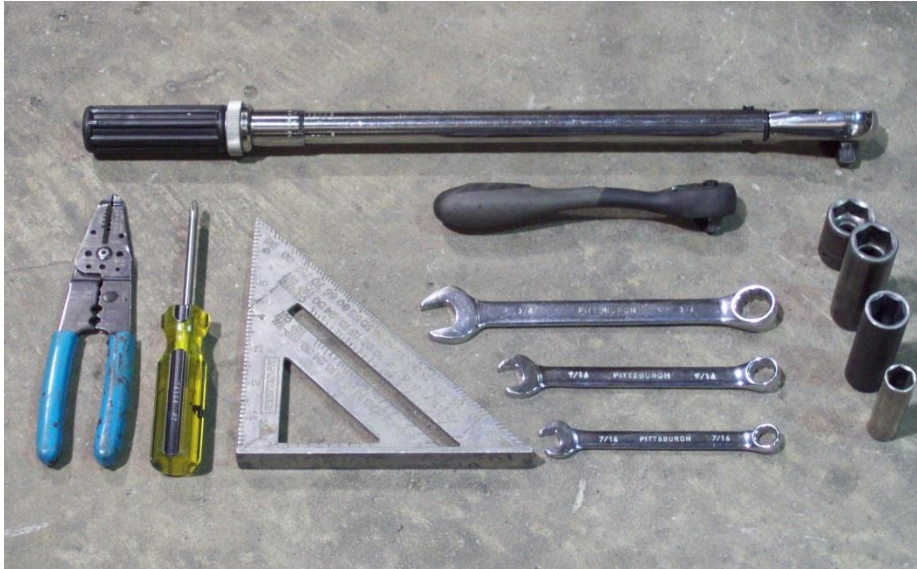


SUT-1000CLC



Torque wrench, carpenters square, wire cutters, Phillips screwdriver, 7/16, 9/16, and 3/4" combination wrenches, ratchet, 9/16, 3/4, 13/16", and 7/8" sockets.

ASSEMBLY REQUIREMENTS

***Torque all T-bolt nuts to 35 foot pounds.**

***Check all lights before towing.**

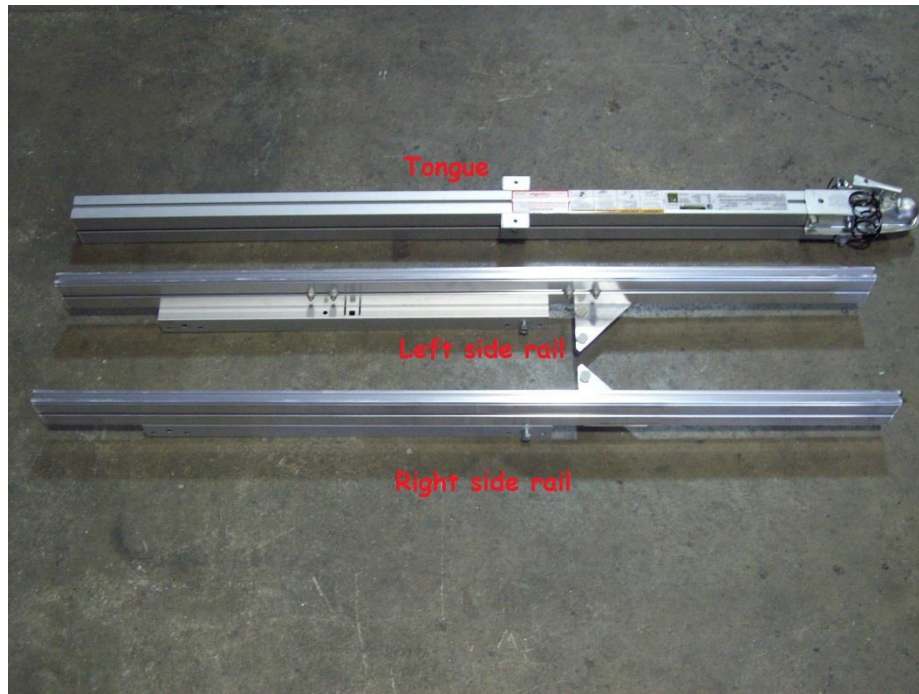
***Tire pressure not to exceed recommendation on serial tag.**

***Re-torque wheel nuts after first 25 miles to 80 ft. pounds and periodically thereafter.**

Failure to follow the assembly instructions could result in serious injury or death.

Incorrect assembly or modifications to your trailer will void any specific or implied warranty.

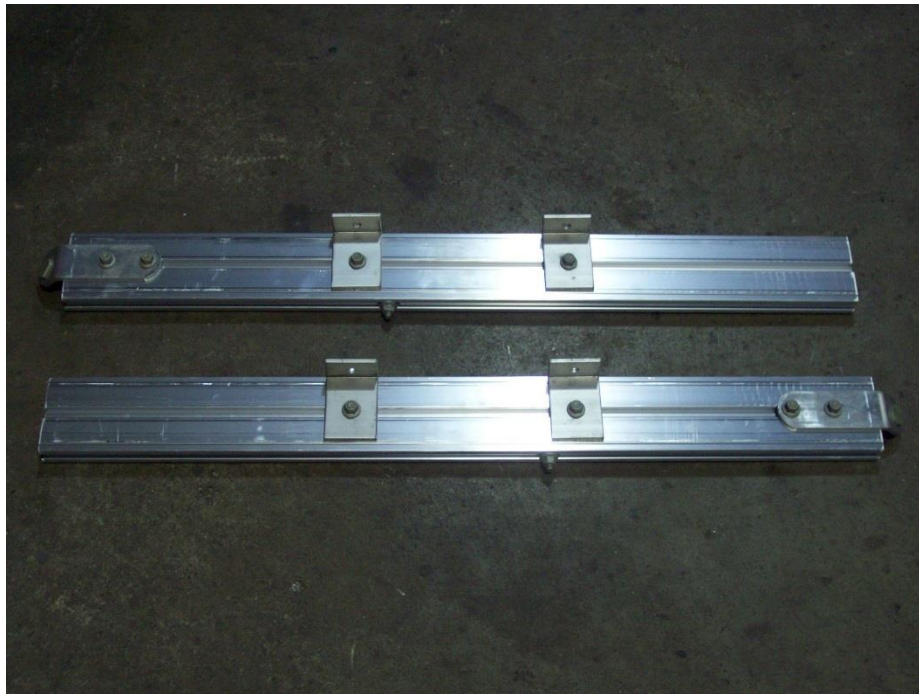
For questions or assistance assembling your trailer call 800-282-5042.



Tongue and side rails



Cross members



Front diagonals



Park jack, park jack hardware, fender hardware, corner plates, apex plate, wiring harness, tail light brackets, and light kit.



Axle, tires, springs, hardware and fenders.



Stringers



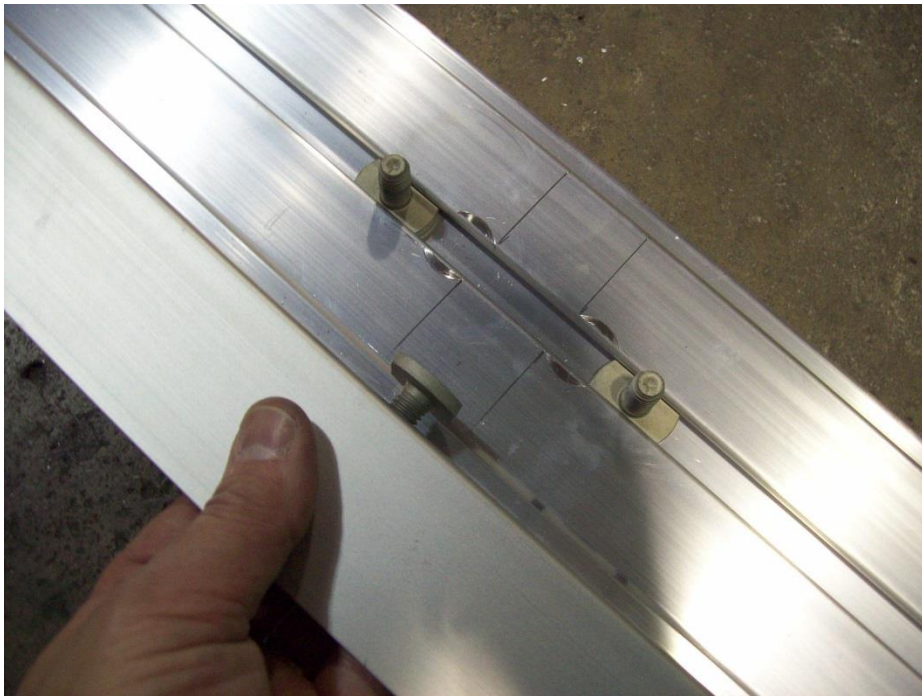
Locate the left side rail and one of the cross members



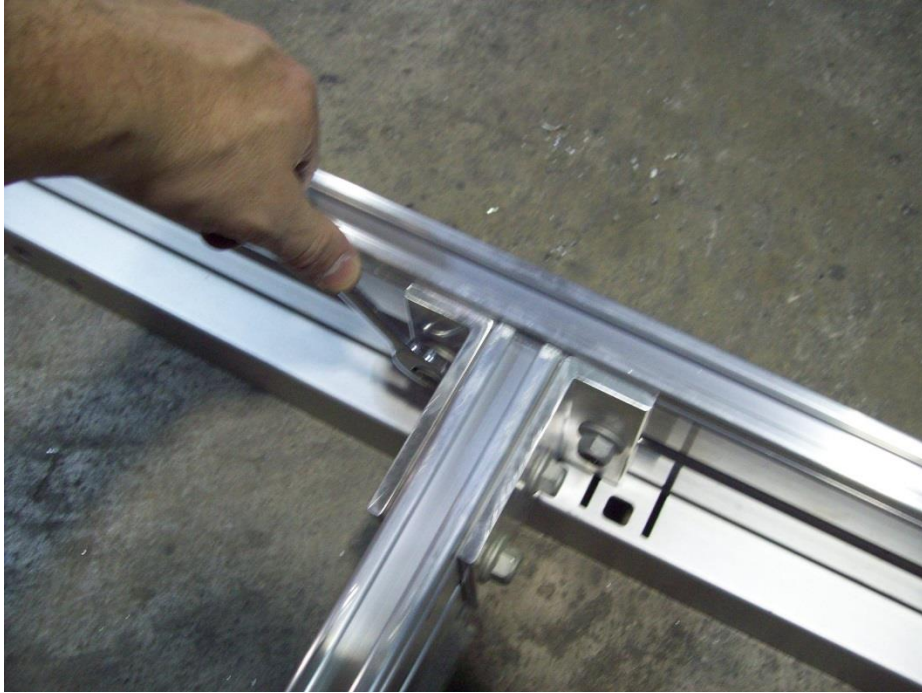
Remove the nut on the underside of the cross member.



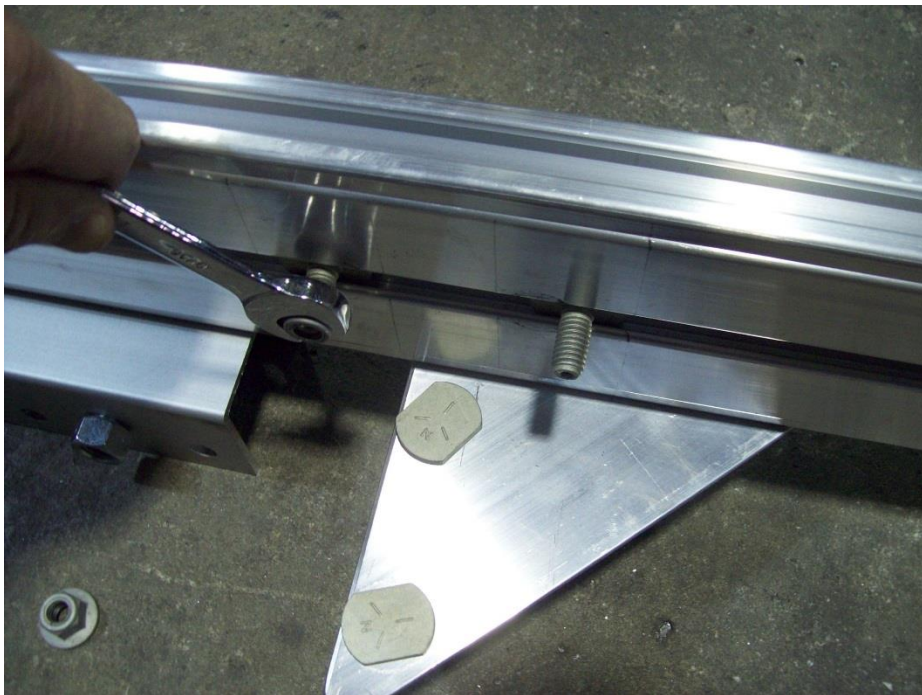
Remove the two nuts above the sub rail clip.



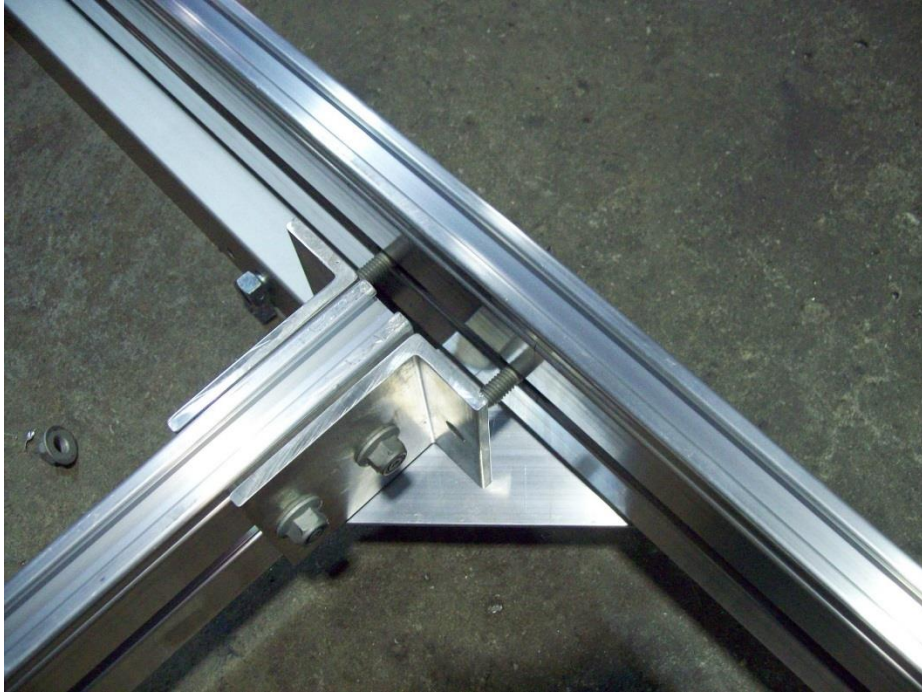
Install the T-bolt and nut that was removed from the underside of the cross member and install it in the sub rail clip.



Align the cross member with the pencil marks on the side rail. Insert the cross member into the T-bolts and install nuts and tighten. The nut on the underside will be tightened later.



Go towards the next mounting point, on the front side rail, and remove the nuts.

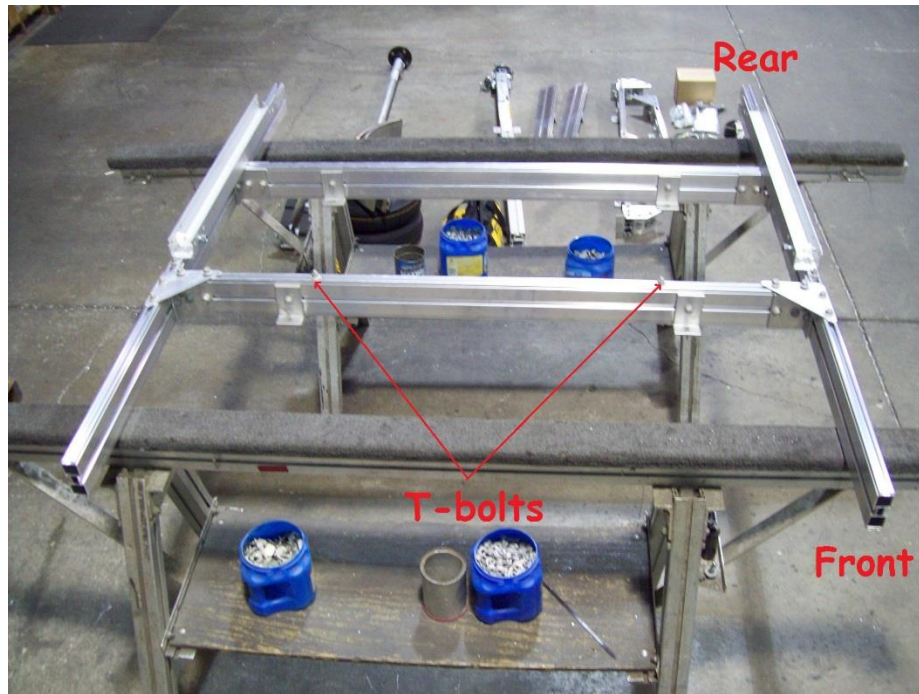


Align the cross member with the pencil marks on the side rail. Insert the cross member into the T-bolts and install nuts and tighten. The nut on the underside will be tightened later.



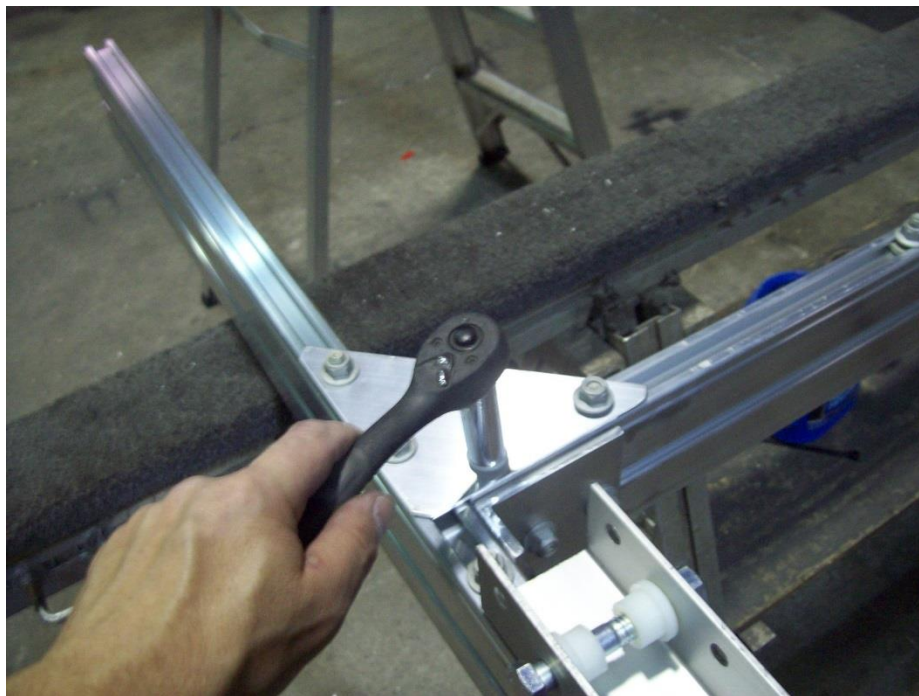
Shown up right

At this point install the right side rail into the cross members using the same process as the left side, previously described.

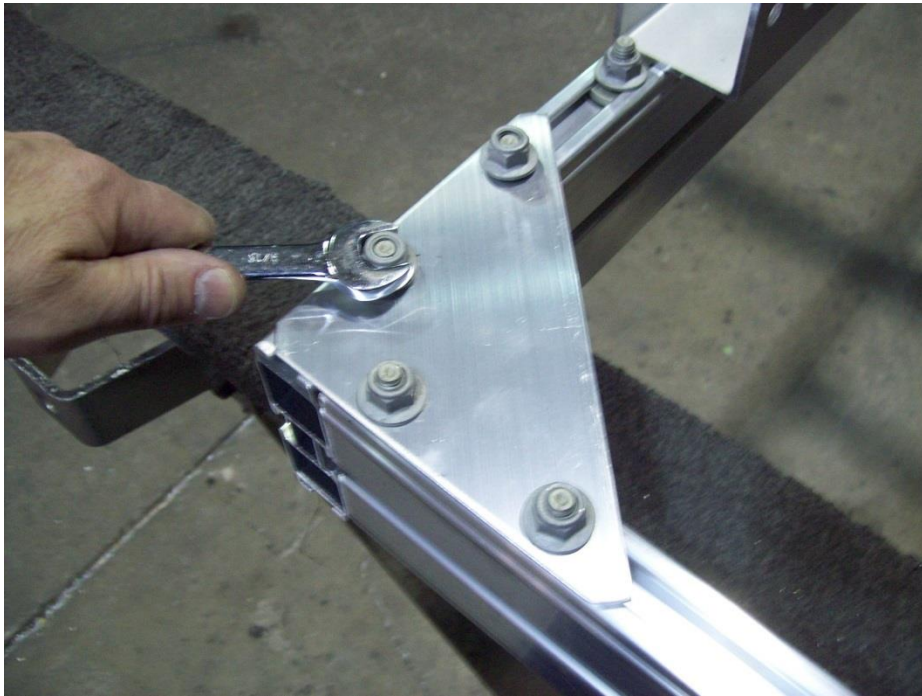
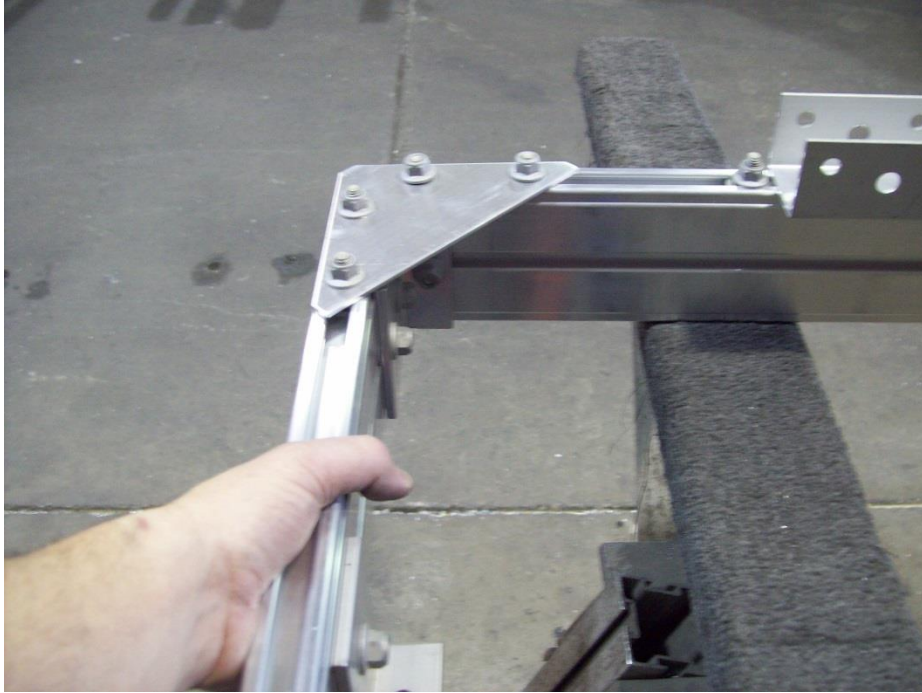


Upside down

Flip the trailer frame upside down. Make sure that the front cross member has two T-bolts on the underside as shown. These will be used later.



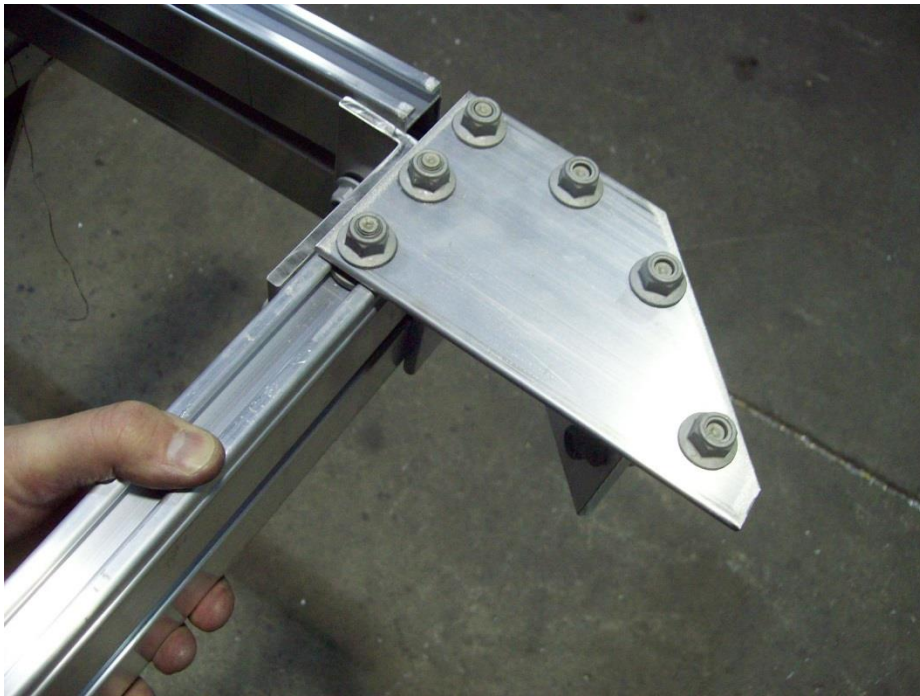
Go through and tighten all nuts that are loose on each cross member.



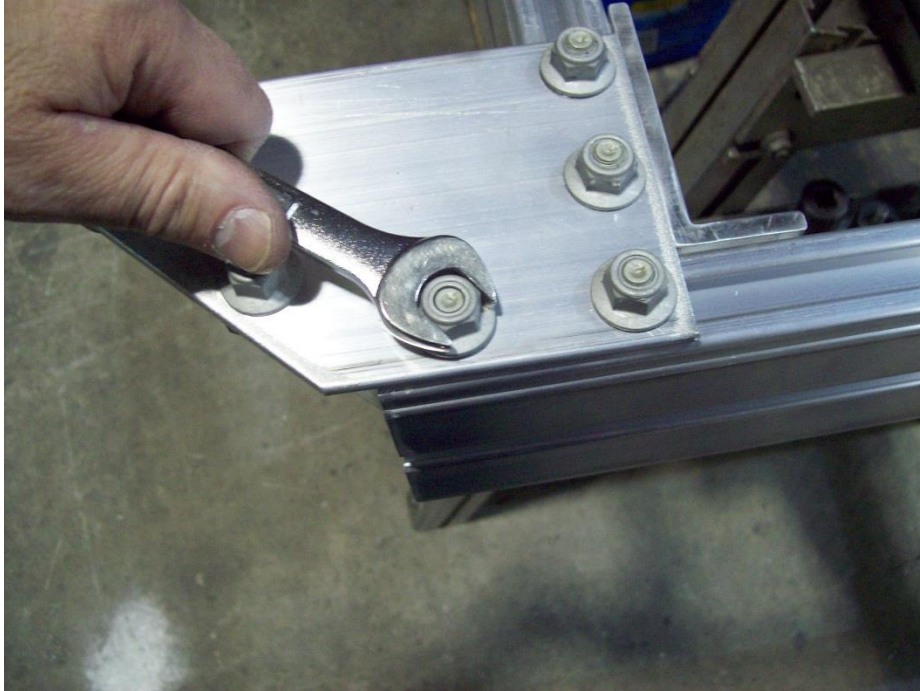
Insert the rear cross member into each side of the side rails. Once aligned with the ends of the side rails, tighten nuts.



Make sure to tighten the nuts on the inside also.



Locate the front cross member then slide it into the side rails.



Once in position tighten all nuts.



Insert the diagonals into the brackets as shown. Make sure when installing the diagonals, the mounting brackets are facing down.



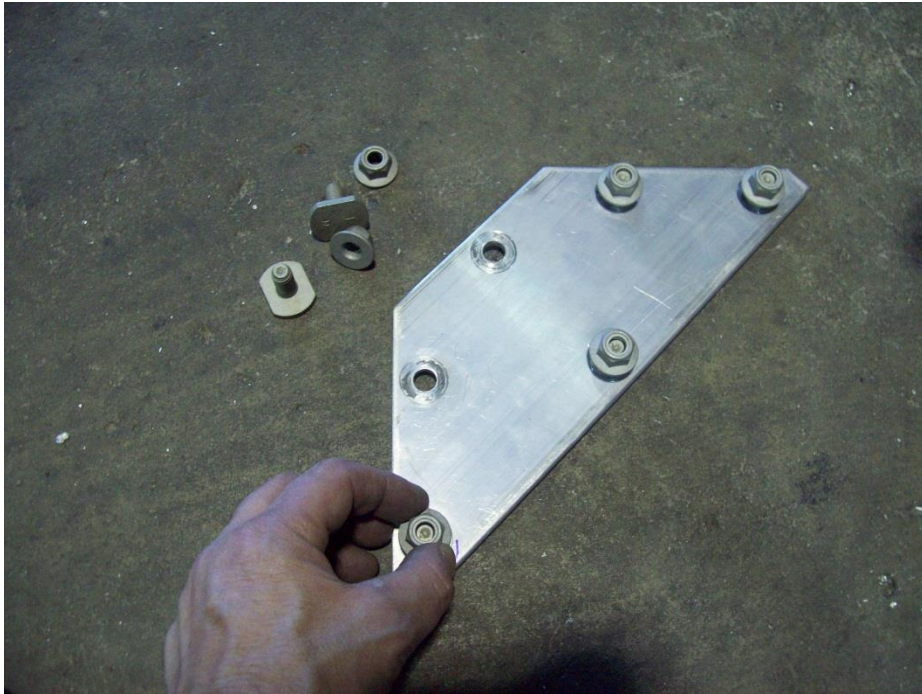
At this point the trailer should look like this.



Locate the tongue and insert into the brackets at the end of the diagonals.



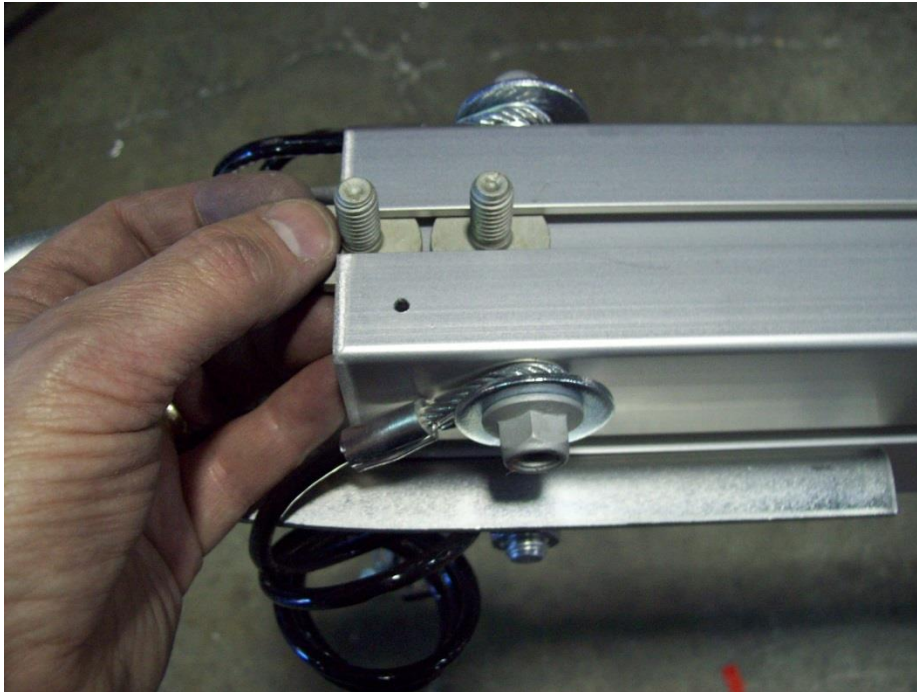
Once tongue is in position tighten nuts.
Remember, Trailer is still in upside down position.



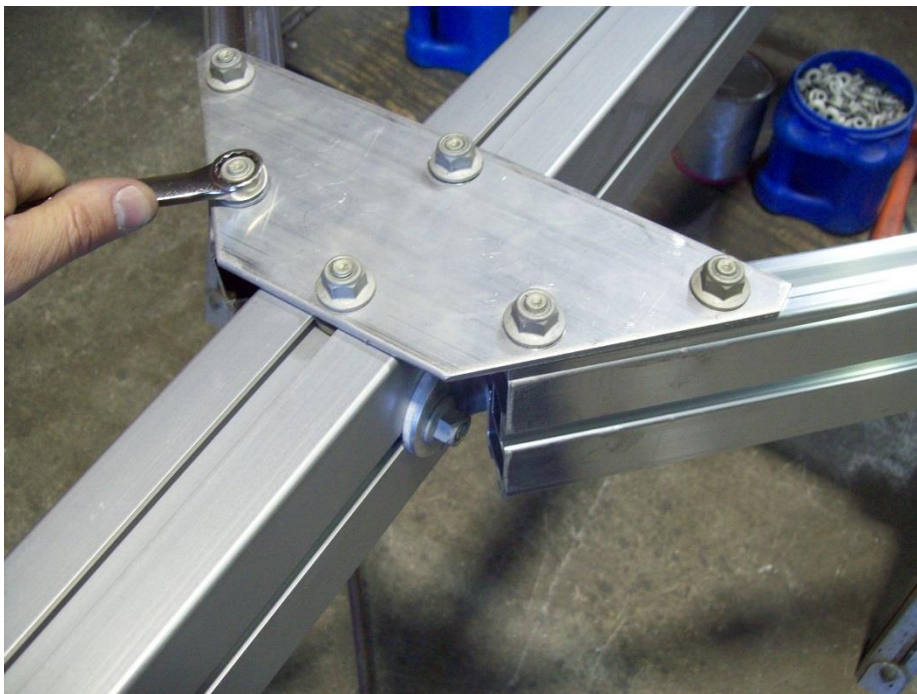
Locate the apex plate and remove the T-bolts and nuts from it.



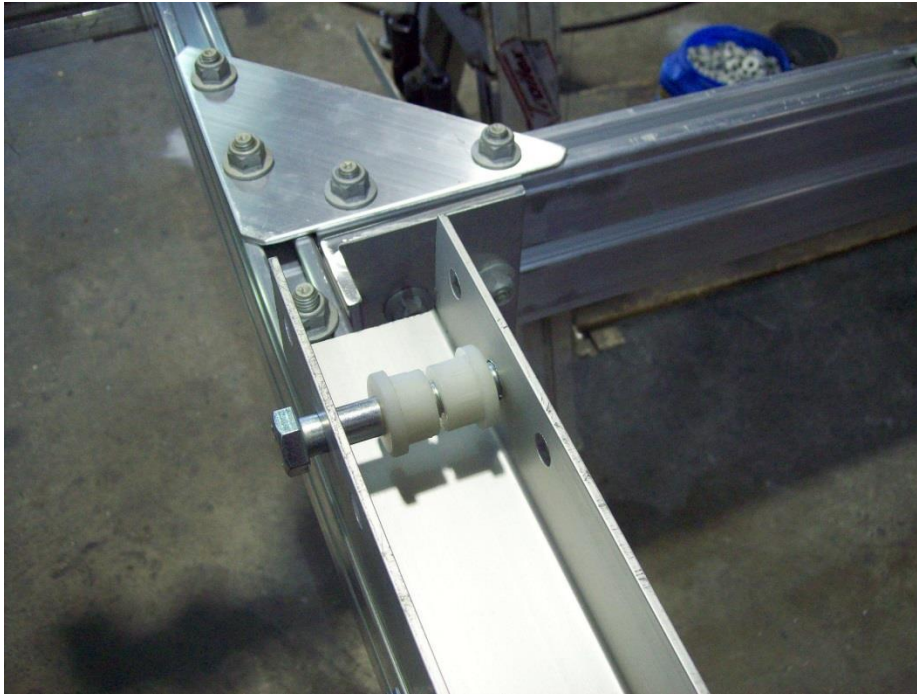
Take four of the T-bolts and insert two of them into each side of the diagonal.



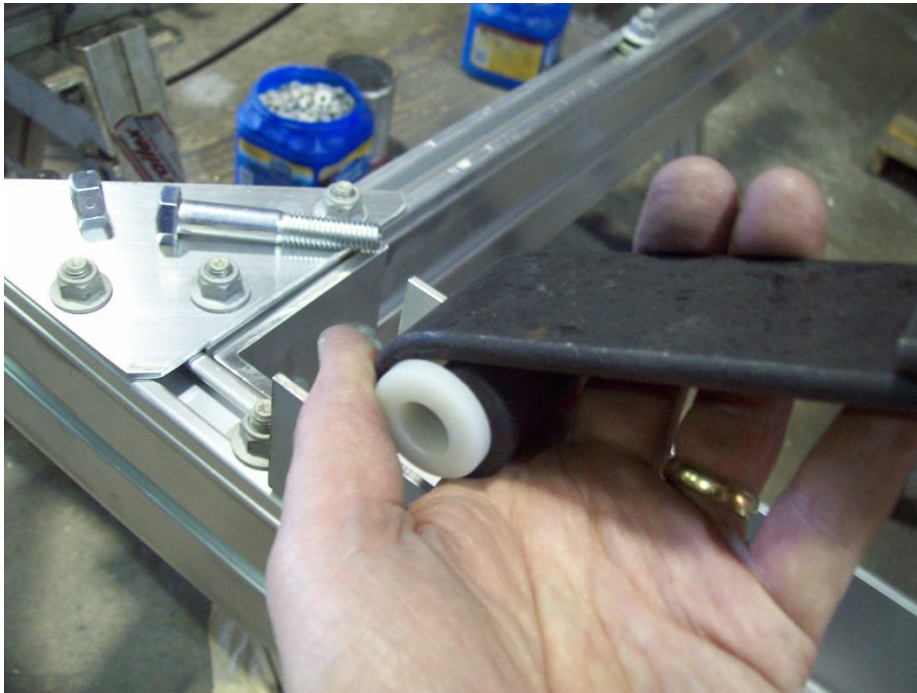
Insert the last two T-bolts into the underside of the tongue section.



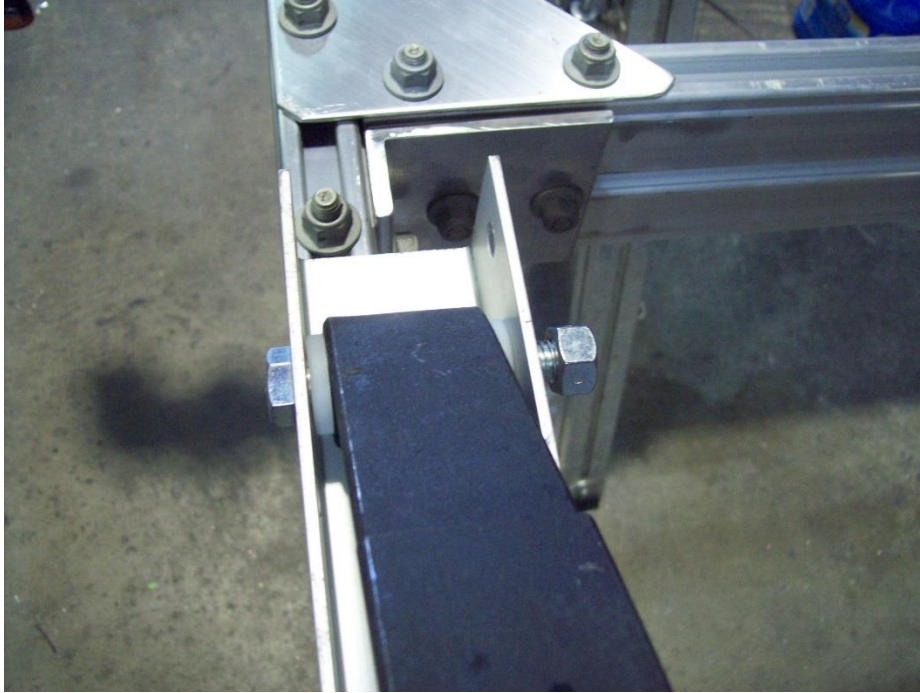
Install the apex plate over top of the T-bolts.



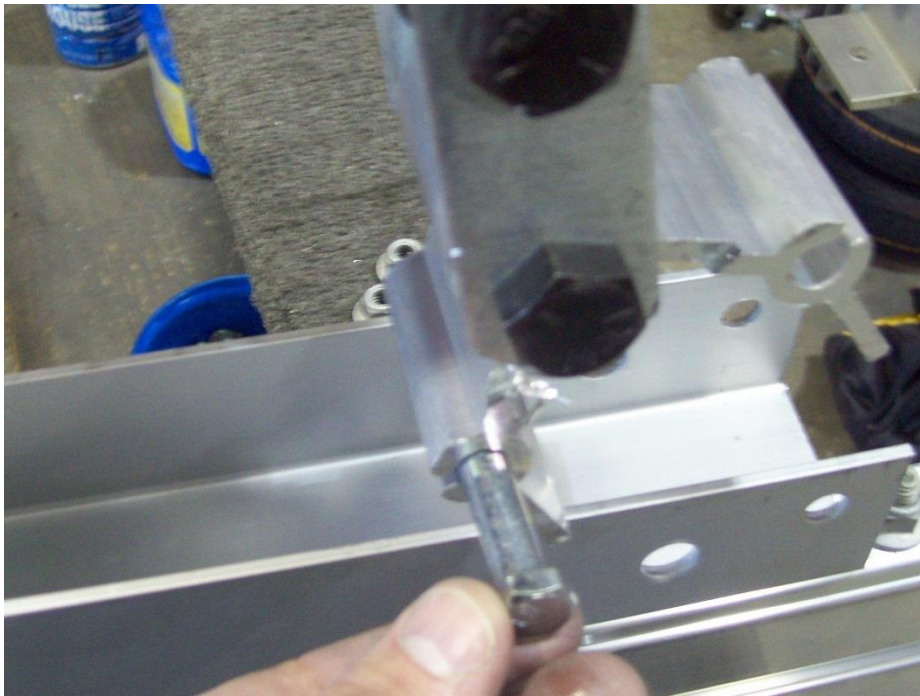
At the front of the sub rail clip you'll find a bolt, bushing and nut to mount the spring. Remove the parts from the sub rail clip.



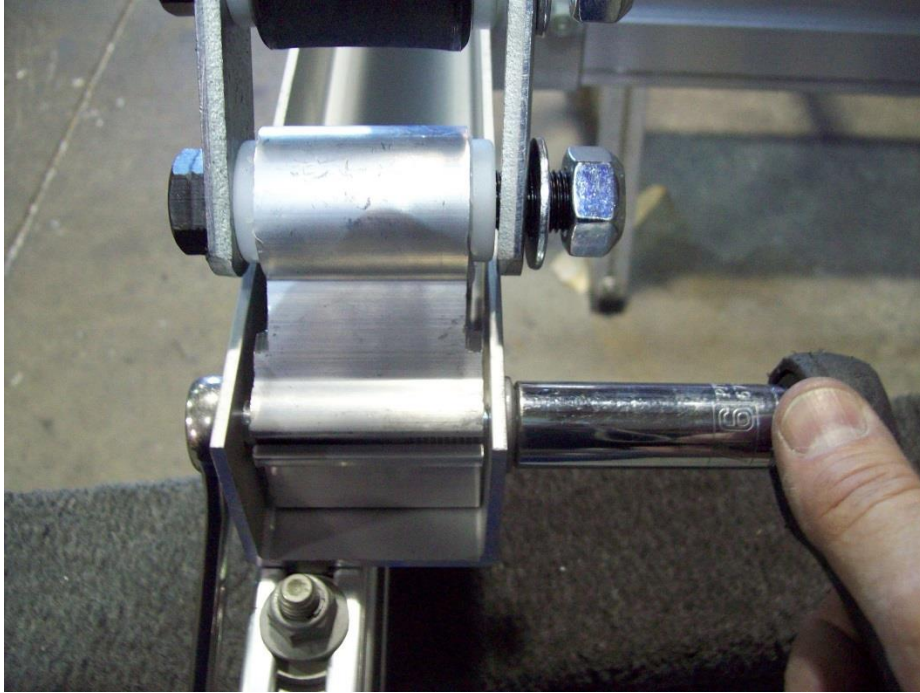
Install bushing on each side of the front spring.



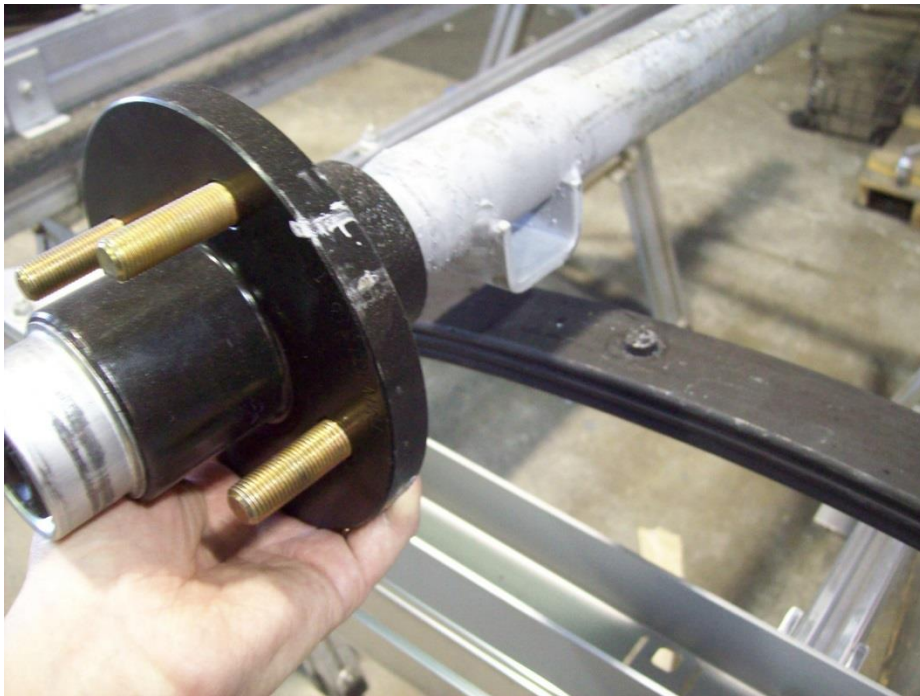
Insert bolt back through the spring and install nut. Do not tighten yet.



Remove bolts and nuts from the spring hanger. Lower hanger down into sub rail clip and reinstall bolts and nuts.



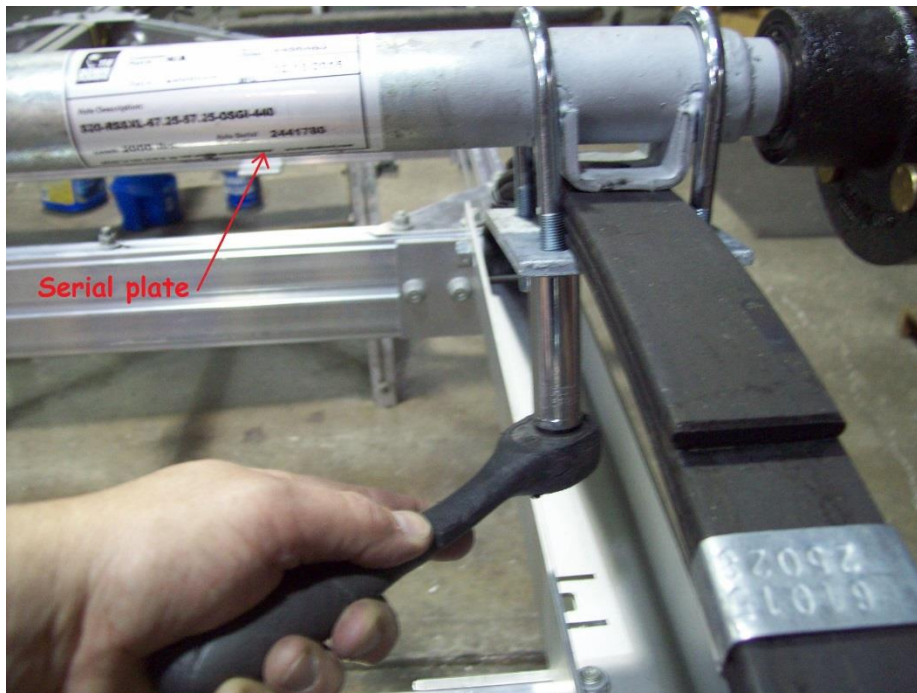
Once the hanger is in position tighten nuts. *Do not torque these bolts.*



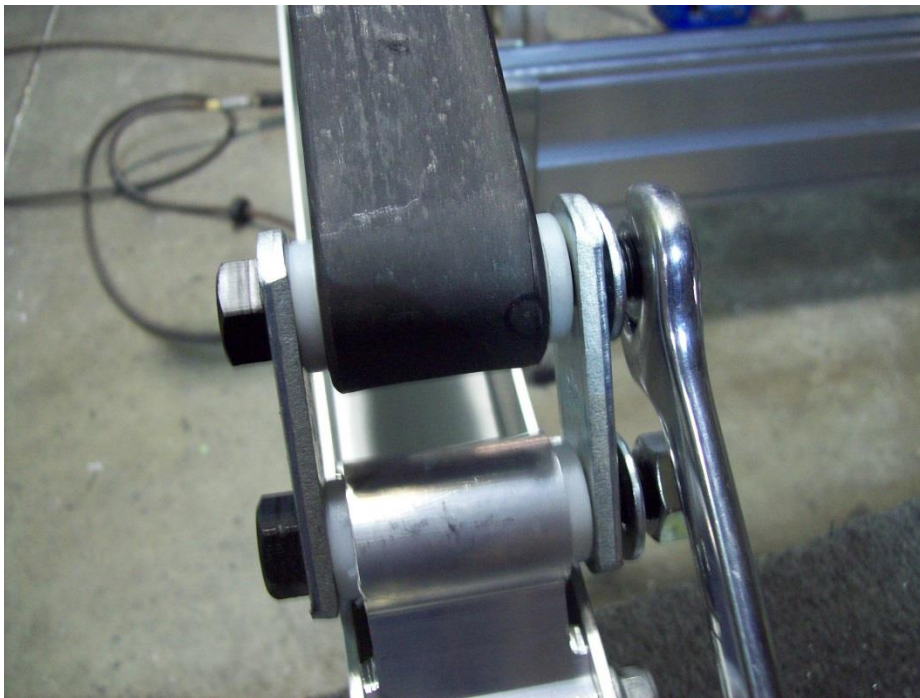
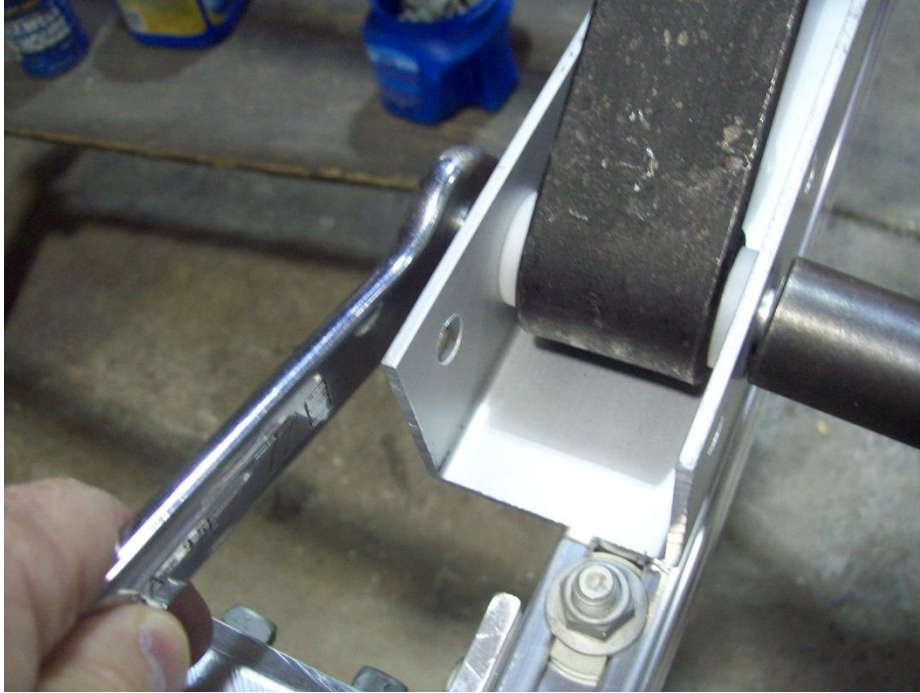
Take the axle and lay it over top of the locating pins on the springs.



Install U-bolts over top of the axle as shown.



Insert the U-bolts through the tie plate and install nuts and tighten evenly. Do not torque nuts. Face the axle's serial plate toward the rear of the trailer to protect it from debris.



Now go back and tighten the front spring bolt and the shackle bolts.
Do not torque nuts.



Locate the harness for the trailer and one small ring terminal. Strip white ground wire and install ring terminal.



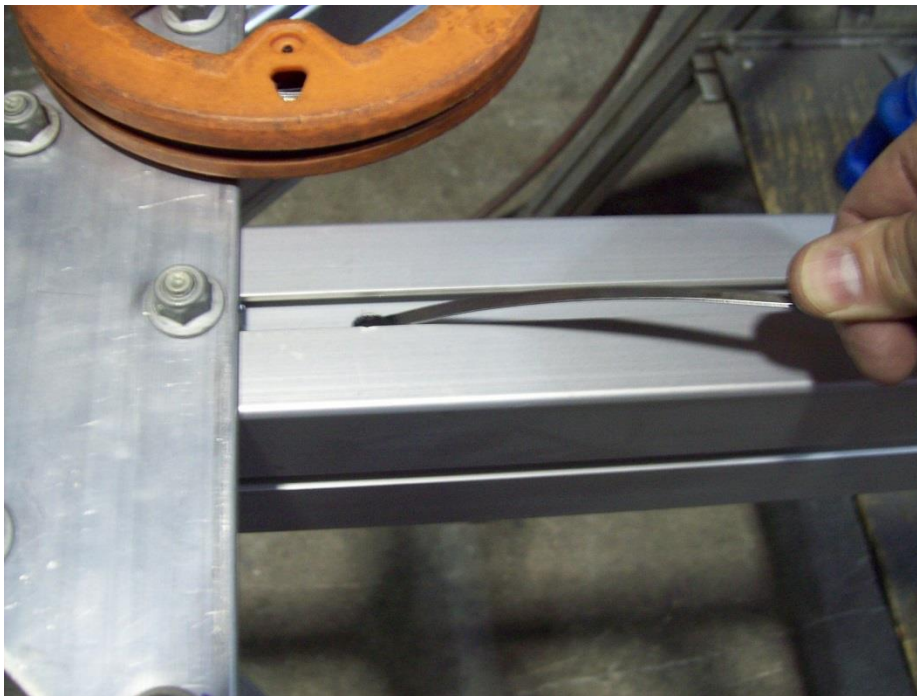
Install Phillips screw through the ring terminal into the pre-drilled hole located under the tongue just behind the coupler.



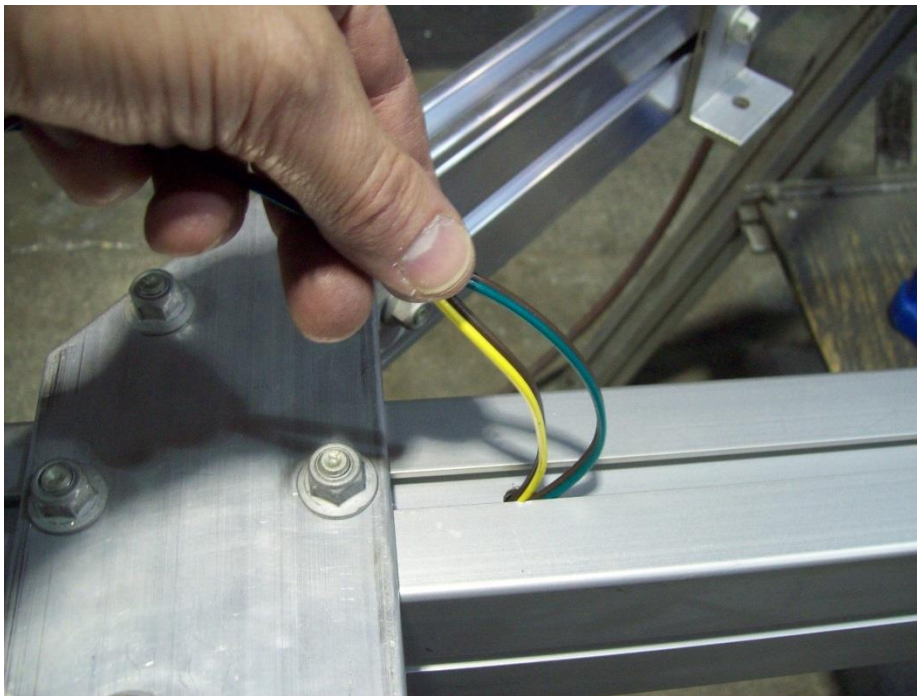
With electrical tape start at the four prong connector, keeping the harness tight and tape the wires together. Space the tape about the width of four fingers apart.



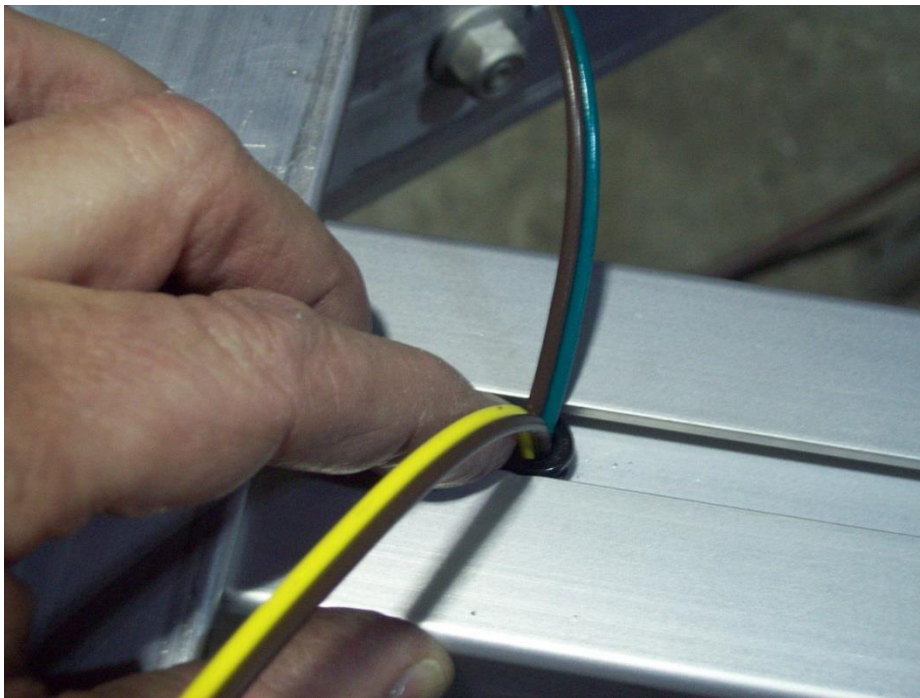
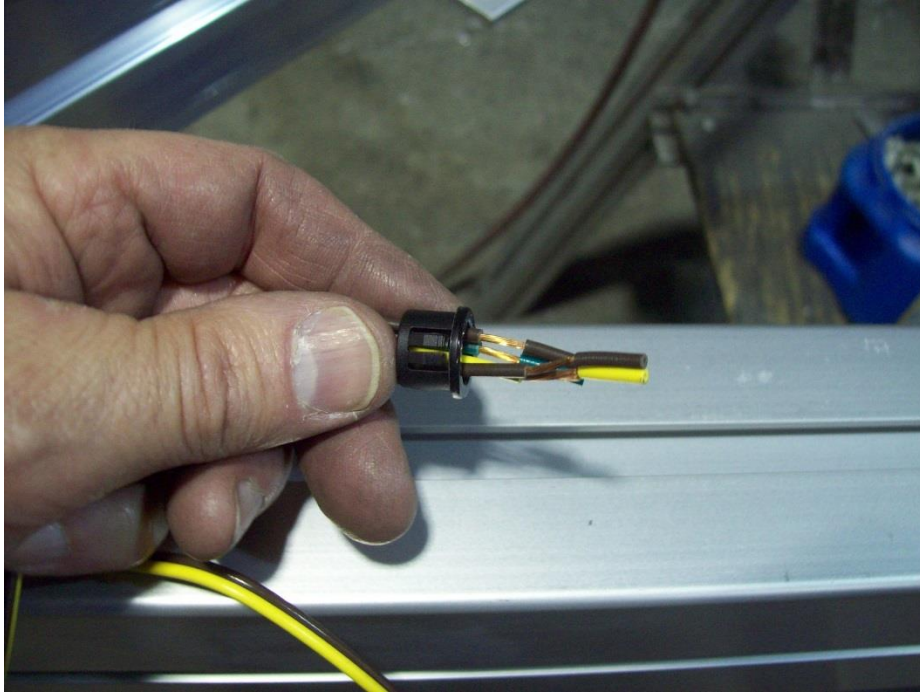
Tape the harness right up to the coupler and stop there. Your wiring harness should look like this when finished.



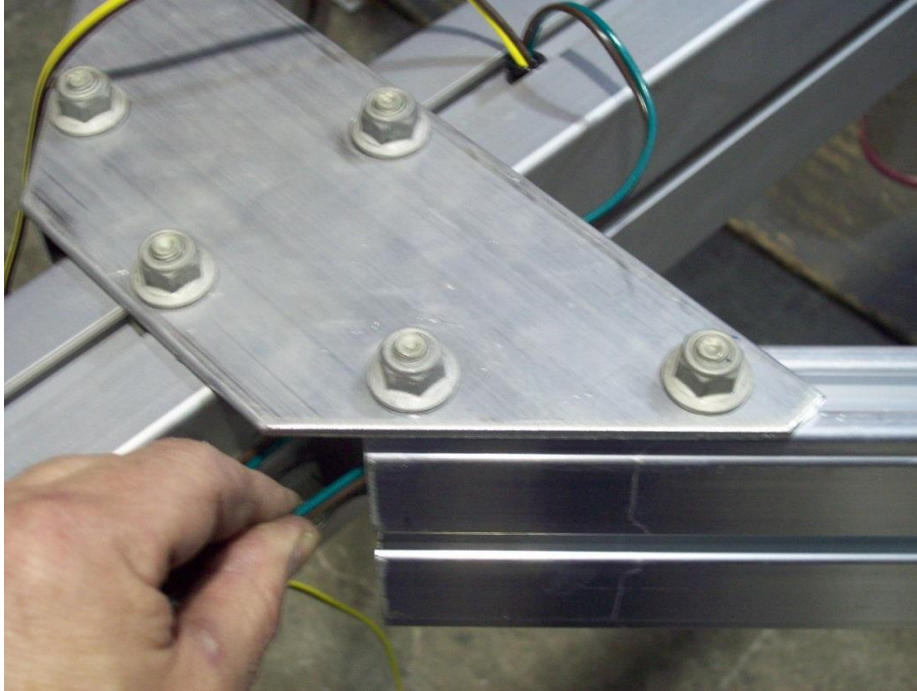
Locate the hole on the underside of the tongue behind the apex plate. Insert either a snake or sturdy wire to the front of the tongue section to attach the harness too.



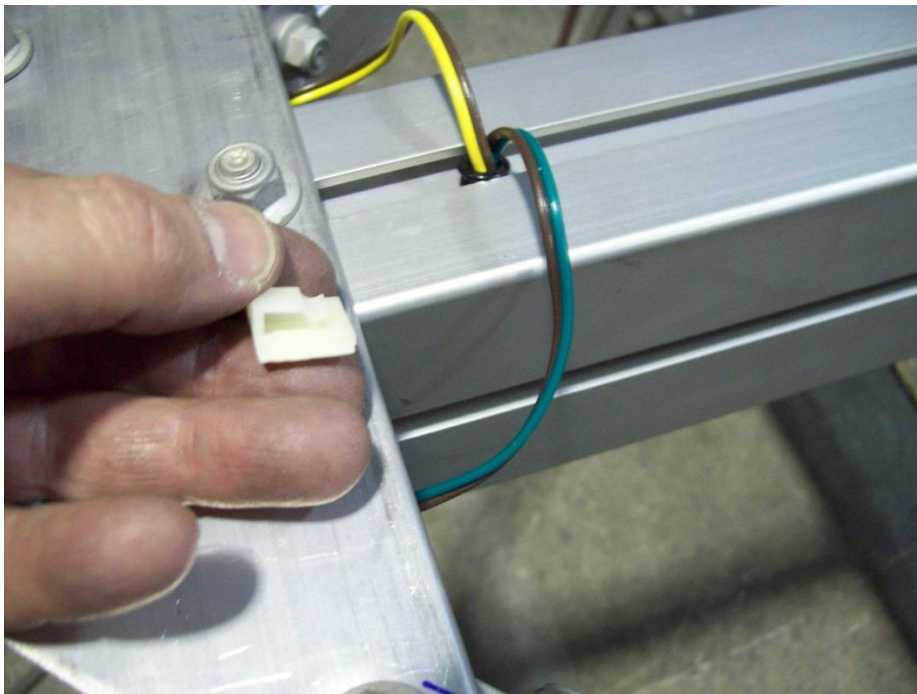
Tape wiring harness to the snake or wire and pull it back to the hole.
Carefully pull the harness through the hole.



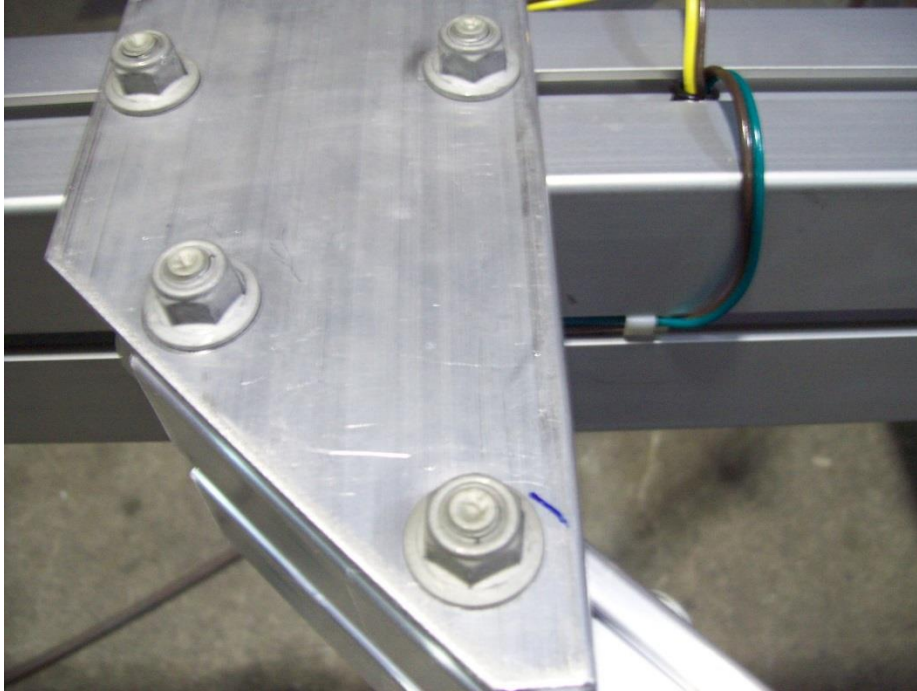
Insert harness through barrel clips and pull through. Once barrel clip is at the hole in the tongue push it into place.



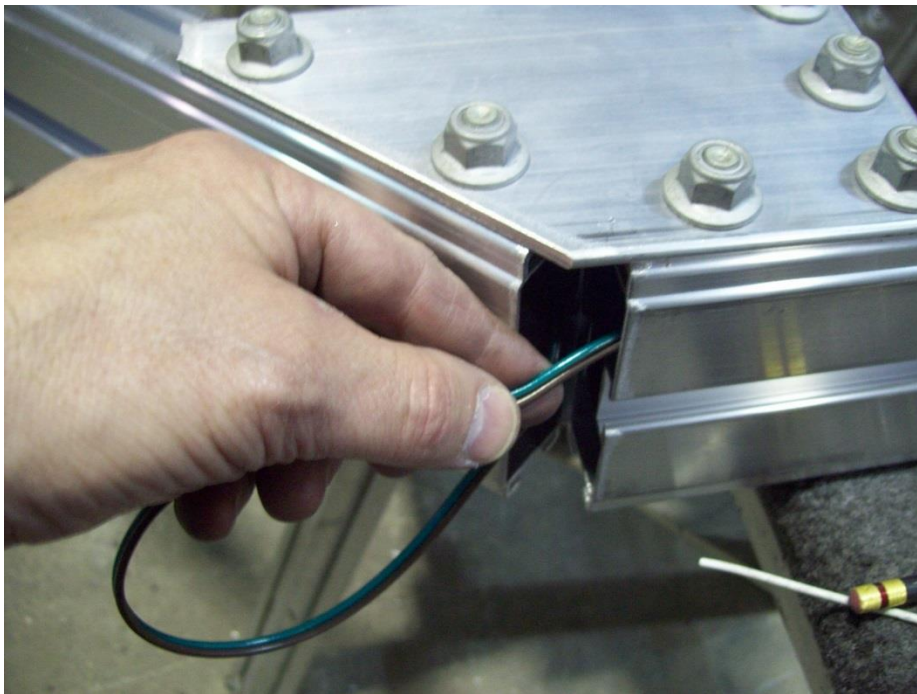
Pull the harness down on each side of the tongue section as shown. Insert harness into the top channel of each diagonal and push through.



Locate adhesive clips to hold harness down.



Install one adhesive clip on each side of the harness then insert into tongue section on both sides.



Pull harness through diagonal and insert into the top channel of the side rail as shown. Push harness through the side rail till it comes out the back. Repeat process for the other side.



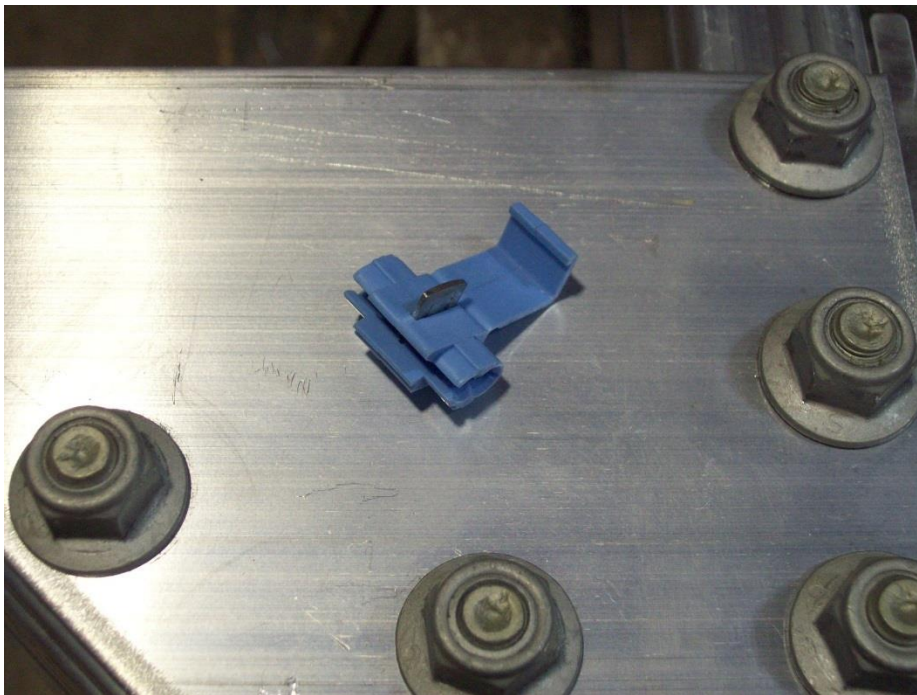
Once harness starts to come out grab it and pull the excess wire. Cut harness about 6" away from the side rail leaving enough wire to attach the lights to.



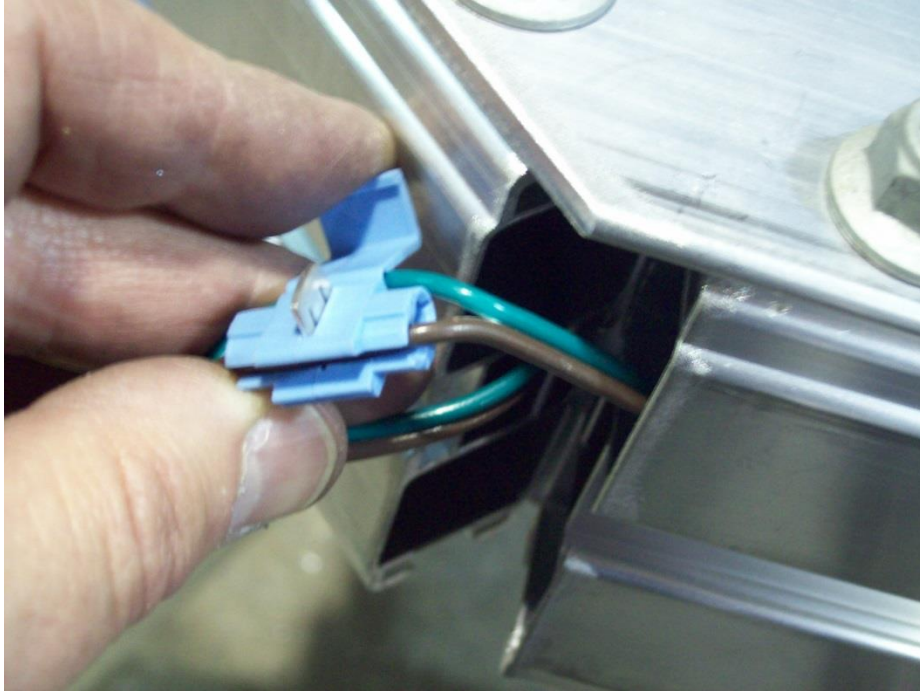
Take left over wire and separate the wires as shown. Take the brown wire and cut it about 12" long. This will be used to connect the side marker light.



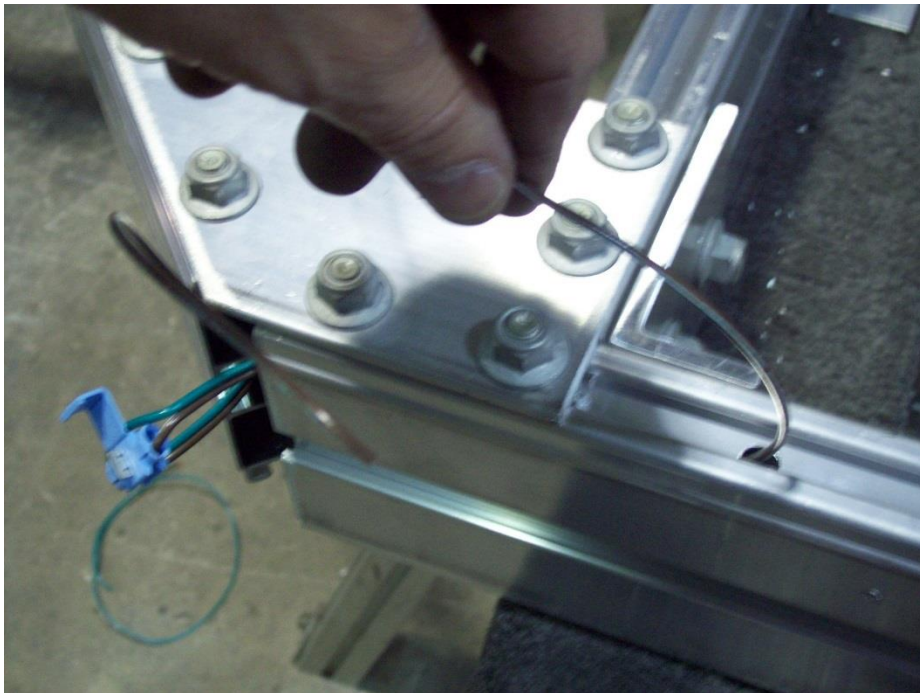
Now go back to the front diagonal and side rail and pull a little of the harness out. Take a knife and very carefully separate the two wires. Use caution to not expose wires when cutting casing.



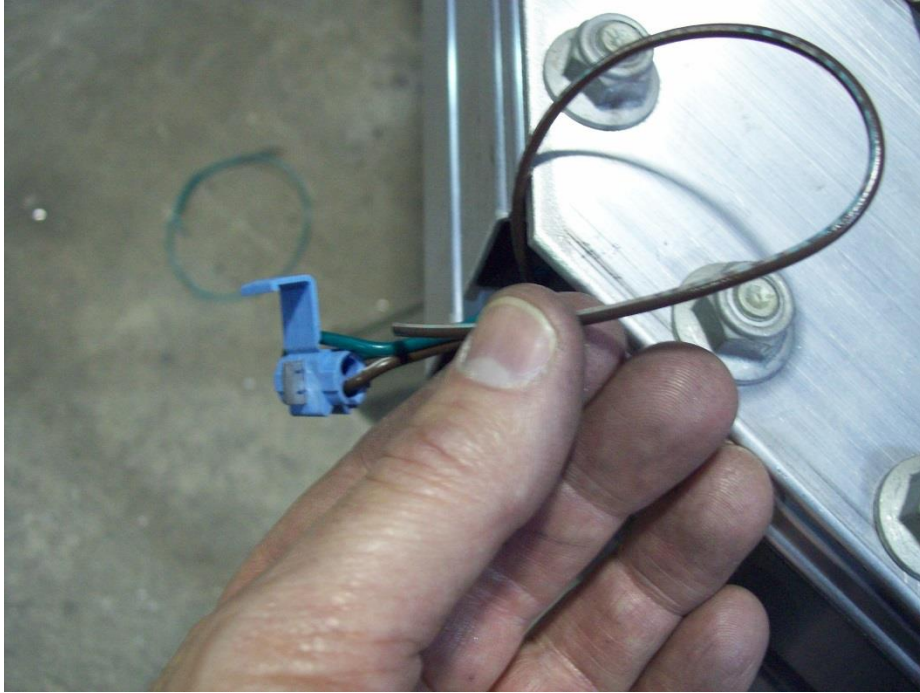
Locate the scotchlok connector.



Install the open side of the scotchlock connector over the brown wire as shown.



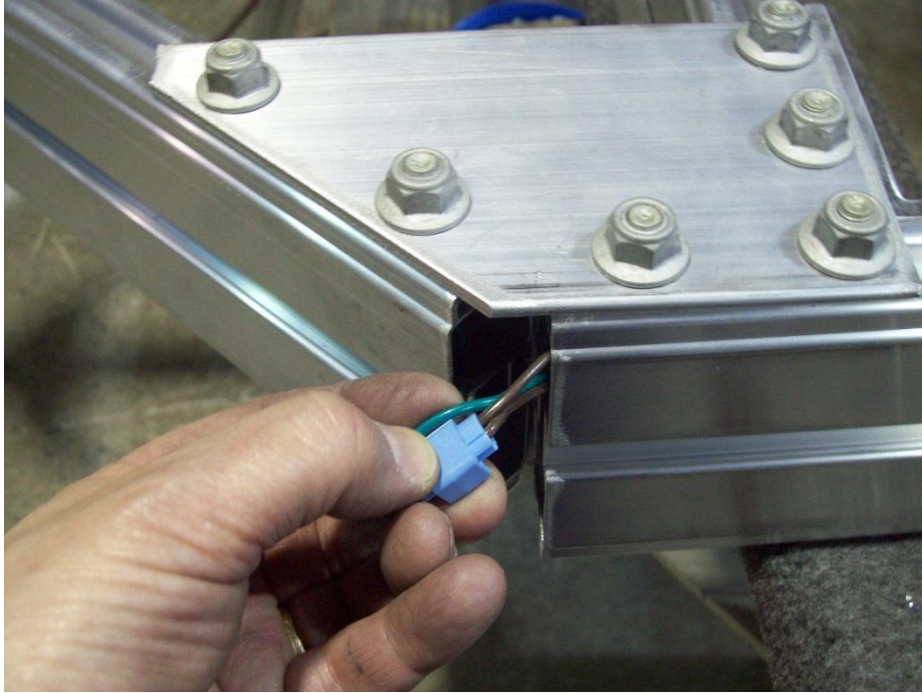
Take the 12" piece of brown wire that was cut and inset it through the hole in the side rail.



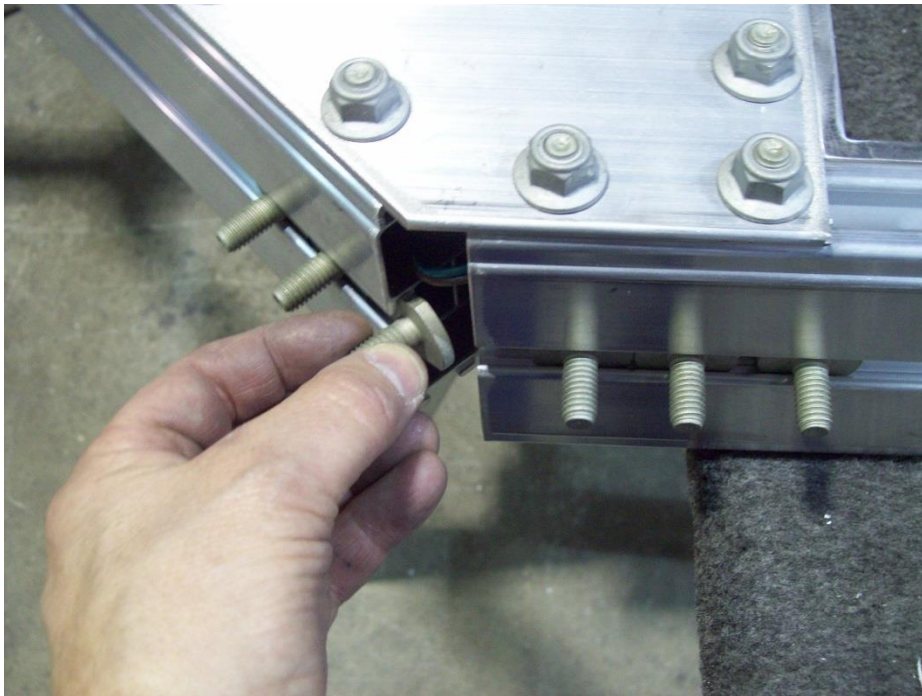
Insert the wire into the blocked hole of the scotchlok connector.



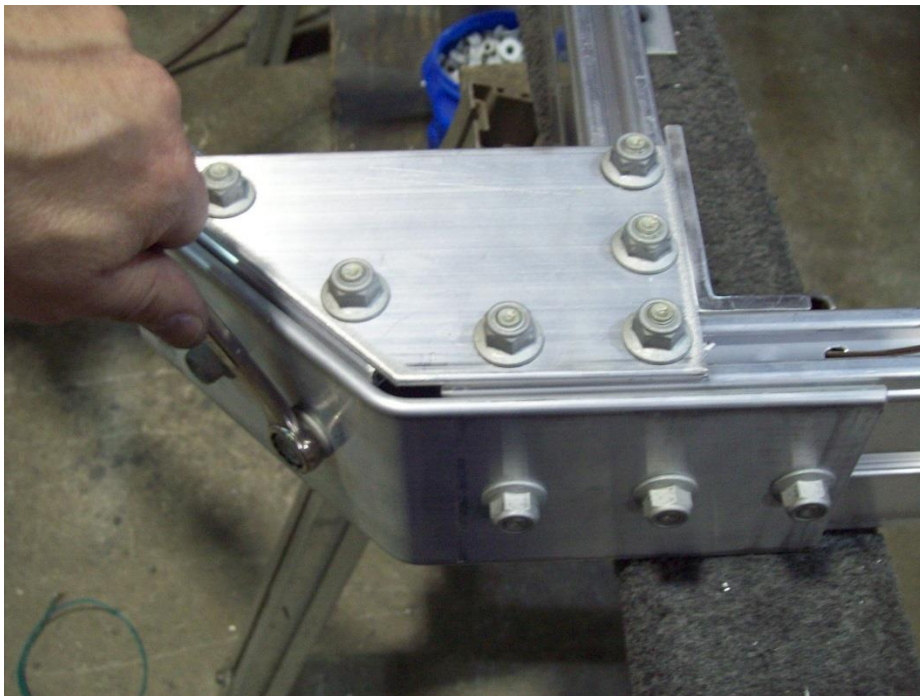
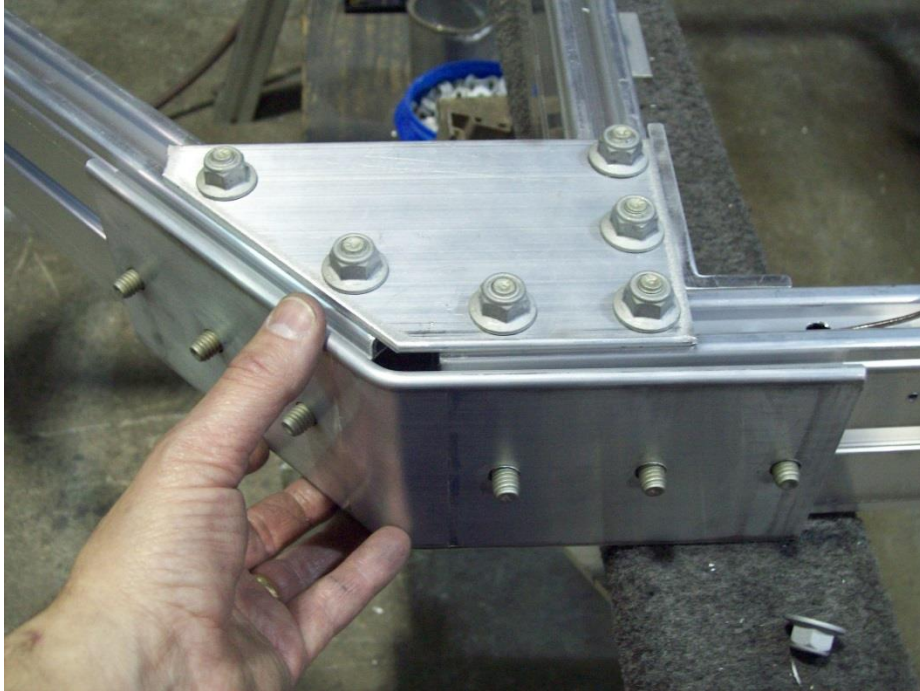
Once wire is in place push the blade down on the connector as shown.



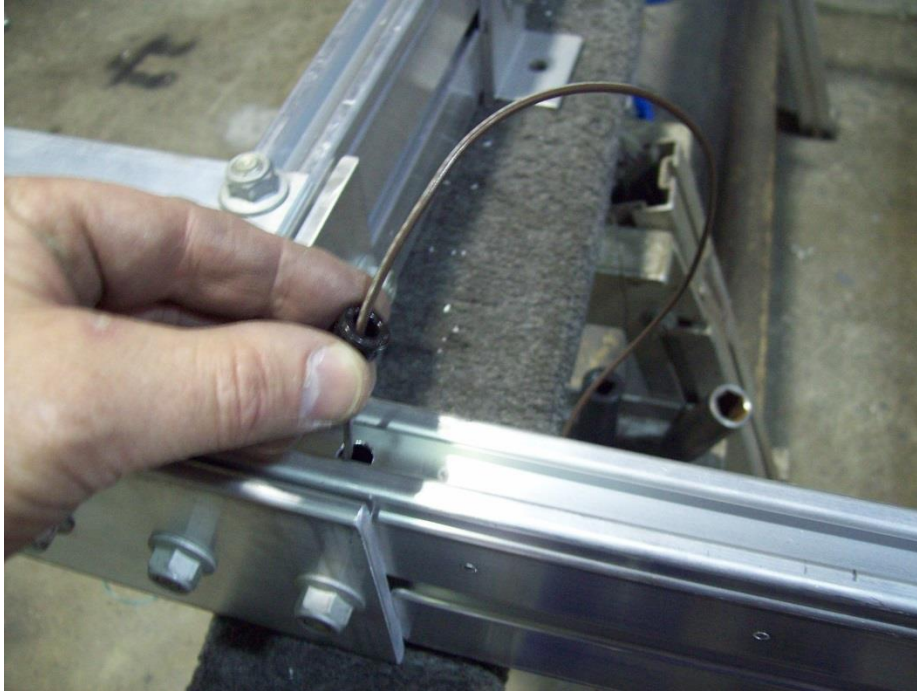
Close the cover on the connector and push inside the side rail.



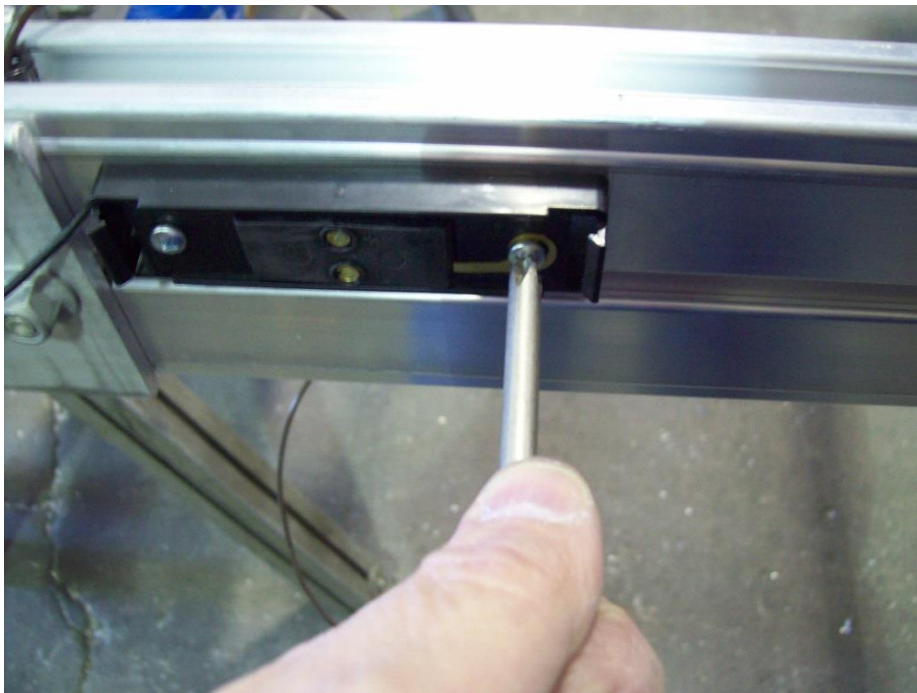
Locate the T-bolts and insert three in the diagonal and in the side rail.



Locate the corner plates and install it over the T-bolts. Install the nuts and tighten.



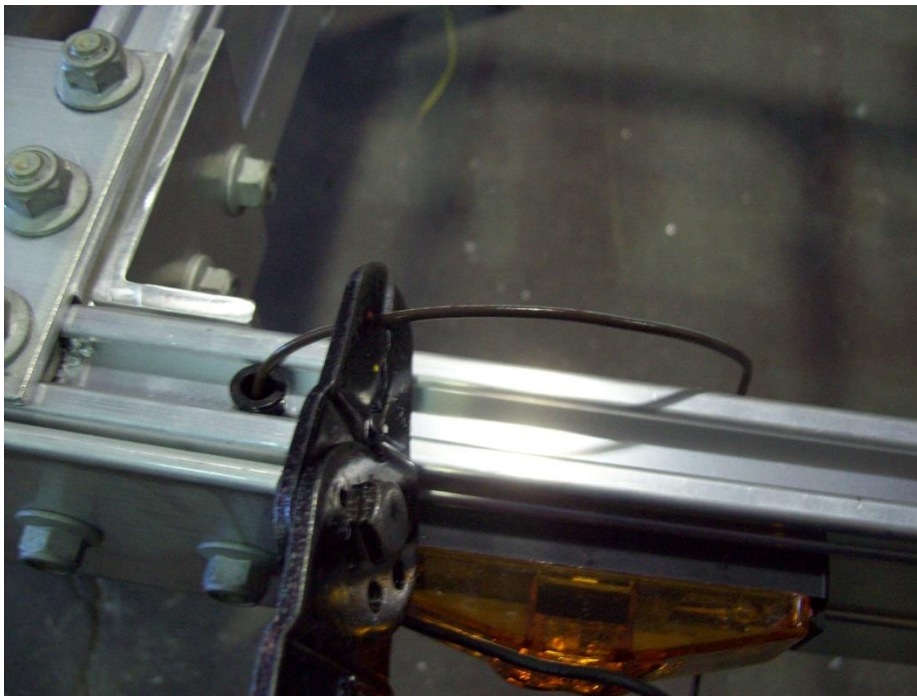
Take one of the barrel clips and insert the brown wire through it. Push the barrel clip into the hole.



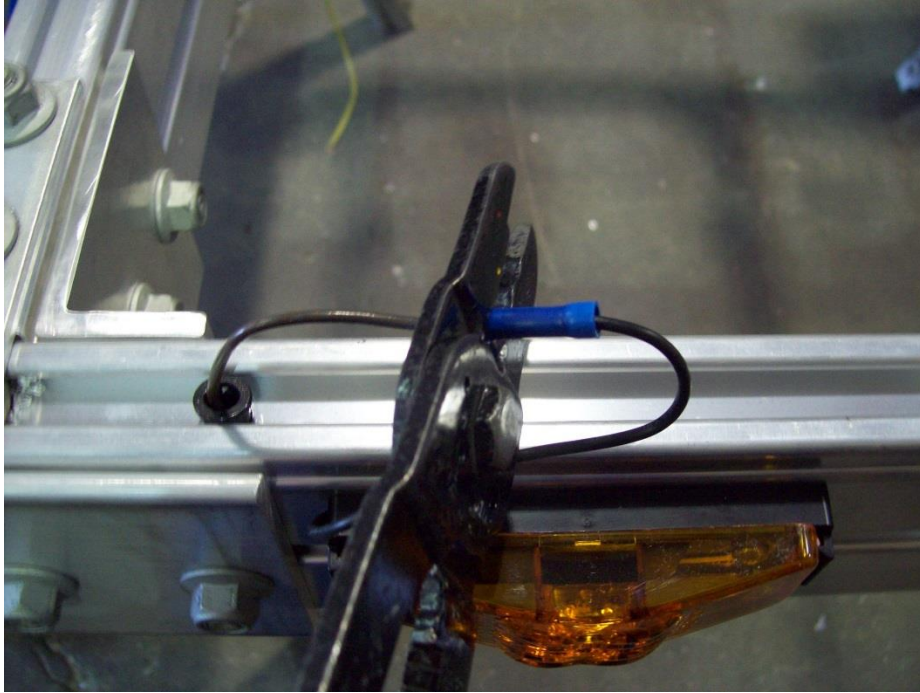
Find the side marker light base and two Phillip screws and install it by the corner plate as shown.



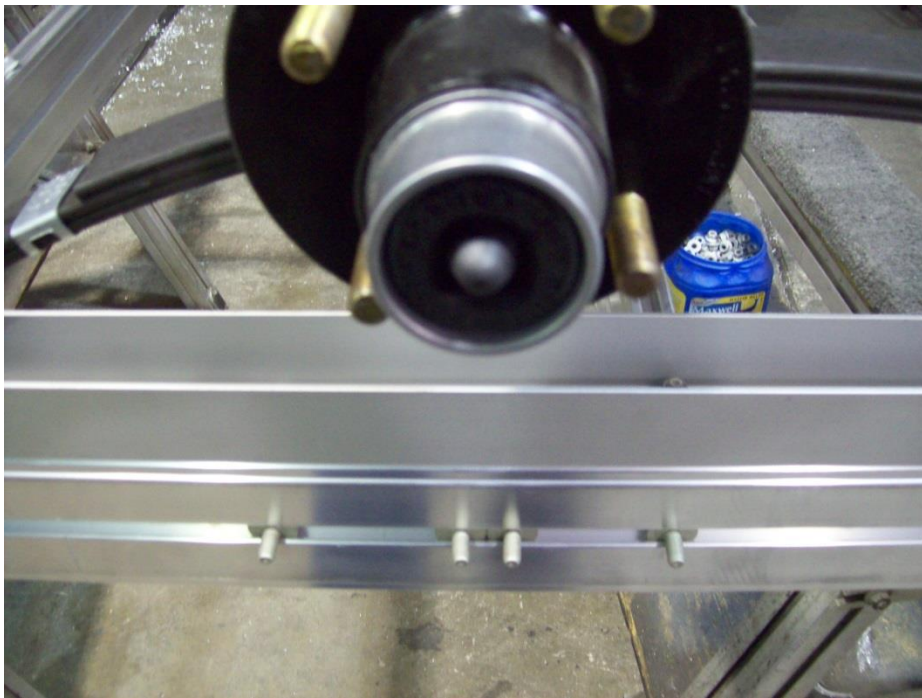
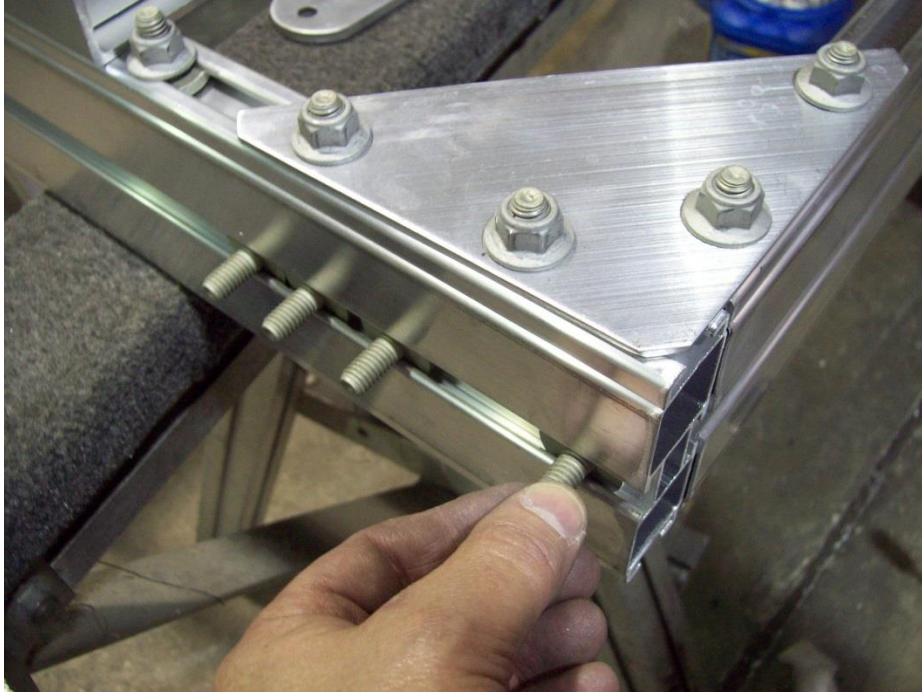
Take lens and insert the terminals into the plugs on the side marker and snap in place.



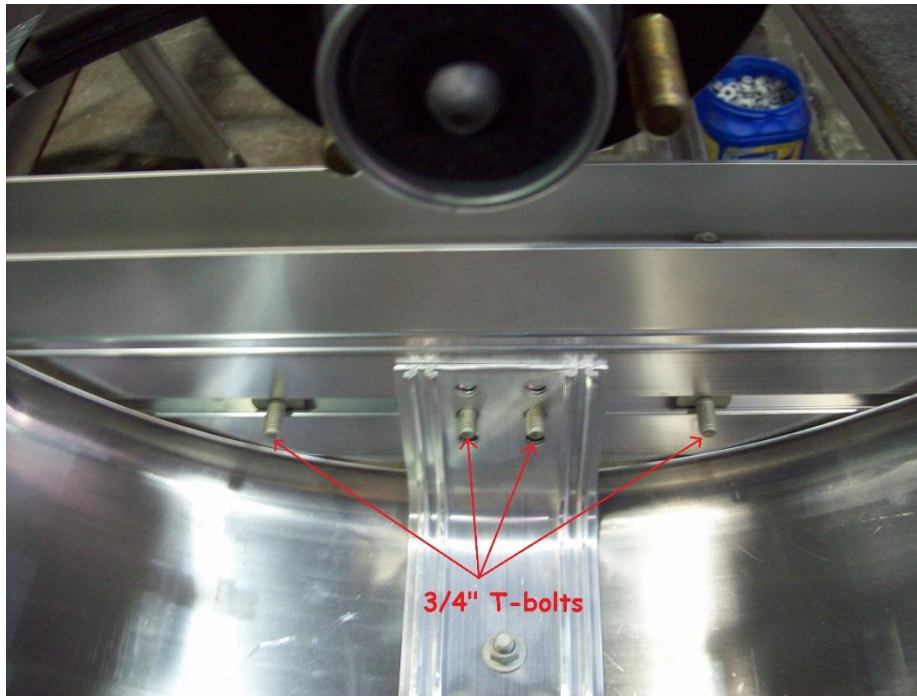
Cut the excess wire off and trim and strip a 1/4" of casing off.



Install a butt connector on the wires and crimp in place. Locate one adhesive clip and install it over the wire, then insert it into the rail as shown.



Take four T-bolts and insert them into the back of the side rail and slide towards the axle. Position the T-bolts as shown under the axle.



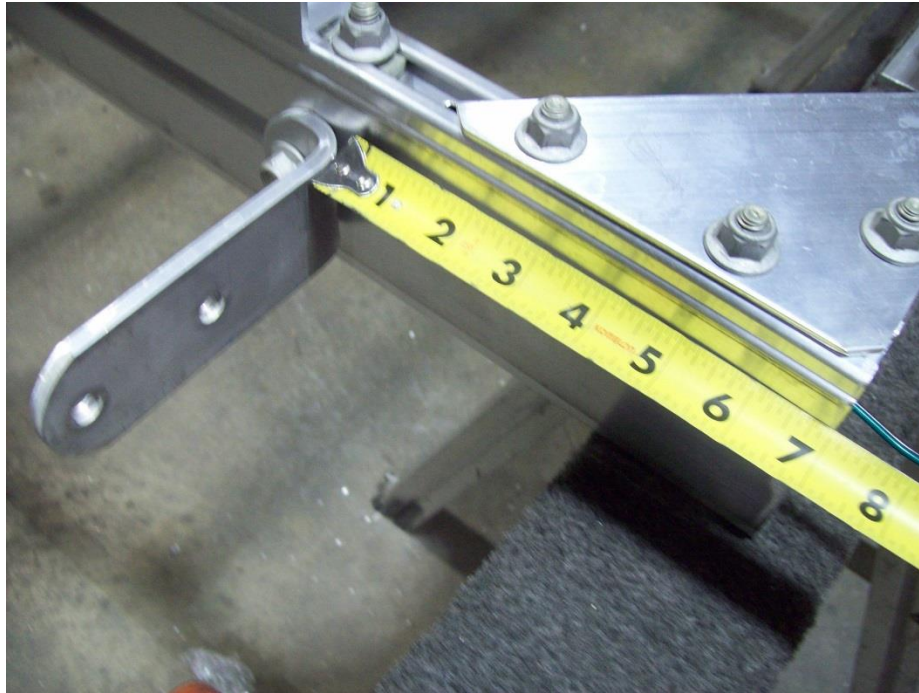
Place the fender bracket over the two center T-bolts and center it.
Install nuts but do not tighten all the way.



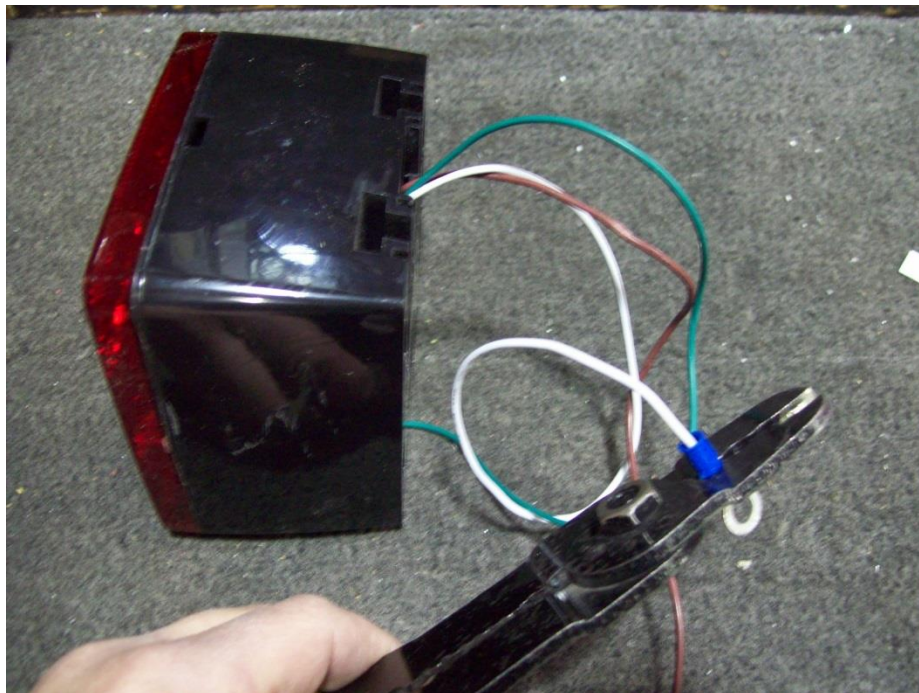
Install the rubber washer first, followed with steel washer and nut.



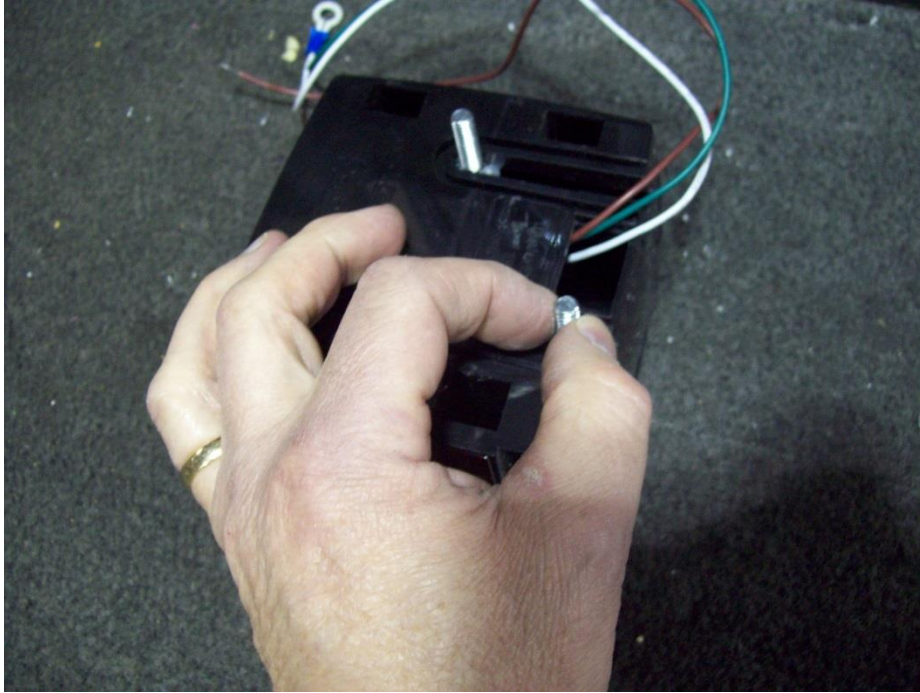
Once fender is in position, tighten all nuts Repeat the process for the other side.



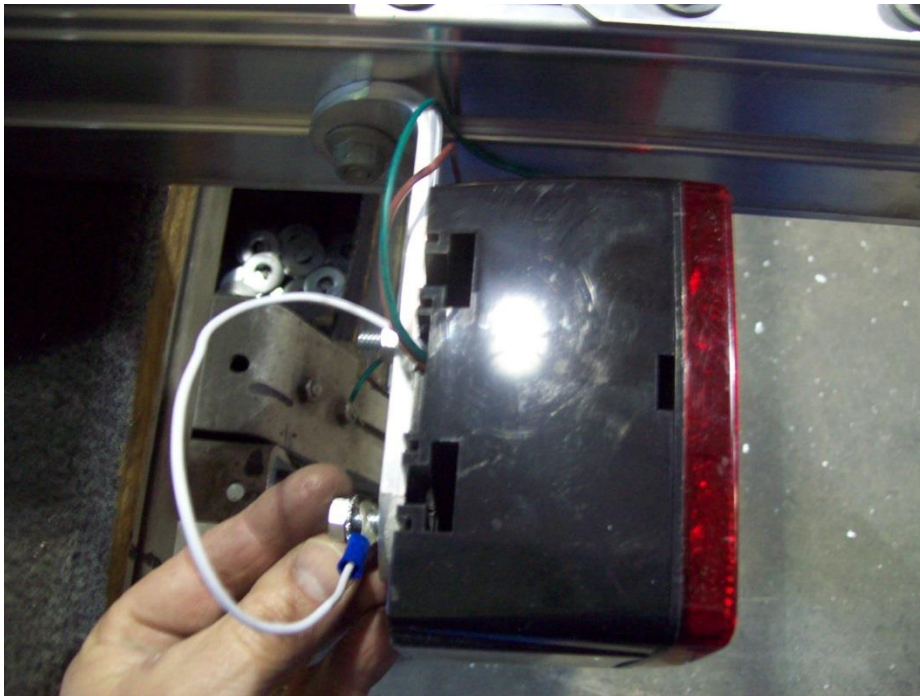
Insert one of the tail light brackets into the back of the side rail and position 7" from the rear. Tighten the nut once it's in place. Repeat for other side.



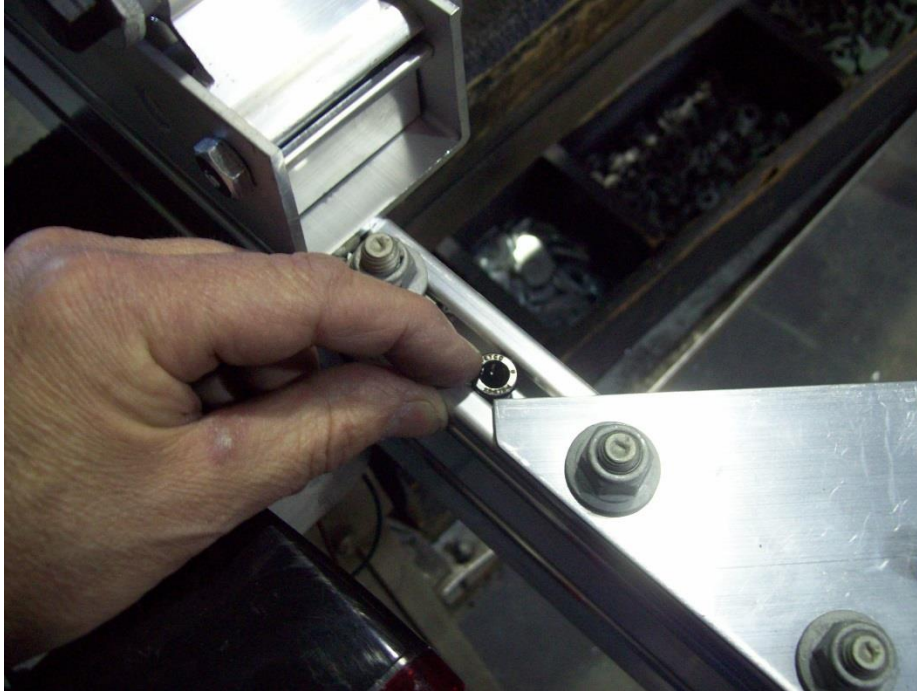
Take both tail lights and crimp a large ring terminal on the white wire of each. These are the ground wires.



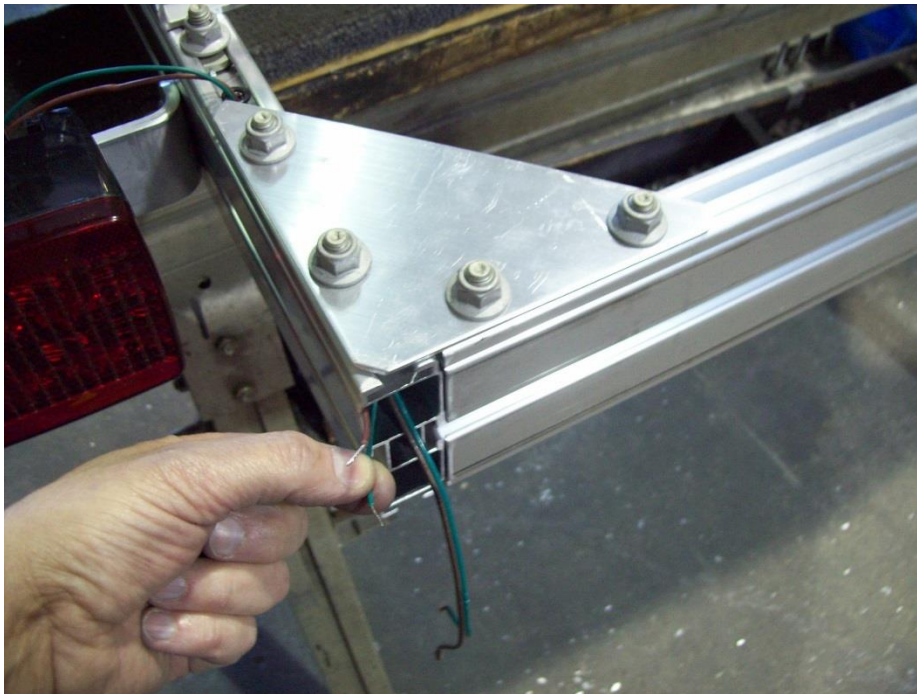
Slide two carriage bolts from the light kit into the back of the lights.



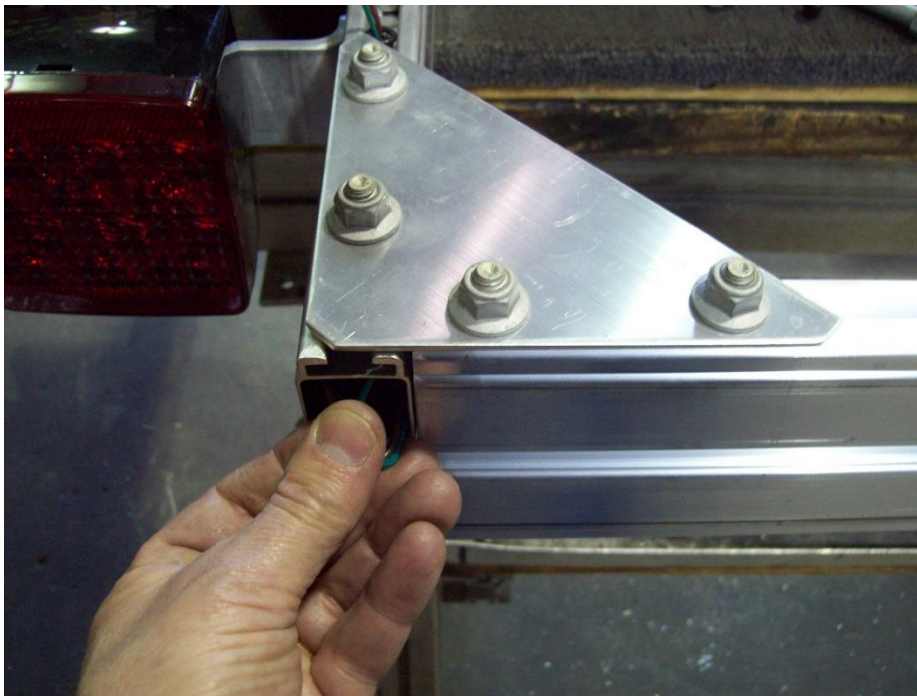
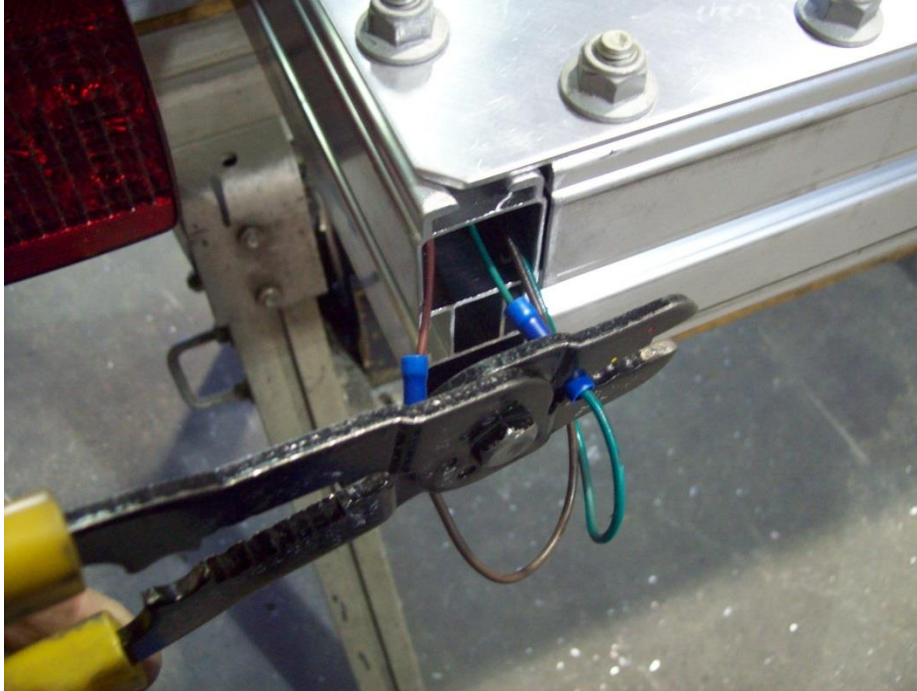
Insert bolts through the tail light brackets and install ground wire on the outside of the bracket as shown. Install nuts and tighten.



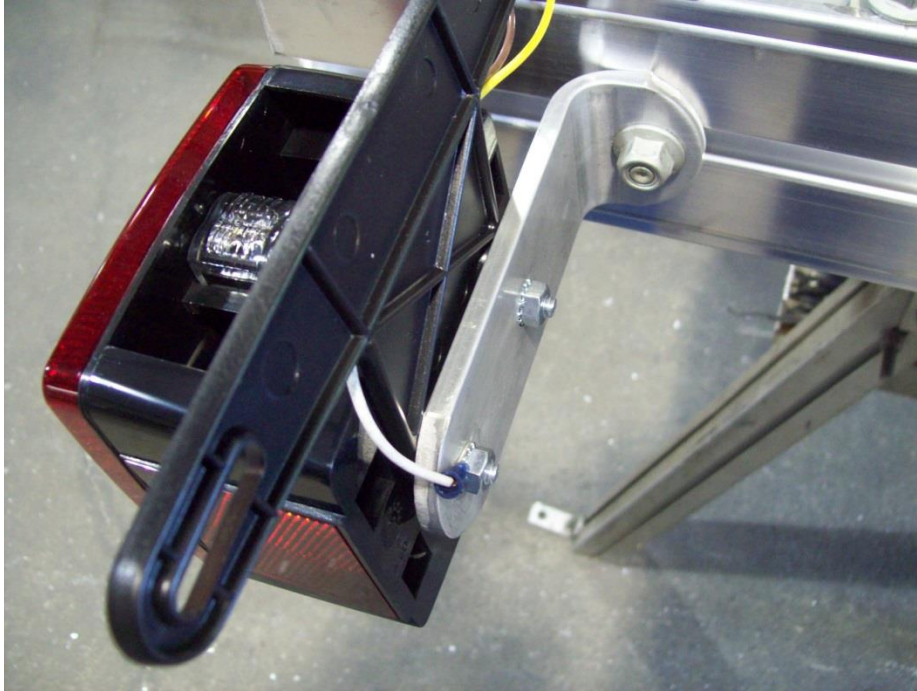
Insert one barrel clip in the side rail and push in place



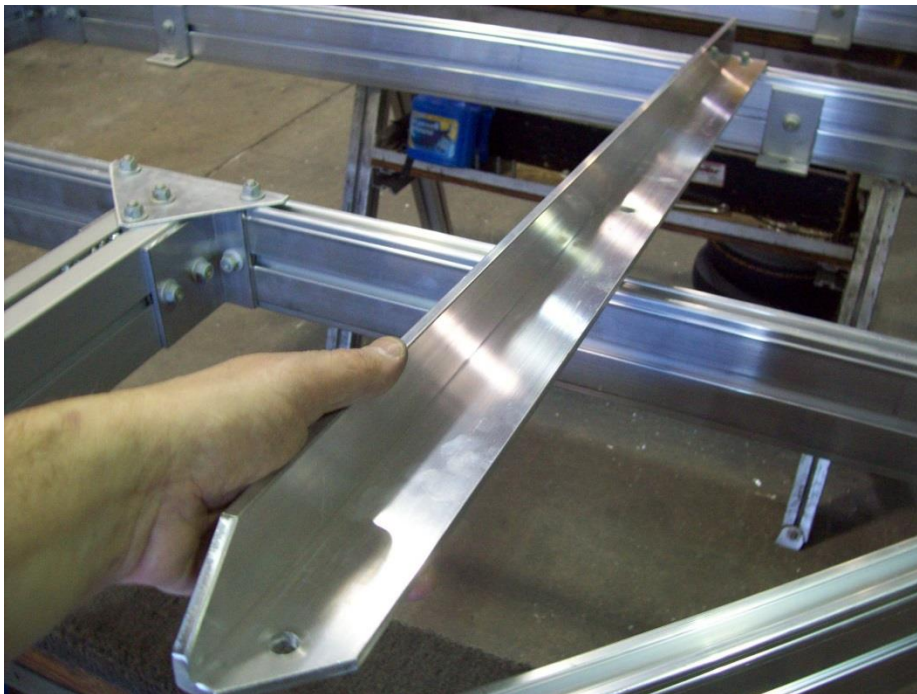
Insert wires from tail light through the barrel clip and push towards the rear of the trailer.



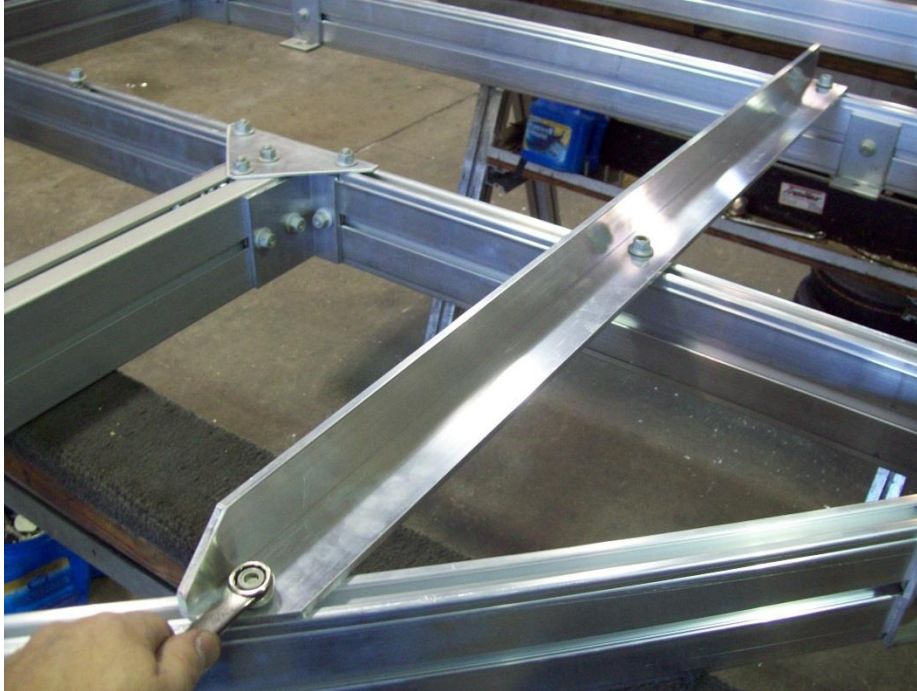
Crimp one butt connector on each of the brown wires and green wires as shown. Push the harness and butt connectors back into the side rail. Repeat process for other side.



Insert the plastic license plate bracket between the light and the tail light bracket on the driver's side of the trailer.



At the front of the trailer locate the three T-bolts one in the diagonal and the other two in the cross members. Place the stringer over top the T-bolts and align.



Install the nuts and tighten.



Install the wheels with the valve stems facing out. Install the wheel nuts with the *tapered side facing the wheel*. Turn the trailer right side up and tighten nuts.



Torque to 80 foot pounds in a cross pattern. Re-tighten after 25 miles.



Locate the park jack and hardware bag. Take two bolts and run them through the holes at the top mounting holes of the jack. Add the brackets and nuts but do not tighten. Lay the jack over top of the tongue section as shown.



Finished trailer

KJM 4/27/16