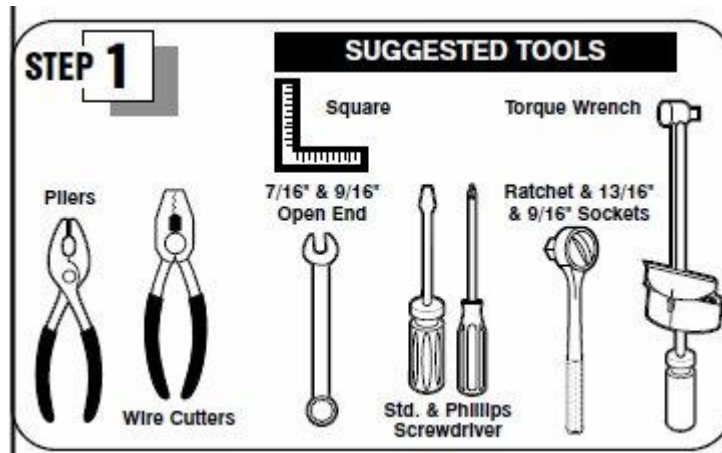


SUT-350-M2



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.



Tongue sections, splice plates, and coupler



Rear cross member

Rear of side rails

Front cross member



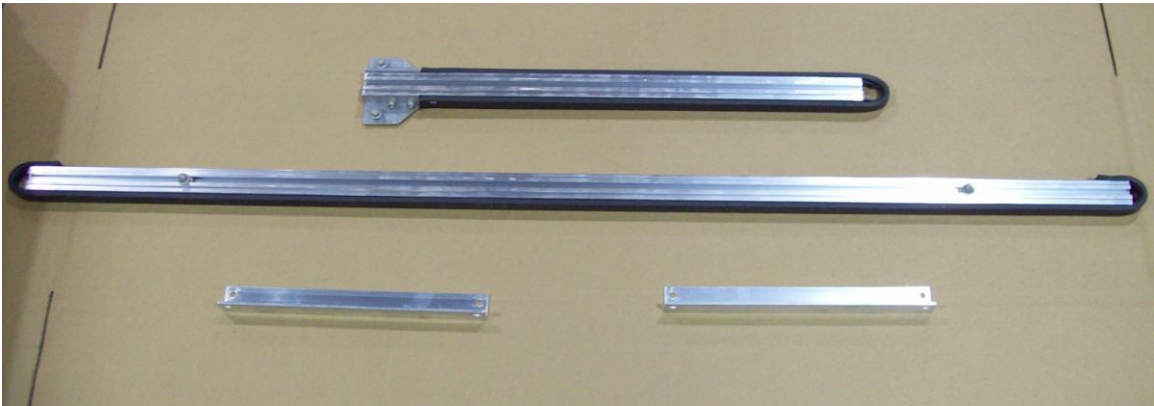
Axle assembly, springs and U bolt hardware.



Fenders and tires



Front crossbar and vertical support



Rear crossbar, vertical support and rear stabilizers



Front post, base braces and side arm braces

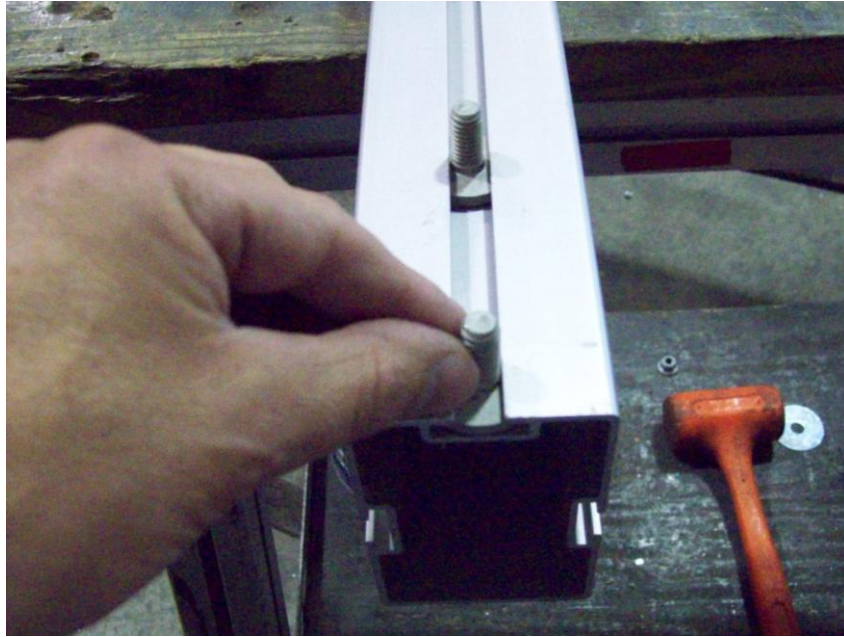


Lights, brackets, harness, and hardware



Skid and side marker bracket

Optional step for spare tire carrier



Slide 2 T-bolts on the underside of the front tongue section that has the serial number on it.



Position carrier about 18" away from the back edge of the tongue section then tighten nuts

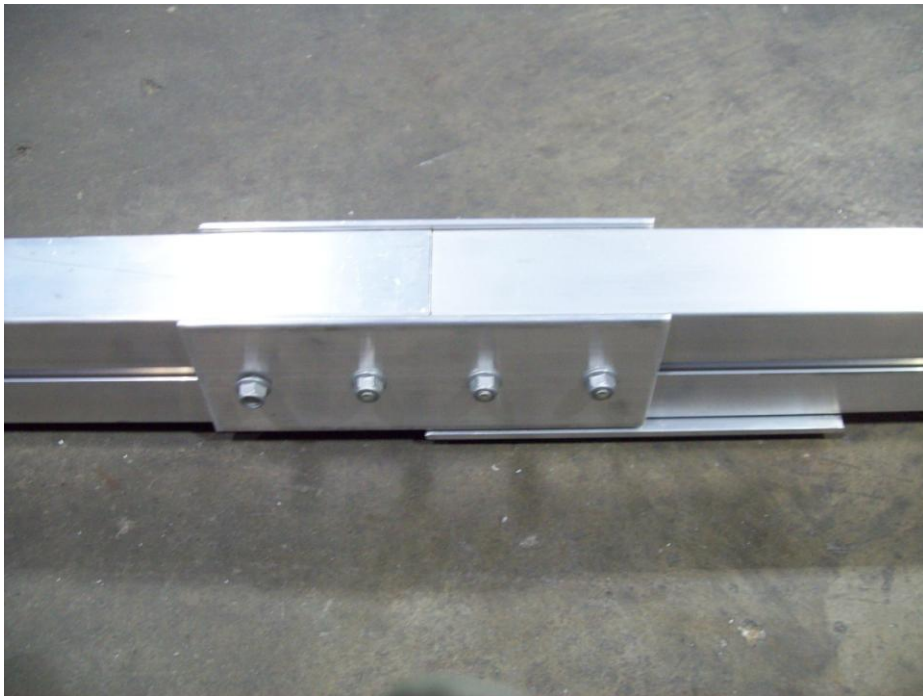
Tongue assembly



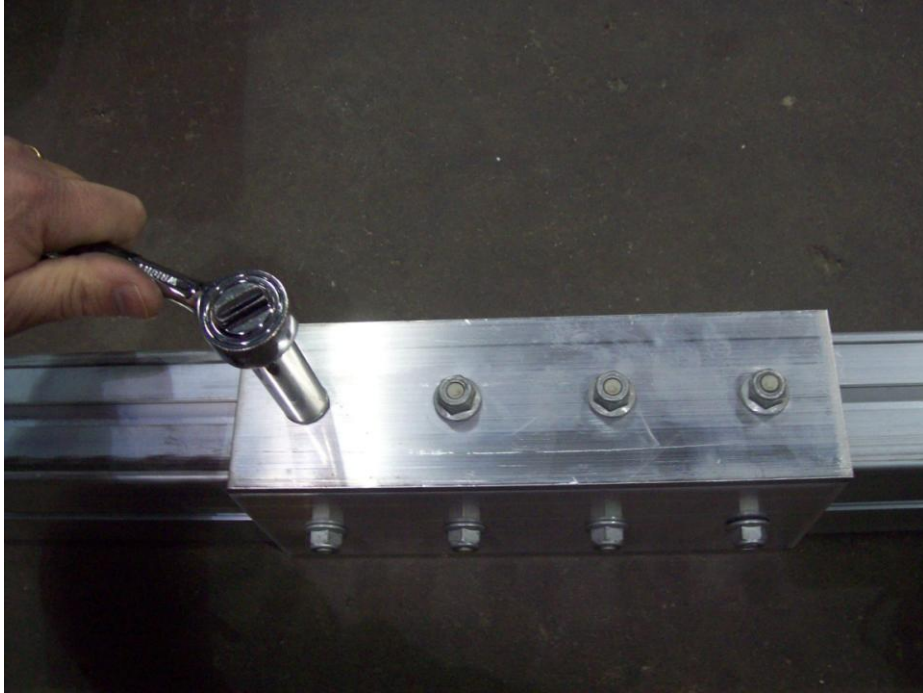
Before assembly of the tongue section find the front post, and take the T-bolts off the base braces, and the side arm braces. Install two T-bolts on each side of the front tongue section before you put the splice plates on.



Attach the three splice plates with T-bolts to the rear tongue section.



Slide 2 side plates over the adjacent tongue section until the plates are centered between the tongue sections. Then tighten nuts.

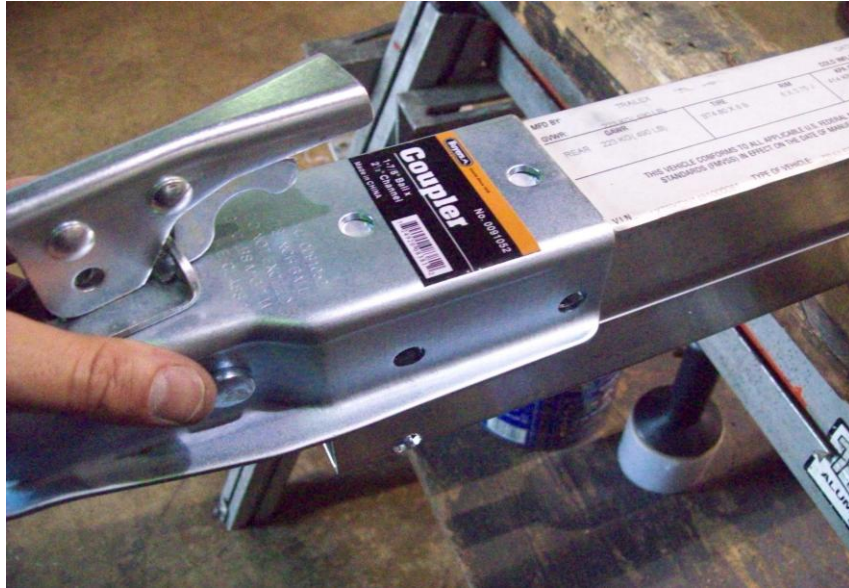


Slide bottom plate over and align with side plates.

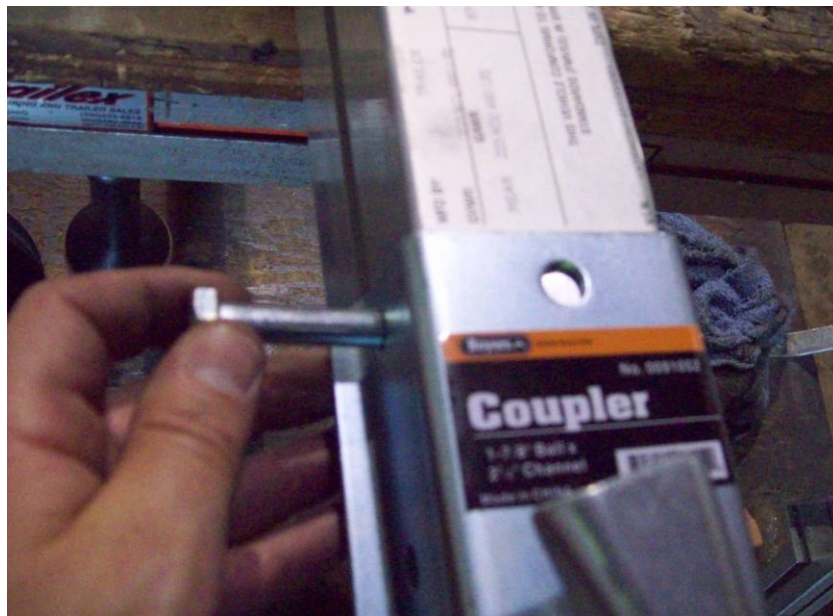


Tighten all 12 nuts making sure that the tongue sections are as tight as possible to one another.

Installation of coupler



Install coupler on tongue section with VIN # on it, holes are pre-drilled in the tongue.



Install a 3 1/4" bolt through the rear hole of the coupler.

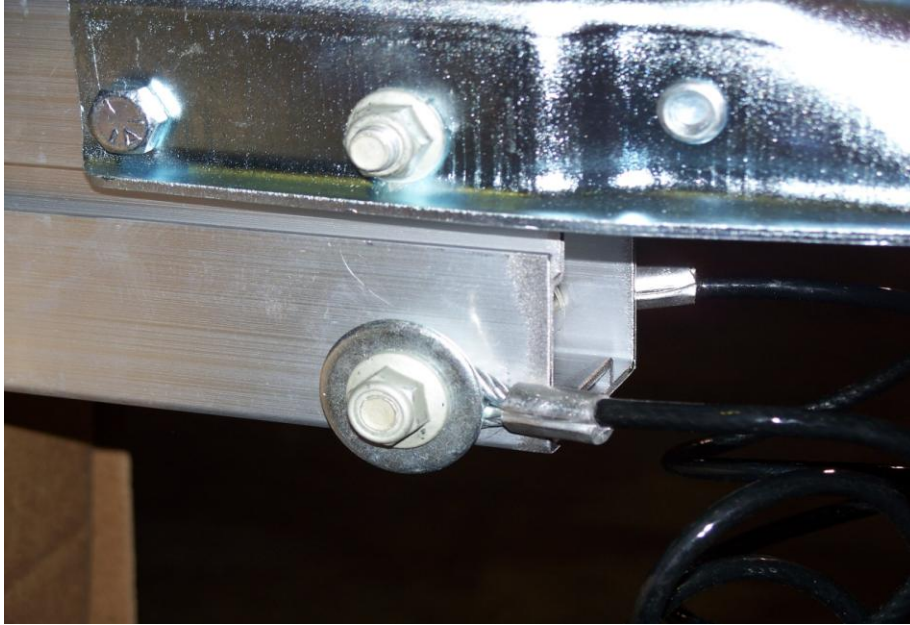


Repair T-bolt 3 1/4" bolt

Install the repair T-bolt on the inside of the tongue to go through the front hole in the coupler. Install nuts and make sure to tighten.



Repair T-bolt Safety hitch cables and hardware



Install the repair T-bolt on the inside of the lower tongue section. Next add the cable over the bolt then a flat washer and then the nut.

Frame Assembly



Install the side rail with T-bolt facing inward into the back of the rear cross member as shown. Repeat the process for the other side.



Add front cross member, which is flush with the end of the side rails.



Once in place, square up the side rails and cross members. Tighten all nuts.

Frame attachment to tongue



Remove the lower T-bolts from all four angle mounting brackets.



Install two T-bolts in each side of the rear tongue section.



Loosen both angle brackets and align the left bracket with the pencil marks on the cross member and tighten. Leave the other loose until you install it on the tongue section.



Rear cross member shown

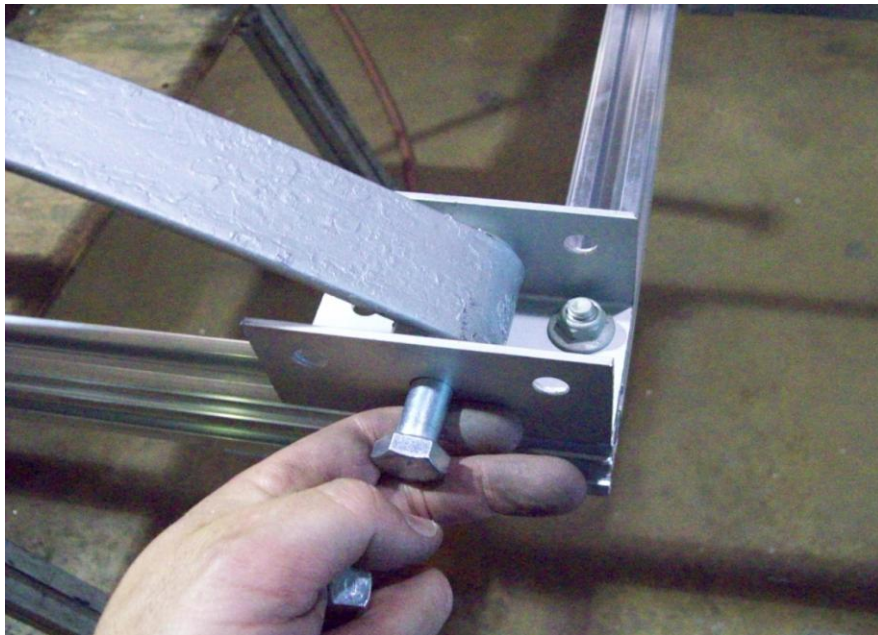
Align the right bracket with the pencil marks on tongue and cross member then install nuts and tighten.



— Rear of trailer

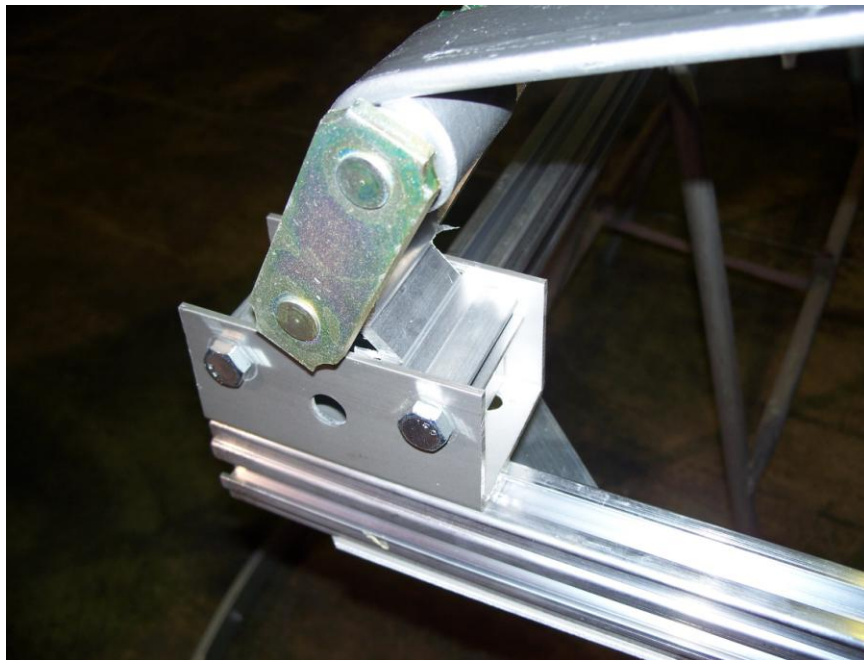
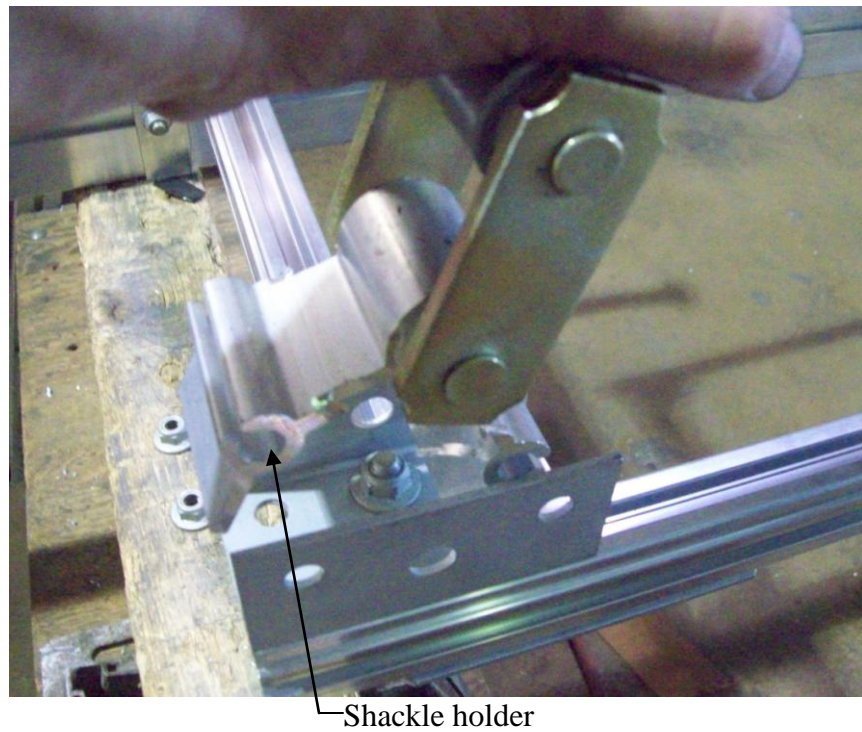
Frame should look like this when attached to tongue section.

Spring Installation



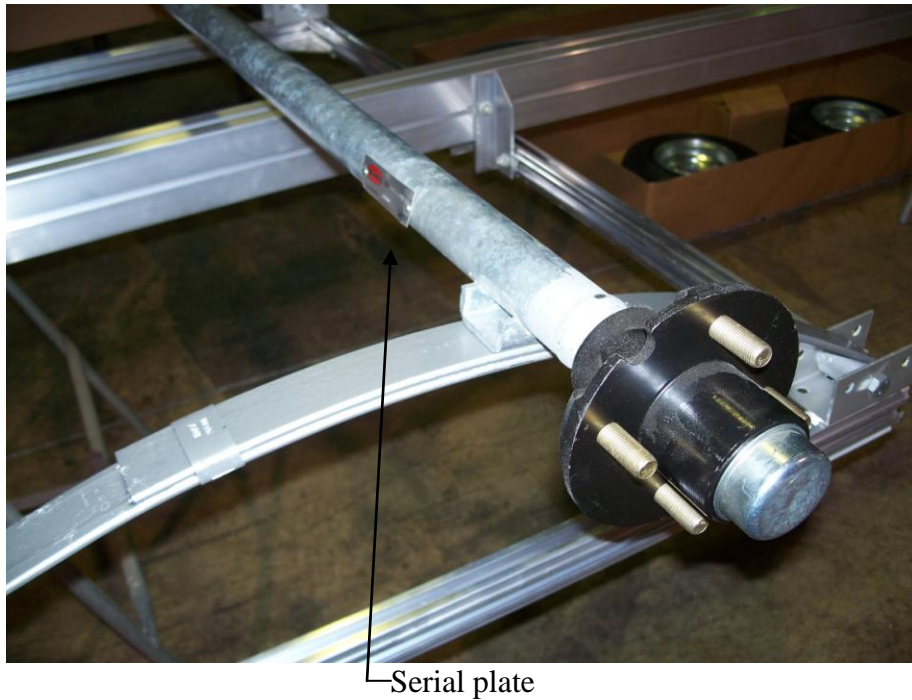
Trailer shown flipped over

Remove the bolt from the front spring eye and install the spring into the spring hanger in the center hole with the nut towards the inside of the trailer. Do not tighten yet.



Remove the two bolts from the shackle holder at the rear of the spring and install the shackle holder into the rear spring hanger with the nuts toward the inside of the trailer then tighten the nuts. Do not tighten the shackle nuts yet.

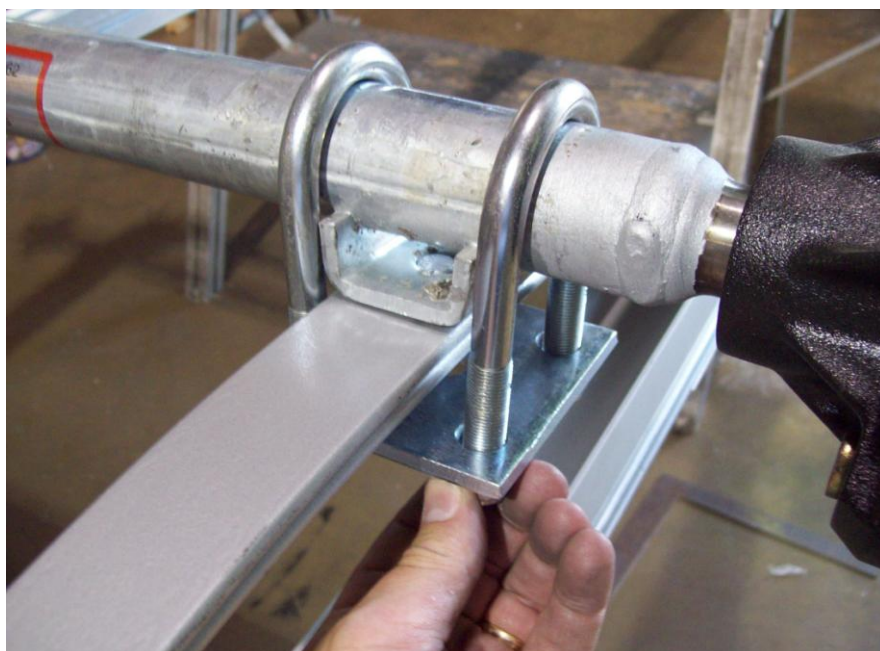
Axle Installation



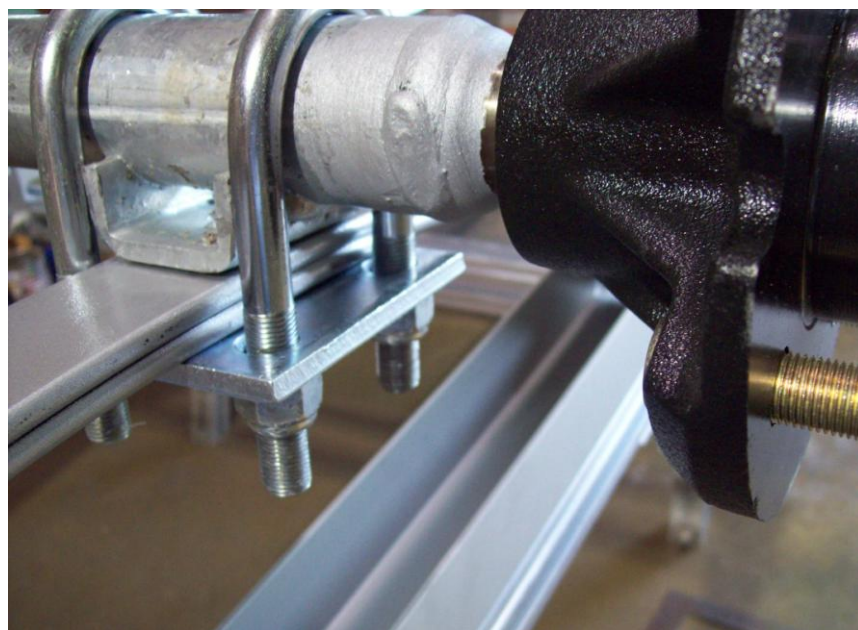
Locate the axle and install it on the springs as shown. Make sure the locating studs on the springs are in the holes on the axle's spring seat. Face the axle's serial plate toward the rear of the trailer to protect it from debris.



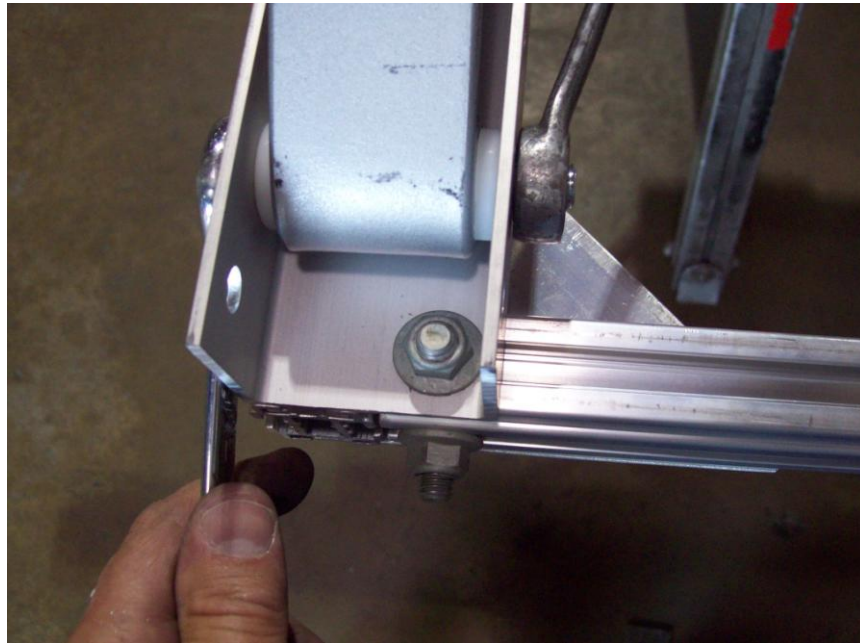
Locate the U-bolts and tie plates.



Install the U-bolts and tie plates as shown.



Install the nuts and tighten them evenly.

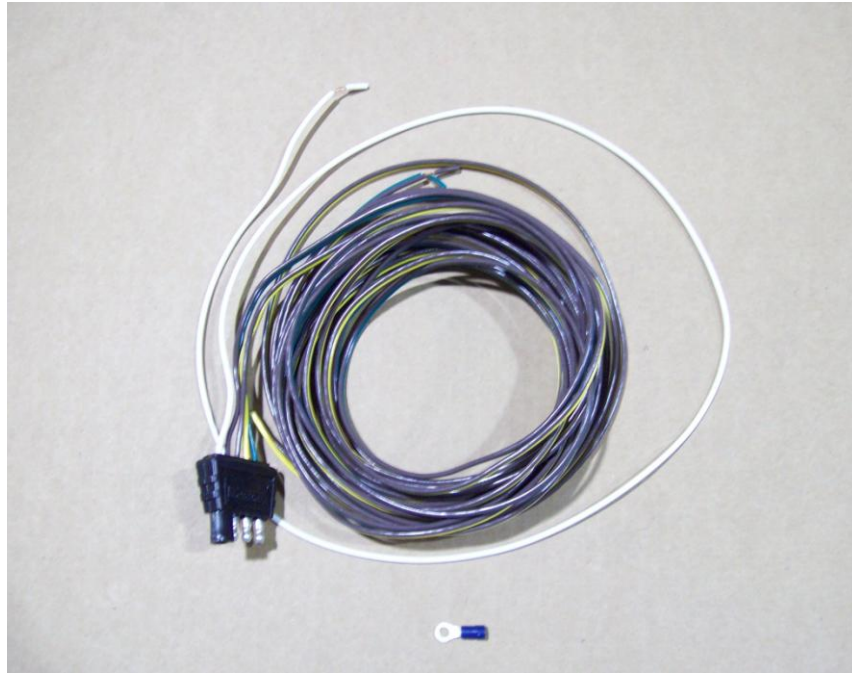


Go back and tighten all of the spring mounting nuts that were left loose previously.

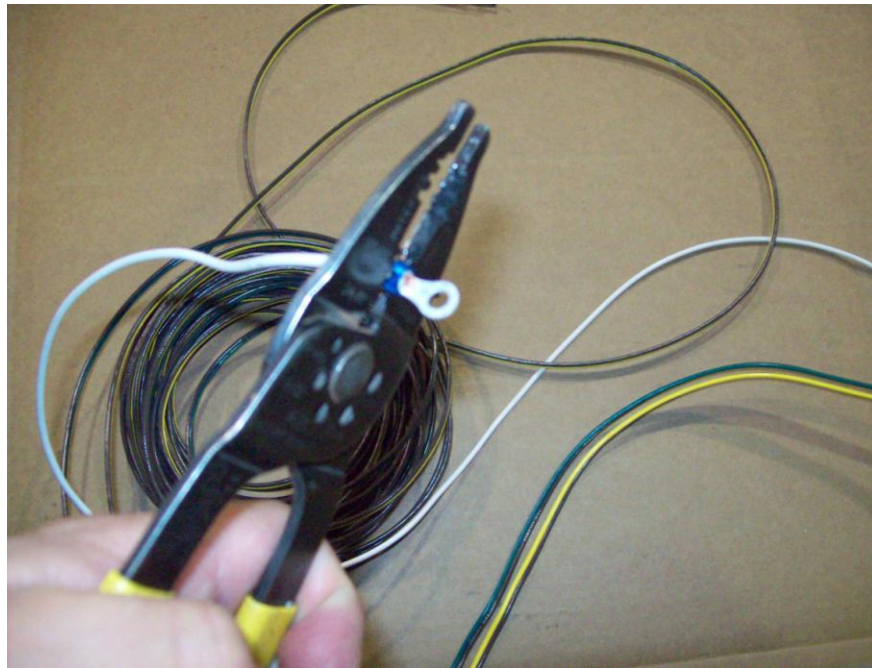


On the rear shackle, do not over tighten as this will not allow the suspension to move properly.

Wiring



Locate harness and ring terminal.



Strip the white ground wire and install the ring terminal.



Locate the $\frac{3}{4}$ " long Philips screw.



Install Philips screw through the ground wire into the pre-drilled hole located under the tongue just behind the coupler.



Extend a tape measure inside the tongue from the rear of the trailer until it protrudes at the front of the trailer under the coupler.

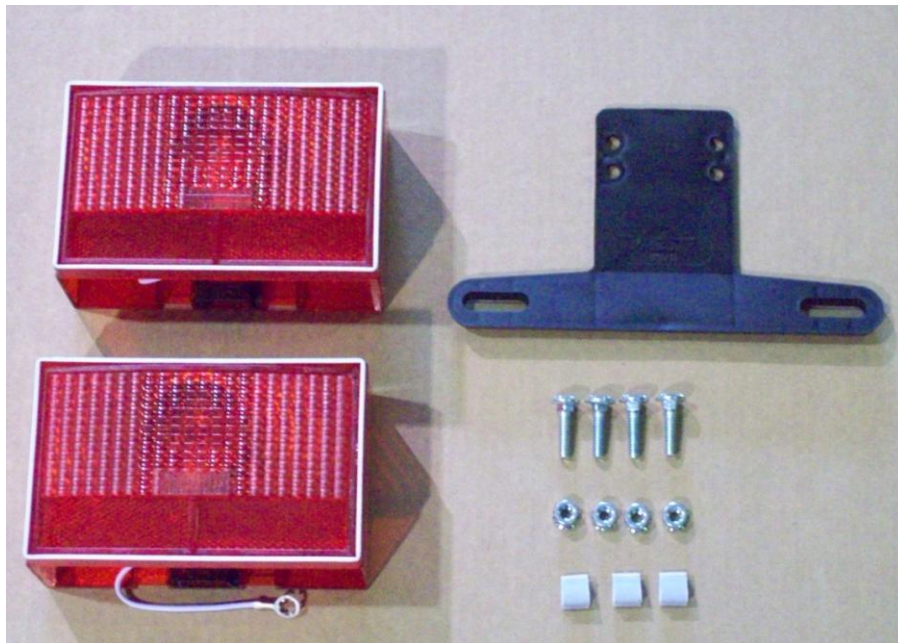


Attach both wires of the harness to the end of the tape measure with either tape or a tie. Retract the tape measure until it comes out the back of the tongue with both wires attached.

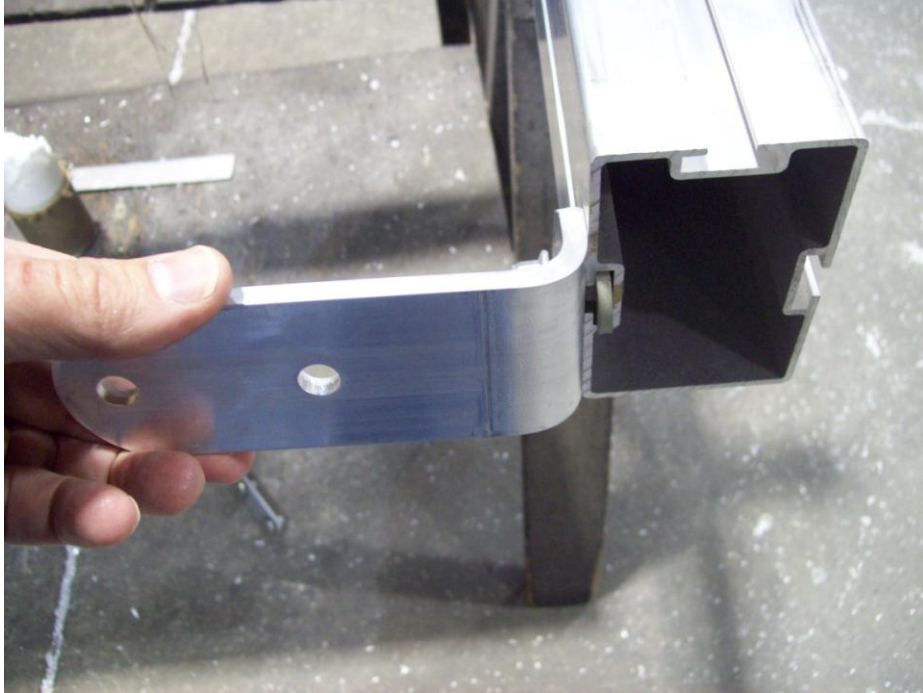
Installation of tail light and light brackets



Locate the tail light brackets.



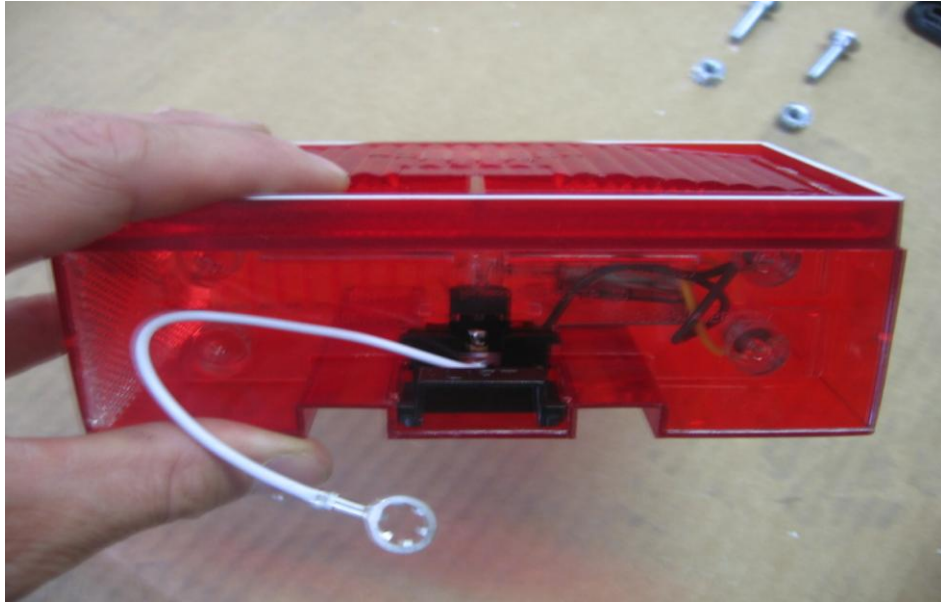
Locate the tail lights, carriage bolts, nuts and license plate bracket.



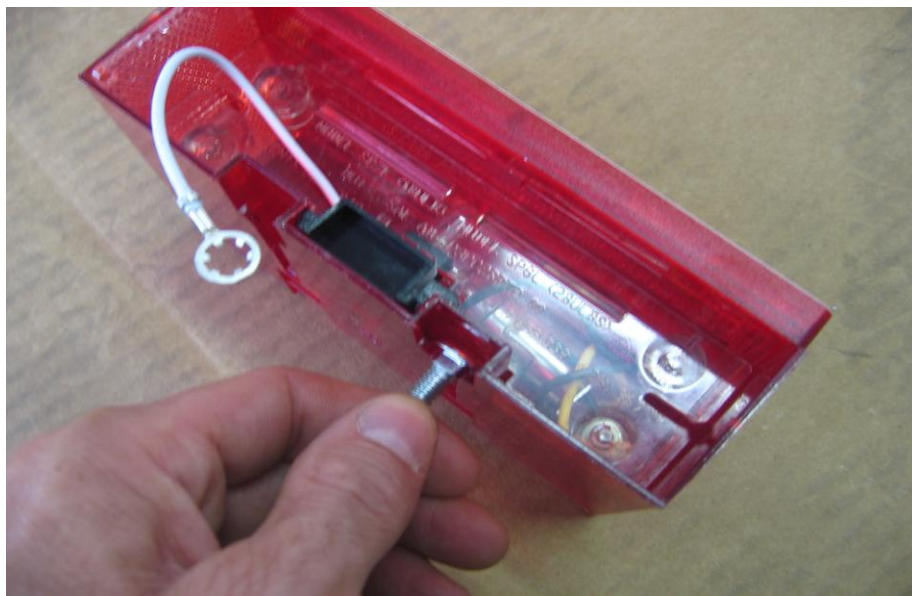
Install the tail light brackets from the rear of the tongue as shown.



Position the tail light brackets 8" from the rear of the tongue.



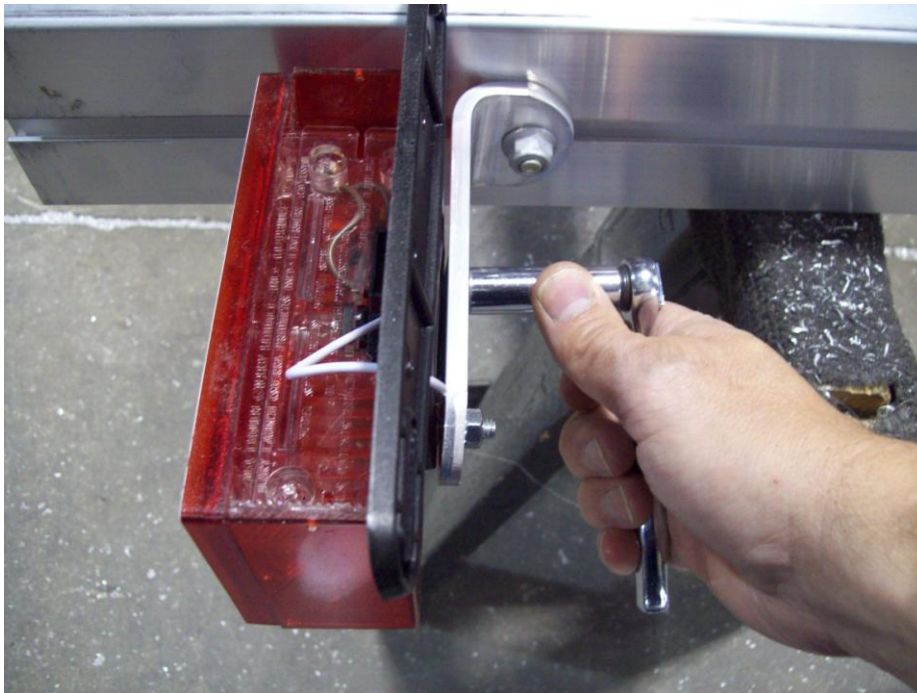
The light with the yellow wires is for the left (driver's side) of the trailer.



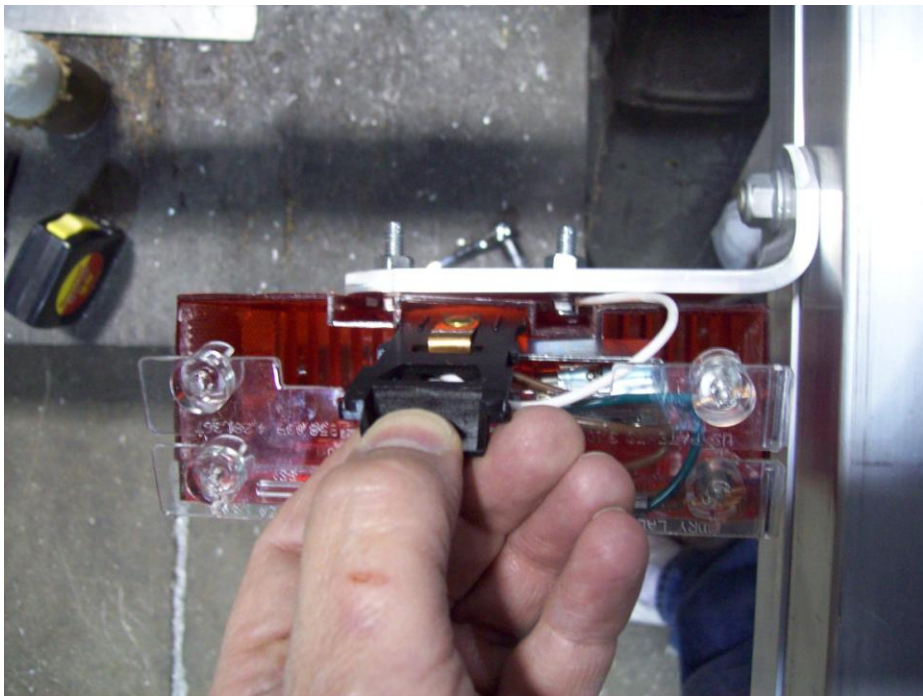
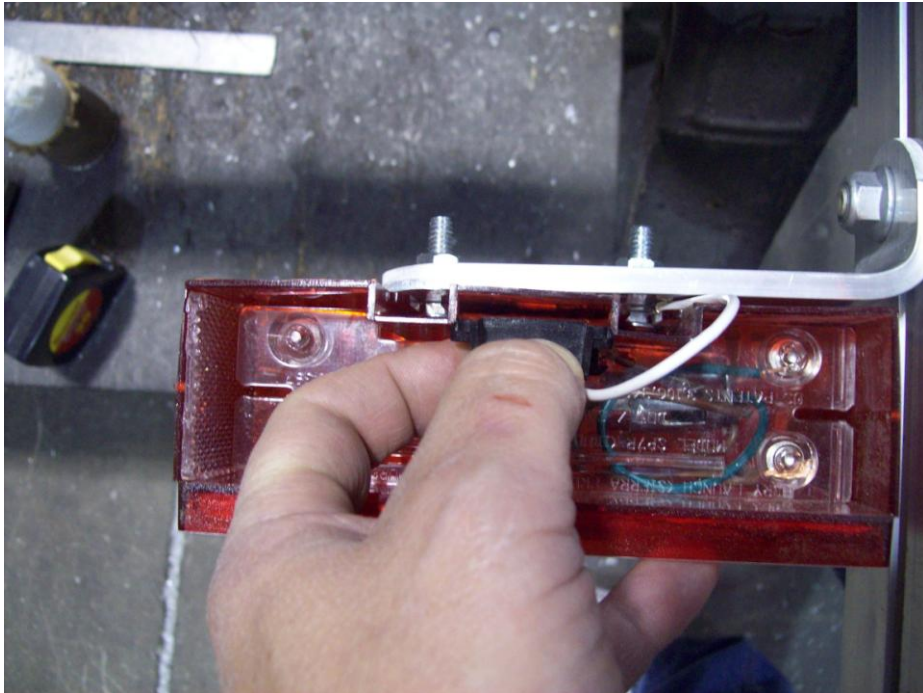
Slide the carriage bolts into the slots in the back of the tail lights until they lock in place.



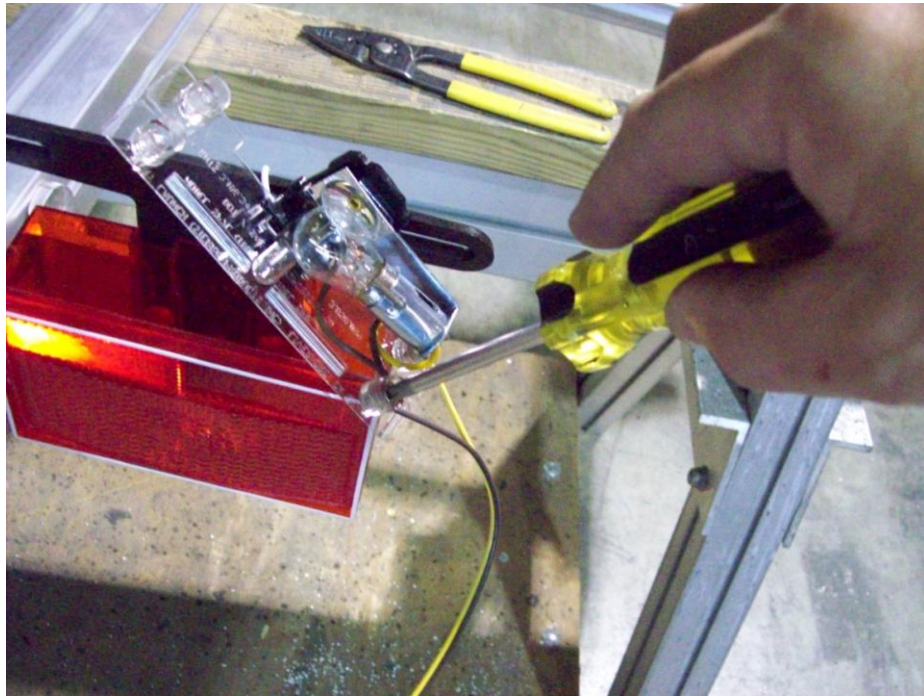
Repeat the process for the right side as shown.



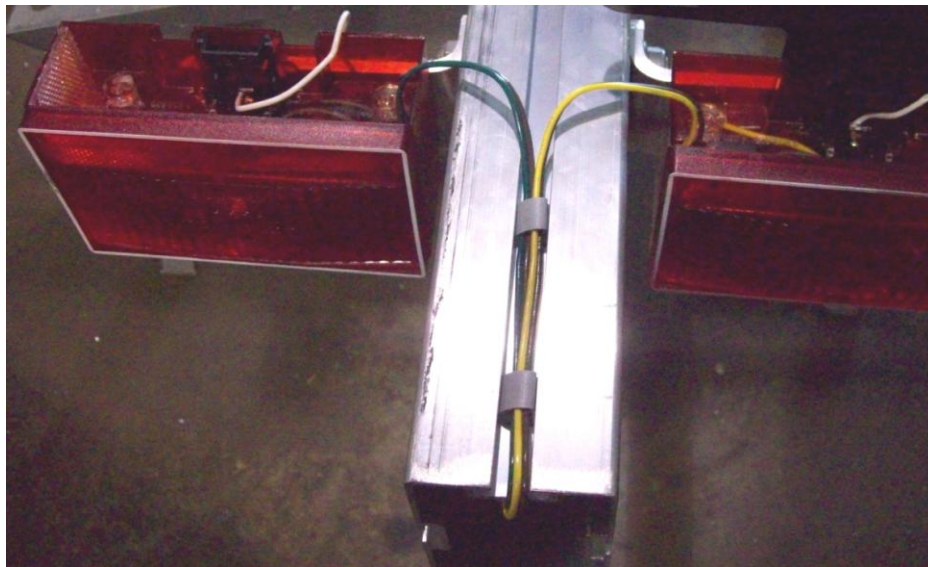
Install the left tail light with the license plate holder between the light and the bracket. Repeat for the other side. Make sure to tighten nuts but don't over tighten them.



Locate the black tab at the bottom of the tail light. Move the tab toward the rear of the trailer and pull up releasing the bulb assembly from the light housing.

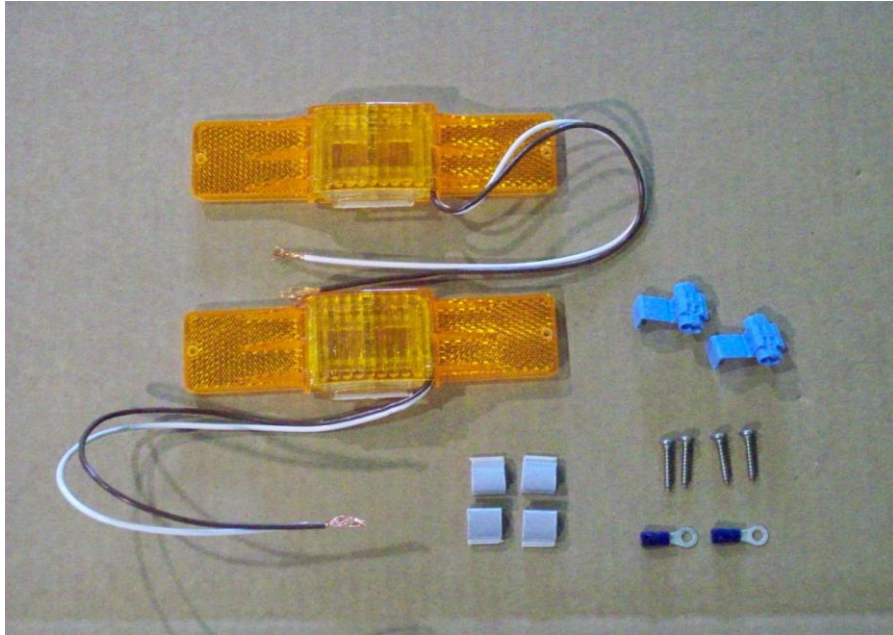


Loosen the wire retaining screws and install the color matching wires from the wire harness onto the corresponding retaining screws.



Re-install the bulb assembly into the light housing making sure to route the wires through the slot in the base of the bulb assembly. Install adhesive backed clamps in the locations shown and route the wires through them.

Side marker lights, bracket and skid



Locate the two amber side marker lights, four small Philips screws, adhesive backed clamps, two ring terminals, and two blue connectors.



Cut approximately 8 ½" off of the white wires on both side marker lights.



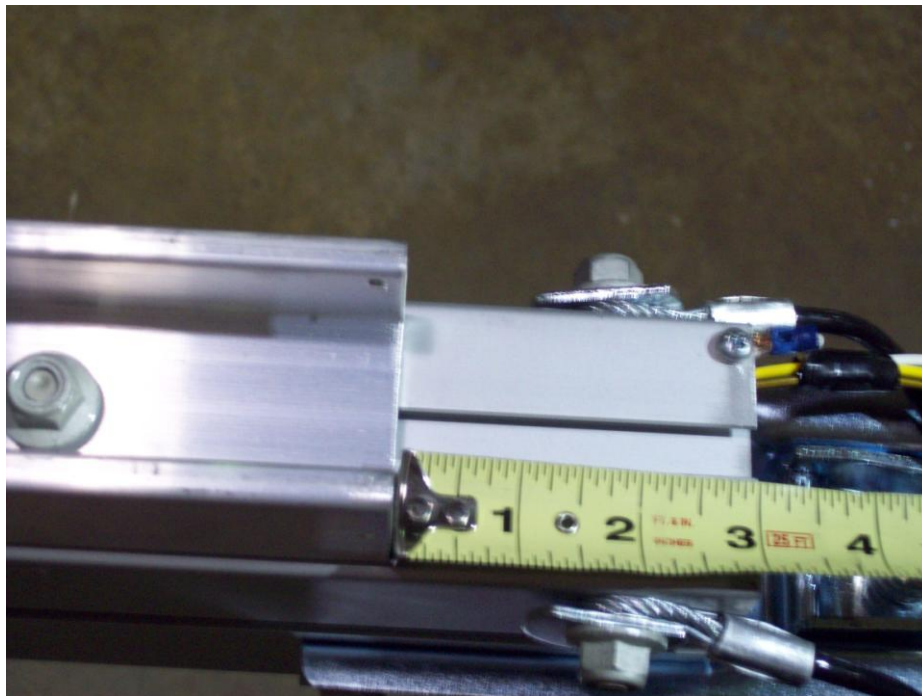
Strip 1/4" of insulation from the wire.



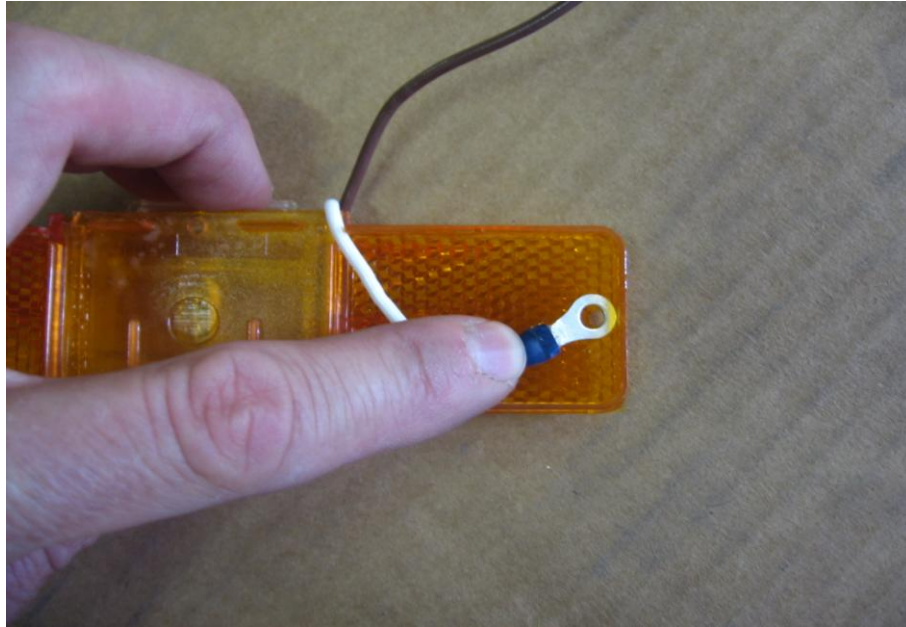
Install the ring terminals by crimping the terminal onto the bare wire.



Locate the skid and light bracket.



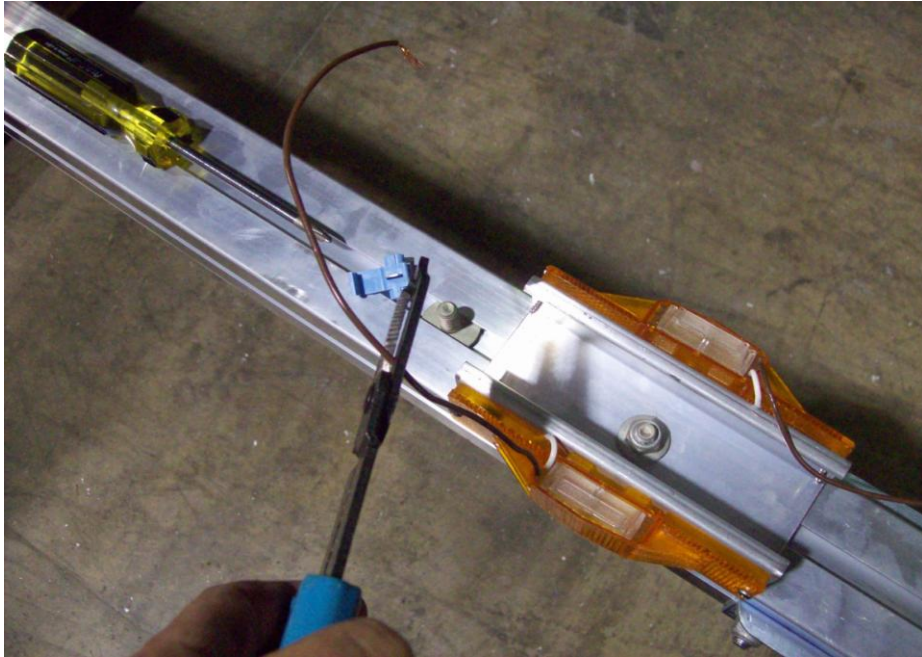
Take one T-bolt off the skid and slide it in the bottom of the tongue. Then install the bracket for the lights and position it 3" from the end of the tongue as shown. Tighten the nut.



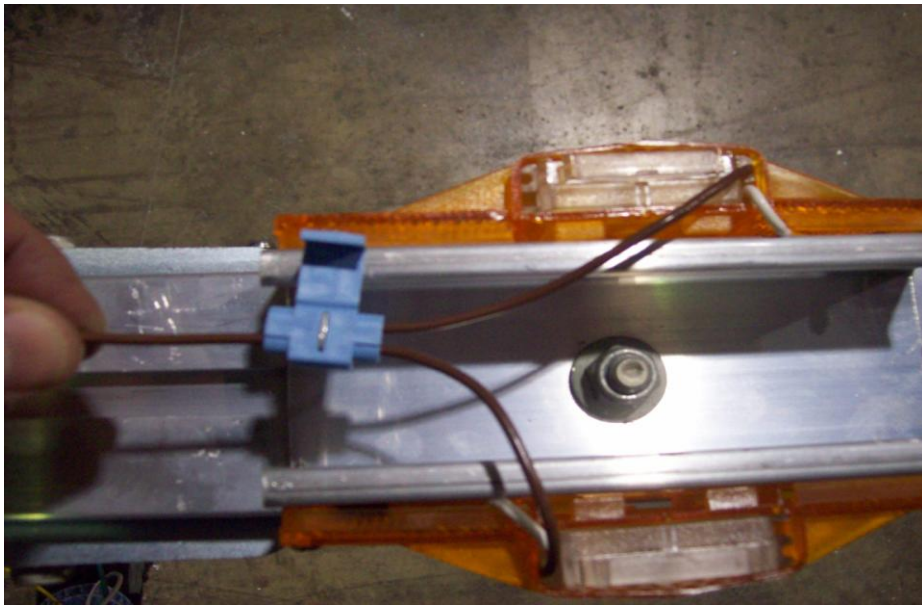
Align the ring terminals with the screw hole nearest the wire on the back of the side marker light. Make sure the wire is routed through the gap on the back of the light so it does not become pinched when the light is installed



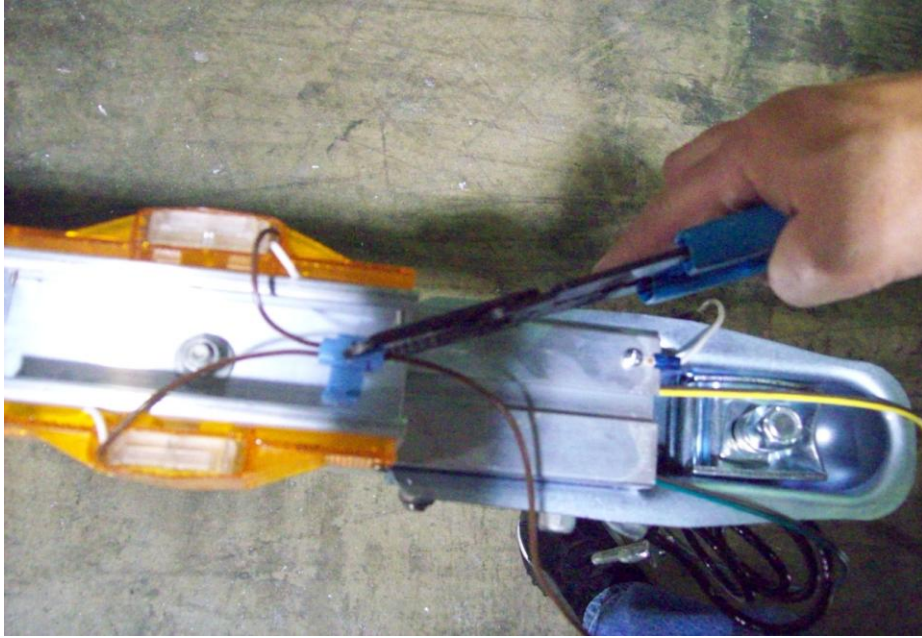
Install the side marker lights into the pre-drilled holes in the light bracket using a Philips screwdriver. Be sure the screw is through the ring terminal on the back side of the lights. This will supply a ground to the lights. DO NOT OVER TIGHTEN



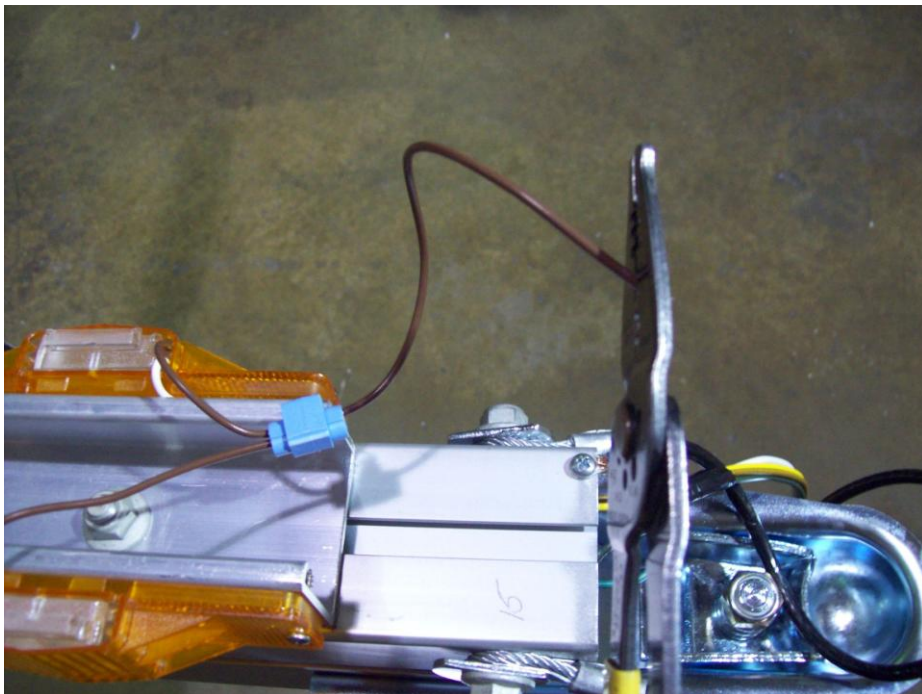
Cut 6" off of the brown wire on the left (driver's side) marker light. Do not strip the wire.



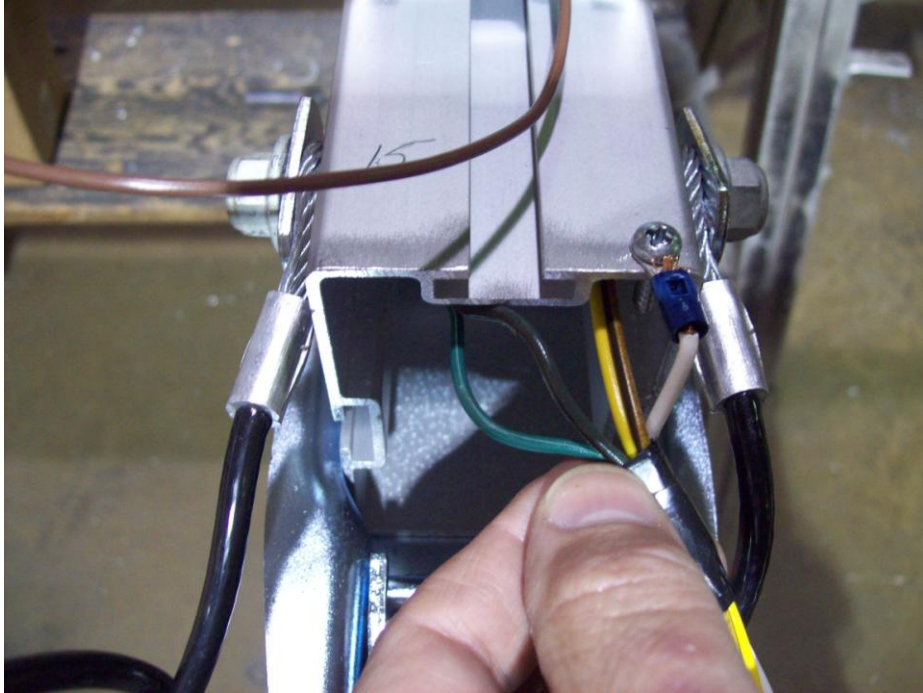
Insert brown wire that has been cut into the hole in the connector closest to the hinge. This hole does not pass all the way through. The wire should go in about $\frac{1}{2}$ ". Pass the other wire through the remaining open slot in the connector at a point close to the side marker light.



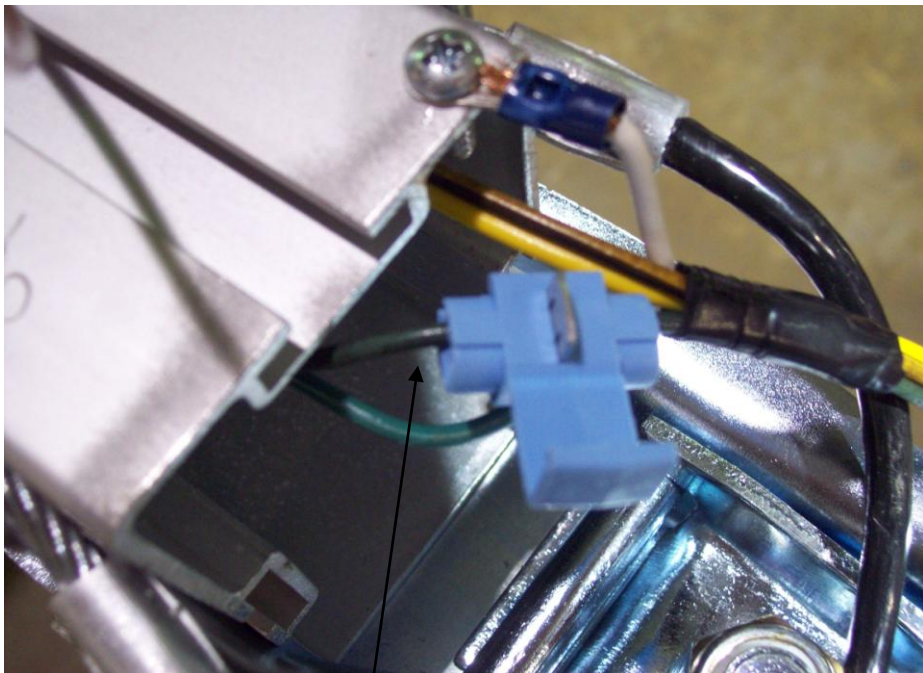
Use pliers to push the metal spade down until it is flush with the plastic. This is what makes the electrical connection between the two wires. Close the plastic cover of the connector over the spade until it snaps into position.



Cut the exposed strands of wire off of the end of the brown wire on the right (passenger side) marker light.

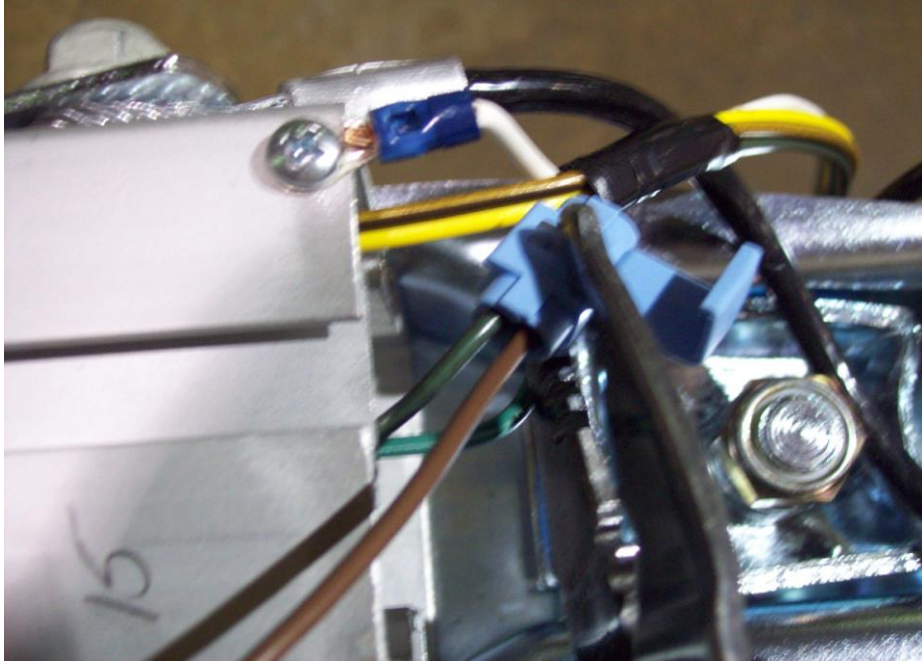


Now separate the brown and green wire on the harness right by the end of the tongue section.

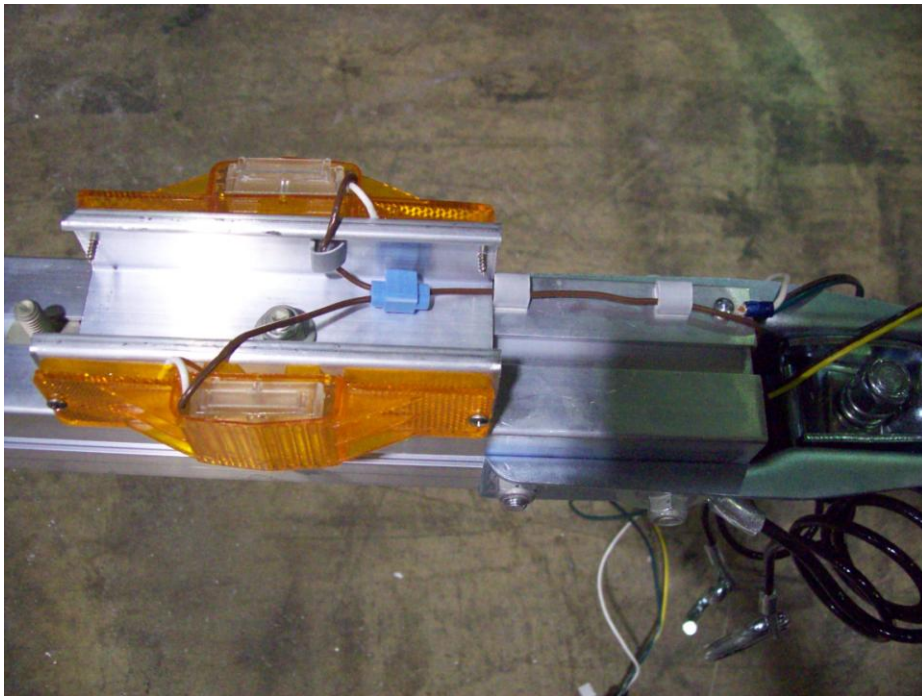


— Brown wire

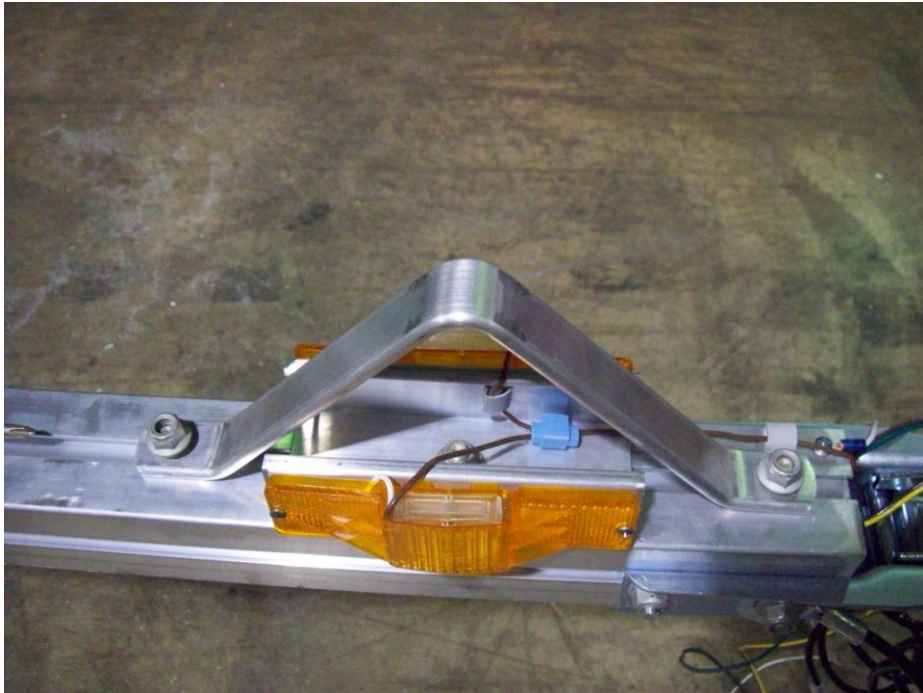
Insert the brown wire from the harness through the open slot in the blue connector.



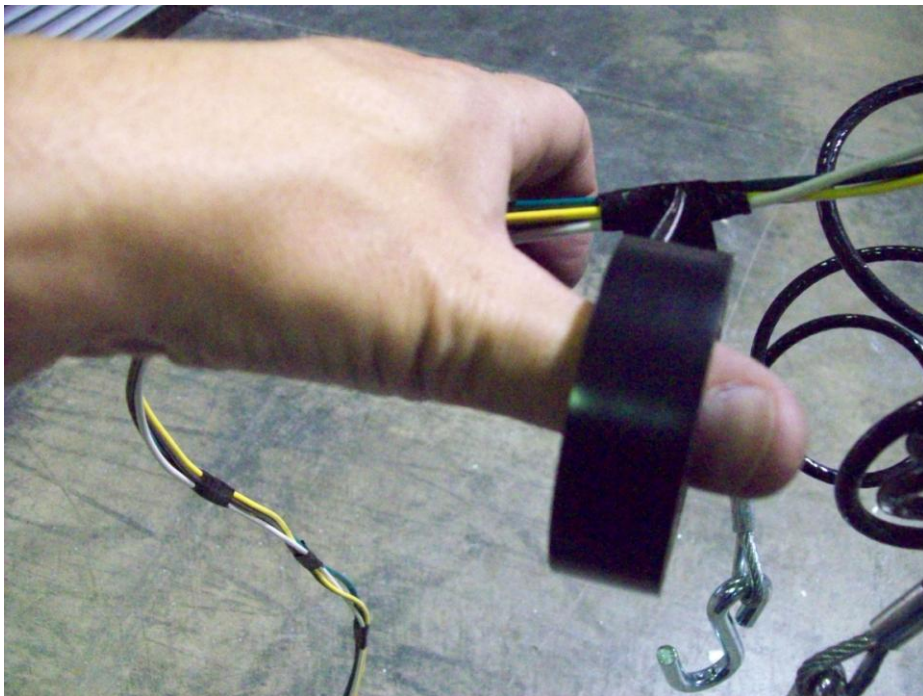
Insert the brown wire from the side marker lights into the closed side of the connector. Then use pliers to push metal spade down until flush with the plastic. Close the plastic cover of the connector over the spade until it snaps into position.



Locate the adhesive backed clamps. Install them as shown and run brown wire from the side marker lights through them.



Install the skid on the front tongue section. Tighten the nuts for the skid in the location as shown.



Tape wiring as shown



Your wiring harness should look like this when finished.

Fender Installation



Locate fenders, washers, T-bolts, and nuts.



Locate (2) 1 1/8" T-bolts from the hardware bag and install them into the side rails. Slide them 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 hub and tighten the nuts. Repeat for the other side.

Wheel Installation



Locate 8 lug nuts, and wheels.



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

Front Crossbar Installation



T-bolts previously taken out on page 7
Locate the front post.



Attach the front post to the two T-bolts on each side of the tongue section with the side arm braces facing forward. Then adjust braces and tighten nuts.



Locate the front crossbar and vertical support.



Remove the two nuts from the T-bolts on the crossbar. Then position the center crossbar T-bolt with the front of the post and slide down until the other bolts line up with the side angle braces.



Attach nuts and then tighten.

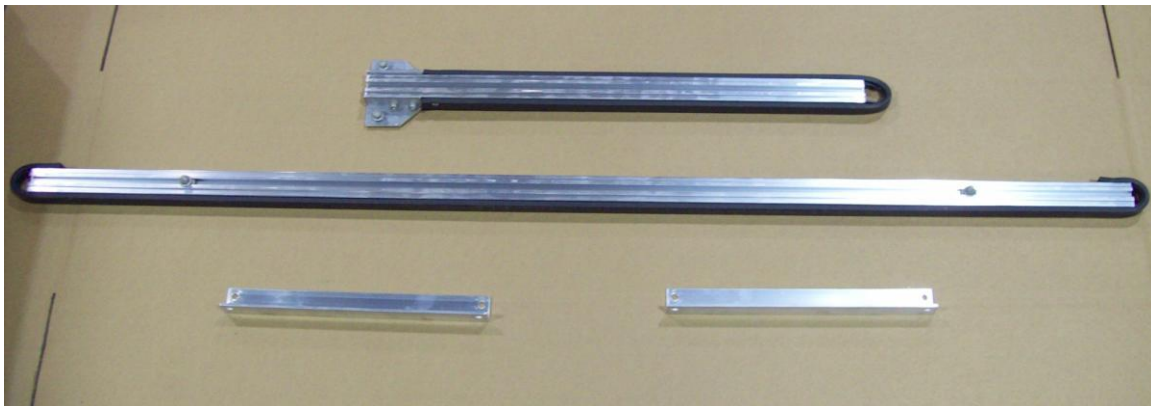


Next slide the vertical support into the front crossbar facing the front of the trailer.

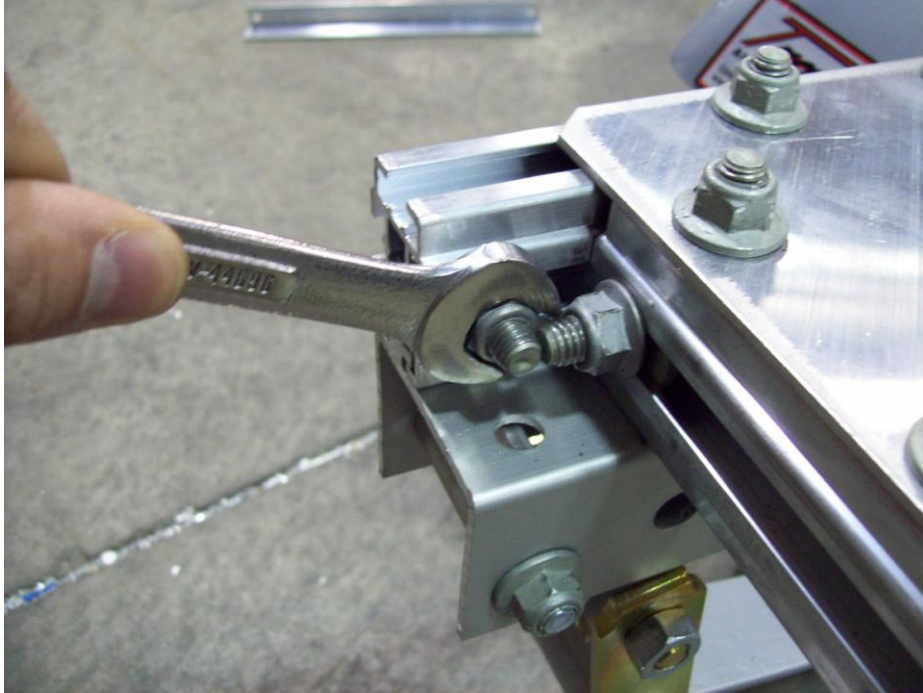


Position the vertical support in the center of the crossbar then tighten nuts.

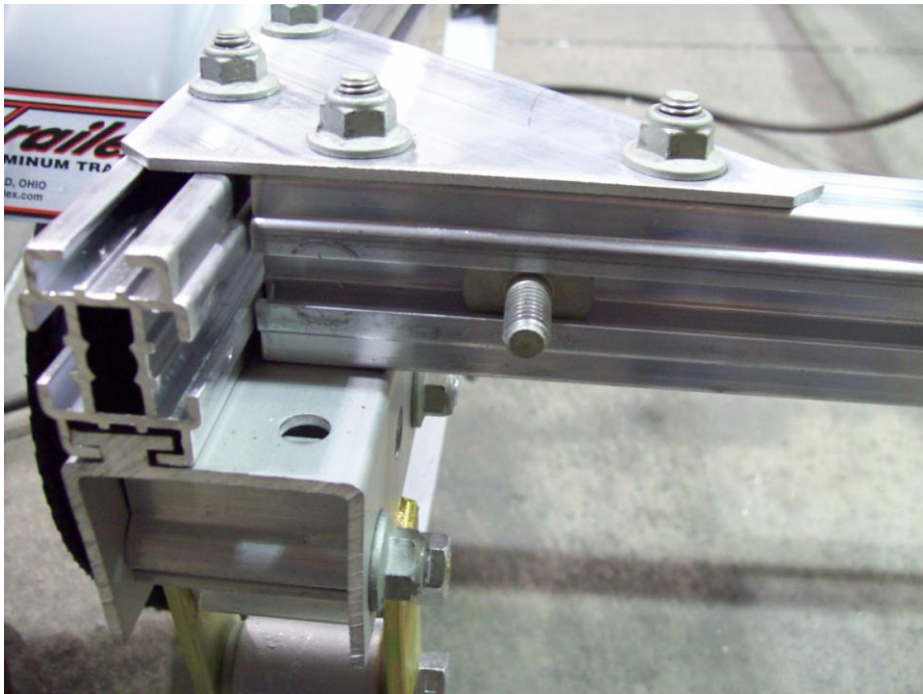
Rear crossbar installation



Locate the rear crossbar, vertical support and rear stabilizer.



Remove the nuts from the side rails and rear cross member.



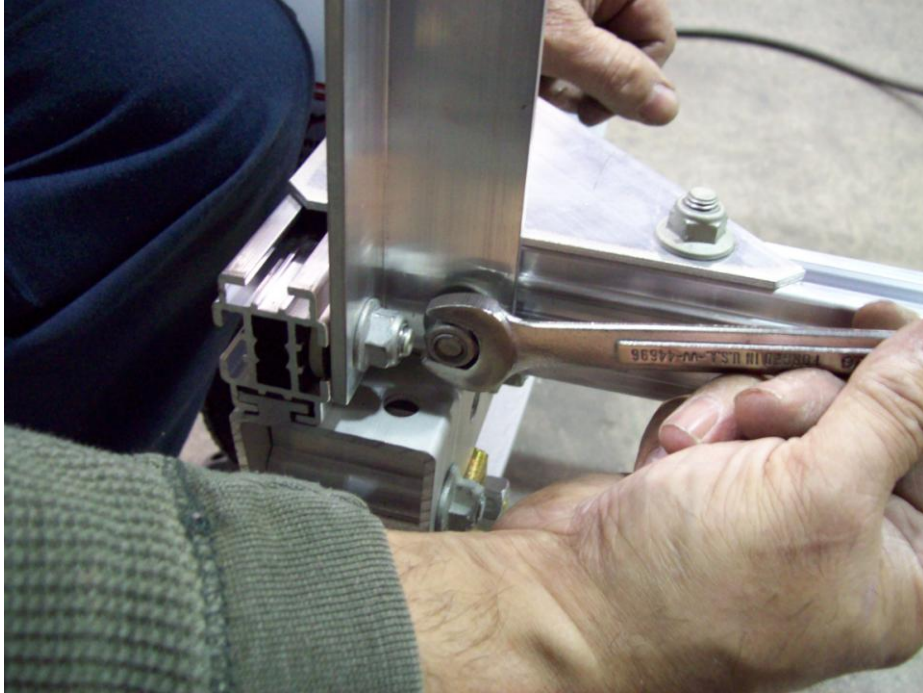
Now remove the T-bolt from the side rail.



Place rear stabilizer over T-bolt in cross member.



Install T-bolt back into side rail and slide rear stabilizer over top of the T-bolt.



Install nuts and then tighten. Repeat process for the other side.



Install the vertical support on the rear crossbar facing the back of the trailer. Be sure to center the vertical support between the pencil marks that are on the crossbar.



Pencil marks

Attach the crossbar to the rear stabilizer brackets. Align the pencil marks on the crossbar to the outside edges of the stabilizer brackets as shown.



Attach nuts at both ends and tighten.



Install one web strap clip to each of the vertical supports as shown. Then position the clips and tighten the nuts.



Install one web strap clip to each corner of the crossbars. Position the clips and tighten the nuts.

Torque lug nuts



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

Finished trailer



KJM10/09 REVISED 9/18/14

