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## Installation Instructions

### Model 239 2007 Toyota Tundra Two and Four Wheel Drive All Bed Lengths



## Model 239 7/07

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, 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 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.
- 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 Flip-Over gooseneck hitch installation as specified in these Installation Instructions.

## INSTALLATION PROCEDURE

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

1. Mark and center punch a location from the rear lip of the truck bed (tailgate end) centered between the wheel wells as stated below:

### All Models 42 1/2"

Center a hole in this location using a 3-1/2" hole saw. Smooth the hole with a file and clean all saw tailings from the bed area before proceeding.

2. If using a vehicle hoist, raise the truck at this time. If using a jacking device Chock the front tires to prevent the truck from rolling. Jacking against the rear bumper or frame, 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. Identify the Front and Rear Crossmembers. The **Front Crossmember** has the end holes **closer to the end of the bar** than the Rear Crossmember does.

4. Slide the Crossmember across the frame with the notches facing forward on the Front Crossmember and rearward on the Rear Crossmember (see photo). The **Chamfered area** of the notch is to be **down**. Use an adjustable wrench to turn the Crossmember to an upright position. You may have to trim the bed sealant some to do this.

5. Raise the Center Assembly into position with the **ball socket toward the front of the truck**. Use an overhead lifting device, or a saw horse in the bed of the truck, and cable or rope to hold the Center Assembly firmly against the underside of the bed floor.



## INSTALLATION PROCEDURE - CONTINUED

6. Fasten the Center Assembly to the Cross Members using 1 1/2" x 1/2" bolts. Square the Assembly across the frame. Tighten the bolts holding the Center Assembly to the Cross Members.

7. Fasten the frame plates to the Cross Bars but **do not tighten at this time**. Fasten the Side Plates to the frame using the 4 1/2" U-Bolts. Tighten the top and bottom nuts on the U-Bolts evenly. **DO NOT** over tighten the top nuts.

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

9. **Torque** 1/2" fasteners to **65 foot pounds** in the following sequence: First the Cross Members to Center Assembly, then the Cross Members to the Frame Plates.

10. Drill four 1/2" holes for the Safety Chain Brackets from under the truck bed. 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" nut on each U-bolt leg. Tighten each nut until thread extends through the nut.

11. From the driver side, pass the Actuating Rod through the 1/2" 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 and tighten to 15 foot pounds. Be certain the Actuating Rod rotates freely and moves in and out freely.

12. 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.

13. Keep the base of the Flip-Over ball lightly lubricated with lithium grease.

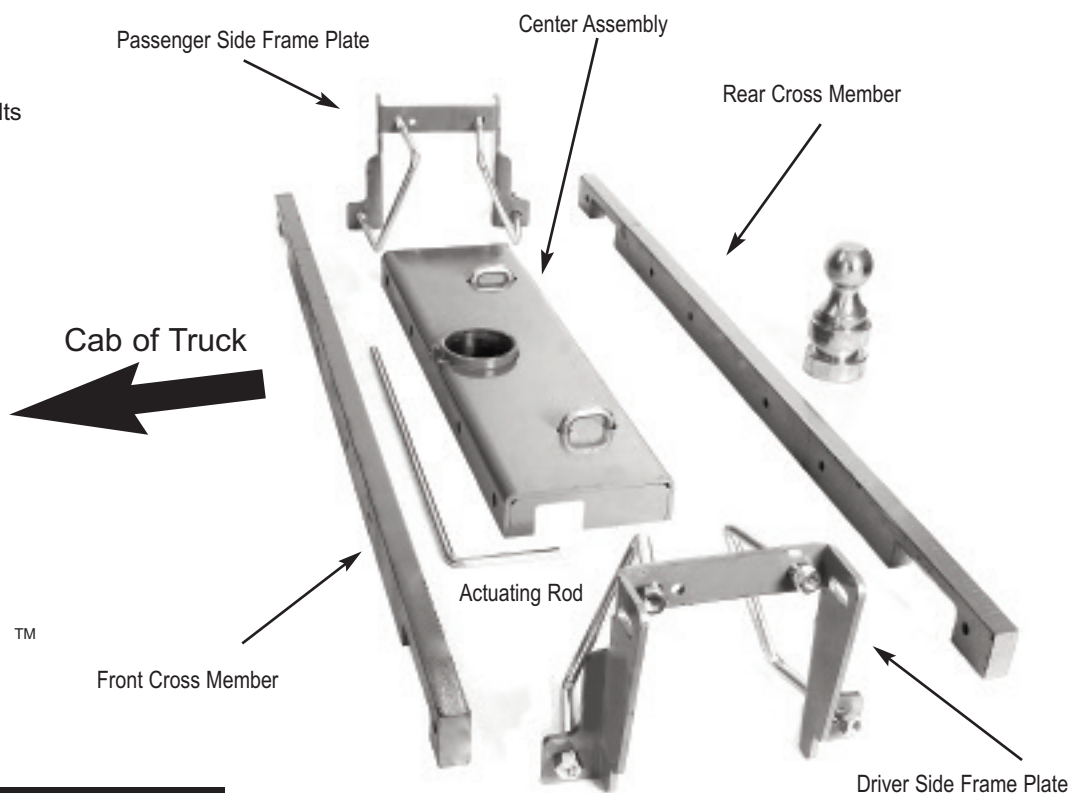
14. Please read the **SAFE TOWING INSTRUCTIONS** on the Flip-Over WARRANTY sheet.



Position Bars as shown to slide across frame. Note that front bar has end holes close to end of bar.

### HARDWARE PROVIDED

- 12 - 1/2" X 1-1/2" Grd. 8 Bolts
- 8 - 1/2" Lock Nuts
- 4 - 1/2" Flat Washers
- 4 - 4 1/2" U-Bolts
- 2 - U-Bolts w/springs and nuts



**Flip-Over**™

Model Number 239  
Gross Trailer Weight: 30M lbs.  
Gross Trailer Tongue Weight: 7.5M lbs.

Patent Pending