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Installation Instructions

Flip-Over Model 308 Ford Super Duty

Fits 2017-2020 (F250,F350,F450) (4WD Only)
(F450 works with factory bed only)



www.popuphitch.com

FOR THE SAFEST INSTALLATION

08/27/20

WARNING Most pick up trucks have **FUEL LINES** and/or **BRAKE LINES** and/or **ELECTRICAL WIRING** positioned along the truck framersails where your under-bed 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 under-bed gooseneck hitch.
- ALWAYS correctly chock tires prior to raising truck with jacking device. For protection 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 under-bed gooseneck hitch installation as specified in these Installation Instructions.
- **READ ALL SAFETY AND WARNINGS ON THE LAST PAGE OF THE PROVIDED INSTRUCTIONS.**

INSTALLATION PROCEDURE

WARNING: Verify adequate trailer swing clearance between trailer nose and cab of truck, and trailer and rear of truck. Its suggested to lay the entire hitch out as shown on pg 2 as to familiarize yourself with all the parts.

1. You may need to remove the spare tire and heat shield if equipped for extra space while installing. It's possible you may want to detach the exhaust mounts to allow more room when fitting hitch into place.
2. **Place hole in the truck bed at factory marked divot location.** From under the bed, drill a 1/4" pilot hole in the center of the factory-provided divot, in the center of the ball location. Once the pilot hole is drilled, a 3-1/2" diameter hole must be cut in this location. Using a 3-1/2" hole saw, proceed to cut the hole in the bed. Smooth the hole with a file and clean all saw tailings from the bed area before proceeding.
3. We recommend **installing the individual hitch parts in a specific sequence.** While placing one part after the other, install the necessary bolts as you go, leaving the bolts almost snug, yet loose enough that the parts can move around slightly. In the following sequence, go ahead and place parts **#1 - #6 and #8** into their given locations and loosely install the bolts (**Do not tighten bolts at this time**). **Note:** the driver and passenger mount angles use the 5/8" x 4" bolts, nuts and washers which pass through the frame of the truck.
4. With parts #1 through #6 in position, it is time to place the **#7** (center channel assembly) into position. **Note** the position of the rear mount brackets and the front mount brackets and how they fit to the center channel. Loosely install the center channel bolts. The rear bolts for the center channel assembly uses the (4) 1/2" x 1-1/4" hex bolts, washers and lock nuts. The front side of the center channel uses the (4) 1/2" x 1- 1/2" carriage bolts. **Note:** do not forget to place (part #8) the front center bolt plate before installing the carriage bolts.
5. At this time, all of the hitch hardware should be ready to tighten. **Tighten in this sequence: First:** tighten the (part #1) drivers SIDE mount angle to the truck frame. **Second:** tighten the (part #4) passenger SIDE mount angle to the frame. **Third:** tighten the (part # 2) drivers FRONT mount bracket to the (part #1) drivers SIDE mount angle. **Forth:** tighten the (part #5) passenger FRONT mount bracket to the (part #4) passenger SIDE mount angle. **Fifth:** tighten the (part #3) drivers REAR mount bracket to the (part #1) drivers SIDE mount angle. **Sixth:** tighten the (part #6) passenger REAR mount bracket to the (part #4) passenger SIDE mount angle. **Seventh:** tighten (part #7) center channel assembly to both passenger and driver side REAR mount brackets (part #'s 6 & 3). **Eighth:** tighten (part #7) center channel assembly to both driver and passenger FRONT mount brackets (part #'s 5 & 2). During this step make sure (part# 8) to secure the front center bolt plate to the front mounts.
6. Drill four 1/2" holes for the Safety Chain Brackets from under the truck bed. Drill through the four 9/16" holes in the Center Assembly through the truck bed floor. Remove all tailings before proceeding. 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" lock nut on each U-bolt leg. Tighten each nut until thread just extend through the nut.
7. Next attach the handle to the "Latch Arm" using the supplied 5/16" X 5/8" Clevis Pin and the 1-3/16" X 1/4" Cotter Hair Pin. See illustration on page 2 if needed.

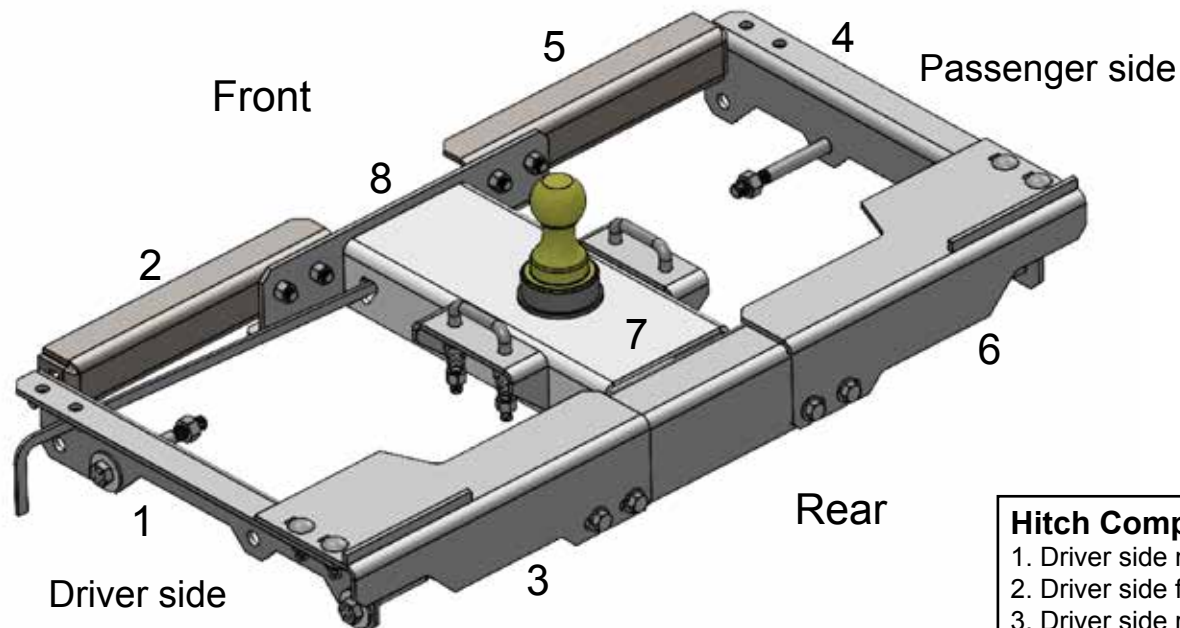
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INSTALLATION PROCEDURE- CONTINUED

8. You can now re-attach the exhaust to its mount and put the spare tire back in place.

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

10. Please read the **SAFE TOWING INSTRUCTIONS** on the WARRANTY sheet. Fill out and return warranty card to us, or go online to www.popuphitch.com and fill out the online version.



Hitch Components

1. Driver side mount angle
2. Driver side front mount bracket
3. Driver side rear mount bracket
4. Passenger side mount angle
5. Passenger side front mount bracket
6. Passenger side rear mount bracket
7. Center channel assembly
8. Front center bolt plate

Hardware Provided

- 6 - 1/2" x 1 1/4" hex bolts grd 8
- 18 - 1/2" lock nuts
- 10 - 1/2" flat washers
- 8 - 1/2" x 1 1/2" carriage bolts
- 4 - 5/8" x 4" hex bolts grd 8
- 4 - 5/8" flat washers
- 4 - 5/8" Hex nuts
- 1- 5/16" X 5/8" Clevis Pin
- 1- Cotter Hair Pin
- 2 - Safety chain u-bolts
- 4 - Safety chain springs

Torque Specifications:

- 1/2" Grd 8 Bolts - 80 ft. lbs.
- 5/8" Grd 8 bolts - 159 ft. lbs.
- 1/2" Carriage bolts - 57 ft. lbs.

Please call or email with questions.
Call us at 800-837-8578 or
email us at info@popuphitch.com

Model Number 308
Gross Trailer Weight: 30M lbs.
Gross Trailer Tongue Weight: 7.5M lbs.

**Flip-
Over**



READ ALL SAFETY AND WARNINGS BEFORE STARTING THE INSTALL

WARNING AND SAFETY INFORMATION, READ ENTIRELY BEFORE INSTALLATION.

Read all installation and operating instructions along with all labels before using this product.

PopUp Towing's under-bed hitches are standard with a 2-5/16" ball. Make sure the coupler on the trailer is designed for 2-5/16" ball. Using a larger size coupler could cause loss of attachment and cause serious injury.

Do not modify this product in any manner. Doing so could alter the integrity and proper use of the product causing serious damage or injury.

Do not exceed tow or tongue rating of coupler, tow or tongue rating of the hitch, or tow or weight ratings of the truck or trailer. See vehicle and trailer manufacturer information for proper ratings. Exceeding these ratings may cause damage to truck and/or trailer, or possible bodily injury.

Adding components such as a PopUp Towing under-bed gooseneck hitch to the chassis of any vehicle can be hazardous. There is potential for unexpected combustion of fuel, electric shock, burns, shifting or falling of unstable vehicle, damage to vehicle, injury from tool usage and many other hazards. This installation must be completed by someone who is aware of the hazards involved.

Always be sure the ball is properly latched into place while in the up or down position. Before hauling heavy loads make sure that your hitch will clear the truck's differential before hauling a load.

Cab clearance can be an issue with short bed trucks and limits towing on certain trailers. Failure to insure that there is adequate clearance before towing, may result in property damage, or serious injury.

IMPORTANT: The hitch is designed to install only at the location described in the included instructions. Failure to place the ball hole precisely may result in property damage or difficulty during installation.

Failure to follow the bolt tightening sequence and torque settings listed above may result in the hitch being misaligned which could affect the performance of the hitch, or result in property or bodily damage.

PopUp Towing Products assumes no responsibility for injury to self, or damage that may occur during installation. As always its best to have this product installed by an experienced installer.

NOTICE: Galvanic corrosion information, reference Ford SVE Bulletin Q-222R1 for attaching accessories to aluminum panels and structures. Found at www.fleet.ford.com/truckbbas