes using white 739 caulk.
8. Put the stern rails back into the arch tubes and on the starboard side run the stern light wire through the 3/8" hole. Make sure to caulk the back of the hole when with white 739 caulk when the installation is complete.
9. Secure the stern rail to the deck using the designated fasteners. On the outboard bases if no metal was present when you drilled through the deck then you will need to fasten a fender washer, lock washer and hex nut on the bolts.
10. Clean up excess caulk using alcohol.

Revision Dates:

Expected Time: 45 min.

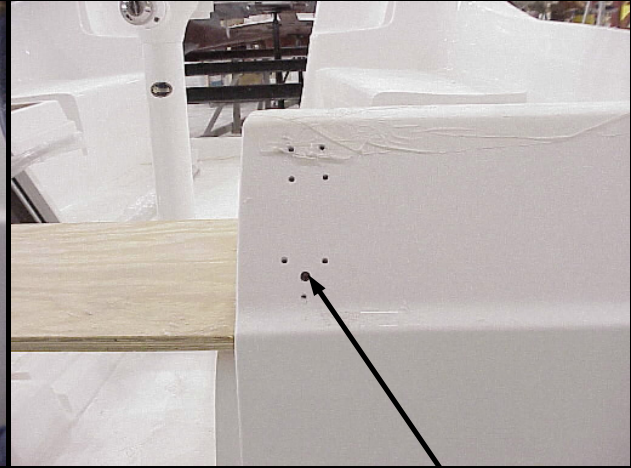
356 SOP STERN RAIL PORT AND STBD INSTALLATION

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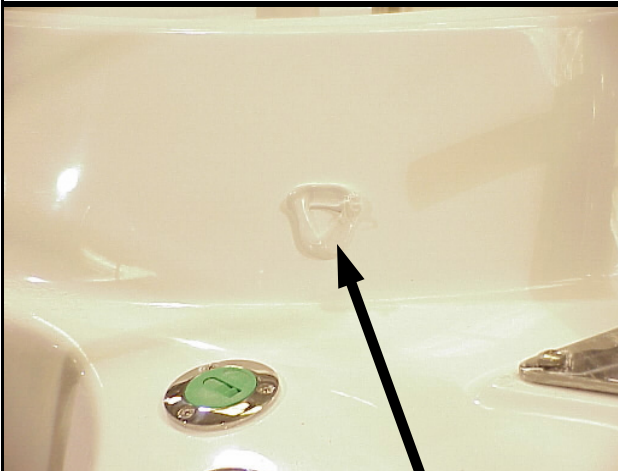
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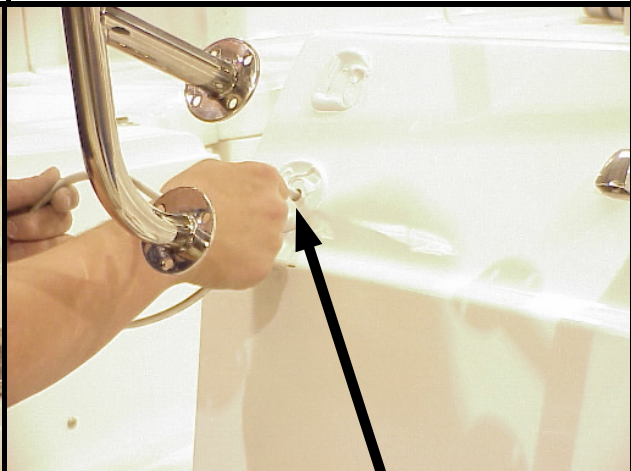
DRILL MARKED LOCATIONS



3/8" HOLE IN CENTER OF LOWER INBOARD
HOLE PATTERN OF STARBOARD SIDE STERN
RAIL FOR STERN LIGHT WIRE



CAULK ALL HOLES WITH WHITE 739 CAULK



FEED STERN LIGHT WIRE THRU 3/8" HOLE IN
CENTER OF LOWER INBOARD HOLE PATTERN
OF STARBOARD SIDE STERN RAIL