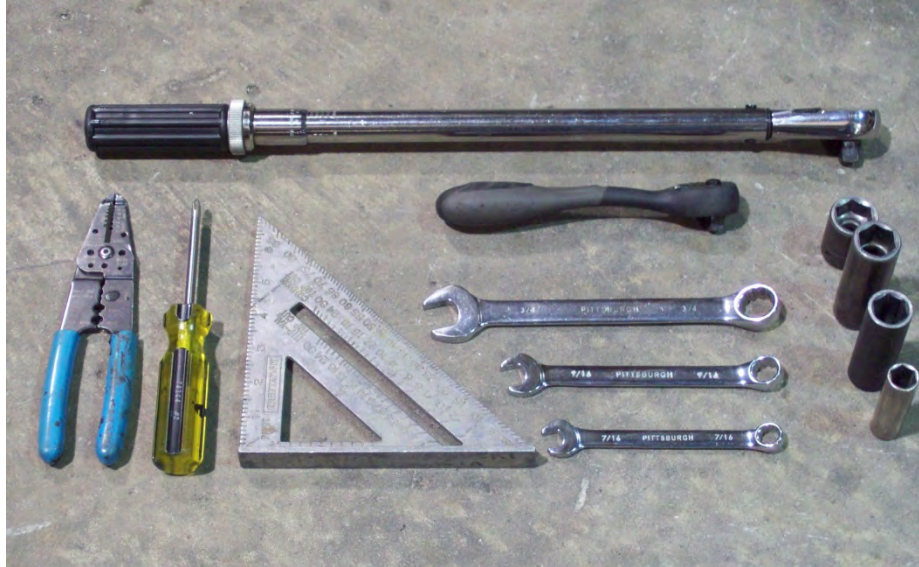


# SUT-200-S RUNNING GEAR CONVERSION TO SUT-220-S



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 35-40 foot pounds.**

**\*Check all lights before towing.**

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

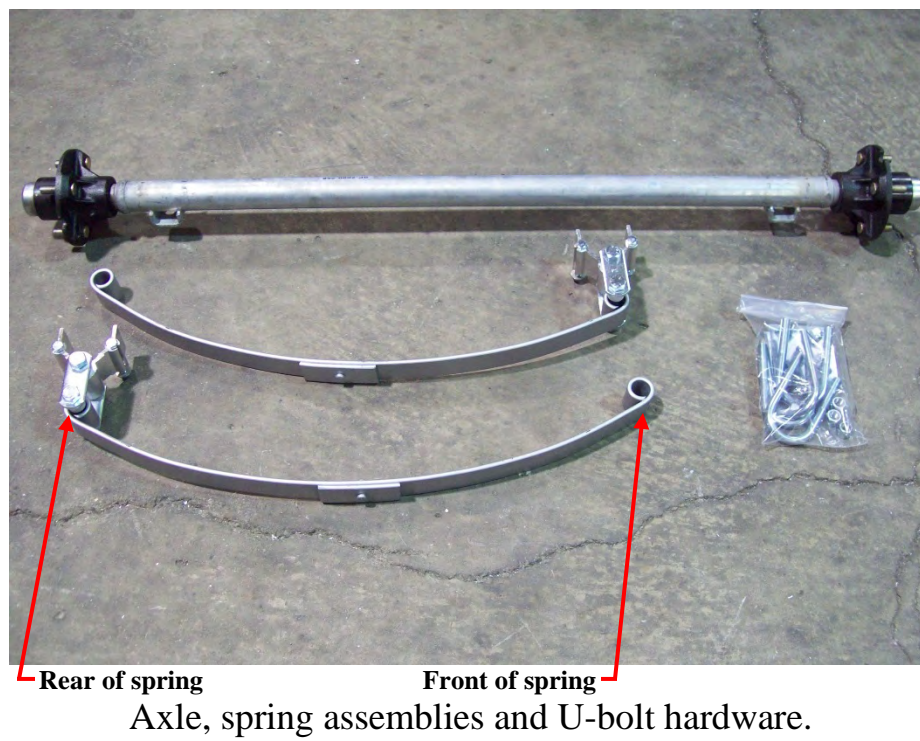
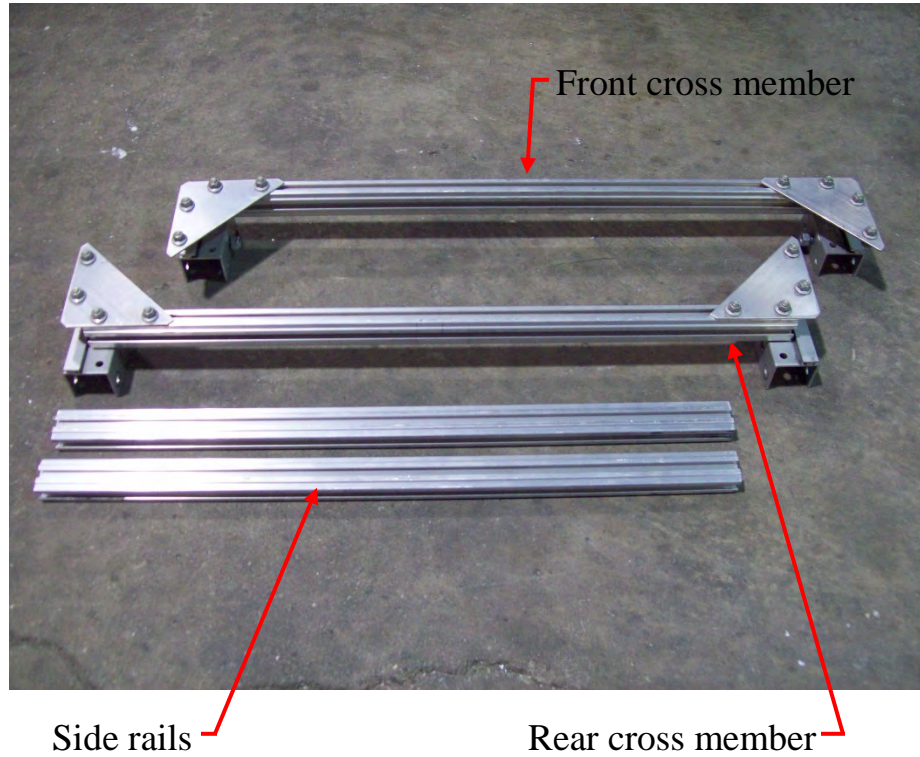
**\*Re-torque wheel nuts after first 25 miles to 80 ft. pounds and periodically thereafter.**

**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.**

## UNPACK AND IDENTIFY THE FOLLOWING PARTS.







2) Hardware bags



Loosen and remove the lug nuts and wheels. After removal set aside these will be used later on.



Loosen and remove the nuts and washers holding the fender on.



Set fenders aside for now these will be used later.

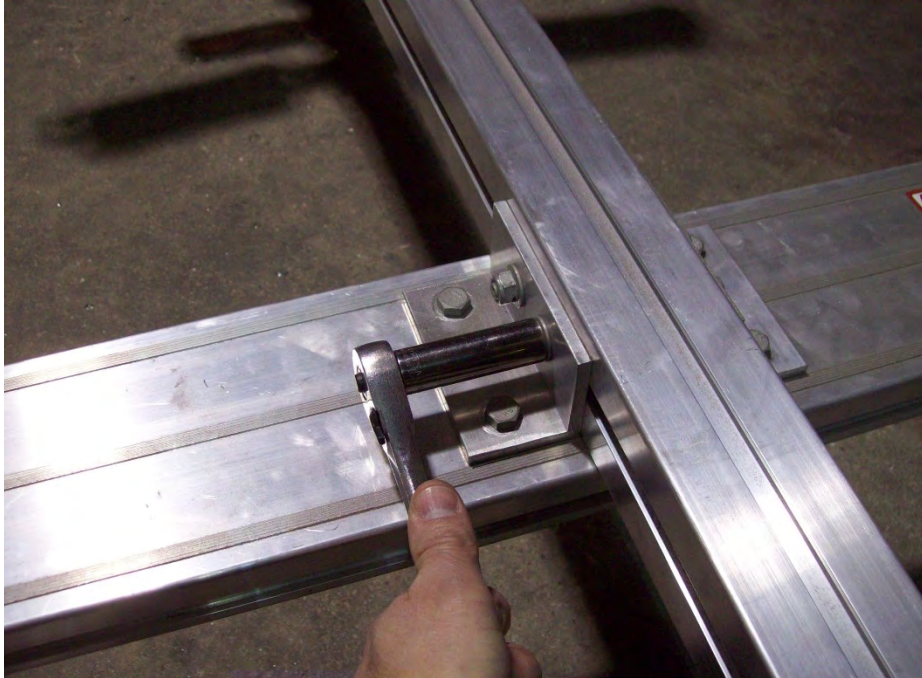




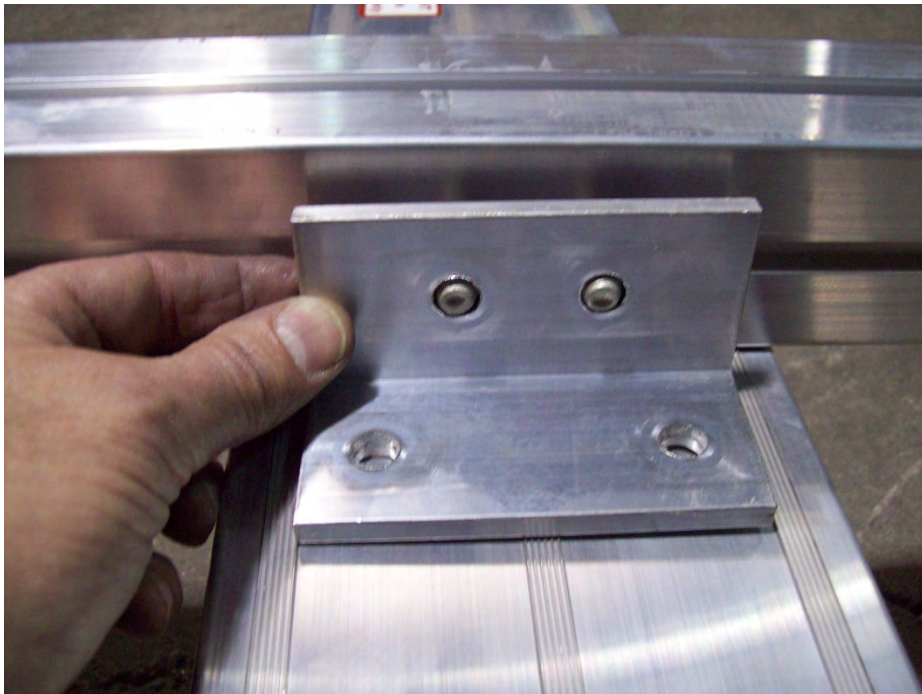
**Shown upside down**  
Remove the nut from the tie rod ends.



**Shown upside down**  
Lift both tie rod ends off the T-bolt.



Remove nuts from angle brackets on tongue section and axle.



Once nuts and bolts are off, remove the angle brackets and move axle assembly out of the way.



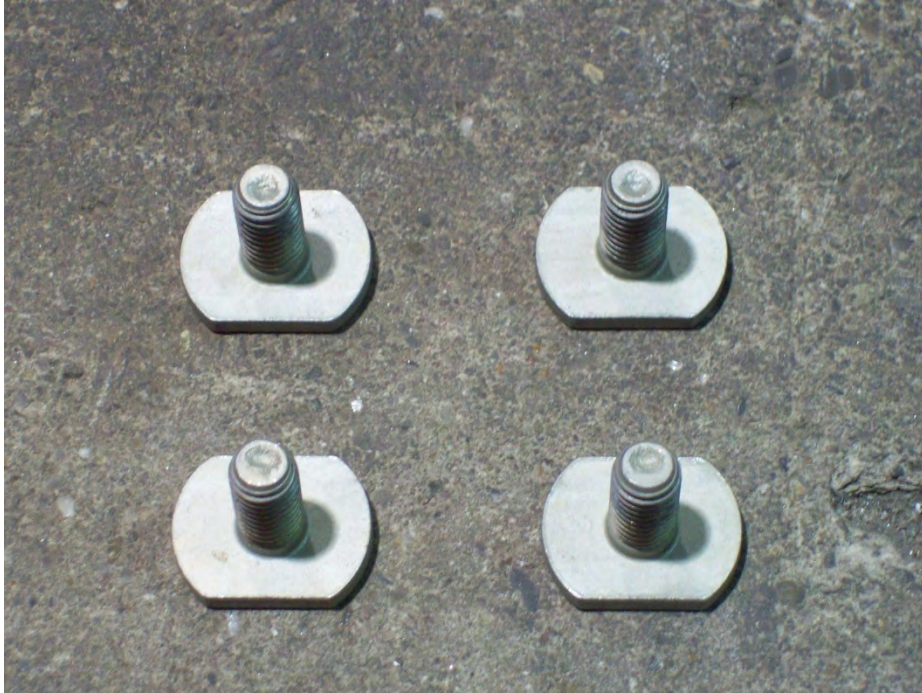
## Frame assembly



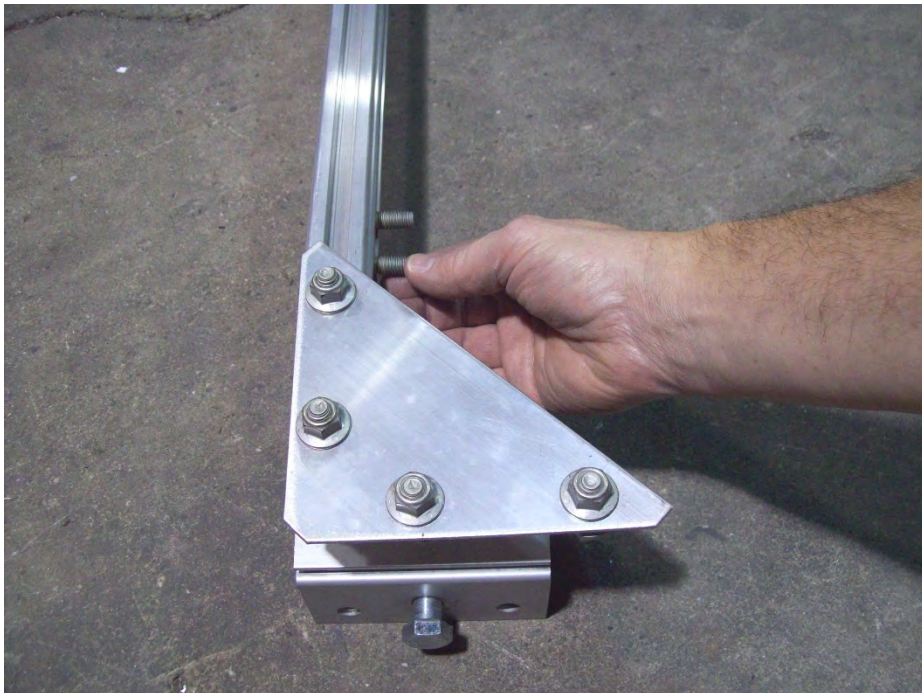
Locate the side rails, rear cross member and front cross member.



Locate the hardware bag with the angle brackets, T-bolts and nuts.

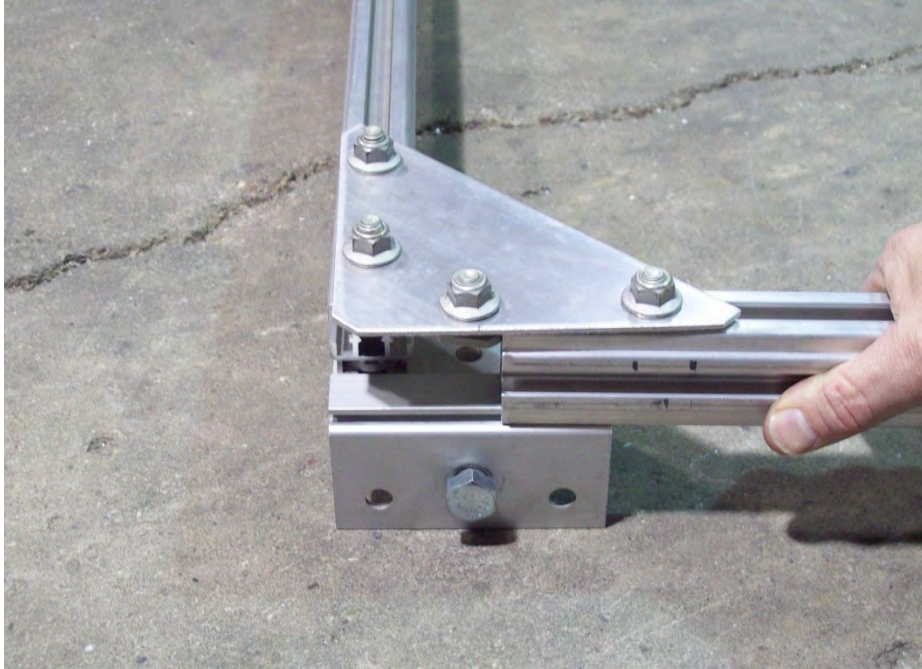


Remove 4 T-bolts from the hardware bag with the angle brackets.

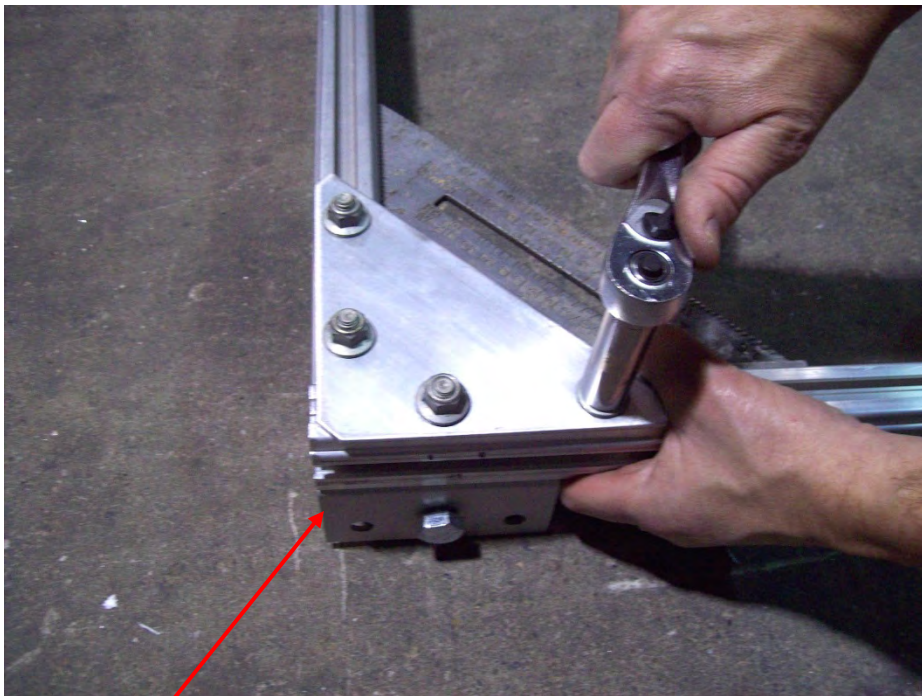


Install 2 T-bolts into the rear side of the front cross member as shown.



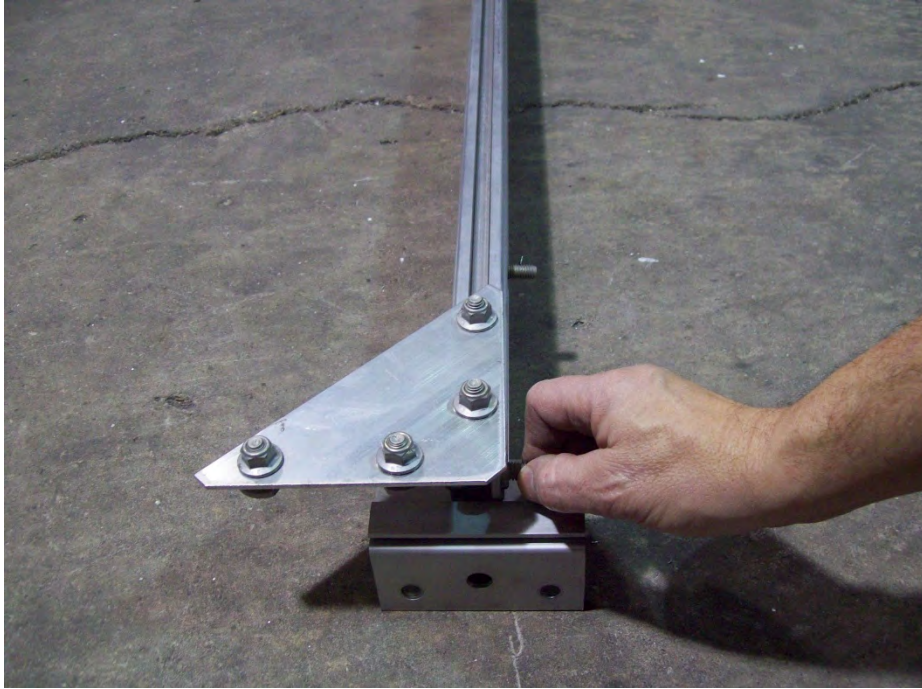


Insert the side rail into the front cross member.

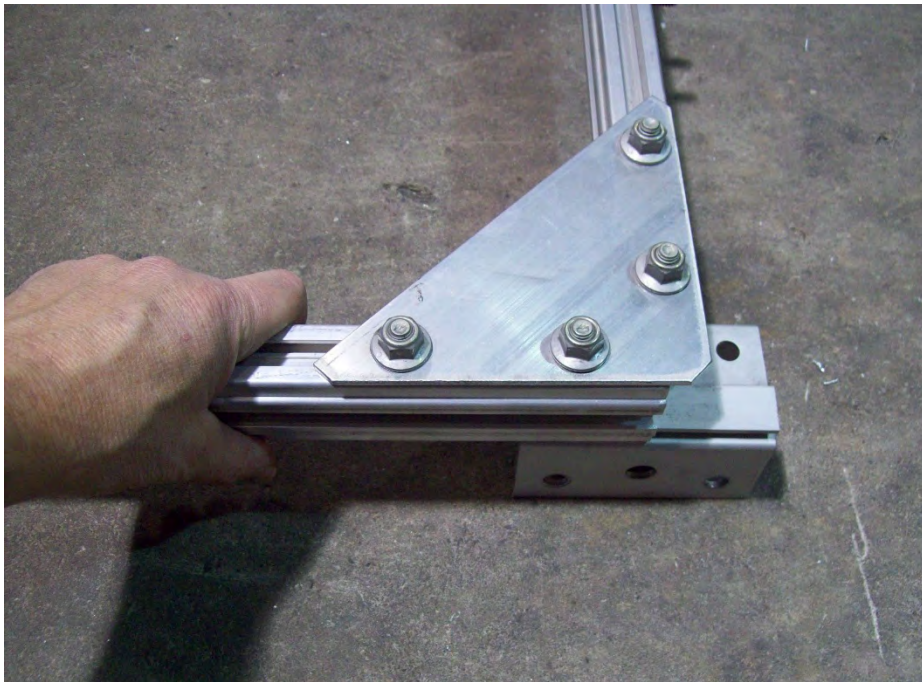


Sub rail clip

Slide the side rail all the way to the edge of the sub rail clip as shown. Square up assembly and tighten nuts.

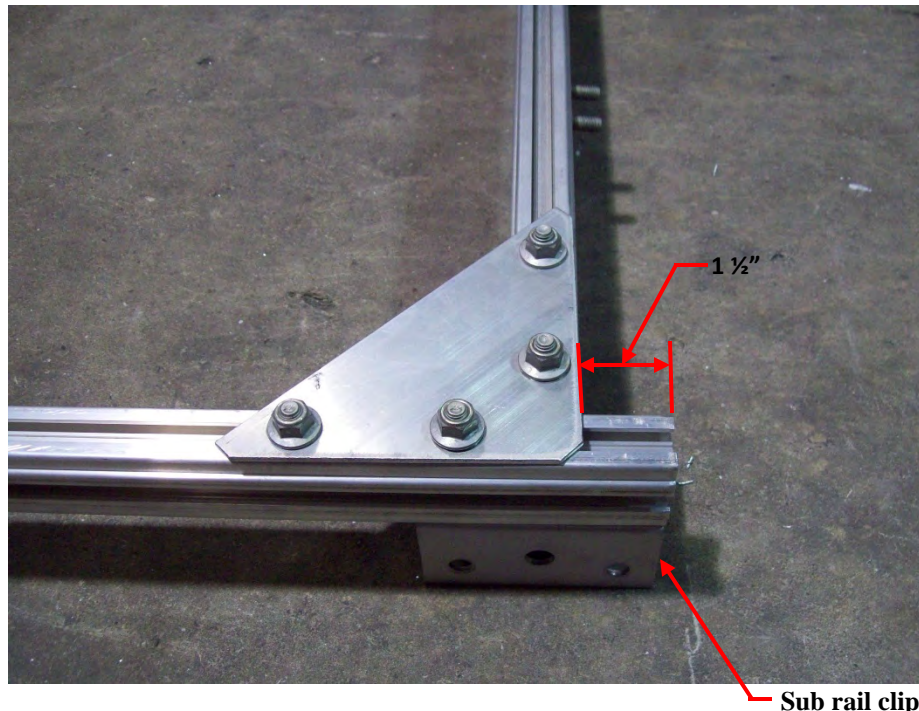


Install 2 T-bolts into the rear side of the rear cross member as shown.

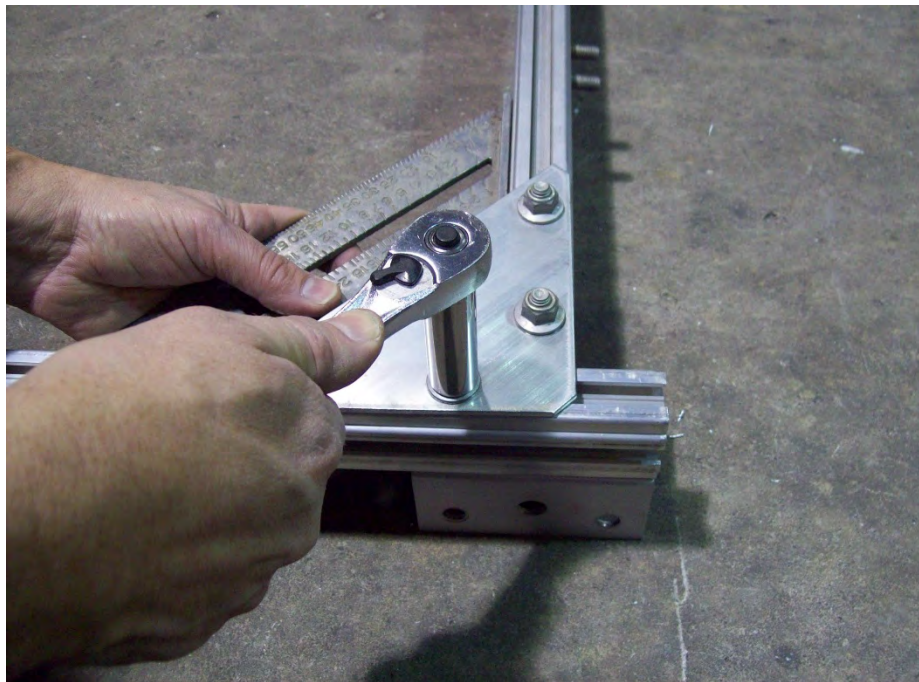


Insert the other end of the side rail into the rear cross member.





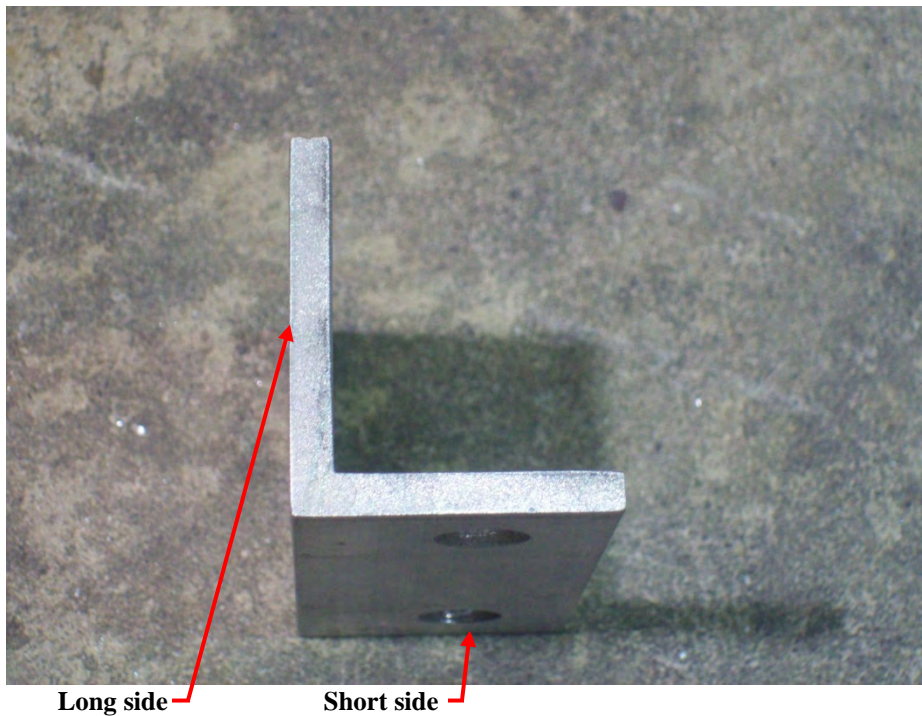
Slide the side rail all the way to the edge of the sub rail clip as shown. The side rail should be about 1 1/2" pass the rear cross member when in position.



Square up and tighten nuts. Repeat the process for the other side at this point.

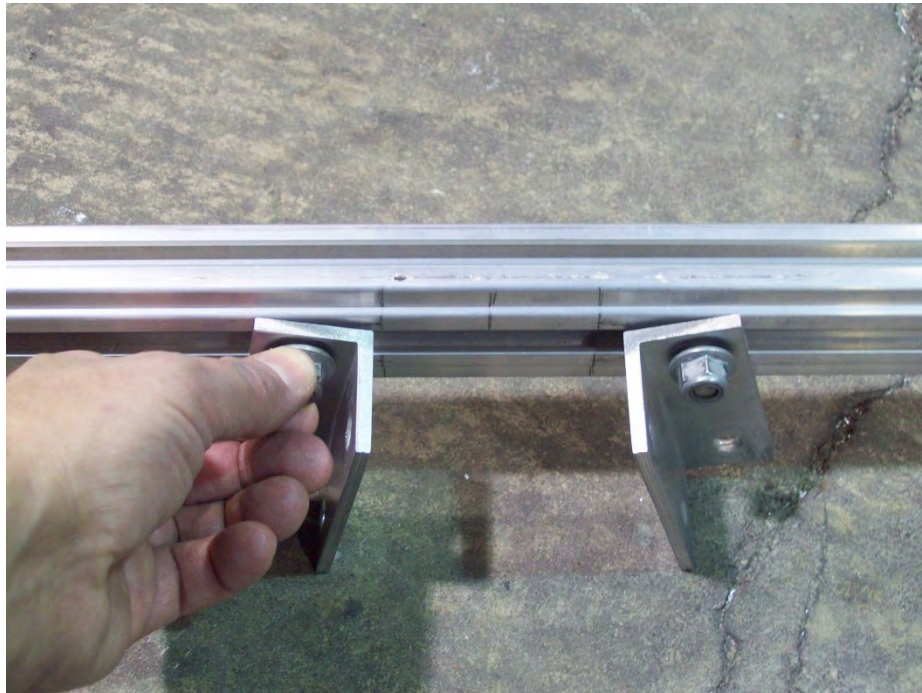


Your frame should look like this. Notice that the side rail extends passed the rear cross member. If not assembled properly, the spring assembly will not have enough arch to work correctly.

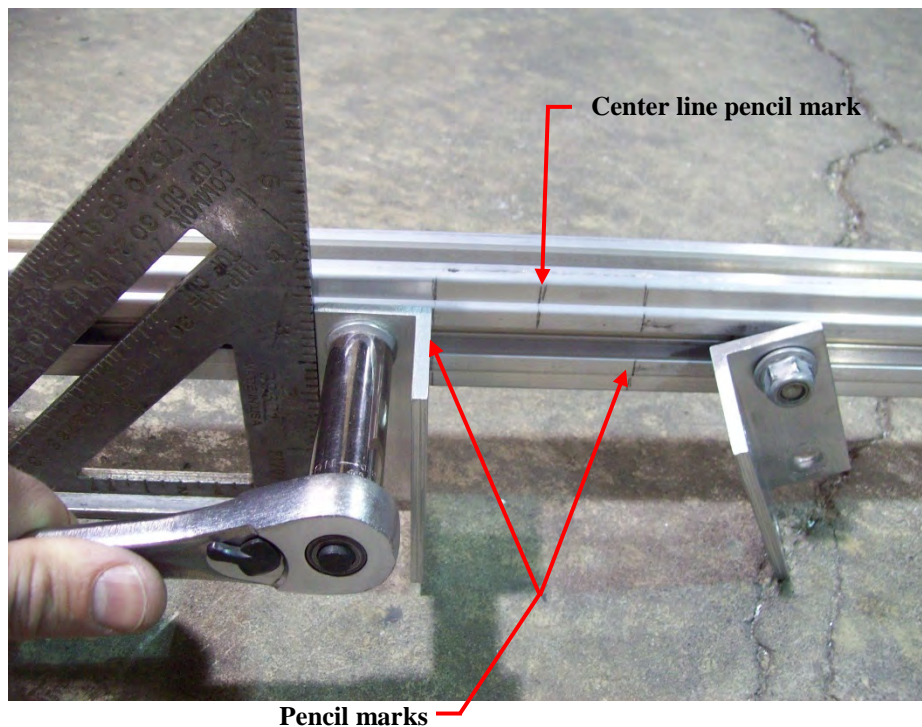


When attaching the angle brackets to cross member the short side should go against the cross member and long side against the tongue section.





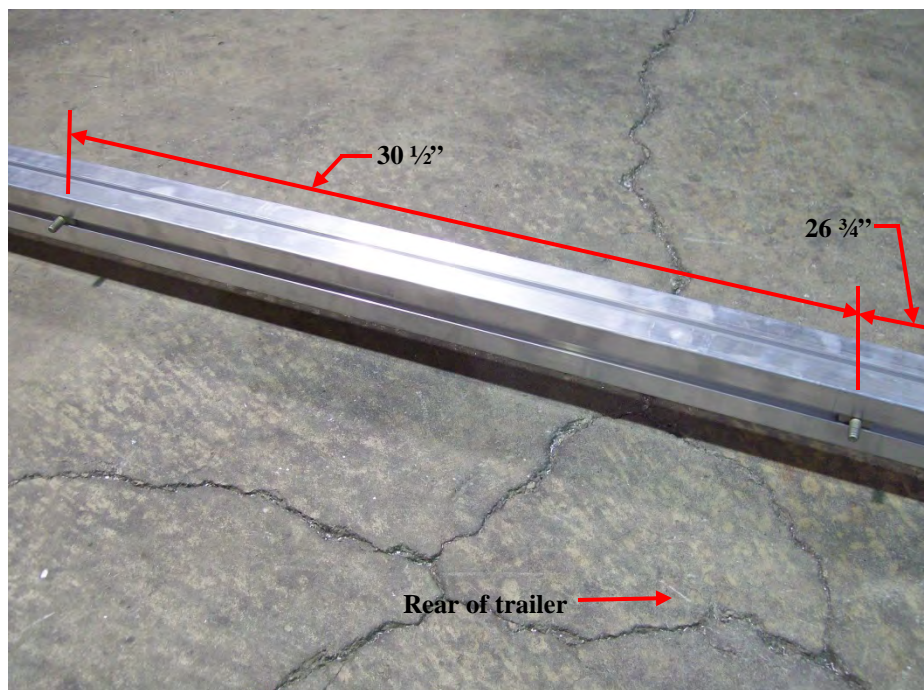
Install the angle brackets on the T-bolts already in the cross members as shown.



Align the front and rear left side angle brackets with the pencil marks on the frame. Square up angle brackets and tighten nuts. Leave brackets on the other side loose at this point.

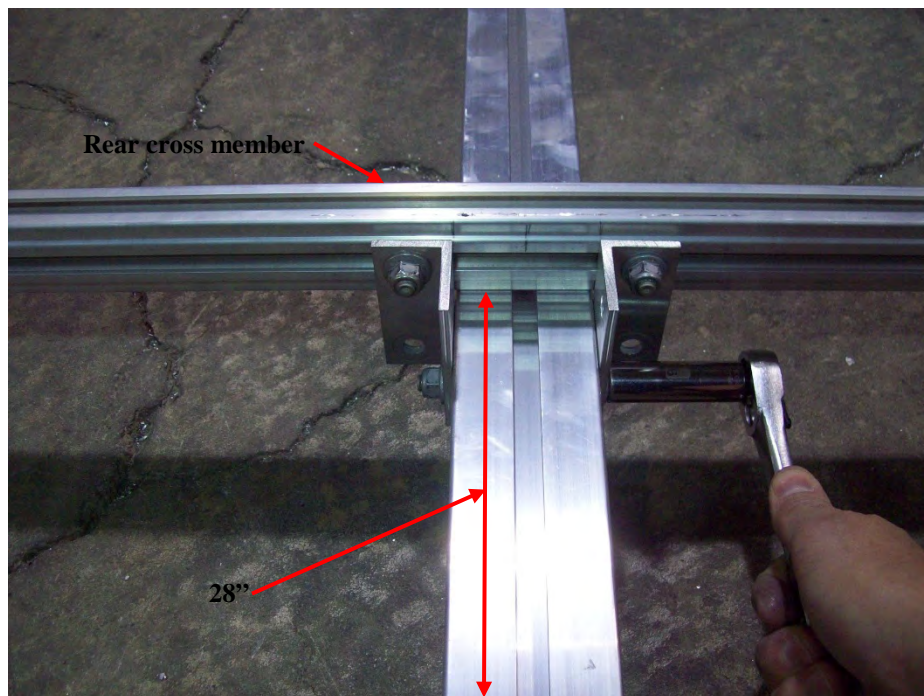
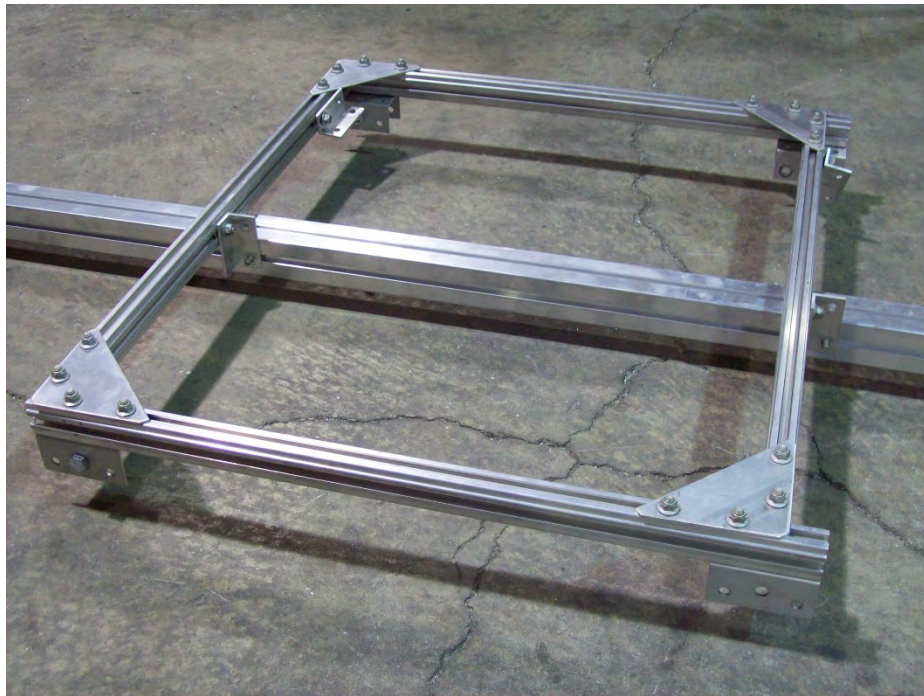


Your frame should look like this with the angle brackets attached to the rear side of each cross members.



Separate the two T-bolts on each side of the tongue section that held the previous axle assembly on. From the end of the rear tongue section position two of the rear T-bolts at  $26 \frac{3}{4}$ " and the front ones at  $30 \frac{1}{2}$ " away for the angle brackets.





Install the angle brackets into the T-bolts on the tongue section. Make sure the rear cross member is 28" away from the end of the tongue. Once in position slide the other angle brackets over install nuts and tighten. Flip trailer over at this point.

## Axle and spring assemblies

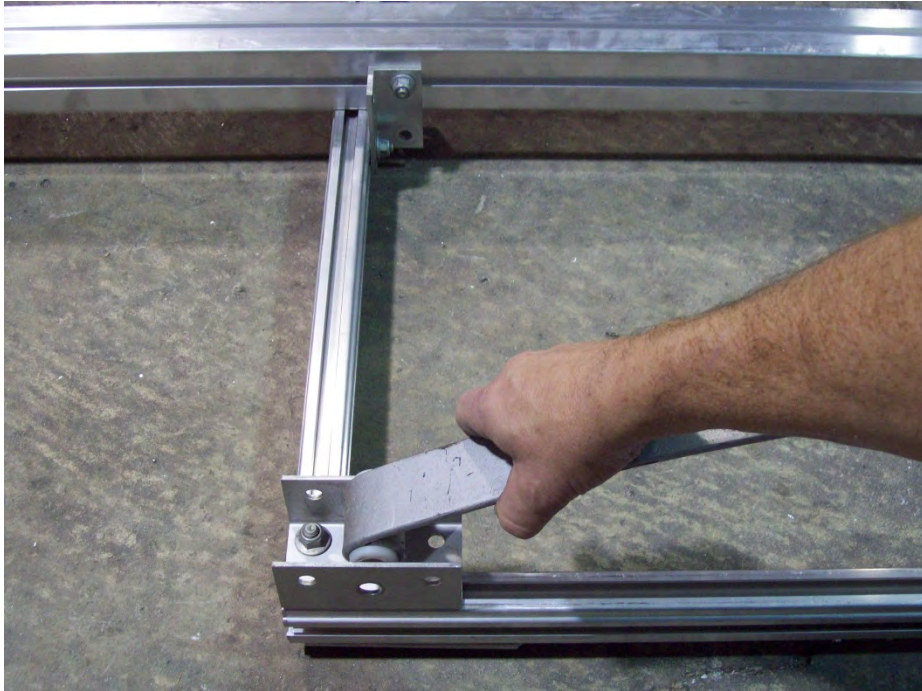


Locate the axle, spring assemblies and U-bolt kit.

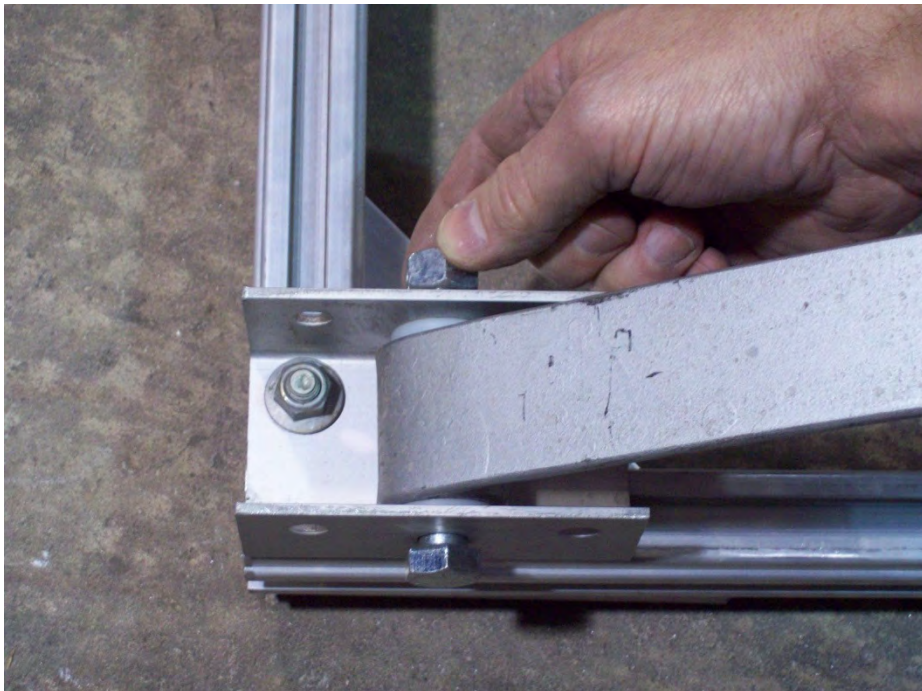


Remove the bolt, bushings and nut from the front sub rail clip.

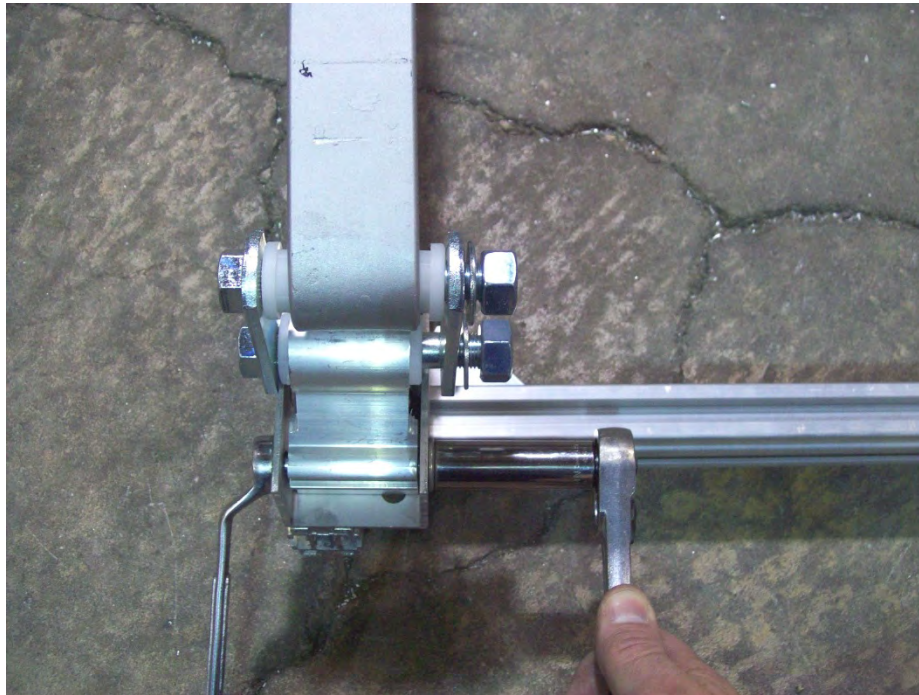
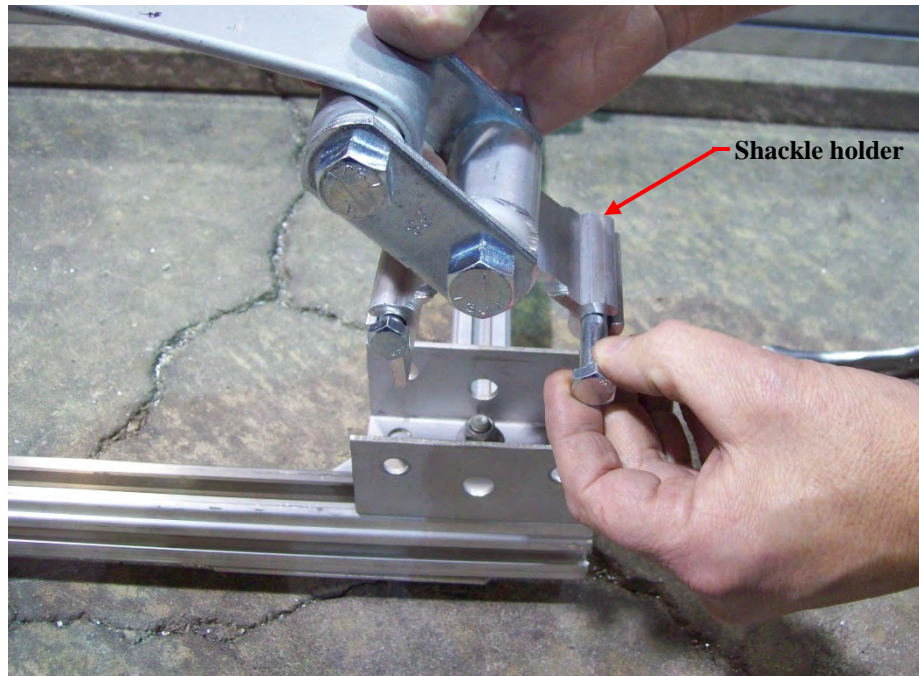




Install bushing into the front leaf spring and insert into sub rail clip as shown.

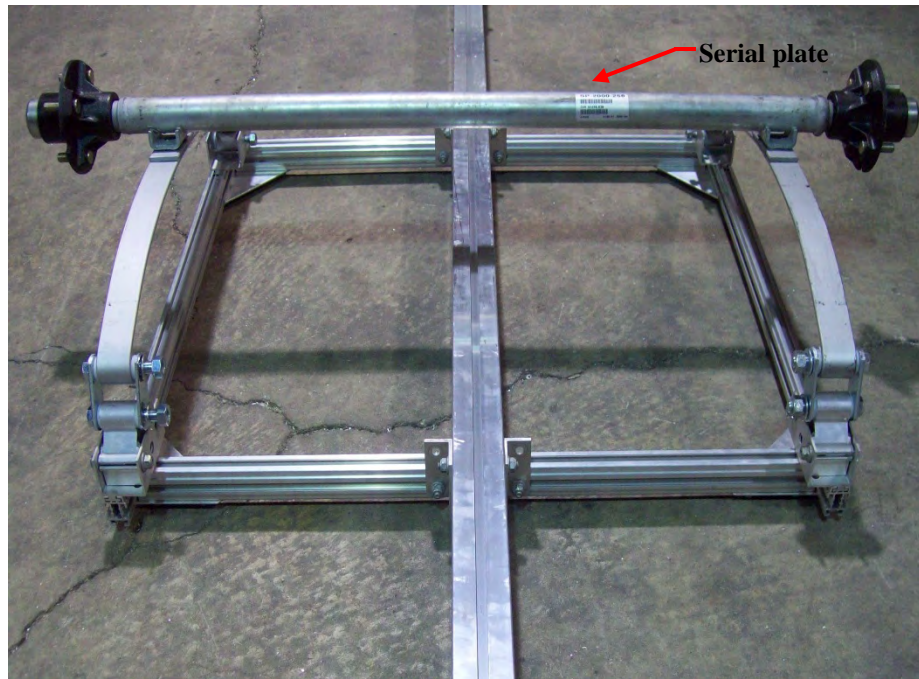


Reinstall nut and bolt but leave loose for now.



Remove the two bolts from the shackle holder at the rear of the spring and install the shackle holder into the rear sub rail clip with the nuts toward the inside of the trailer. These nuts can be tightened at this time.

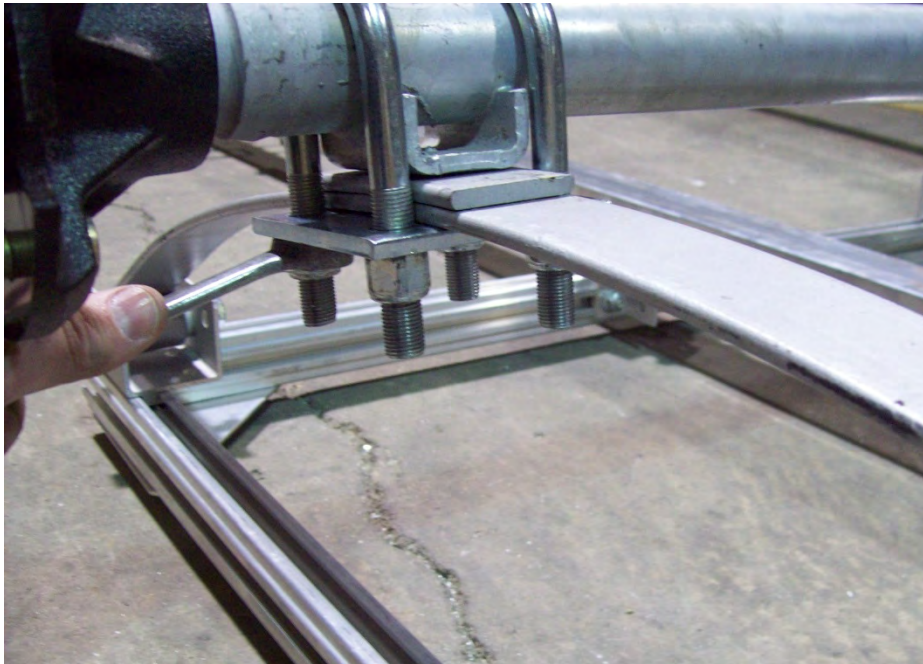
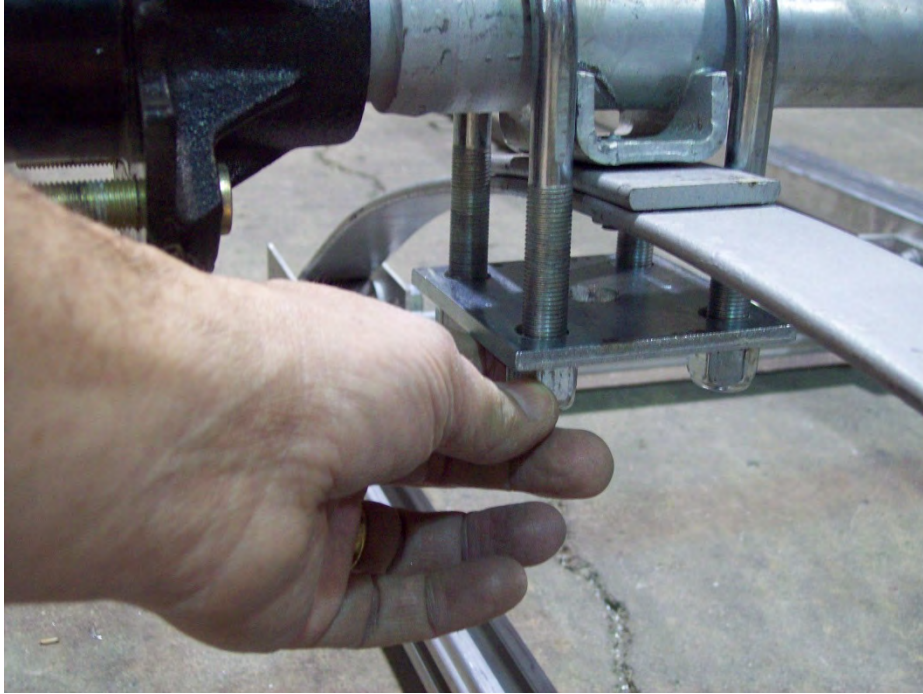




Locate the axle and install it on the springs as shown. Make sure the locating studs on the springs are in the holes on the axle's spring seat. Face the axle's serial plate toward the rear of the trailer to protect it from debris.

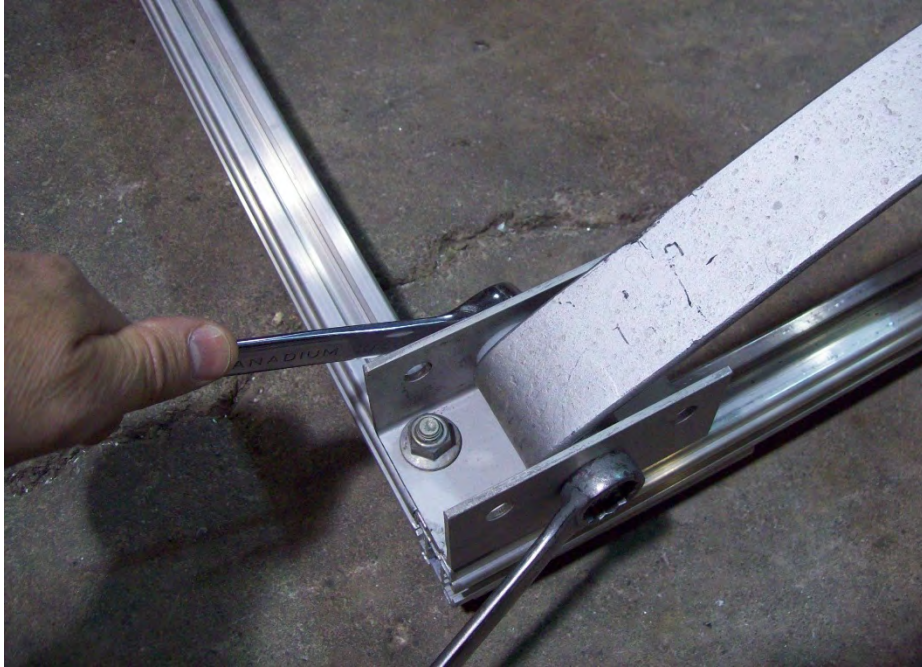


Locate the U-bolts, nuts and tie plates.

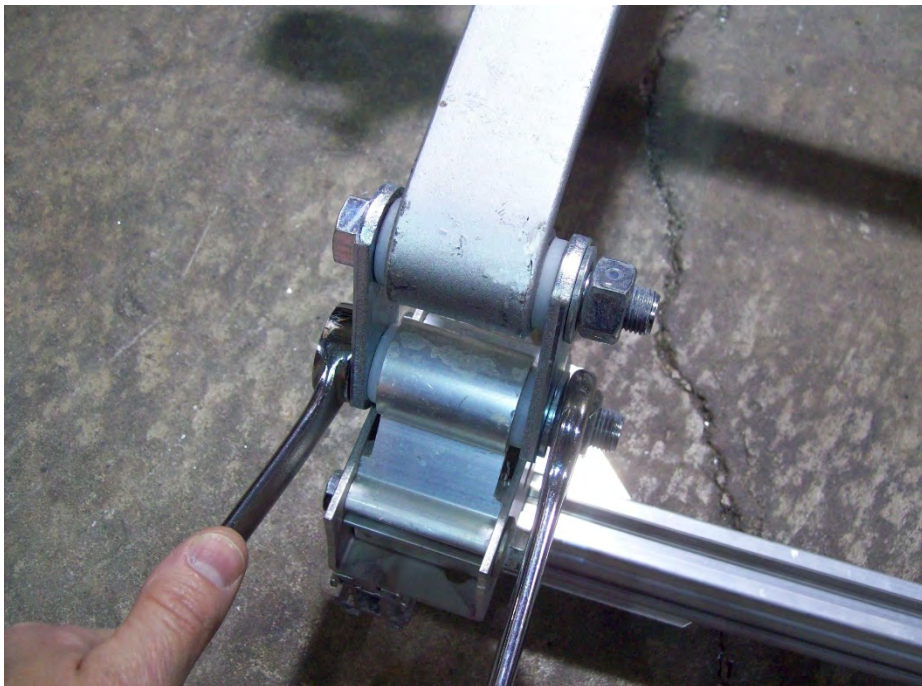


Install the U-bolts and tie plates and nuts. Tighten nuts evenly as shown.





Go back and tighten all the spring mounting nuts that were left loose previously.

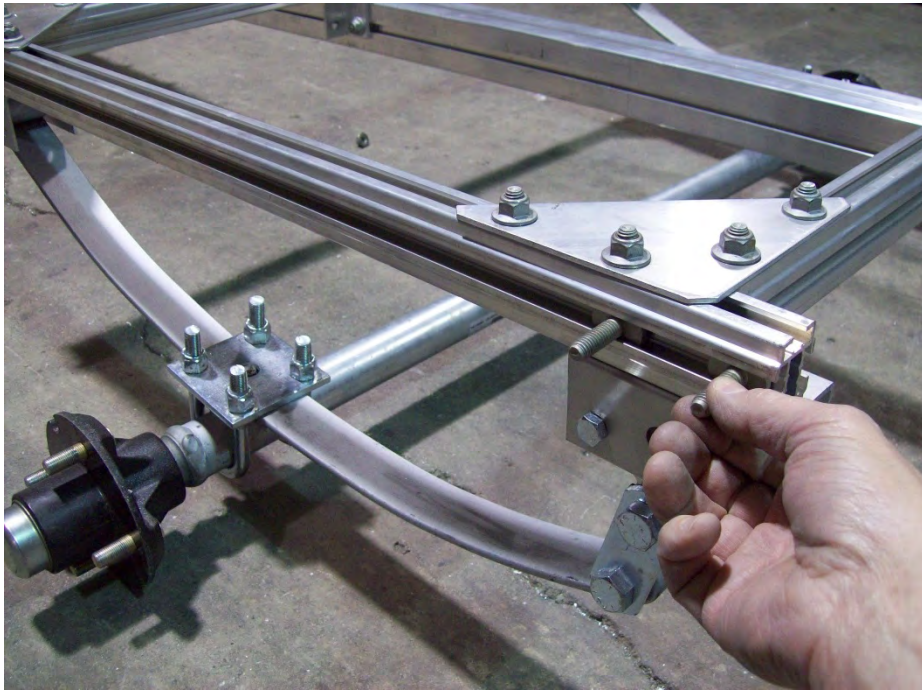


On the rear shackle, do not over tighten as this will not allow the suspension to move properly.

## Fenders

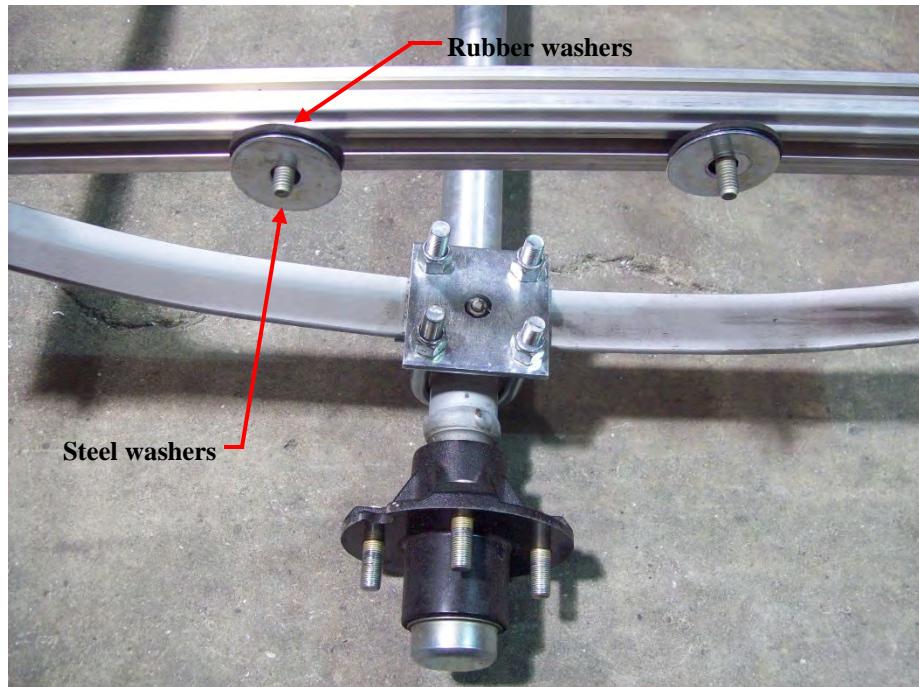


Reuse your old fenders and locate, 8) large steel washers, 4) rubber washers, 4) 1 1/8" T-bolts and 4) nuts from the hardware bag.



Insert two 1 1/8" T-bolts into the side rail.





Slide the T-bolts into position over the tire and install two rubber washers and two steel washers as shown.



Install the fender, two more steel washers, and nuts, center the fender over the axle and tighten the nuts. Repeat for the other side.

## Wheels

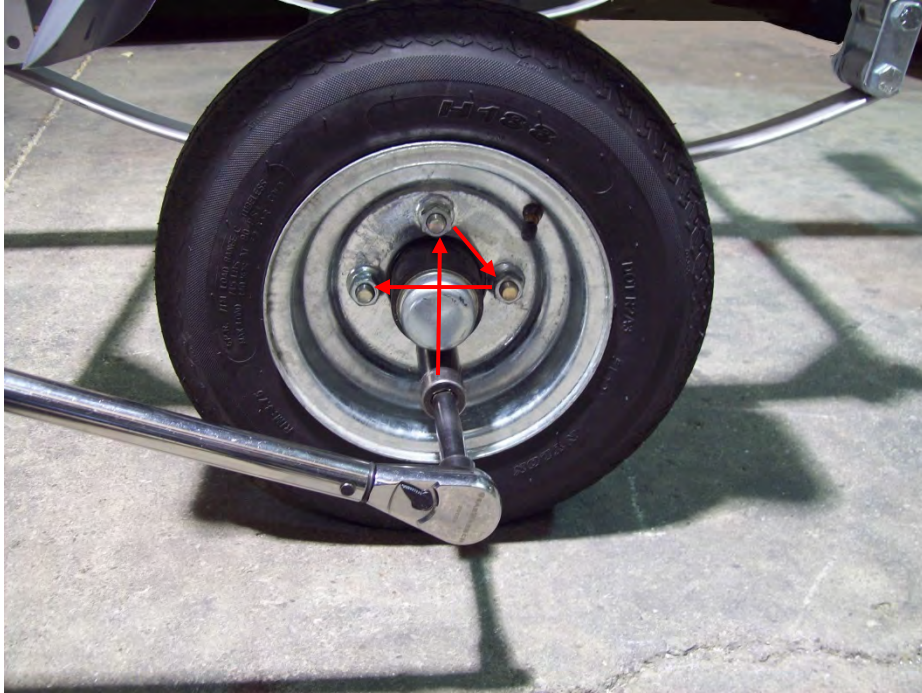


Locate the wheels and the 8) lug nuts.



Install the wheels with the valve stems facing out. Install the lug nuts with the tapered side facing the wheel.



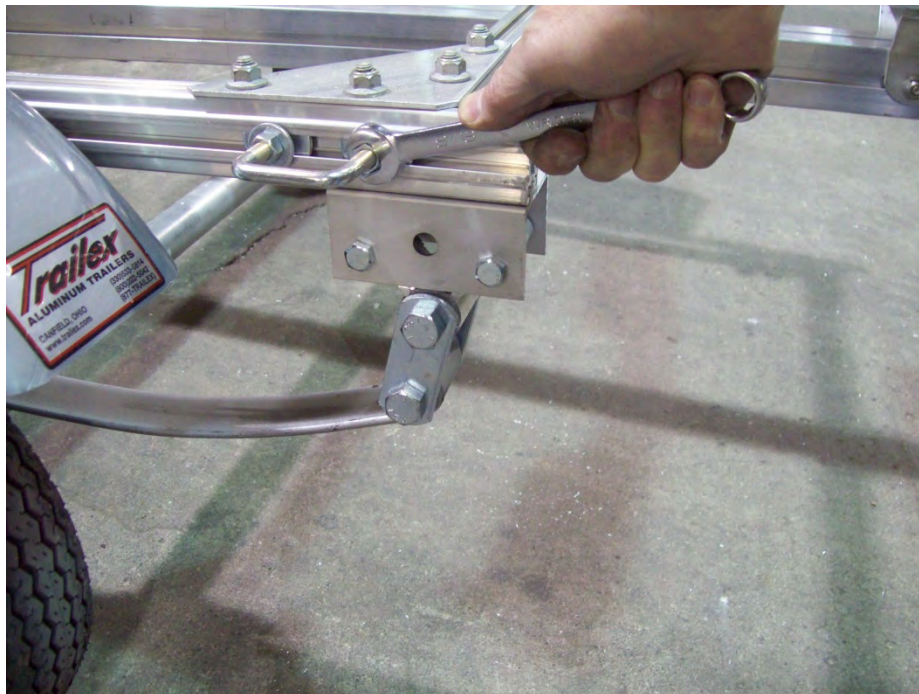


Tighten to 80 foot pounds in a crossing pattern. Re-tighten after 25 miles.

### **Web strap clips**

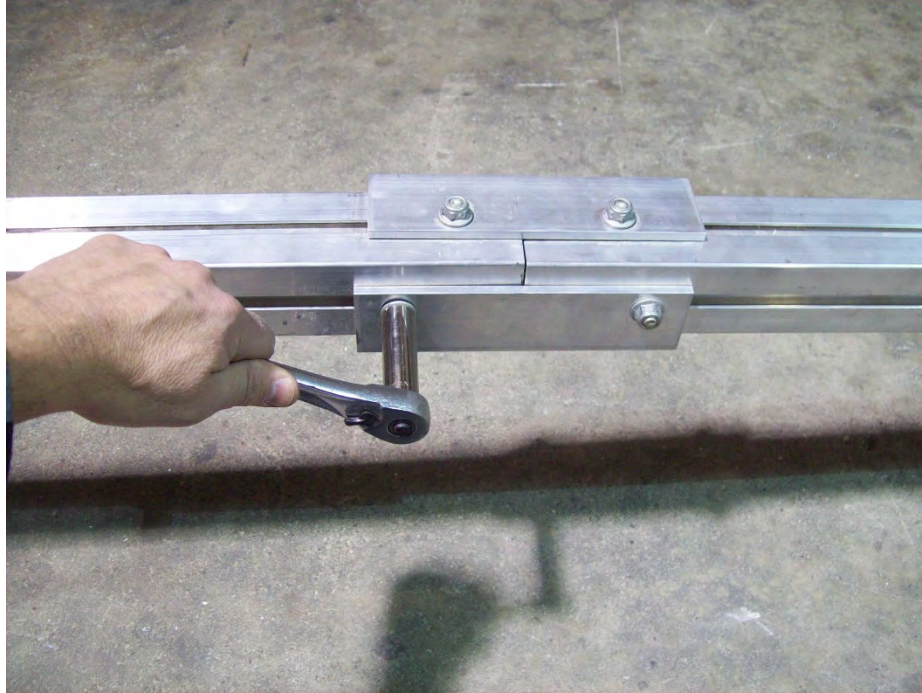


Locate the four web strap clips.

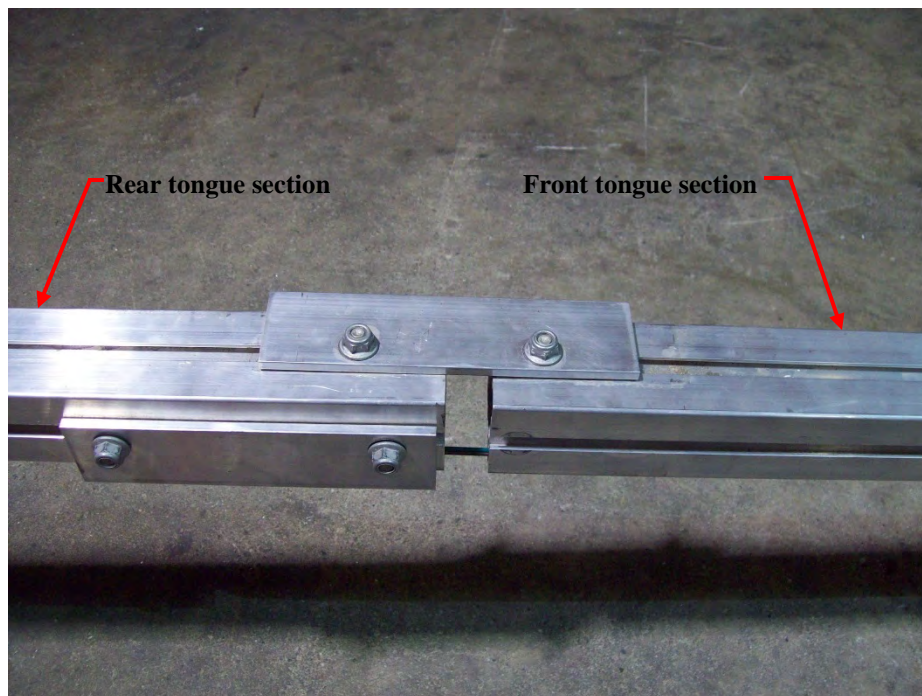


Install a web strap clip on each side rail at the back as shown. Then tighten nuts.

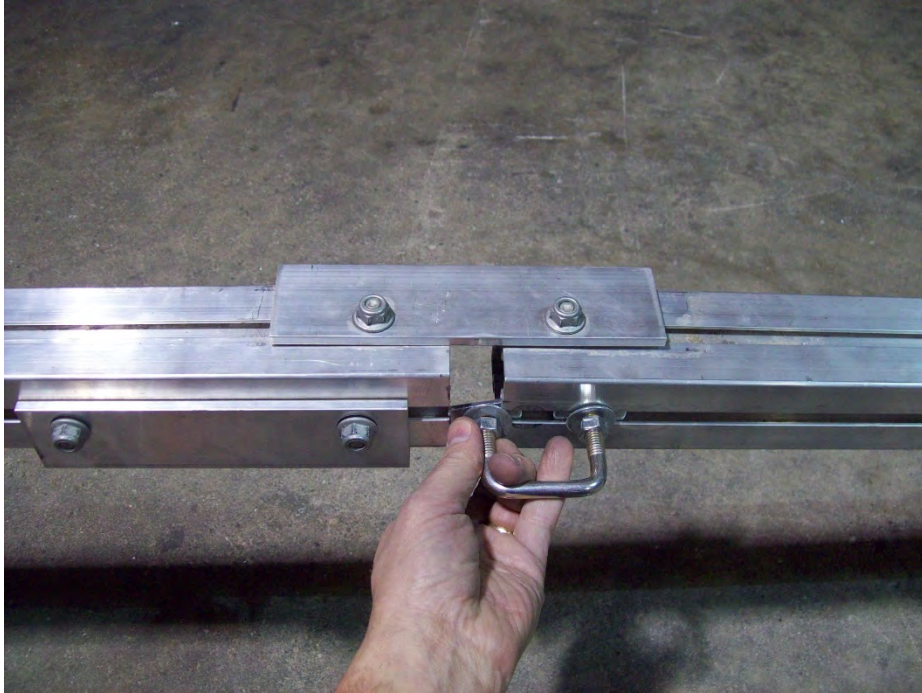




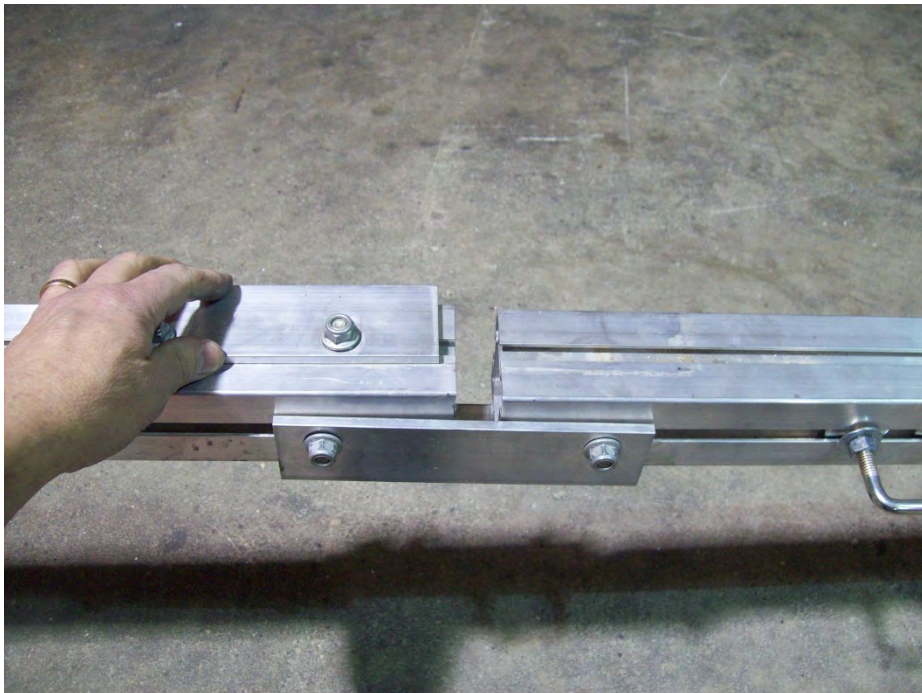
Loosen all the nuts on both of the splice plates.



Slide the bottom splice plate back onto the rear tongue section. Leave the top splice plate attached to both section to hold together. Very carefully separate the tongue just enough to install a web strap clip into the channel.

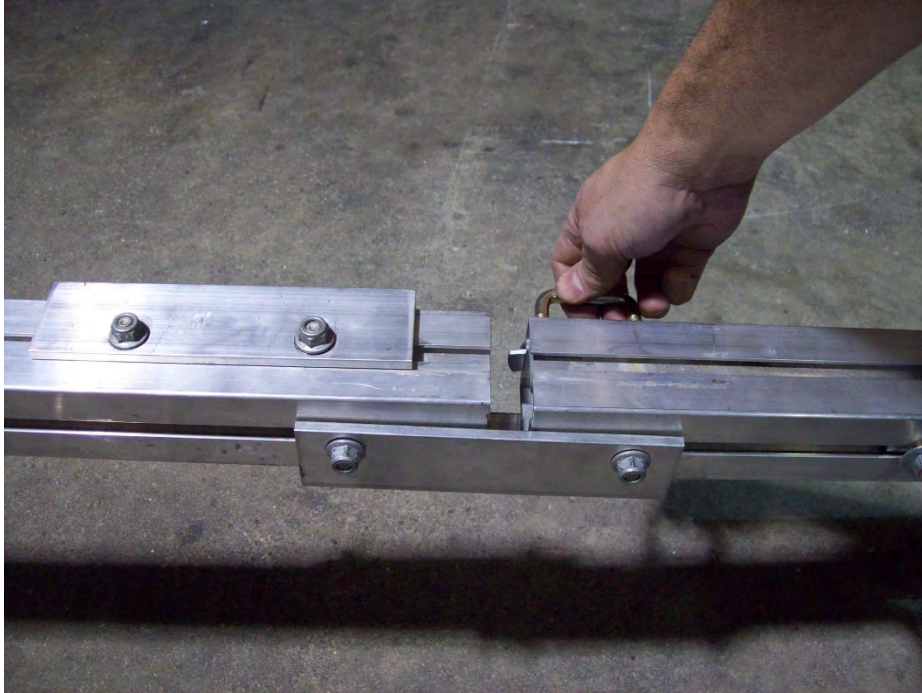


Insert one web strap clip into the channel and slide forward towards the cradle holder.

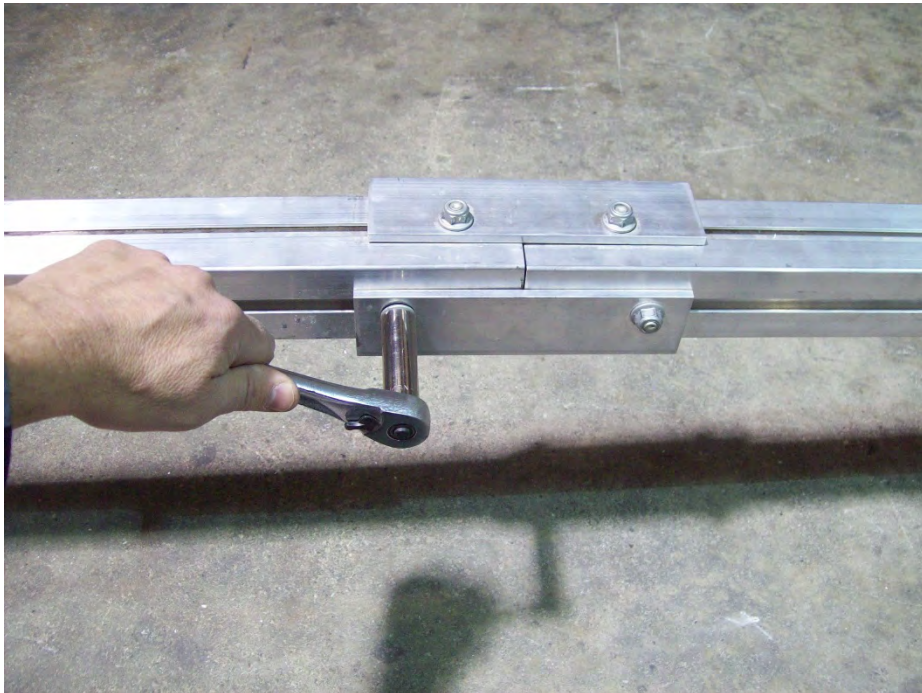


Slide the bottom splice plate back over to the front tongue section connecting both tongues. Take the top plate and slide it back onto the rear tongue section as shown.





Insert the last web strap clip into the channel and slide forward.



Realign the tongue and the splice plates and tighten nuts.



Once web straps are in position tighten nuts. Final adjustments will be made when boat is on the trailer.

### **Finished trailer**







KJM 1/29/14