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## Installation Instructions

# Flip-Over Model 238 Chevrolet / GMC

Fits 2011 - 2016  
2500HD - 3500HD (2WD & 4WD)



[www.popuphitch.com](http://www.popuphitch.com)

FOR THE SAFEST INSTALLATION

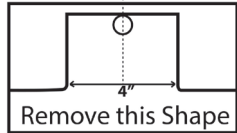
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**WARNING** Most pick up trucks have **FUEL LINES** and/or **BRAKE LINES** and/or **ELECTRICAL WIRING** positioned along the truck framerails where your under-bed hitch will install. **BEFORE INSTALLATION** identify and examine the location of fuel 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. READ spray in bed liner warning on last page.**

1. Mark and center punch a location from the rear lip of the truck bed centered between the wheel wells for the **specific** truck the hitch is being installed in, as stated here: **Center of hole: Short Bed Trucks 44-1/2" Long Bed Trucks (8' Bed) 49 1/4"** 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. Remove the spare tire if more room is needed. If using a vehicle hoist, raise the truck at this time. If using a jacking device, always 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. Cut away a portion of the aluminum heat shield where the hitch will install.
4. Locate the truck beds crossmember behind the hole for the ball. Cut and remove a notch in the fender lip as shown in the illustration (4" ahead of the truck bed crossmember on short bed trucks and 8 3/4" ahead on long bed trucks). Pass the **front angle cross member** over the frame through the notch with the plain side forward and with the hole side facing the rear of the truck. Center the cross member across the frame rails approximately 6" ahead of the 3-1/2" hole.
5. Pass the **rear cross member 1" X 2"** bar across the top of the frame rails. Using an adjustable wrench, turn the bar up. Notice the threaded holes are not in the centerline of the bar. Position the bar so the holes are nearest the bottom side. Center the cross member across the frame rails 3" behind the 3 1/2" hole.
6. Raise the center assembly into position under the truck bed with the protruding tube passing into the 3-1/2" hole. Use an overhead lifting device, or a saw horse in the bed of the truck, with a ratchet strap to hold the center assembly firmly against the underside of the bed floor. Do not pull it up so tight that it bows the truck bed.
7. Fasten the center assembly to the front and rear cross member using 1-1/4" bolts with flat washers on all oval holes. **Pull the slack out of the bolts but do not tighten at this time.** Square the assembled cross members and center assembly across the frame.
8. Fasten the frame plate tabs to the crossmembers using 1 1/4" bolts with flat washers and lock nuts. **Pull the slack out of the bolts, but do not tighten at this time.**

## INSTALLATION PROCEDURE- CONTINUED

9. Secure the Frame Plates to the frame using one u-bolt and one 7" bolt. The 7" bolt goes thru the existing vertical hole in the frame from underneath with a 1/2" and 3/4" washer. Position the 3/4" washer against the bottom of the frame.

Pass the 5-1/4" wide u-bolt from inside the truck frame thru the round holes in the frame plate above and below the truck frame. **Pull out the slack using flat washers and lock nuts. CAUTION:** Be certain that the drivers side frame plate u-bolt is under the wire harness.

**10. IMPORTANT: Tighten the bolts in the following sequence. First tighten the bolts holding the center section to the cross bar and angle. Important: Next, release the center section from the overhead lifting device. Check to assure that the cross angle and bar are resting securely on the frame.** Next tighten the frame plates to the frame, then cross members to the frame plates, **Follow the torque guidelines listed below.**

11. 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 **nearest to 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 just does extend through the 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 torque specifications.** Be certain the Actuating Rod rotates and moves in and out freely.

13. 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.

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

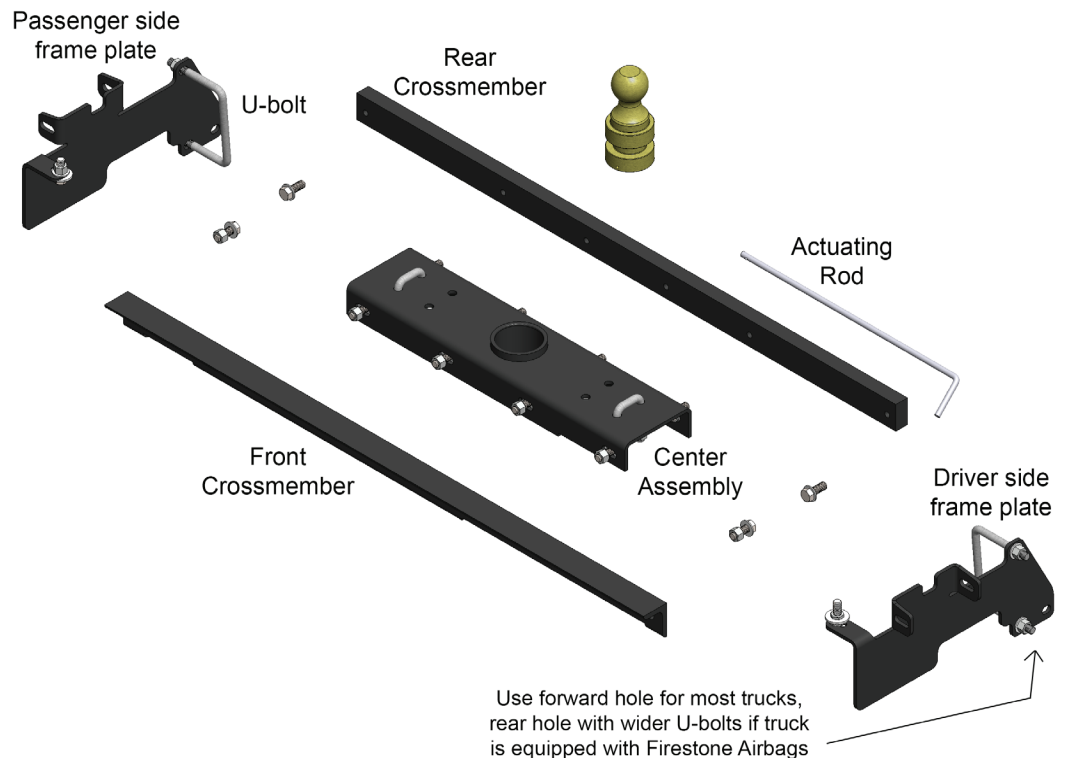
15. Please read the **SAFE TOWING INSTRUCTIONS** on the WARRANTY sheet. Fill out and return warranty card to us, or go online to [www.popuphitch.com](http://www.popuphitch.com) and fill out the online version.

### Torque Specifications:

1/2" Gr 8 Bolts - 119 ft. lbs  
1/2" Gr 5 Bolts - 78 ft. lbs  
Actuating rod set screw - 15 ft. lbs.  
Frame plate U-Bolts - Tighten until the tabs bend in **slightly.**

### Hardware Provided

12 - 1/2" X 1-1/4" Gr 8 Bolts  
2 - 1/2" X 7" Gr 5 Bolts  
16 - 1/2" Lock Nuts  
20 - 1/2" Flat Washers  
2 - 3/4" Flat washers  
2 - 5-1/4" U-Bolts  
2 - 5 13/16" U-Bolts  
2 - 2" Safety Chain U-Bolts  
4 - Springs for U-Bolts



Please call or email with questions.  
Call us at 800-837-8578 or  
email us at [info@popuphitch.com](mailto:info@popuphitch.com)

Model Number 238  
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.

**CAUTION:** If your truck is equipped with a spray in bed liner that covers the rear lip of the truck bed, make sure and add the thickness of the bed liner to the hole location measurement before drilling the hole.