

Flip-Over™

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Installation Instructions

219R1 Dodge Ram 229R1 Mega Cab

Fits 2002-2008 1/2 Ton
Does not fit '09 1/2 Ton
Fits 2003-2009 3/4 & 1 Ton
Tubular Frame Long & Short Bed



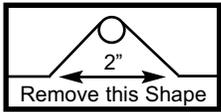
Us Patent No. 7,168,727

Model 219R1 and 229R1 03/09

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-Overhitch 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.

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 for **SHORT BED TRUCKS at 45"** or for **LONG BED TRUCKS at 47"** from the rear lip of the truck bed floor (tailgate end) centered between the wheel wells. Use a 3-1/2" hole saw to cut a hole in the bed floor centered at this location. Smooth hole edges with file after sawing. Clean all saw tailings from the bed area before proceeding.
2. If so equipped, cut and remove the tail pipe heat shield between the two truck bed cross members ahead of and rearward of the axle where the hitch will install.
3. Locate the bed sill that is forward of the hole for the ball. Measure back 4 1/2" on the bed lip and cut out a section as shown. This will allow the angles to be passed across the top of the frame and give clearance for the actuating rod.

4. Pass the Front Bar Cross Member (2) across the frame rails of the truck from the driver side with the 1/4" spacers on the bottom for 3/4 and 1 ton trucks or on the top for 1/2 ton trucks. Center the Front Bar Cross Member across the frame about three inches in front of the 3-1/2" hole.
5. Pass the Rear Angle Cross Member (1) across the frame rails similarly, with the plain side (2" leg) up and with the hole leg facing forward. **If installing a 219** position the Rear Angle Cross Member across the frame about 5" rearward of the 3-1/2" hole in the bed floor. For the **229** move the Rear Angle against the truck bed sill located behind the 3-1/2" hole in the bed floor.
6. With the actuating rod coupler facing the driver side of the truck, raise the Center Assembly (3) into position between the Cross Members, fitting the pressed bolts in the front Cross Member into the Center Assembly holes with the protruding tube in the channel web passing into the 3-1/2" hole. Use an overhead lifting device or a saw horse in the bed of the truck, and chain or rope to hold the Center Assembly firmly against the underside of the bed floor. Insure that the top of the Center Assembly channel is flush with the bottom of the bed floor.
7. Fasten the Center Assembly to the Front Cross Member with 1-1/4" bolts. Slide the Rear Cross Member forward and fasten it to the Center Assembly with 1-1/4" bolts with washers on the slotted holes and 1/2" nuts. Do not fully tighten these fittings at this time. Square the assembled Cross Members and Center Assembly across the frame from front to back and side to side.
8. Identify the driver side Frame Plate (pictured) and passenger side Frame Plate. Position the Frame Plate extension tabs between the Cross Members. **Remove the brake cable bracket if necessary.** Fasten the Front Cross Member to the Frame Plates using a flat washer and 1/2" nut on the bent tang of the Frame Plate. Fasten the Rear Cross Member by passing a 1-1/4" bolt with a flat washer from the Frame Plate and securing with a flat washer and 1/2" nut. *Do not fully tighten these fittings at this time.*

(over)

INSTALLATION PROCEDURE - CONTINUED

9. Square the hitch across the frame.

10. Secure the Frame Plates to the frame using one u-bolt and one 1/2" x 7" bolt. The 7" bolt goes thru the existing vertical hole in the frame from underneath with a flat washer against the bottom of the frame. **Note: There are four U-Bolts in the hardware kit. The two wide bolts are used for 3/4 and 1-Ton trucks and the narrower ones are for use in 1/2 ton trucks. See photo for proper placement of the U-Bolts.** **Caution:** Avoid brake and electrical lines when positioning U-Bolt against truck frame.

CAUTION: Use this sequence for tightening Frame Plate fasteners: 1. Snug the center section to the cross rails. 2. Snug the Cross rails to the side plates. 3. Snug the frame plate u-bolt and the 7" bolt. Using the same sequence, torque these fittings to **65 Foot Pounds. Use a Torque Wrench. Do not overtighten.**

11. If the brake cable bracket was removed from frame in Step 8, mount it using the sq. hole in the bottom of the Driver Side Frame Plate using the 5/16" lock nut.

12. From the driver side, pass the Actuating Rod through the 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. You may need to remove some of the lip above where the Actuating Rod installs to allow free travel.

13. Drill four 1/2" holes for the Safety Chain Brackets from under the truck bed. Drill through the two pairs of holes in the Center Assembly that are **farthest from the hitch ball**. 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.

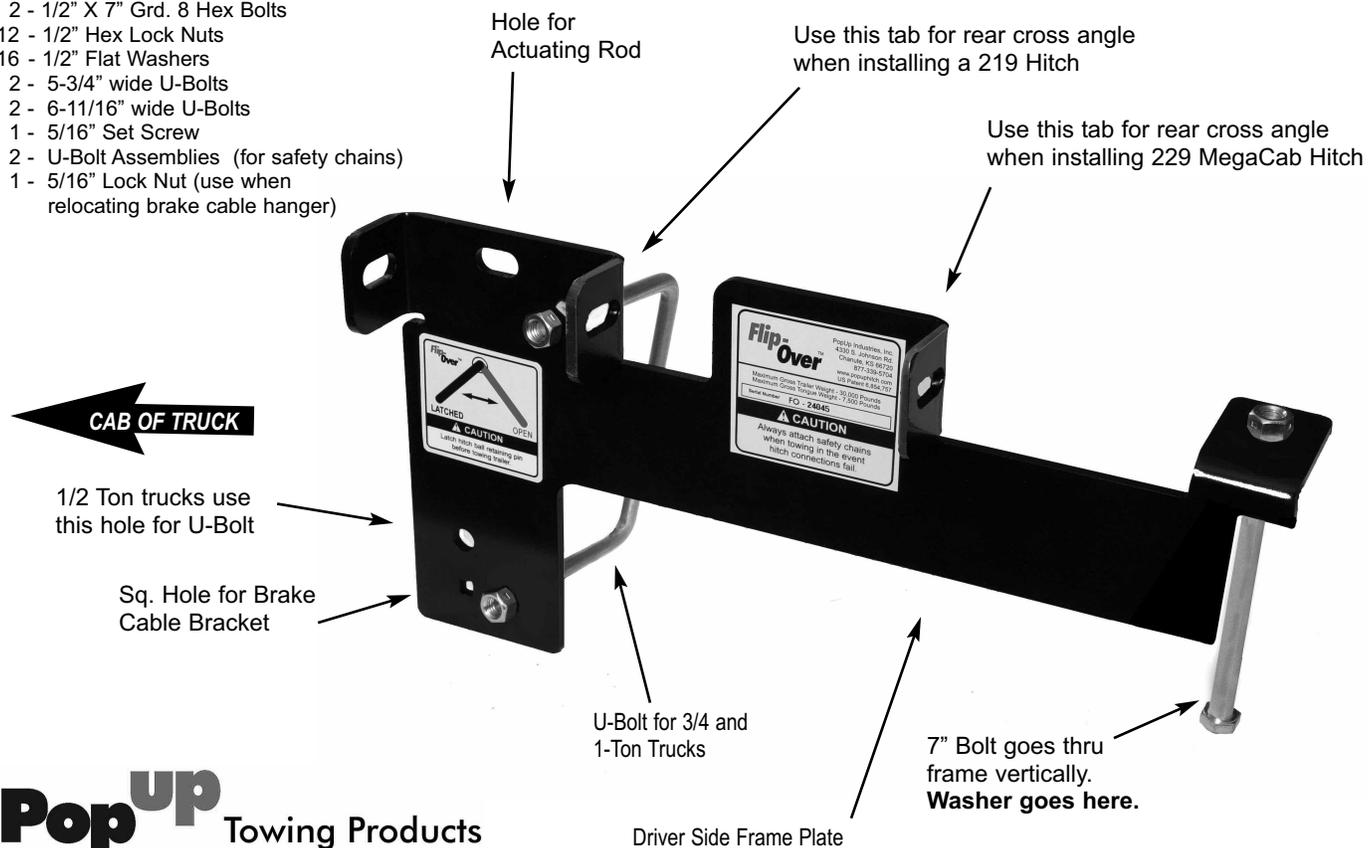
14. Retract the Retaining Pin by rotating the Actuating Rod 90 degrees counter clockwise. Place the Flip-Over ball in the Socket. Rotate the Actuating Rod 90 degrees clockwise to engage the Retaining Pin.

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

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

HARDWARE PROVIDED

- 12 - 1/2" X 1-1/4" Grd. 8 Hex Bolts
- 2 - 1/2" X 7" Grd. 8 Hex Bolts
- 12 - 1/2" Hex Lock Nuts
- 16 - 1/2" Flat Washers
- 2 - 5-3/4" wide U-Bolts
- 2 - 6-11/16" wide U-Bolts
- 1 - 5/16" Set Screw
- 2 - U-Bolt Assemblies (for safety chains)
- 1 - 5/16" Lock Nut (use when relocating brake cable hanger)



PopUp Towing Products
Mfg by: Young's Products, LLC



Model Number 219R1 and 229R1
Gross Trailer Weight: 30M lbs.
Gross Trailer Tongue Weight: 7.5M lbs.

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