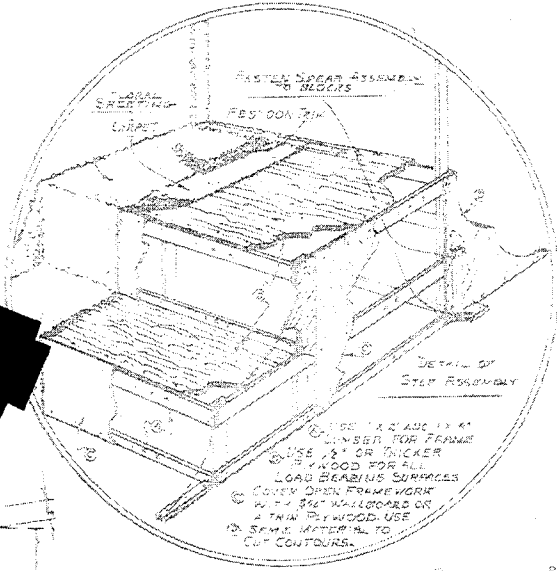
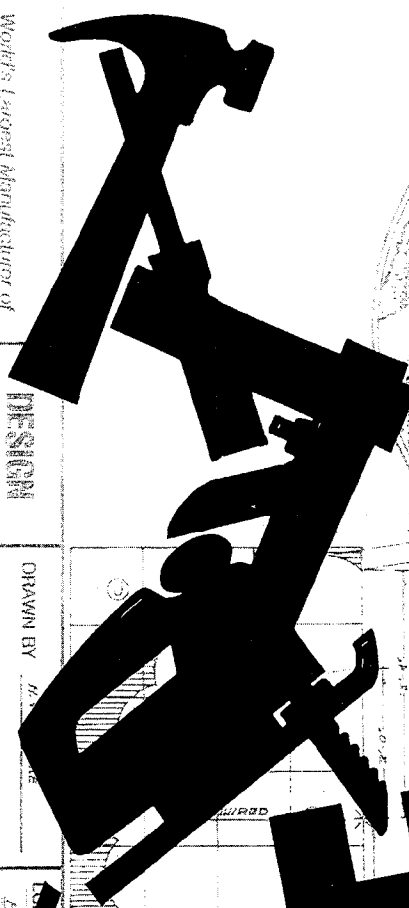


World's Largest Manufacturer of  
Patterns from Builders  
and Contractors  
1177

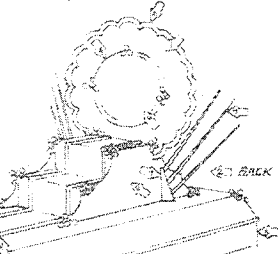
DESIGN  
1177

CHECKED BY  
DATE 5/22/78

DRAWN BY  
DATE 5/22/78



DECORATING CODE



7" OR  
OR ALTER TO YOUR FRONT  
WIDTH

the

HOW TO DO IT

MANUAL FOR THE AMATEUR

FLOOR  
BUILDER

FLOOR SHEETING  
COLOR 1 CARPET - BACKGROUND  
COLOR 2 BALANCE OF ENTIRE  
FLOOR FRAME

ASSEMBLED  
CIRCLE 1  
PRINTED TO MATCH  
COLOR 1  
LETTERS TO MATCH  
COLOR 2

TRAILER  
PLATFORM

FRONT  
APRON  
RAISED  
FOR  
TONGUE  
CLEAR

SPRINK - USE STOCK  
1 x 4

SPRINK BASE  
USE 1/2" OR THICKER  
PLYWOOD

FRONT ELEVATION

GROUND  
LINE

THIS PLAN IS FOR A TRAILER PLATFORM 3'-0" HIGH.  
IF YOUR TRAILER IS DIFFERENT - ADD TO OR REDUCE  
APRON HEIGHT ACCORDINGLY. FRANGE DROP ALWAYS  
REMAINS 11"-3".

# *WHY a parade float manual?*

Building a professional-looking parade float is easy when you know how. Vaughn's assembled this manual to provide the amateur float builder with the practical float building know-how we have accumulated during our 40 plus years in the business. This manual contains the step-by-step procedures for building a parade float using basic tools such as skil saw, hammer, staplers, etc. By following the methods outlined in this manual, you too, can build a professional-looking parade float.

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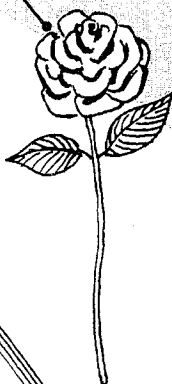
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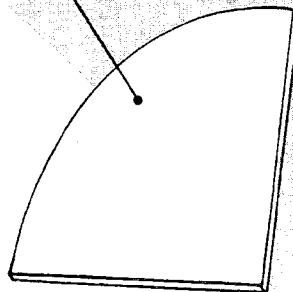
# FLOAT DECORATING MATERIALS

FOIL PAPER

FLOWERS

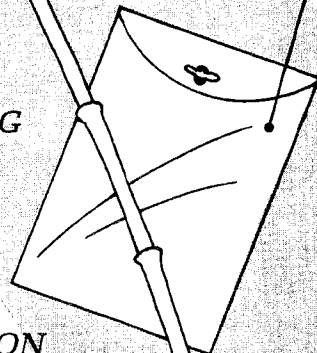


CONTOURS



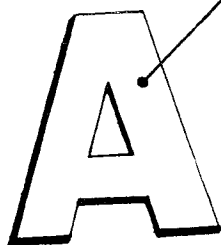
RATTAN

CONSTRUCTION PLAN

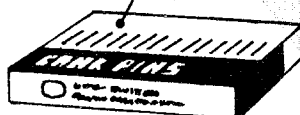


DECORATED BACKGROUND

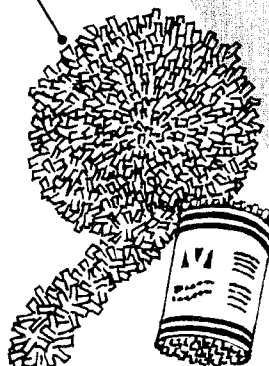
LETTERS



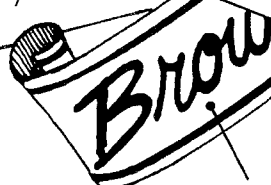
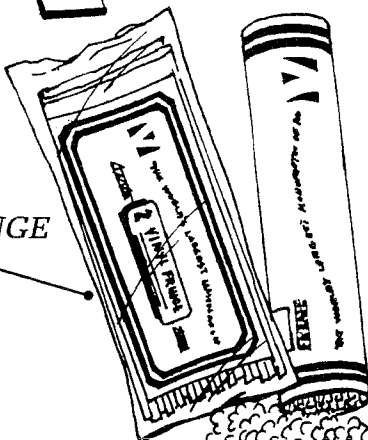
DECORATING PINS



FESTOON



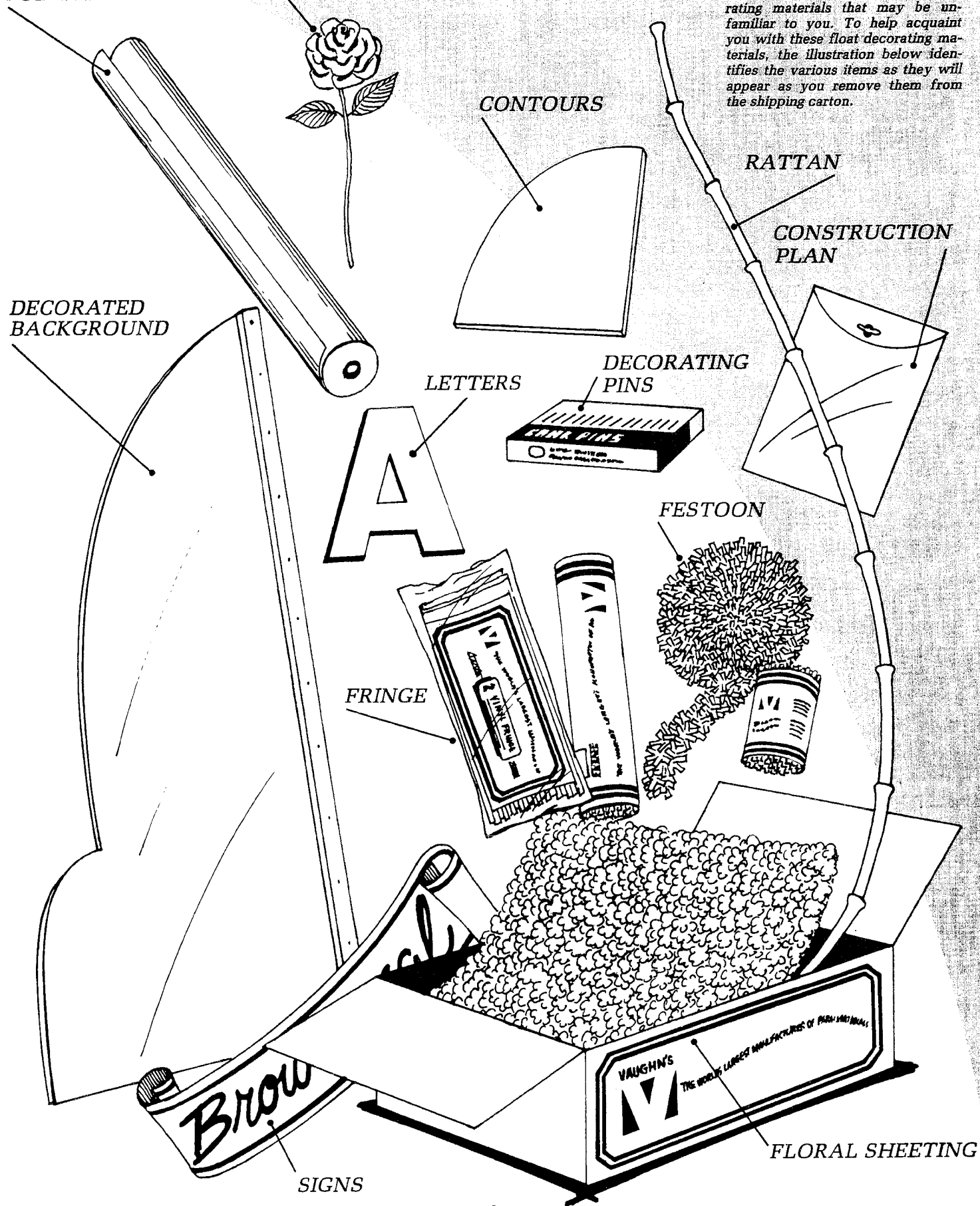
FRINGE



SIGNS

FLORAL SHEETING

Throughout this manual, references will be made to various float decorating materials that may be unfamiliar to you. To help acquaint you with these float decorating materials, the illustration below identifies the various items as they will appear as you remove them from the shipping carton.

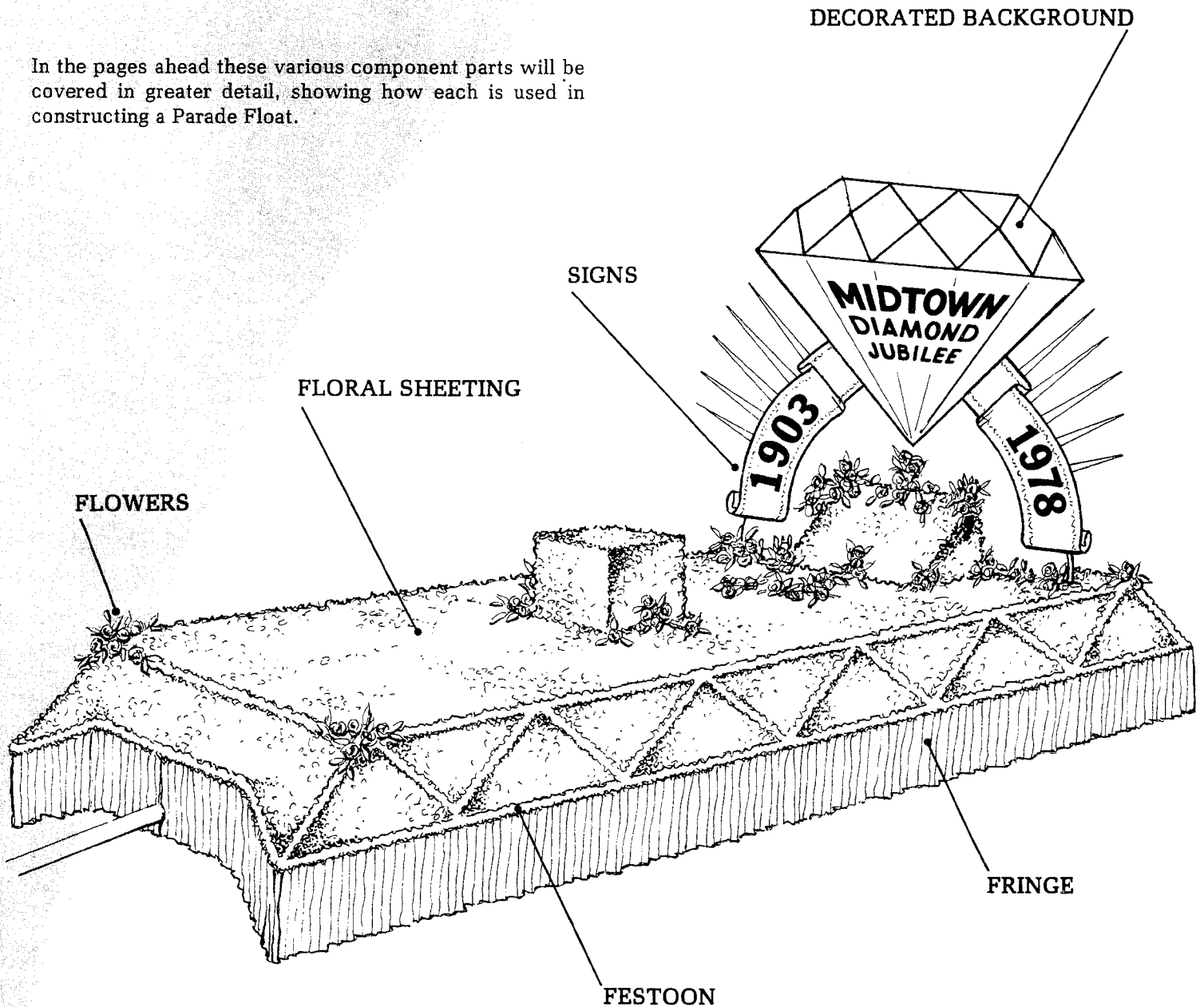


# THE PARADE FLOAT KIT

A Parade Float Kit consists of various component parts which, when assembled according to the construction plan provided, form the finished Parade Float. The various components of a Parade Float are:

- |                      |                 |
|----------------------|-----------------|
| Trailer Bed          | Floral Sheeting |
| Framework            | Fringe          |
| Contours             | Festooning      |
| Superstructure       | Flowers         |
| Decorated Background | Lettering       |
| Props                | Signs           |

In the pages ahead these various component parts will be covered in greater detail, showing how each is used in constructing a Parade Float.

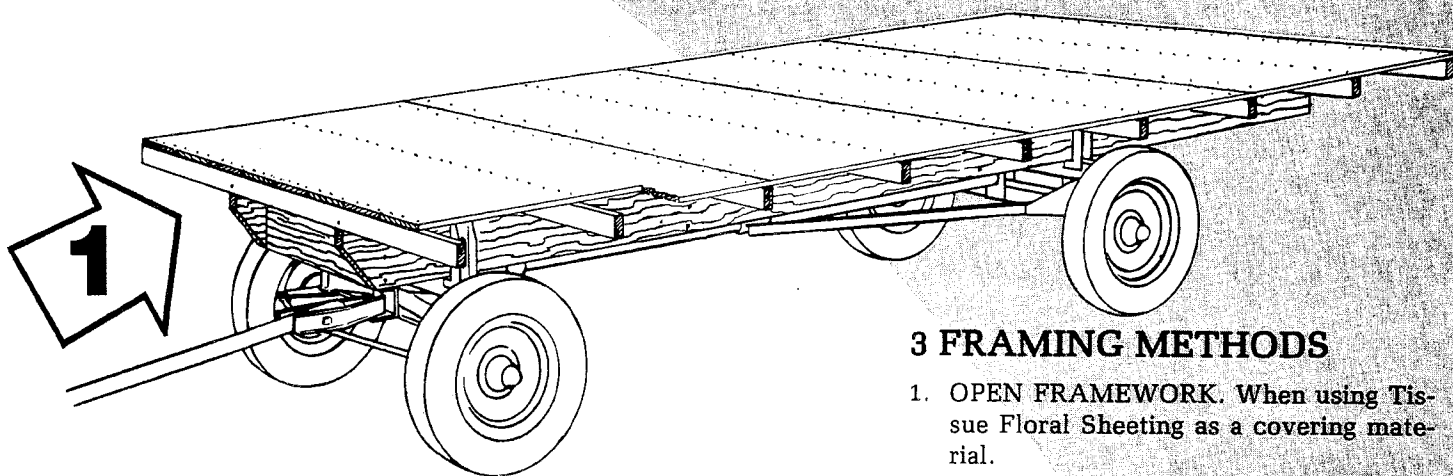


The illustration above shows how some of the various float decorating materials appear, in position, on a finished Parade Float. Using basic hand tools and following the construction techniques shown in this manual, you will be able to build a professional looking Parade Float.

# BASIC TRAILER CONSTRUCTION

A Parade Float begins with the trailerbed. Vaughn's Parade Float Trailer Kits are designed to be built on a basic 4 wheel chassis, flat-bed type trailer. A hay wagon or utility trailer with a flat bed works just fine. Trailers of this type, normally are 7 to 8 feet wide and 14 to 18 feet in length.

Illustrated below is a trailer bed showing 4 x 8 foot plywood sheets covering the top. The trailer bed you use may have a top made of 1" x 6" or larger boards. If the surface is not level and sturdy or has holes in it, you may wish to cover the top with sheets of plywood to provide a sturdy and smooth construction surface.



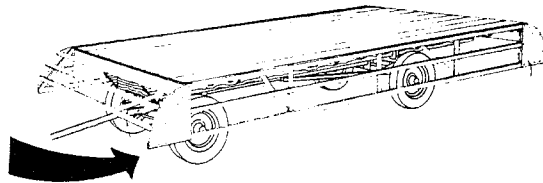
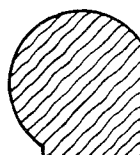
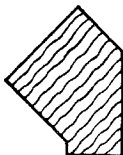
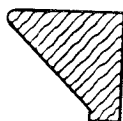
A variety of float bed designs may be made from the basic construction by the use of cut-out contour shapes of wallboard or plywood. Curved or angular surfaces add to the stream-lined rhythm of a float and can easily disguise the box-like UNDERSTRUCTURE OF THE TRAILER.

## 3 FRAMING METHODS

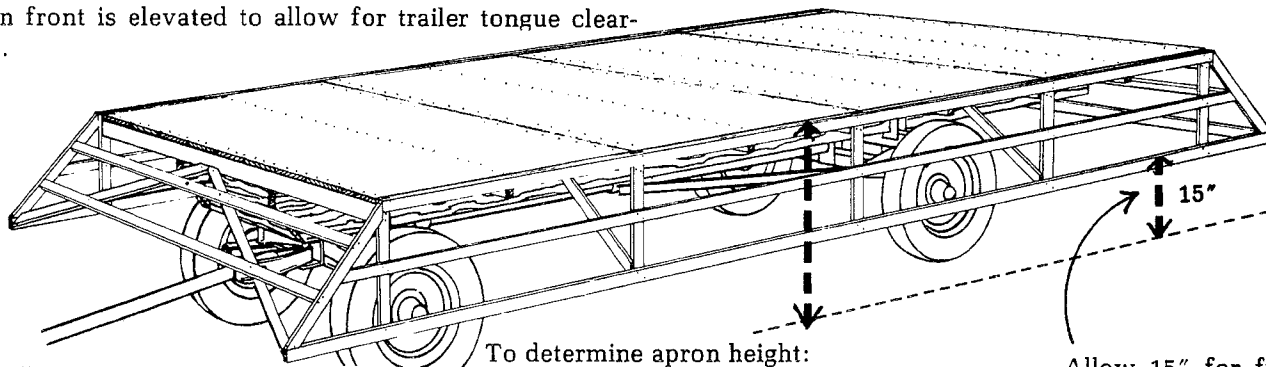
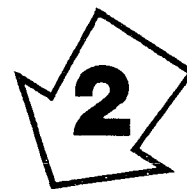
1. OPEN FRAMEWORK. When using Tissue Floral Sheeting as a covering material.
2. COVERED FRAMEWORK. Solid surface over framework when using Vinyl Floral Sheeting or Foil Paper as covering materials.
3. PLYWOOD ONLY. Forming solid surfaces using a minimum of structural wood framing for strength.

## CONTOURS

Nail 1" x 2" cross members between contours. Nail braces to these members from trailer bed when using framing method #1.



The framework between the trailer bed and the ground is called the apron. The apron framework is constructed of 1" x 2" wood and is nailed to the trailer bed and secured from side-to-side by cross members front and rear and apron braces along each side. The lower cross member in apron front is elevated to allow for trailer tongue clearance.



To determine apron height:

1. Measure distance from trailer bed to ground.
2. Deduct 15" for fringe drop.
3. Remaining measurement is height to build apron framework. 5

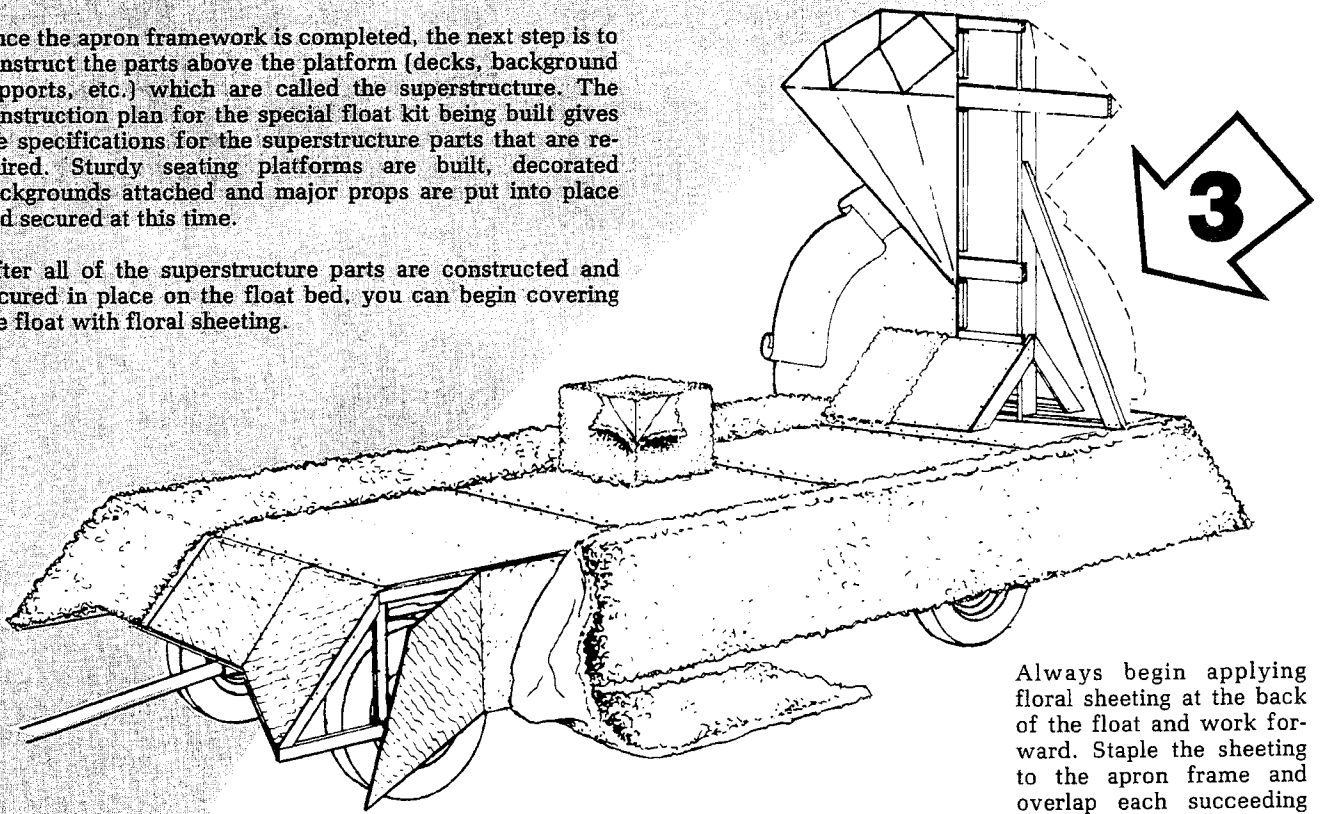
Allow 15" for fringe drop from the bottom of apron framework to ground.



## BASIC TRAILER FINISHING

Once the apron framework is completed, the next step is to construct the parts above the platform (decks, background supports, etc.) which are called the superstructure. The construction plan for the special float kit being built gives the specifications for the superstructure parts that are required. Sturdy seating platforms are built, decorated backgrounds attached and major props are put into place and secured at this time.

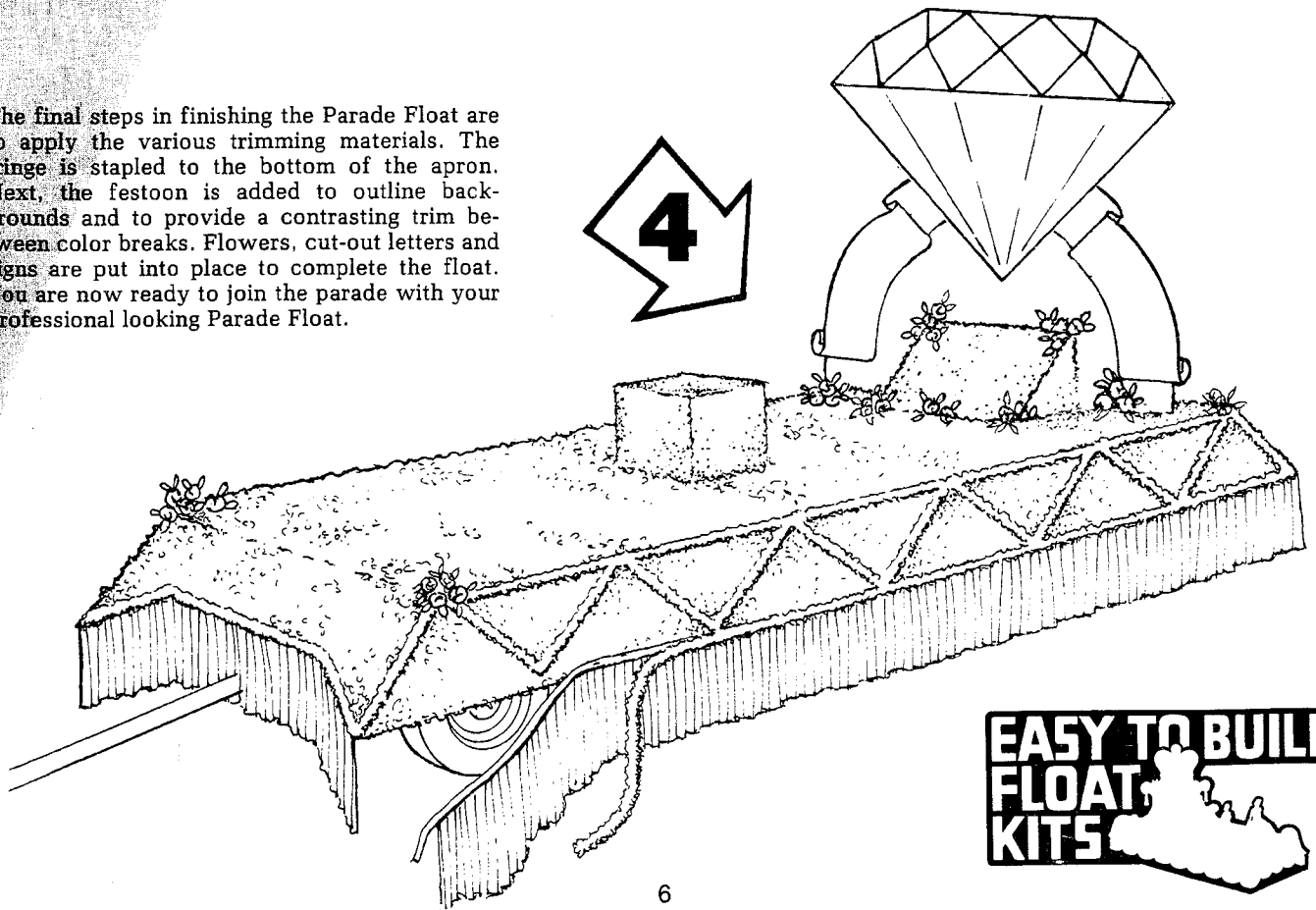
After all of the superstructure parts are constructed and secured in place on the float bed, you can begin covering the float with floral sheeting.



Always begin applying floral sheeting at the back of the float and work forward. Staple the sheeting to the apron frame and overlap each succeeding sheet at least 1" or more.

**NOTE:** Plywood or wallboard backing must be applied over the entire apron framework if vinyl floral sheeting is to be used. This is not required when tissue floral sheeting is used.

The final steps in finishing the Parade Float are to apply the various trimming materials. The fringe is stapled to the bottom of the apron. Next, the festoon is added to outline backgrounds and to provide a contrasting trim between color breaks. Flowers, cut-out letters and signs are put into place to complete the float. You are now ready to join the parade with your professional looking Parade Float.

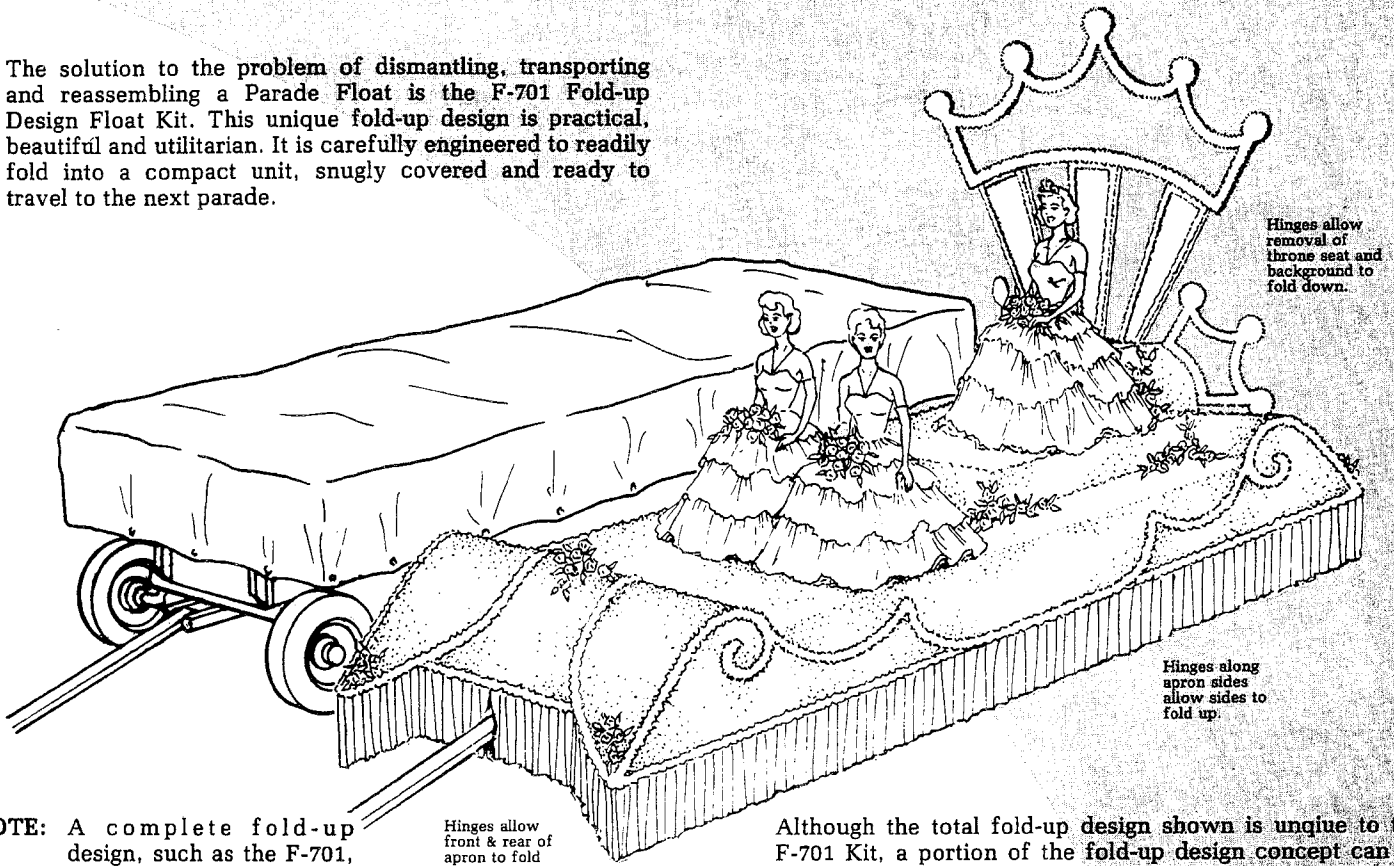


**EASY TO BUILD  
FLOAT  
KITS**



# FOLD-UP DESIGN F-701

The solution to the problem of dismantling, transporting and reassembling a Parade Float is the F-701 Fold-up Design Float Kit. This unique fold-up design is practical, beautiful and utilitarian. It is carefully engineered to readily fold into a compact unit, snugly covered and ready to travel to the next parade.



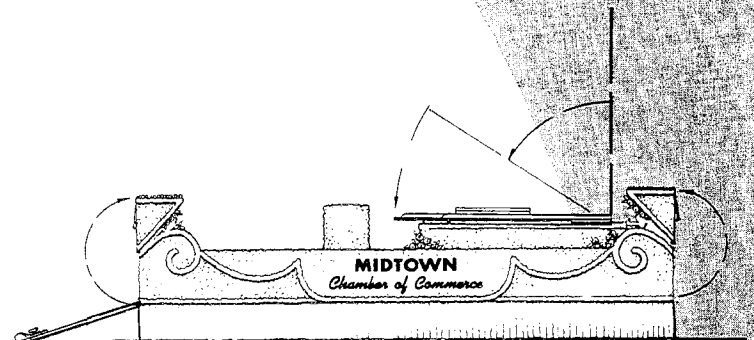
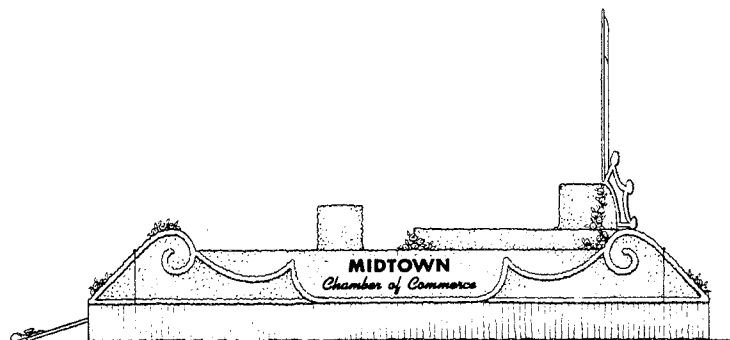
Hinges allow removal of throne seat and background to fold down.

Hinges along apron sides allow sides to fold up.

Hinges allow front & rear of apron to fold up.

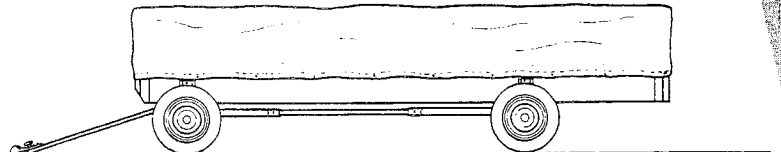
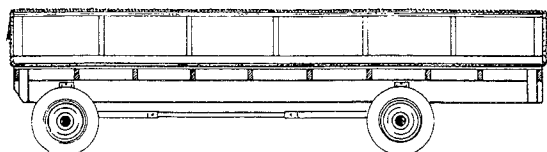
**NOTE:** A complete fold-up design, such as the F-701, requires careful engineering in order for it to accommodate the float superstructure and background as the F-701 does.

Although the total fold-up design shown is unique to the F-701 Kit, a portion of the fold-up design concept can be applied to many of the standard float designs offered by Vaughn's. The apron sides and, in most cases, the apron front and rear can be successfully adapted to the fold-up concept by installing hinges where the apron framework joins the trailer bed.



1. Remove throne seat and background wings, place them on forward area of float.

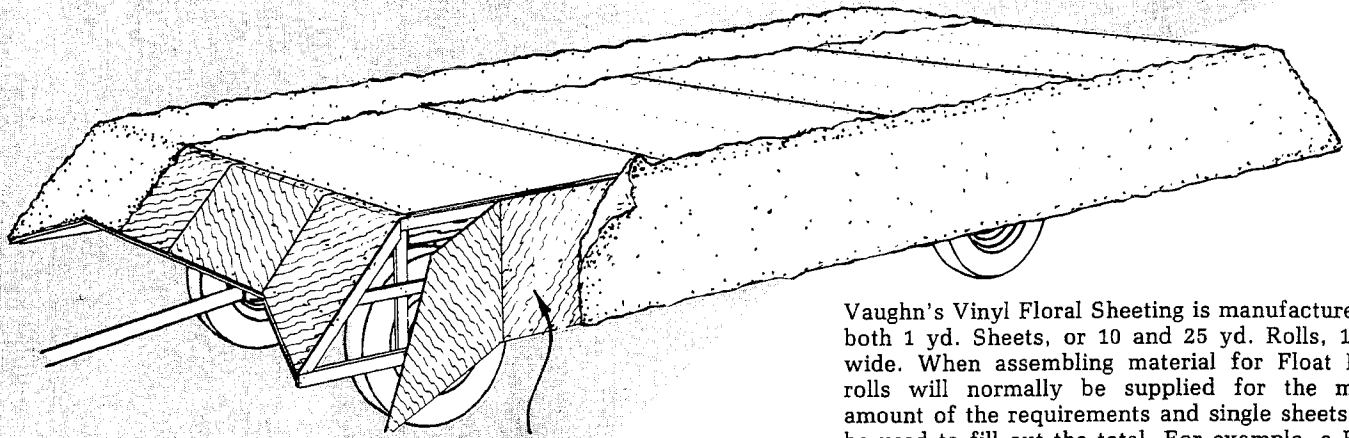
2. Fold background down onto throne deck.  
3. Fold front and rear sections of float apron up.



4. Fold apron sides up and lock to front and rear sections to form a sturdy box.  
5. Flip hanging fringe over to the inside.

6. Place grommeted canvas cover over the unit and fasten it to the float bed.  
7. The folded up unit is now ready for travel.

# THE APPLICATION OF VINYL SHEETING

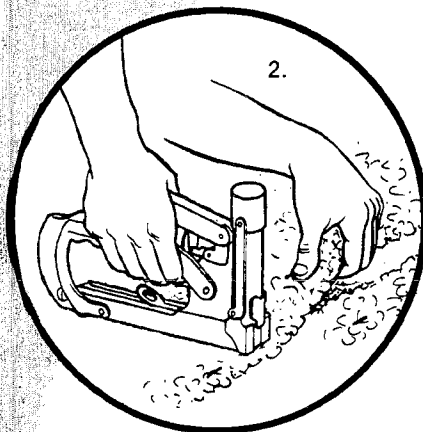
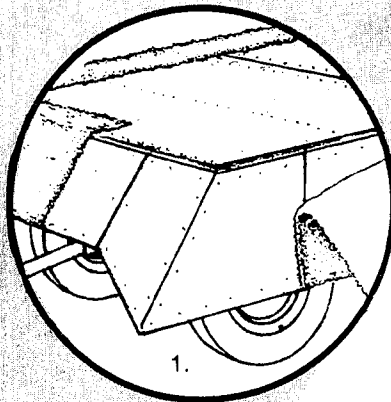


Vaughn's Vinyl Floral Sheeting is manufactured in both 1 yd. Sheets, or 10 and 25 yd. Rolls, 1 yd. wide. When assembling material for Float Kits, rolls will normally be supplied for the major amount of the requirements and single sheets will be used to fill out the total. For example, a Float Kit specifying 38 White Floral Sheeting would normally combine 1 — 10 yd. roll, 1 — 25 yd. roll and 3 single sheets. Variables may occur do to inventory.

## STEP 1

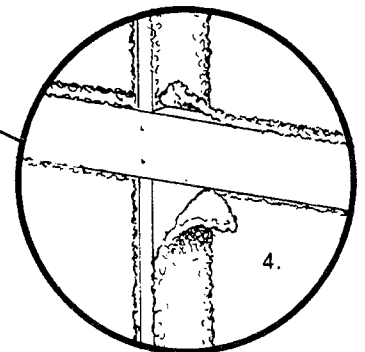
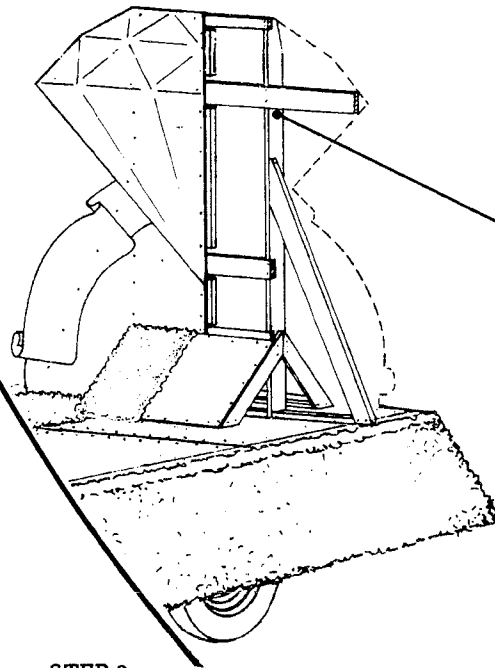
For best results Vinyl Sheeting should not be applied over open framework. An underlayment of 3/16" wallboard or 1/4" plywood should first be put on the float to provide a solid surface to staple the sheeting and also serve as a barrier to prevent the wind from pocketing underneath and tearing the material loose.

**EASY TO BUILD  
FLOAT  
KITS**



## STEP 2

When applying floral sheeting in rolls, staple down the edges and then staple at random over the entire surface of the sheeting to hold it down securely. Lap material over onto the platform if it is to be in the same color. Trim off the material at the top edge of the apron if a different color is used on the platform.

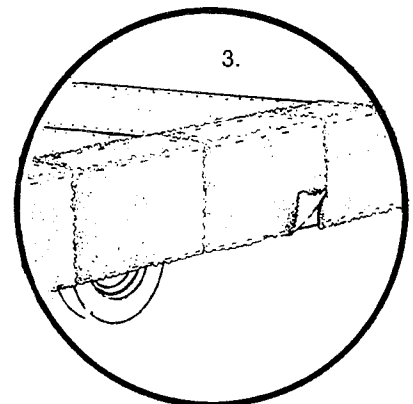


## STEP 4

Cover background support frame after you have finished decorating the Float frame so that any trim pieces left over may be used here before cutting new material.

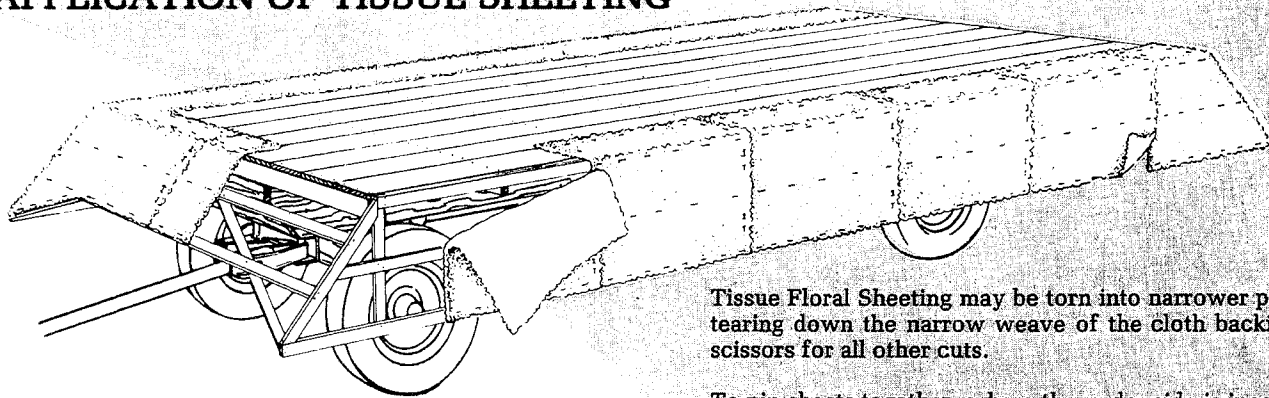
## STEP 3

When using single floral sheets, always start at the back of the float. Staple material flush with the bottom edge of apron. As you apply each sheet, overlap preceding sheet by about 1 inch and staple securely. This will prevent wind from getting under leading edges when float is in forward motion. If the float platform is to be of the same color, staple sheets over onto it. If it is to be of a different color, cut sheets off along top edge of apron sides after stapling.





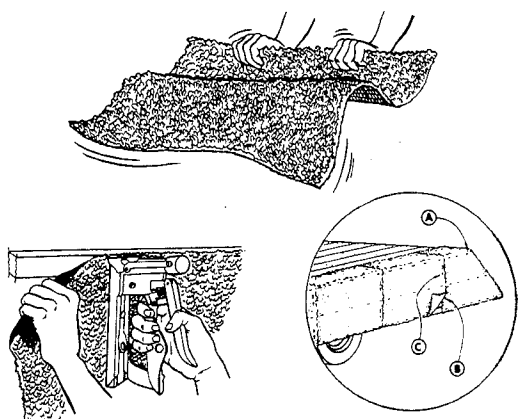
# THE APPLICATION OF TISSUE SHEETING



Vaughn's Tissue Floral Sheeting is manufactured in sheets approximately 1 yard square and can be cut into pieces and joined together again with pins without the seams showing.

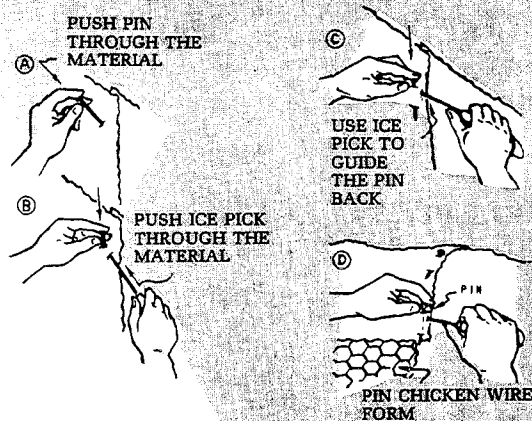
Tissue Floral Sheeting may be torn into narrower pieces by tearing down the narrow weave of the cloth backing. Use scissors for all other cuts.

To pin sheets together, where the under side is inaccessible to punch pin back through the material with your finger (such as over chicken wire forms, etc.) use an ice pick to guide the pin as shown in illustrations A-B-C-D.

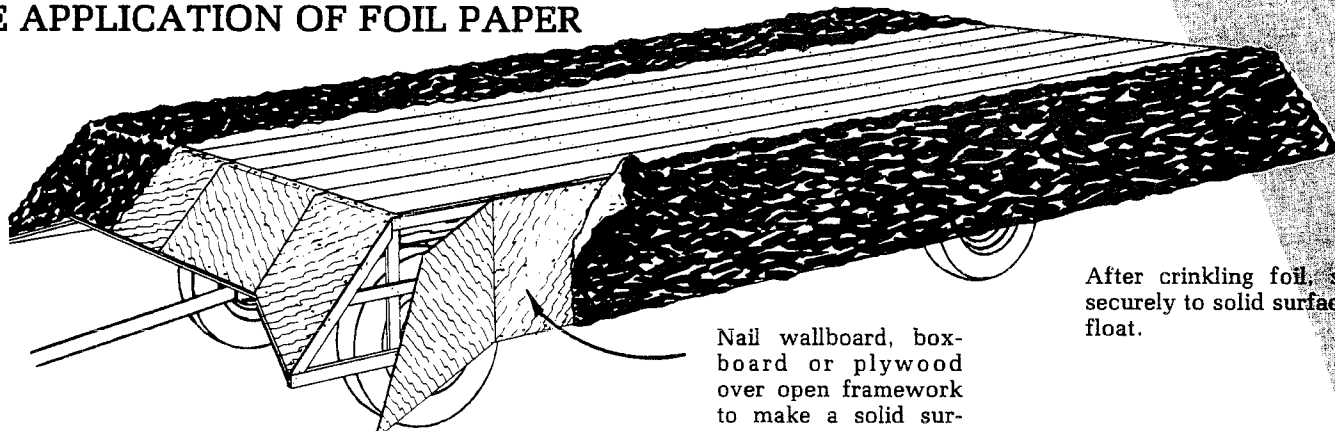


After unpacking sheets, "fluff" out the petals by shaking, as you would a rug.

- Apply tissue sheeting by:
- (A) Starting at the back, staple floral sheets to apron framework.
  - (b) Overlap succeeding sheets at least 1" or more.
  - (C) Pin overlapping sheets together where material joins over open framework.



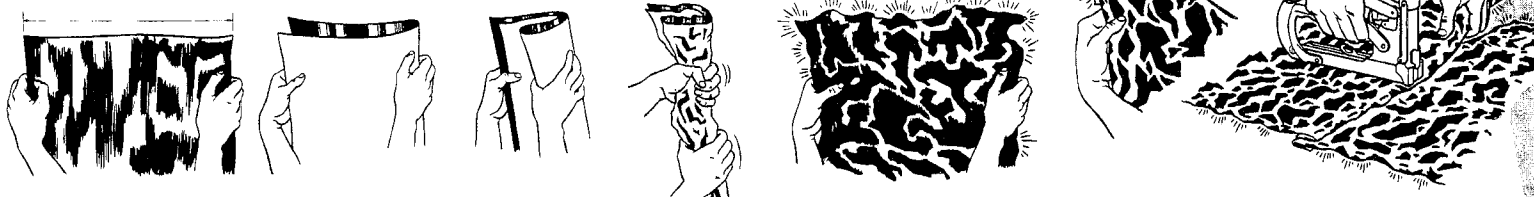
# THE APPLICATION OF FOIL PAPER



Foil paper is aluminum foil with a paper backing. This should be applied to solid surfaces such as wallboard, wooden platforms, etc.

Nail wallboard, box-board or plywood over open framework to make a solid surface for stapling on foil paper.

After crinkling foil, staple securely to solid surfaces of float.



1. Unroll foil paper

2. Fold foil down length at center but do not crease on the fold.

3. Repeat fold down the length of foil paper. Folded length should now be about 6 1/2" wide.

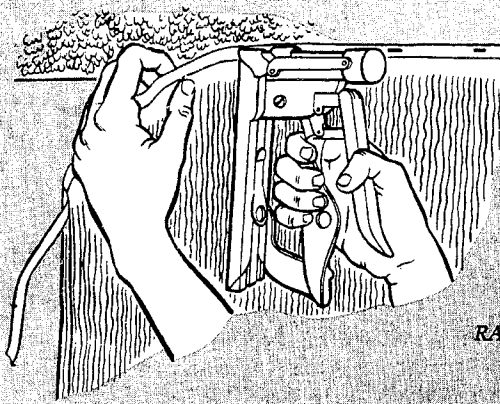
4. Using both hands, crush paper together down the entire length of foil.

5. Open the folds and lightly smooth out the foil paper. It will then have a crinkly, sparking appearance.

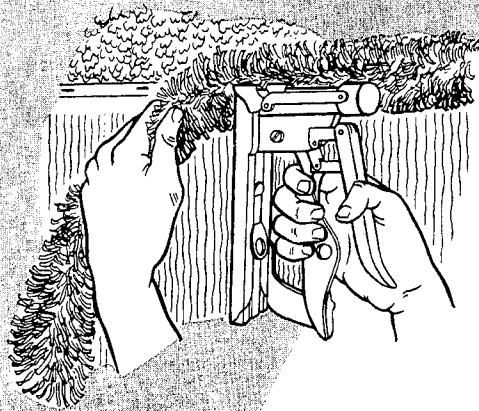
6. Fold under the edges along the length of foil paper.

7. Staple the edges down and then staple at random over the entire surface of the foil paper to hold it down securely.

# THE APPLICATION OF FRINGE AND FESTOON



Fringe is used as a drop between the apron frame and the ground to hide the wheels and give the display a "floating" appearance. Staple fringe to the apron base around the entire perimeter of the float.

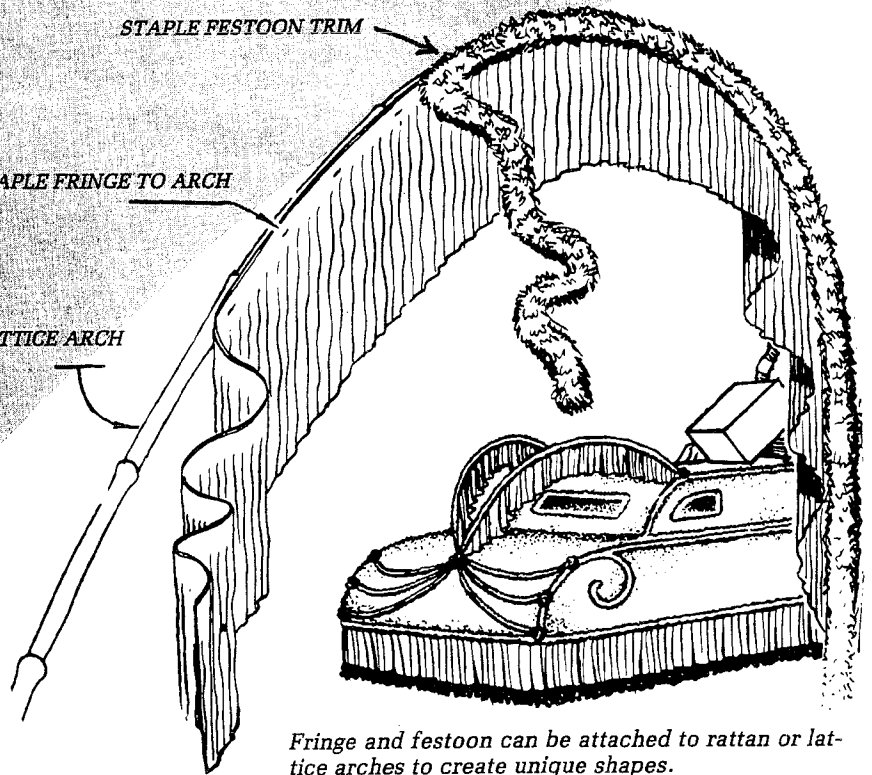


Festooning is a rope like trimming material. It is stapled around apron base to hide the fringe tape heading and in many other ways such as outlining backgrounds or contrasting trim between color breaks.

STAPLE FESTOON TRIM

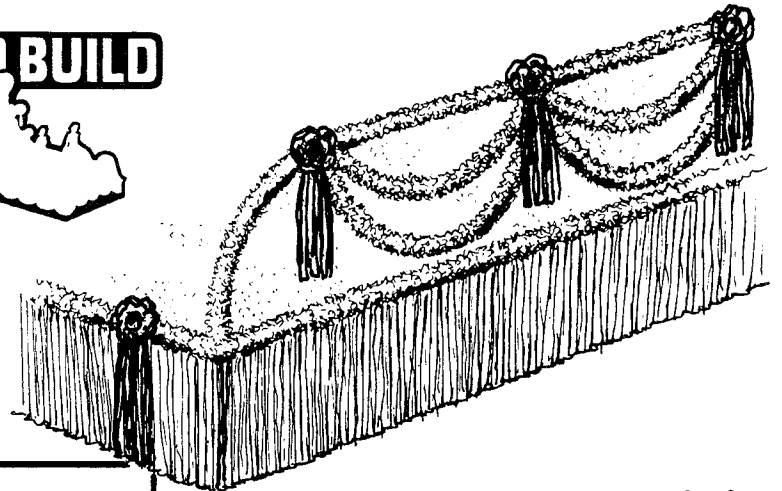
STAPLE FRINGE TO ARCH

RATTAN OR LATTICE ARCH

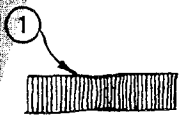


Fringe and festoon can be attached to rattan or lattice arches to create unique shapes.

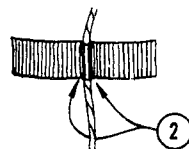
**EASY TO BUILD  
FLOAT  
KITS**



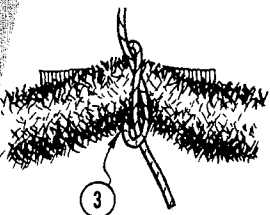
## HOW TO FASTEN FESTOON TO AUTOMOBILE



1 Cut pieces of decorator's tape about 3" long.



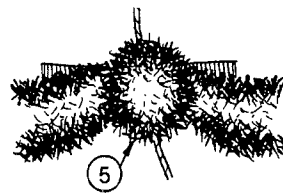
2 Tape string to auto at point where festoon is to be fastened. Press tape firmly down each side of piece of string.



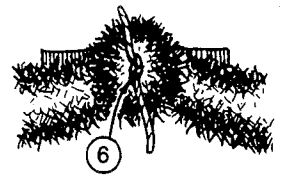
3 Place festoon over tape and loop the string around it and tie knot in string.



4 To make rosettes at tie points, cut about a 9" piece of festoon of a contrasting color and roll into a ball.



5 Place festoon ball over the knot in string.

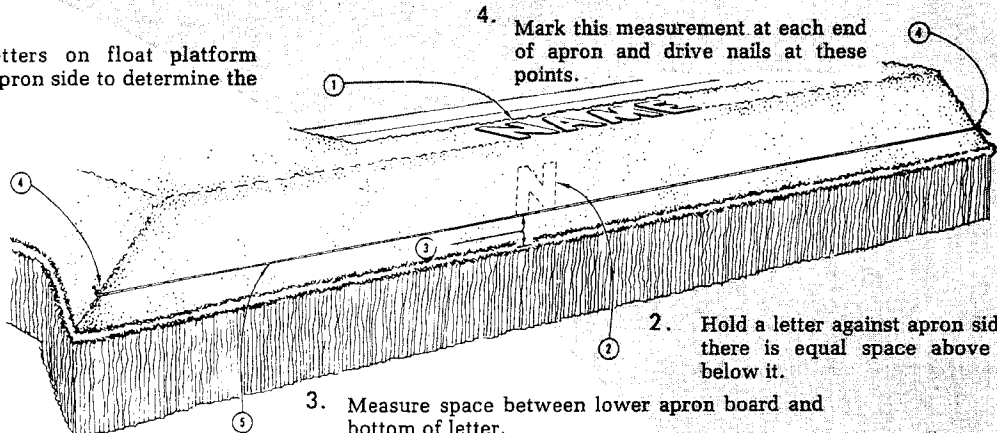


6 Loop string over ball and tie in a knot cut off loose ends of string.

Another variation is to attach tassels of a contrasting color applied over fringe or combined with flower rosettes and festoon. Tassels are made by simply cutting off 10" of fringe, rolling the fringe into a tight roll and stapling the tape heading. The rosette is used to cover the fringe heading.

# THE APPLICATION OF CUT-OUT LETTERS TO FLOAT APRON

1. Arrange letters on float platform above the apron side to determine the spacing.



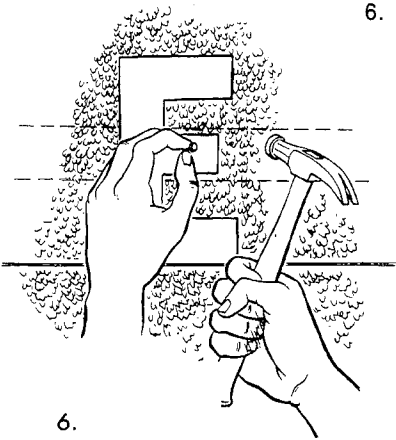
2. Hold a letter against apron side so there is equal space above and below it.

3. Measure space between lower apron board and bottom of letter.

5. Tie a string tightly between nails. This is the lettering guide line.

6. To Fasten Cut-Out Wallboard Letters:

Place bottom of letter along guideline string and nail to center board of apron frame.

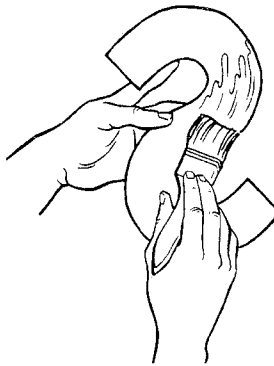


6.

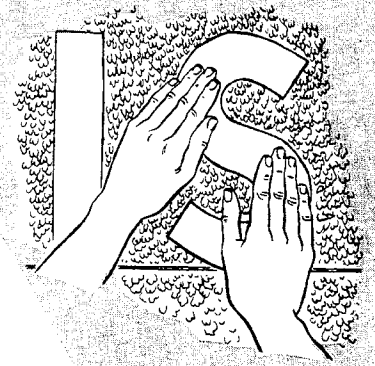
7. To Fasten Cut-Out Letters of Floral Sheeting or Foil Paper:

(a) Apply a coat of adhesive to back of letter.

(b) Place bottom of letter along guideline string and press firmly over entire face of letter until it adheres to float.



7.

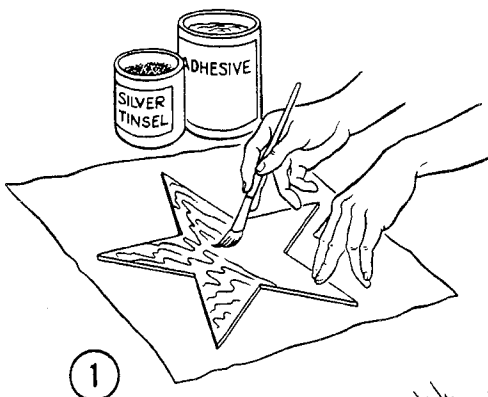


## TINSEL FLITTER AND DIAMOND DUST

Many effects may be achieved with these sparkling products. Gold, Silver, or Colored Tinsel Flitter gives a glittering, diamond-sparkle to stars, cut-out letters, figures, etc. A beautiful, snowy, sparkling appearance may be had by using White Diamond Dust over white or light-colored paints.

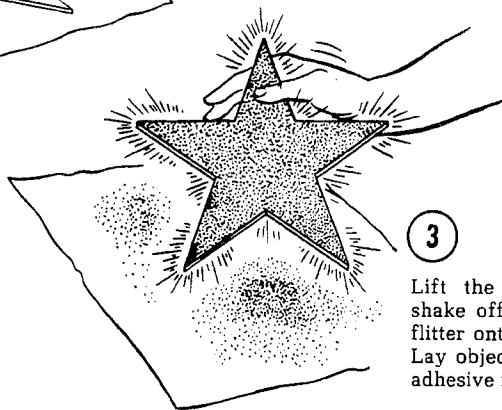
Tinsel Flitter and Diamond Dust may be applied with one of the following adhesives:

- White Latex Adhesive
- Shellac
- Glue
- Waterglass
- Paint



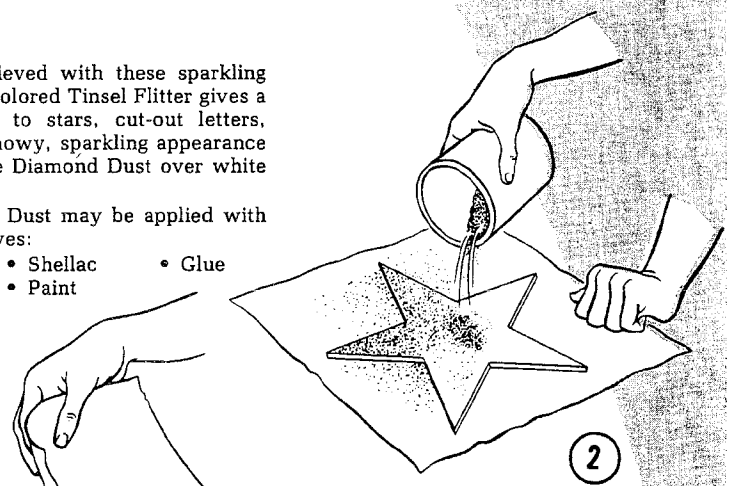
1

Place object to be flittered on a large piece of paper. Apply a coat of adhesive on the portion of the object to be flittered, such as on the outline edge of a letter, or over the entire face of a cut-out star.



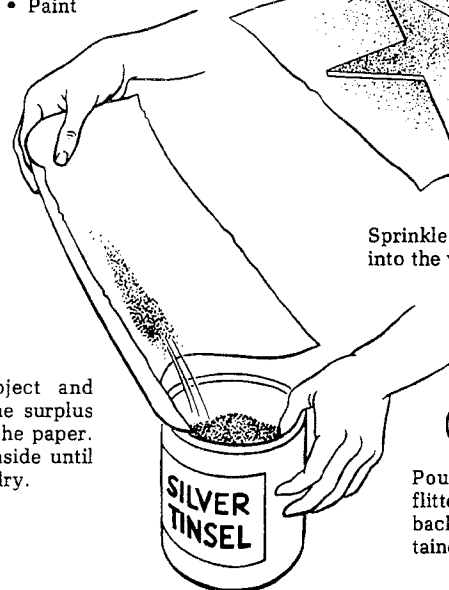
3

Lift the object and shake off the surplus flitter onto the paper. Lay object aside until adhesive is dry.



2

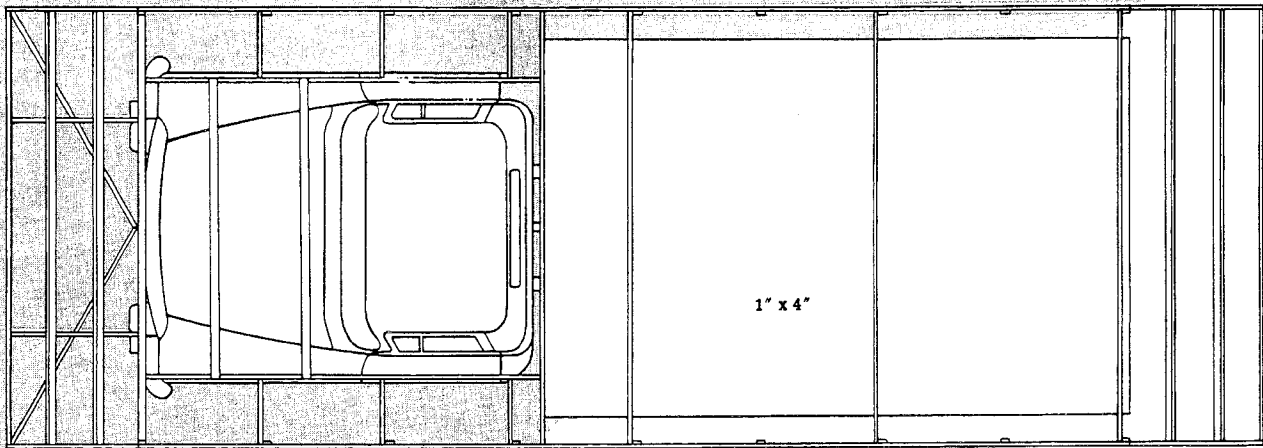
Sprinkle the flitter generously into the wet adhesive.



4

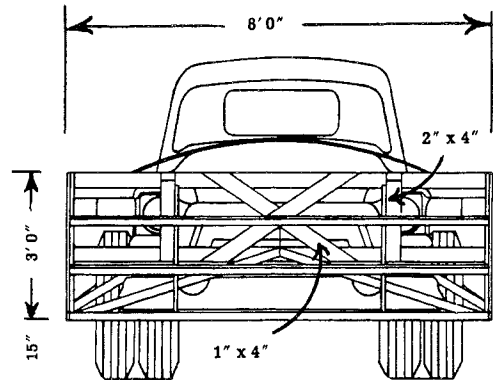
Pour the surplus flitter on the paper back into the container.

# DECORATING A FLAT BED TRUCK

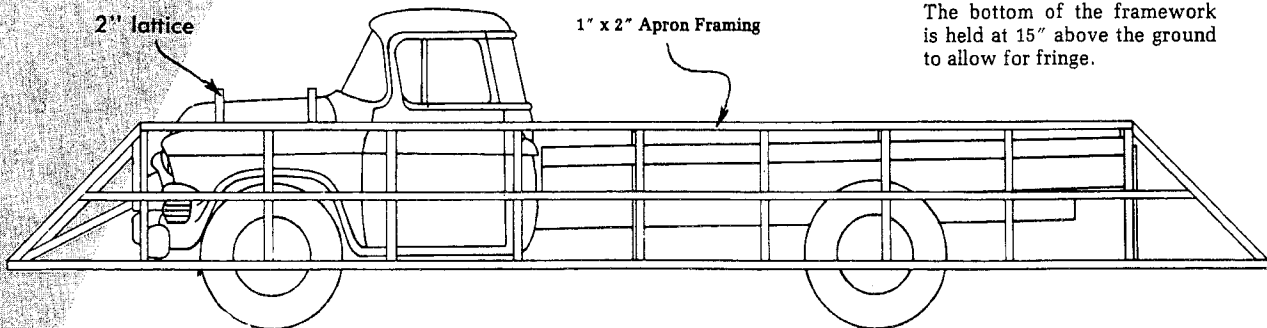


A flat bed truck can easily be converted into a self-propelled float or a decorated pulling vehicle. The construction technique is essentially the same as framing a trailer type parade float, except the truck replaces the 4 wheel trailer..

Using framing method #1, the apron framework is constructed of 1" x 2" wooden members joined together in the front and rear of the truck by 1" x 4" "X" braces and 2" x 4" upright members. The entire framework is then cross braced by 1" x 4" for added stability and strength. See illustrations.

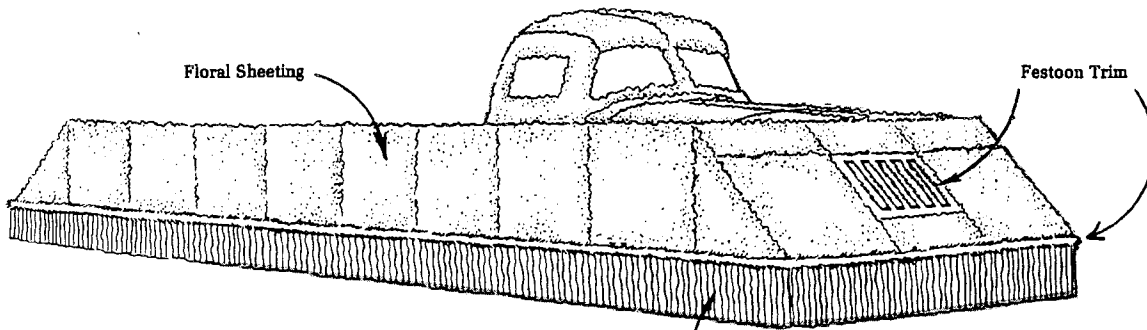


The bottom of the framework is held at 15" above the ground to allow for fringe.



If the truck is to be covered with Vinyl Floral Sheeting or foil paper, framing method #2 must be used. The entire framework must be covered with wallboard or 1/4" plywood. Tissue Floral Sheeting may be applied directly over the open framework.

When attaching the decorating materials follow the same procedures and methods as with trailer decorating. Remember to start at the rear and work forward overlapping at least 1" as you go forward.

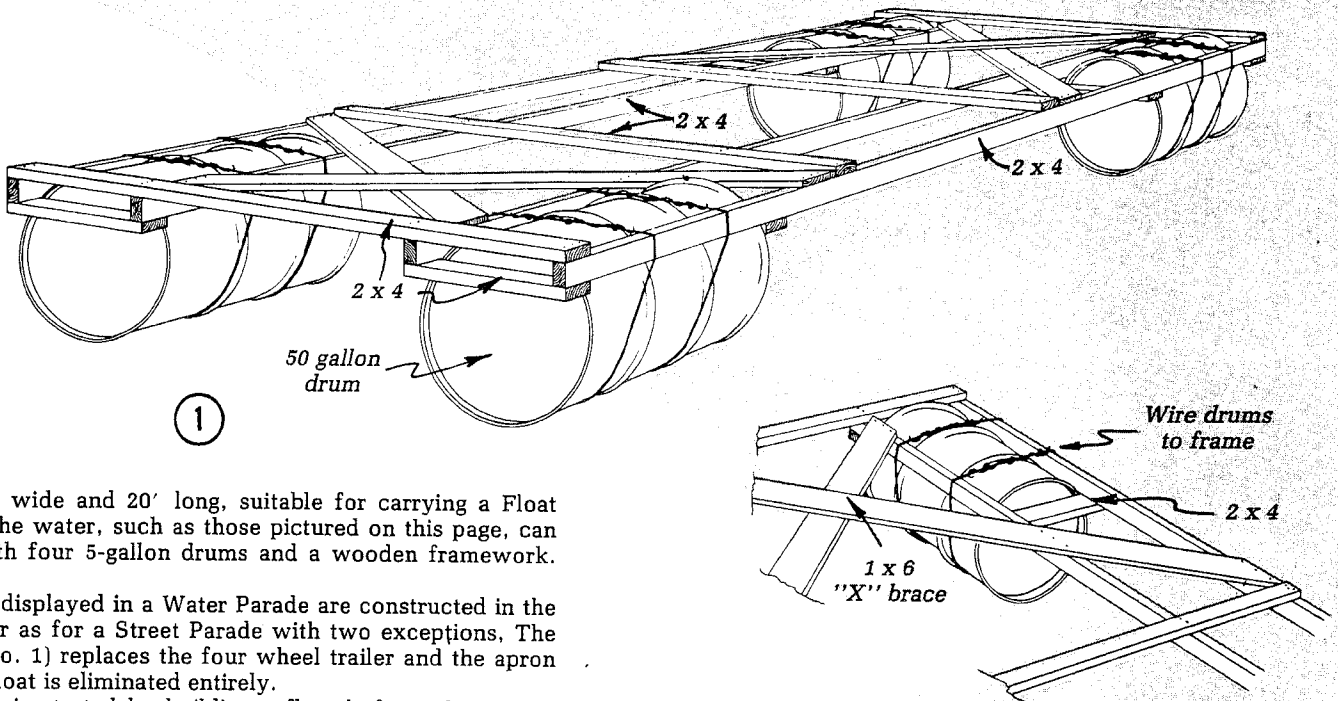


Complete the truck decorating by attaching the fringe and festoon. Be certain not to cover the radiator opening with sheeting. Keep the radiator opening clear to allow for good air flow.

Fringe



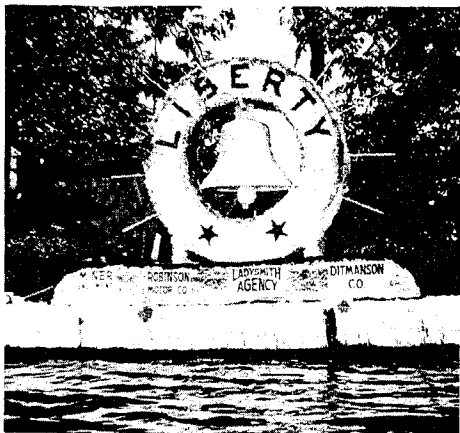
# WATER PARADES BARGE AND FLOAT CONSTRUCTION



A Barge, 8' wide and 20' long, suitable for carrying a Float Display on the water, such as those pictured on this page, can be made with four 5-gallon drums and a wooden framework. (Ill. No. 1)

Floats to be displayed in a Water Parade are constructed in the same manner as for a Street Parade with two exceptions, The Barge (Ill. No. 1) replaces the four wheel trailer and the apron around the float is eliminated entirely.

Construction is started by building a flat platform the size of the Barge, upon which the framing for the superstructure is built, the same as you would on a trailer platform. After construction, the float can be completely decorated, except for the Fringe, and stored until the day it is to be entered in the Parade.



The procedure for assembling a Water Parade, is as follows:

All Barges are placed on the shore near the water.

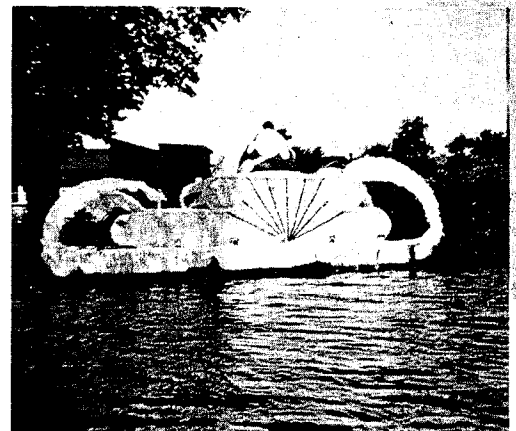
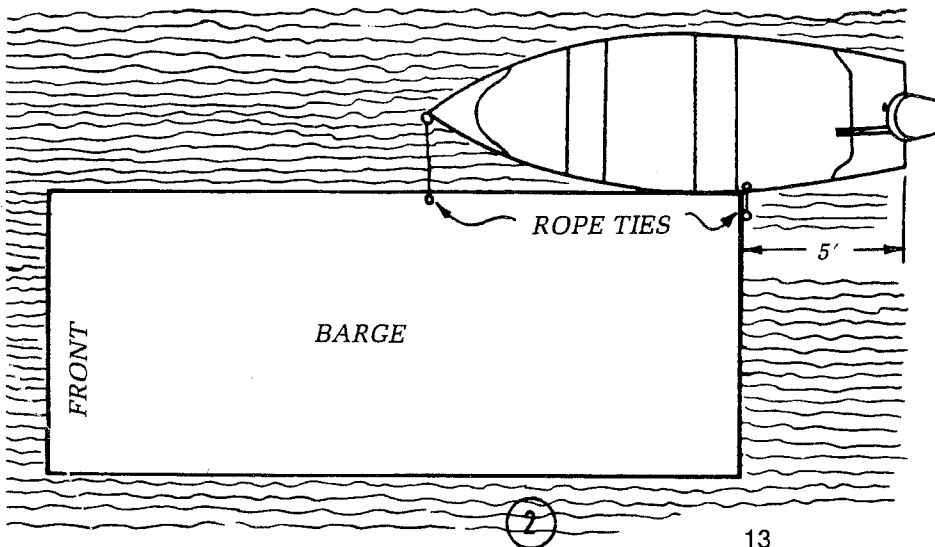
The Float displays are transported from storage to the assembly area on large flat bed trucks.

The Floats are transferred off the trucks onto the Barges by a crew of assembly men.

The Floats are then fastened securely to the Barges with wire and the Fringe is stapled around the edges of the Float platforms.

A mobile boom crane, fitted with a double cable sling that is looped around under each end of the Barges, is used to lift the assembled units off from the shore and place them out on the water.

Each Float is then tied to an outboard motor boat (as in Ill. No. 2) and taken to the line-up area where it is anchored until Parade time.





## ANIMATED PROPS

ANIMATED MOTIONS CAN BE ACHIEVED ON A FLOAT BY MANUAL OPERATION OF SIMPLE MECHANICAL MOVEMENTS.



Display props can be made to move from side to side, revolve, etc. by simple lever or crank and pulley action. Manual operation can be performed by personnel seated out on the Float or from underneath a deck built high enough to camouflage the operator.

Side to Side or full Rotation can be accomplished with the crank, belt and pulley installation. Operation can be achieved from several different locations on Float by the length of the belt used. See illustration No. 1.

A more basic side-to-side animated motion can be accomplished with a simple mechanism such as the one shown in illustration 2.

**EASY TO BUILD  
FLOAT  
KITS**

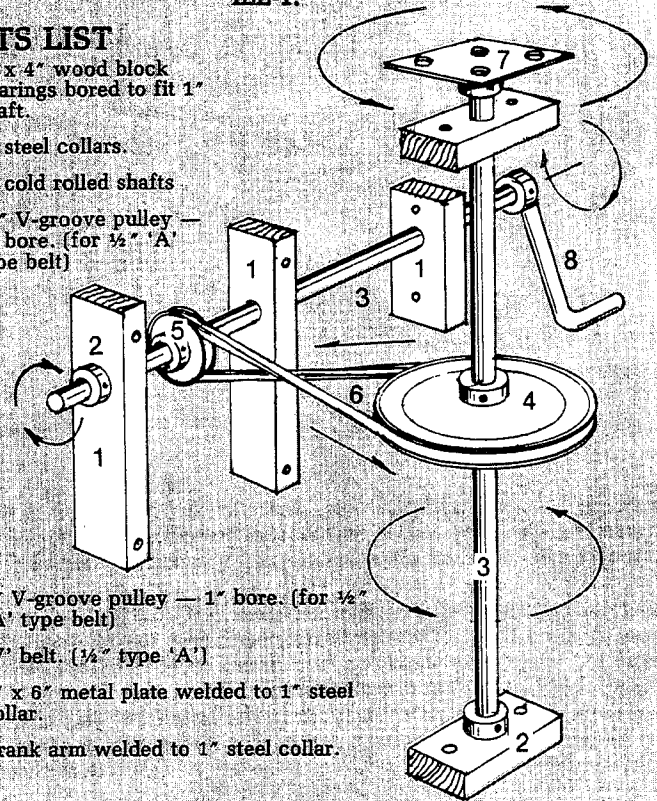
### PARTS LIST

1. 2" x 4" wood block bearings bored to fit 1" shaft.
2. 1" steel collars.
3. 1" cold rolled shafts
4. 12" V-groove pulley — 1" bore. (for ½" 'A' type belt)

5. 4" V-groove pulley — 1" bore. (for ½" 'A' type belt)
6. V belt. (½" type 'A')
7. 6" x 6" metal plate welded to 1" steel collar.
8. Crank arm welded to 1" steel collar.

9. These items are generally available at Farm Machinery and Industrial Supply companies or possibly your local hardware store. Metal plate and crank arm can probably be obtained at your local blacksmith or welding shop.

ILL-1.

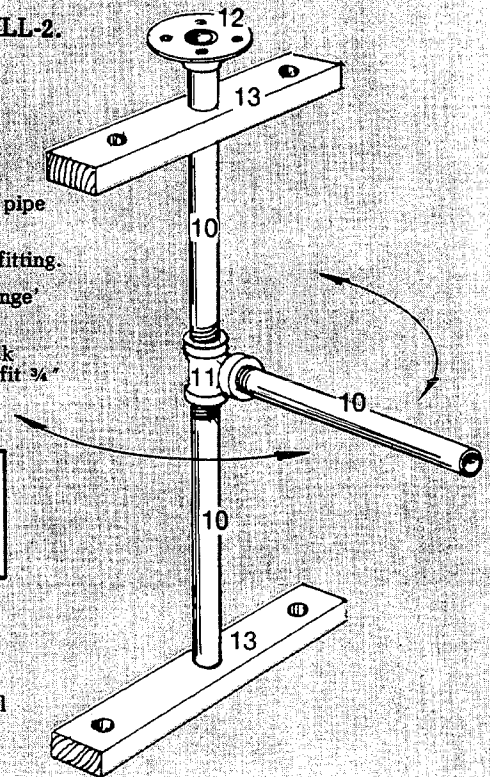
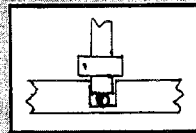


ILL-2.

### PARTS LIST

10. ¾" threaded steel pipe sections.
11. ¾" steel pipe 'T' fitting.
12. ¾" steel pipe 'Flange' fitting
13. 2" x 4" wood block bearings bored to fit ¾" steel pipe.

16. A small steel ball bearing placed under cold rolled shaft in wood bearing socket will greatly increase ease of turning.



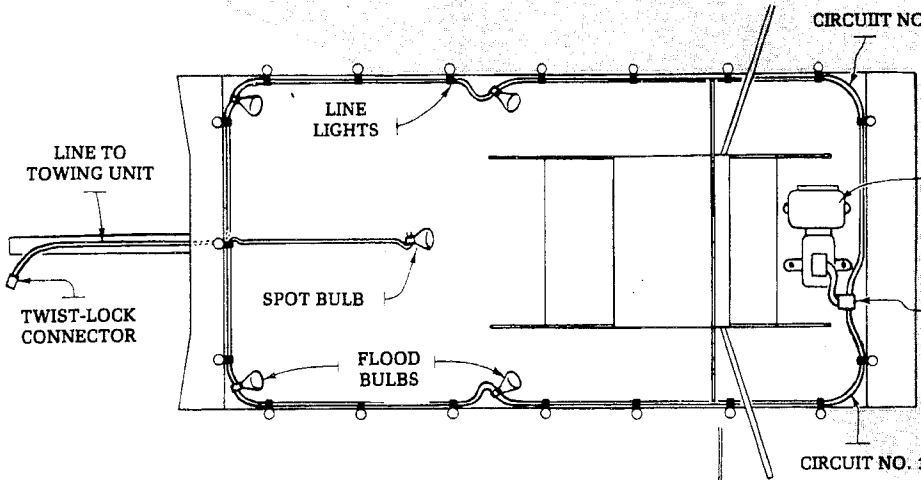
14. These items should be readily available at any Plumbing Supply or Hardware Store.

15. Apply lubricating grease to all bearing blocks.



# FLOAT LIGHTING

## BASIC WIRING LAYOUT USING 110 VOLT GENERATOR



The pin type, bakelite socket is easily connected without stripping insulation by placing wires in pin slots and tightening base cap.

110 VOLT ELECTRIC GENERATOR

2 CIRCUIT FUSE AND SWITCH BOX WITH 110 VOLT GENERATOR

CIRCUIT NO. 1

CIRCUIT NO. 2

LINE TO TOWING UNIT

TWIST-LOCK CONNECTOR

SPOT BULB

FLOOD BULBS

LINE LIGHTS

1.

Pin type socket

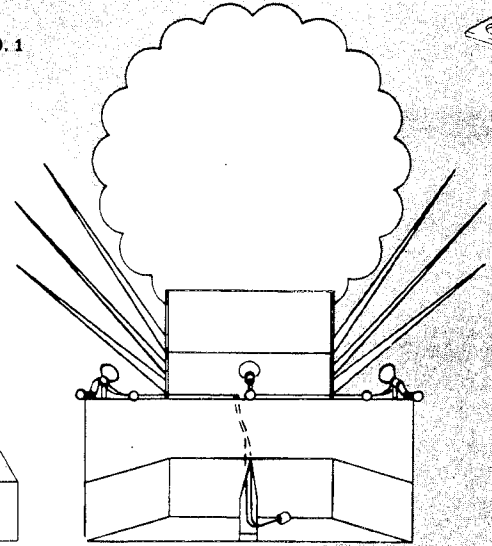
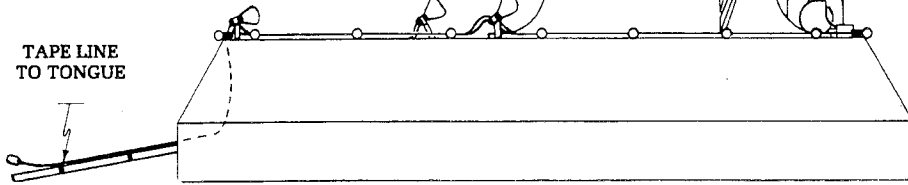
2.

To clamp socket, tighten bolt. Fasten to float.

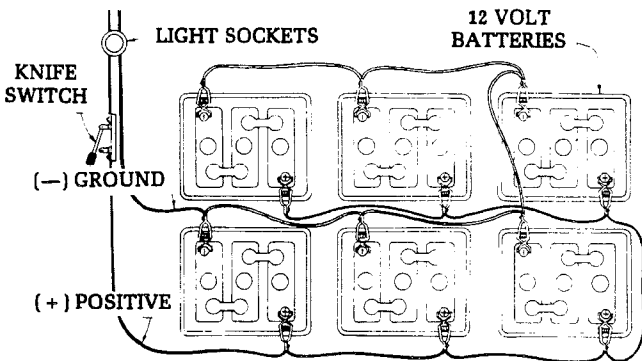
Recessing the lighting sockets allows wiring to be put under the framework. A hole is drilled through the float bed surface to fit the barrel of the pin type socket. See illustration 1.

An inexpensive flood light bracket can be made with perforated pipe strap, a pin type socket and a 3/8" bolt. See illustration 2.

TAPE LINE TO TONGUE



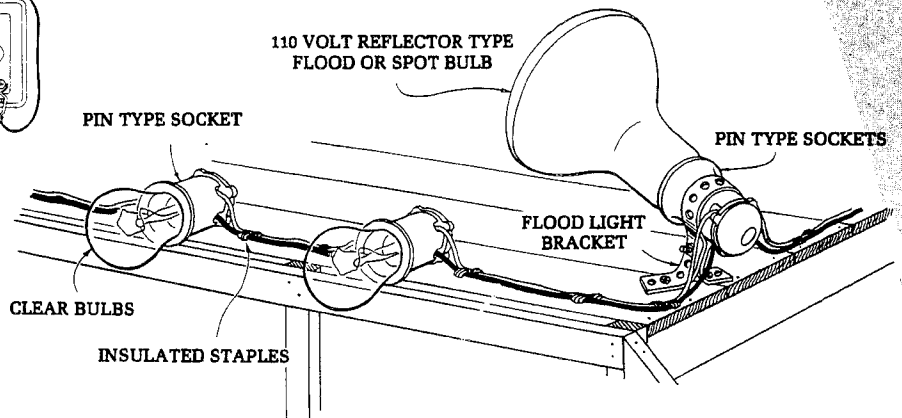
## 12-VOLT BATTERY LIGHTING SYSTEM



Use six batteries of 12 volts each connected in parallel. Use 12 volt bulbs (25 watts each for general illumination, 50 watts each with attachable reflectors). Total lighting should not exceed 600 watts, which is the equivalent of twenty-four 25-watt bulbs or sixteen 25-watt and four 50-watt bulbs. This system should give approximately 2 to 3 hours of illumination, starting with batteries at full charge.

## SURFACE WIRING

Surface wiring may be used instead of recessed, however, extreme care should be taken when applying decorating materials over surface wiring, to prevent driving a staple into the wires. Take extra caution when applying foil paper because it is a good conductor of electricity.



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