

Flip-Over™

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Patent Pending

Installation Instructions

Model 200 Flat Bed Weld-In Hitch

For Use With 1/8" Thick
Steel Flat Bed Truck Decks



Model 200

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-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 and/or Welding.**

- 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

1. The Flat Bed Weld-In Hitch is designed for installation in trucks using 1/8" steel decks.
2. The center of the 3-1/2" deck hole the ball socket tube will fit into 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 Top Plate of the Flat Bed Hitch and for the Actuating Rod. Use a 3-1/2" saw and cut a hole centered at the location you have chosen for the socket tube. You may want to drill a 1/4" pilot hole first.
3. 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 and verify adequate clearance for the Flip-Over ball and for the Actuating Rod. If these clearances are acceptable, weld the 1/2" thick Top Plate to the underside of the steel deck. Additional bracing on both sides of the Flat Bed Hitch should be welded between the bed cross members or sills 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 freely and be certain it moves in and out freely.**
5. Affix adequate safety chain anchors to the deck. Never tow a trailer without securely attaching safety chains.
6. Retract the Retaining Pin by rotating the Actuating Rod 90 degrees counter clockwise. Place the Flip-Over ball in the Socket Tube. Rotate the Actuating Rod 90 degrees clockwise to engage the Retaining Pin.
7. Keep the base of the Flip-Over ball lightly lubricated with lithium grease.
8. Please read the **SAFE TOWING INSTRUCTIONS** on the Flip-Over WARRANTY sheet.

