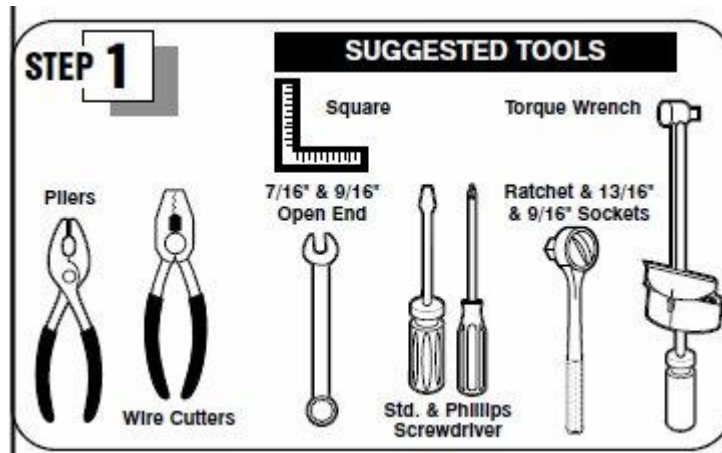


SUT-350-S



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



Side Rails and cross members

Front cross member

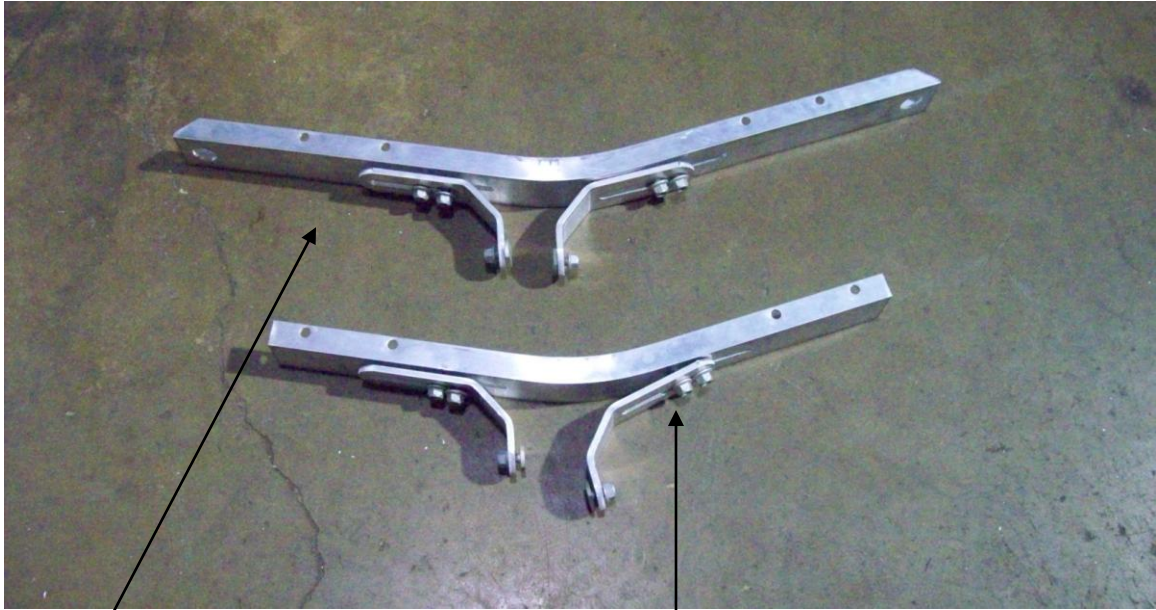
Rear cross member



Axle assembly, springs and U bolt hardware.



Fenders, tires, light kit, wiring harness, and hardware.



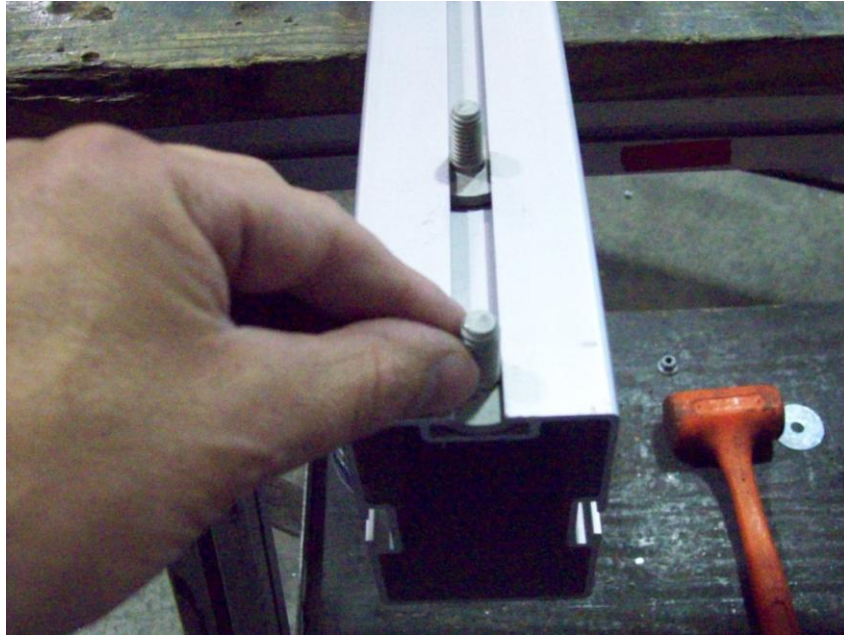
Rear cradle holder

Front cradle holder

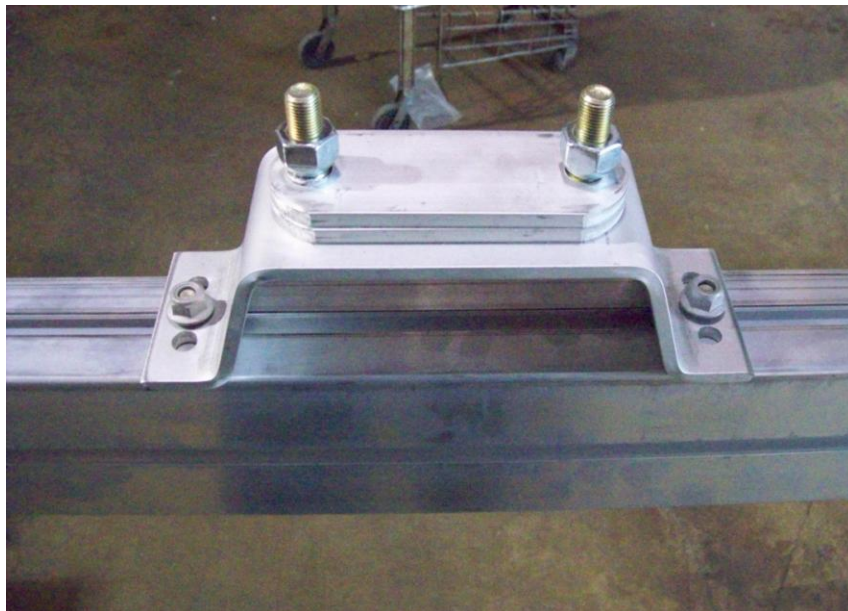


Padded cradles with brackets

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.

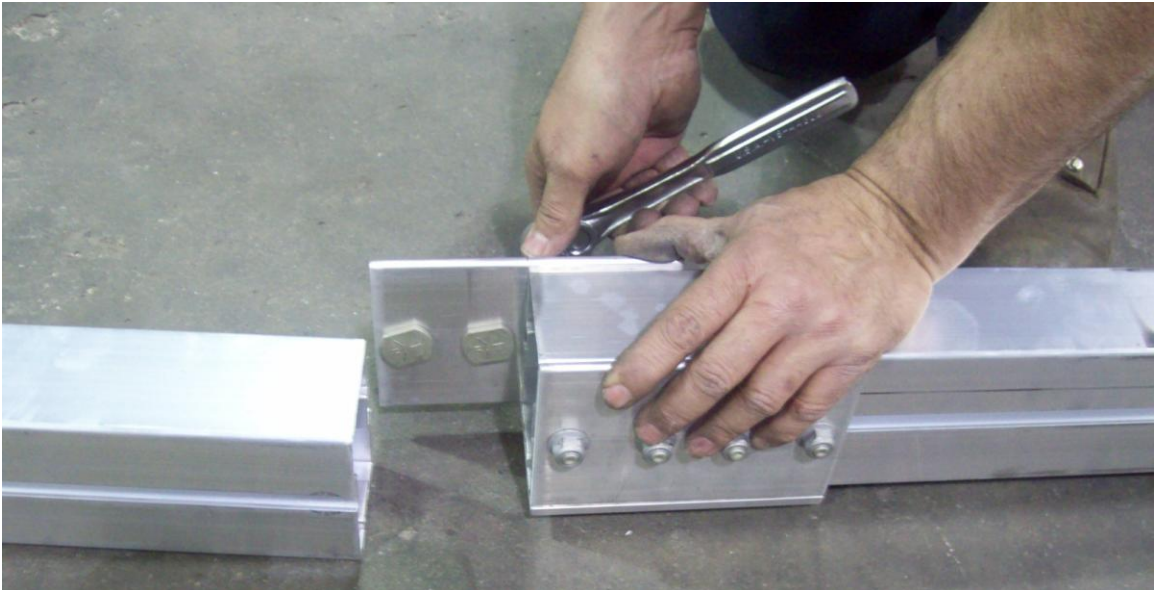


Position carrier about 12" away from the splice plates then tighten nuts.

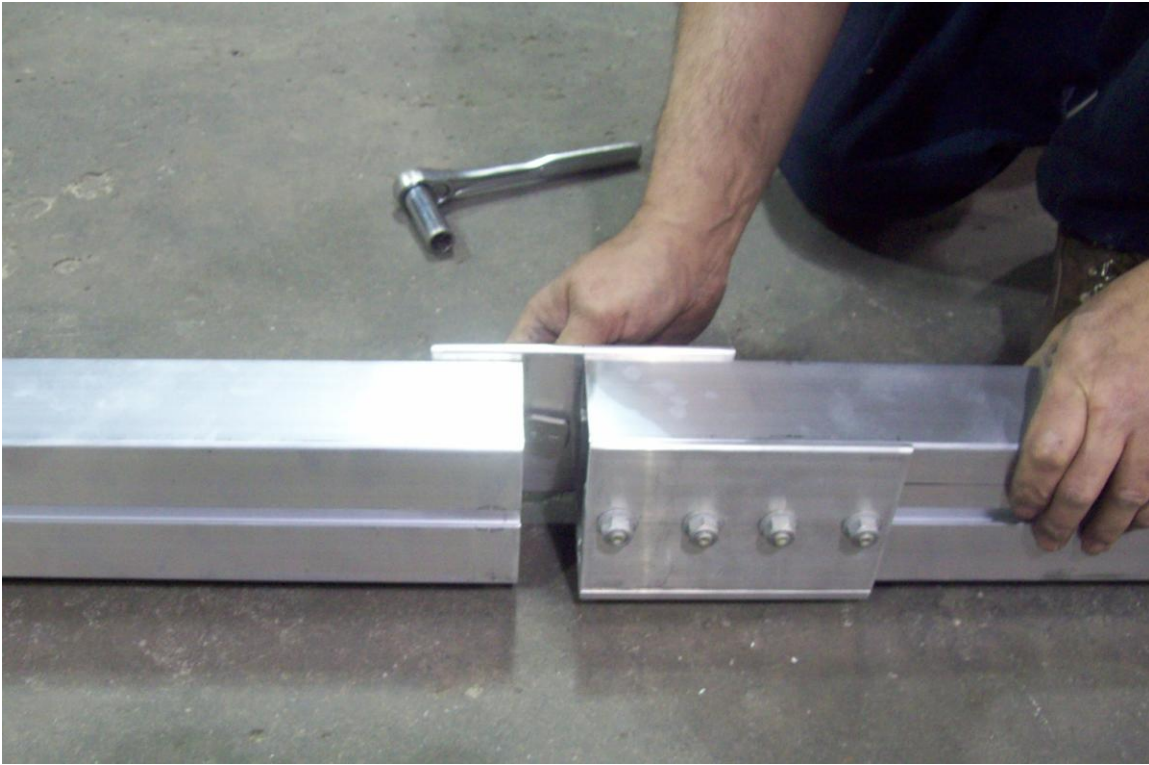
Tongue assembly



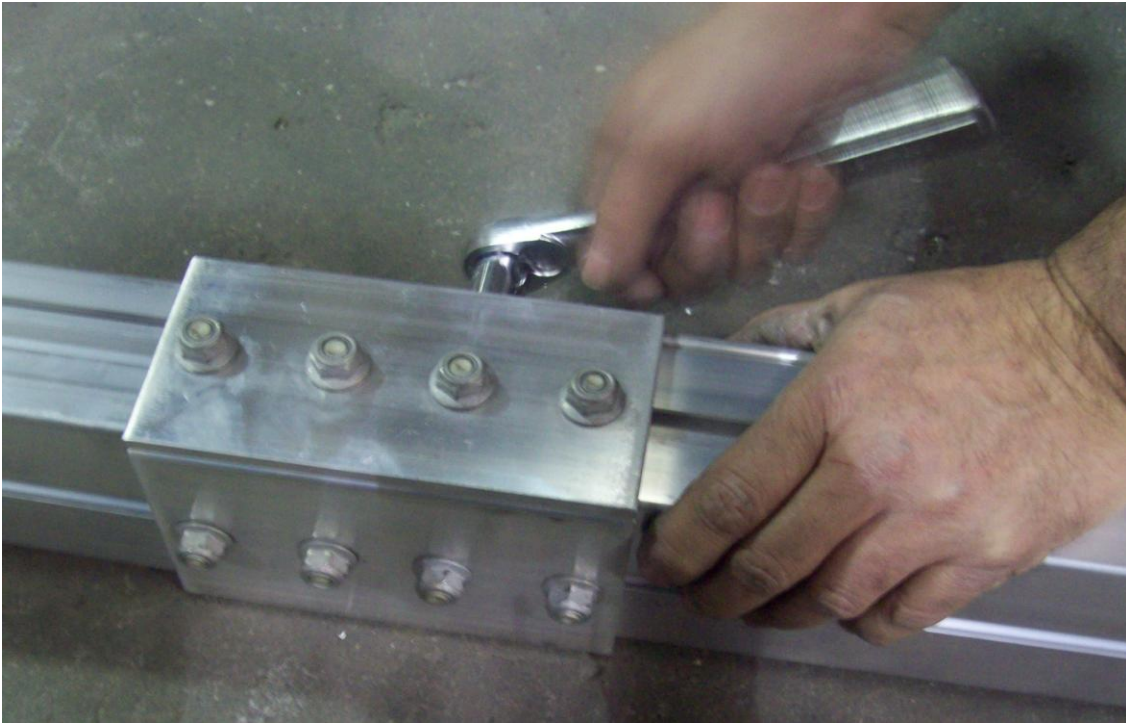
Unwrap the two tongue sections and loosen the 2 nuts (1 per side) located at the rear of the front tongue section and slide them forward towards the coupler. These will be used later to install the angle brackets to the tongue from the front cross member.



Lay the tongue sections end to end and loosen 4 nuts on each splice plate.



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

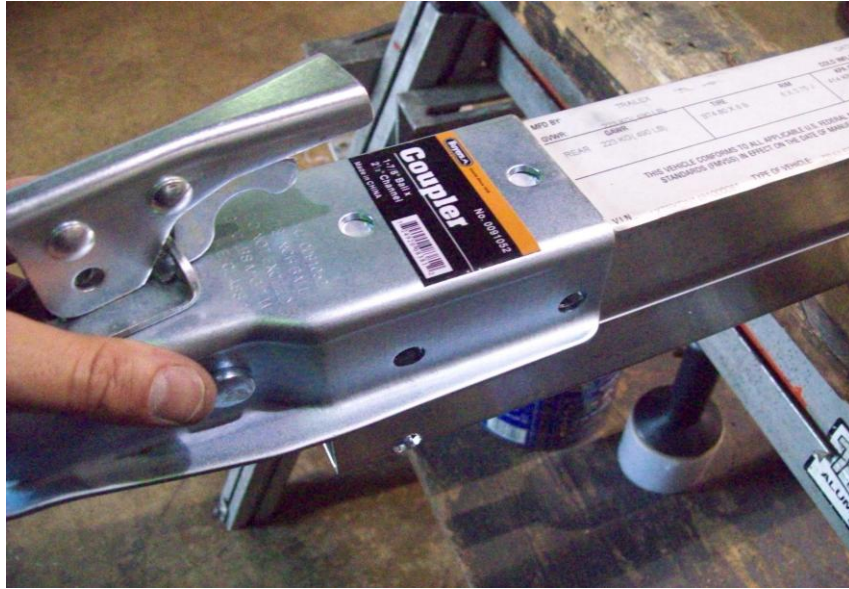


Then slide bottom plate over and align with side plates.

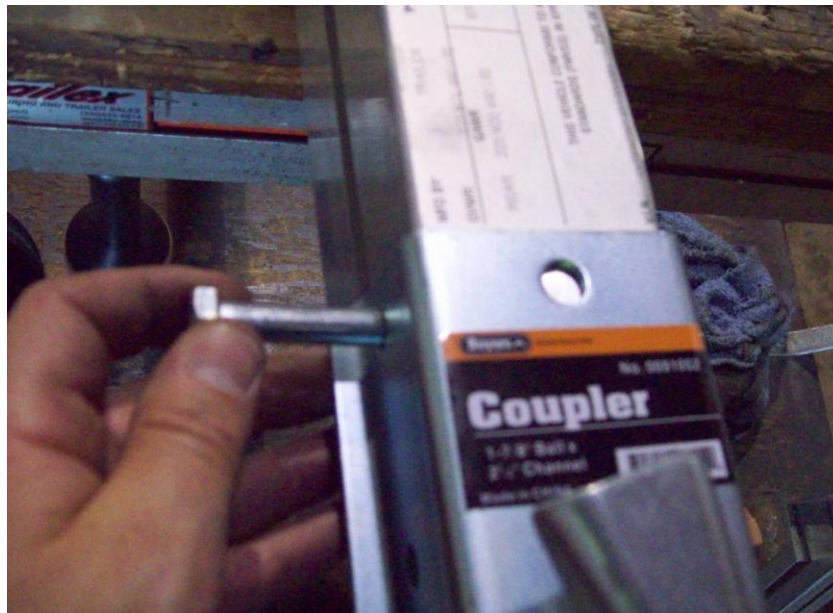


Tighten all 12 nuts making sure that the tongue sections are as tight as possible to one another.

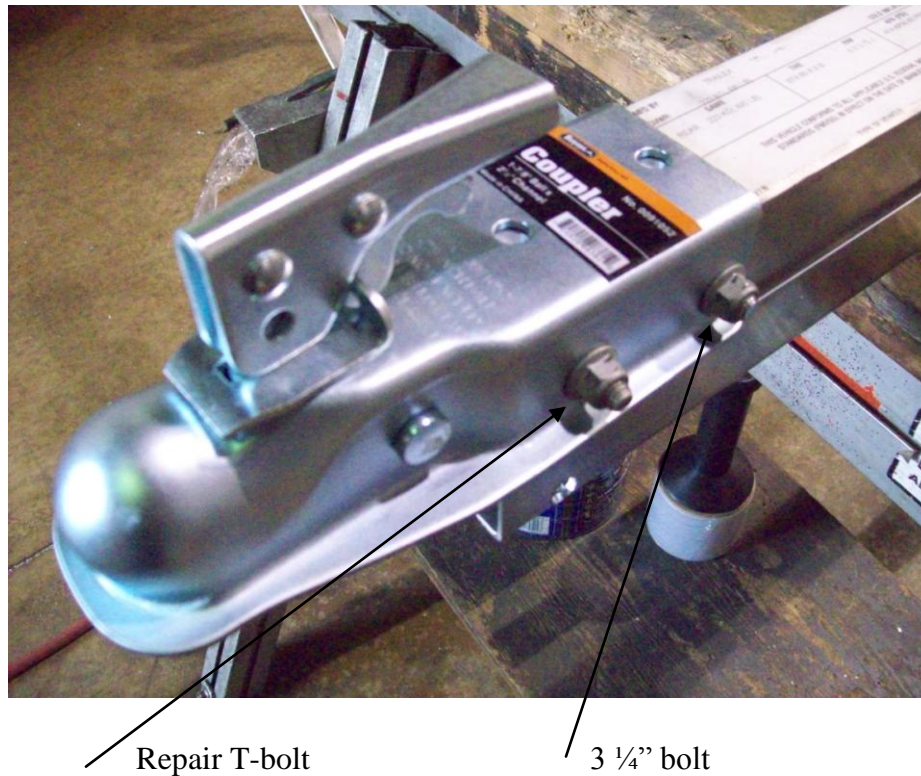
Installation of coupler



Before install the coupler slide 3 t-bolt on each side of the tongue these bolts will be used later in the assembly. Now install coupler on tongue section with vin # on it, holes are pre-drilled in the tongue.



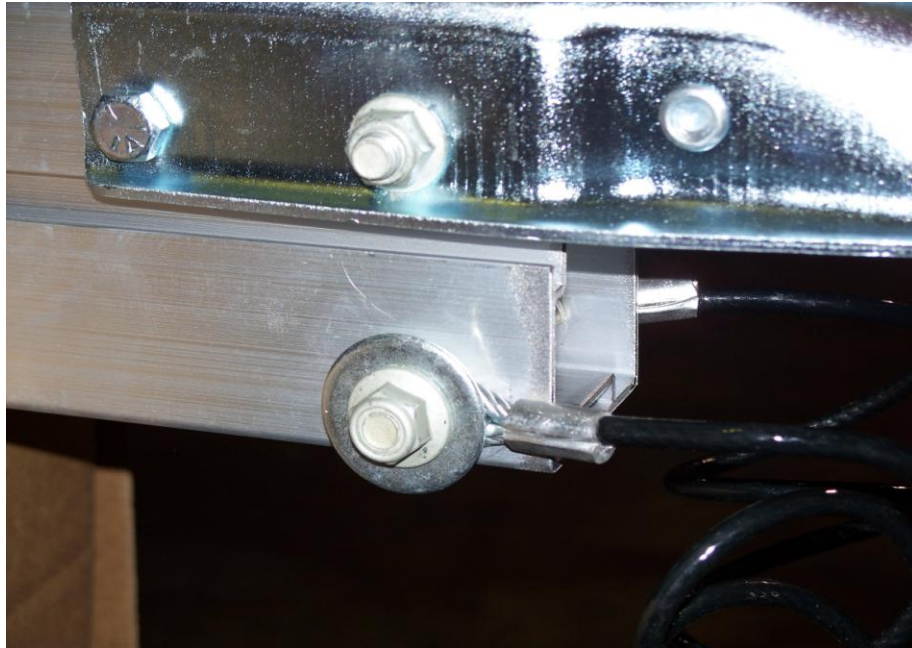
Install a 3 1/4" bolt through the rear hole of the coupler.



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

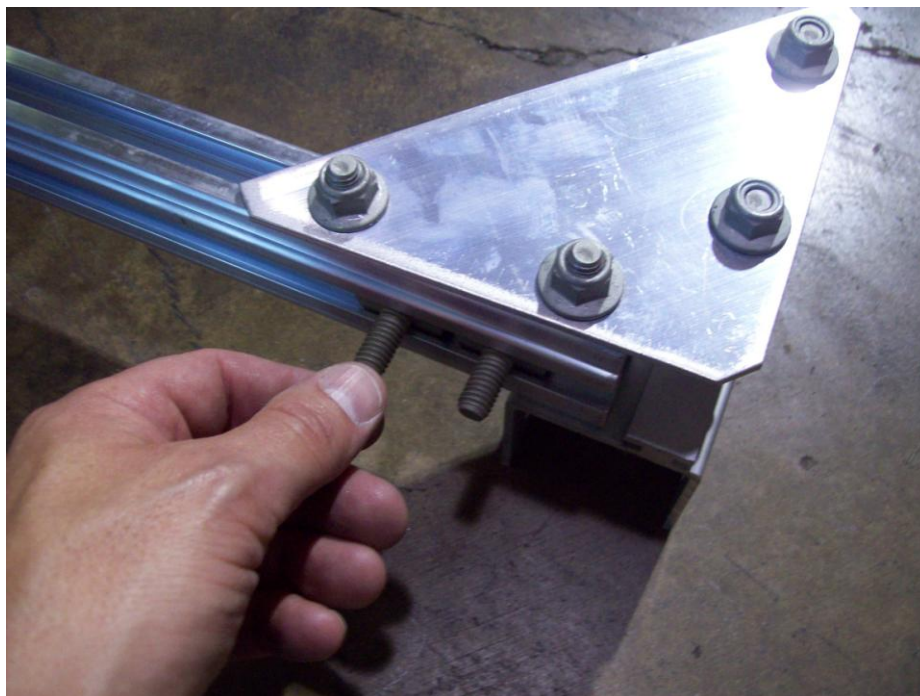


Safety hitch cables and hardware

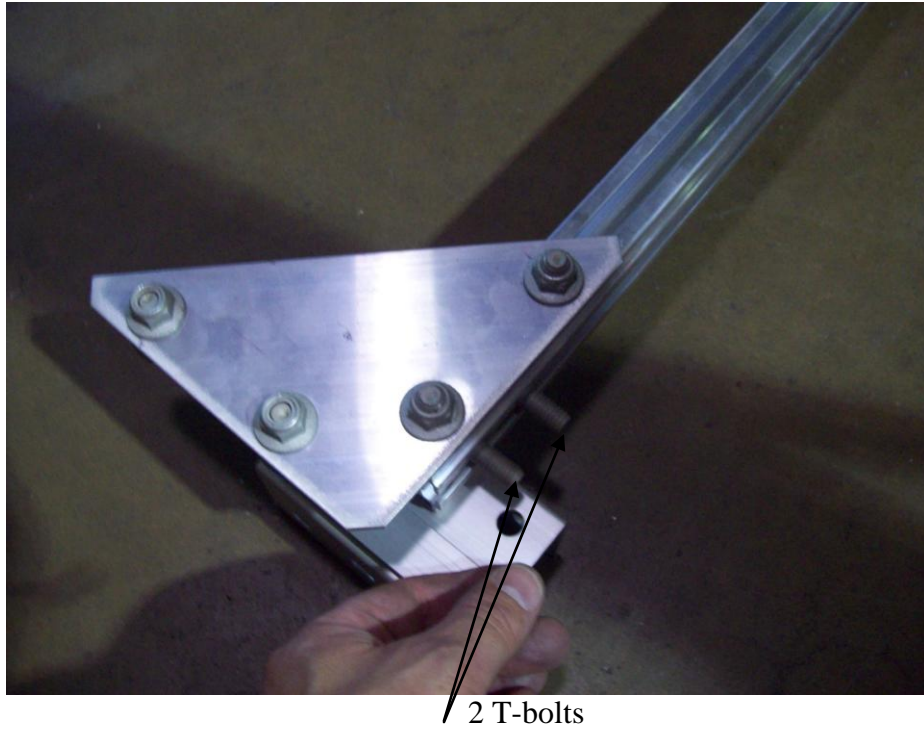


Install the repair T-bolt on the inside of the lower tongue section. Next add the cable over the bolt then a flat washer and last the nut.

Frame Assembly



Install 2 T-bolts to the front side of the forward cross member.



Install 2 T-bolts to the back side of the rear cross member.



Next layout the front and rear cross member and slide the side rails through them to make a square frame as shown.



Once in place square up the side rails and cross members. Then tighten all nuts.

Frame attachment to tongue

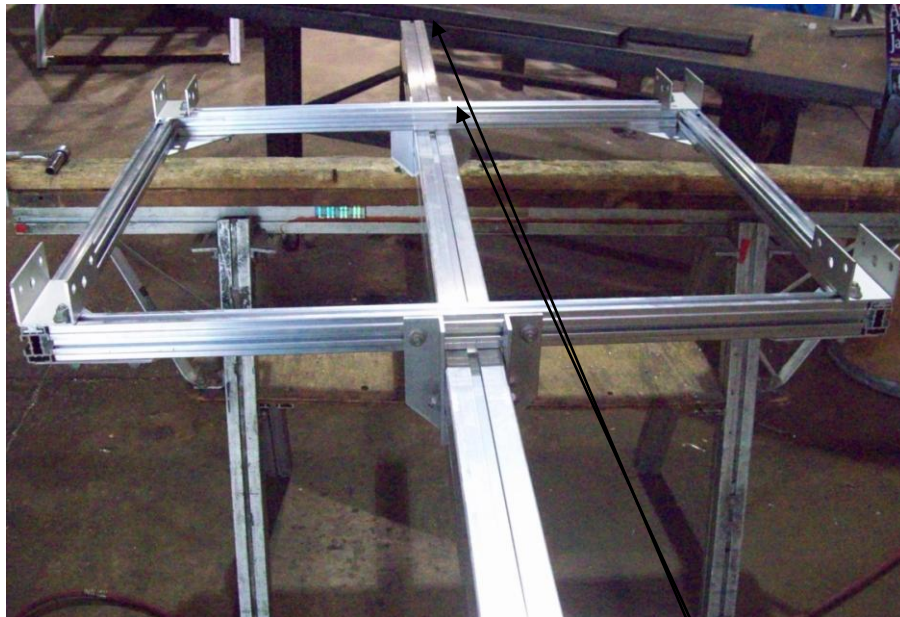


Locate the bag with the angles for the tongue to cross member.



Shown up side down

Slide 2 T-bolts on each side of the tongue section from the back going forwards. Slide angle brackets on cross member over to the tongue section and align with T-bolts on tongue. Check to make sure tongue is centered on pencil marks that are on the front of cross member. Then tighten all nuts.



Frame shown up side down

37 inches

The rear cross member should be 37" away from the rear of the tongue.

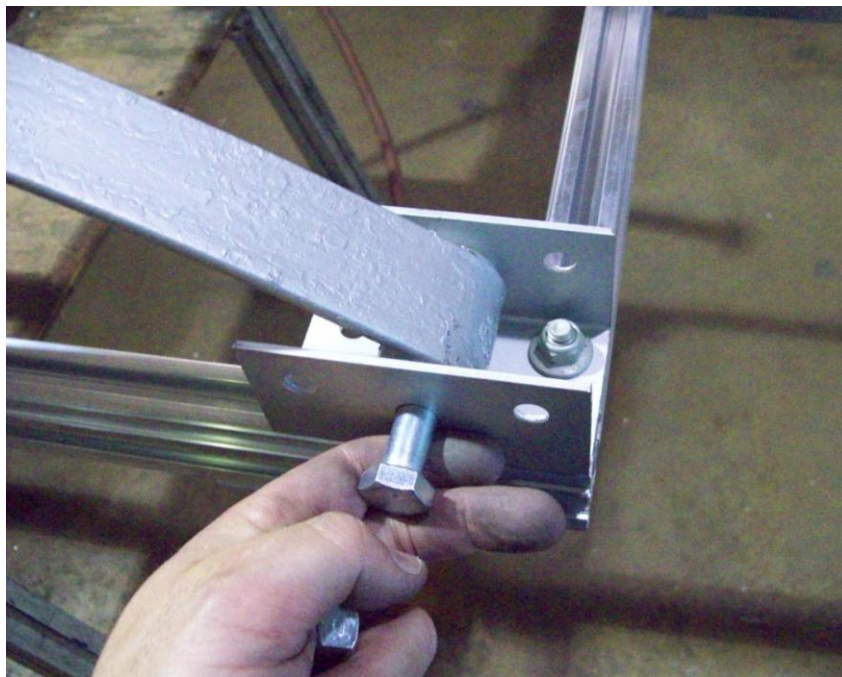


Rear cross member

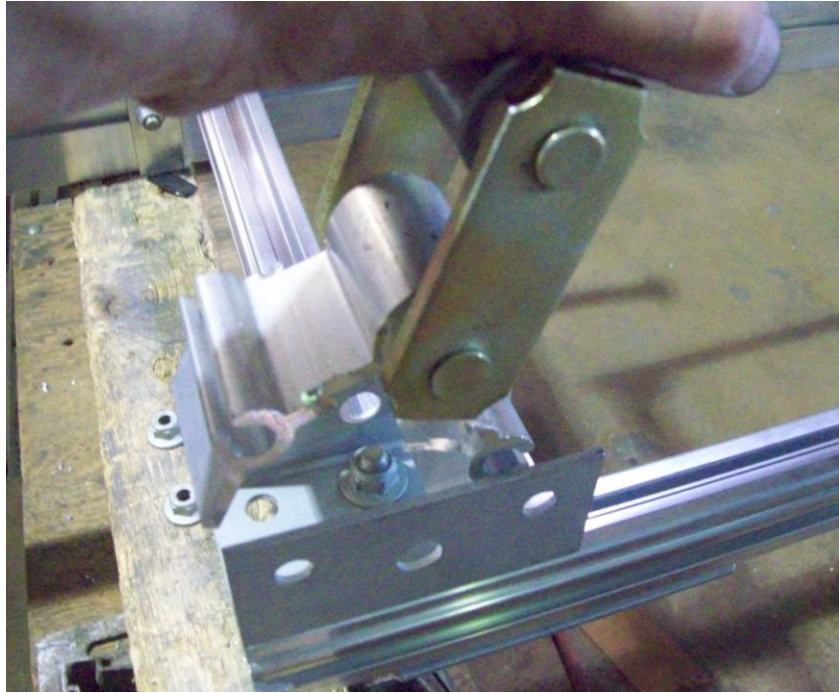
Front cross member

Frame attached to the tongue section shown up side down.

Spring Installation

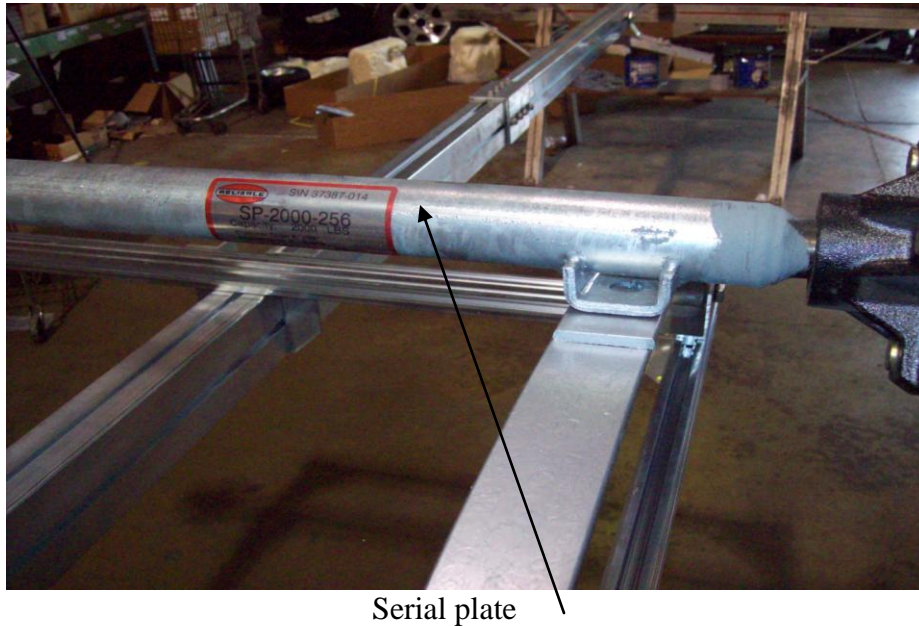


Remove the bolt from the front spring eye and install the spring into the spring hanger in the center hole with the nut towards the inside of the trailer. Do not tighten yet.



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.

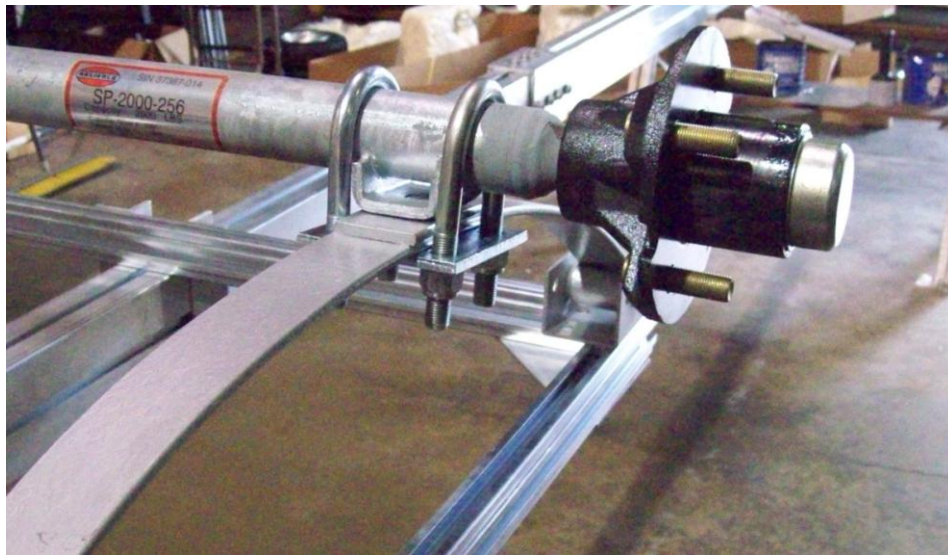
Axle Installation



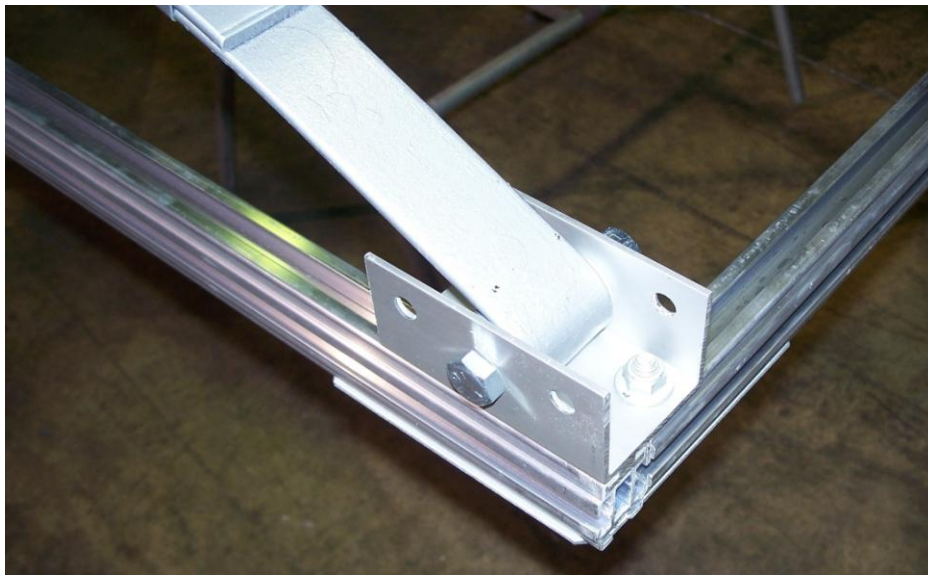
Locate the axle and install it on the springs as shown. Make sure the locating studs on the springs are in the holes on the axle's spring seat. Face the axle's serial plate toward the rear of the trailer to protect it from debris.



Locate the U-bolts and tie plates and install them as shown.



Install nuts on U-bolts. Tighten all the nuts evenly as shown in the picture.



Now go back and first tighten the front spring mounting nuts that were left loose previously.

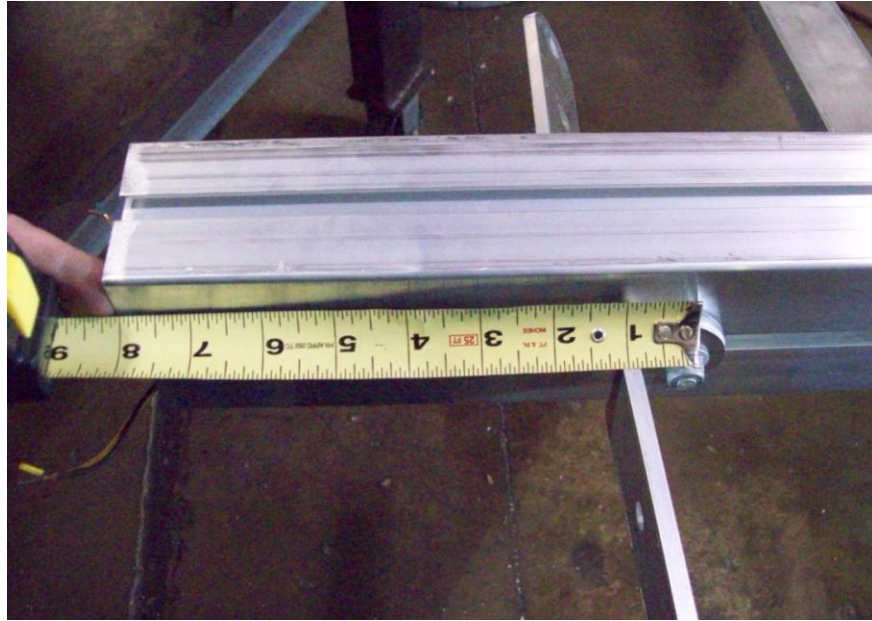


On the rear shackle, do not over tighten as this will not allow the suspension to move properly.

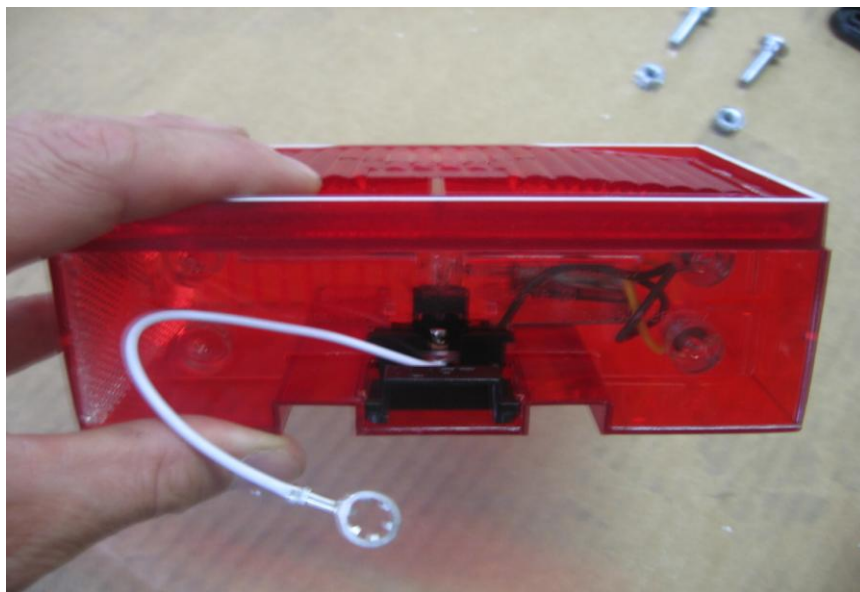
Installation of tail light and light brackets



First install the rear cradle bracket and slide forward for now.



Install light bracket on both sides of the tongue section 8" from the back.



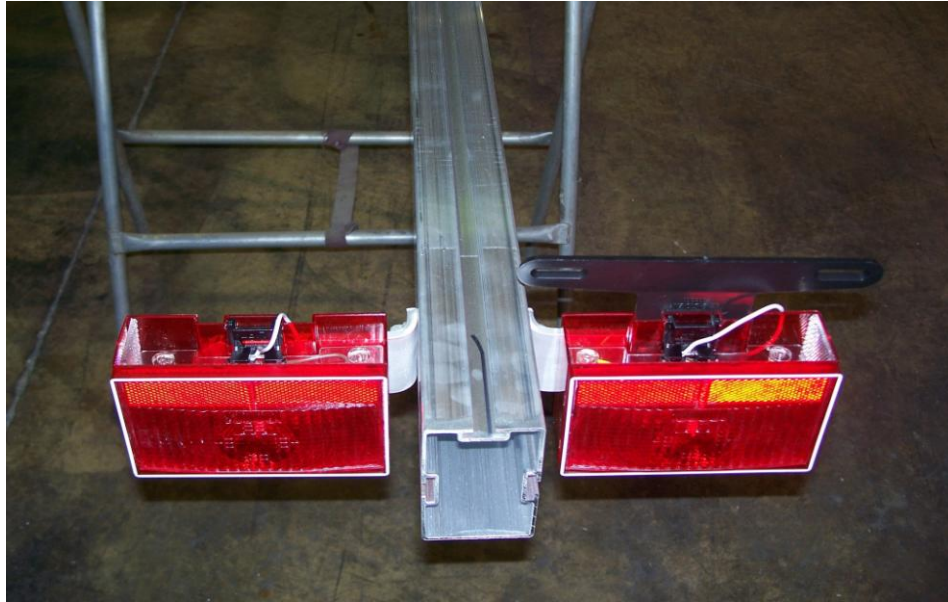
The light with the yellow wires is for the left (driver's side) of the trailer.



Slide the carriage bolts into the slots in the back of the tail lights.



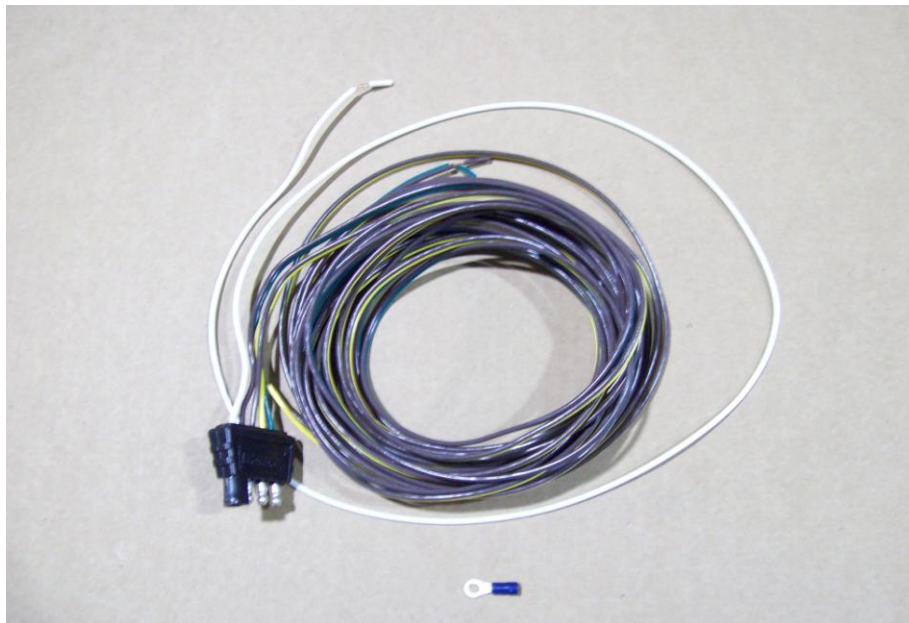
Mount the license plate bracket to the driver side tail light.



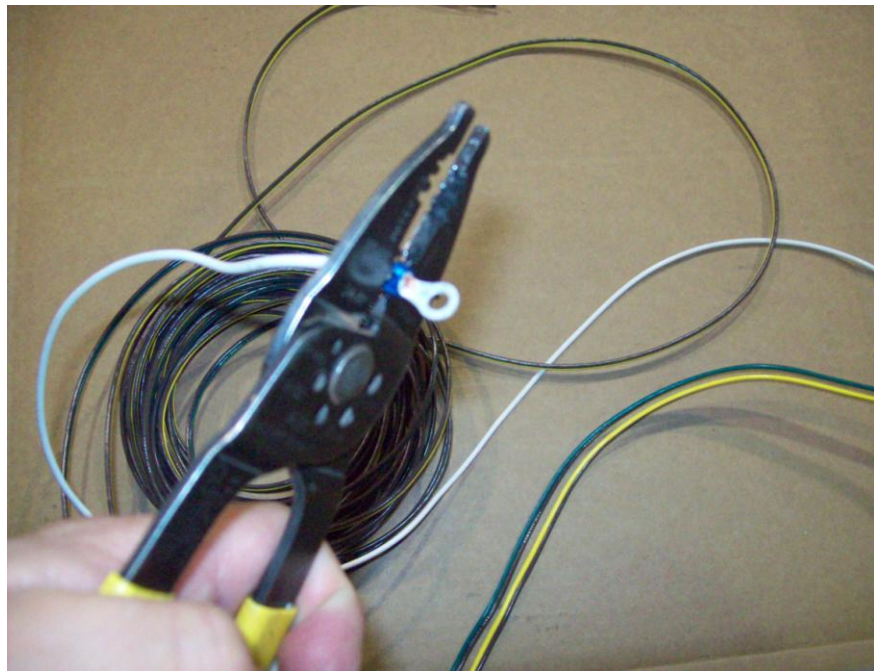
Shown up side down

Install the left tail light with the license plate holder between the light and the bracket. Tighten the tail light in this position.

Wiring



Locate harness and terminal.



Take the white ground wire and strip it and install ring terminal.



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



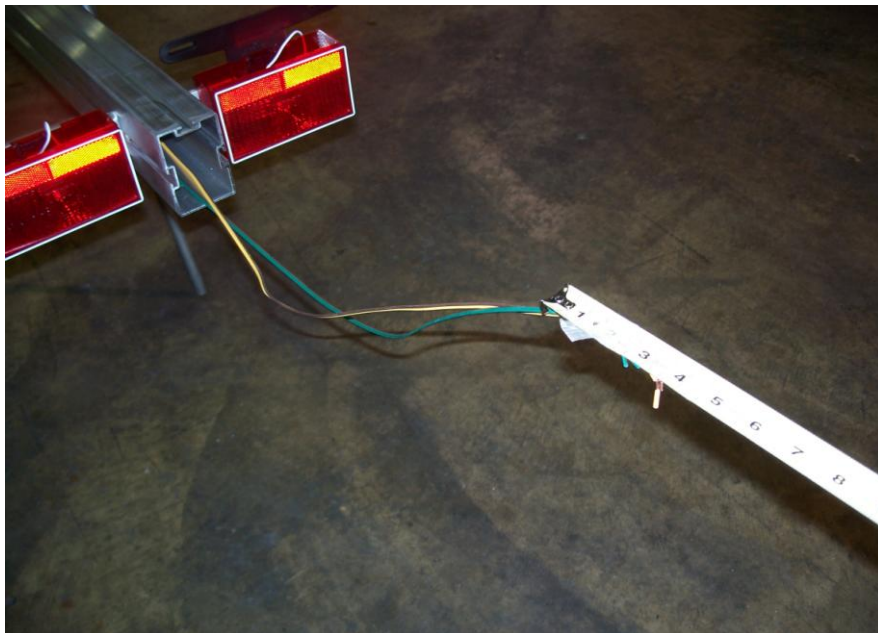
Install Philips screw through the ground wire into the pre-drilled hole located under the tongue just behind the coupler.



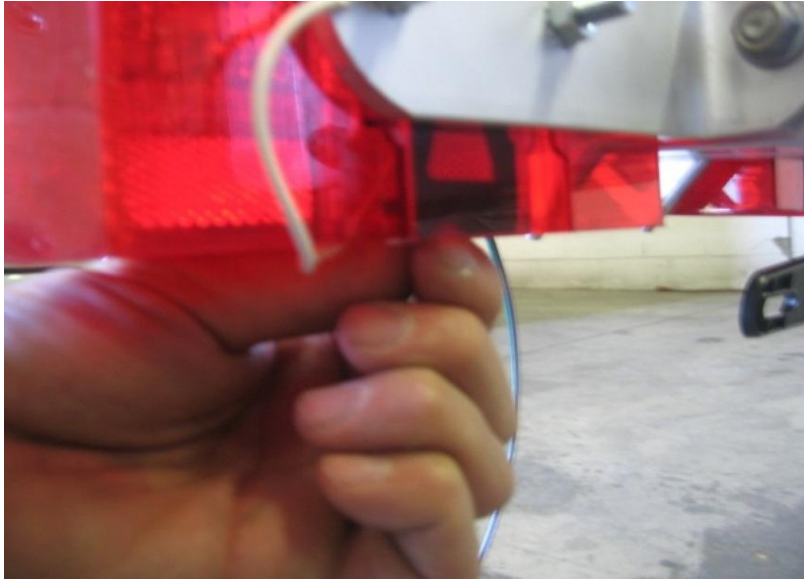
Extend a tape measure inside the tongue from the rear of the trailer until it protrudes at the front of the trailer under the coupler.



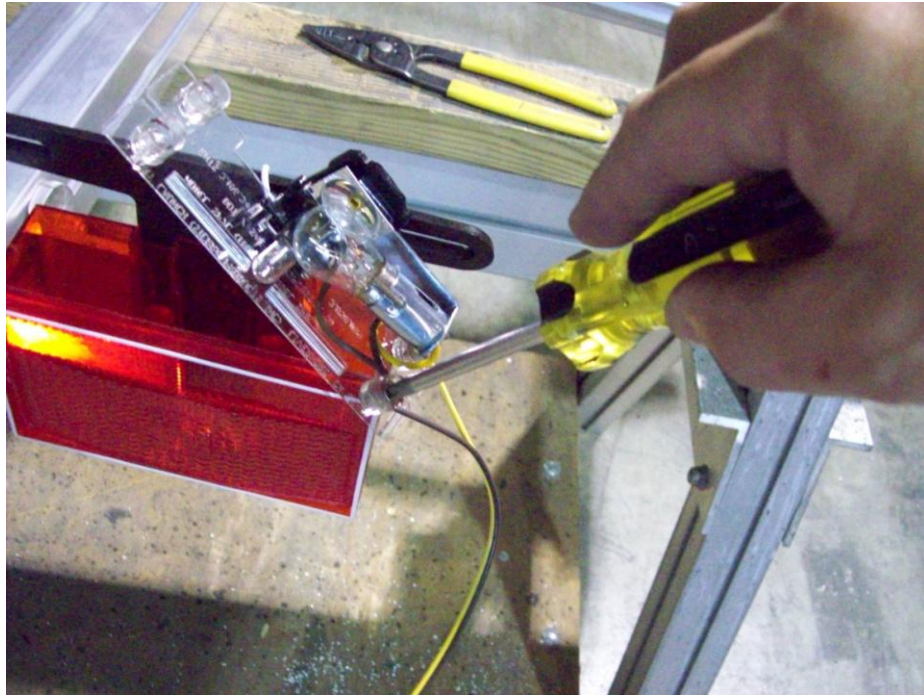
Attach both wires of the harness to the end of the tape measure with either tape or a tie.



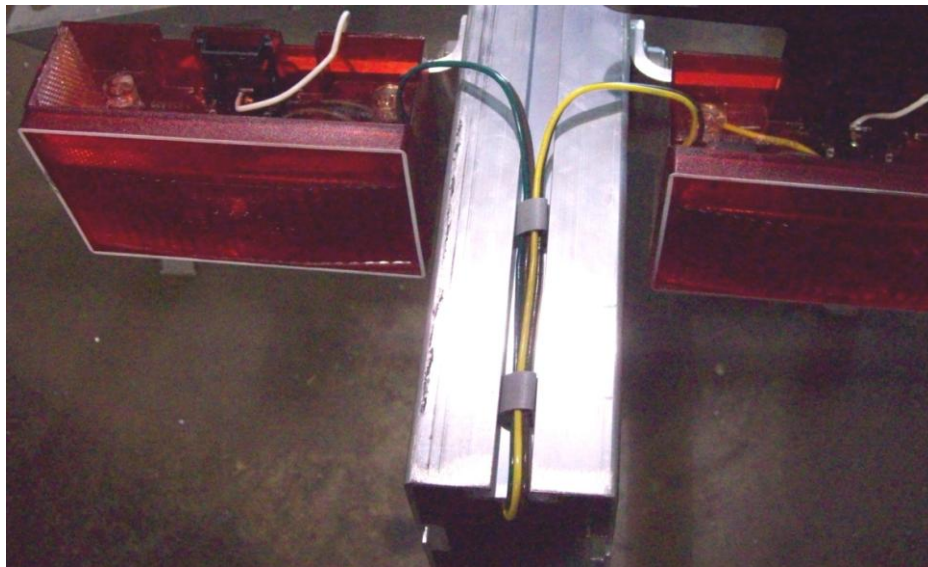
Retract the tape measure until it comes out the back of the tongue with both wires attached.



Locate the black tab at the bottom of the tail light. Move the tab toward the rear of the trailer and pull down 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.

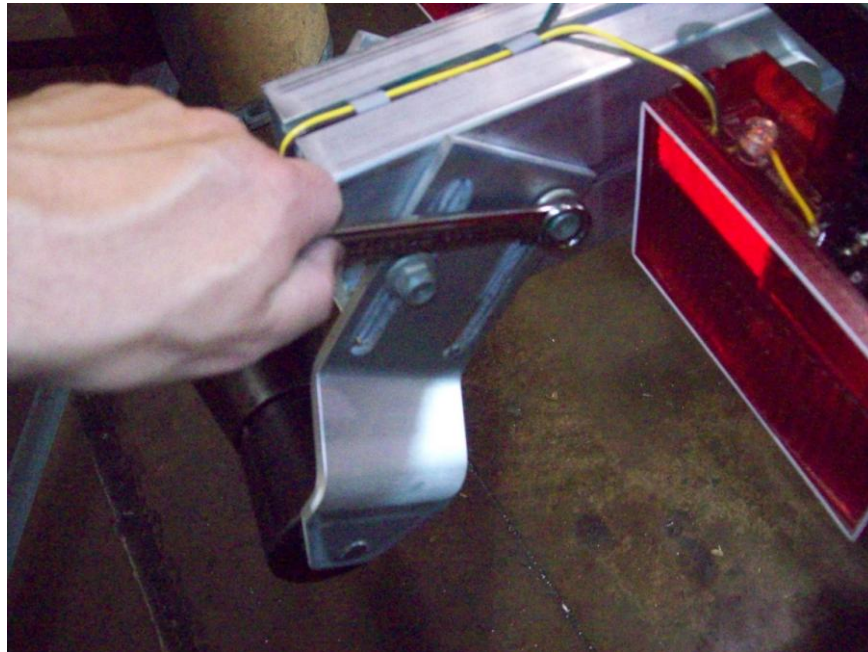


Re-install the bulb assembly into the light housing making sure to route the wires through the slot in the base of the bulb assembly. Install adhesive backed clamps in the locations shown and route the wires through them.

Rear roller installation



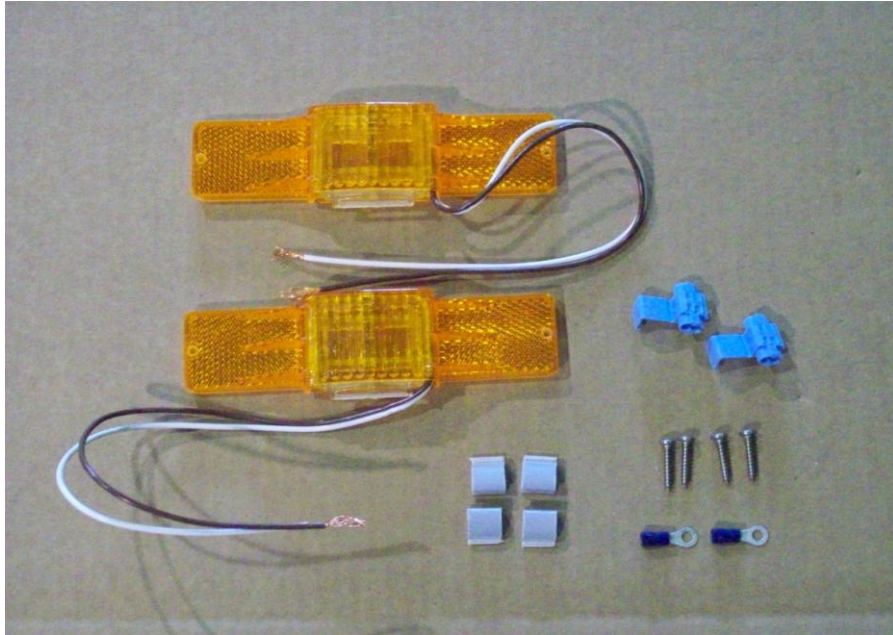
Install the T-bolts and nuts on the bracket with the nuts facing outward.



Angle the rear roll as shown and tighten all nuts.

NOTICE: The final position of this roller is such that it never touches the hull during transport – only during launch and retrieval.

Running lights, bracket and skid.



Locate the two amber running 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 running lights.



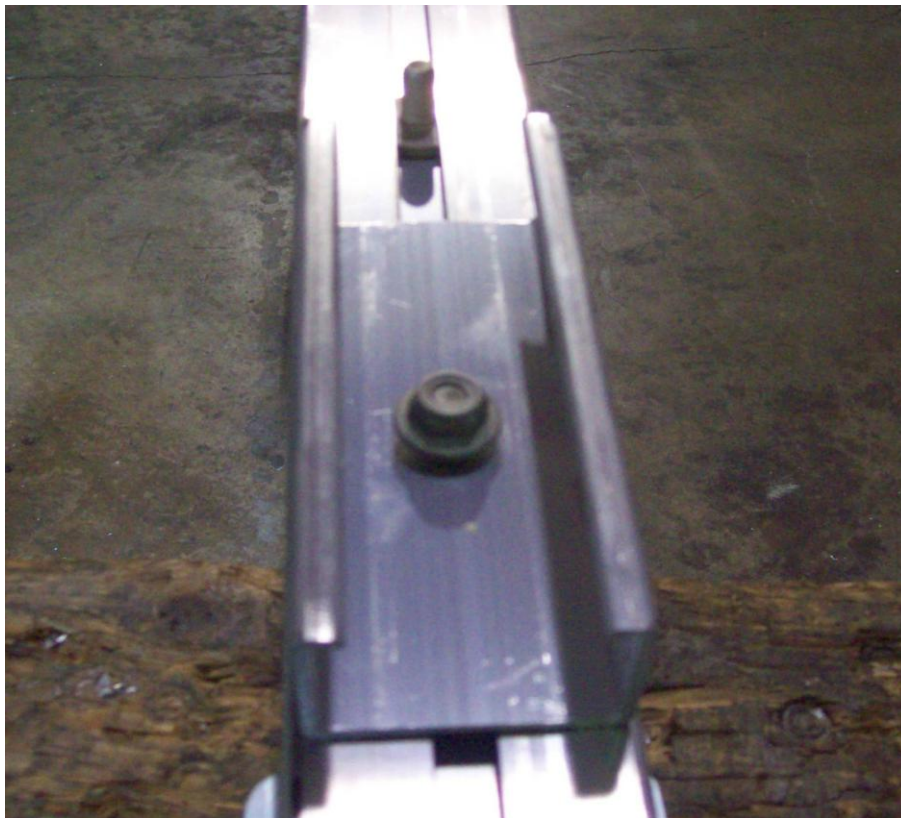
Strip 1/4" of insulation from the wire.



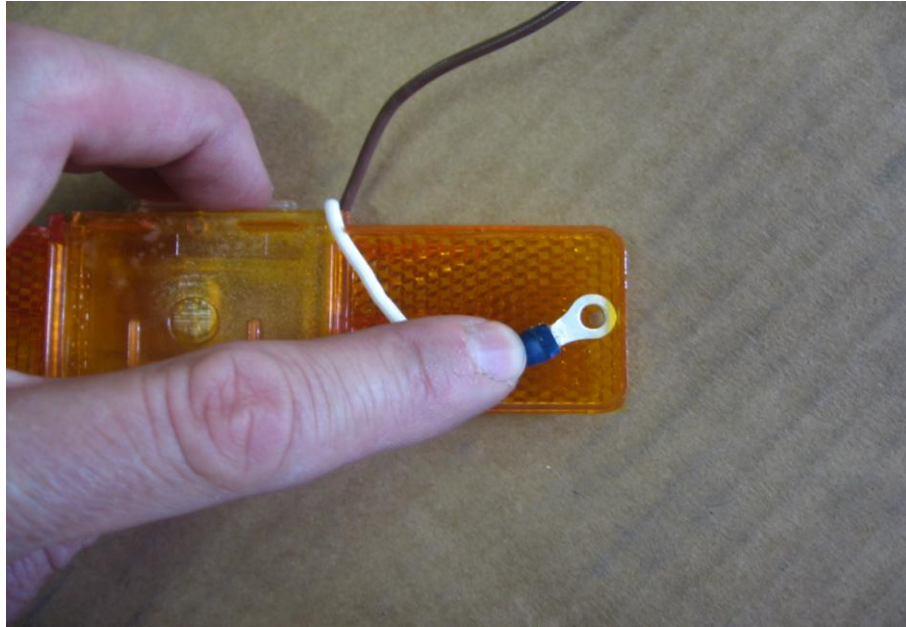
Install the ring terminals by crimping the terminal onto the bare wire.



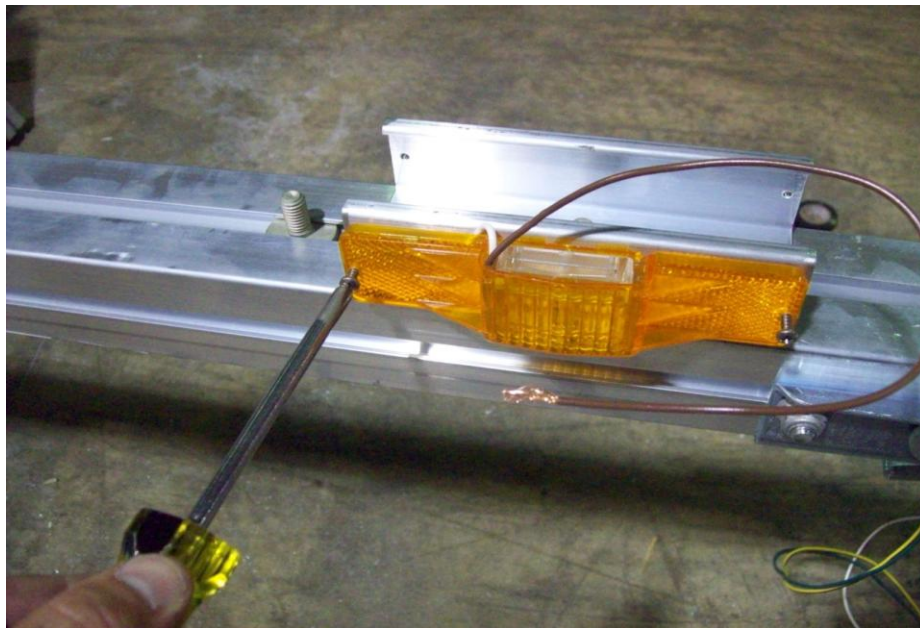
Locate the skid and light bracket.



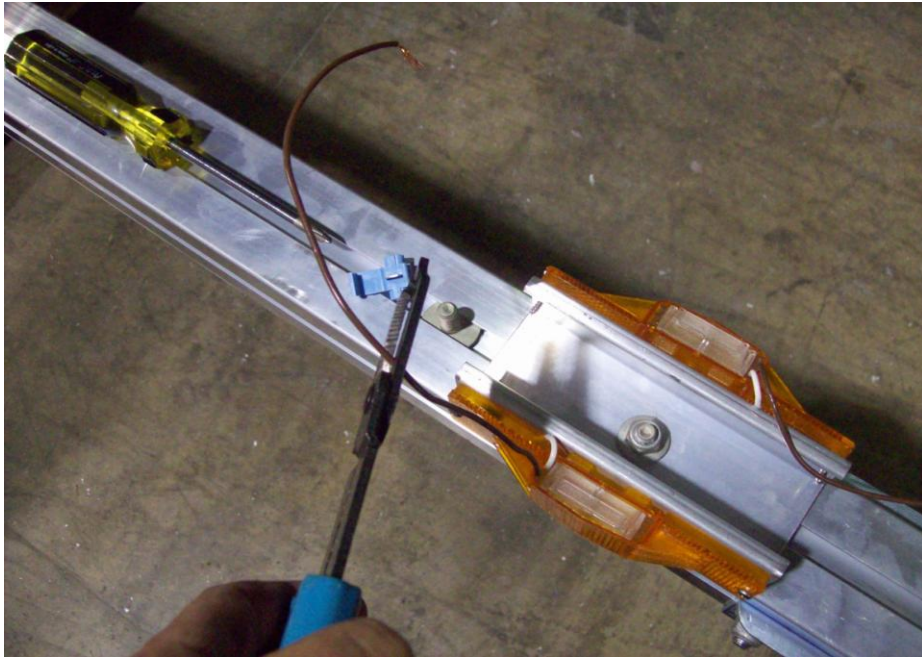
Take one T-bolt off the skid and slide it in the bottom of the tongue. Then install the bracket for the lights and position as shown.



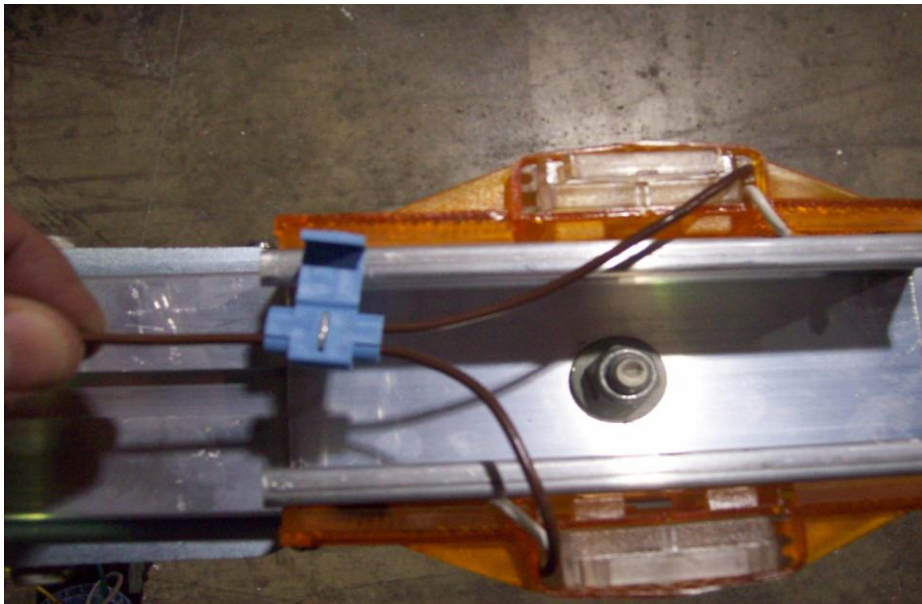
Align the ring terminals with the screw hole nearest the wire on the back of the running light. Make sure the wire is routed through the gap on the back of the light so it does not become pinched when the light is installed



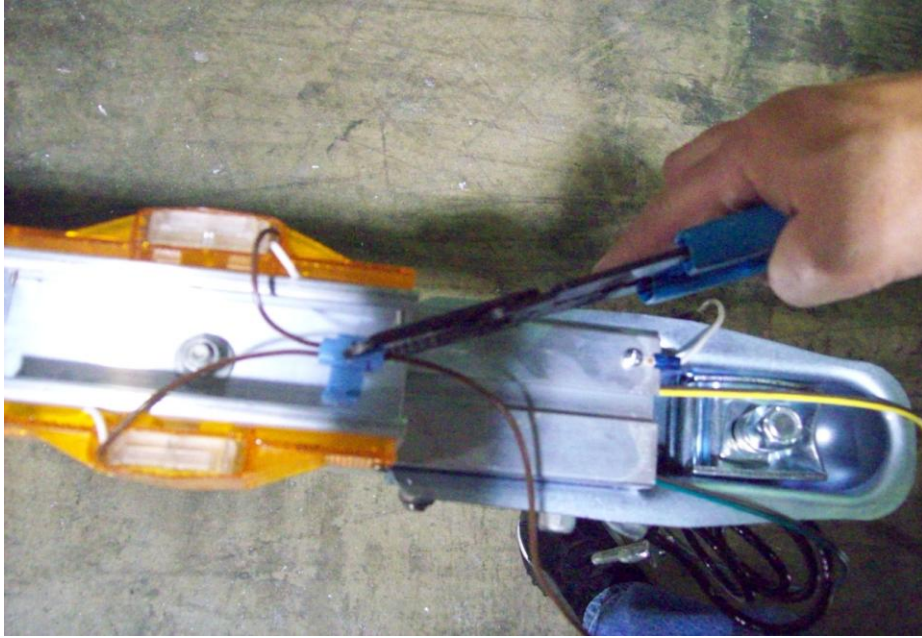
Install the running lights into the pre-drilled holes in the running light bracket using a Philips screwdriver. Be sure the screw is through the ring terminal on the back side of the lights. This will supply a ground to the lights. DO NOT OVER TIGHTEN



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



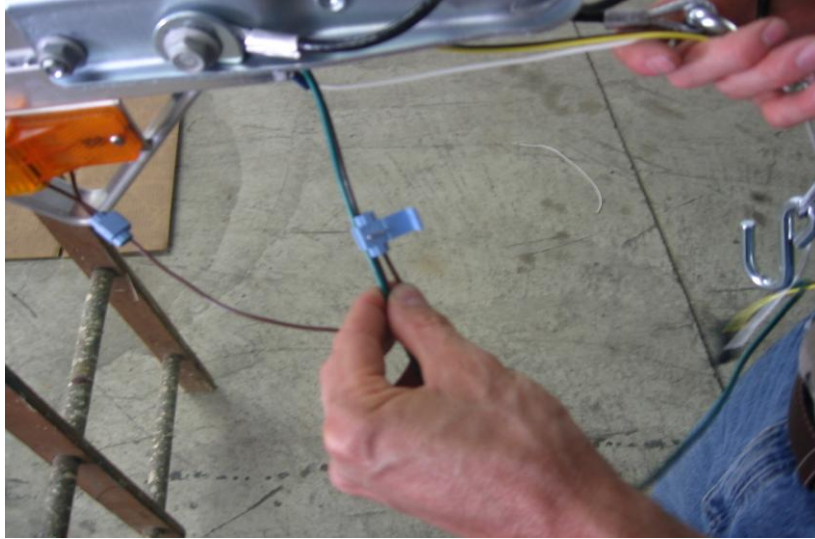
Insert brown wire that has been cut into the hole in the connector closest to the hinge. This hole does not pass all the way through. The wire should go in about $\frac{1}{2}$ ". Pass the other wire through the remaining open slot in the connector at a point close to the running lights.



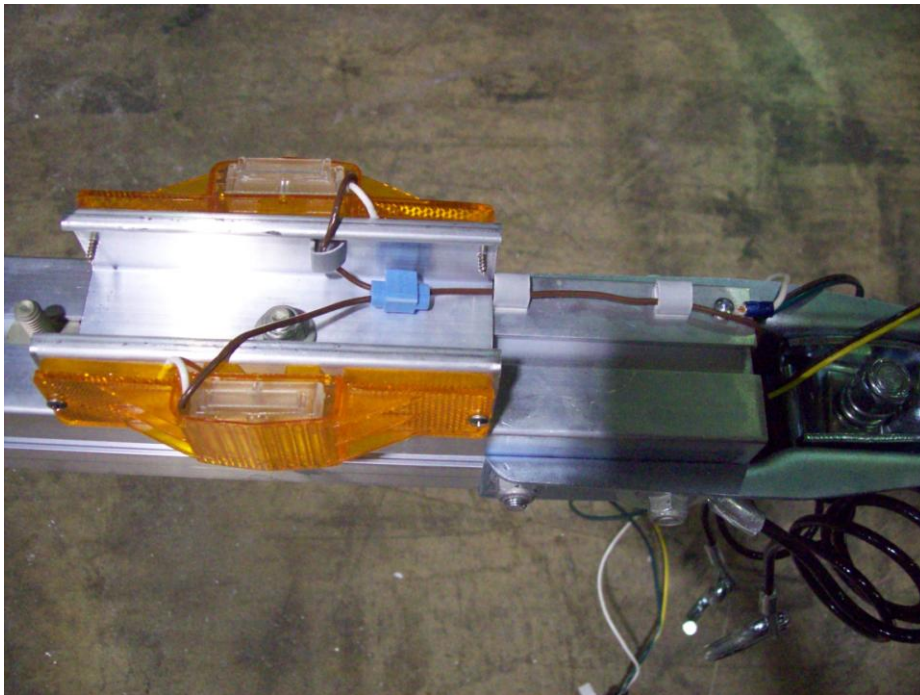
Use pliers to push the metal spade down until it is flush with the plastic. This is what makes the electrical connection between the two wires. Close the plastic cover of the connector over the spade until it snaps into position.



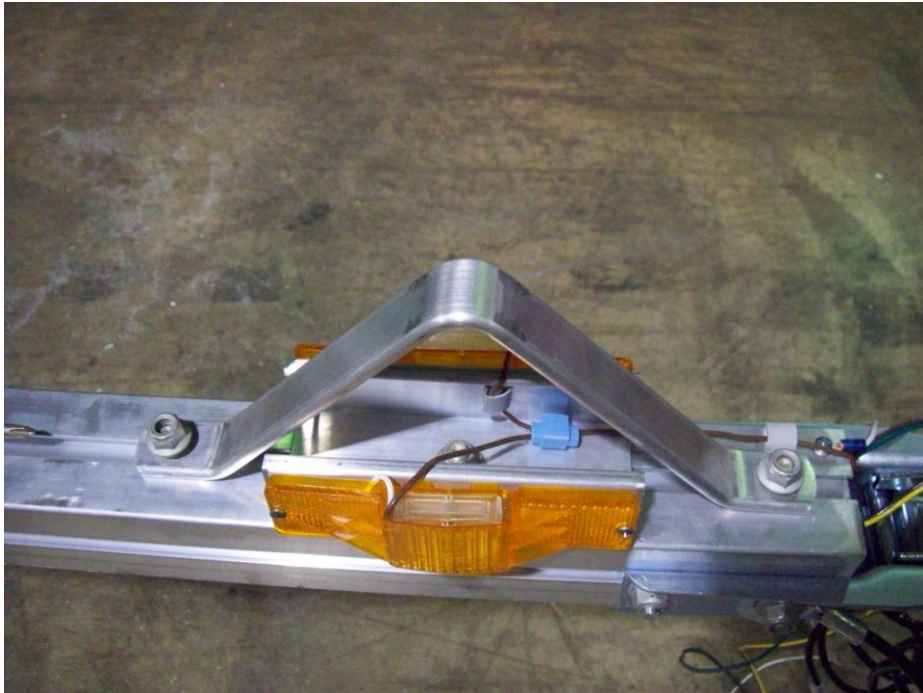
Cut the exposed strands of wire off of the end of the brown wire on the right (passenger side) running light.



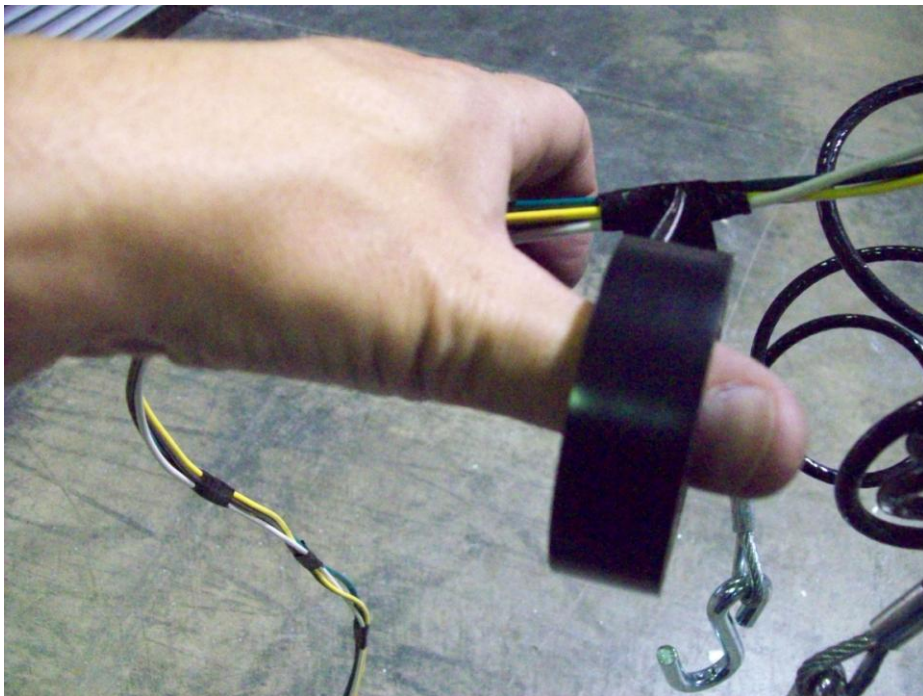
Measure 34" back from the front plug on the green/brown wire and pass the brown wire through the open slot in the second light blue connector at this location. The green wire will rest just outside the connector. Insert the brown wire from the running lights into the closed side of the connector and close the spade and cover as previously described. This will make the connection from the main harness to both running lights.



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



Install the skid on the front tongue section now. 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 axle 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



Locate 2 web strap clips

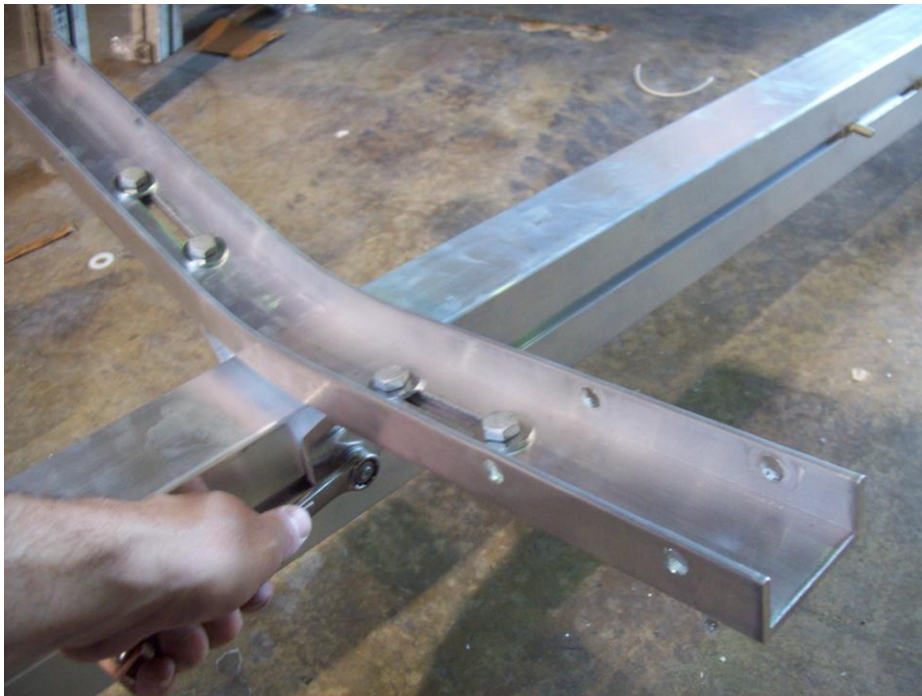


Install a web strap clip on each side rail at the back as shown. Then tighten nuts.

Front cradle holder installation



Locate the front cradle holder with brackets.



Using the rearward most bolts of the three that were moved toward the coupler during tongue assembly, attach the front cradle holder assembly at the pencil marks located 36" from the front of the tongue. Final location of the front cradle holder will be determined when the boat is fitted to the trailer.



Tighten the nuts making sure the cradle holder brackets are perpendicular to the tongue.



Slide the bolts out to the ends of the slots and tighten the nuts.



Locate the padded cradles.



Remove the bolt from the pivot plate.



Install the padded cradle (inner position shown – this may vary depending on the width of the hull). Final angle will be determined when the trailer is fitted to the boat.



Position the rear cradle holder assembly about 12" from the rear and repeat the steps to install the padded cradles.



Install the bow stand with the roll facing the rear of the trailer and the handles facing forward as shown.



Adjust bow stand and tighten nuts. Final positioning of the bow stand will be determined by your boat.

Torque lug nuts



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

Finished trailer





KJM 8/09 REVISED 9/18/14