

Flip-Over™

PopUp Industries, Inc.
4330 Johnson Rd., Chanute, KS 66720
800-837-8578
www.popuphitch.com info@popuphitch.com

Installation Instructions

Model 219C
Dodge RAM
DOES NOT FIT MEGA CAB TRUCKS
Fits 2002-2007 1/2 Ton
Fits 2003-2007 3/4 & 1 Ton
Tubular Frame Long & Short Bed



Model 219C 9-06 FOR THE SAFEST INSTALLATION

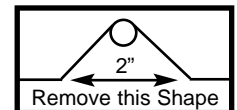
WARNING Most pick up trucks have **FUEL LINES** and/or **BRAKE LINES** and/or **ELECTRICAL WIRING** positioned along the truck frame rails where your Flip-Over hitch will install. **BEFORE INSTALLATION** identify and examine the location of fuel lines, brake lines and electrical wires. Be sure you will 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 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. Remove the spare tire. 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. In the driver side rear wheel well, locate the 7/16" hole over the axle on the lip formed where the bed floor and fender well are welded together. It is necessary to remove the lip below this hole to allow the cross members to be passed across the top of the frame rails. Cut the metal away under the hole as shown.
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 against the truck bed sill 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. Center the Rear Angle Cross Member across the frame about 5" rearward of 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 with the ball tube fitting 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 using washers and 1/2" X 1-1/2" bolts. Slide the Rear Cross Member forward and fasten it to the Center Assembly with 1/2" X 1-1/2" 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 to back and side to side.
8. Identify the driver side Frame Plate (4, with labels) and passenger side Frame Plate (5). Position the Frame Plate extension tabs between the Cross Members. Remove the brake cable bracket if required. Fasten to the Front Cross Member using a flat washer and 1/2" X 1-1/2" bolt on the bent tang of the Frame Plate. Fasten to the Rear Cross Member by passing a 1/2" X 1-1/2" 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.
9. Be certain the hitch is square across the frame front to back and side to side.



(over)

INSTALLATION PROCEDURE - CONTINUED

10. Secure the Frame Plates to the frame using Clamping Plates (7&8) and four 1/2" bolts and lock nuts. **Note:** Front and Rear Clamping Plates are different. *Rear Plates have one rounded corner.* Use the 1/2" X 4-1/2" carriage bolt for the Driver Side Frame Plate passed from outside the frame through the top forward square hole. Use 1/2" X 4-1/2" bolts passed through the Clamping Plates from inside the frame in the other holes. Use the lower holes for 3/4 and 1 ton trucks. Use the center holes for 1/2 ton trucks.

CAUTION: Carefully follow these instructions for tightening Frame Plate fasteners: It is important to ALTERNATELY tighten fasteners to draw the Clamping Plates evenly against the inside of the frame. Torque these fittings to precisely 55 Foot Pounds. **Use a Torque Wrench.**

11. Install a self-tapping 3/8" bolt into the frame through the center hole (9) of each frame plate. Use a letter "T" bit (11/32" can be substituted) to drill a hole in the frame after starting the hole using a 3/8" bit for centering. Torque the self-tapping bolt to 15 Foot Pounds. Mount removed Brake Cable Bracket with 5/16" carriage bolt and nut in square hole provided in Driver Side Frame Plate.

12. Torque all the fittings between the Cross Members and Center Assembly and Frame Plates to 65 Foot Pounds.

13. From the driver side, pass the Actuating Rod (6) through the 1/2" hole (NOT 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, and tighten to 7 foot pounds. Remove some of the lip above where the Actuating Rod installs to allow free travel.

14. 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.

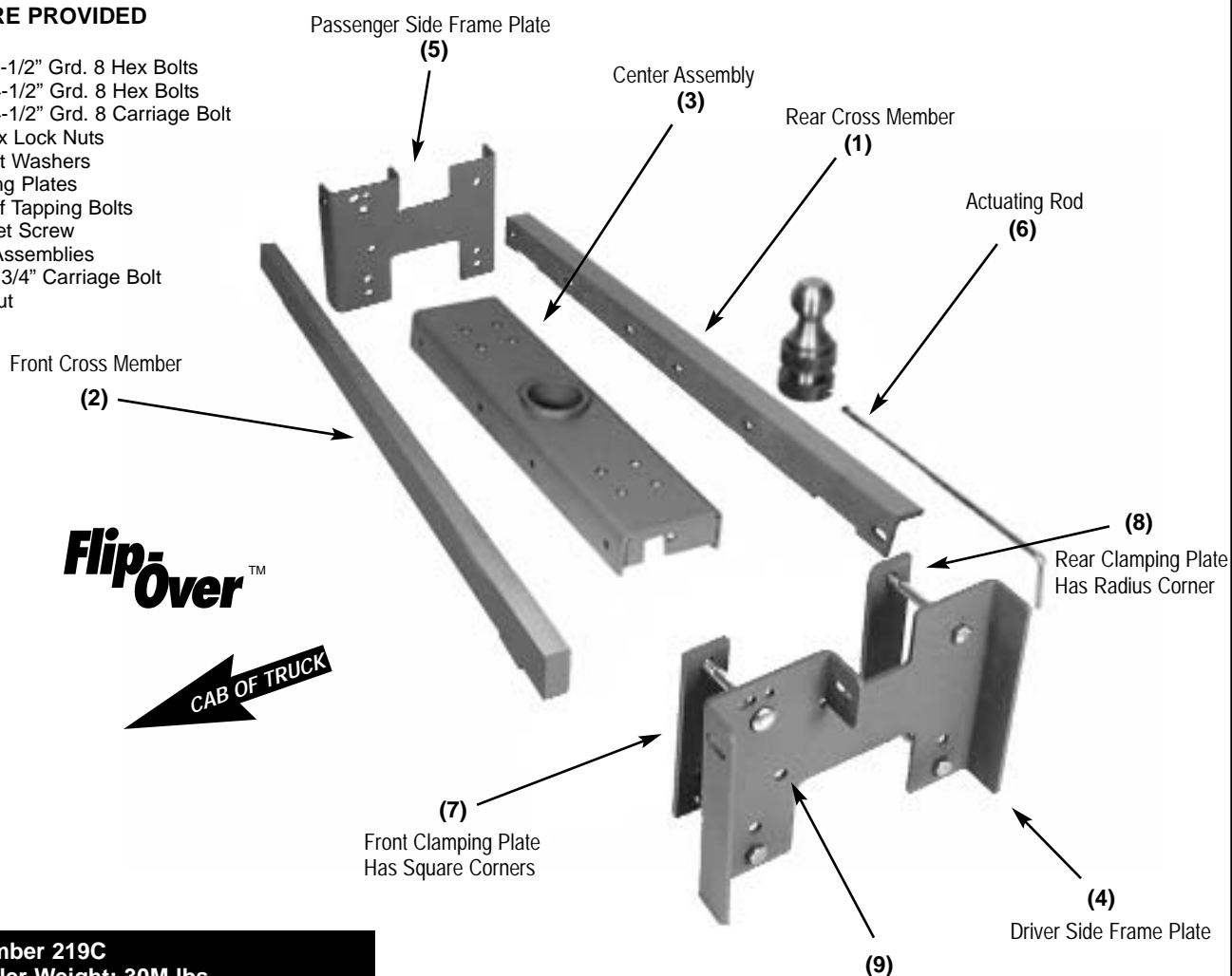
15. Retract the Retaining Pin by rotating the Actuating Rod 90 degrees counter clockwise. Place the Flip-Over ball in the Socket. Rotate the Actuating Rod 90 degrees clockwise to engage the Retaining Pin.

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

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

HARDWARE PROVIDED

- 12 - 1/2" X 1-1/2" Grd. 8 Hex Bolts
- 7 - 1/2" X 4-1/2" Grd. 8 Hex Bolts
- 1 - 1/2" X 4-1/2" Grd. 8 Carriage Bolt
- 20 - 1/2" Hex Lock Nuts
- 14 - 1/2" Flat Washers
- 4 - Clamping Plates
- 2 - 3/8" Self Tapping Bolts
- 1 - 5/16" Set Screw
- 2 - U-Bolt Assemblies
- 1 - 5/16" X 3/4" Carriage Bolt
- 1 - 5/16" Nut



Model Number 219C
Gross Trailer Weight: 30M lbs.
Gross Trailer Tongue Weight: 7.5M lbs.

Patent Pending