



## Installation Instructions

# Flip-Over Model 208 Ford Super Duty

Fits 08-16 (F250,F350,F450) (2WD, & 4WD)  
99-07 (F250,F350) (4WD Only)



### FOR THE SAFEST INSTALLATION

11/15

**WARNING** Most pick up trucks have **FUEL LINES** and/or **BRAKE LINES** and/or **ELECTRICAL WIRING** positioned along the truck framerrails where your under-bed hitch will install. **BEFORE INSTALLATION** identify and examine the location of fuel lines, brake lines and electrical wires. Be sure you will not damage fuel lines, brake lines or electrical wiring when positioning the hitch components, drilling holes or tightening fasteners. **Be Certain To Avoid Fuel Tanks When Drilling Holes.**

- Wear Safety Glasses, Gloves and Particle Mask for protection while installing a under-bed gooseneck hitch.
- ALWAYS correctly chock tires prior to raising truck with jacking device. For protection ALWAYS use jack stands when working under or around a truck which has been raised by a jacking device.
- Be certain the exhaust system is cool prior to installation to avoid possible burns from hot tail pipe and muffler.
- Torque ALL fasteners used in the under-bed gooseneck hitch installation as specified in these Installation Instructions.
- **READ ALL SAFETY AND WARNINGS ON THE LAST PAGE OF THE PROVIDED INSTRUCTIONS.**

### INSTALLATION PROCEDURE

**WARNING: Verify adequate trailer swing clearance between trailer nose and cab of truck, and trailer and rear of truck. READ spray in bed liner warning on last page.**

- 1. For both Short and Long Bed trucks, center the Hole in the Truck Bed Floor at 46 1/8" from the rear lip of the truck bed floor.** Center the hole between the wheel wells. Drill hole using a **3 1/2"** hole saw. File or sand the edges of the hole to remove any burrs, and remove all saw tailings from the bed area.
- 2.** If using a vehicle hoist, raise the truck at this time. If using a jacking device, always chock the front tires to prevent the truck from rolling. Lift the rear of the truck approximately 10". **It is not necessary to lift the rear tires off the ground.** Properly position jack stands under the rear frame of the truck to protect against jack failure.
- 3.** Install the **rear crossmember** (the rear angle has a small notch cut out for extra clearance above the exhaust). Slide the angle across the frame from the drivers side wheel well forward of the hole. Then slide it in position behind the hole. The leg with the holes goes toward the front. Once in place, use an adjustable wrench to turn it up so the leg with the holes is verticle with the flat leg on top.
- 4.** Slide the **front cross member** across the frame rails forward of the hole for the ball, with the plain side forward and the leg with the holes facing rearward.
- 5.** Raise the center assembly into position under the truck bed with the ball tube passing into the 3-1/2" hole. Use an overhead lifting device, or a saw horse in the bed of the truck, and cable or strap to hold the Center Assembly firmly against the underside of the bed floor. Do not pull it up so tight that it bows the truck bed. On some trucks you may need to release the rear exhaust hanger and pull the exhaust down, install the Center Section, and re-fasten the hanger.
- 6.** Fasten the Center Assembly to the Front and Rear Cross Member using flat washers on the oval holes and 1/2" x 1 1/4" bolts. **Pull the slack out of the bolts but do not tighten at this time.** Square the assembled cross members and center assembly across the frame.
- 7.** Fasten the crossmembers to the frame plate tabs using 1/2" x 1 1/4" bolts with flat washers and lock nuts. **Pull the slack out of the bolts but do not tighten at this time.** Fasten frame plates to the frame by passing a 3/4" bolt with washer from inside the truck frame through the 3/4" hole in the frame plate and secure with 3/4" nut. **Do not tighten at this time.**

**Install the U-bolts from the inside of the frame with the legs angled down. Leave nuts loose at this time.**

**CAUTION:** Avoid fuel tank, brake lines and/or wiring

## INSTALLATION PROCEDURE- CONTINUED

**IMPORTANT:** Square up the hitch **before tightening** the bolts in the following sequence. **First** tighten the bolts holding the Center Section to the Cross Angles. **Important: Next**, release the center section from the overhead lifting device. **Check** to make sure that the cross angles are resting securely on the frame. **Next** tighten the frame plates to the frame, **then** cross members to the frame plate tabs, **Now** tighten the u-bolts. The tabs on the frame plates may bend in slightly when tight.

**Always follow the torque guidelines listed below.**

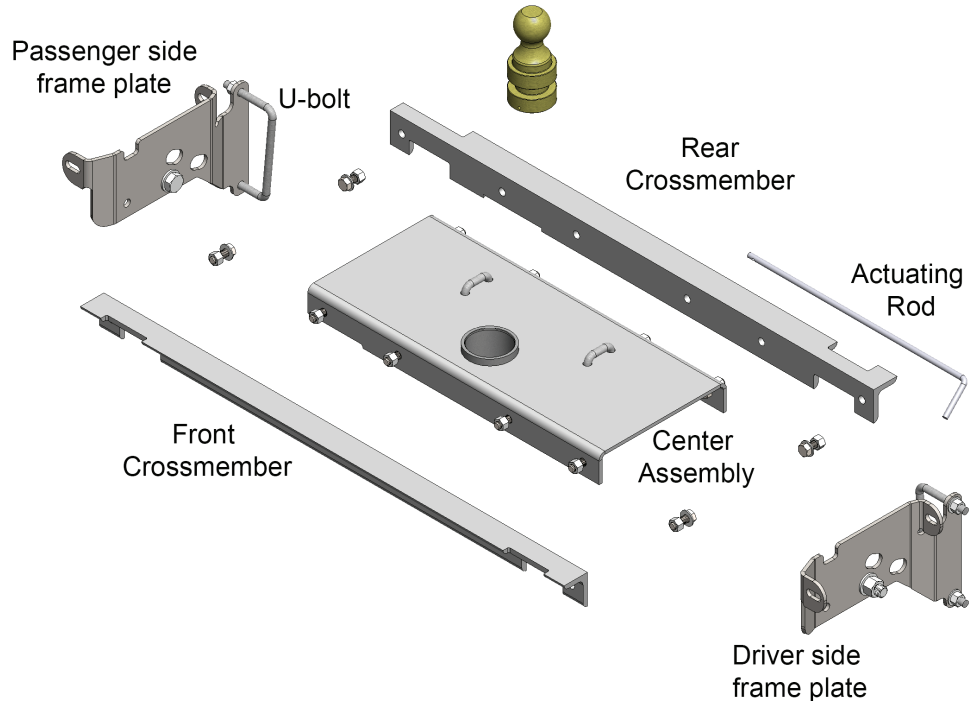
8. Drill four 1/2" holes for the Safety Chain Brackets from under the truck bed. Drill through the four 9/16" holes in the Center Assembly through the truck bed floor. Remove all tailings before proceeding. Place a U-bolt in each pair of holes from the top side of the bed. From under the bed, place a spring and 1/2" lock nut on each U-bolt leg. **Tighten each nut until thread just extend through the nut.**
9. From the driver side, pass the Actuating Rod thru the slotted hole between the Frame Plate extensions and into the linkage coupler. Align the Actuating Rod so the set screw seats in the hole provided in the rod, **make sure you tighten to the correct torque specifications.** Be certain the Actuating Rod rotates freely and moves in and out freely.
10. Retract the Retaining Pin by rotating the Actuating Rod 90 degrees counter clockwise. Place the Flip-Over ball in the Socket. Rotate the Actuating Rod 90 degrees clockwise to engage the Retaining Pin.
11. Keep the base of the Flip-Over ball lightly lubricated with **lithium grease.**
12. Please read the **SAFE TOWING INSTRUCTIONS** on the WARRANTY sheet.

### Torque Specifications:

- 3/4" Bolts - 155 ft. lbs.
- 1/2" Bolts - 119 ft. lbs.
- 1/2" U-Bolts - 50 ft. lbs
- Actuating rod set screw - 15 ft. lbs.

### Hardware Provided

- 12 - 1/2" X 1-1/4" Grd. 8 Bolts
- 20 - 1/2" Lock Nuts
- 4 - 1/2" Flat Washers
- 2 - 3/4" X 2" Bolts & Nuts
- 4 - 3/4" Flat Washers
- 2 - Safety Chain U-Bolts
- 4 - Springs for safety chain u-bolts
- 2 - Slanted U-Bolts



# Flip-Over™



Model Number 208  
Gross Trailer Weight: 30M lbs.  
Gross Trailer Tongue Weight: 7.5M lbs.

## READ ALL SAFETY AND WARNINGS BEFORE STARTING THE INSTALL

### WARNING AND SAFETY INFORMATION, READ ENTIRELY BEFORE INSTALLATION.

Read all installation and operating instructions along with all labels before using this product.

PopUp Towing's under-bed hitches are standard with a 2-5/16" ball. Make sure the coupler on the trailer is designed for 2-5/16" ball. Using a larger size coupler could cause loss of attachment and cause serious injury.

Do not modify this product in any manner. Doing so could alter the integrity and proper use of the product causing serious damage or injury.

Do not exceed tow or tongue rating of coupler, tow or tongue rating of the hitch, or tow or weight ratings of the truck or trailer. See vehicle and trailer manufacturer information for proper ratings. Exceeding these ratings may cause damage to truck and/or trailer, or possible bodily injury.

Adding components such as a PopUp Towing under-bed gooseneck hitch to the chassis of any vehicle can be hazardous. There is potential for unexpected combustion of fuel, electric shock, burns, shifting or falling of unstable vehicle, damage to vehicle, injury from tool usage and many other hazards. This installation must be completed by someone who is aware of the hazards involved.

Always be sure the ball is properly latched into place while in the up or down position. Before hauling heavy loads make sure that your hitch will clear the truck's differential before hauling a load.

Cab clearance can be an issue with short bed trucks and limits towing on certain trailers. Failure to insure that there is adequate clearance before towing, may result in property damage, or serious injury.

**IMPORTANT:** The hitch is designed to install only at the location described in the included instructions. Failure to place the ball hole precisely may result in property damage or difficulty during installation.

Failure to follow the bolt tightening sequence and torque settings listed above may result in the hitch being misaligned which could affect the performance of the hitch, or result in property or bodily damage.

PopUp Towing Products assumes no responsibility for injury to self, or damage that may occur during installation. As always its best to have this product installed by an experienced installer.

**CAUTION:** If your truck is equipped with a spray in bed liner that covers the rear lip of the truck bed, make sure and add the thickness of the bed liner to the hole location measurement before drilling the hole.