

Flip-Over™

Installation Instructions

Model 200 Flat Bed Weld-In Hitch For Use With 1/8" Thick Flat Bed Truck Decks



Model 200 11-13 FOR THE SAFEST INSTALLATION

WARNING Most pick up trucks have **FUEL LINES** and/or **BRAKE LINES** and/or **ELECTRICAL WIRING** positioned along the truck frame rails where your Flip-Over 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, positioning or tightening U-bolts. **Be Certain To Avoid Damage To Fuel Lines and/or Wiring When Positioning and Tightening U-Bolts.**

- Wear Safety Glasses, Gloves and Particle Mask for protection while installing a Flip-Over gooseneck hitch.
- ALWAYS correctly chock tires prior to raising truck with jacking device. For protection in case of jacking device failure ALWAYS use Jack Stands when working under or around a truck which has been raised by a jacking device.
- Allow the exhaust system to cool prior to installation to avoid possible burns from hot tail pipe and muffler.
- Torque ALL fasteners used in the Flip-Over gooseneck hitch installation as specified in these Installation Instructions.

INSTALLATION PROCEDURE

WARNING: Verify adequate trailer swing clearance between trailer nose cab of truck, and trailer and rear of truck.

1. The Flat Bed Weld-In Hitch is designed for installation in truck beds using 1/8" steel decks.
2. The center of the 3-1/2" deck hole for the ball socket tube should be located anywhere between directly over the axle centerline to eight inches forward of the axle centerline. When determining your location be certain of adequate clearance for the ball to be inverted in the ball socket without contacting the trucks differential. Use a 3-1/2" hole saw to cut a hole centered at the location you have chosen for the socket tube.
3. Grind off powder coat only on the edges that you are going to weld your braces to. From under the truck, insert the socket tube that extends through the top plate of the Flat Bed Hitch into the 3-1/2" hole. Be sure to square up the hitch with the handle mechanism facing the driver side of the truck. Securely weld bracing on both sides of the Flat Bed Hitch between the bed cross members for adequate strength. **DO NOT WELD TO THE SOCKET TUBE because welding will cause it to warp.**
4. Fit the Actuating Rod into the linkage coupler. Align the Actuating Rod so the set screw seats in the hole provided in the rod, and tighten to 7 foot pounds. slide the Actuating Rod Guide over the Actuating Rod. Position it anywhere between 10" and 17" from the Top Plate and weld it to the bottom of the deck. **Be certain the Actuating Rod rotates and moves in and out freely.**
5. Next use a 9/16" drill bit to drill the 4 holes for the safety chain U-Bolts. Place a U-Bolt in each set of holes from the top side. Then place a spring and 1/2" nut on each leg of the U- Bolt and tighten till threads extend through the nut.
6. Retract the Retaining Pin by rotating the Actuating Rod 90 degrees counter clockwise. Place the Flip-Over ball in the socket. Then rotate the the Rod 90 degrees clockwise to lock the ball in place.
7. Keep the base of the ball lightly lubricated with lithium grease.
8. Please read the **SAFE TOWING INSTRUCTIONS** on the Flip-Over warranty sheet



MADE IN

U. S. A.

Model Number 200
Gross Trailer Weight: 30M lbs.
Gross Trailer Tongue Weight: 7.5M lbs.