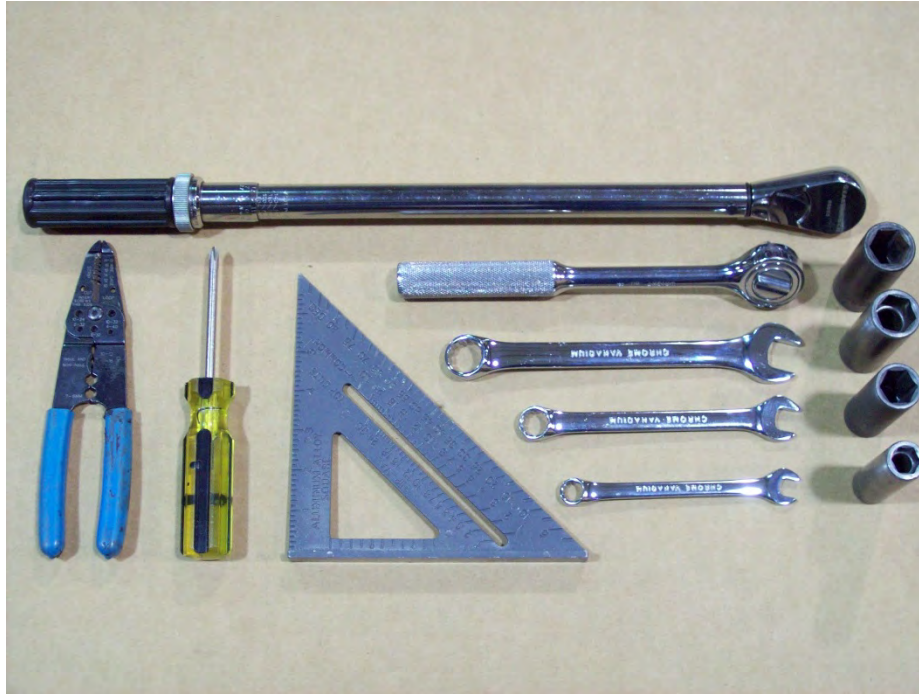


# TX-418HCR



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.**

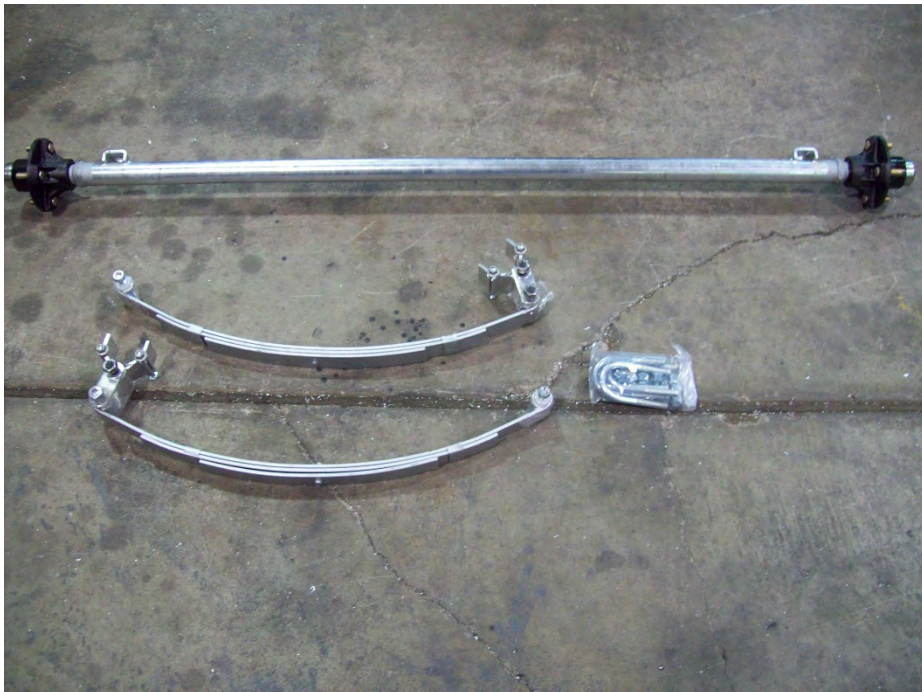
**Incorrect assembly or modifications to your trailer will void any specific or implied warranty.**

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

**Unpack and identify the following parts**



Unwrap the frame and place on saw horses as shown.

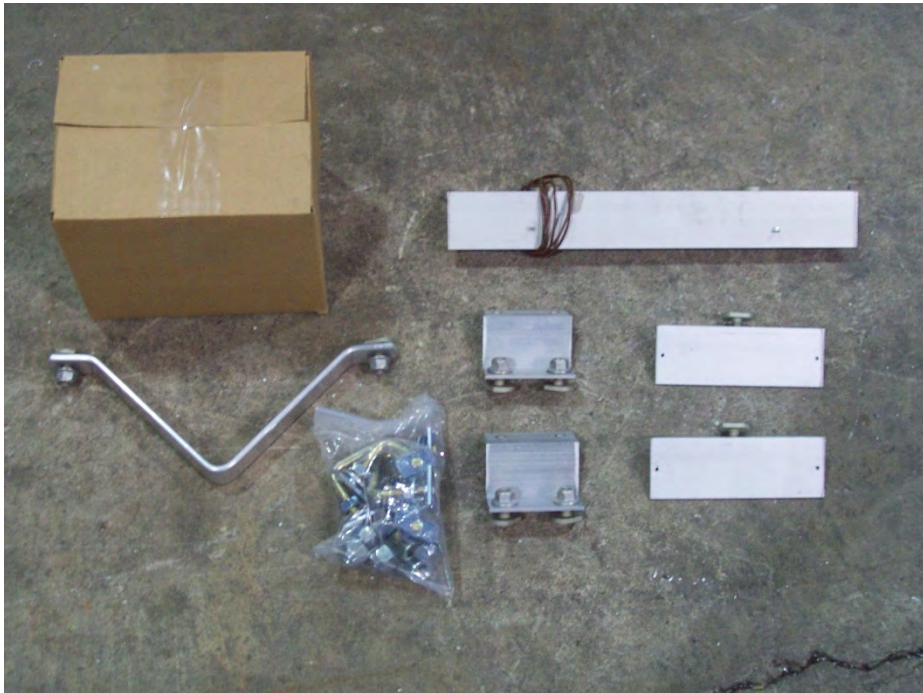


Axle assembly, springs and U-bolt hardware

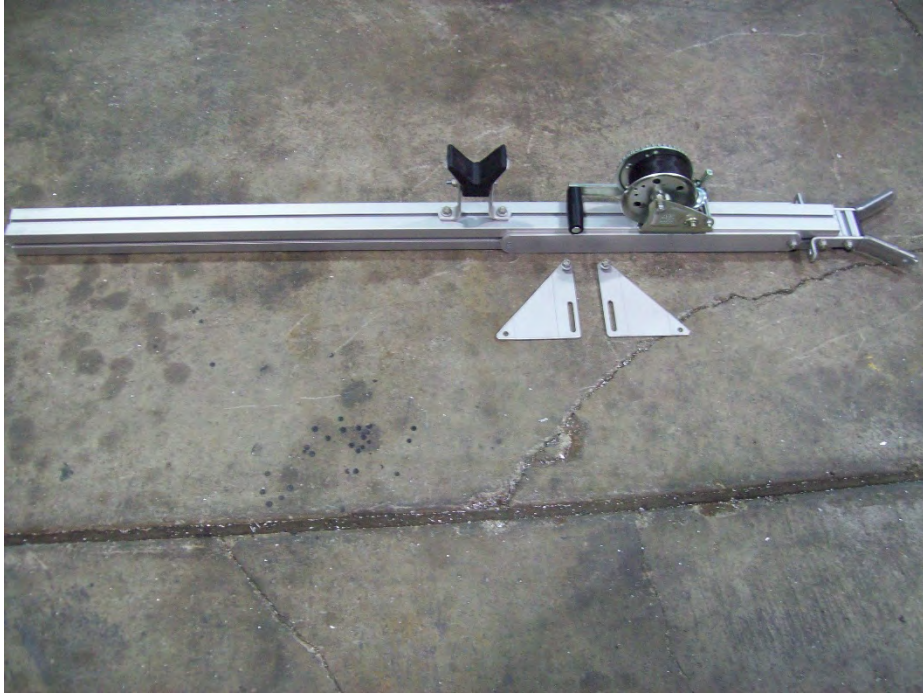




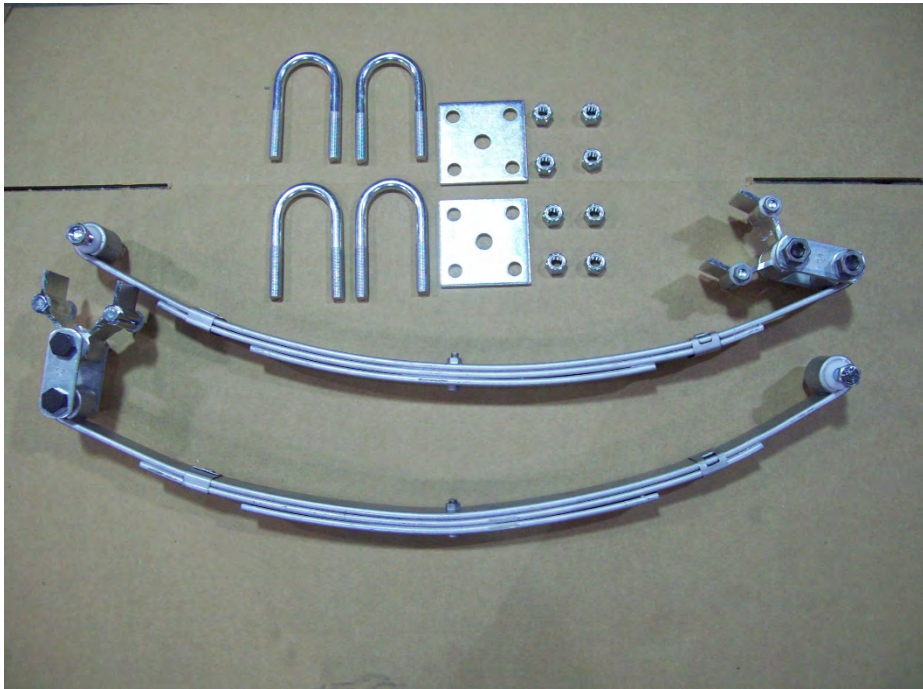
Fenders assemblies, tires



Light kit, skid, web strap clips, stop light bracket, tail light brackets, and side marker brackets.



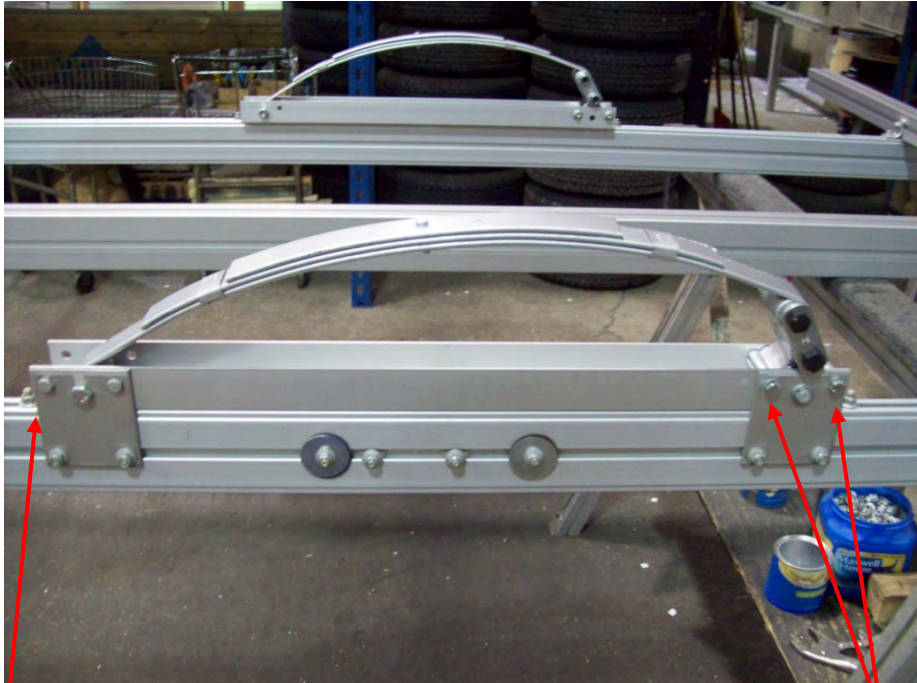
Mast stand with triangle plates. (Shown with optional winch)



Locate the (2) spring assemblies, (4) U-bolts, (2) plates, and (8) nuts.



## Spring and axle installation



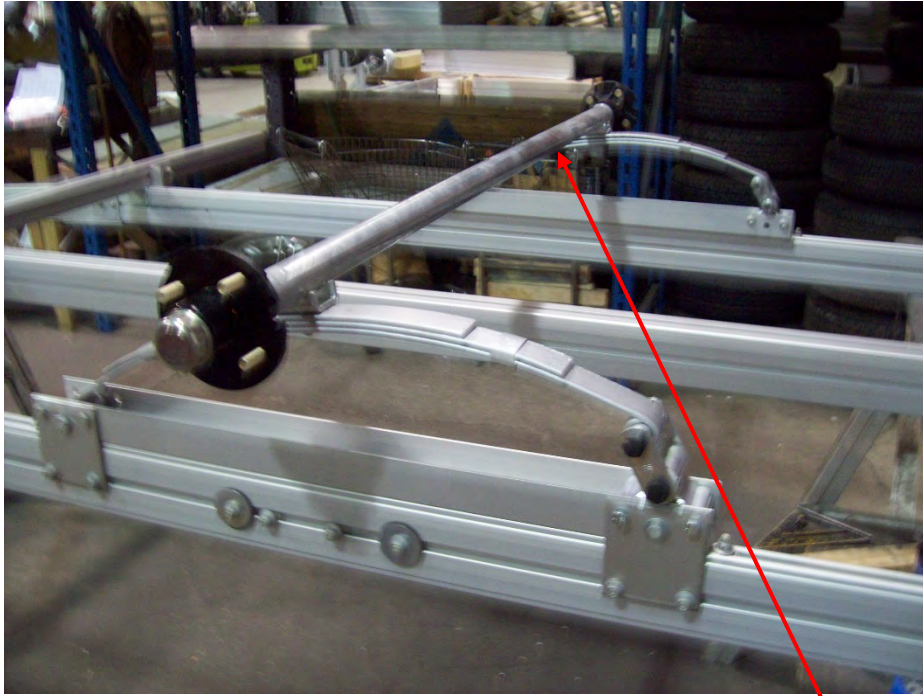
Front of sub rail clip

Tighten the shackle holder nuts

Install the front bolt from the leaf spring in the center hole of the front sub rail clip. Next install shackle holder assembly bolts in the two outer holes of the rear sub rail clip. Tighten the shackle holder nuts only. Do not tighten shackle nuts at this time.

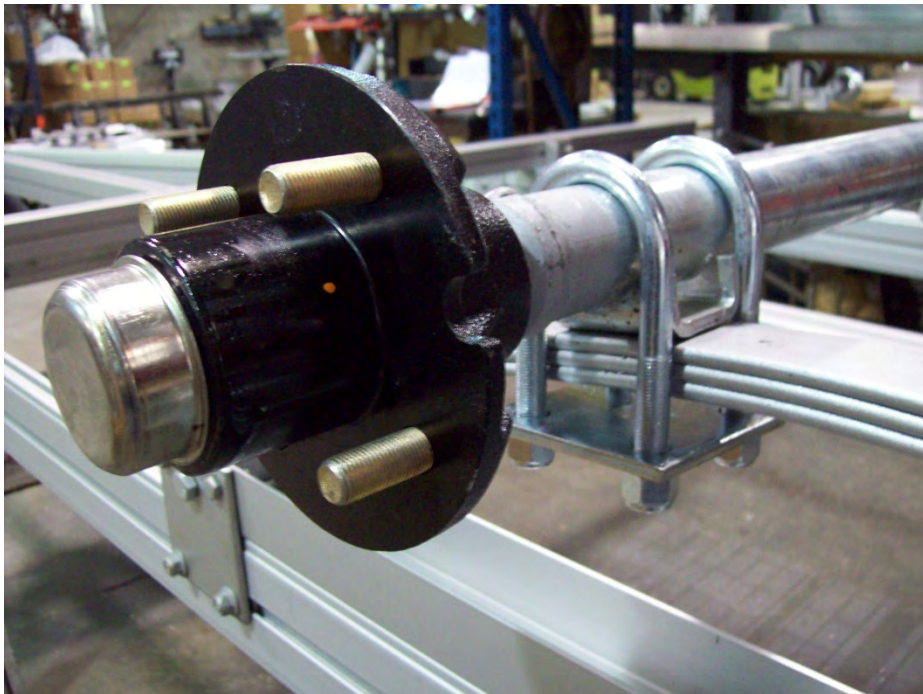


Install the axle making sure the locating studs on the springs are in the holes on the axle's spring seat



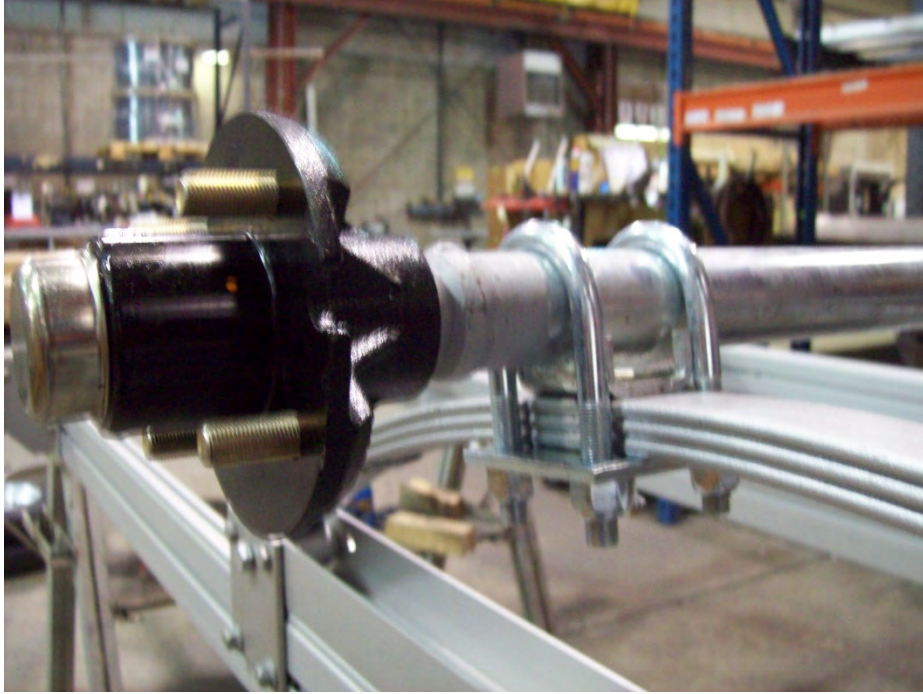
Serial plate

Face the axle's serial plate toward the rear of the trailer to protect it from debris.

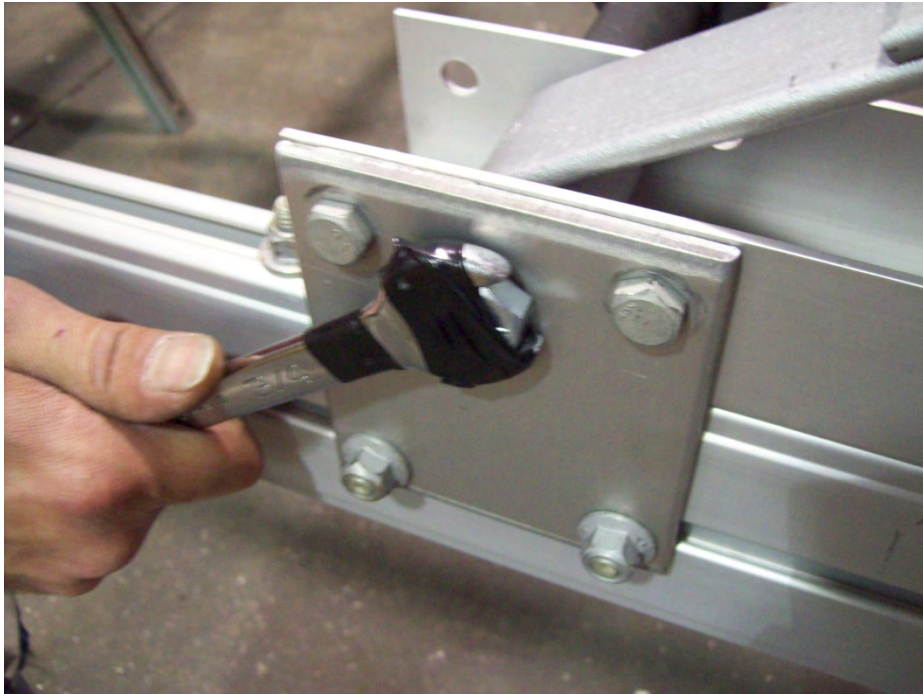


Install the U-bolts, tie plates and nuts as shown.

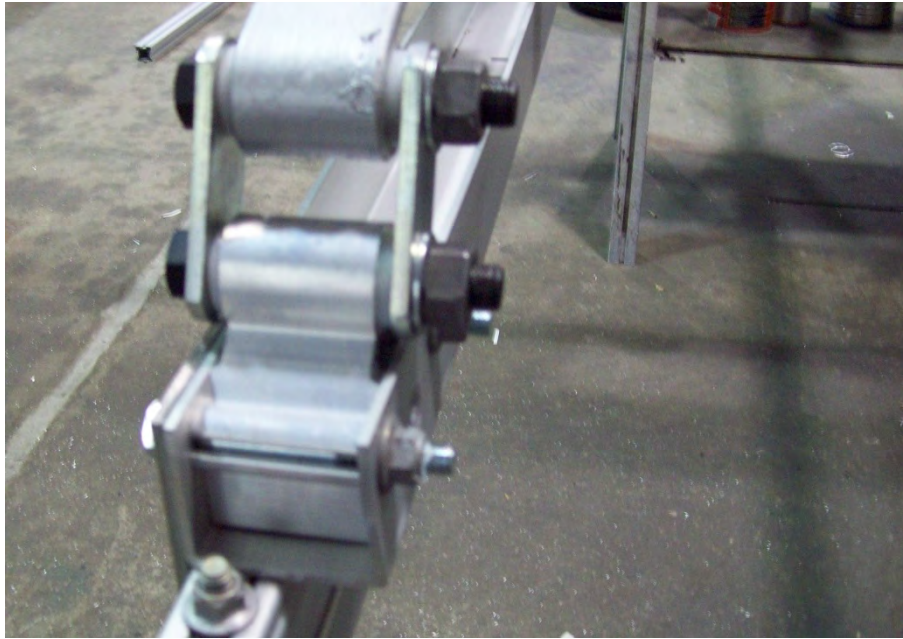




Tighten all the nuts evenly as shown in the picture.

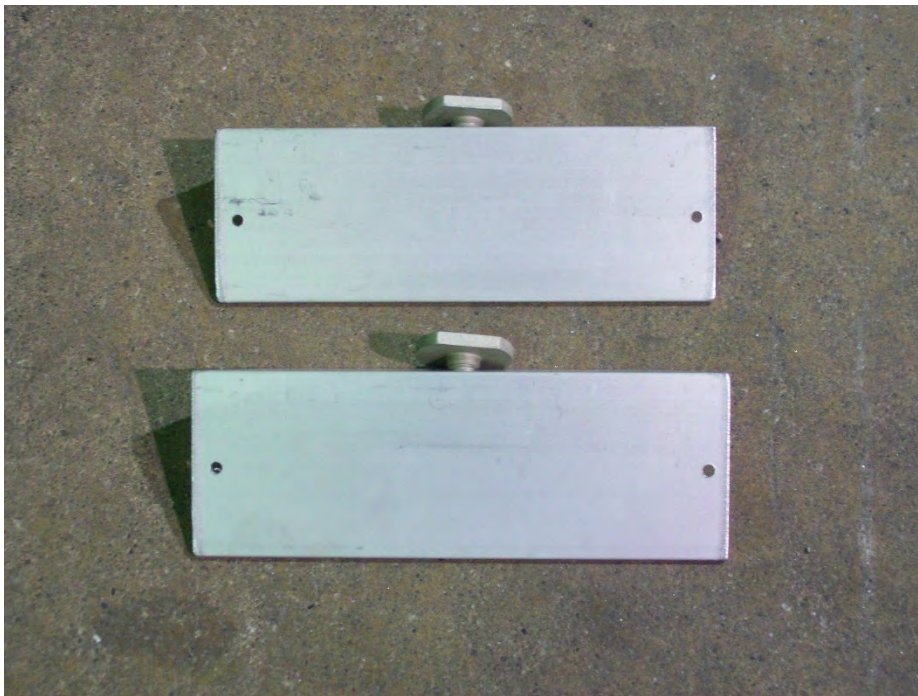


Now go back and first tighten the front spring mounting nuts that were left loose previously.



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

### **Tail light and marker light mounting**



Locate the side marker light brackets.

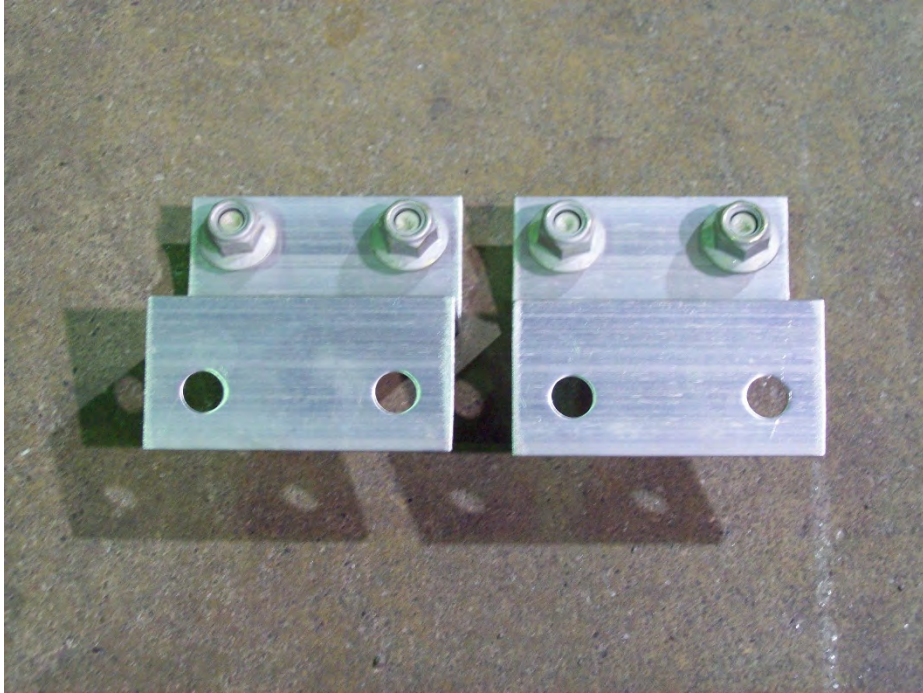




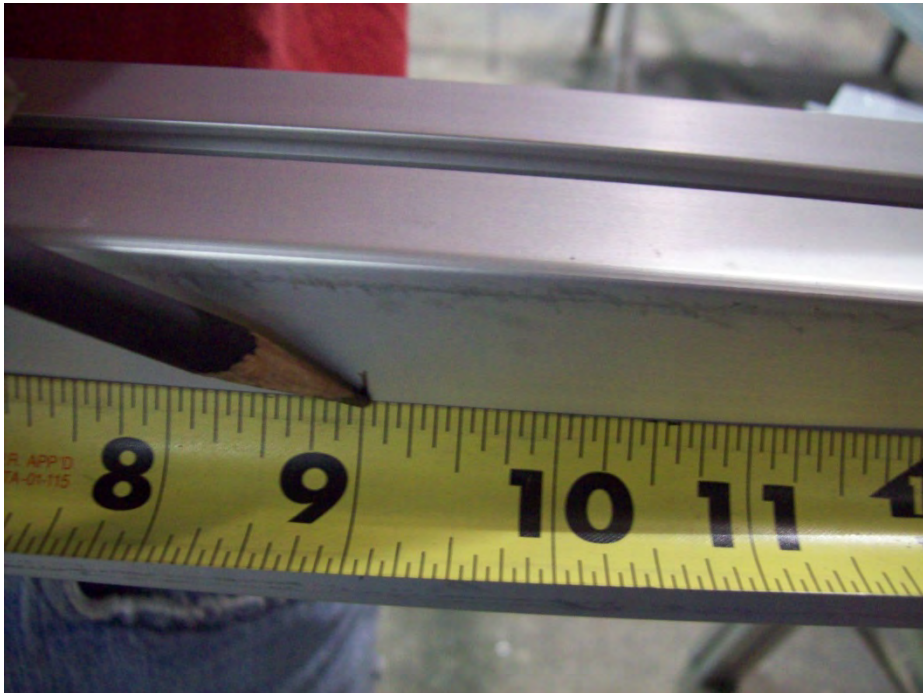
On each side of the front cross member make a pencil mark 3” in from the edge of the cross member.



Slide marker light bracket into position and tighten nuts. Repeat the process for the other side.

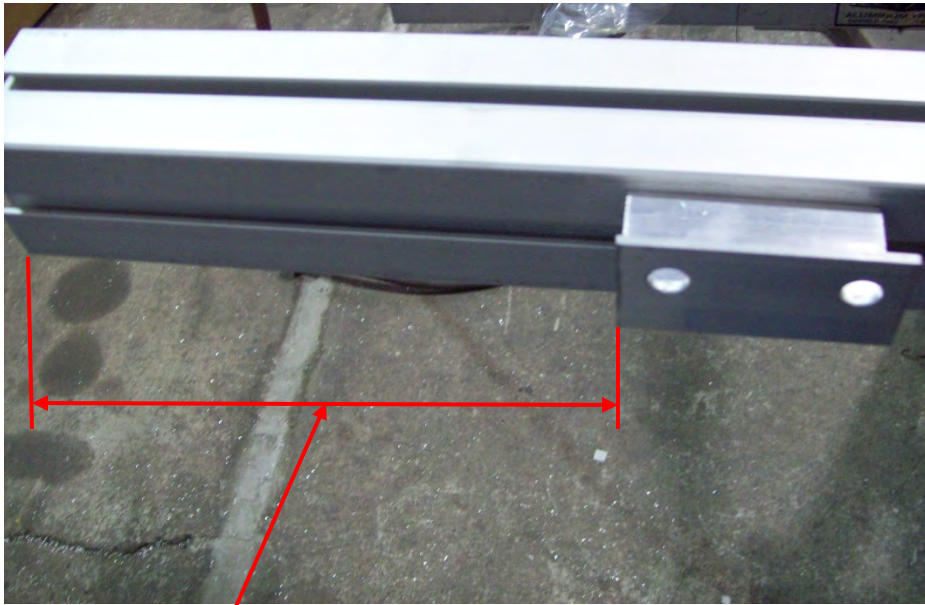


Locate the rear tail light brackets.



From the outside edge of the rear cross member measure in 9" and make a pencil mark as shown.





9 inches

Insert the tail light bracket into the cross member and slide over to the pencil mark. Once in position tighten nuts. Repeat the process for the other side.

## Wiring and lights

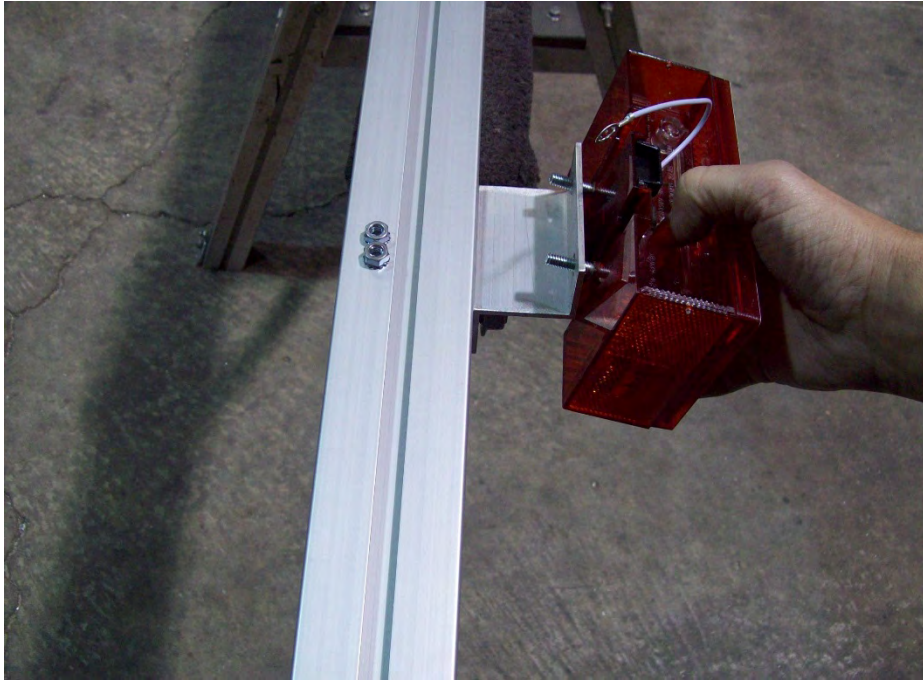


Locate the tail lights, license plate bracket, 4) carriage bolts and 4) nuts inside the light kit box.

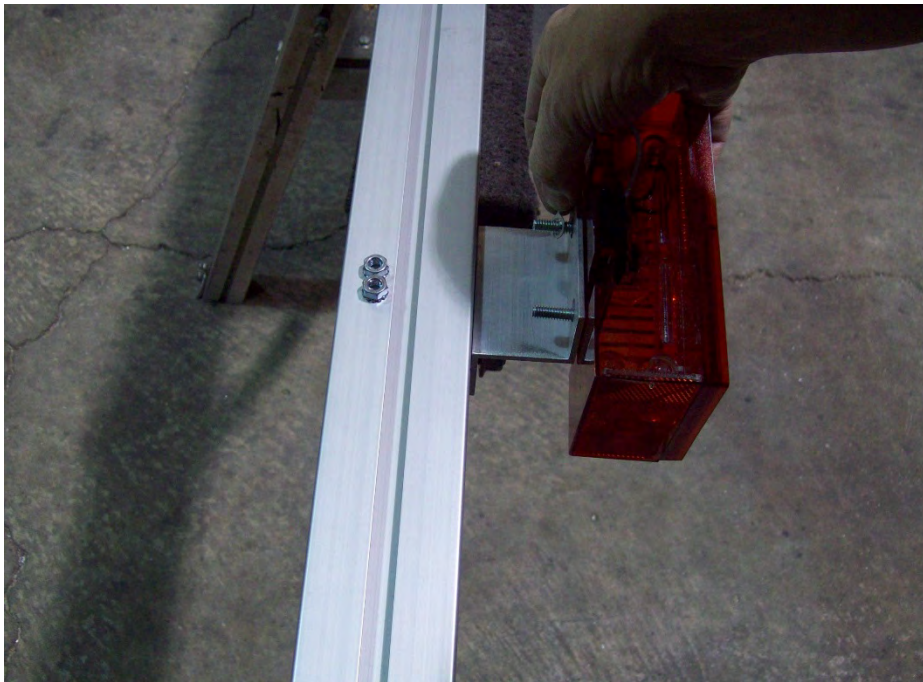


The light with the yellow wires is for the left (driver's side) of the trailer. Install carriage bolts into the back of the tail lights as shown.

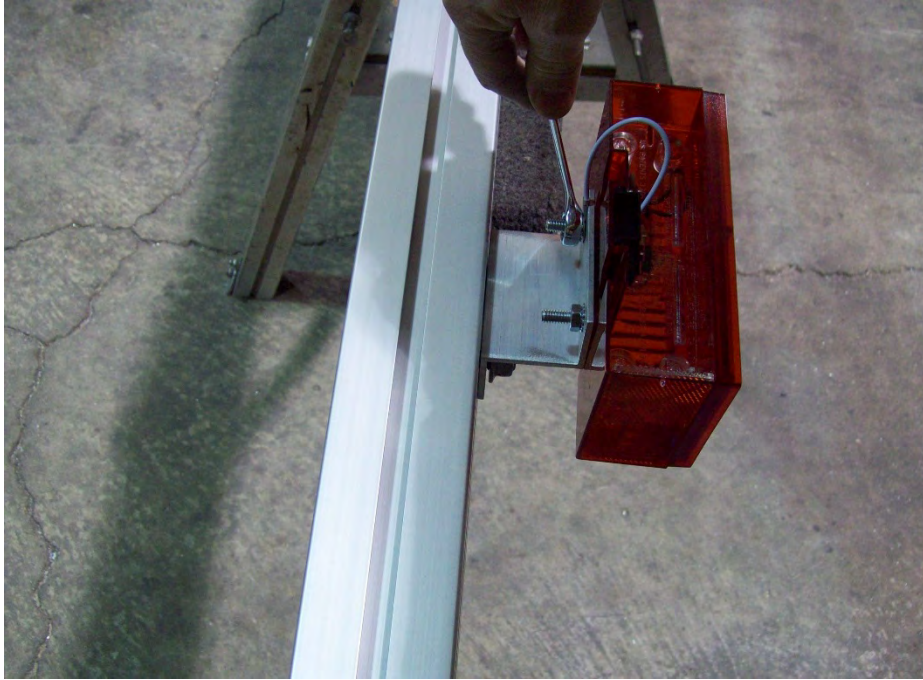




**Passenger side tail light shown**



Install the right tail light onto the bracket and then place the ground wire over top of the bolt as shown.

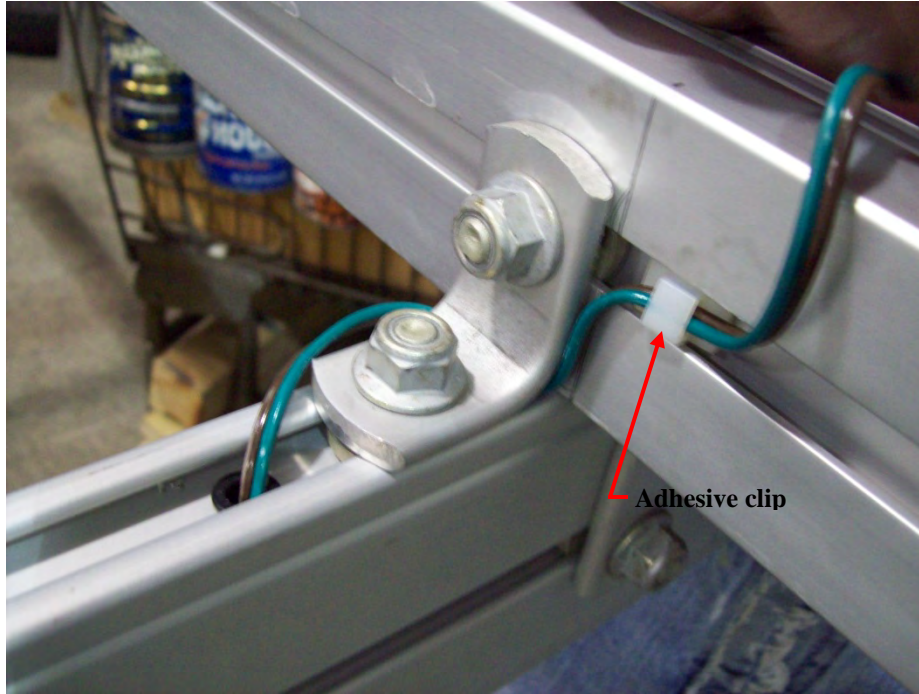


Install nuts and tighten but don't over tighten them.



Remove harness out of the channel on the side rail as shown.

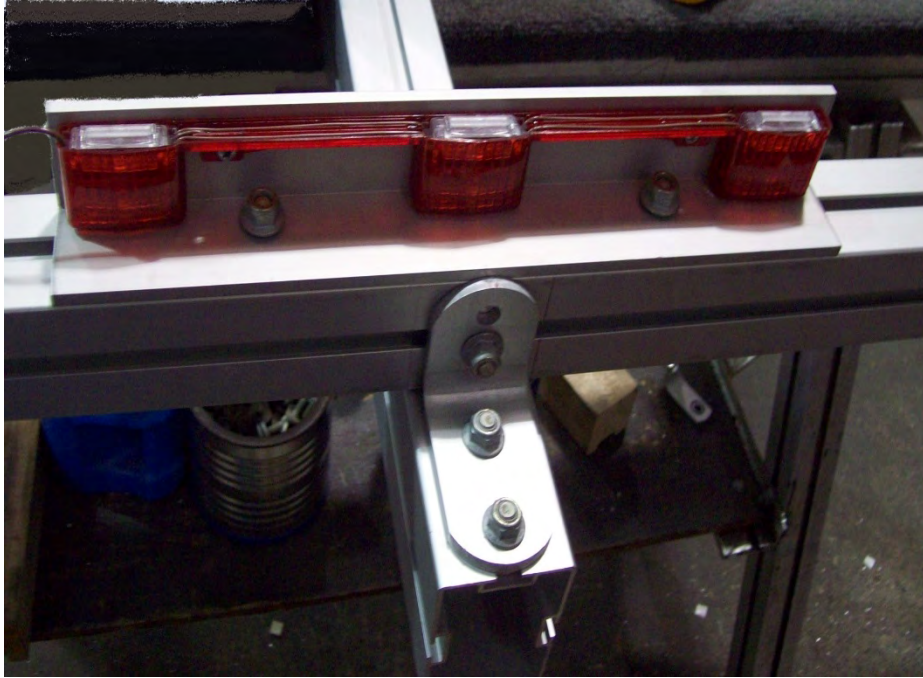




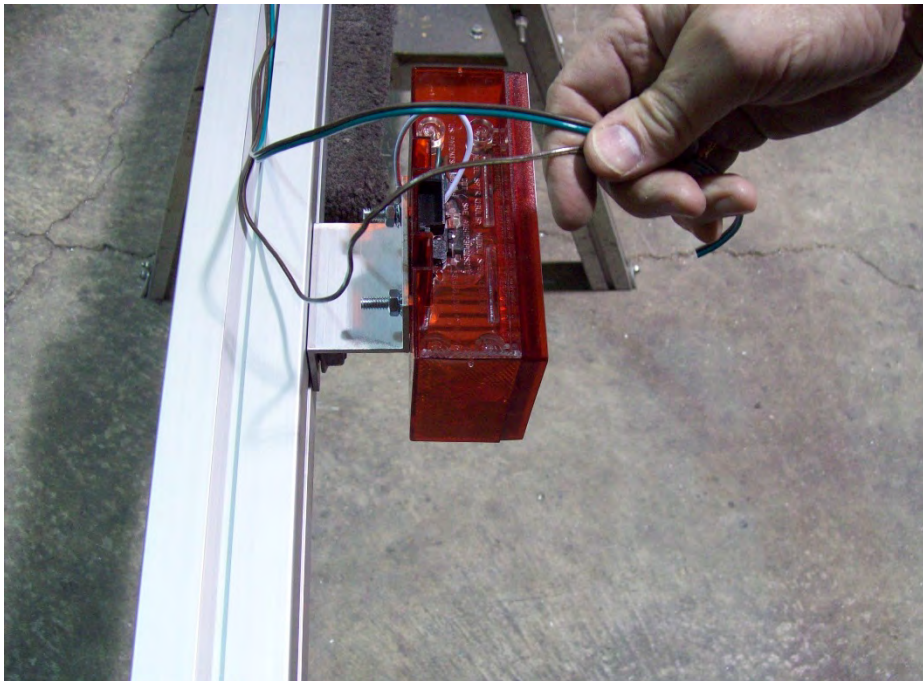
Loop the harness behind the angle bracket and up onto the cross member. Install one adhesive clip to hold harness in place to upper cross member as shown.



Locate the three light bar with mounting bracket. Insert T-bolts from mounting bracket into the rear cross member and slide towards the center.

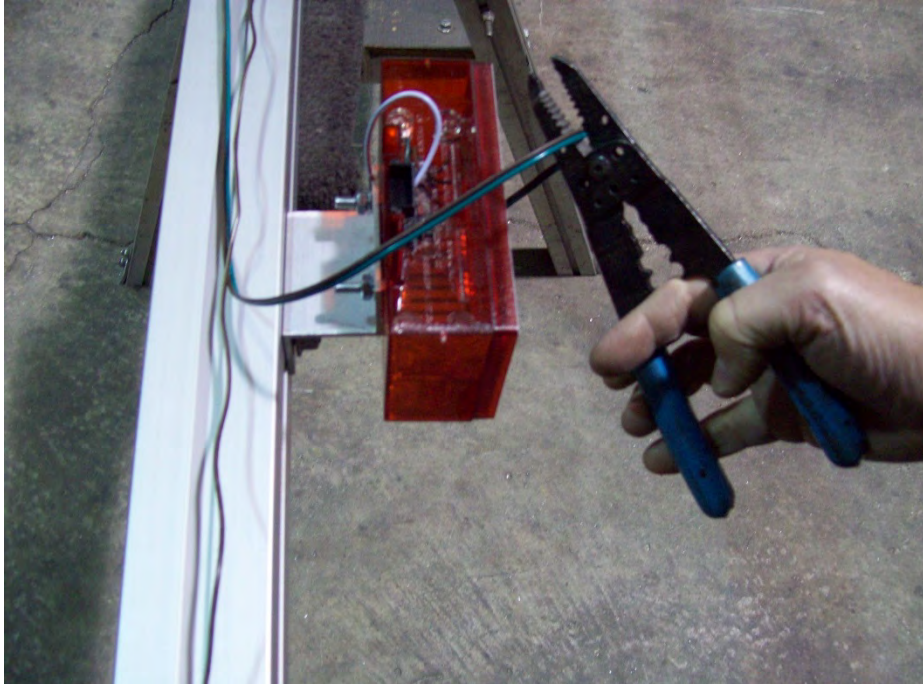


Center the three light bar up with the tongue section and tighten nuts.

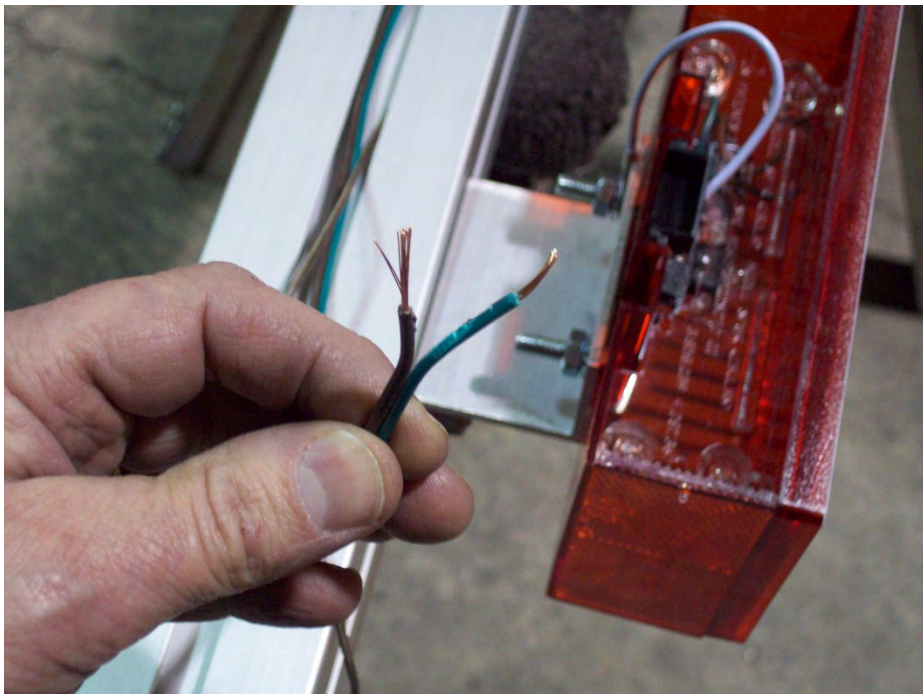


Take the brown wire from the three light bar and the harness and run them across to the right side tail light.

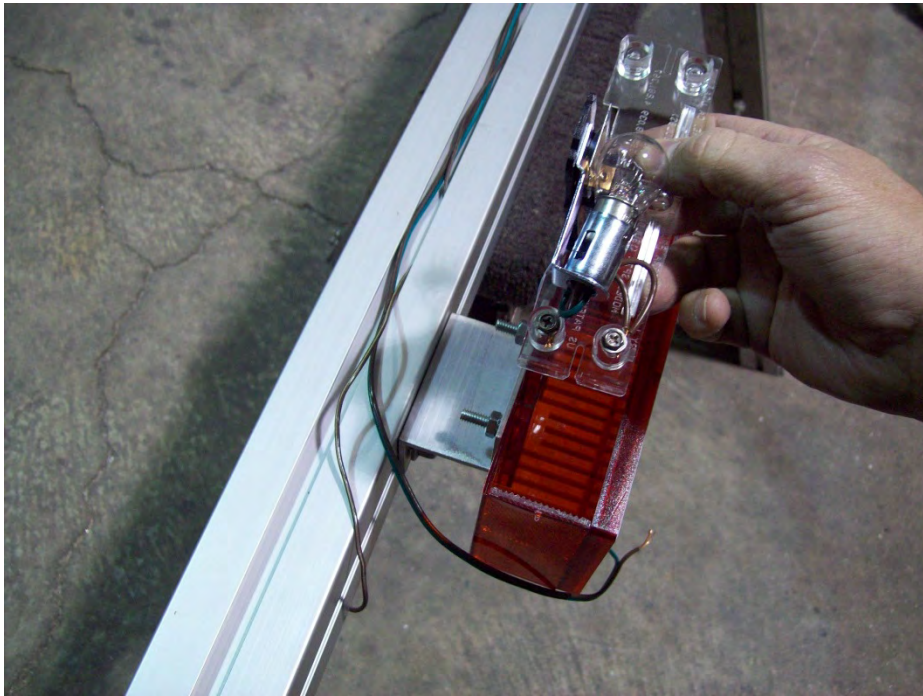
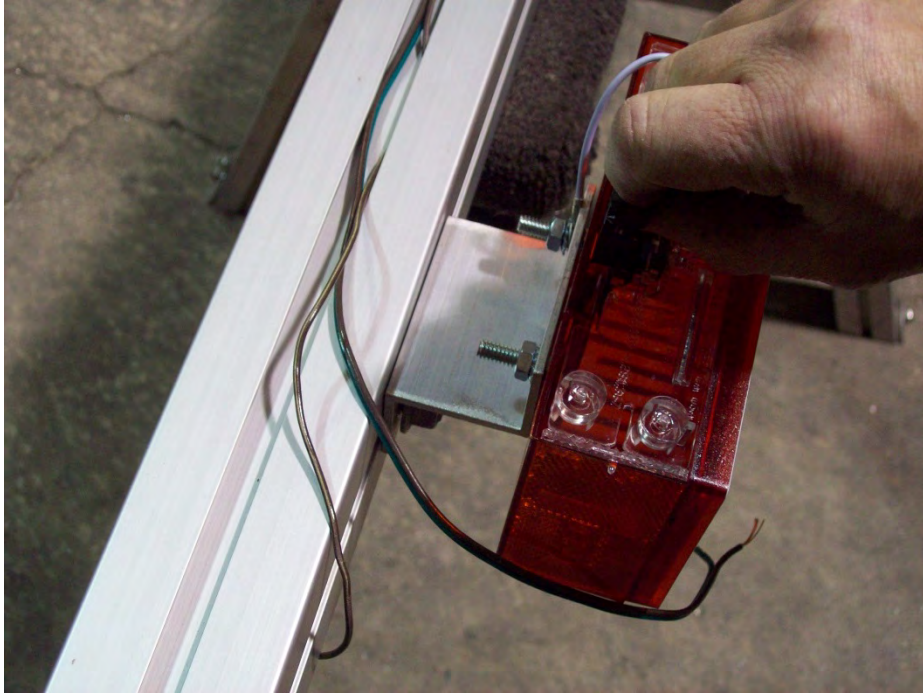




Make sure you have enough harness to reach the tail lights before you trim off excess wire from the harness and the three bar light.

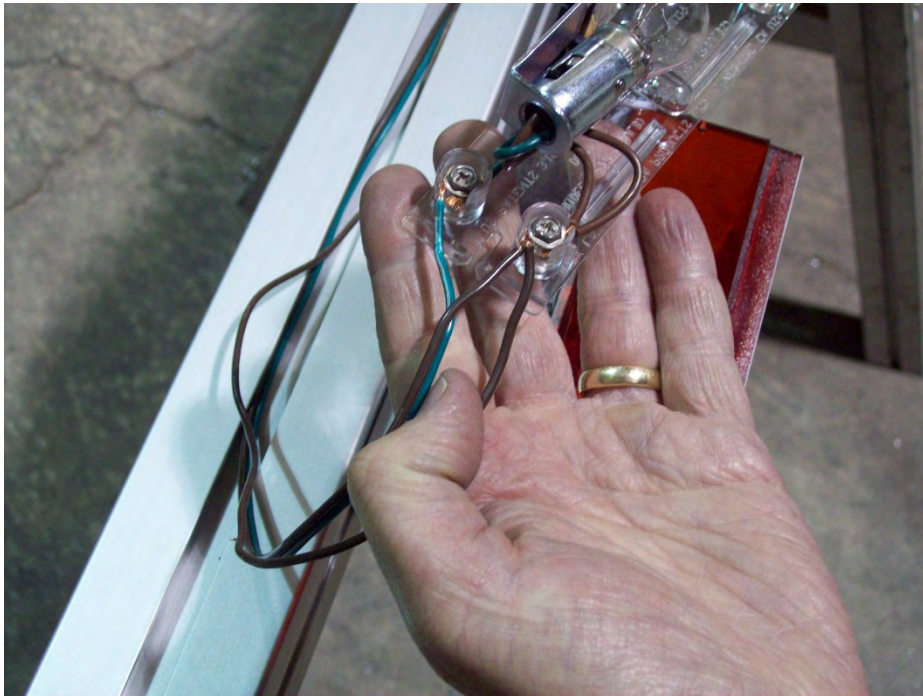


Strip about 1 1/2" of casing off the harness and the three bar light wire.

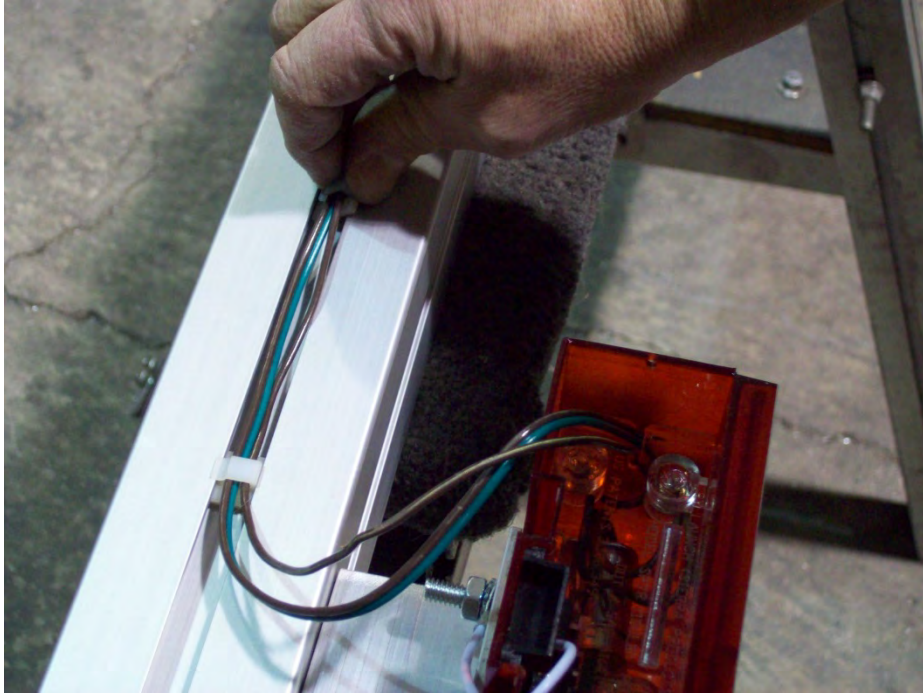


Locate the black tab at the bottom of the tail light. Move the tab toward the rear of the trailer and pull up releasing the bulb assembly from the light housing.



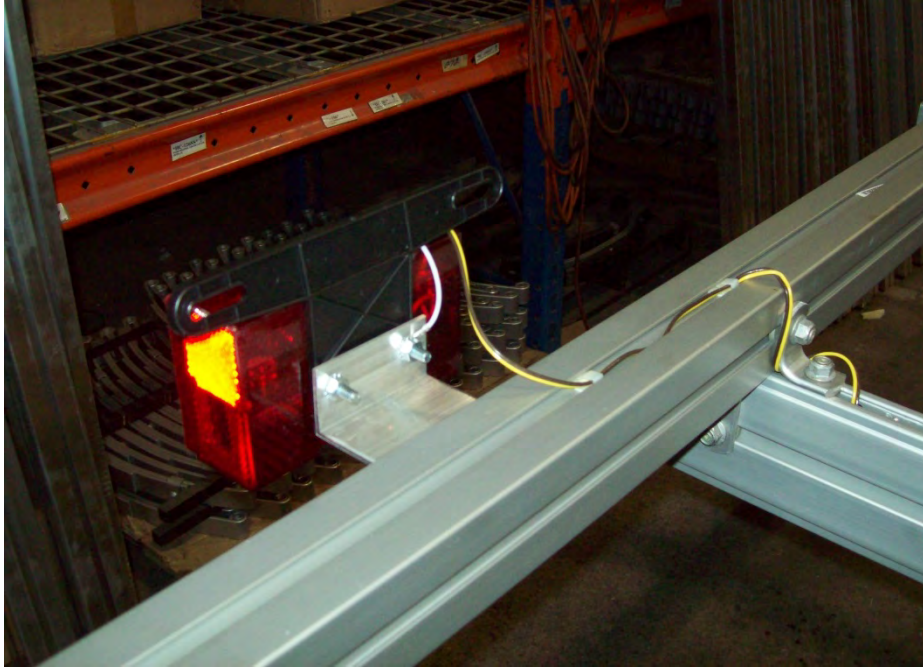


Twist the brown harness wire and the brown wire from the three bar light together. Loosen the wire retaining screws and install the color matching wires from the wire harness onto the corresponding retaining screws.

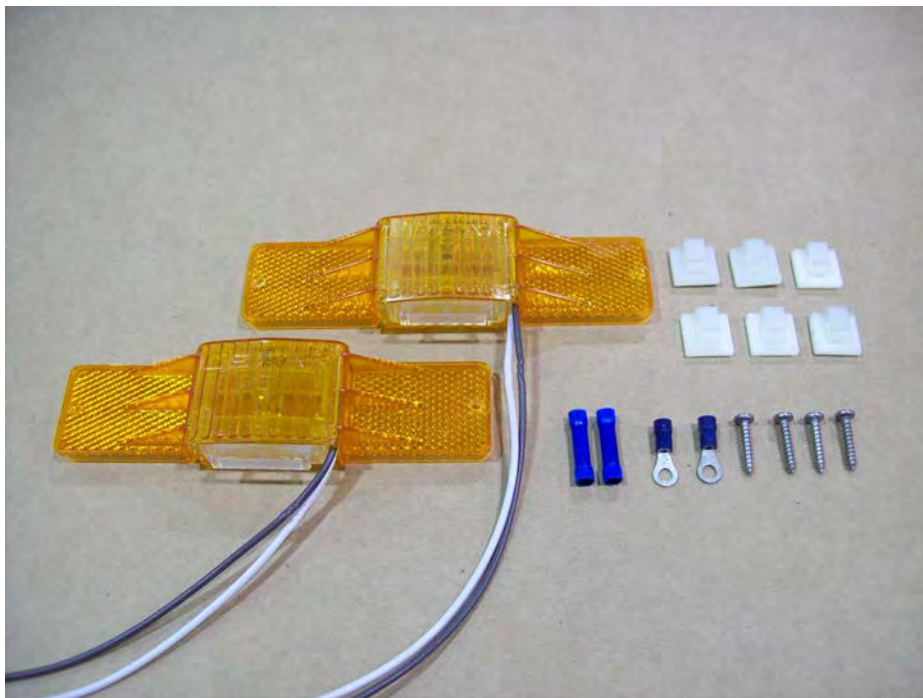


Reinstall into the housing and insert adhesive clips into the channel to hold the harness in place.





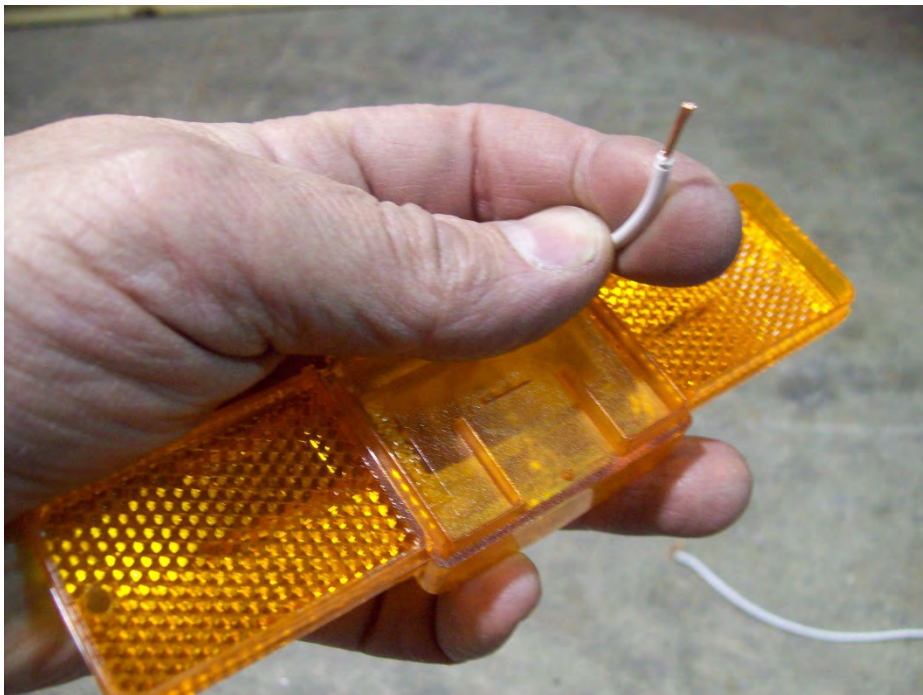
Install the left tail light with the license plate holder between the light and the bracket. Then repeat the wiring process used for the other side.



Locate the two amber marker lights, adhesive backed clamps, two butt connectors, two ring terminals, and four Phillip screws.

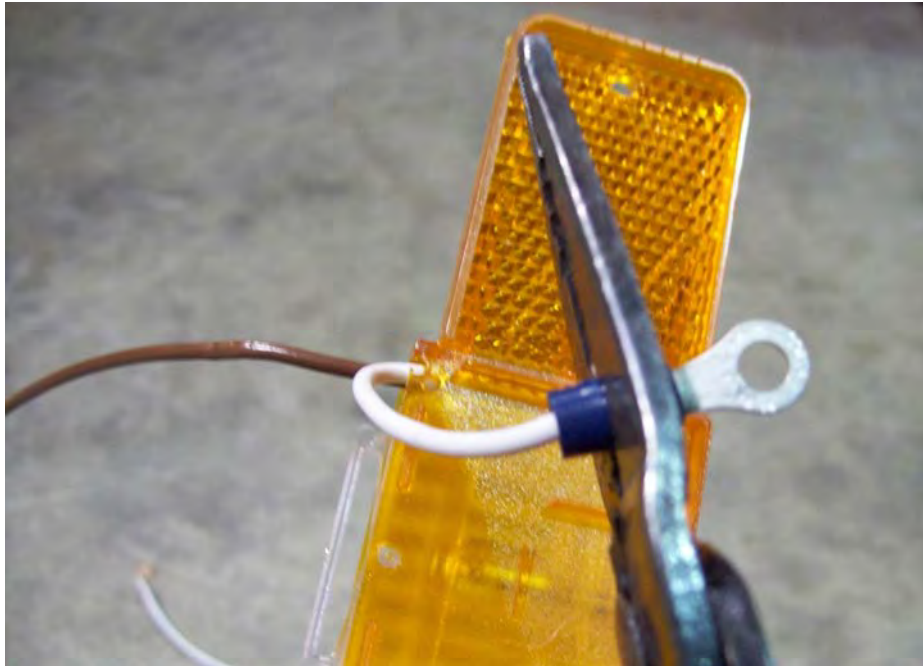


Cut approximately 8 ½” off of the white wires on both marker lights.

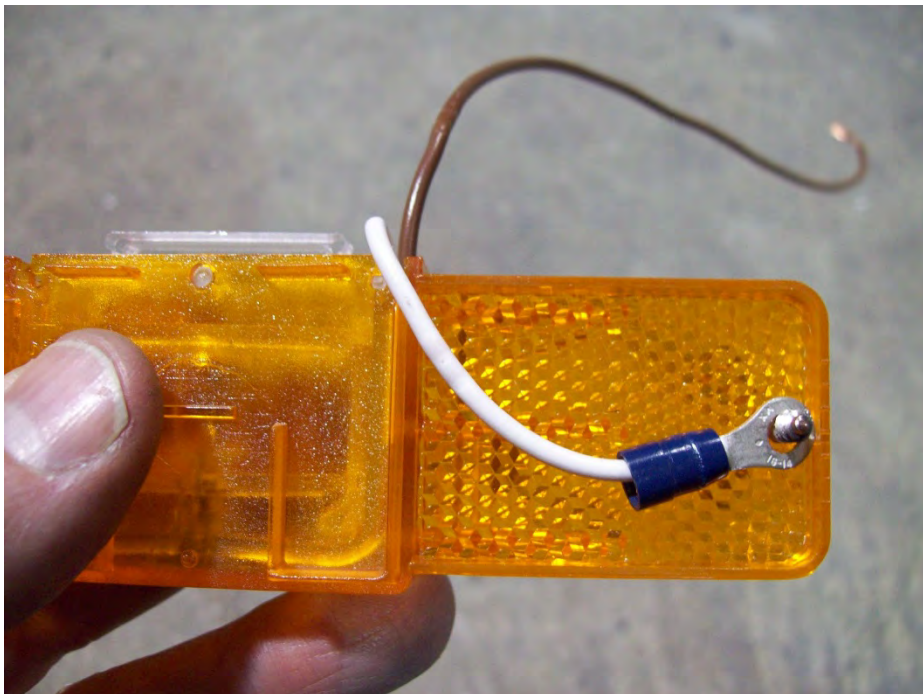


Strip ¼” of insulation from the wire.

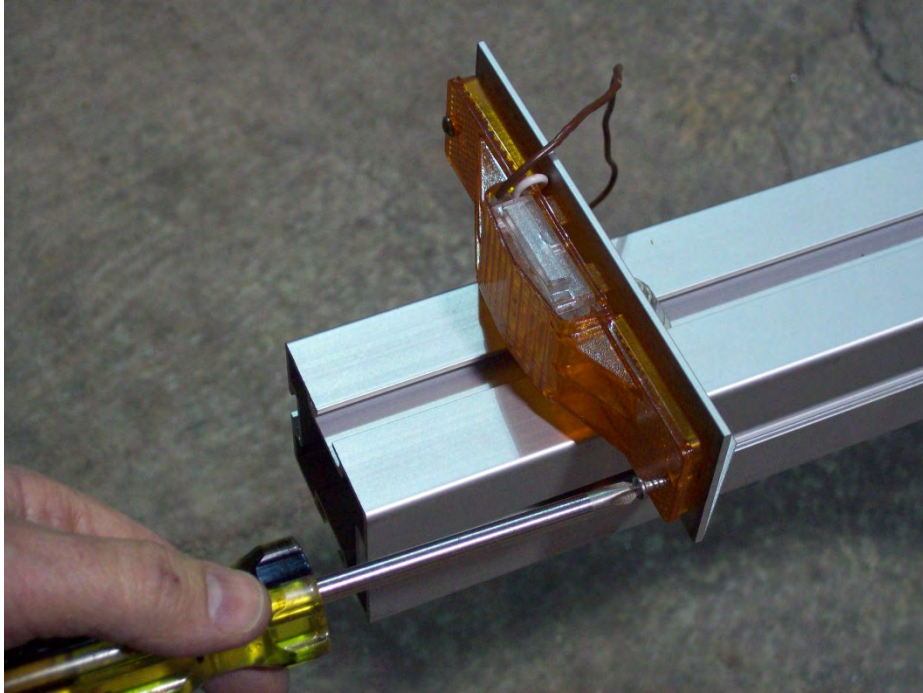




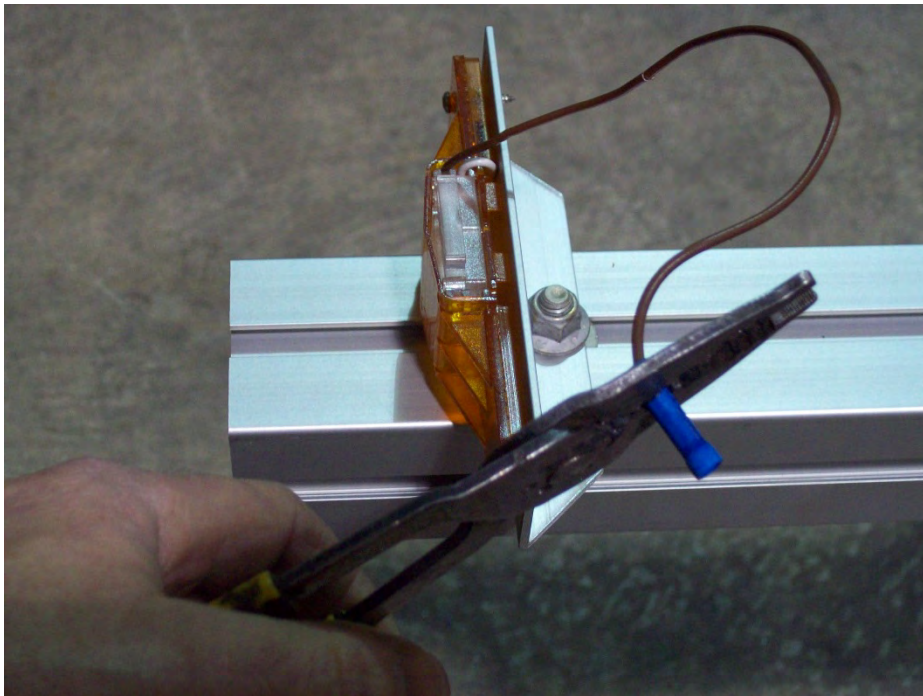
Install the ring terminals by crimping the terminal onto the bare wire.



Align the ring terminals with the screw hole nearest the wire on the back of the marker lights. 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.

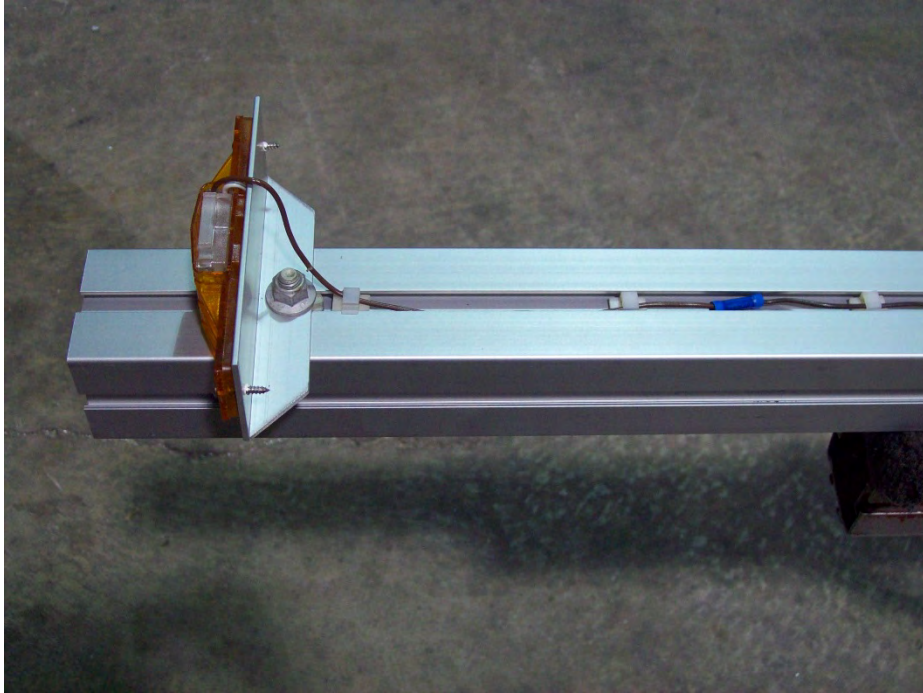


Install the marker light on the bracket making sure the screw goes through the ring terminal on the white wire.



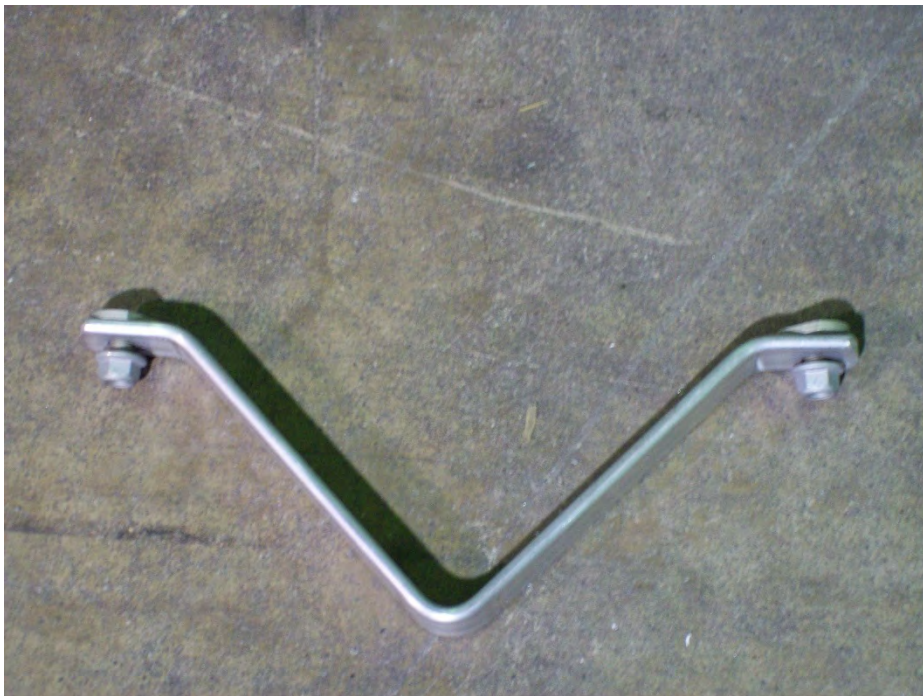
Take the brown wire from the marker light and insert it into the butt connector and crimp it on.



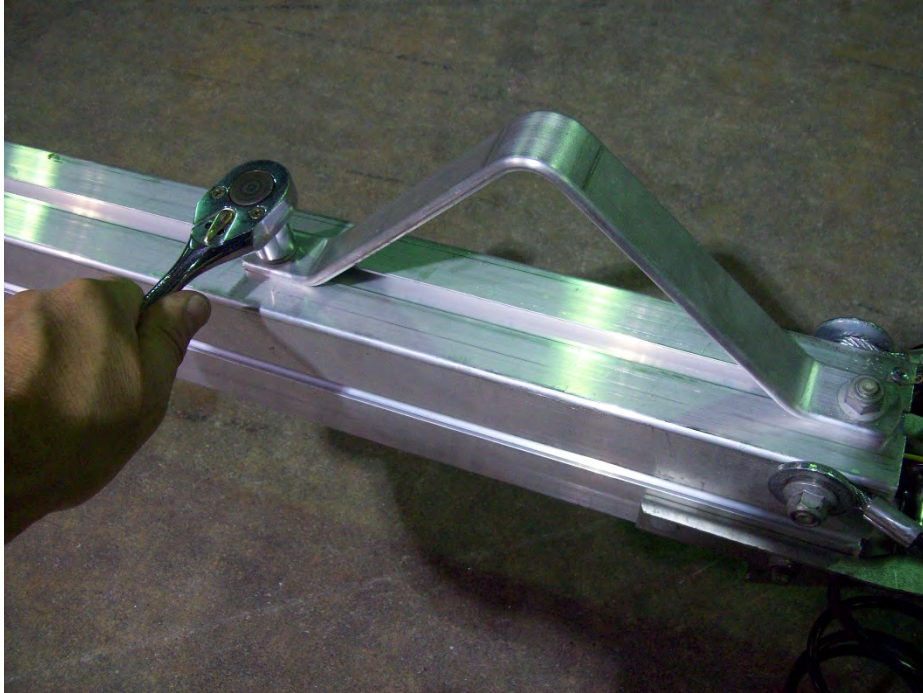


Bring the brown wire over from the side rail and insert into the butt connector and crimp it on. Install adhesive clips to hold wire down as shown.

### **Installation of skid**



Locate the skid.



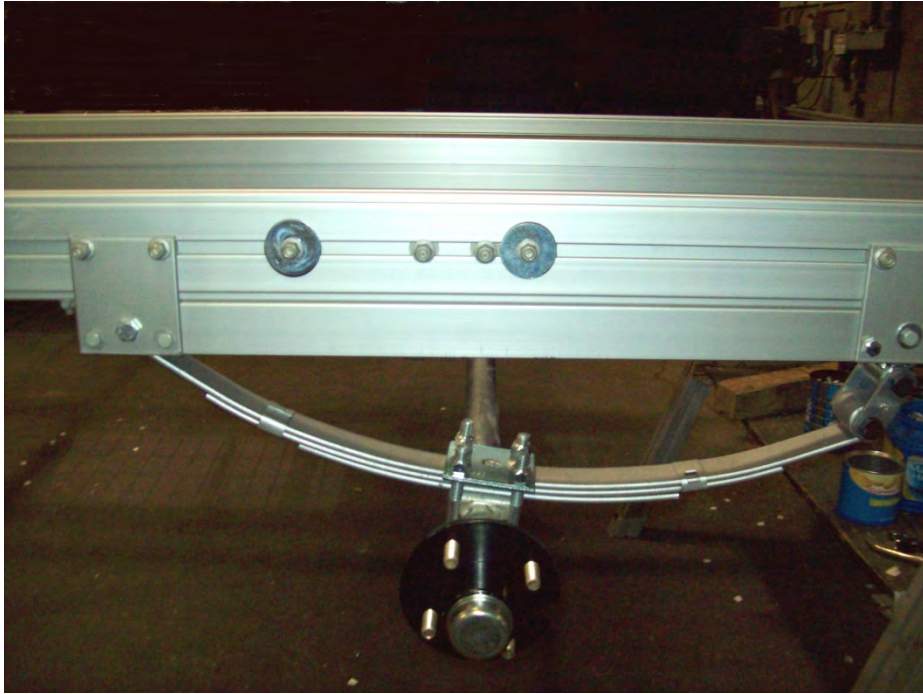
Install the skid into the slot in the bottom of the tongue and tighten nuts.

### **Fender installation**



Locate the fender with brace.





Turn frame over at this point in the assembly process. Remove the two nuts in the center and loosen the outer ones with washers.



Insert T-bolts into the holes at the top of the fender brace. Re-install nuts and center fender over top of axle then tighten nuts. Slide outer T-bolts with washers over top of the fender lip as shown and tighten in position.

## Wheels



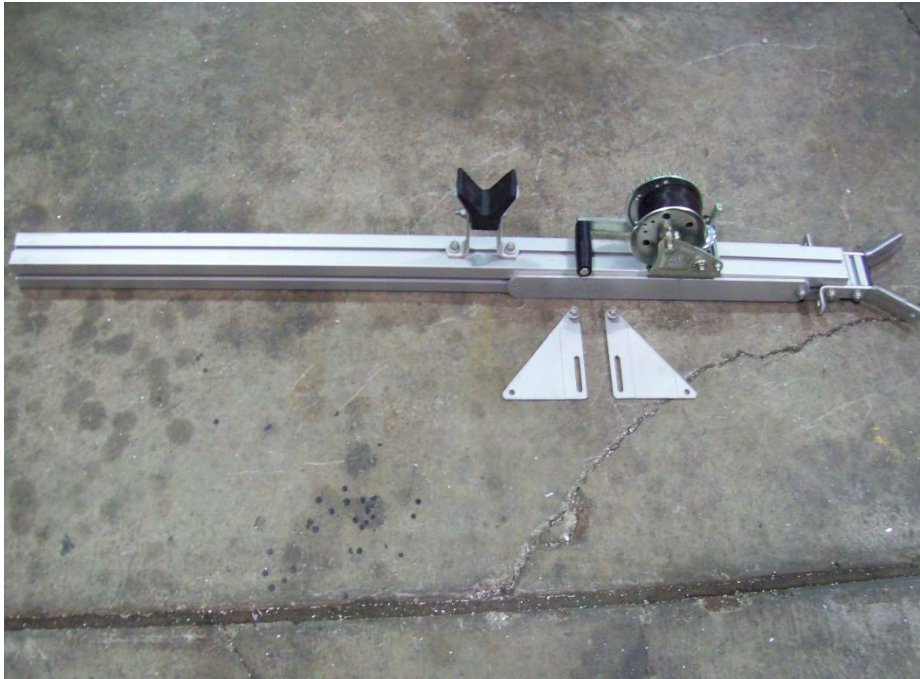
Locate the wheels, and 8) lug nuts.



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



## Mast stand (Shown with optional winch)



Locate the mast stand and (2) triangle plates.

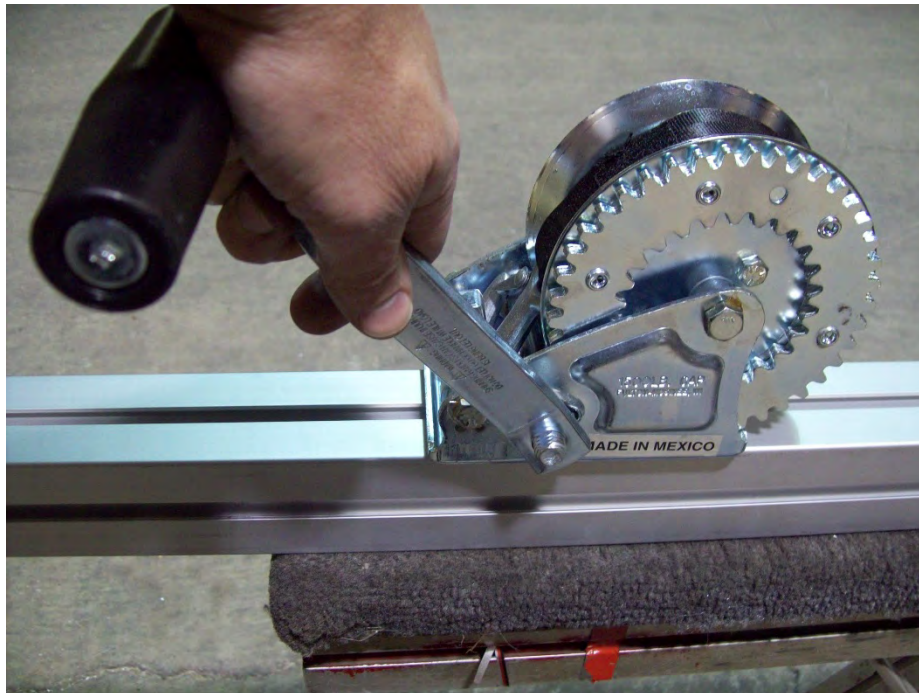


Remove the three nuts from both side of the front tongue.

## Optional Winch Installation

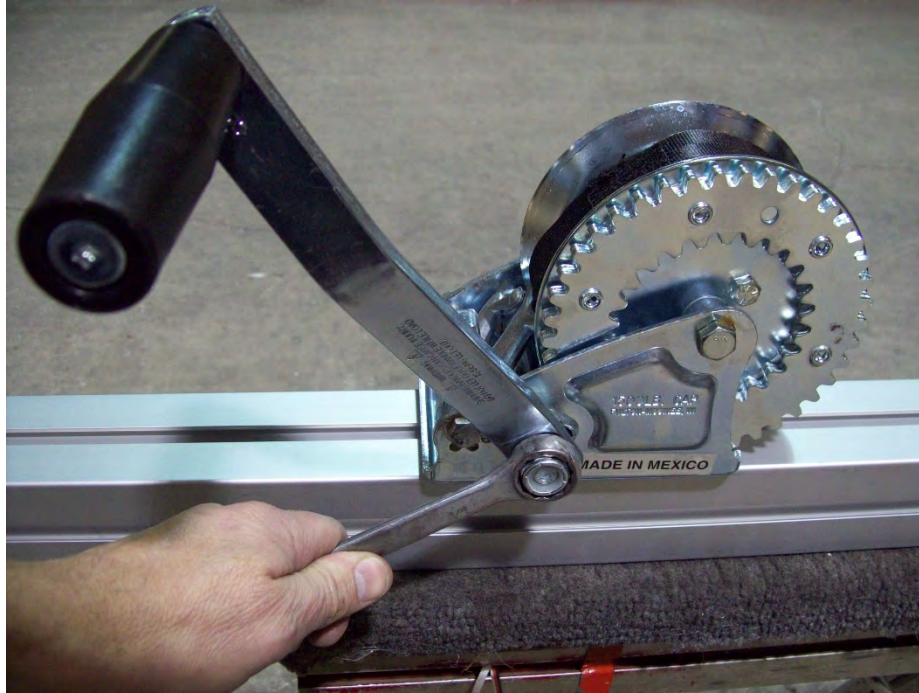


Remove the nut holding the winch handle on.



Take the handle off and flip it over and re-install the handle on the shaft with the handle facing out.





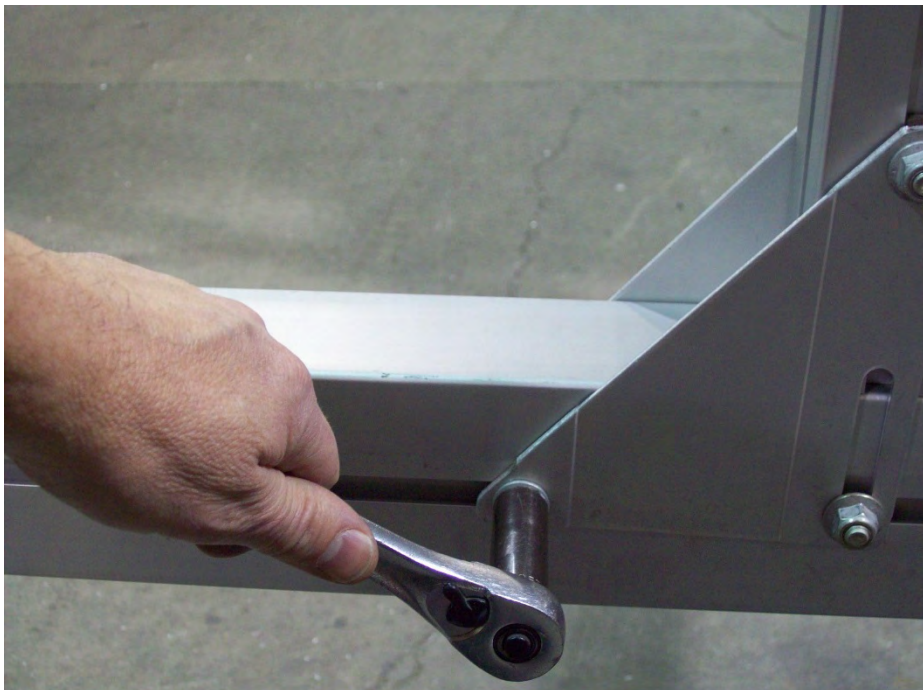
Re-install the nut and tighten.



Insert the triangle plates into the bottom of the mast stand as shown. Leave nuts loose at this point.

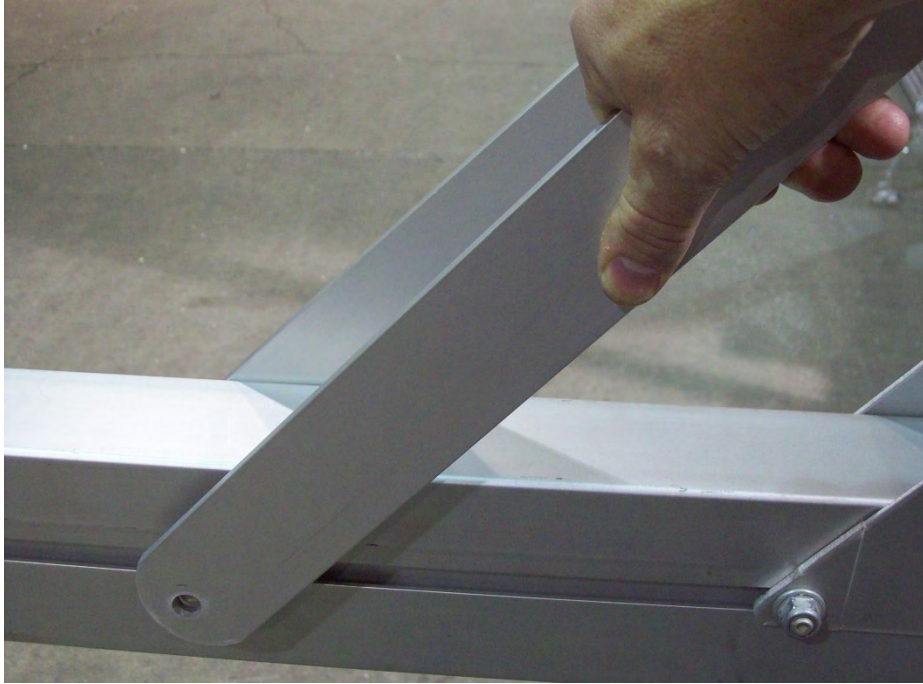


Install the triangle plates on the two rear T-bolts located on either side of the front tongue section.



Tighten nuts at this step, final adjustments will be made when boat is on the trailer.





Loosen the side arms and install over the T-bolts on each side of the tongue.



Adjust side arms with a triangle square at 45 degrees. Tighten nuts.

### **Installation of web strap clips**

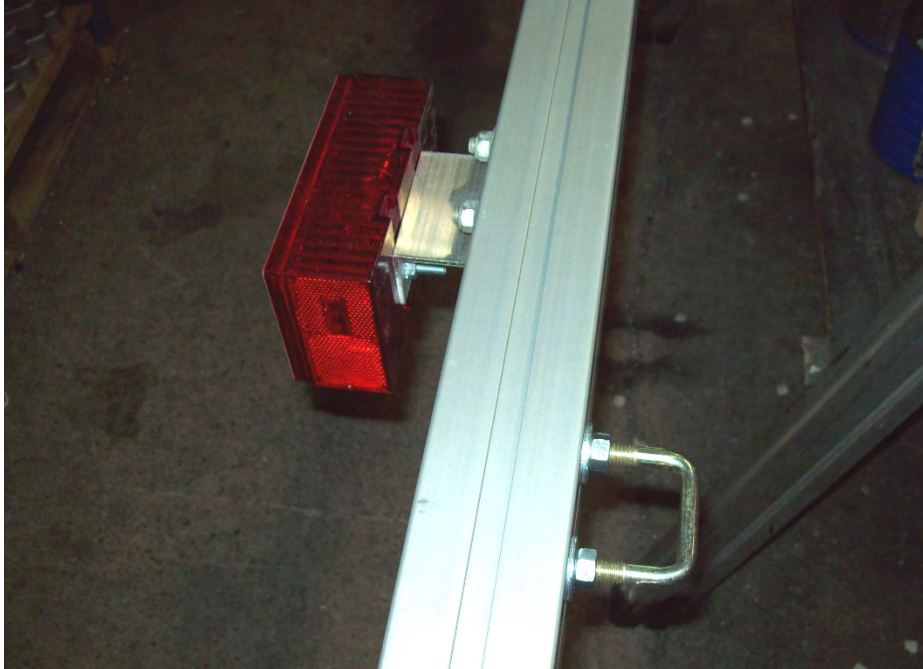


Locate the four web strap clips.



Install one web strap clip on each corner of the cross member and tighten.





Final position will be determined when the boat is on the trailer.



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

## Finished trailer



KJM 12/20/13 2/18/14

Shown with optional rollers, alignment guides, winch and bearing buddy.