TX-418HCR

Suggested Tools:

(3) Saw Horses

Standard Screwdriver

Phillips Screwdriver

Ratchet with 13/16", 9/16", ¾" Sockets

Torque Wrench

7/8", 9/16", ¾" Open End Wrench

Pliers

Wire Cutters

Square

Measuring Tape

Electrical Tape

Spray Lubricant

Utility Knife

(4) Wheel Chocks

Fish Tape

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.

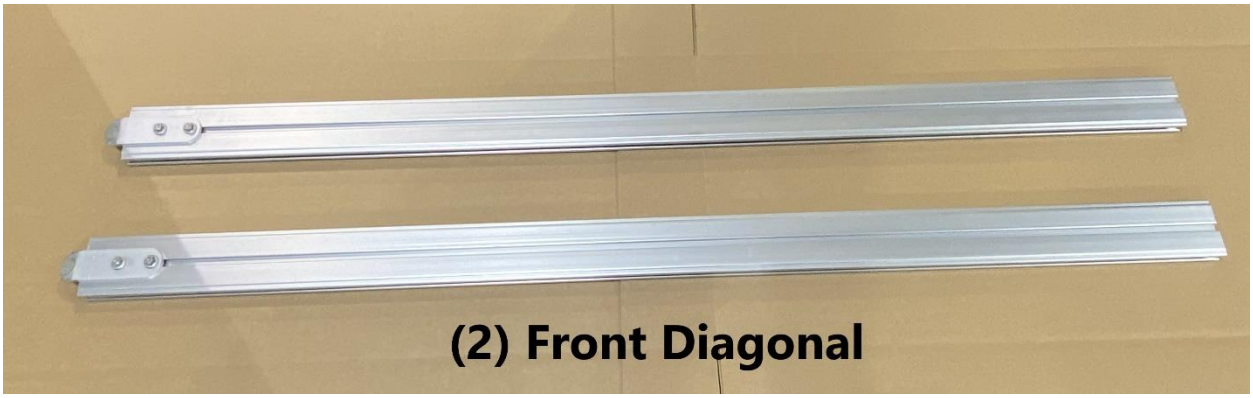
Re-torque wheel nuts after first 25 miles to 80 ft pounds and periodically thereafter.

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

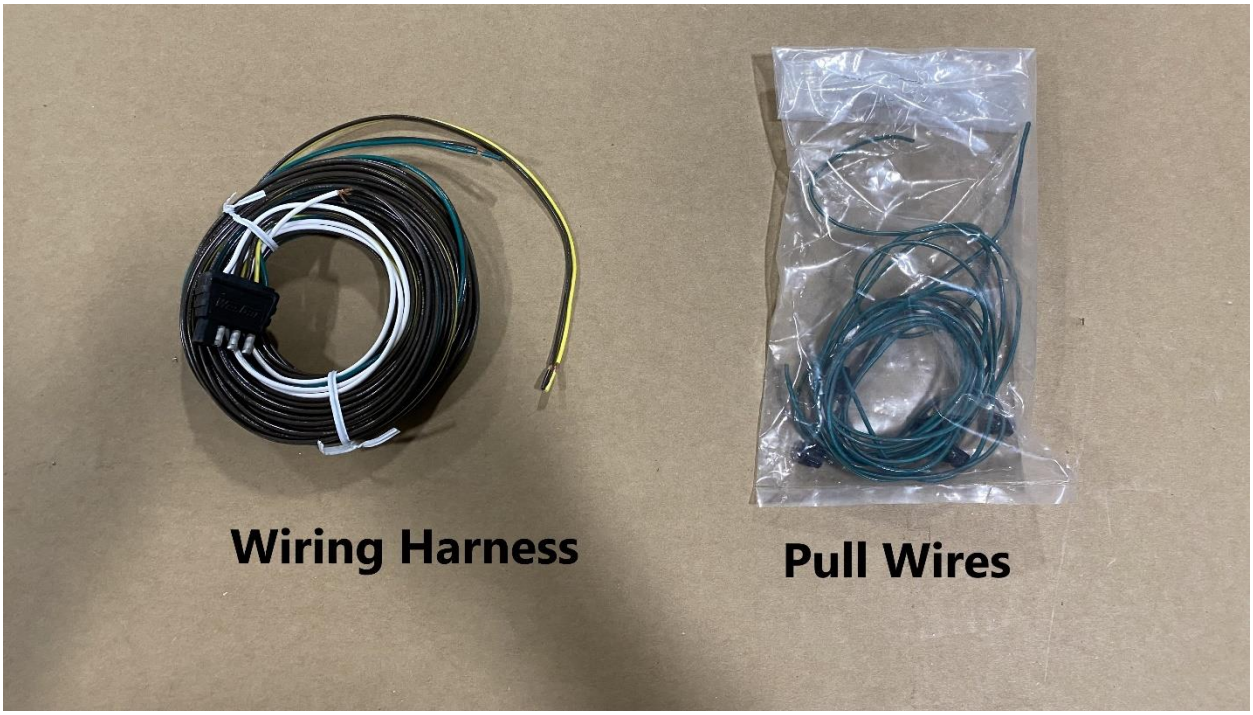
Incorrect assembly or modifications to your trailer will void any specific or implied warranty.

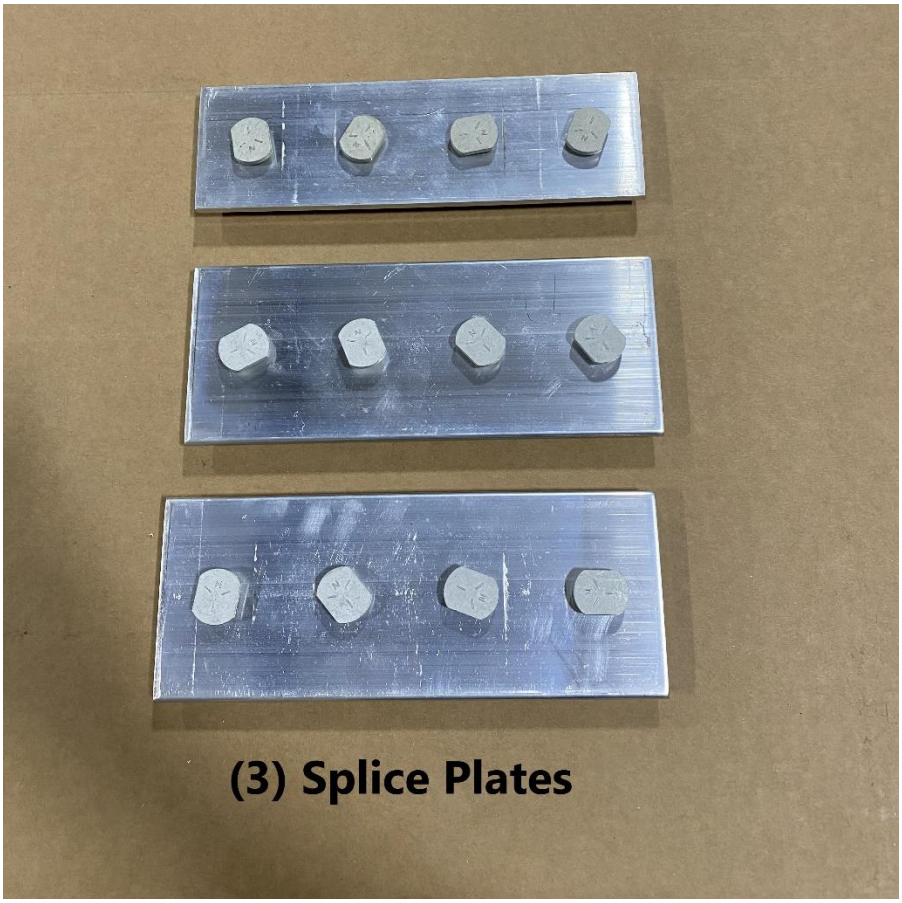
For questions or assistance assembling your trailer call 800-282-5042.

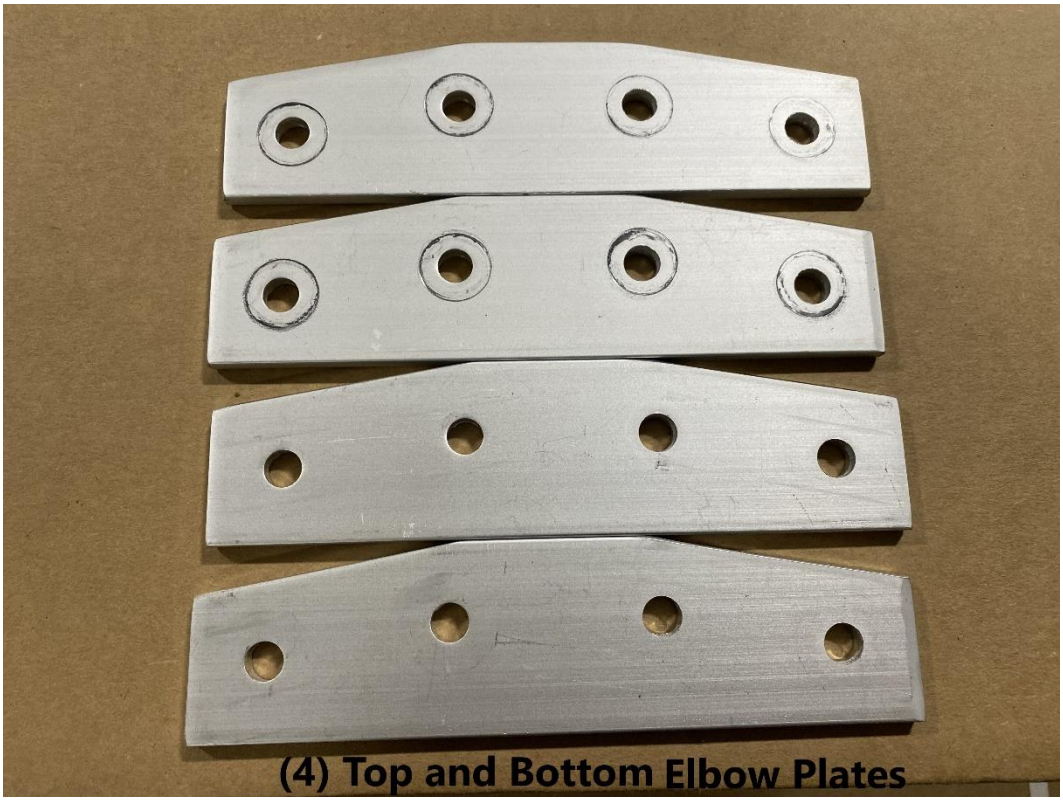
UNPACK AND IDENTIFY THE FOLLOWING PARTS:


(2) Front Diagonal


Top Apex Plate
Trailex
ALUMINUM TRAILERS
CANFIELD, OHIO
www.trailex.com
(330)533-6814
(800)282-5042
(877-TRAILEX)
Bottom Apex Plate


Wiring Harness
Pull Wires


(3) Splice Plates

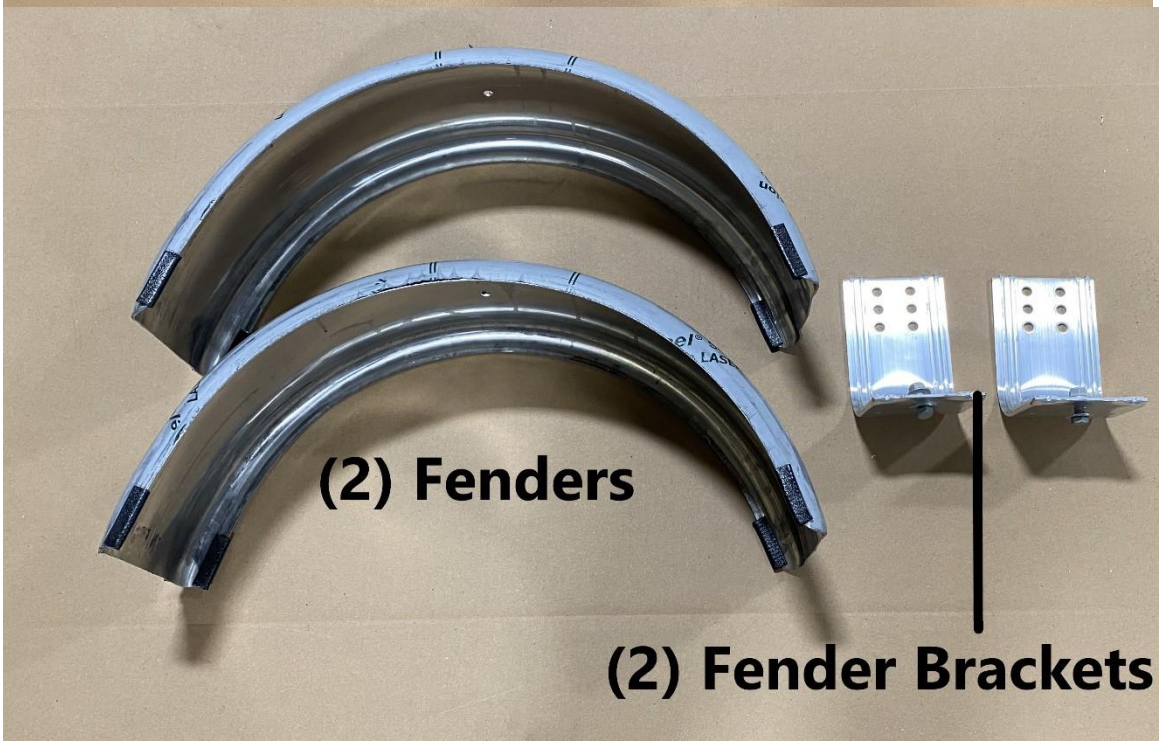

(4) Top and Bottom Elbow Plates

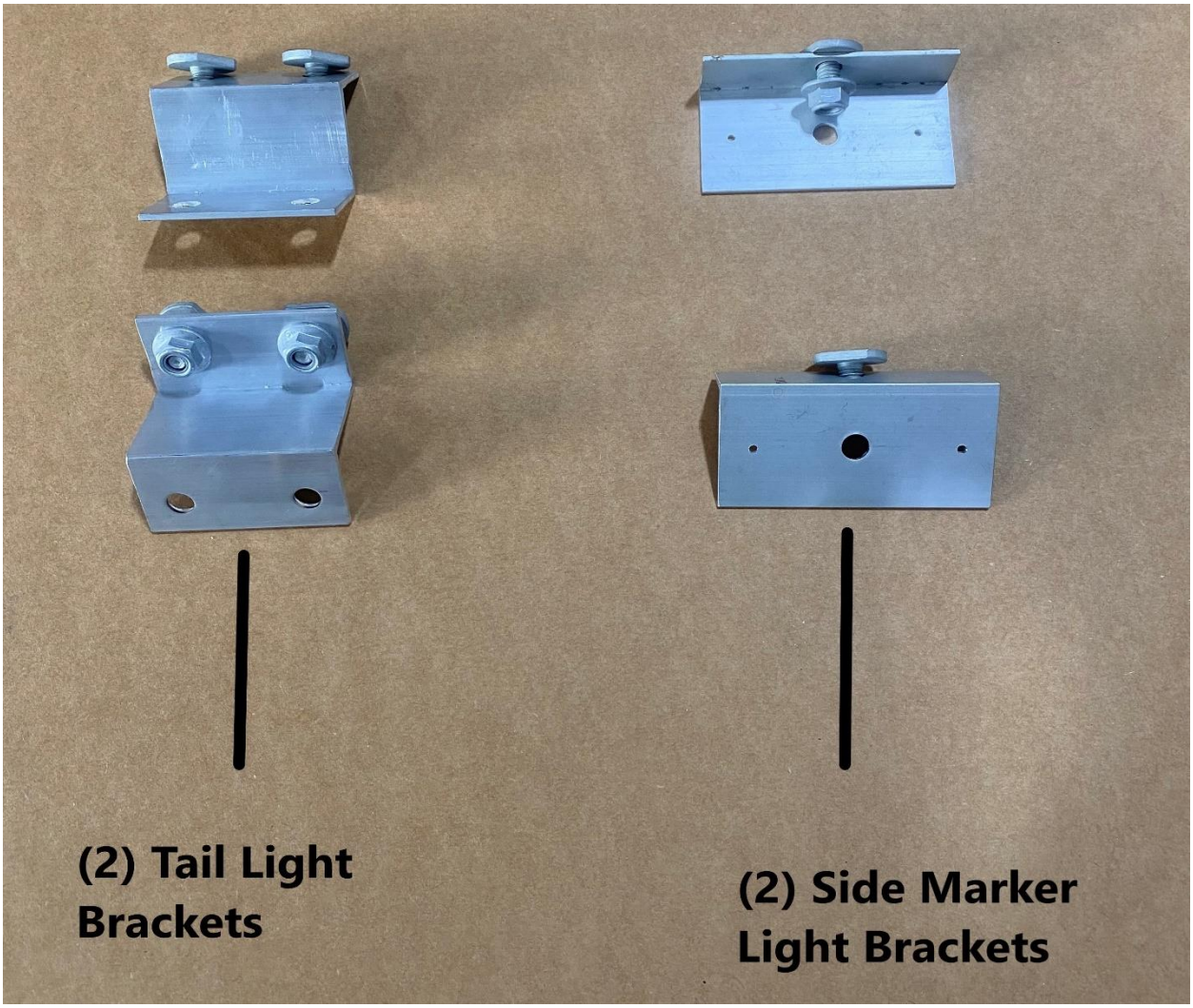

(2) Side Elbow Plates

Hardware Bag

Coupler


(2) 12" Tires


(2) Fenders
(2) Fender Brackets

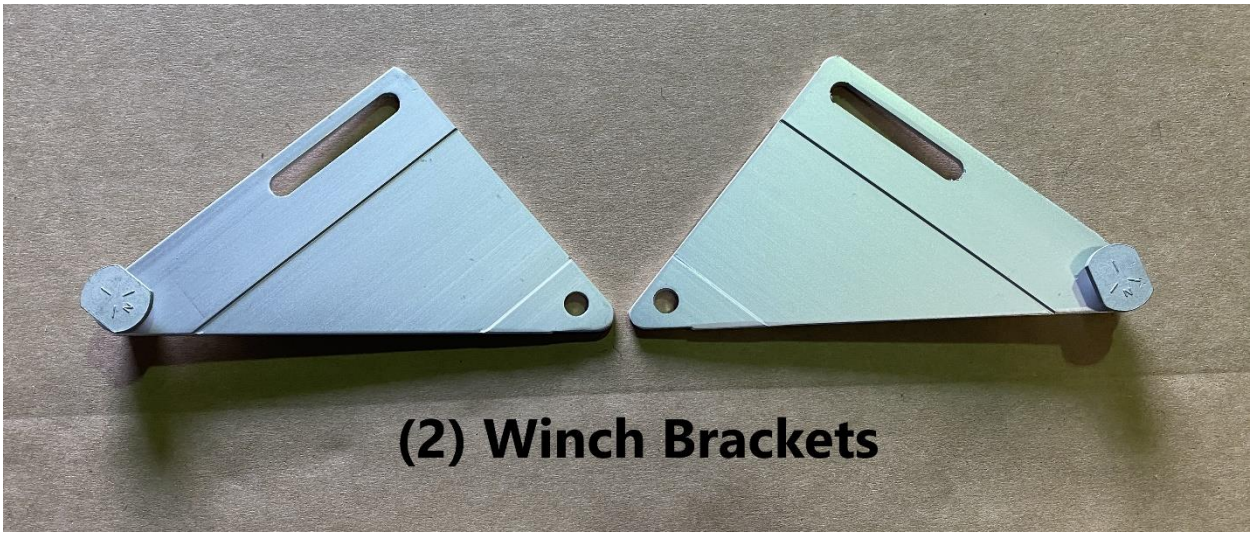

(2) Tail Light Brackets
(2) Side Marker Light Brackets


Skid Bracket


LED Light Kit


(4) Web
Strap Clips

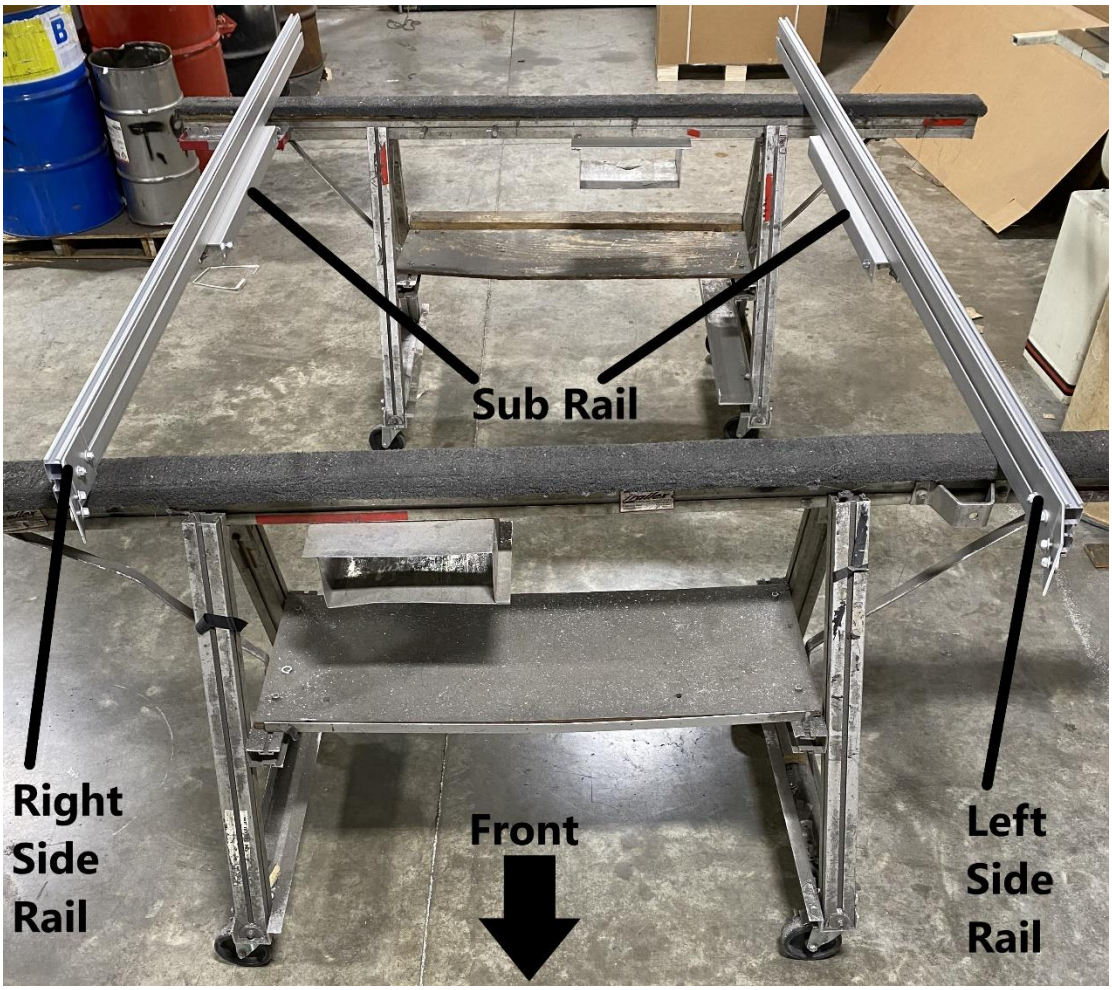

Winch Stand


(2) Winch Brackets

Frame Assembly

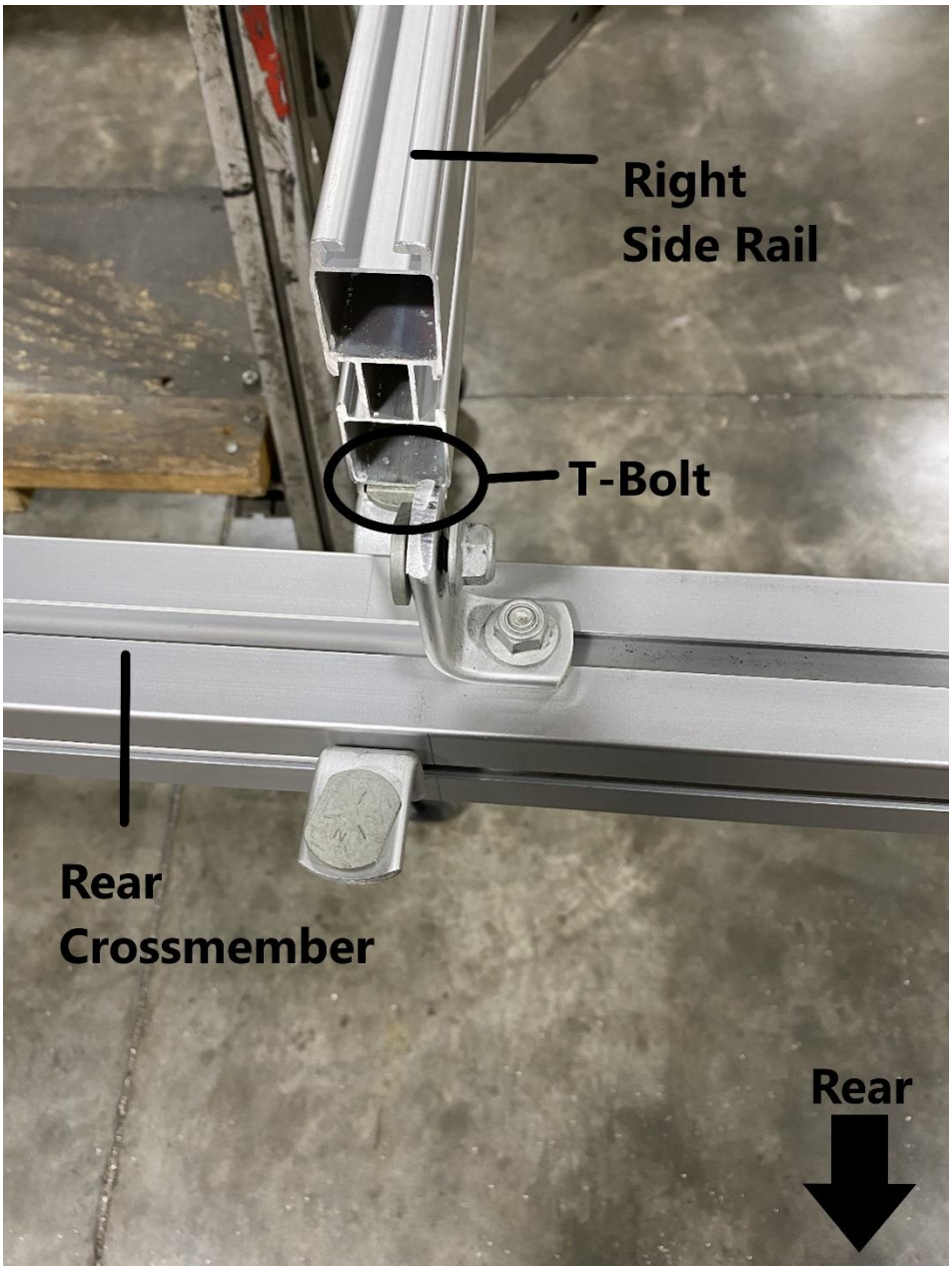
Locate the left side rail. The left side rail will have a vehicle identification sticker.

Locate the right side rail.

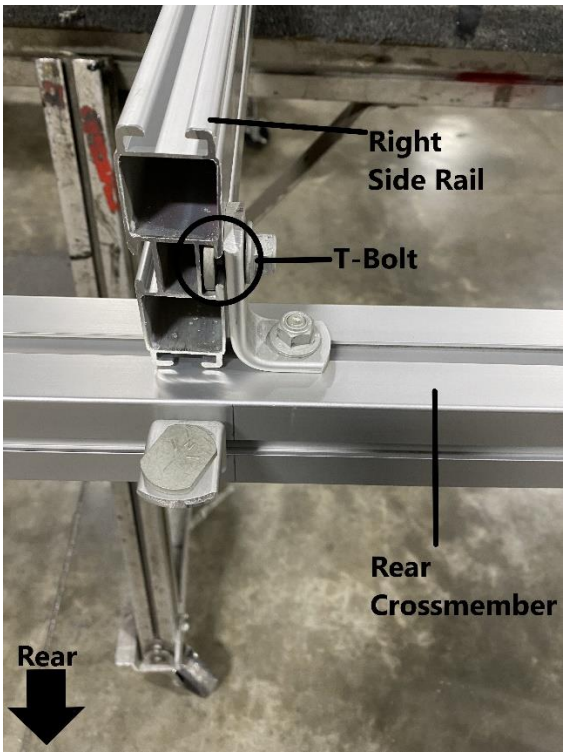


Place the left and right side rails on (2) saw horses as shown. Note that the vehicle identification sticker on the left side rail will be facing towards the outside of the trailer. Also note that the sub-rails offset towards the inside of the trailer.

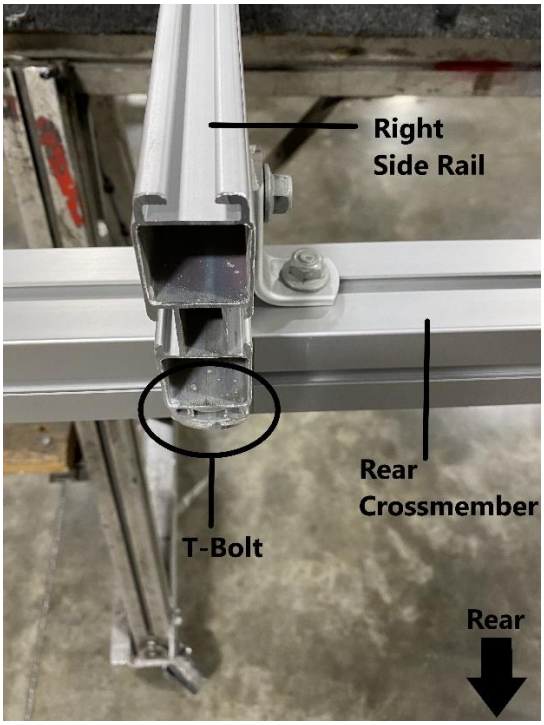
Locate the rear crossmember. Note the (2) circled angles. These will be used to connect the rear crossmember to the left and right side rails.



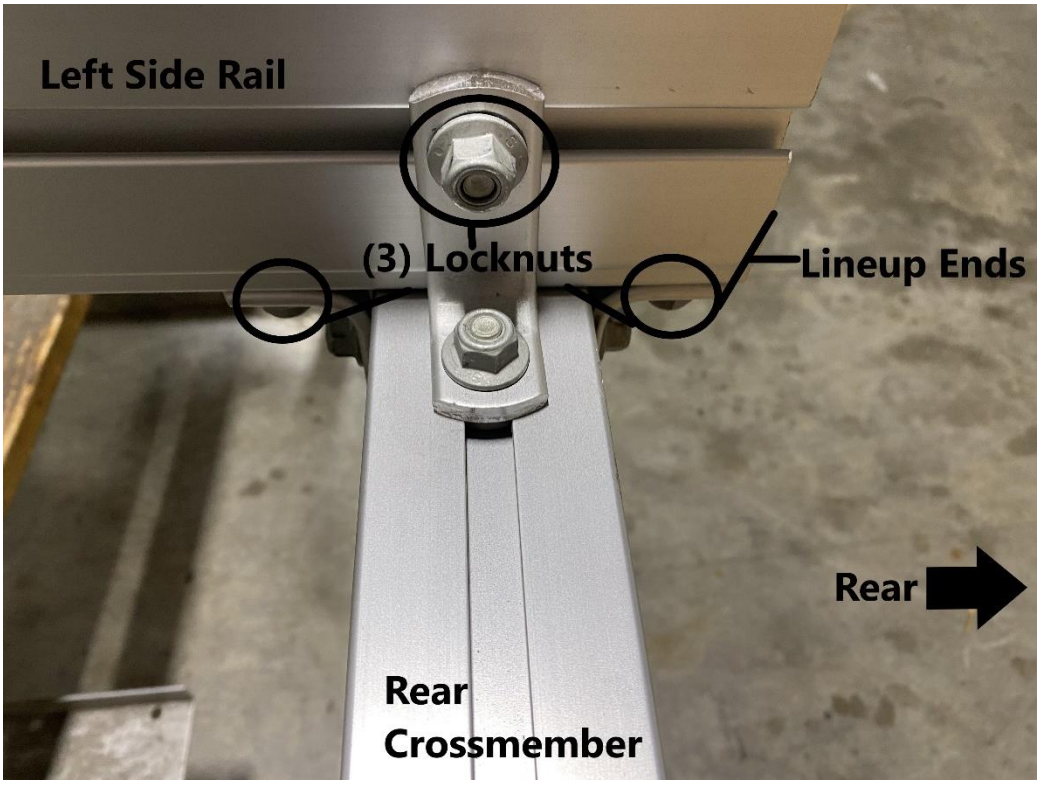
(3) T-bolts will be used to connect the right side rail to the rear crossmember. Slide the first T-bolt installed on the rear crossmember into the bottom groove of the right side rail as shown. Repeat this process for the left side rail.



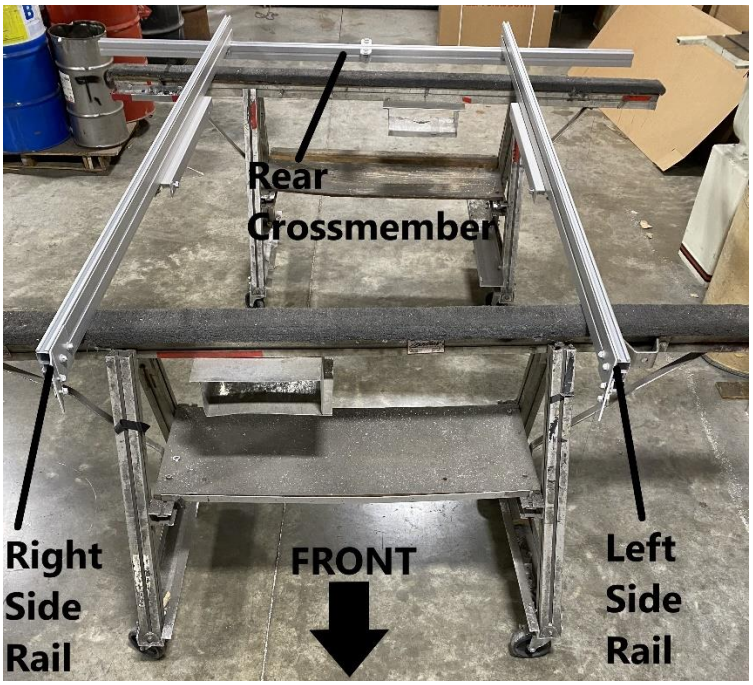
Continue sliding the rear crossmember until the second T-bolt installed on the rear crossmember slides into the side groove of the right side rail. Repeat this process for the left side rail.



Continue sliding the rear crossmember until the third T-bolt installed on the rear crossmember slides into the bottom groove of the right side rail. Repeat this process for the left side rail.

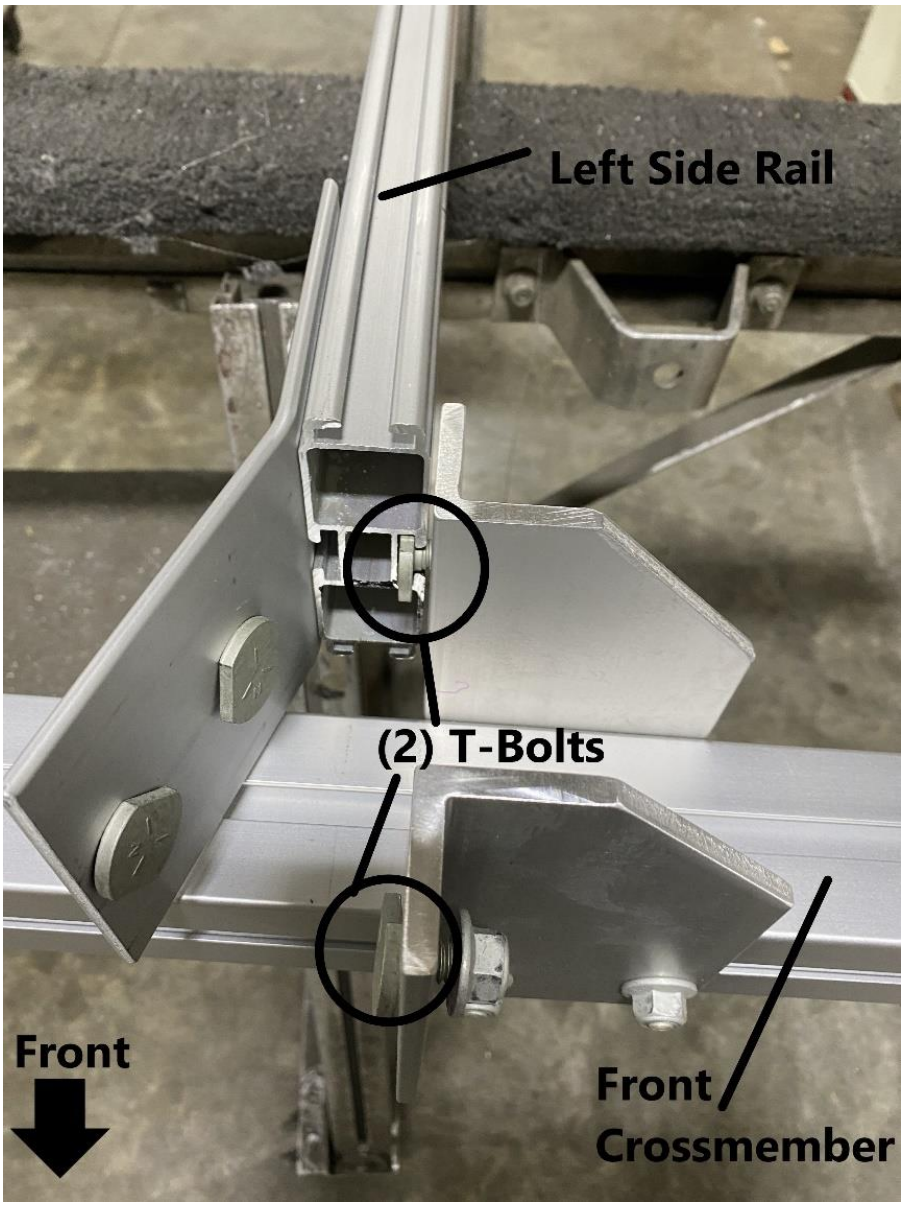


Lineup the end of the left side rail with the end of the rear crossmember as shown. With the trailer lined up, the (3) locknuts will now need to be tightened. Tighten the (3) locknuts shown using a 9/16" wrench. Repeat this process for the other side.



At this point the trailer looks like this.

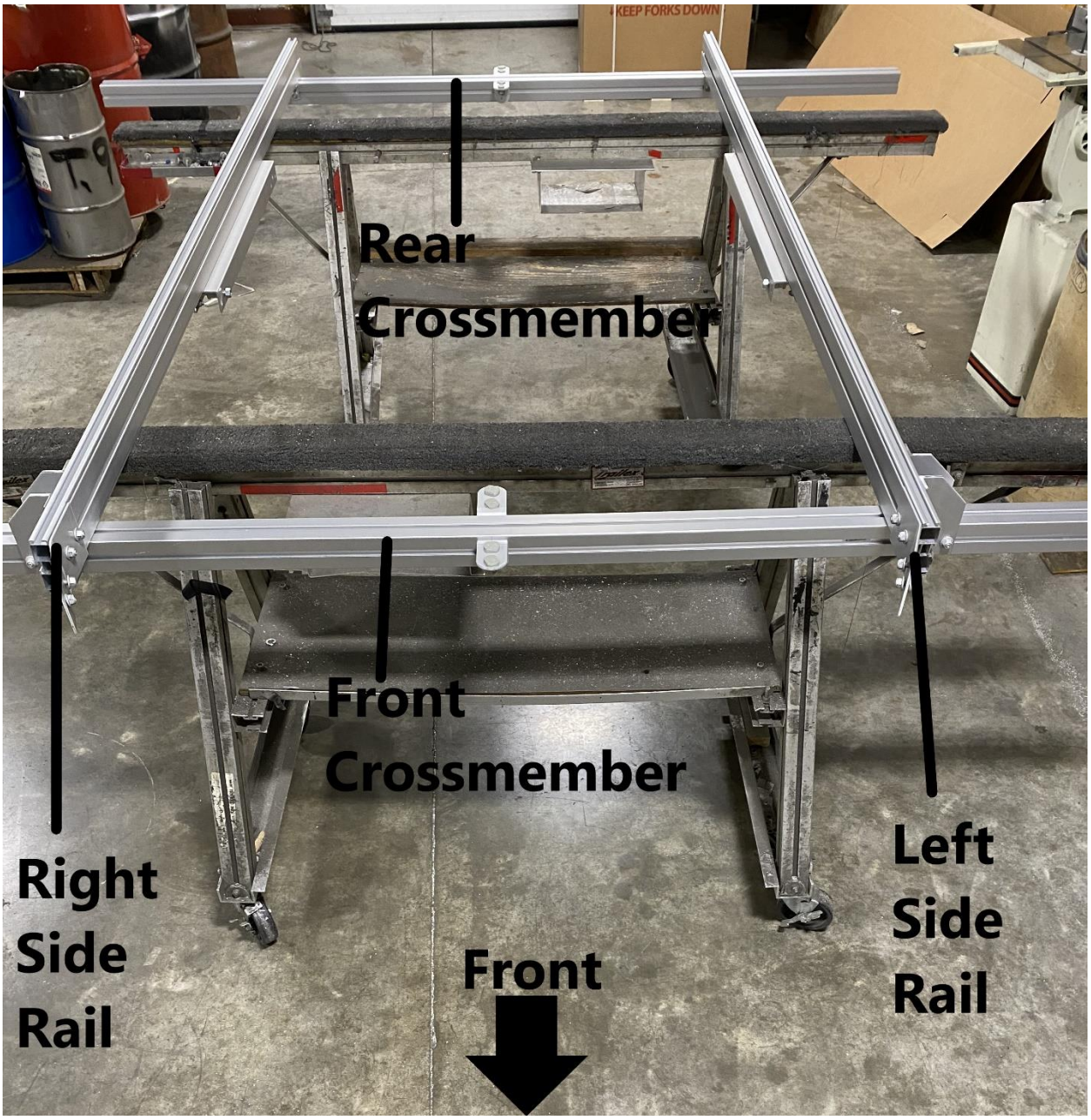
Locate the front crossmember. Note the (4) circled angles. These will be used to connect the front crossmember to the left and right side rails.



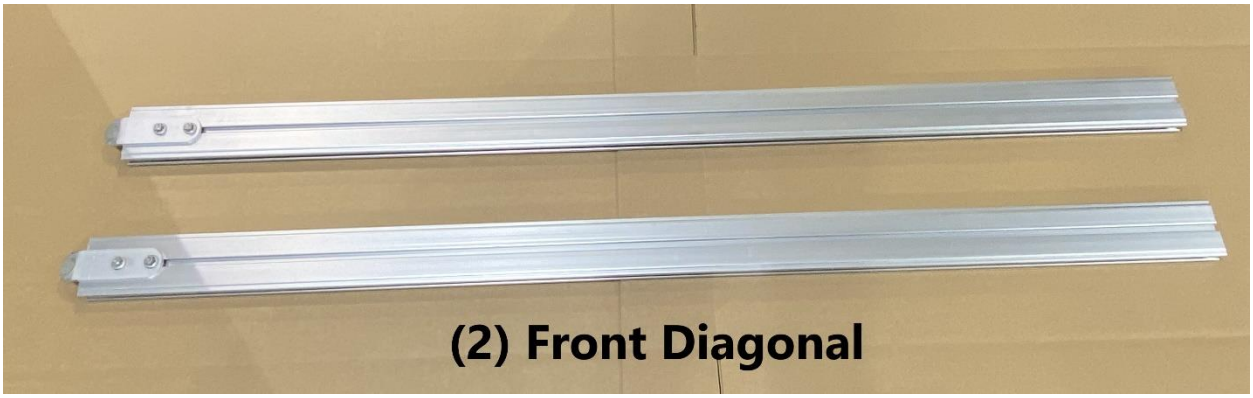
(2) T-bolts will be used to connect the left side rail to the front crossmember. Slide (2) T-bolts installed on the front crossmember into the side groove of the left side rail as shown. Repeat this process for the right side rail.

Note the (4) markings shown on the left side rail. Continue sliding the front crossmember until the front crossmember lines up with the (4) markings. Repeat this process for the other side.

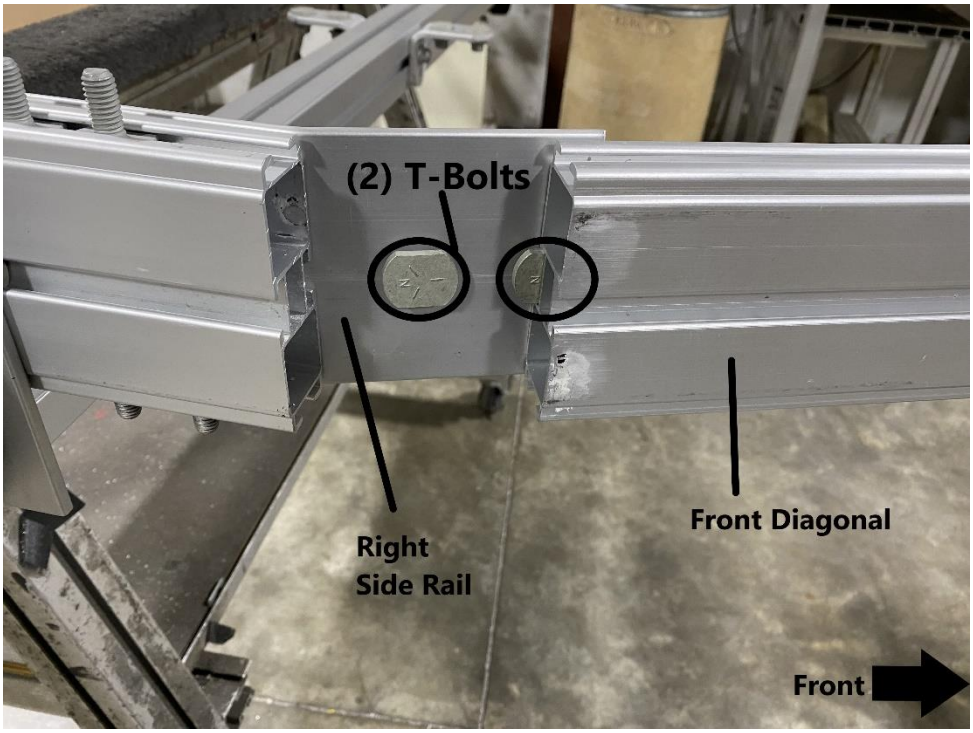
With the trailer lined up, the (2) locknuts will now need to be tightened. Tighten the (2) locknuts shown using a 9/16" wrench. Repeat this process for the other side.



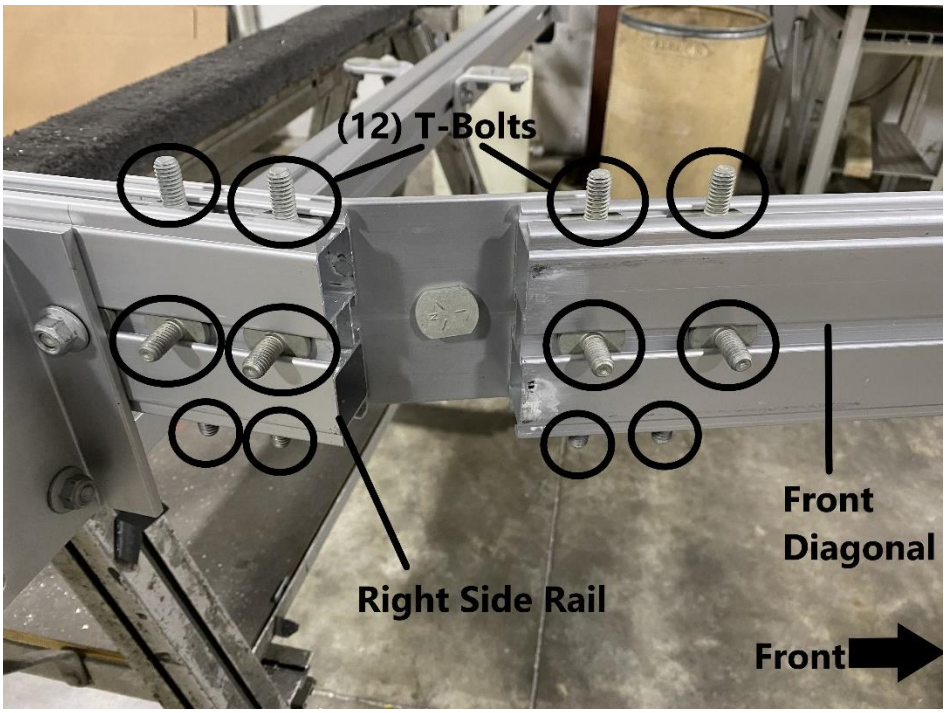
At this point the trailer looks like this.



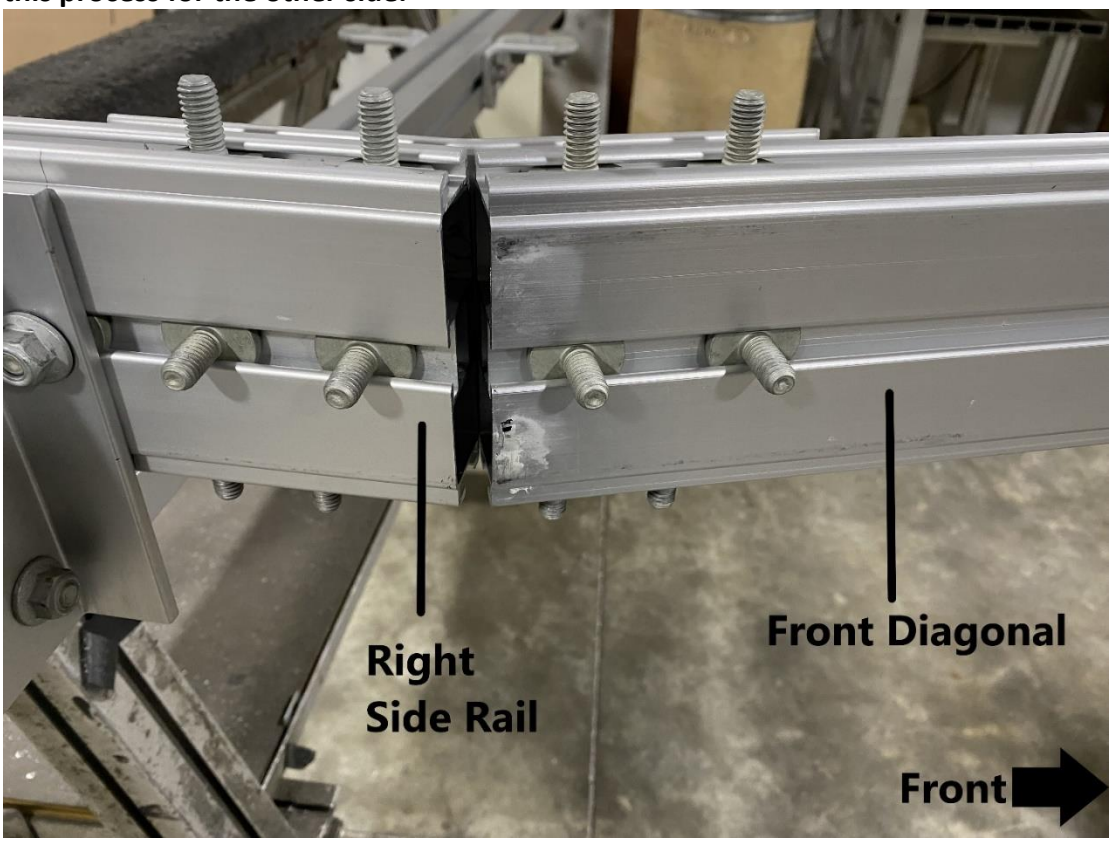
Locate the (2) front diagonals.



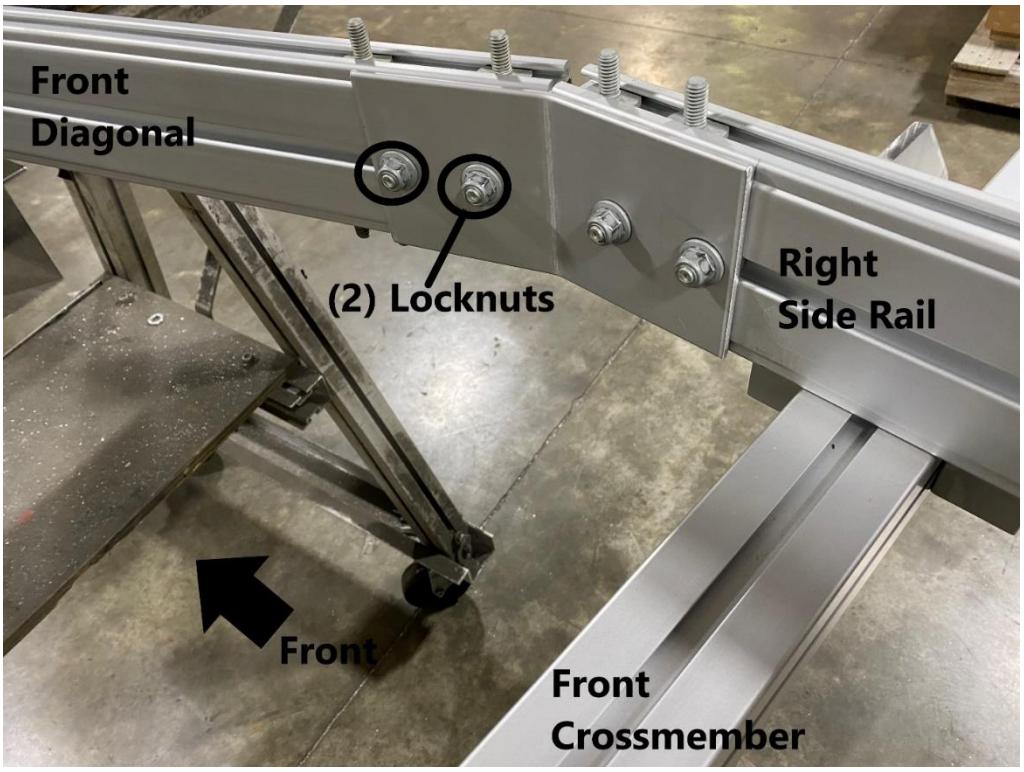
A third saw horse will be necessary to install the front diagonals. Install a front diagonal to the right side rail as shown, using the (2) T-bolts installed on the right side rail. Note that some space will be needed between the front diagonal and right side rail for the next step. Repeat this process for the other side.



Install (12) T-bolts as shown into the grooves of the right side rail and front diagonal. Repeat this process for the other side.

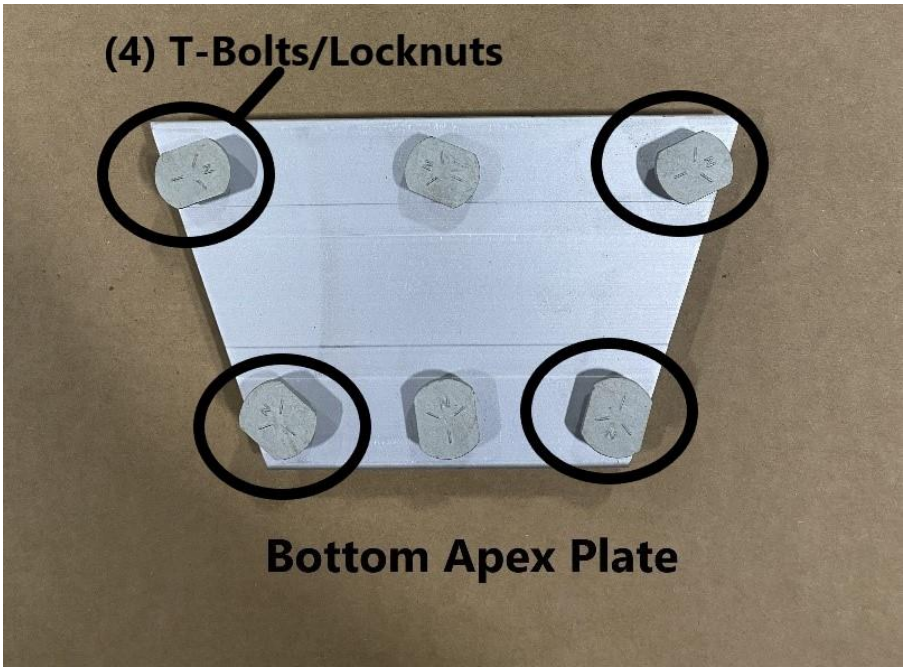


Finish sliding the front diagonal towards the right side rail. Repeat this process for the other side.

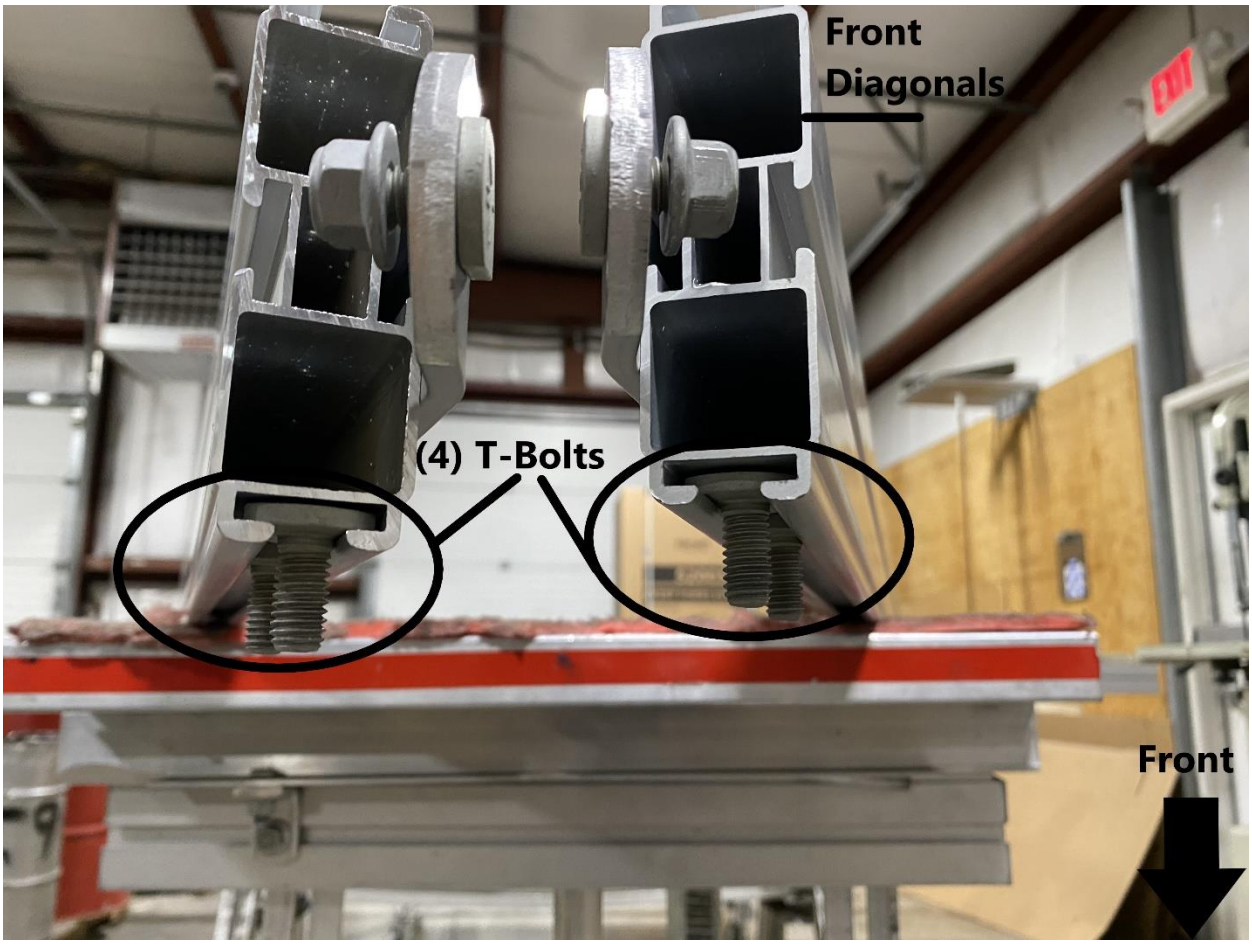


Tighten the two locknuts shown. Repeat this process for the other side.

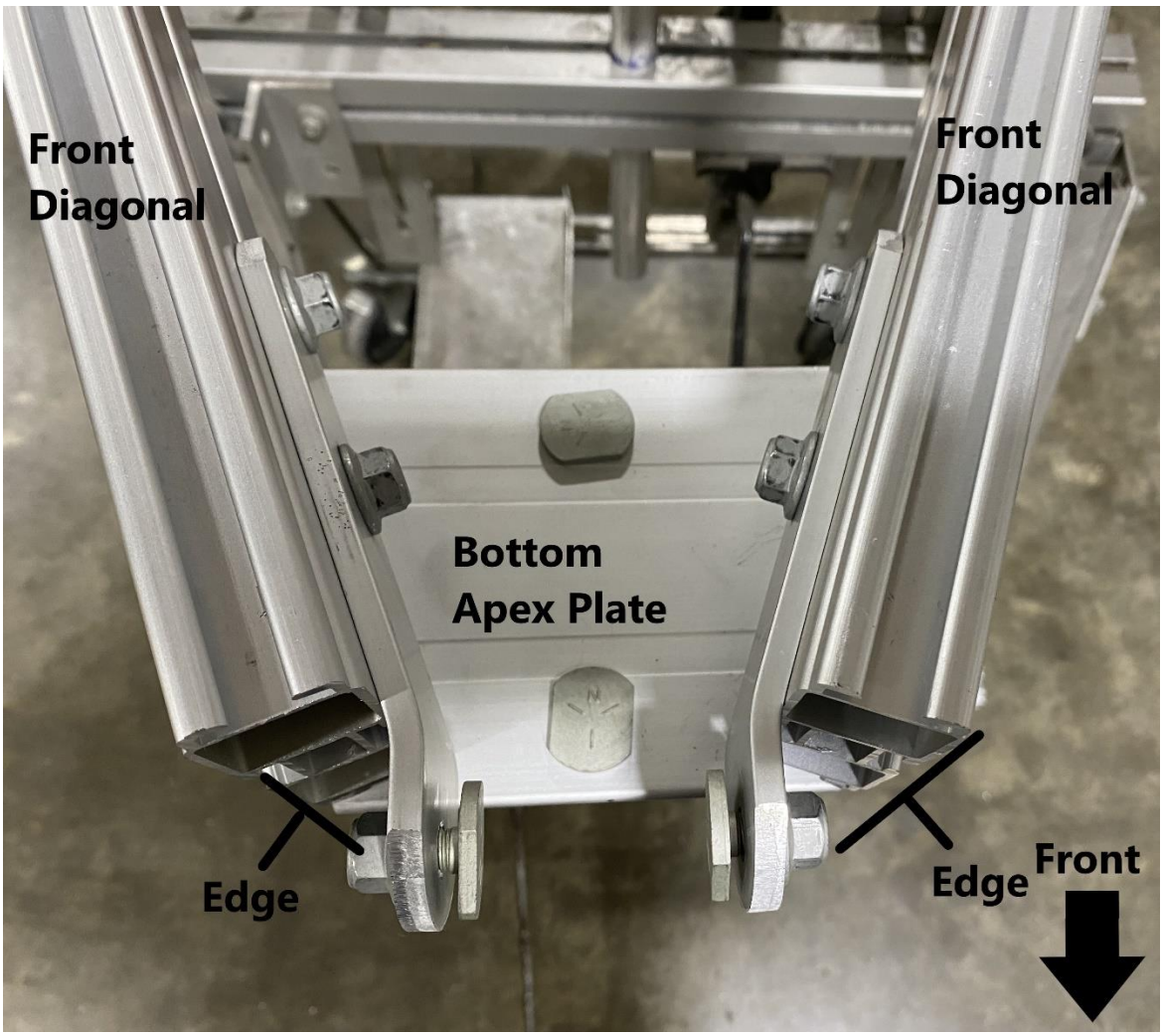
At this point the trailer looks like this.



Locate the bottom apex plate. Remove the (4) T-Bolts and (4) locknuts shown.

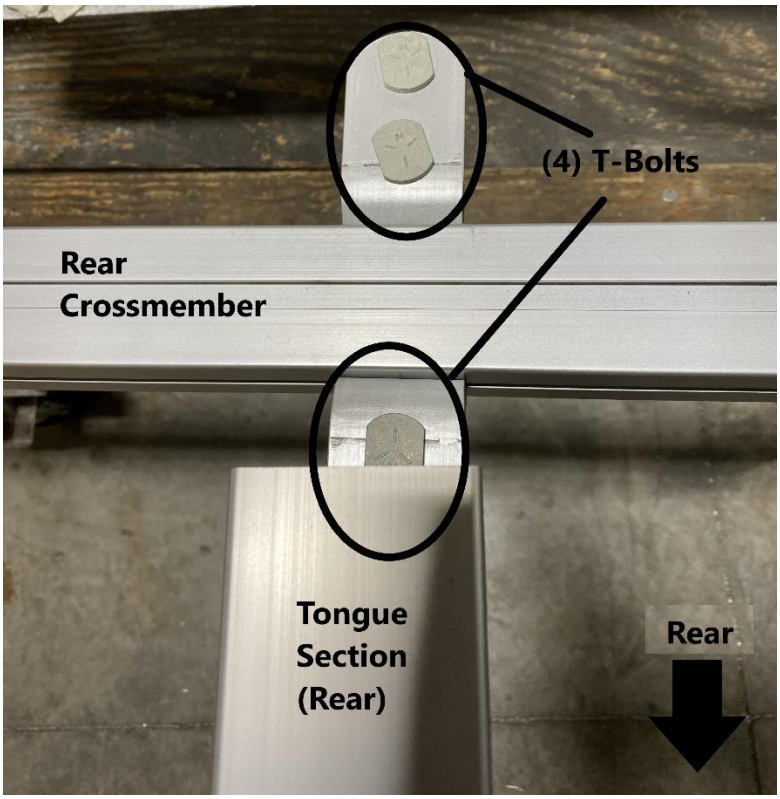


Install (4) T-bolts into the bottom grooves of the (2) front diagonals as shown.

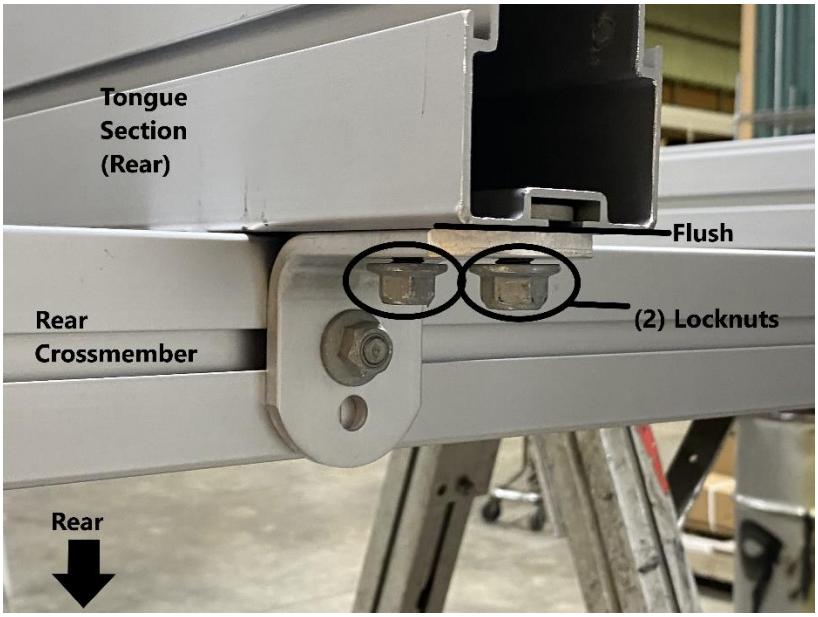


Install the bottom apex plate as shown. Position the bottom apex plate so the edges of the bottom apex plate are flush with the edges of the front diagonals. Install locknuts and tighten using a 9/16” wrench.

Locate the rear tongue section.

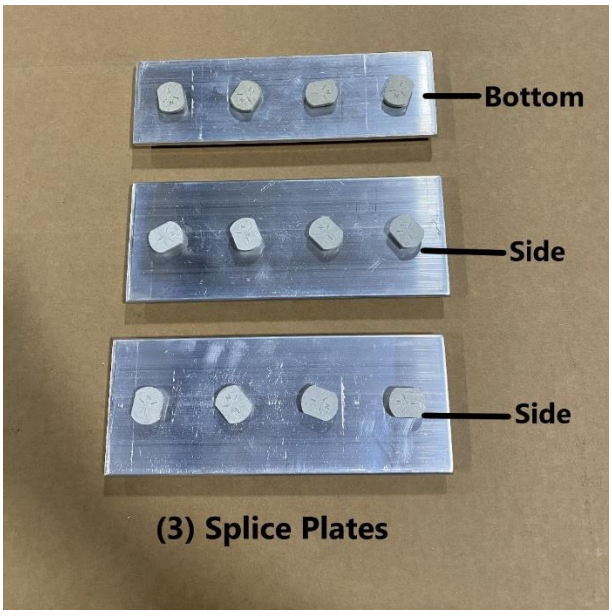


Move to the rear of the trailer. Locate the (4) T-bolts installed in the center of the rear crossmember. Slide the (4) T-bolts of the rear crossmember into the bottom groove of the rear tongue section.

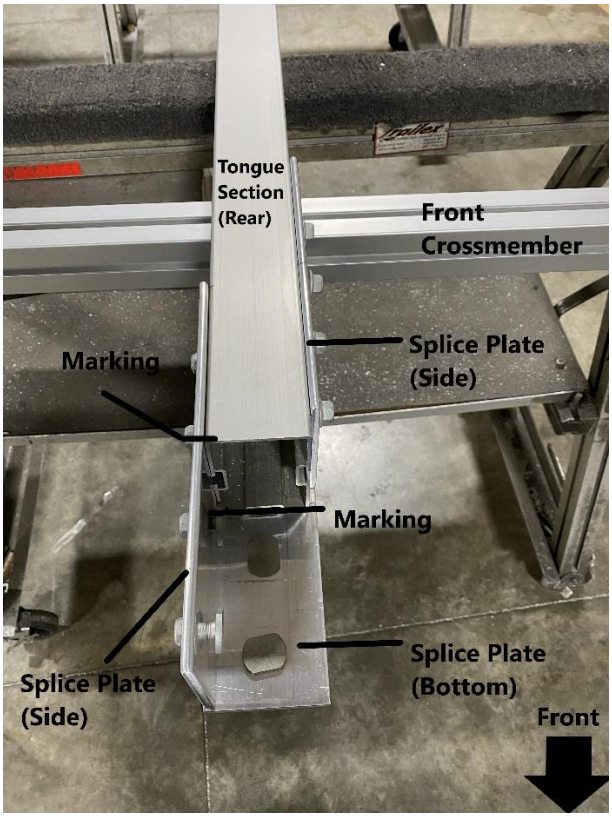


Continue sliding the rear tongue section through the (2) T-bolts installed in the front crossmember. Slide the rear tongue section until it is flush with the rear crossmember as shown. Tighten the (2) locknuts on the rear crossmember using a 9/16" wrench. Also tighten the (2) locknuts on the front crossmember using a 9/16" wrench.

At this point the trailer looks like this.

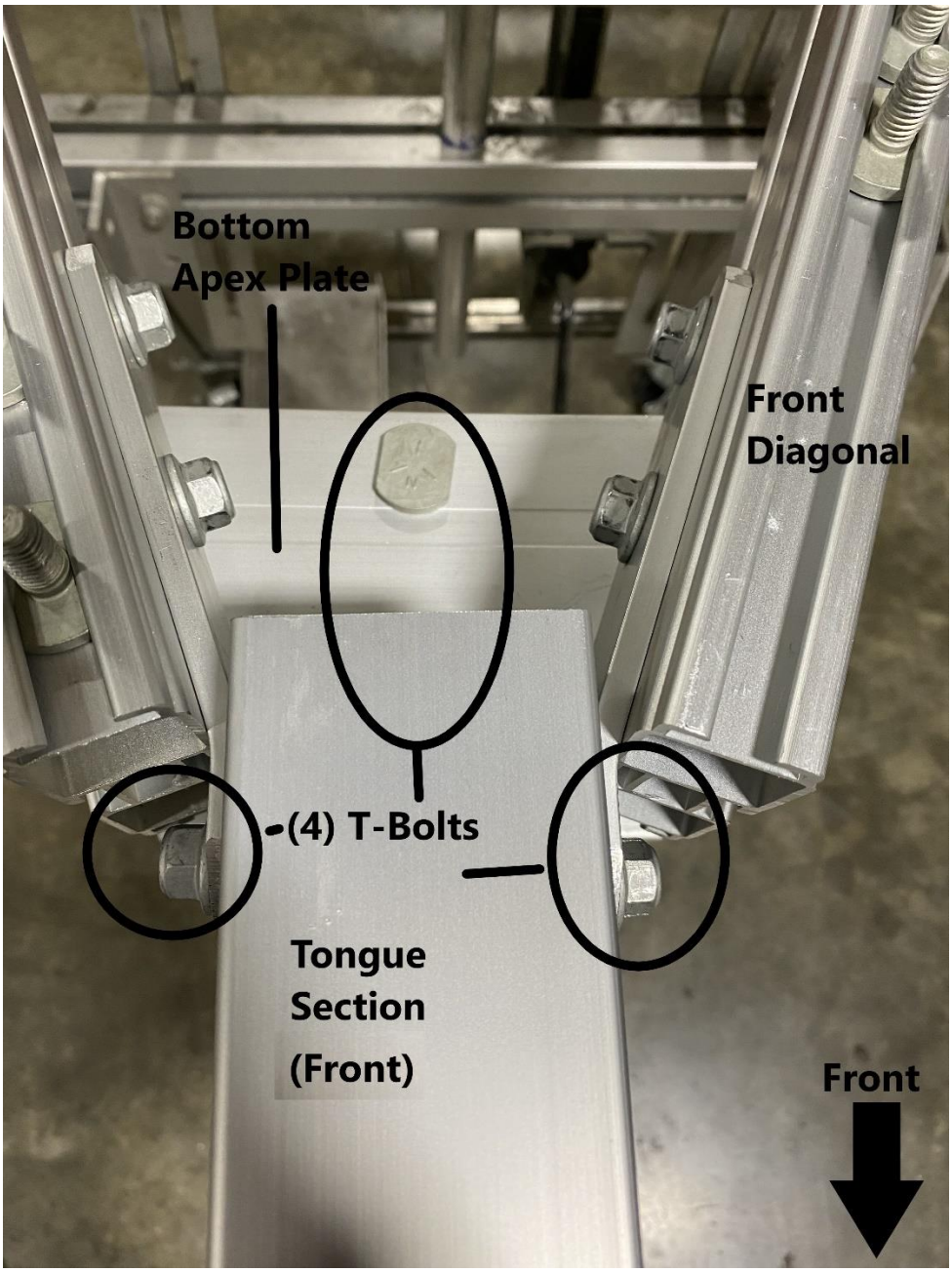


Locate the (3) splice plates. Note the smaller splice plate will be installed on the bottom and the other two will be installed on the side.

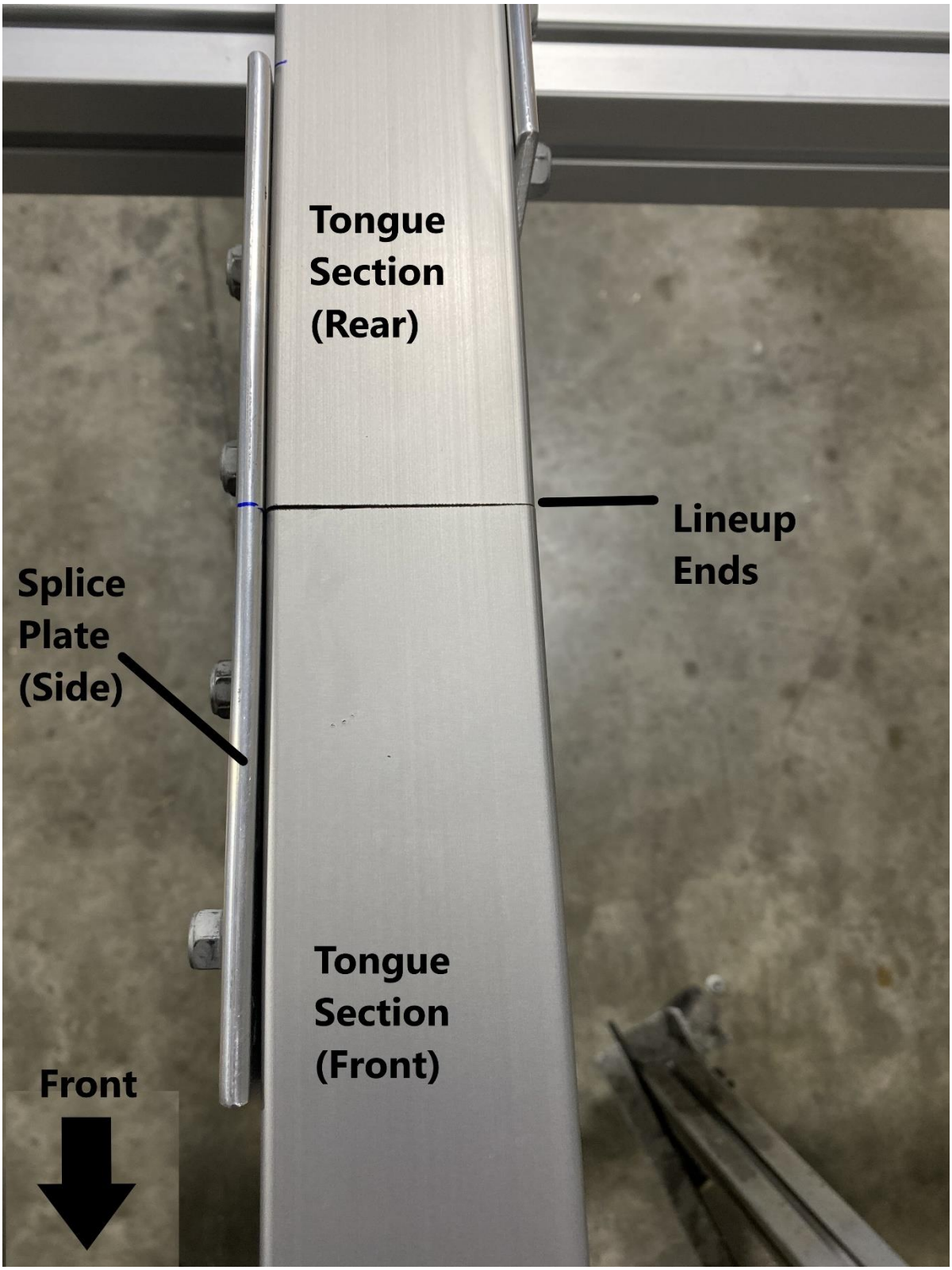


Move to where the rear tongue section connects to the front crossmember. Install the (3) splice plates to the rear tongue section as shown. Note the (2) markings on the splice plates. These will show how far to slide the splice plates into the rear tongue section. Also note that the one side splice plate is fully installed in the side groove of the rear tongue section. This will be moved forward later.

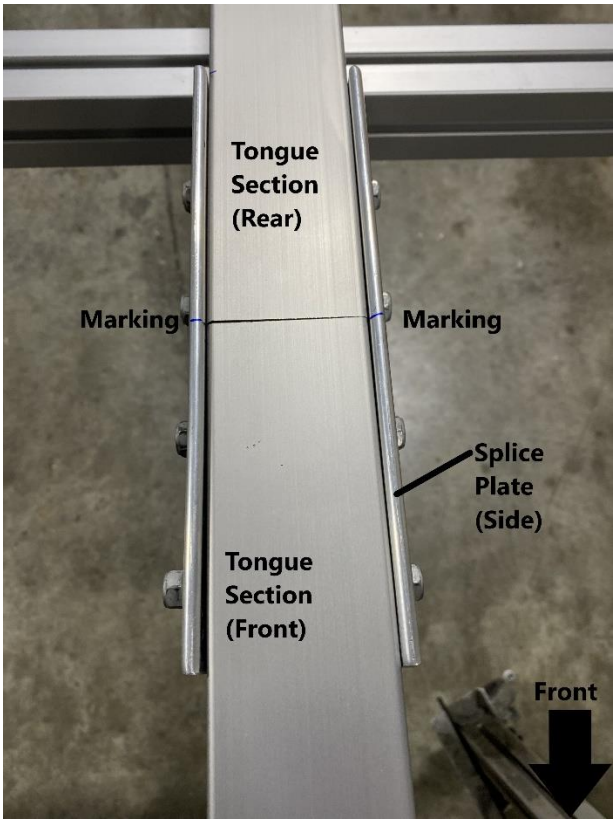
Locate the front tongue section. Note the bottom groove.



Slide the front tongue section through the (2) T-bolts installed on the bottom apex plate and the (2) T-bolts installed on the (2) front diagonals. Note that the (2) safety cables will be on the other end of the tongue section, facing down.



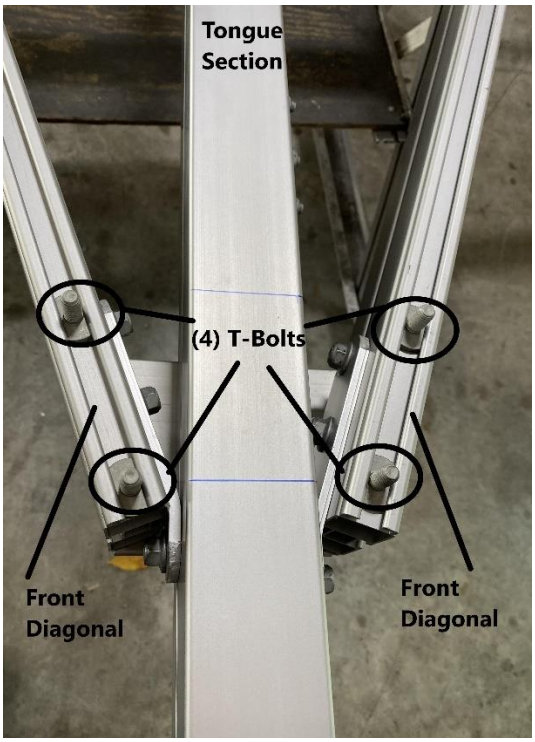
Continue sliding the front tongue section through the bottom and side splice plates installed in the rear tongue section. Lineup the ends of the front and rear tongue sections as shown.



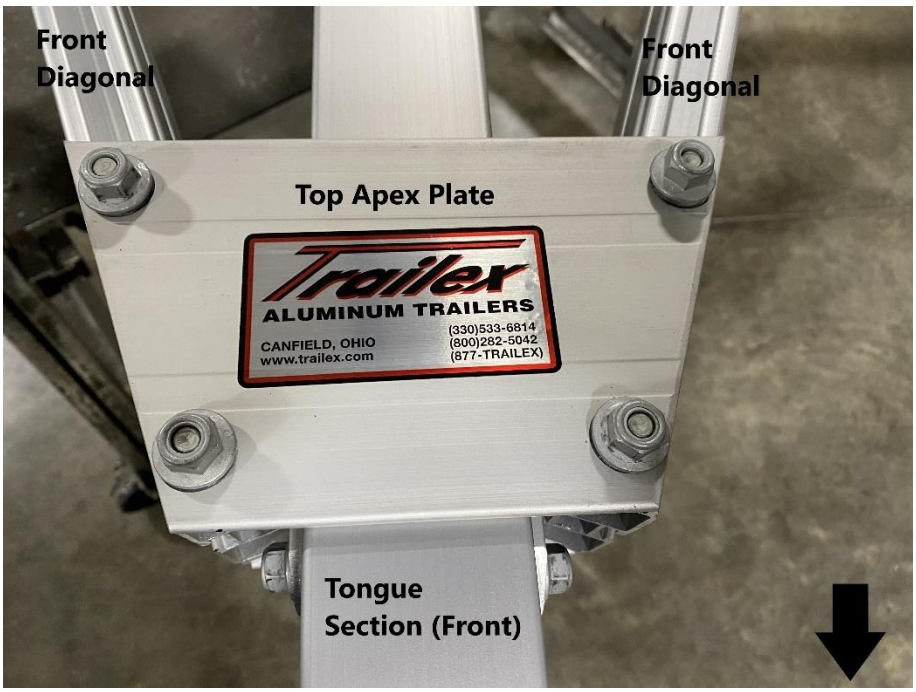
With the tongue sections lined up, the side splice plate can be moved forward. Lineup the two markings of side splice plates as shown.

Tighten the (12) locknuts using a 9/16” wrench.

Locate the top apex plate. Remove the (4) T-bolts and (4) locknuts installed.

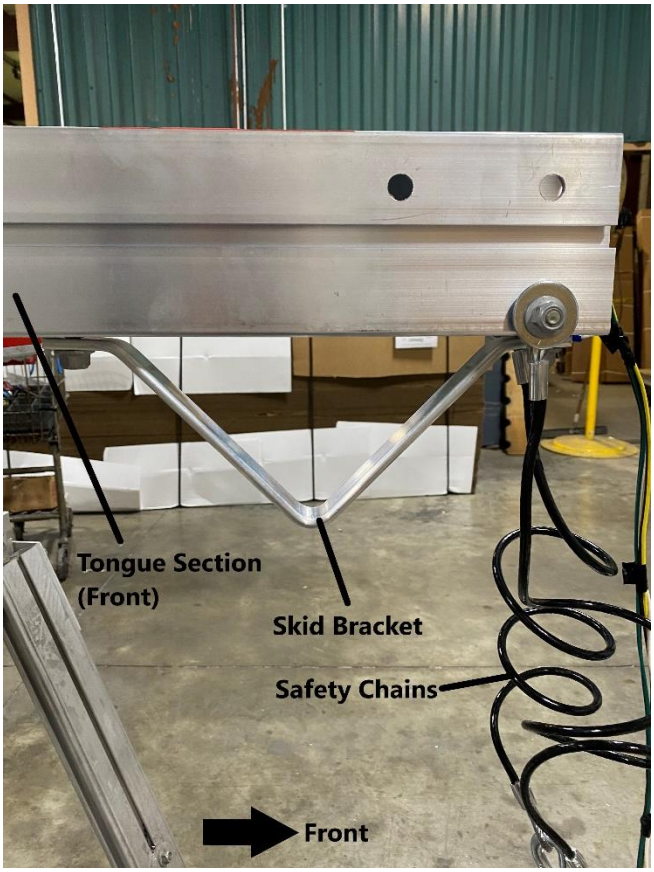


Install the (4) T-bolts removed from the top apex plate into the top grooves of the (2) front diagonals as shown.

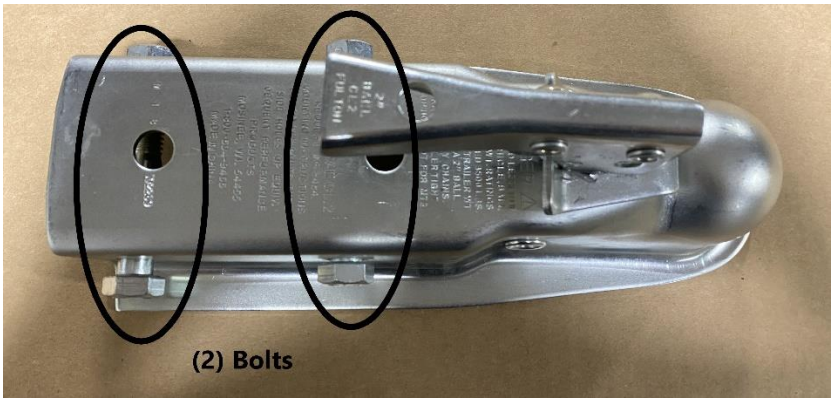


Install the top apex to the (4) T-Bolts installed in the front diagonals. Replace (4) locknuts and tighten using a 9/16" wrench.

Locate the skid bracket.

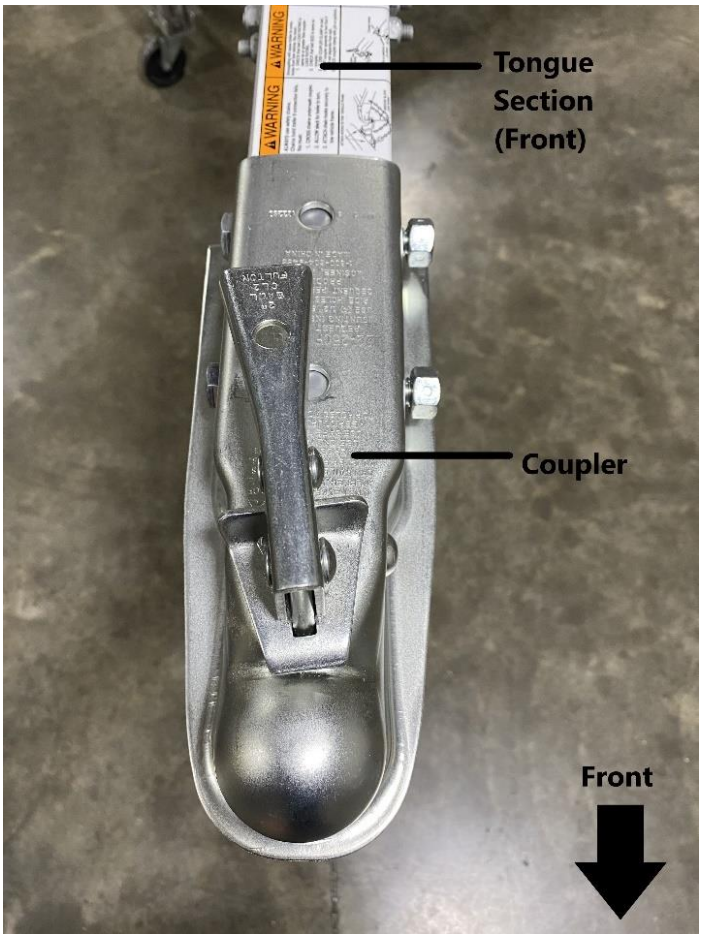


Slide skid bracket into the bottom channel of the tongue section. Position bracket as shown and tighten nuts.



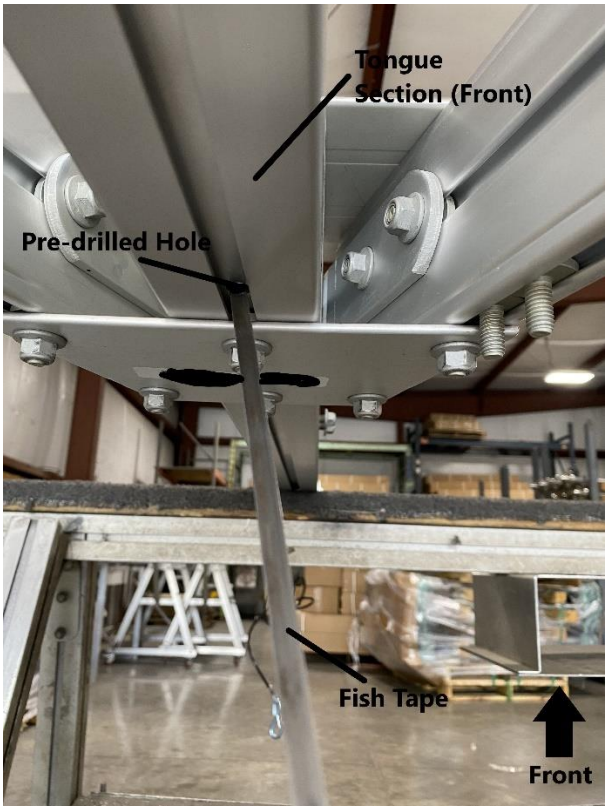
Locate the coupler. Remove the (2) bolts using a ¾" ratchet and wrench.

Locate the (2) coupler holes shown.



Install the coupler to the front tongue section as shown. Lineup the holes of the coupler with the holes of the front tongue section. Replace the (2) bolts and tighten using a ¾" ratchet and wrench.

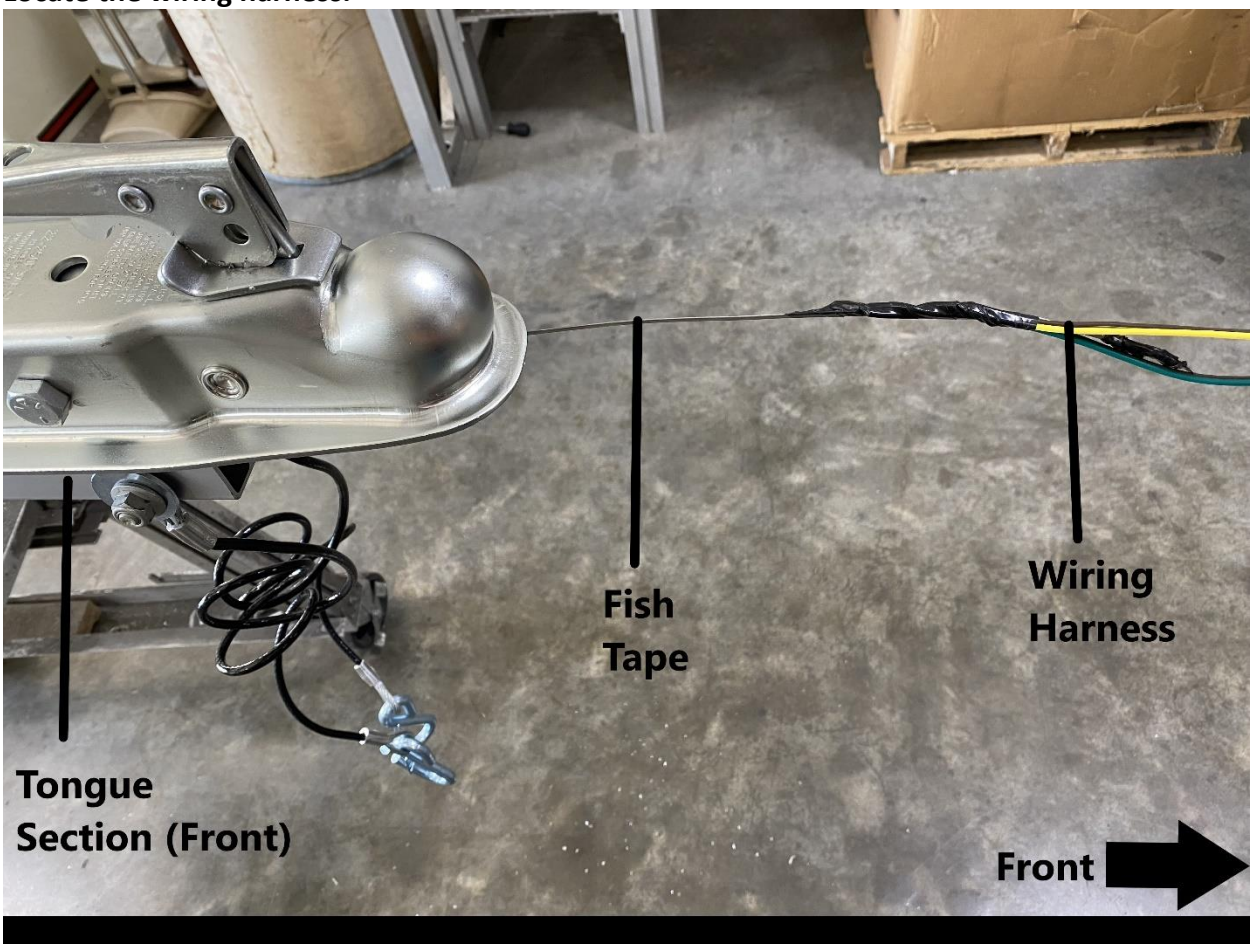
Wiring Instructions



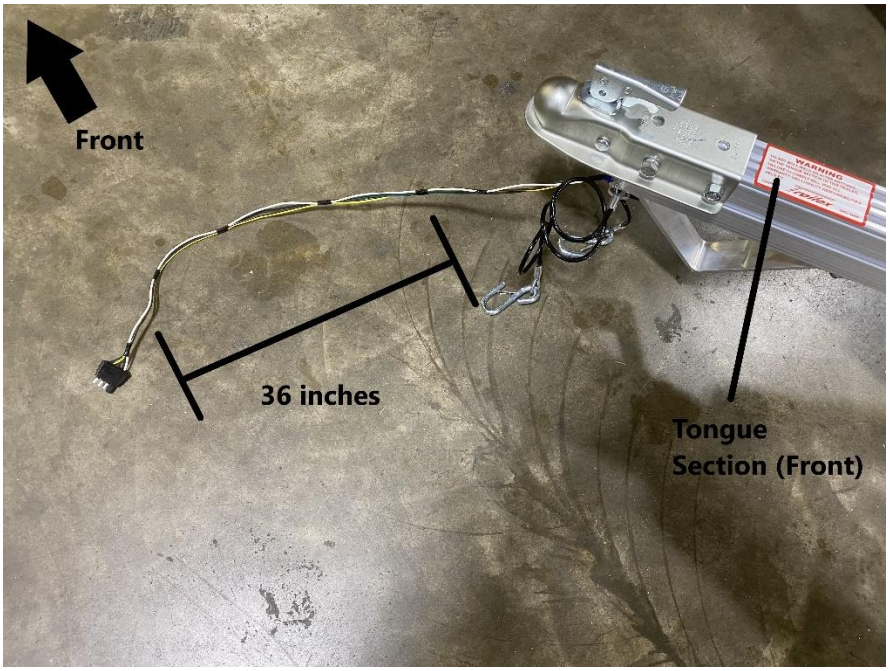
Locate the pre-drilled hole on the bottom of the front tongue section. Run fish tape through the pre-drilled hole towards the front of the tongue section.

Continue running the fish tape until it is through the front tongue section.

Locate the wiring harness.

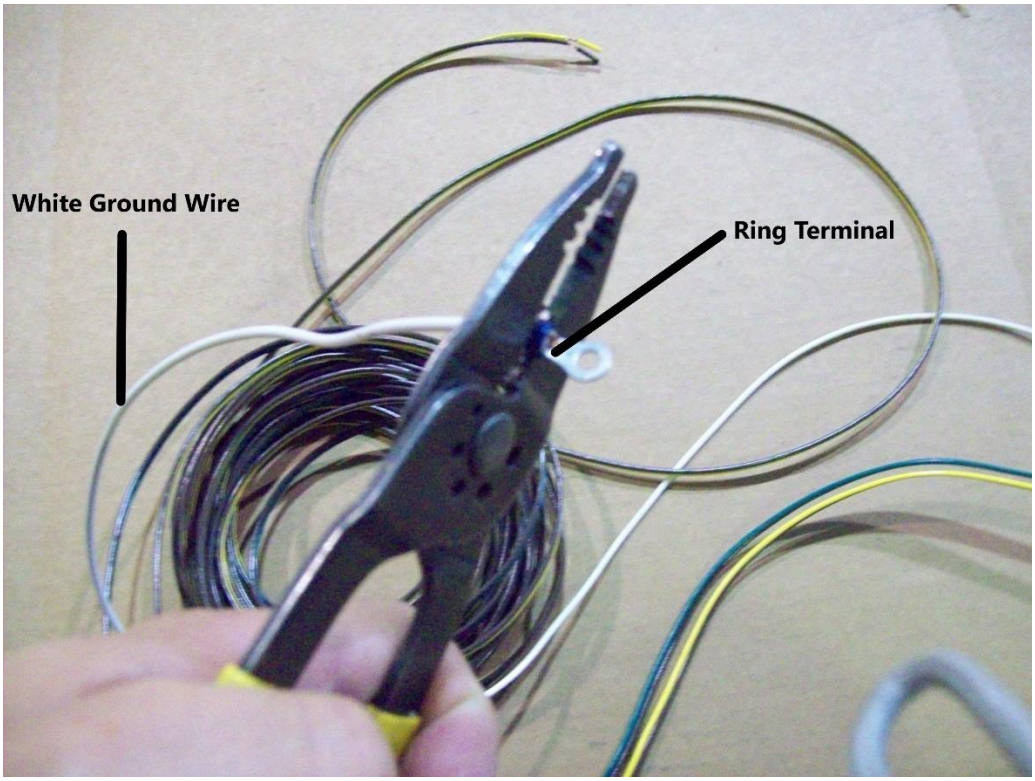


Use electrical tape to attach 4 harness wires (2 brown, 1 green, 1 yellow) to the fish tape. *Do not tape the white ground wire.* The white ground wire will stay at the front of the tongue section.



Pull the wiring harness through the tongue section and out through the pre-drilled hole underneath the tongue section. Leave 36 inches of wiring at the front of the tongue section. This will be used to connect the trailer to the tow vehicle.

Locate a ring terminal found in the LED Light Kit.

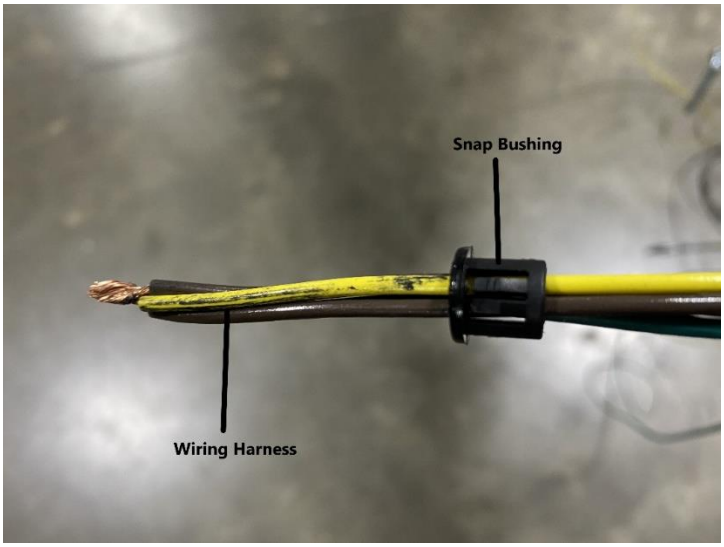


Install the ring terminal to the white ground wire as shown. Strip the end of the white ground wire, place the ring terminal on the end of the white ground wire and crimp the two together.

Locate the ¾" long Phillips screw that is found in the LED Light Kit.

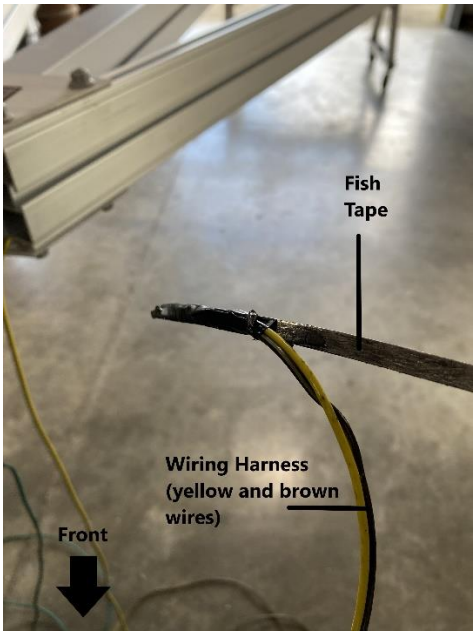
Using a Phillips screwdriver, install the Phillips screw through the ring terminal on the white ground wire into the pre-drilled hole. The pre-drilled hole is located on the driver's side of the front tongue section.

Locate the snap bushing found in the LED Light Kit.

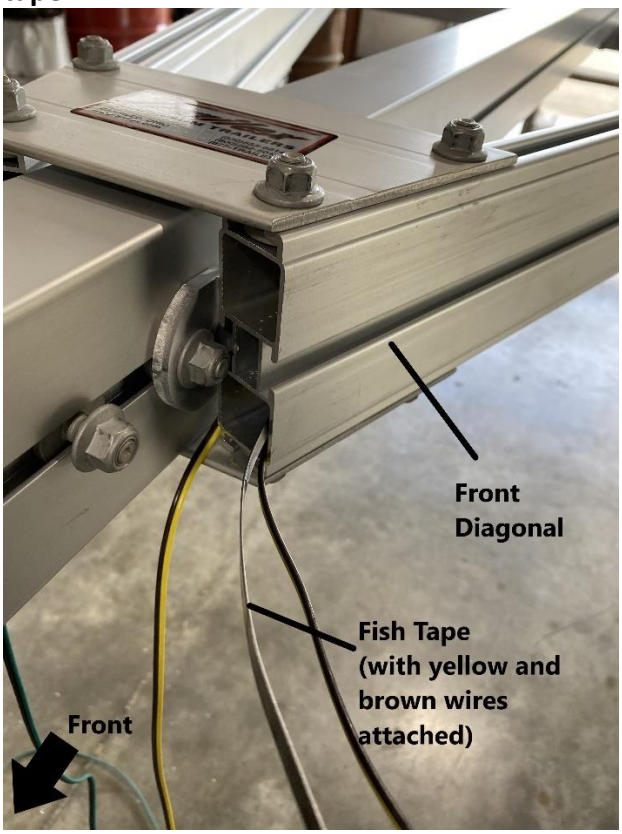


Install the snap bushing on the wiring harness. This will be the end of the wiring harness that was pulled through the tongue section and out through the pre-drilled hole.

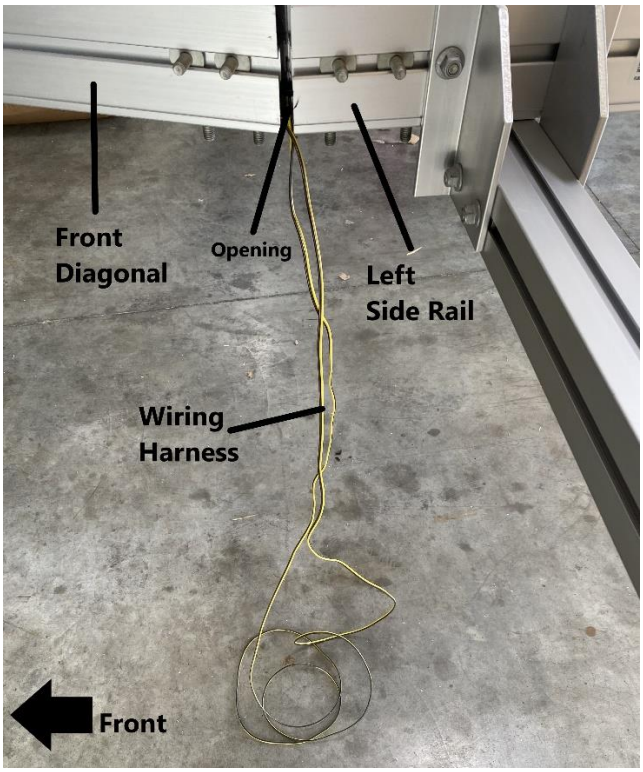
Install the snap bushing into the pre-drilled hole as shown. Run the snap bushing up the wiring harness and press the snap bushing into the pre-drilled hole. Use a standard screwdriver to press the snap bushing into place.



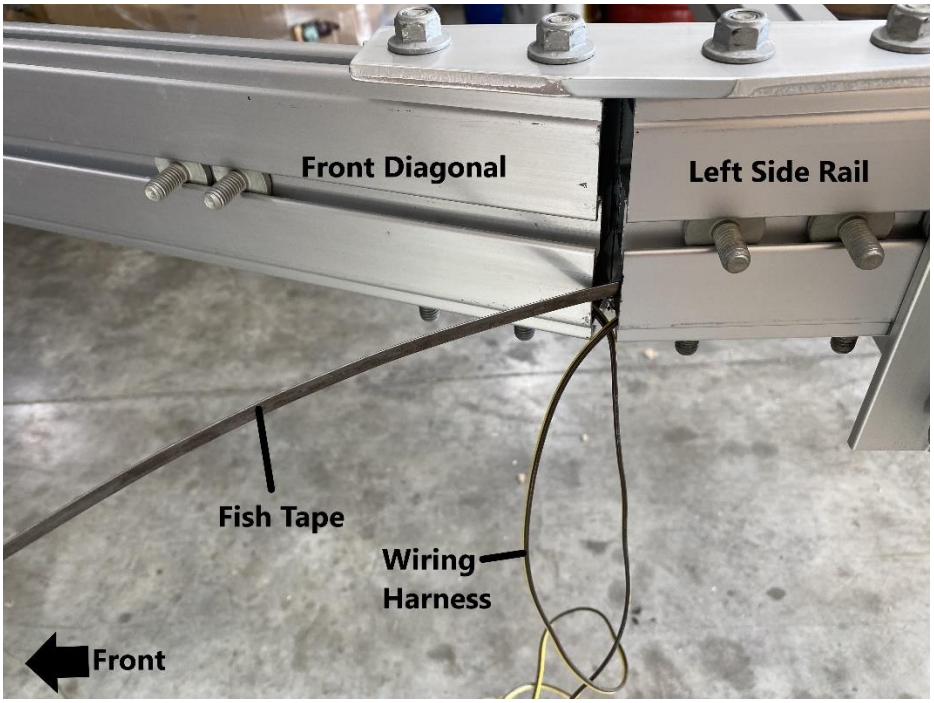
The wiring harness will now need to be ran to the rear of the trailer. Separate the wires so the green and brown will run down the passenger side while the yellow and brown wires will run down the driver's side. Attach the yellow and brown wires to the fish tape with electrical tape.



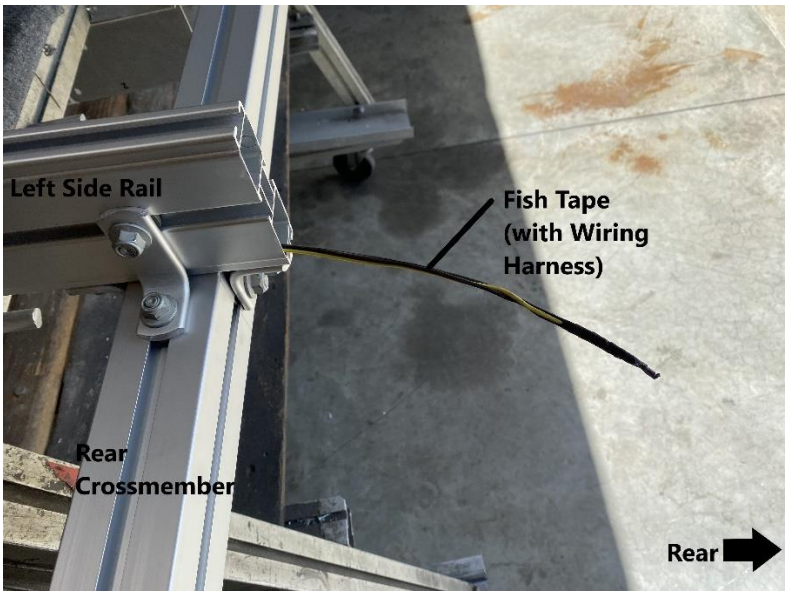
Locate the opening where the front diagonal is connected to the tongue section. Extend the fish tape through the front diagonal towards the rear of the trailer.



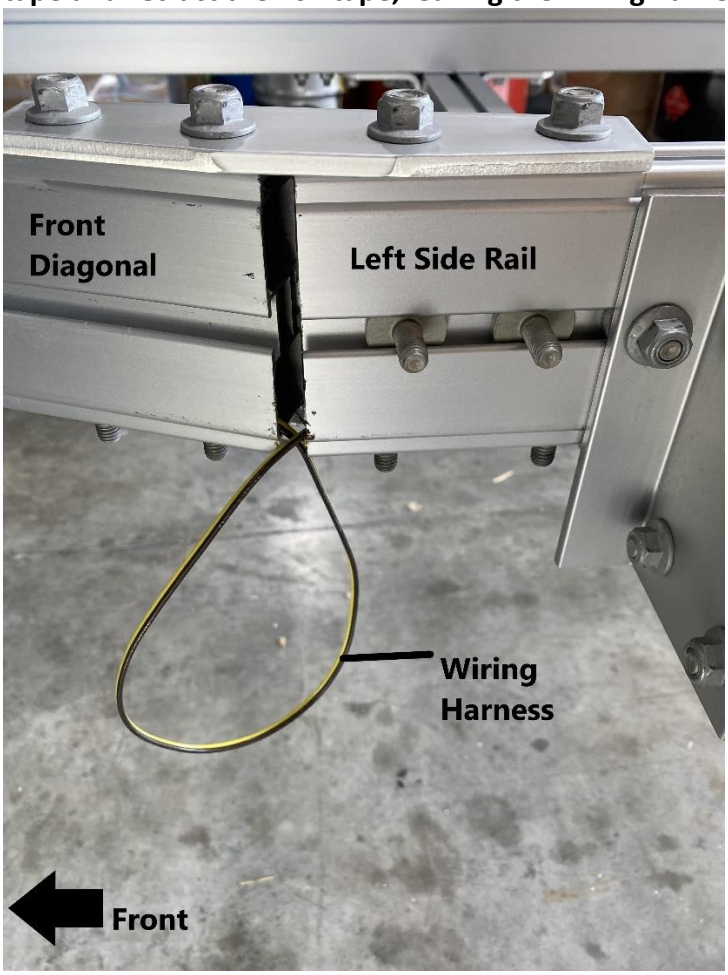
Extend the fish tape until it reaches the opening between the front diagonal and the left side rail. Remove the electrical tape and retract the fish tape, leaving the wiring harness at the opening. Pull the excess wiring harness through the opening.



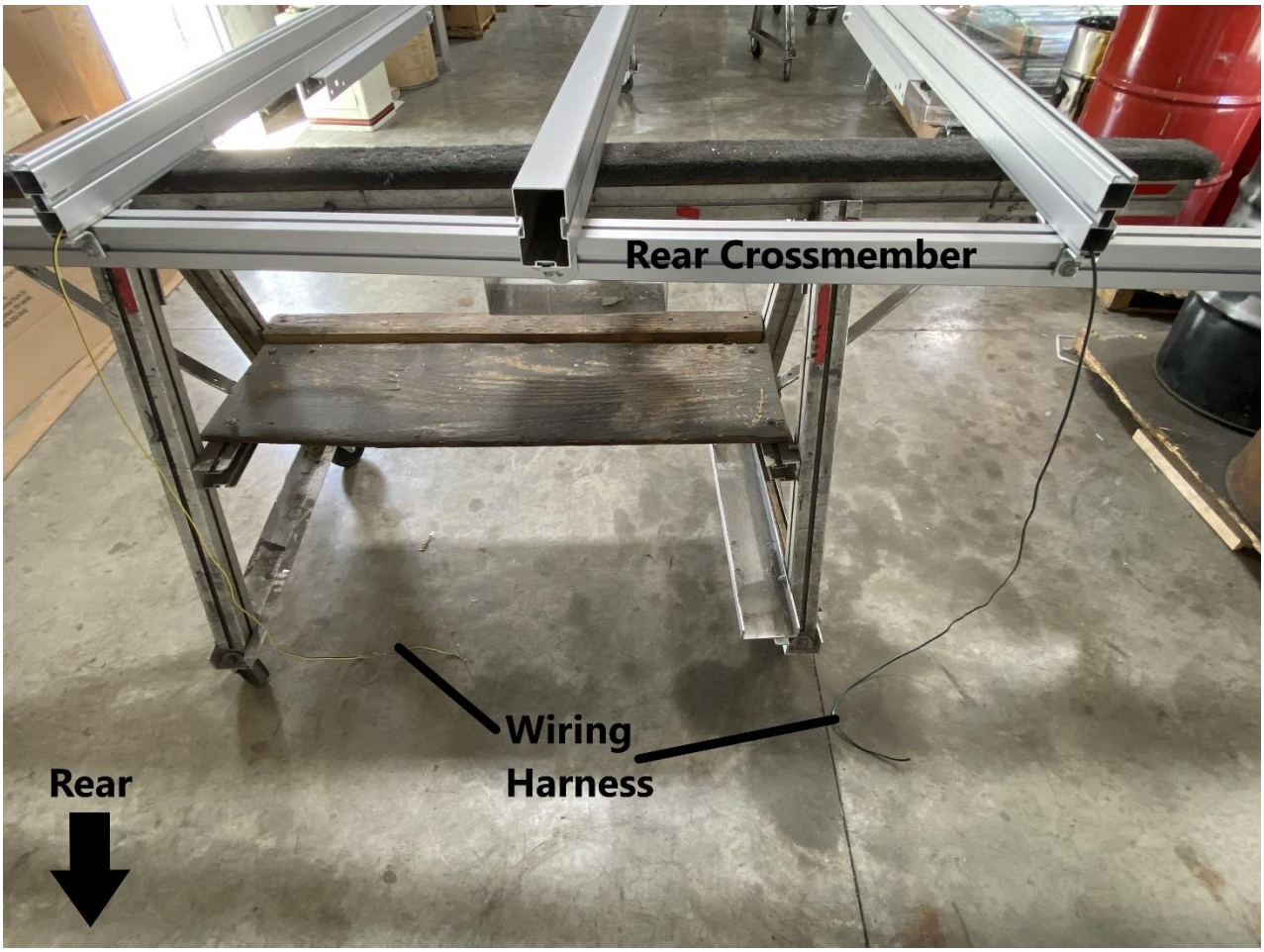
Re-attach the end of the wiring harness to the fish tape. Extend the fish tape through the left side rail towards the rear of the trailer.



Continue extending the fish tape until it reaches the rear of the trailer. Remove the electrical tape and retract the fish tape, leaving the wiring harness at the rear of the trailer.

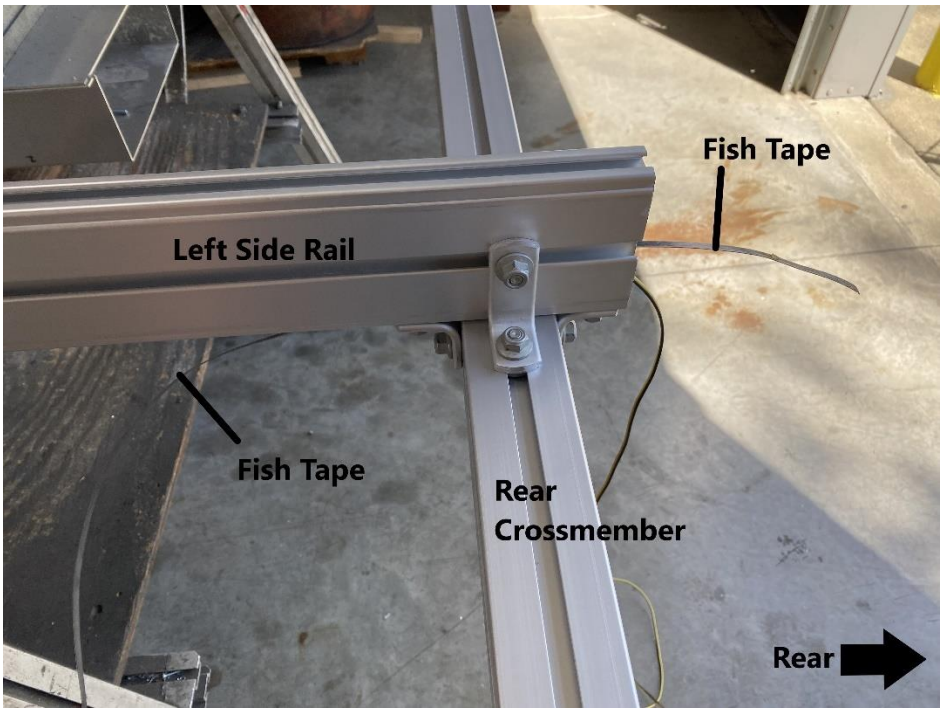


Leave a small amount of wiring harness at the opening by front diagonal and the left side rail. This will be used to connect the amber marker lights to the wiring harness.

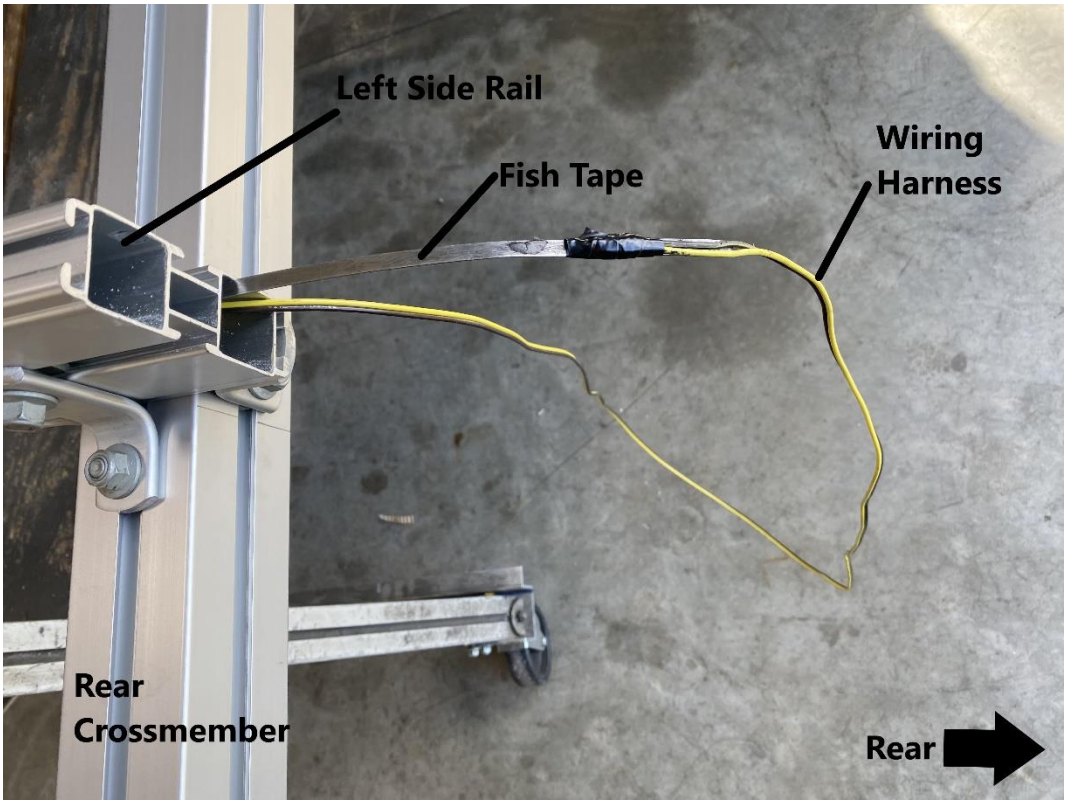


Repeat this process to run the wiring harness down the right side of the trailer. At this point the trailer will look like this.

Locate the pre-drilled hole for taillight on the bottom groove of the left side rail, close to where the left side rail connects to the rear crossmember.



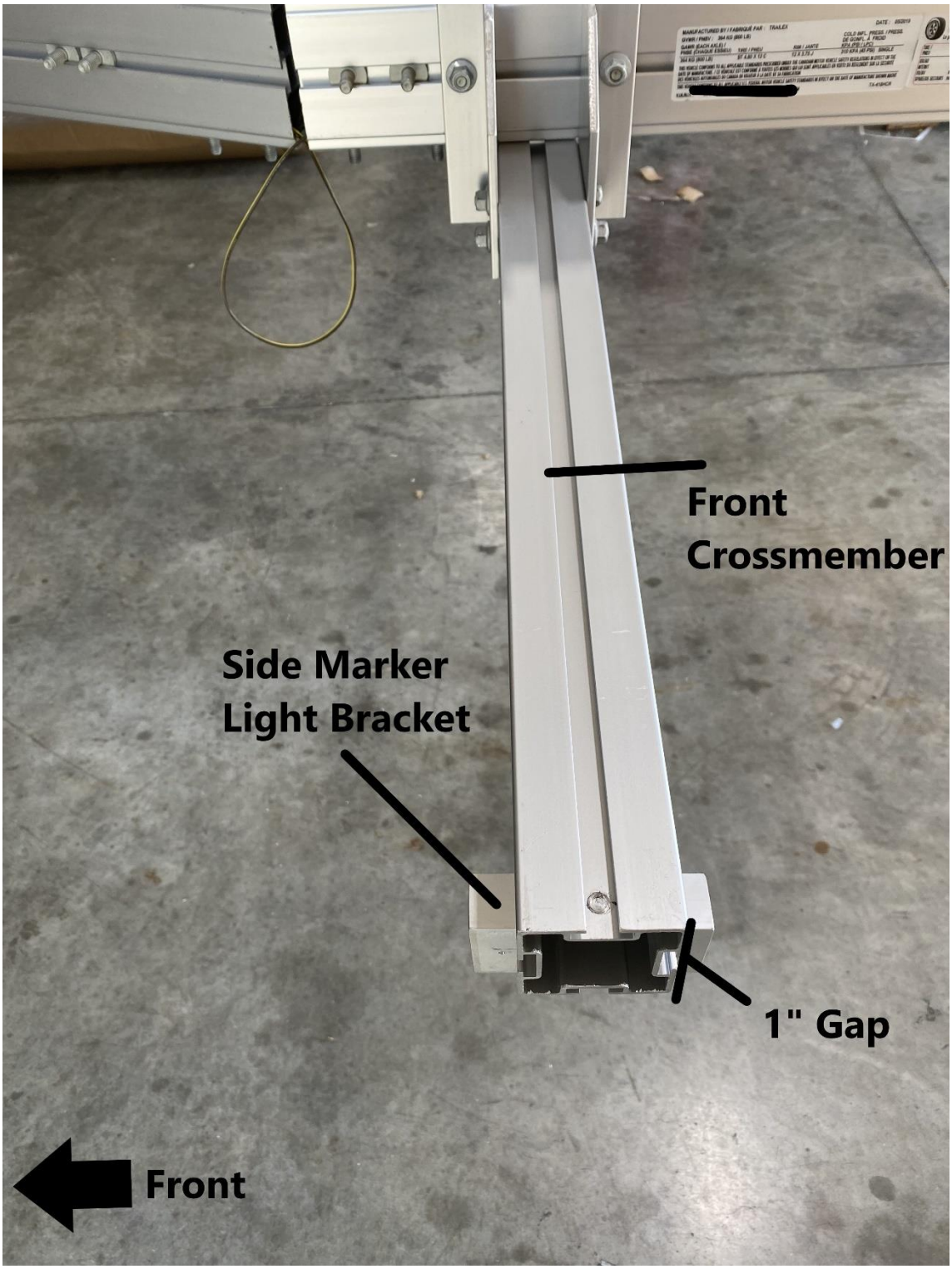
Run the fish tape through the pre-drilled hole for tail light to the rear of the trailer.



Use electrical tape to connect the end of the fish tape to the end of the wiring harness.

Retract the fish tape, leaving the wiring harness through the pre-drilled hole for taillight. Install a snap bushing. Repeat this process for the other side.

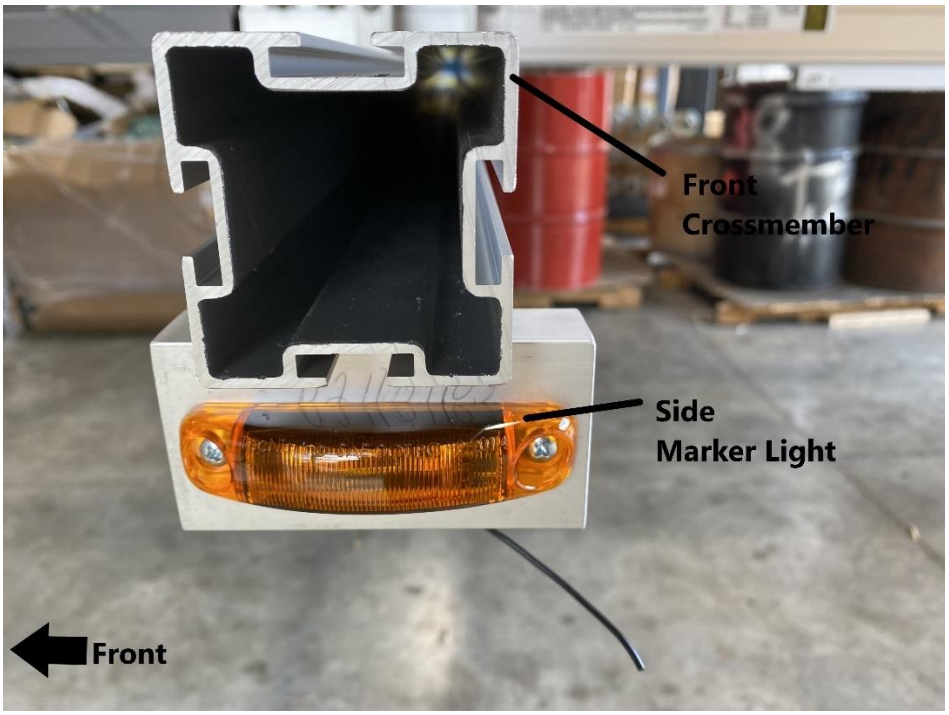
Locate (2) side marker light brackets.



Slide the T-bolt installed on the side marker light bracket into the bottom groove of the front crossmember as shown. Leave 1” at the end of the front crossmember for the side marker light. Tighten the locknut using a 9/16” wrench. Repeat this process to install the second side market light bracket on the other side of the front crossmember.

Locate (2) side marker lights. These can be found in the LED tail light box.

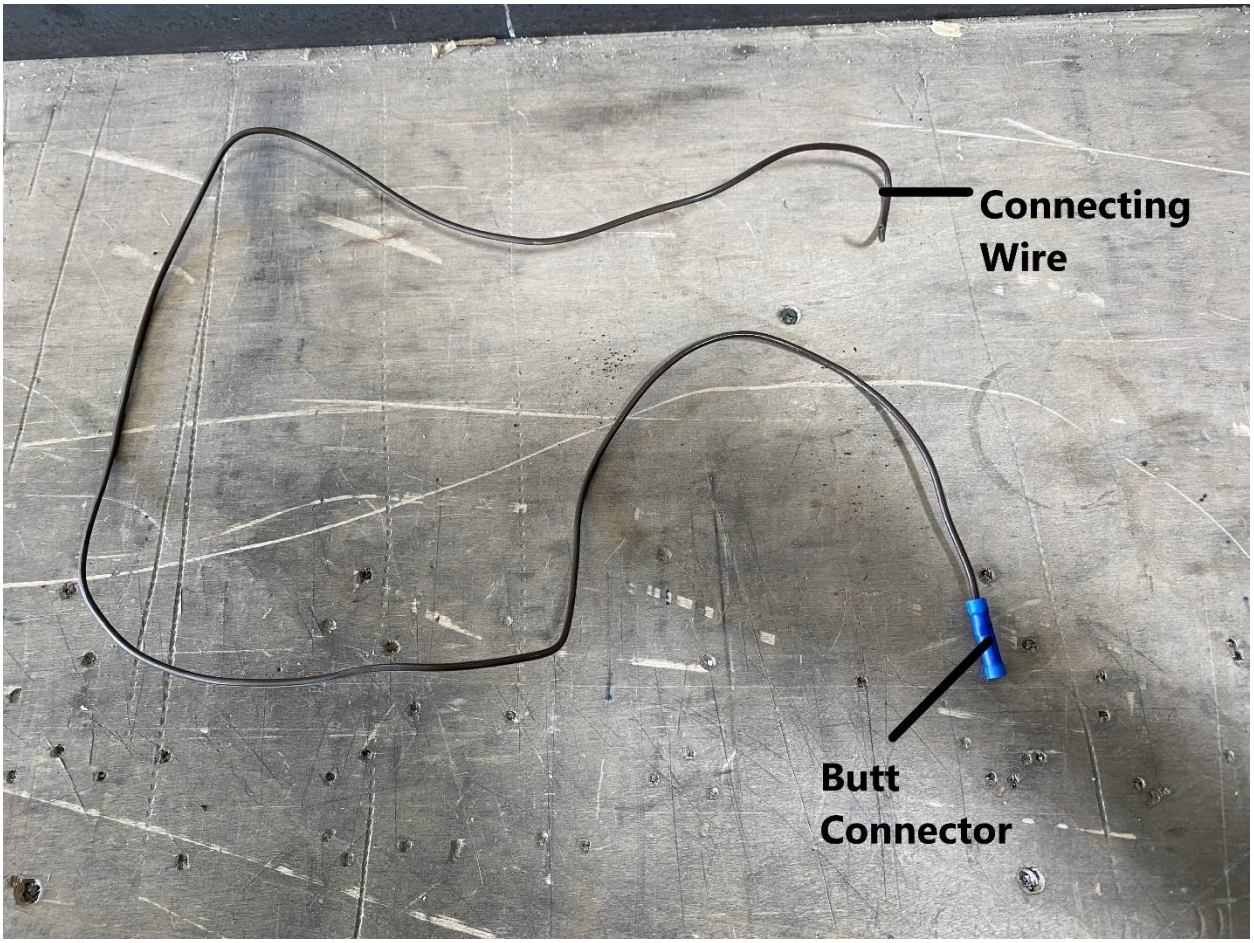
Locate (2) ¾” Phillips screws. These can be found in the LED Tail Light box.



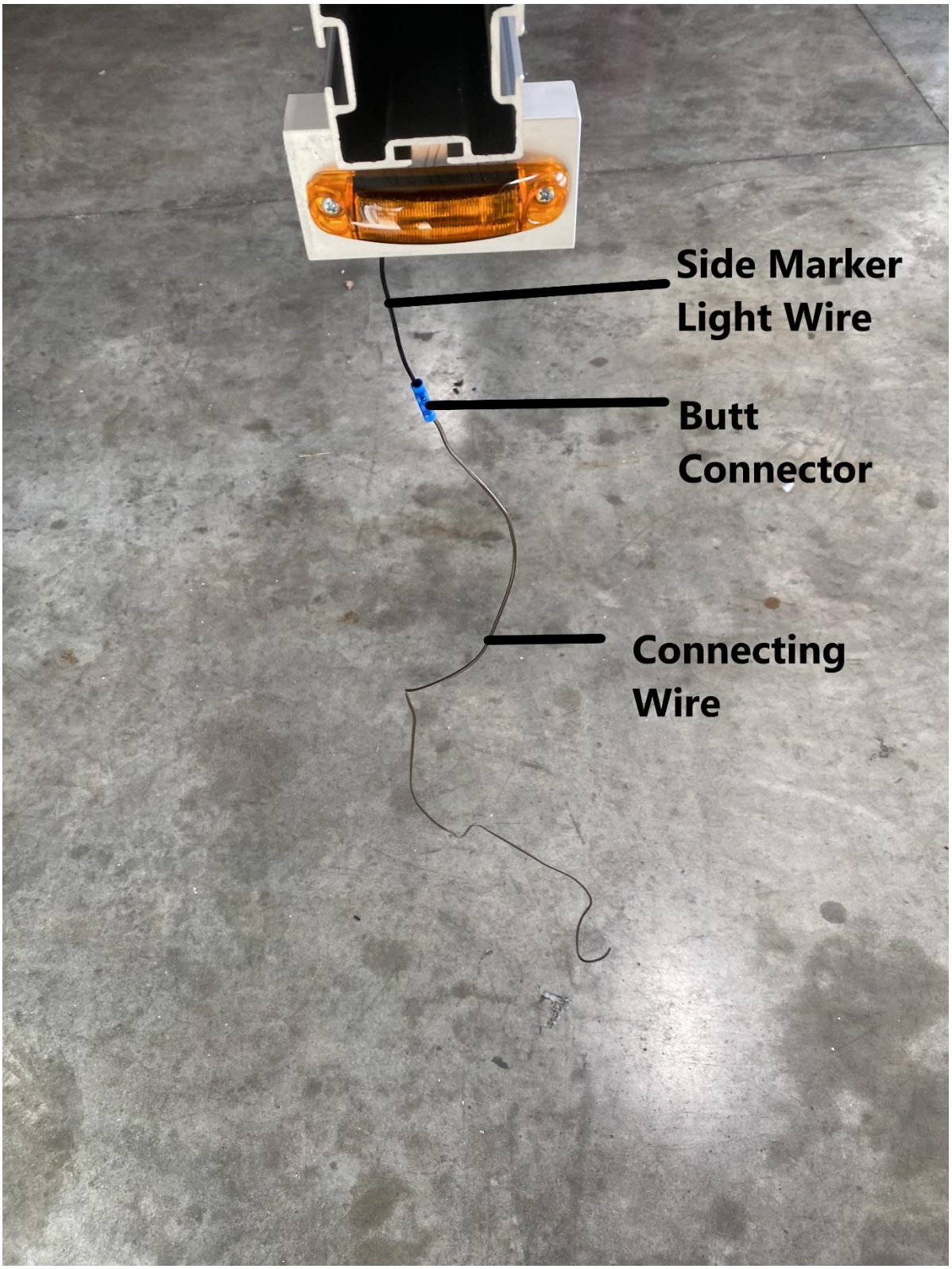
Using a Phillips screwdriver, install the side marker light to the side marker light bracket as shown. The wire will go through the large hole in the center of the bracket. Repeat this process for the other side.

Locate a connecting wire found the pull wire bag.

Locate a butt connector found in the LED Light Kit.

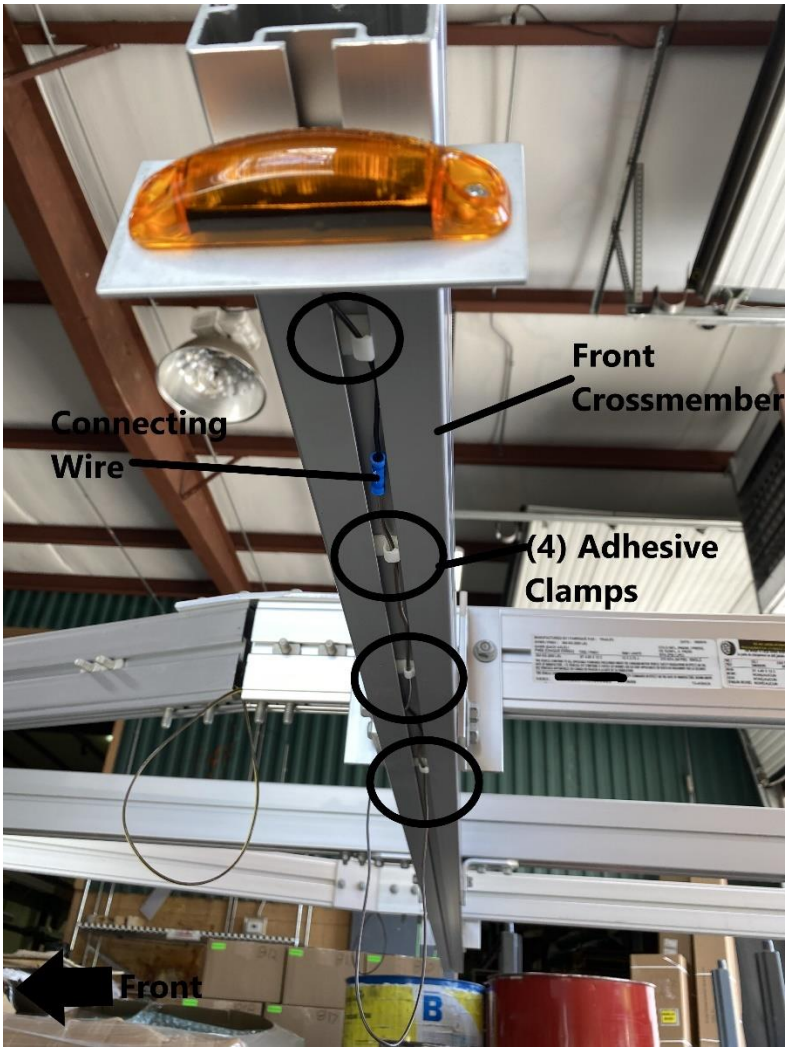


Strip an end of the connecting wire and crimp a butt connector to the connecting wire.

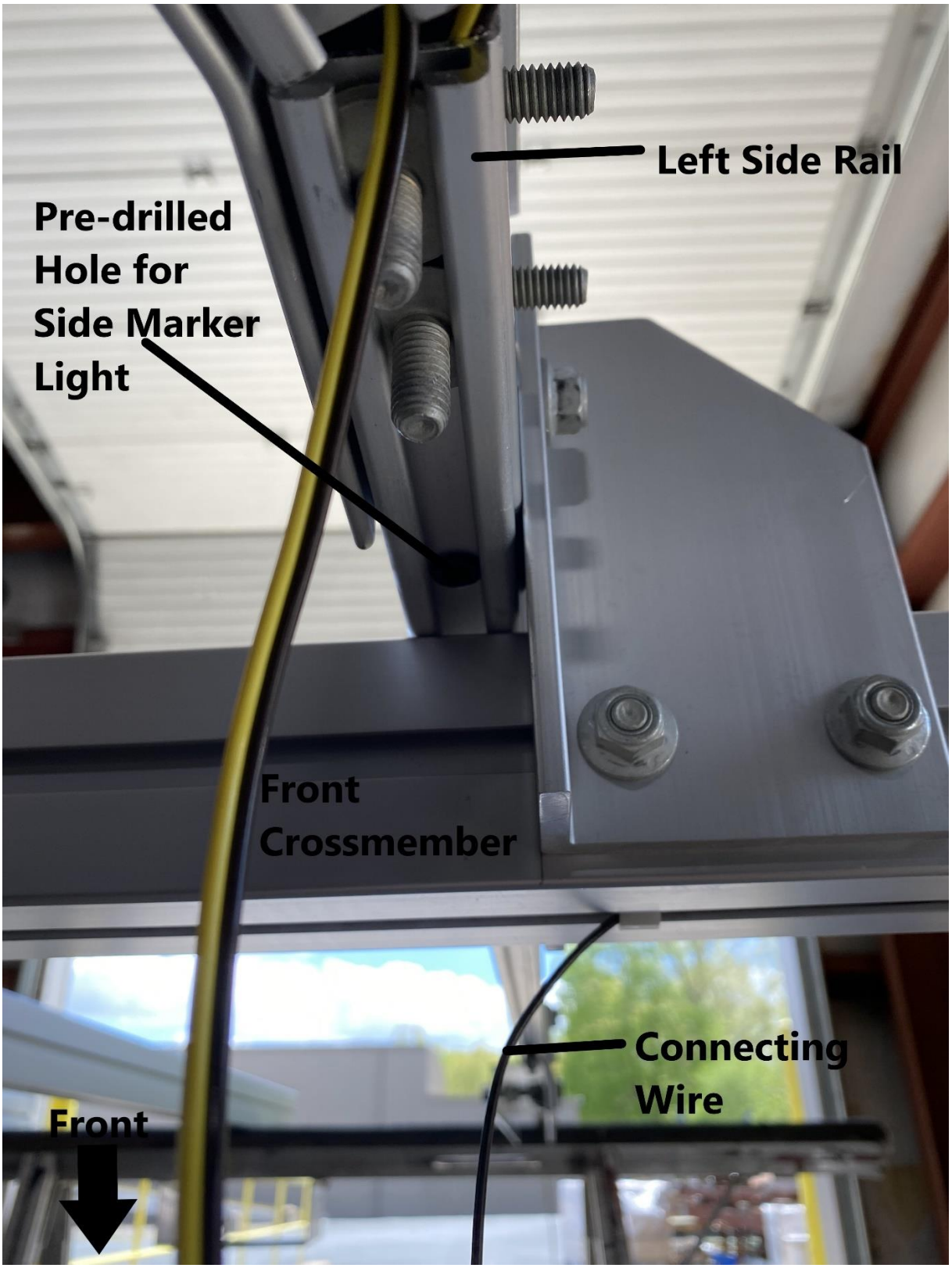


Strip the end of the side marker light wire, insert the end into the butt connector and crimp. At this point the side marker light will look like this.

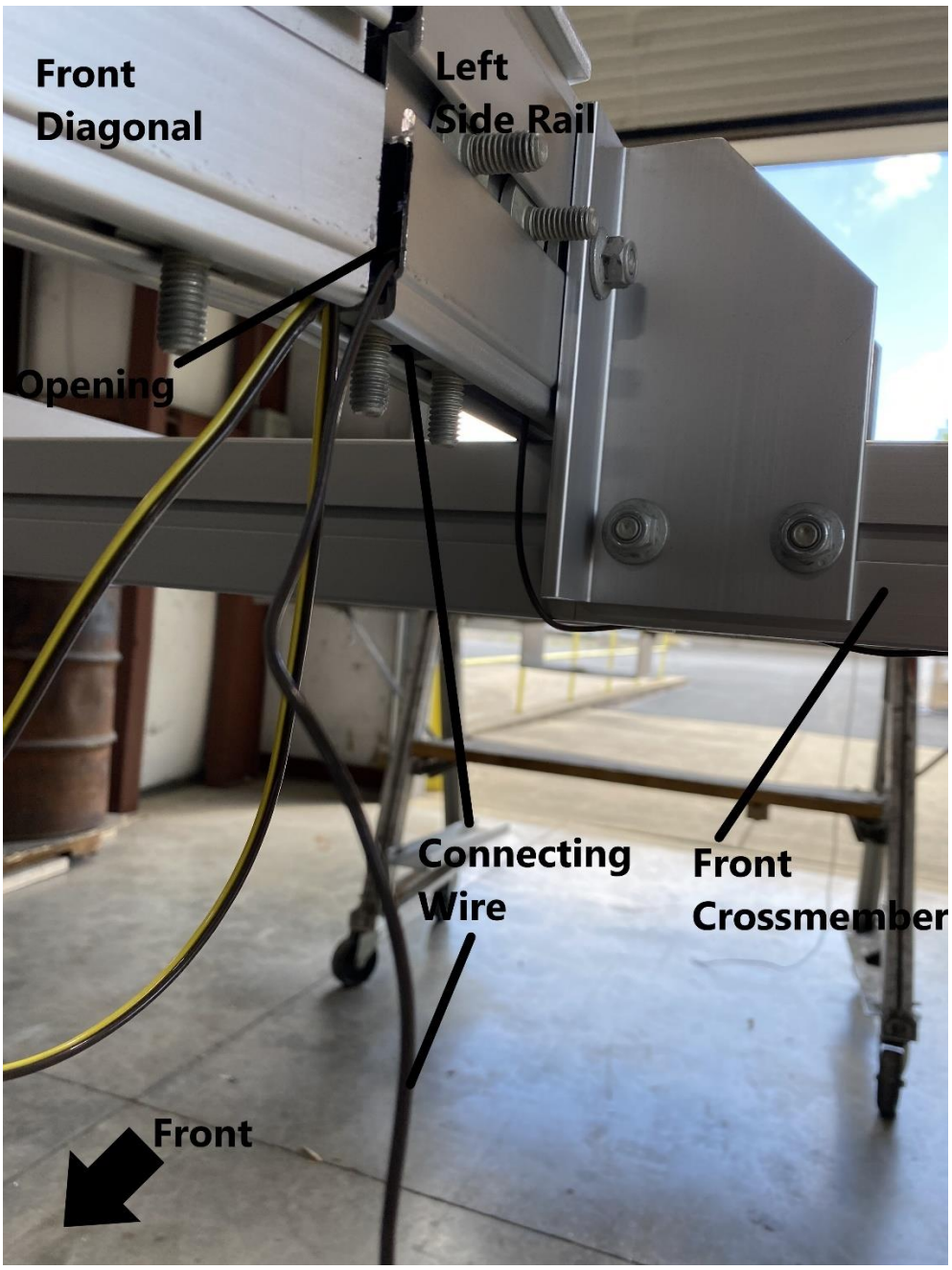
Locate the adhesive wire clamps located in the LED tail light kit.



The connecting wire will now need to be ran towards the inside of the trailer to connect to the wiring harness. Use (4) adhesive clamps to run the connecting wire down the bottom groove of the front crossmember.

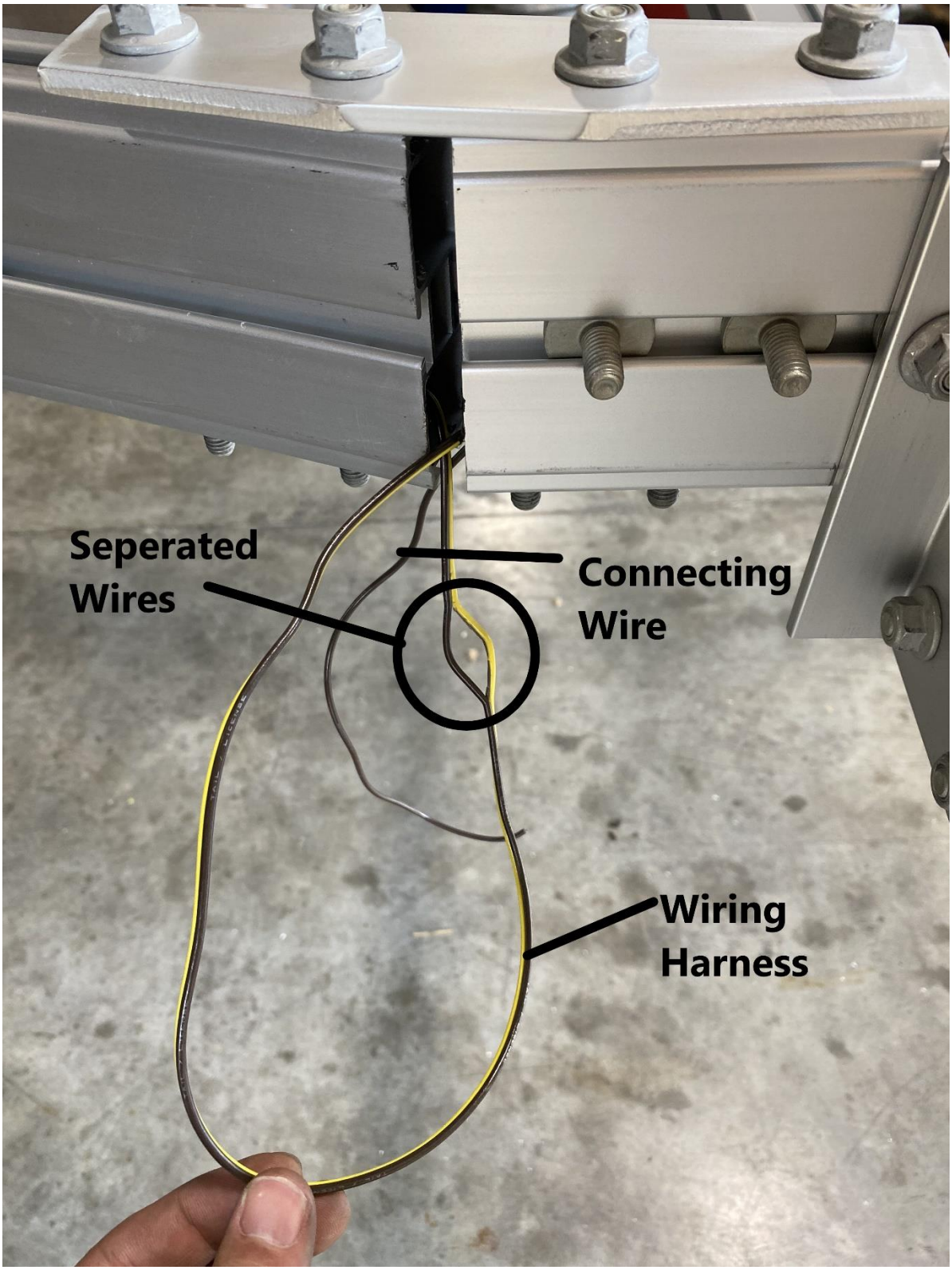


Locate the pre-drilled hole for side marker light. This will be found in the bottom groove of the left side rail, close to where the left side rail and front crossmember connect.



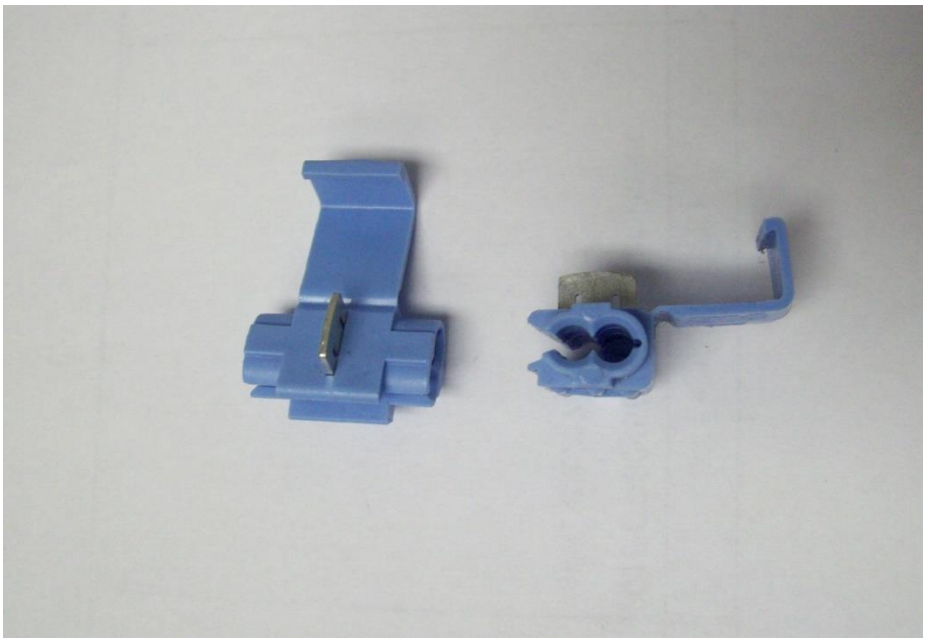
Run the connecting wire through the pre-drilled hole until it is through the opening between the front diagonal and left side rail.

At this point the trailer will look like this.

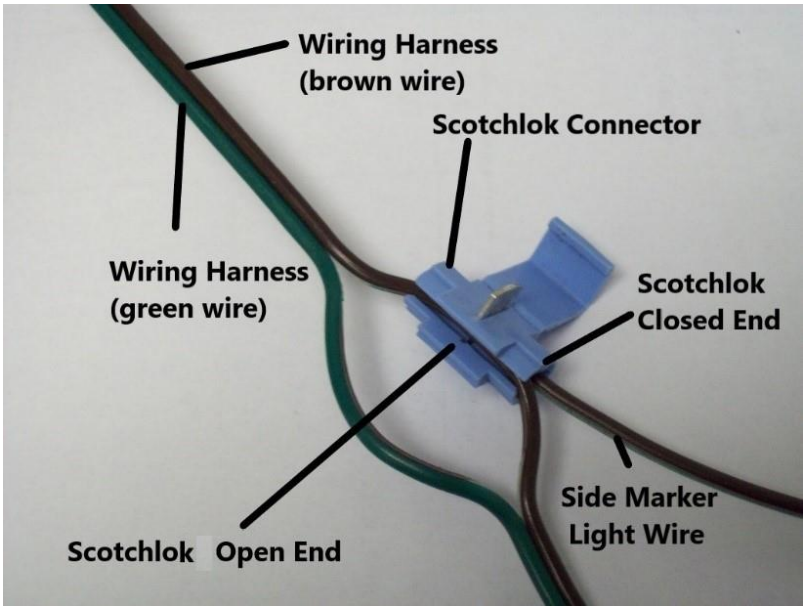


Use a utility knife to create a small separation between the yellow and brown wires of the wiring harness as shown. *Do not cut through the wires.* The following instructions are for the scotchlok connector that will connect the connecting wire to the wiring harness.

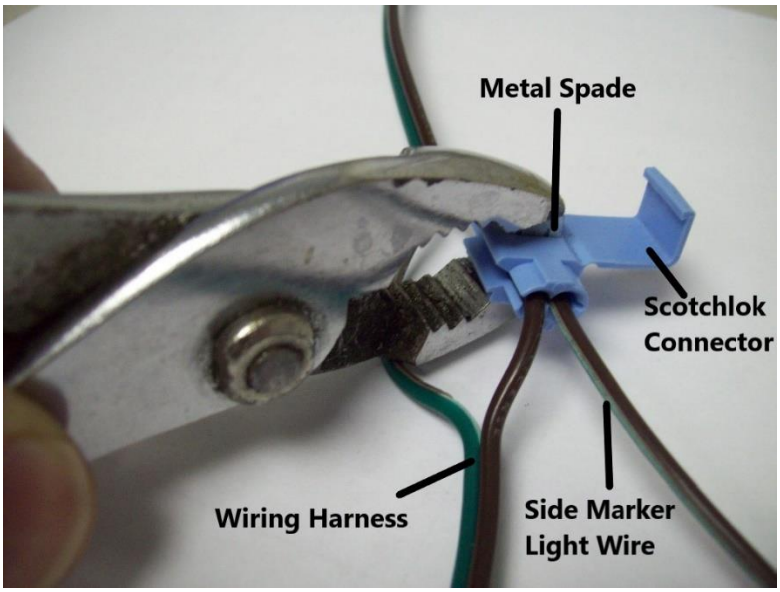
Scotchlok Connector Instructions



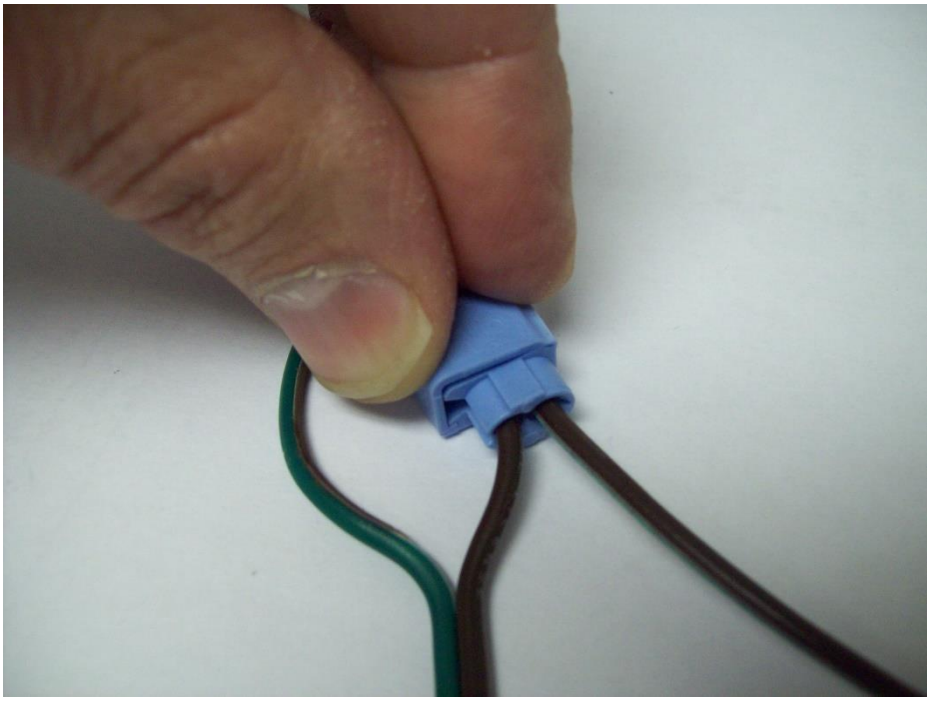
Locate (2) Scotchlok connectors. These will be found in the LED Tail Light Box.



Insert the side marker light wire into the Scotchlok connector. This hole does not pass all the way through. The wire should go in about ½". Pass the brown wire of the wiring harness through the remaining open slot in the connector.



Use pliers to push the metal spade down until it is flush with the plastic of the Scotchlok Connector. This is what makes the electrical connection between the two wires.

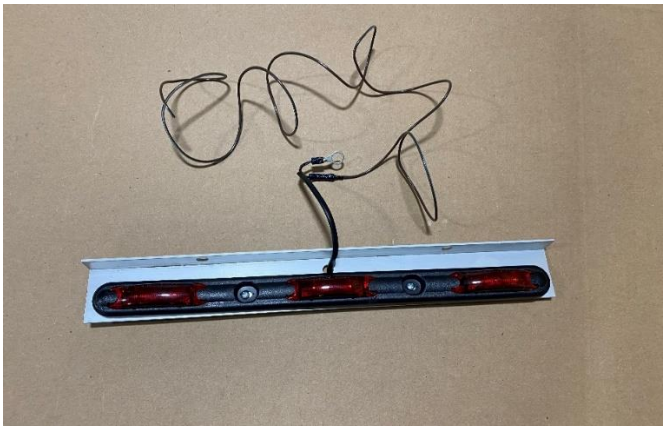


Close the hinge cover on the Scotchlok Connector. Repeat this process for the other side.

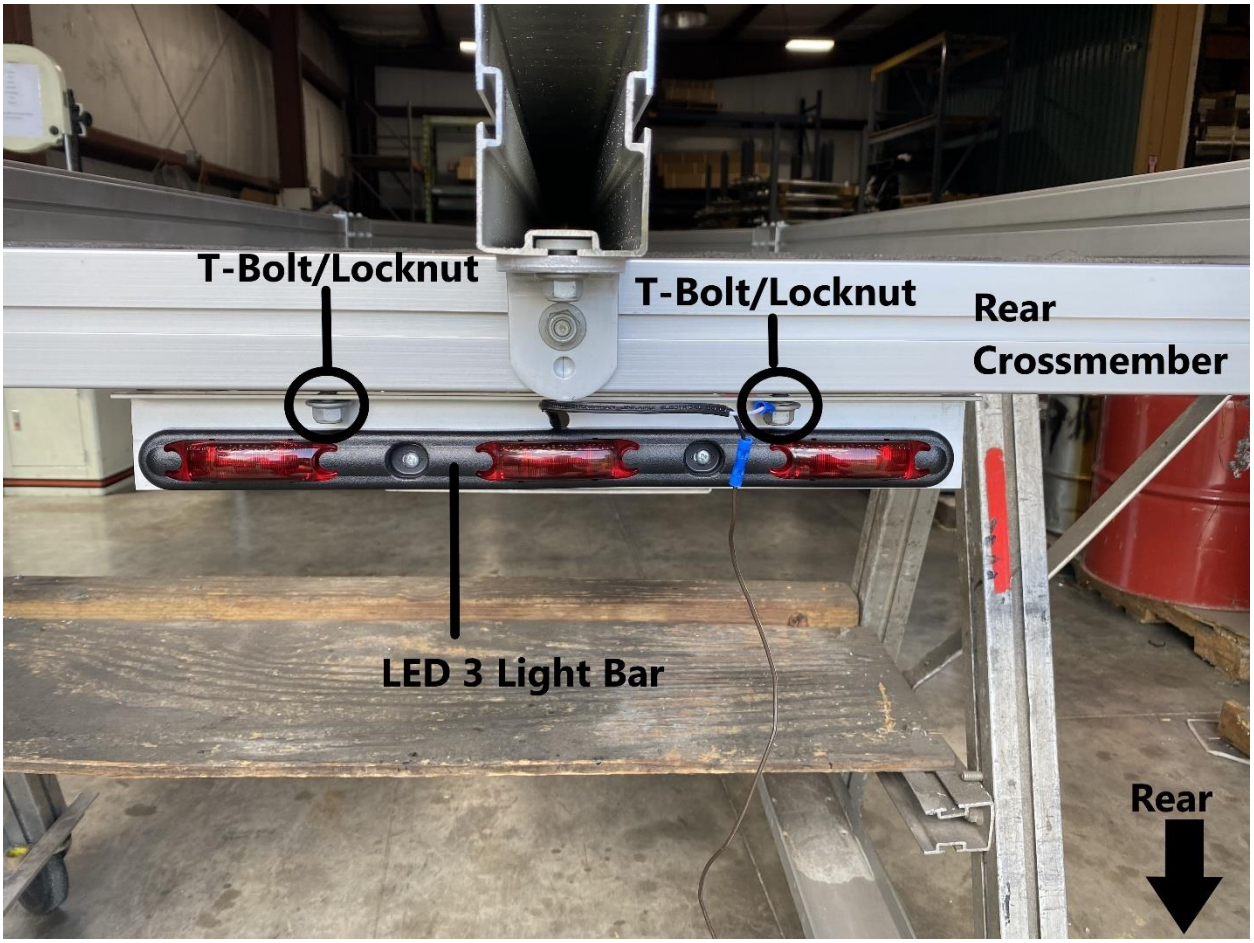
At this point the trailer will look like this.

Carefully insert all the wiring into the trailer. Repeat this process for the other side to connect the other side marker light.

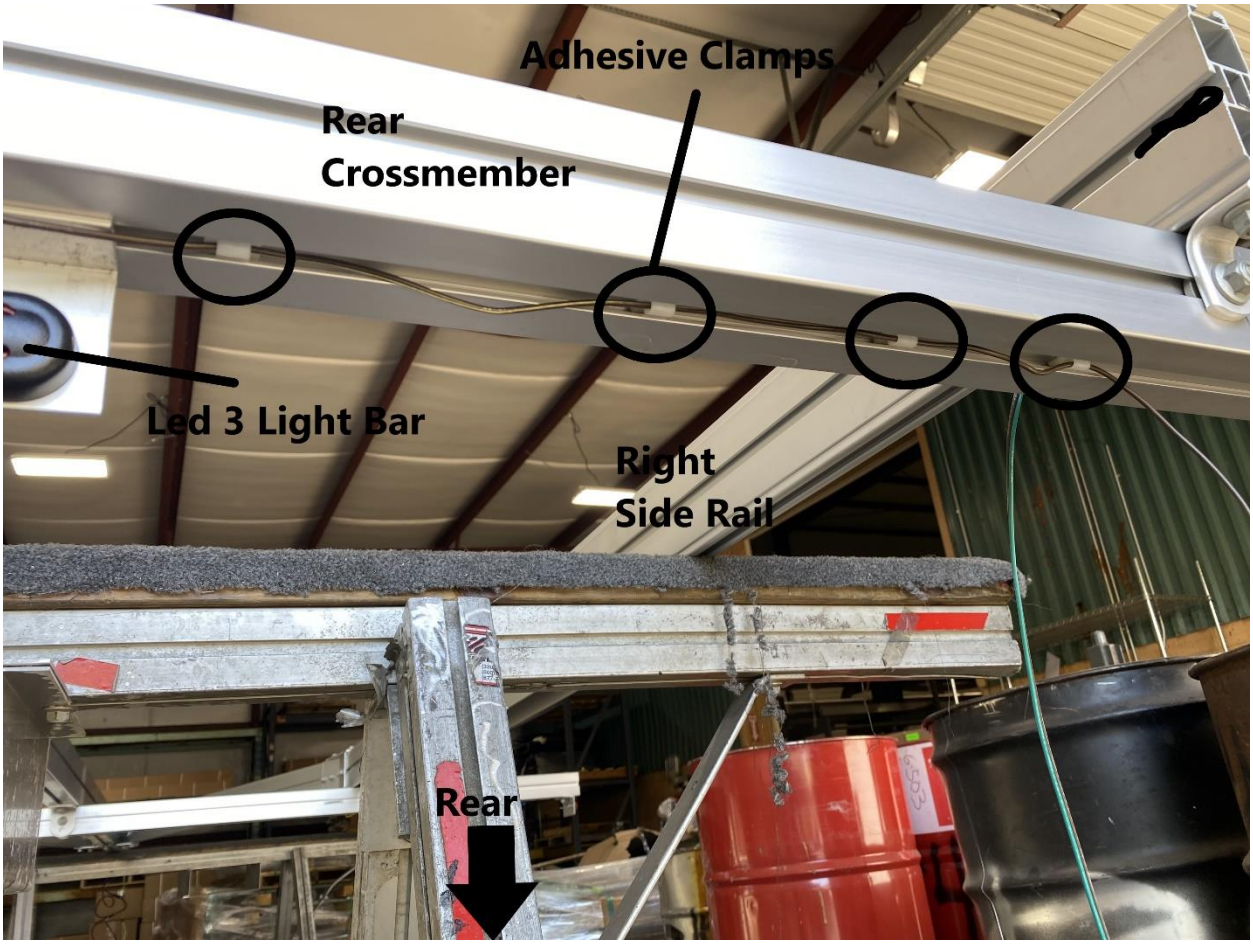
LED 3 Light Bar and Taillight Installation



Locate the LED 3 light bar.

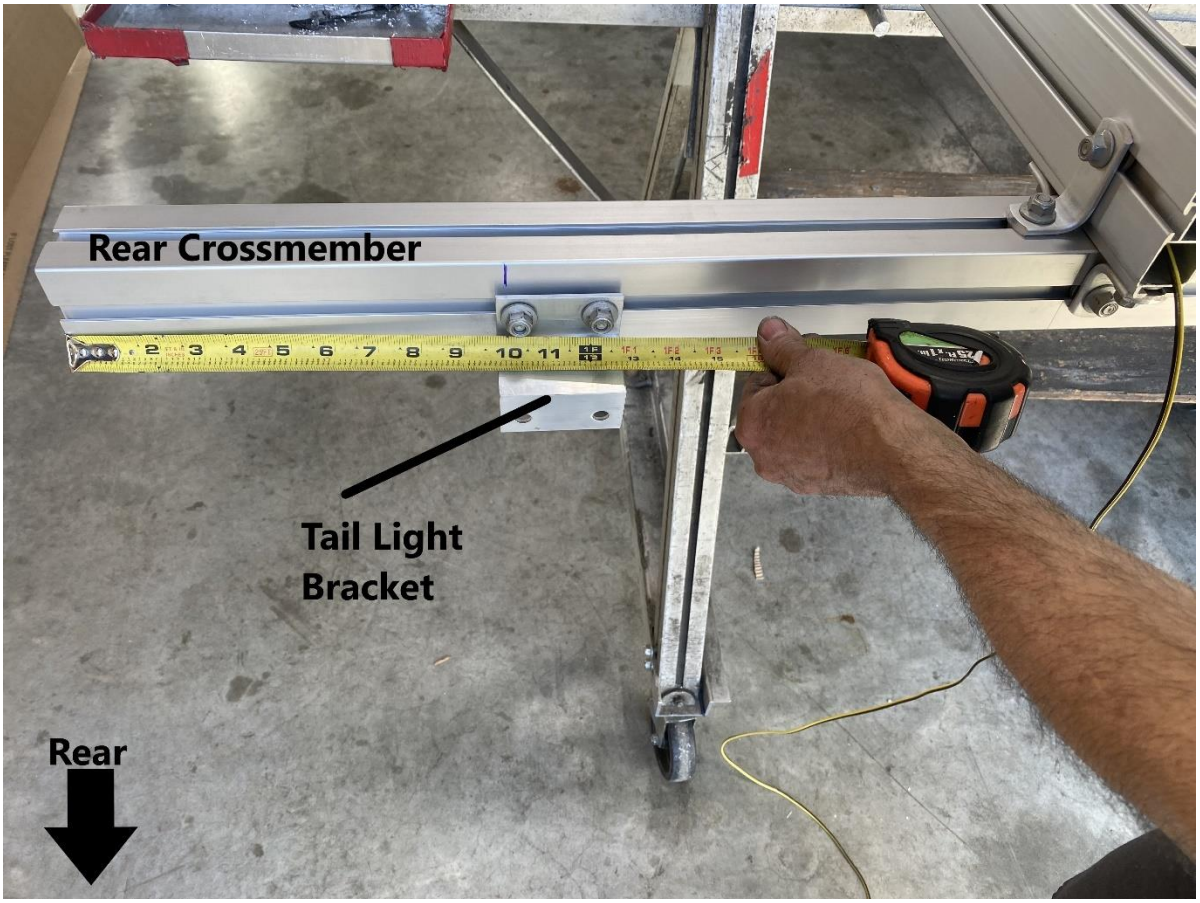


Two T-bolts and locknuts will need to be installed on the LED 3 Light Bar before installing on the trailer. Once the (2) T-bolts and (2) locknuts have been installed, slide the (2) T-bolts into the bottom groove of the rear crossmember until the LED 3 Light Bar is in the center of the rear crossmember. Tighten the locknuts using a 9/16" wrench.



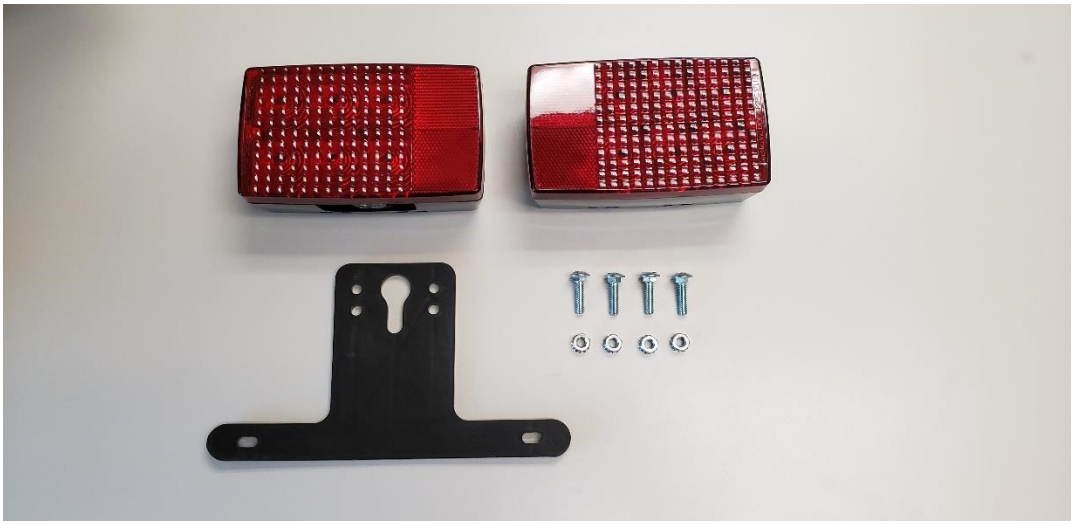
With the LED 3 Light Bar installed, the LED 3 light bar wire will now need to be ran towards the right side rail. Use (4) Adhesive clamps to run the LED 3 Light Bar wire towards the right side rail as shown using the bottom groove of the rear crossmember.

Locate (2) Tail Light Brackets.

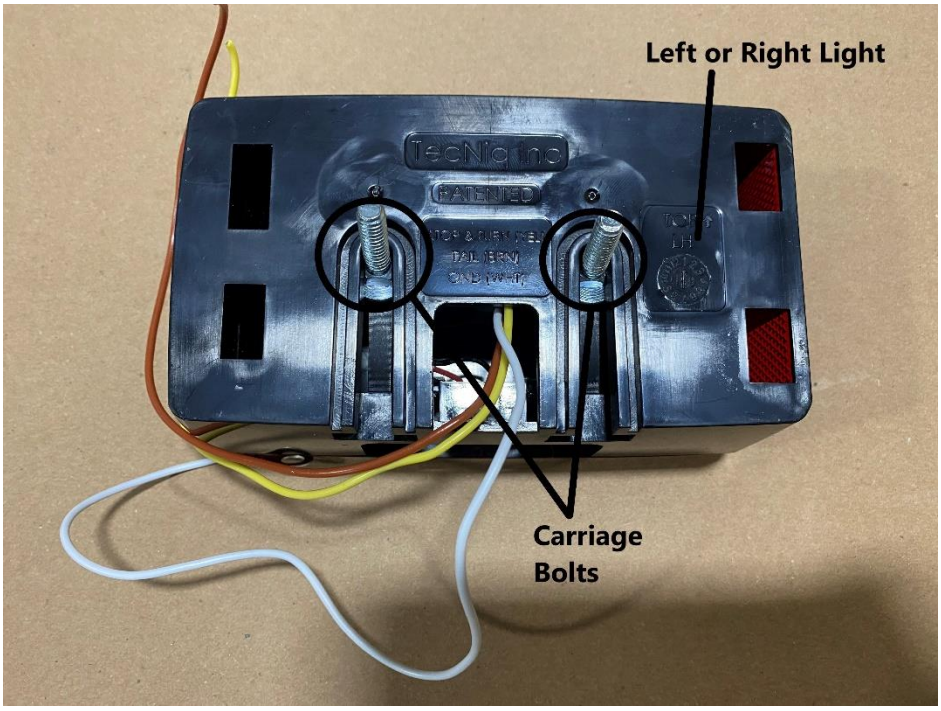


Install the tail light bracket to the rear crossmember as shown. Install the Tail Light Bracket 10” from the end of the rear crossmember. Tighten the two locknuts using a 9/16” wrench. Repeat this process for the other side.

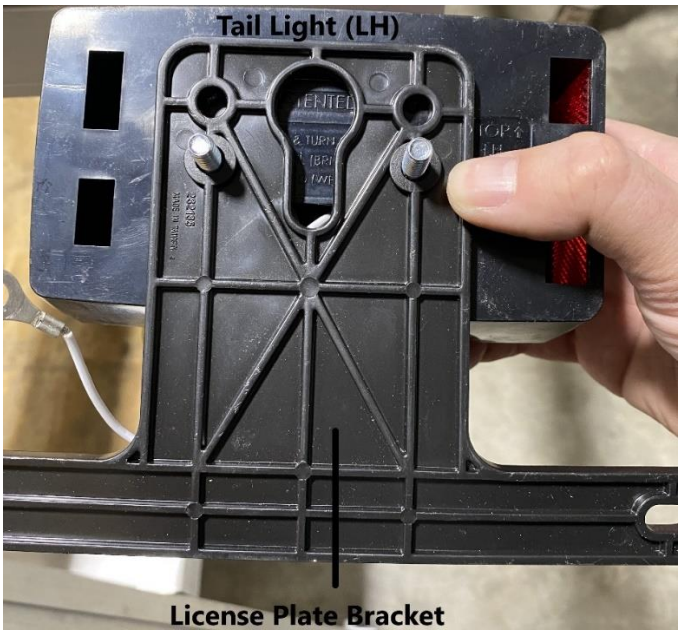
At this point the trailer will look like this.



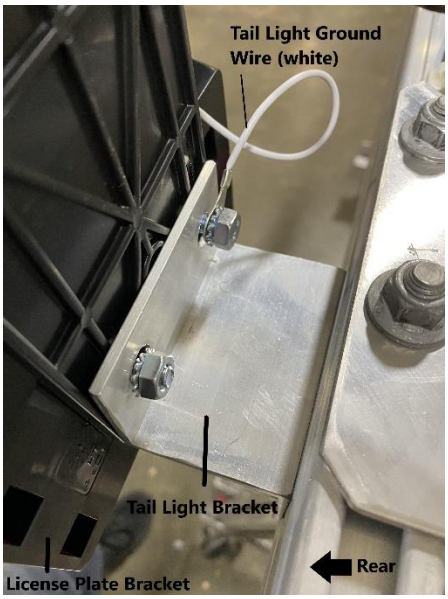
Locate (2) tail lights, (1) license plate bracket, (4) carriage bolts and (4) nuts. These will be inside the LED Light Box.



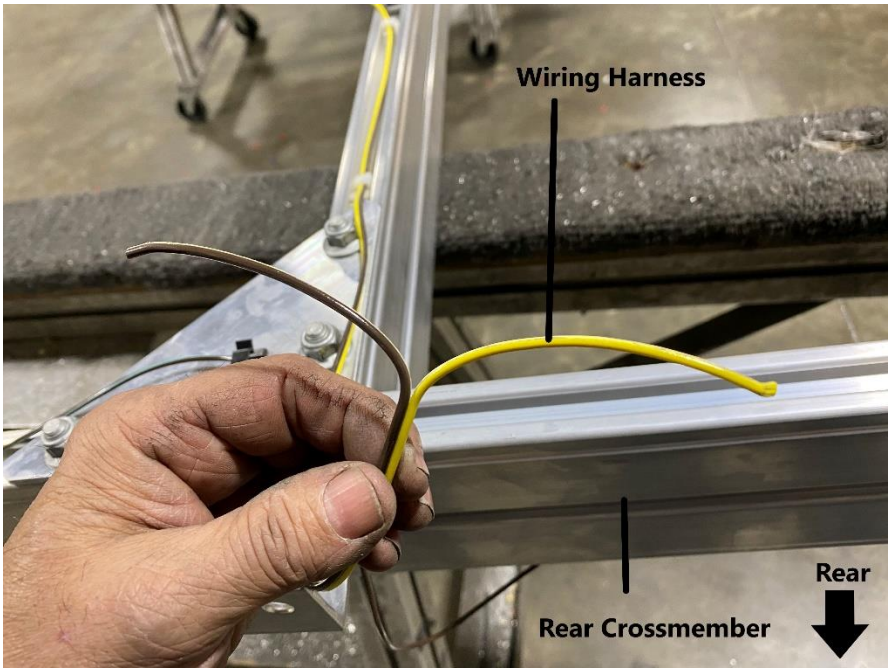
Place the (2) Carriage bolts into the grooves in the tail lights as shown. Note that the back of tail light shows if the light is the left/driver side (LH) or the right/passenger side (RH). It will also show which end is the top of the tail light.



Locate the left/driver side (LH) tail light. Install the license plate bracket to the tail light as shown.

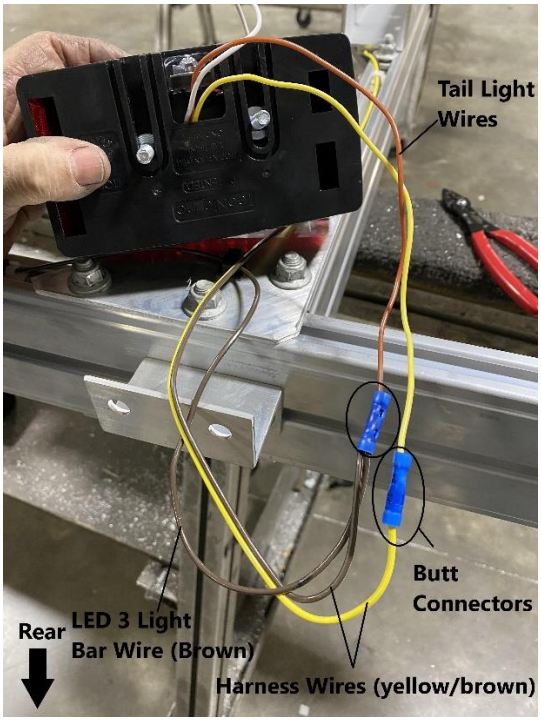


Mount the tail light and license plate bracket to the tail light bracket as shown. Refer to the back of the tail light for which end is the top. Tighten both nuts using a 7/16” wrench. Repeat the process for the other side.

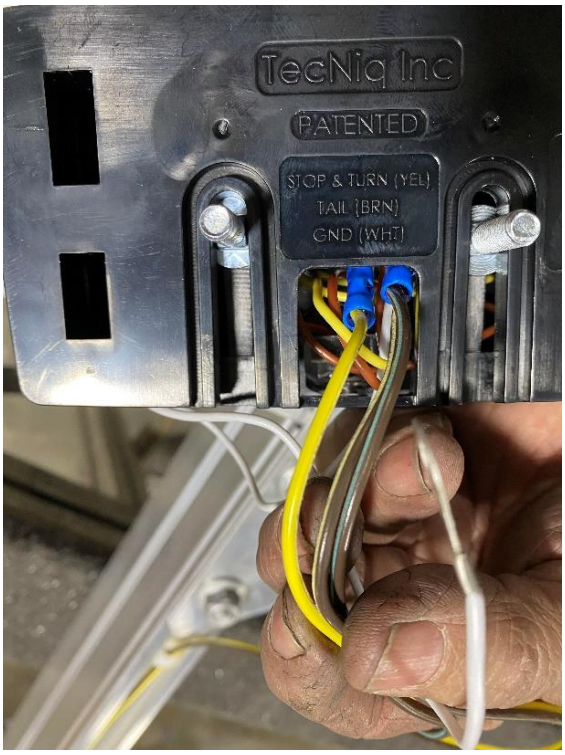


Locate the end of the wiring harness underneath the pre-drilled hole for tail light. Use a utility knife to split the two wires of the wiring harness. Repeat this process for the other side.

Use a pair of wire cutters to strip the ends of the (4) tail light wires, (4) harness wires and (1) LED 3 Light Bar wire.



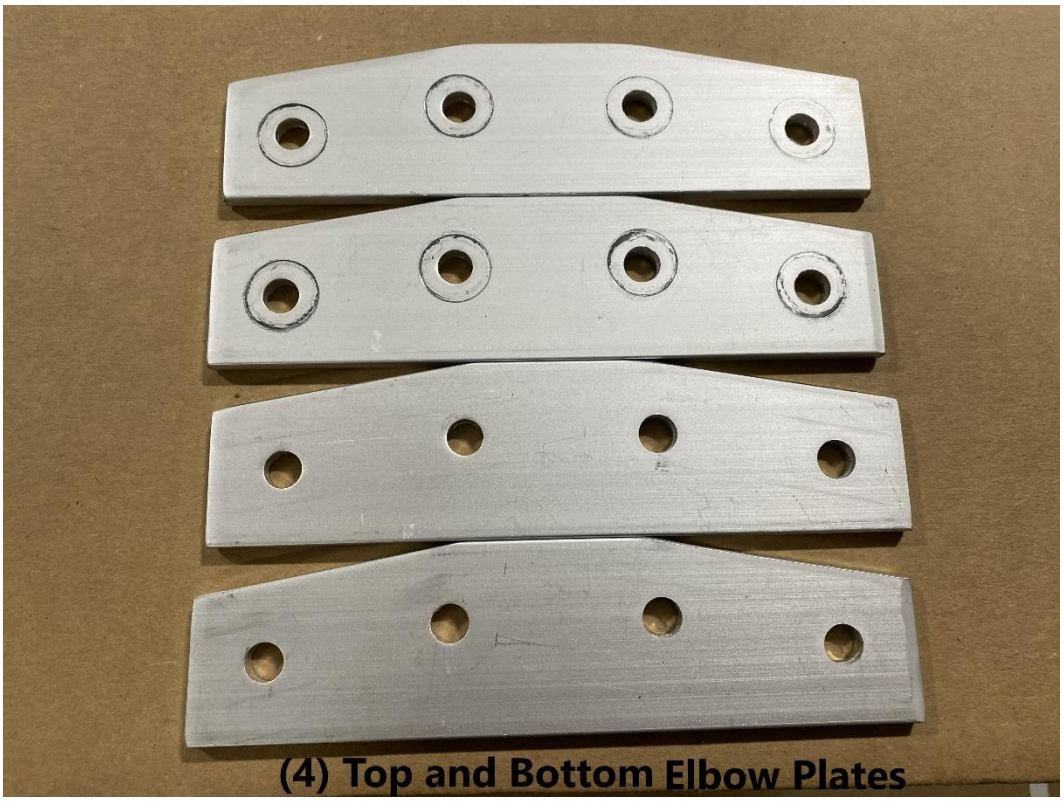
Use butt connectors to connect the tail light and the LED 3 light bar to the wiring harness as shown. Match the brown wire of the harness with the orange wire of the tail light. Same for the yellow wires. Note that both the brown LED 3 light bar wire and the brown harness wire will need to be connected together.



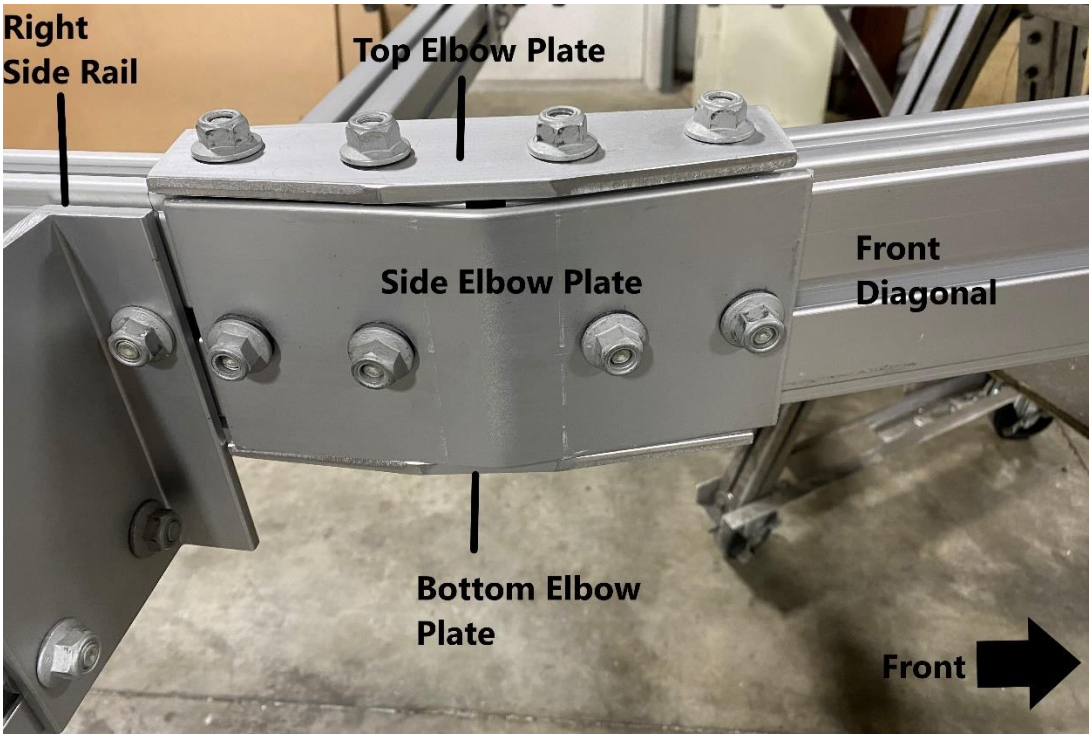
Excess wire can be placed inside the tail light.

The trailer should now look like this.

Locate the (2) side elbow plates.



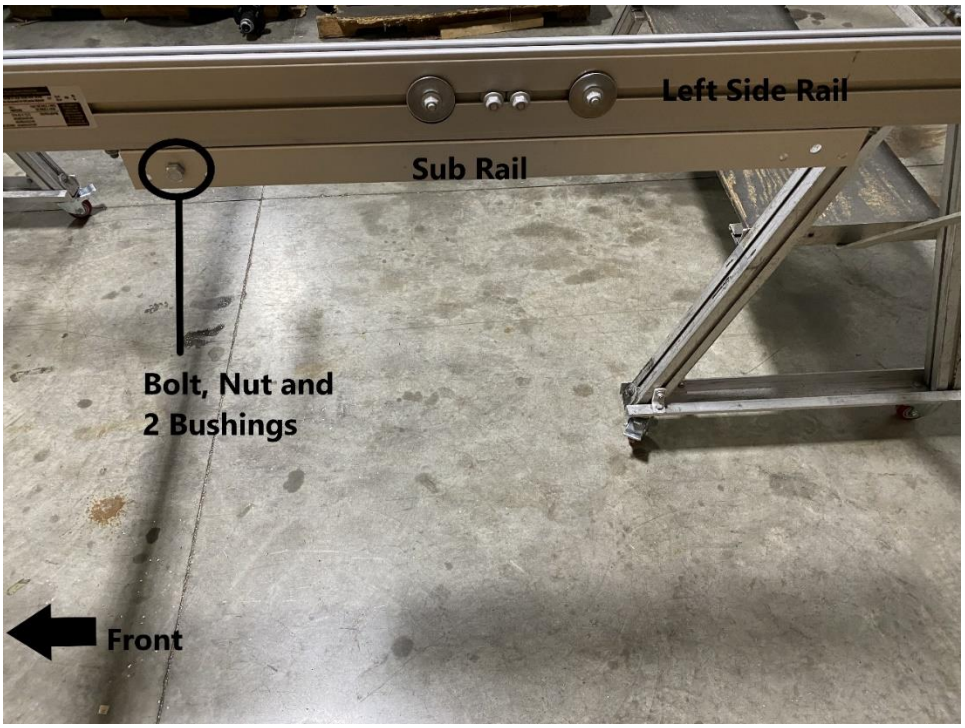
Locate the (4) top and bottom elbow plates.



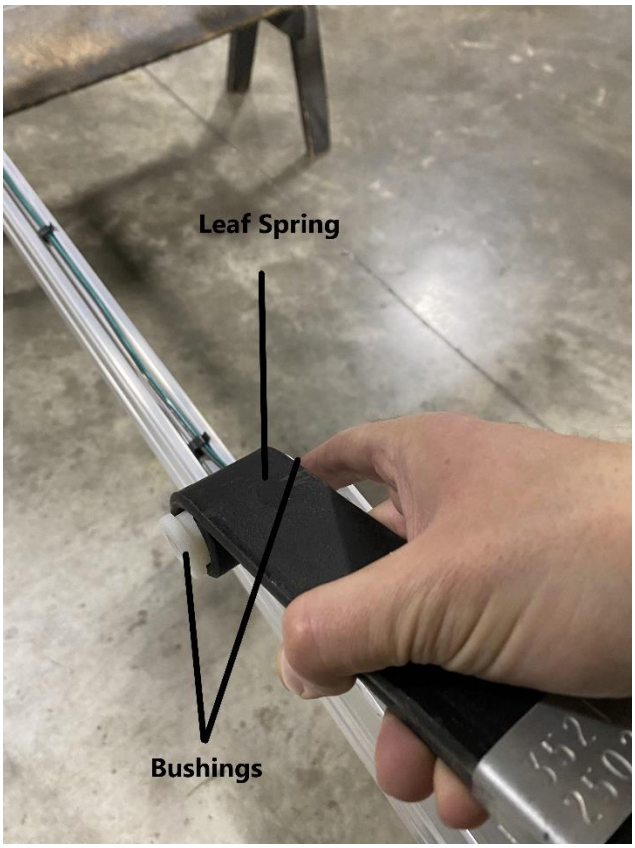
Install the side elbow plate and the top and bottom elbow plates as shown. Replace (12) locknuts and tighten using a 9/16" wrench. Repeat this process for the other side.

Leaf Spring and Axle Installation

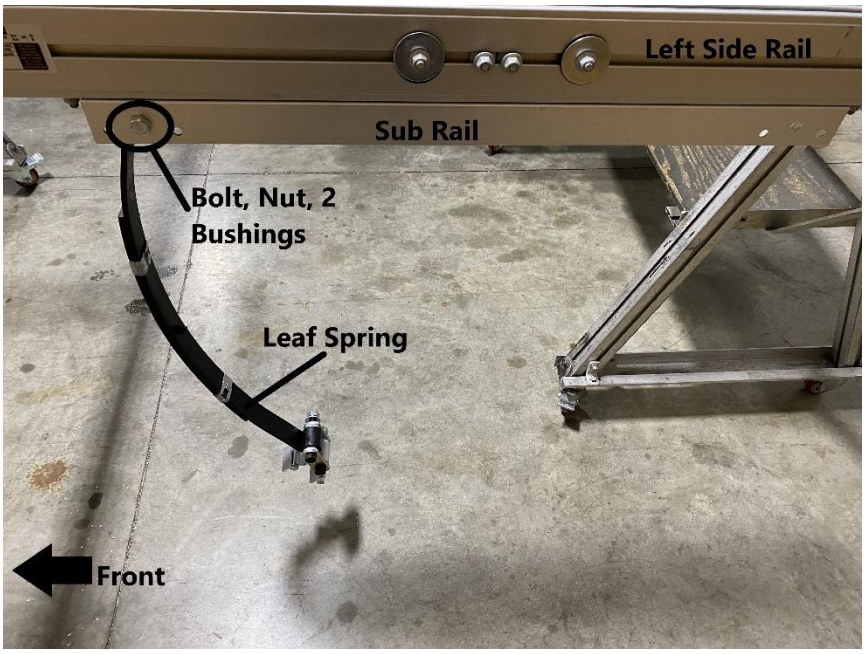
Locate the (2) leaf spring assemblies. Remove the plastic wrap.



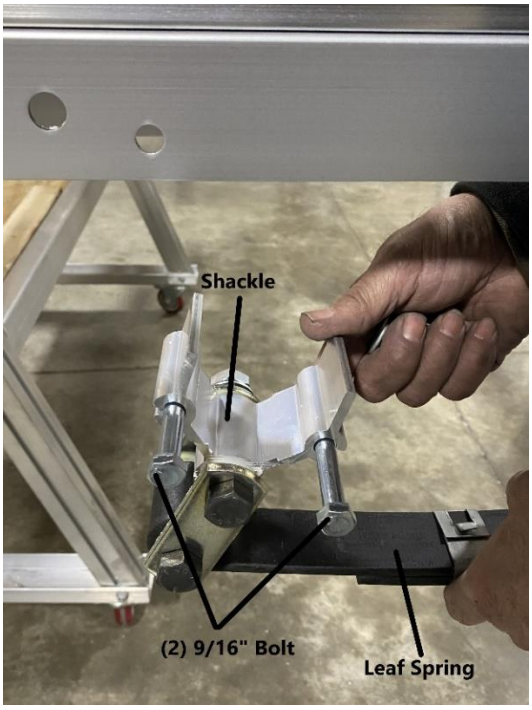
Locate the sub-rail installed on the left side rail. Use a ¾" ratchet and wrench to remove the bolt, nut, and (2) bushings.



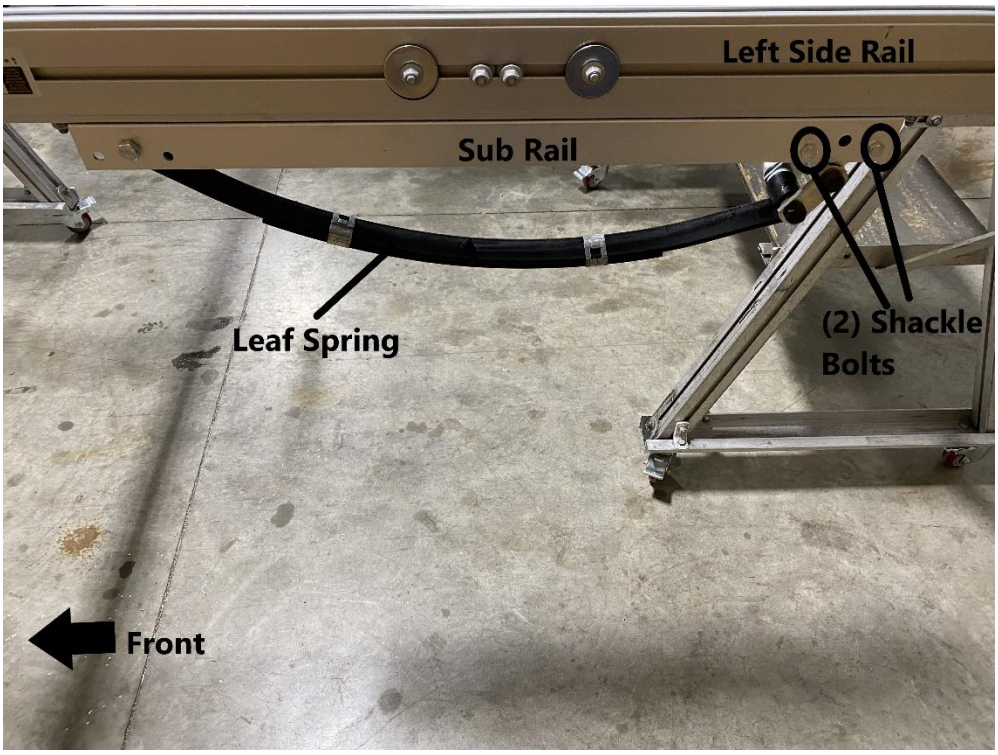
Insert the (2) nylon bushings into the leaf spring.



Install the leaf spring to the sub rail as shown. With the (2) bushings in the leaf spring, replace the ¾" bolt through the sub rail, (2) bushings, and leaf spring. Replace the nut but do not tighten yet.

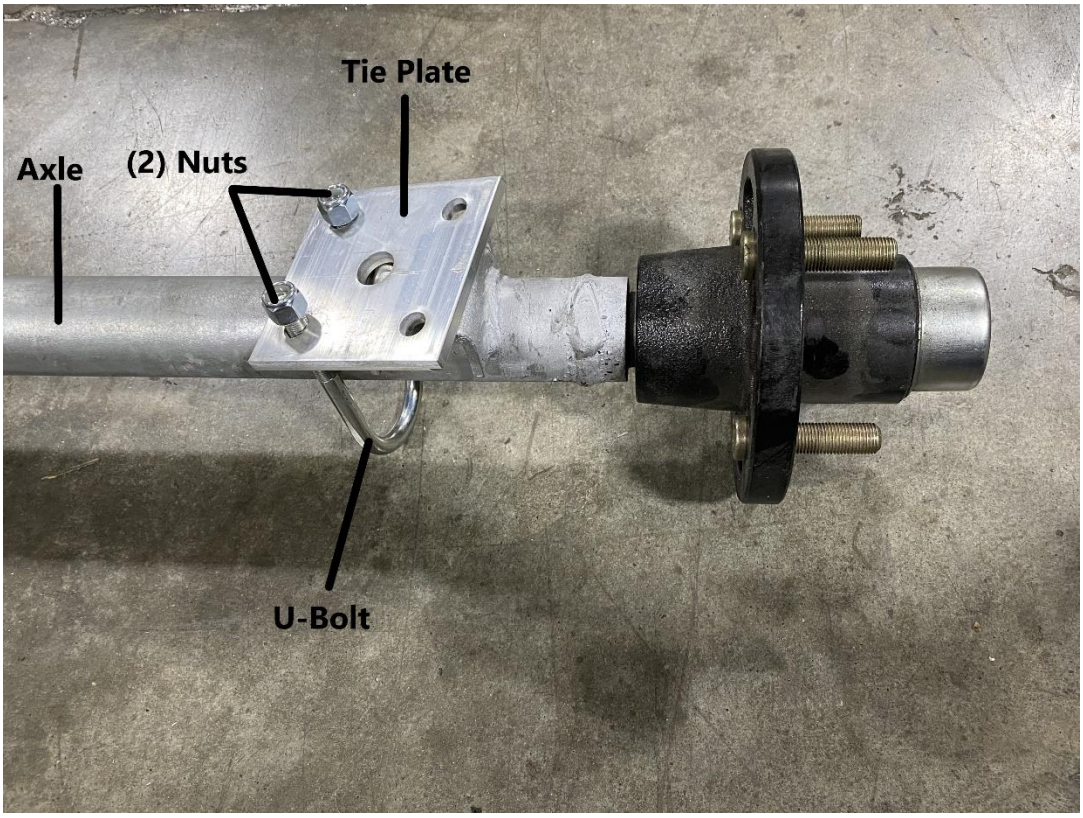


Remove the (2) bolts from the shackle installed on the leaf spring using a 9/16" ratchet and wrench.

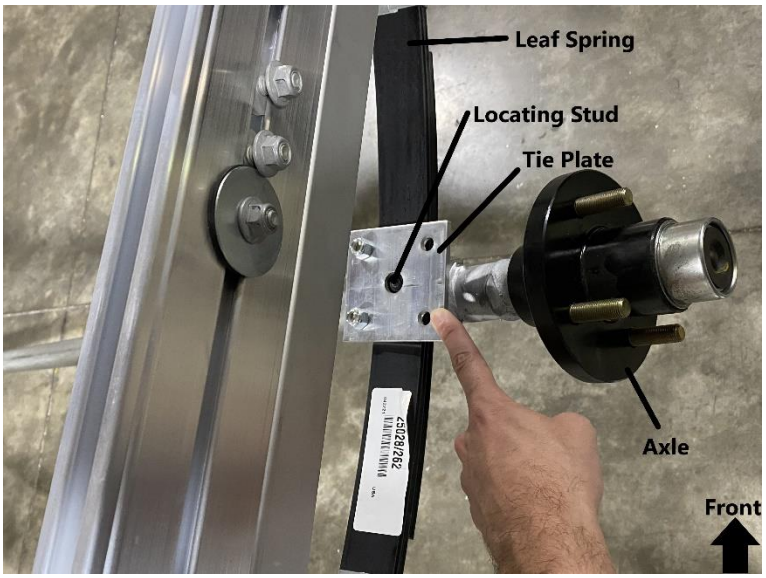


Install the shackle of the leaf spring into the sub rail as shown. Replace the (2) bolts. Replace the nuts but do not tighten yet. Repeat this process to install a second leaf spring on the left side rail.

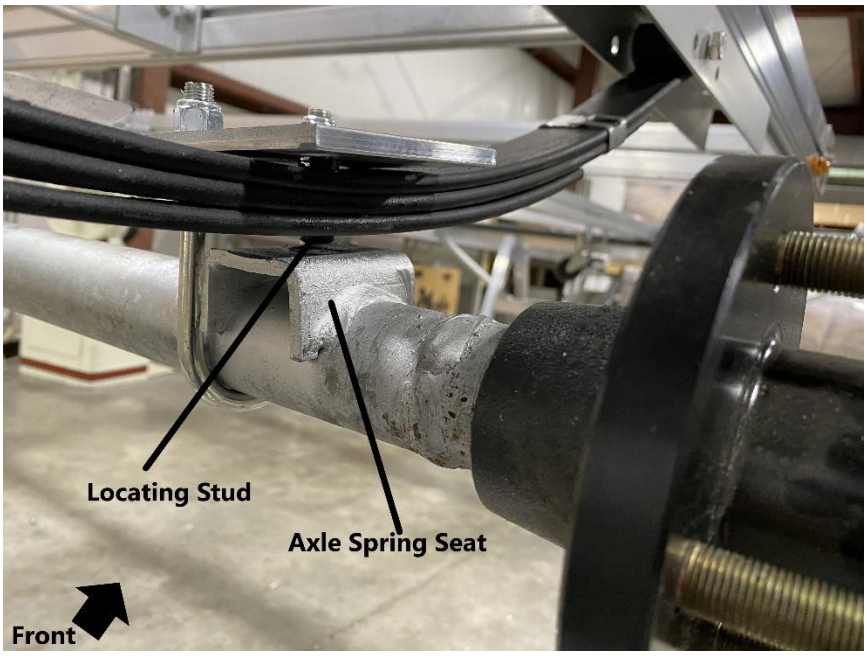
Locate the axle and u-bolt kit.



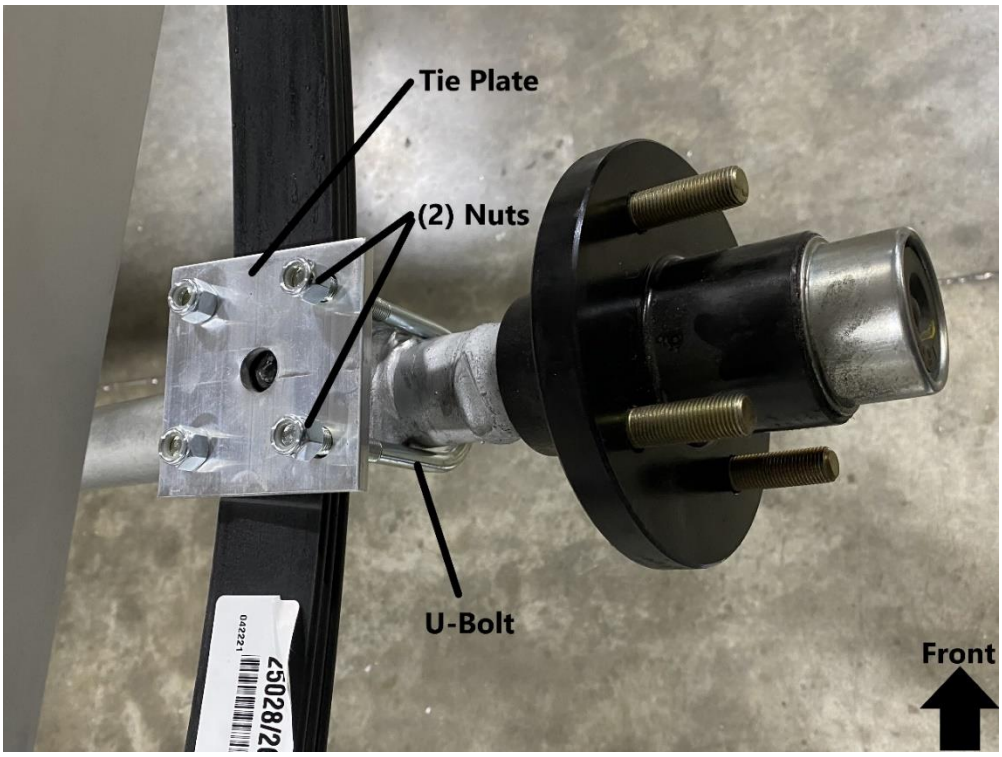
Install the Tie Plate and U-Bolt to the axle as shown. Replace the (2) nuts but do not tighten yet.



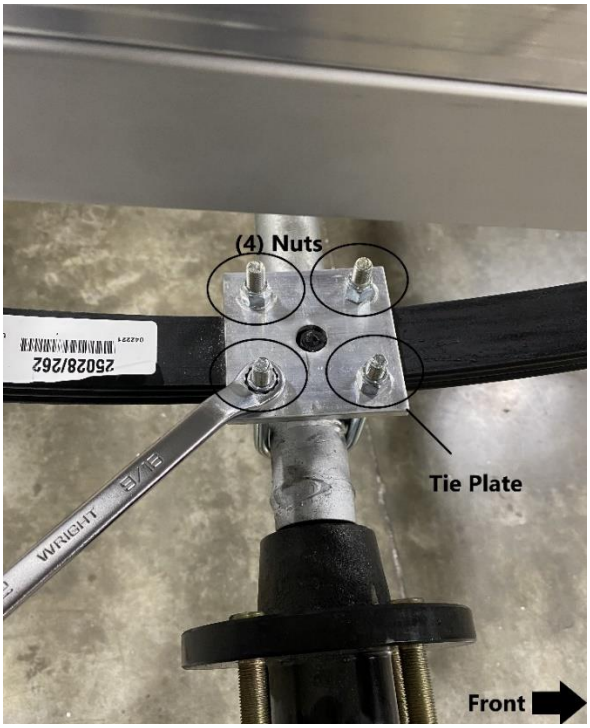
Install the axle to the leaf spring as shown. Slide the tie plate over the leaf spring until the center hole of the tie plate lines up with the locating stud of the leaf spring.



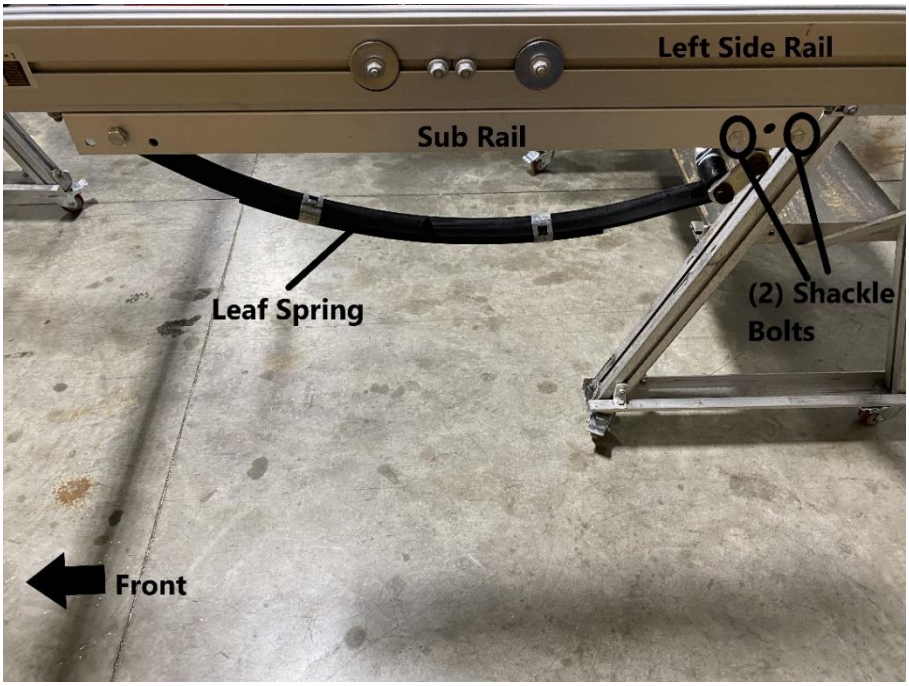
Place the locating stud of the leaf spring into the axle spring seat.



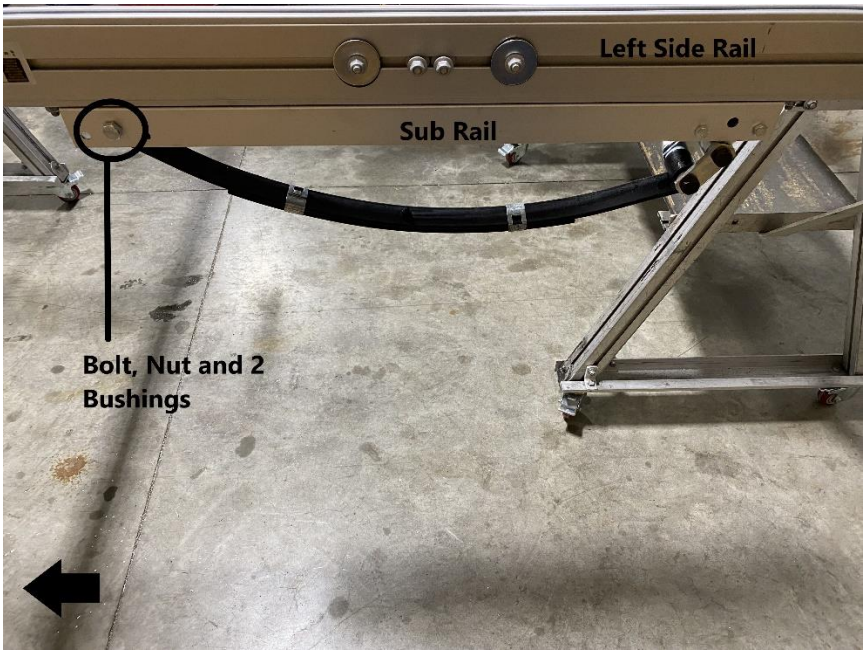
Install the second U-Bolt to the tie plate as shown. Replace the (2) nuts but do not tighten yet. Repeat this process to mount the axle to the leaf spring on the other side of the trailer.



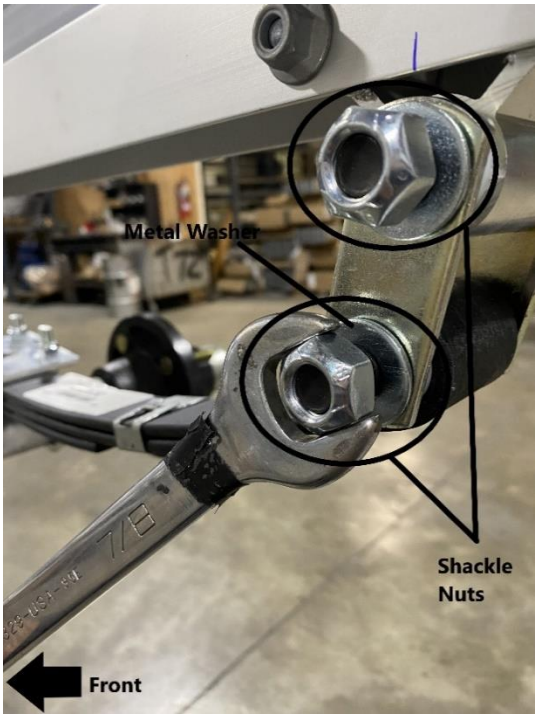
Use a cross pattern to tighten the (4) nuts using a 9/16” wrench. Repeat this process for the other side.



With the axle now installed, the bolts of the leaf spring will now need to be tightened. Tighten the (2) bolts shown using a 9/16” ratchet and wrench. Repeat this process for the other side.

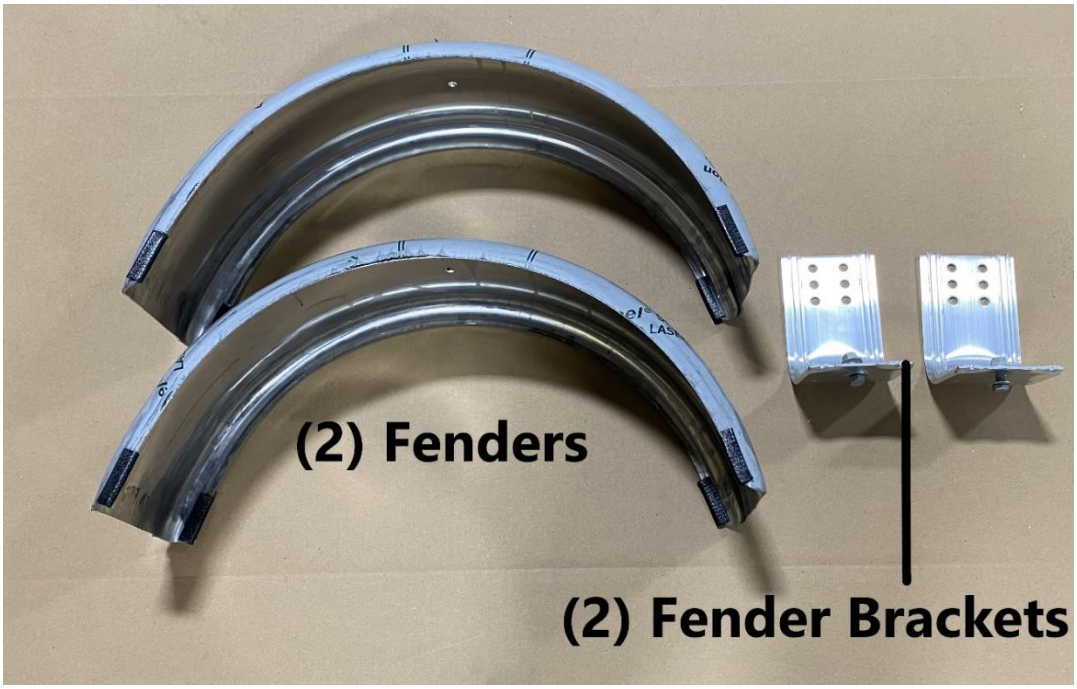


Tighten the bolt shown using a ¾" ratchet and wrench. Repeat this process for the other side.



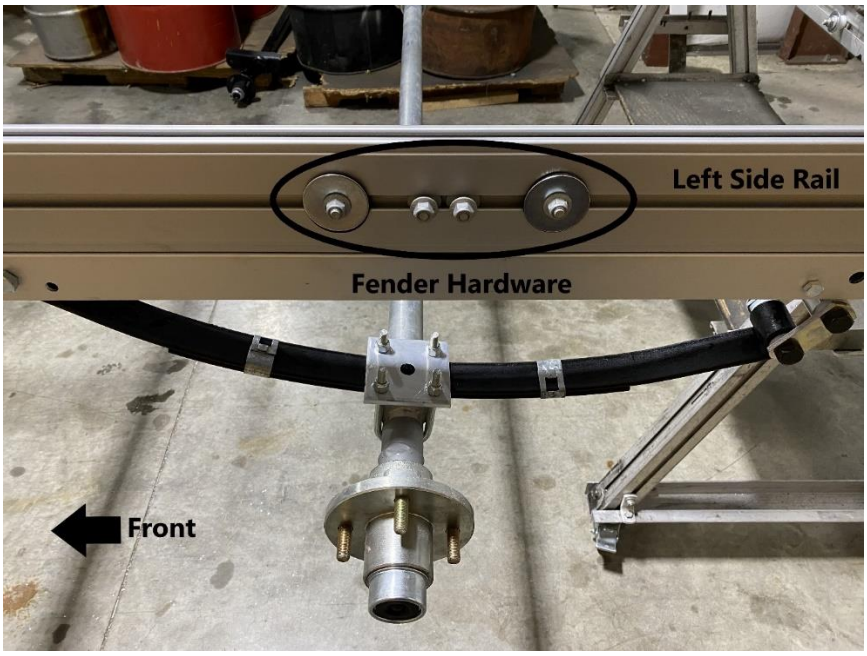
Tighten the rear shackle nuts with 7/8" ratchet and wrench. Tighten the nuts until the metal washers can no longer move. However, do not over tighten as this will not allow the suspension to move properly. Repeat this process for the other side.

Fender installation

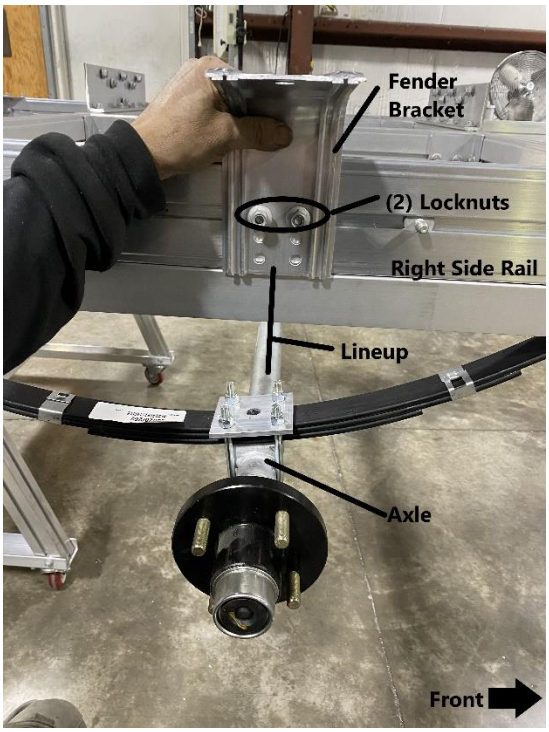


Locate the (2) fenders and (2) fender brackets. Remove the plastic covering from the fenders.

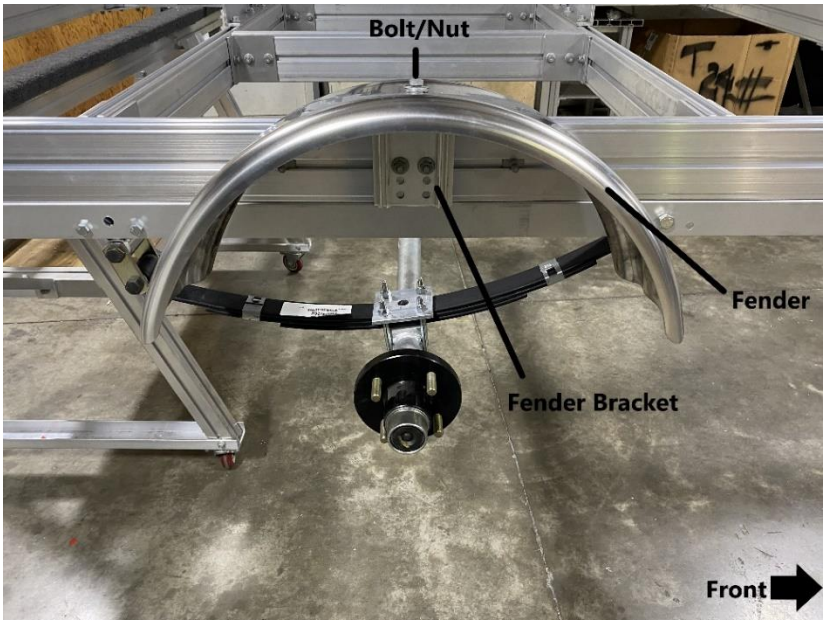
Remove the T-bolt and locknut from both fender brackets.



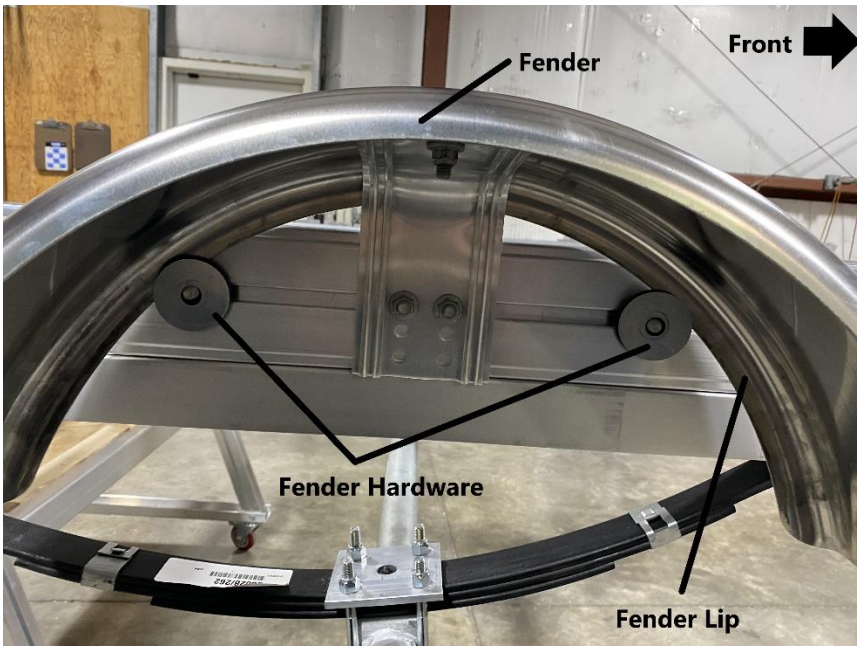
Remove all the hardware from the right side rail using a 9/16” wrench. This will leave 4 T-Bolts in the right side rail.



Install the fender bracket to the right side rail as shown. Use the (2) center T-bolts to install the fender bracket to the right side rail. Lineup the center of the fender bracket to the axle. Replace the locknuts and tighten using a 9/16” wrench.

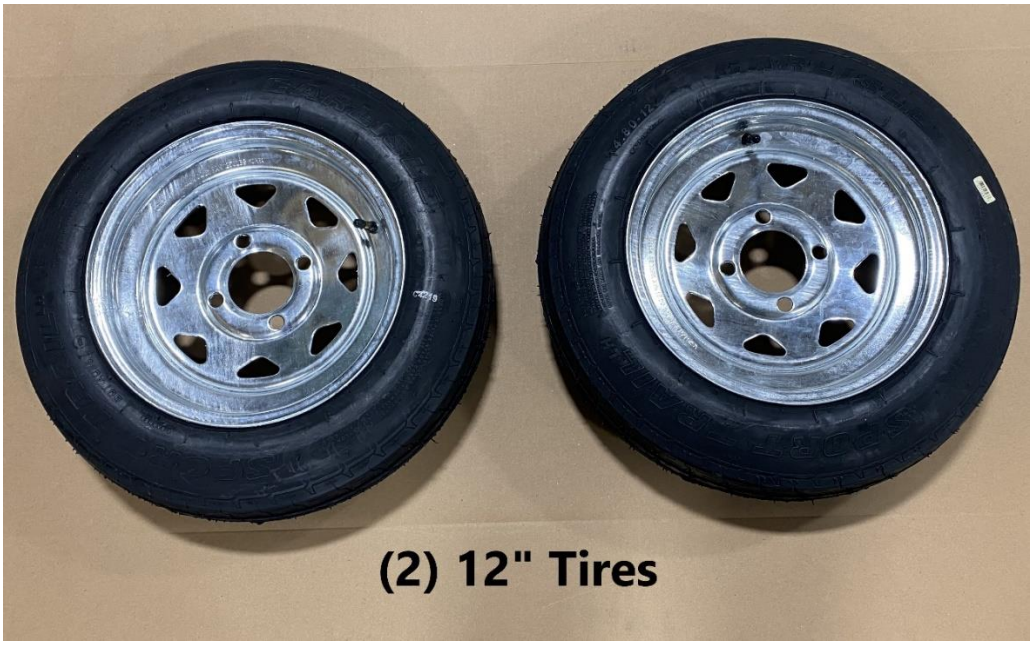


Install the fender to the fender bracket as shown. Replace the bolt and nut that was previously installed on the fender bracket. Tighten using a 9/16" wrench. Do no overtighten as this will damage the fender.

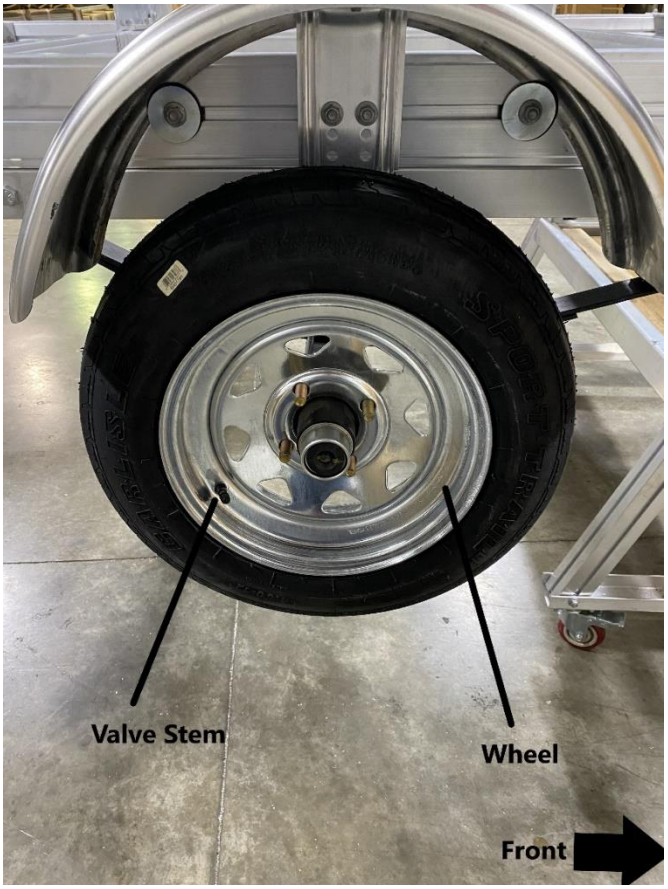


Install the fender hardware as shown, placing a rubber washer behind the fender lip, then a metal washer and locknut in front of the fender lip. Tighten the locknut using a 9/16" wrench. Repeat this process to install both fenders.

Wheels



Locate (2) 12” tires.

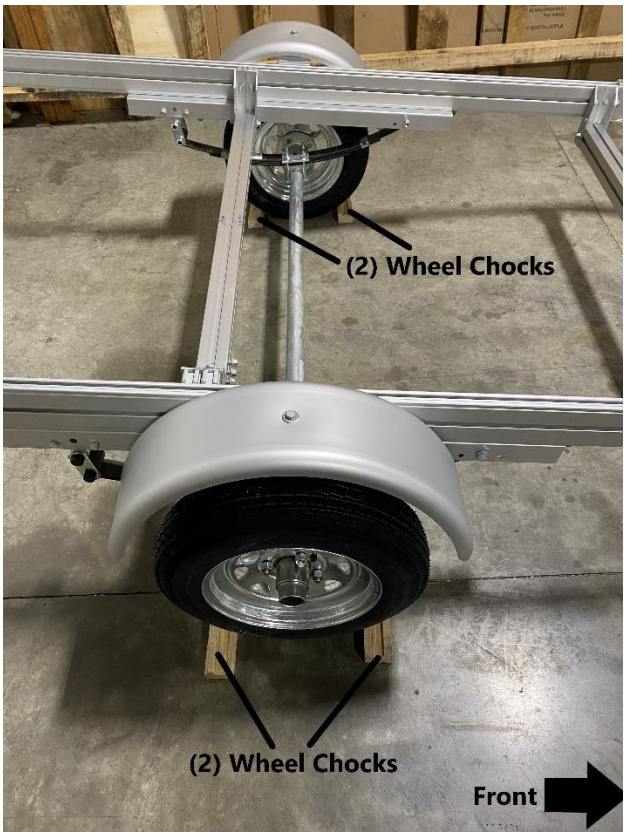


Install the wheels with the valve stems facing out.

Locate the (8) lug nuts found in the U-Bolt kit.

Install the lug nuts with the tapered side facing the wheel.

The trailer can now be removed from the saw horses. At least two people will be necessary.

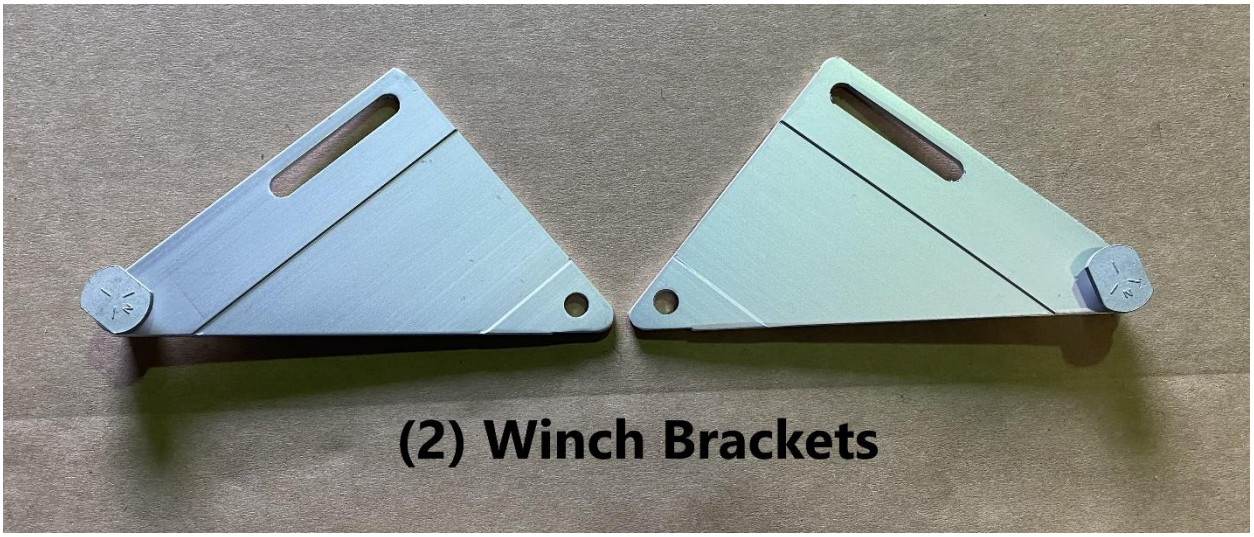


Place (4) wheel chocks as shown, (2) on each tire.

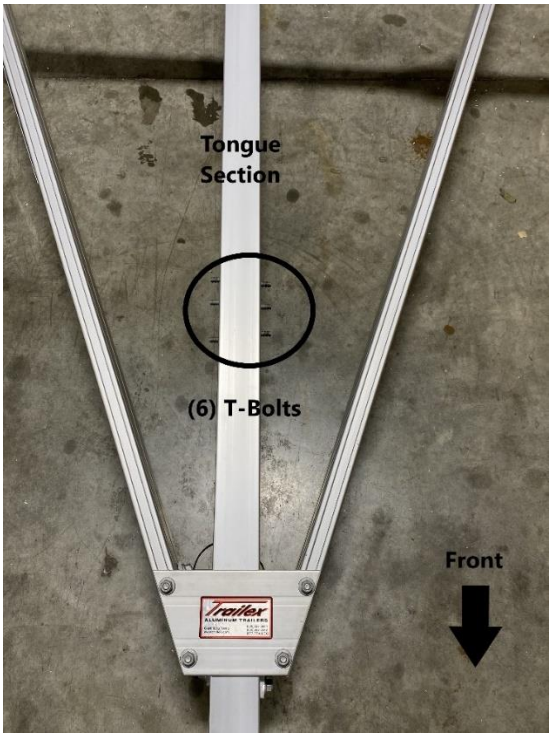
Torque the lug nuts to 80 foot pounds using a X pattern. Repeat the process for the other tire. Note that after 20 miles the lug nuts will need to be re-torqued to 80 foot pounds.

Winch Stand Installation

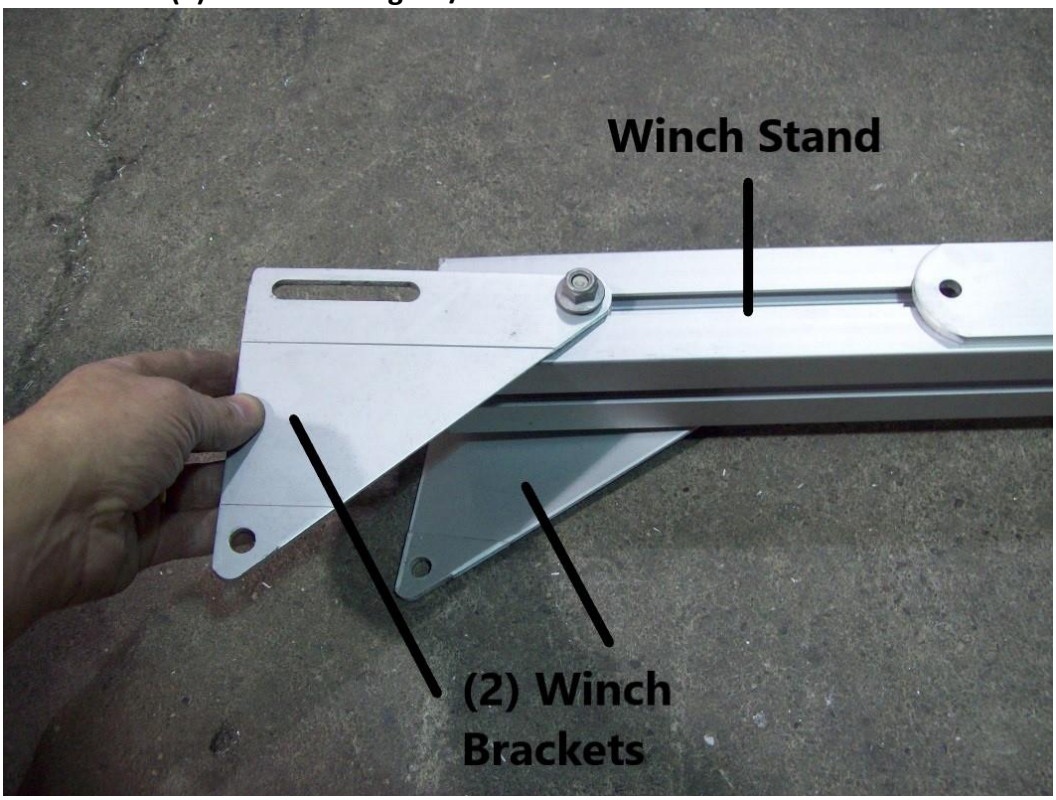
Locate the winch stand.



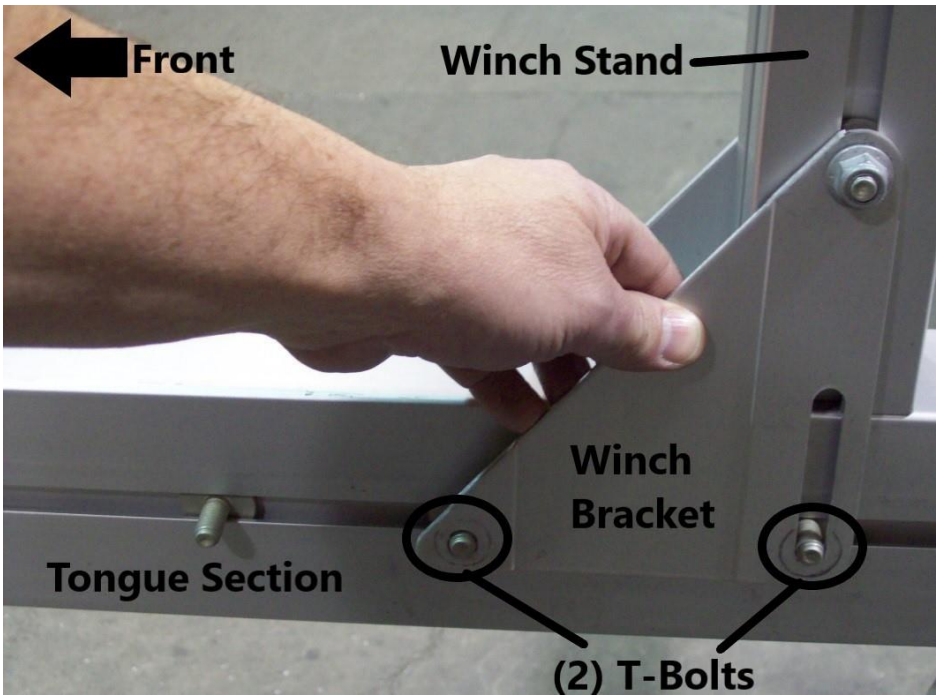
Locate the (2) winch brackets.



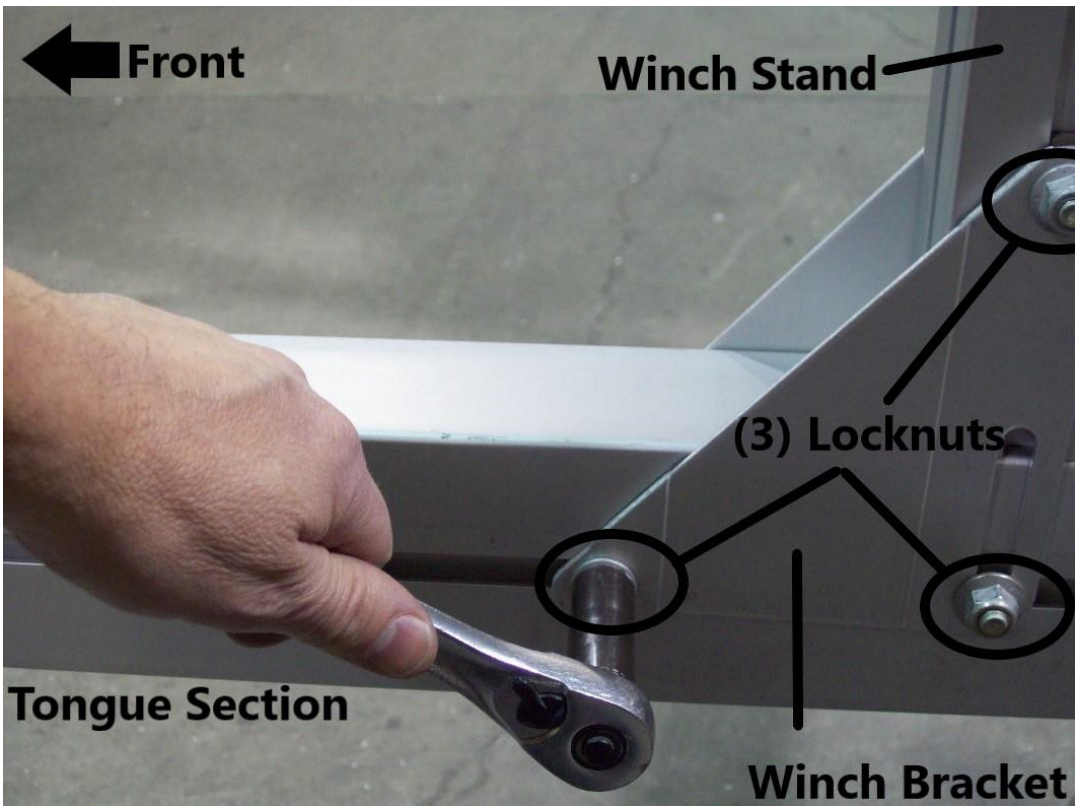
Locate the (6) T-bolts and (6) locknuts installed in the side grooves of the tongue section. Remove the (6) locknuts using a 9/16” wrench.



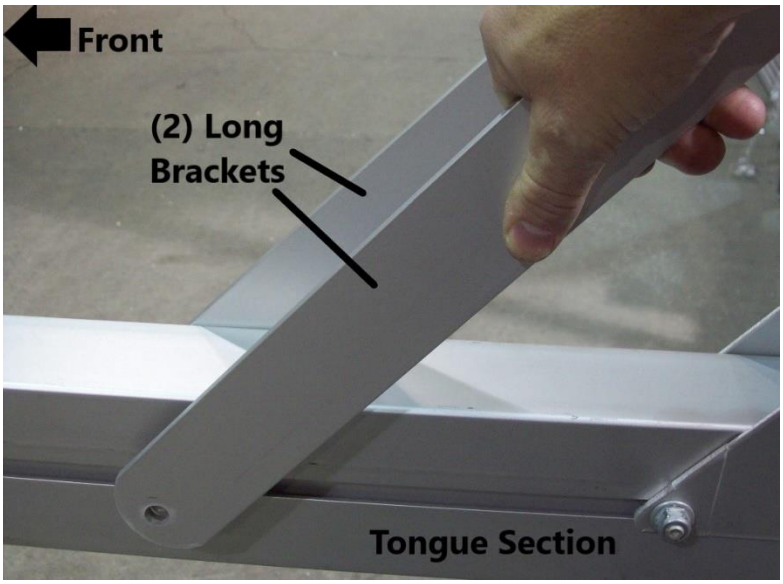
Insert the (2) winch brackets into the bottom of the winch stand as shown. Leave nuts loose at this point.



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



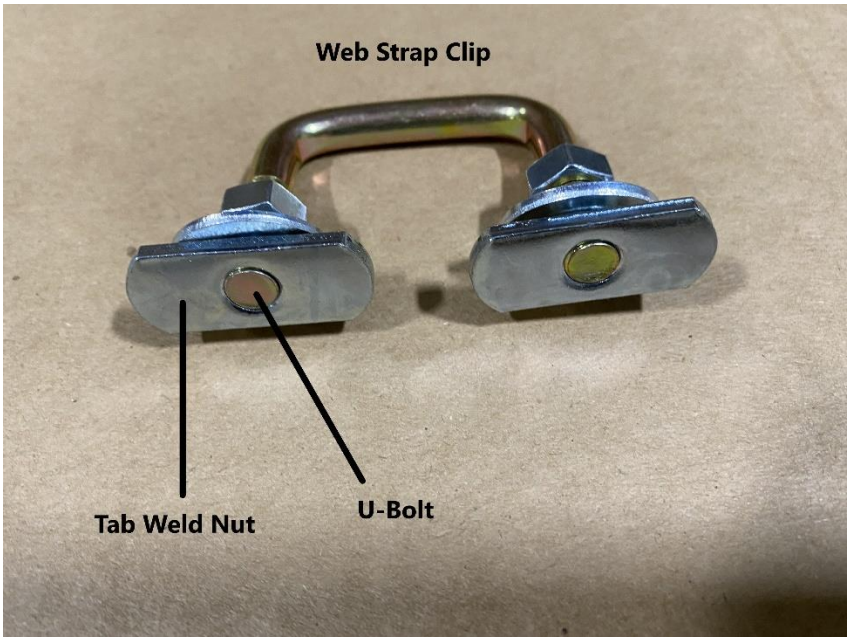
Tighten the (3) locknuts shown using a 9/16” wrench. Repeat this process for the other side. Final adjustments will be made when boat is on the trailer.



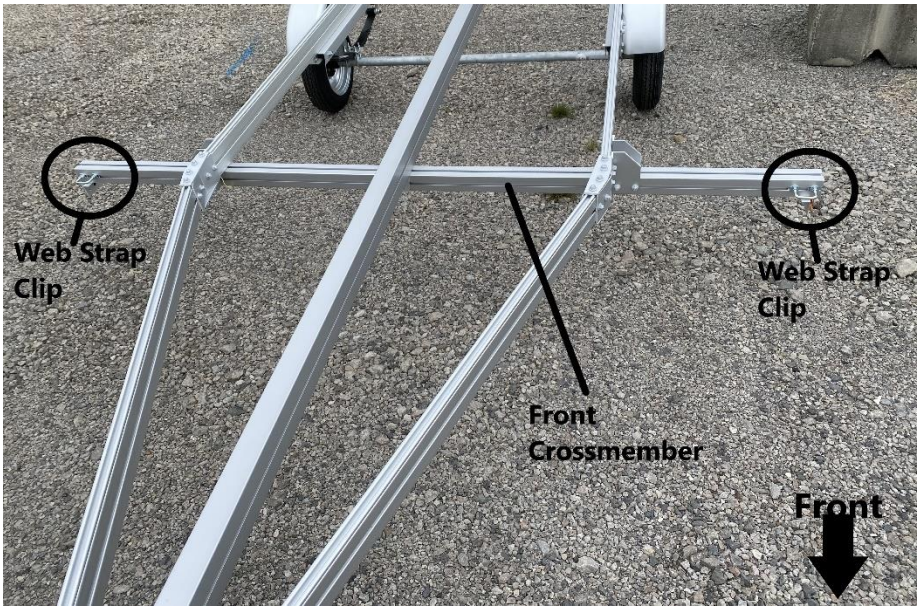
The winch stand will have (2) long brackets installed. Loosen the (2) locknuts holding the (2) long brackets using a 9/16" wrench. This will cause the (2) long brackets to slide down. Install the (2) long brackets on the remaining (2) T-bolts installed on the tongue section. Replace the locknuts and tighten using a 9/16" wrench. Also tighten the (2) locknuts holding the long bracket to the winch stand.

Installation of web strap clips

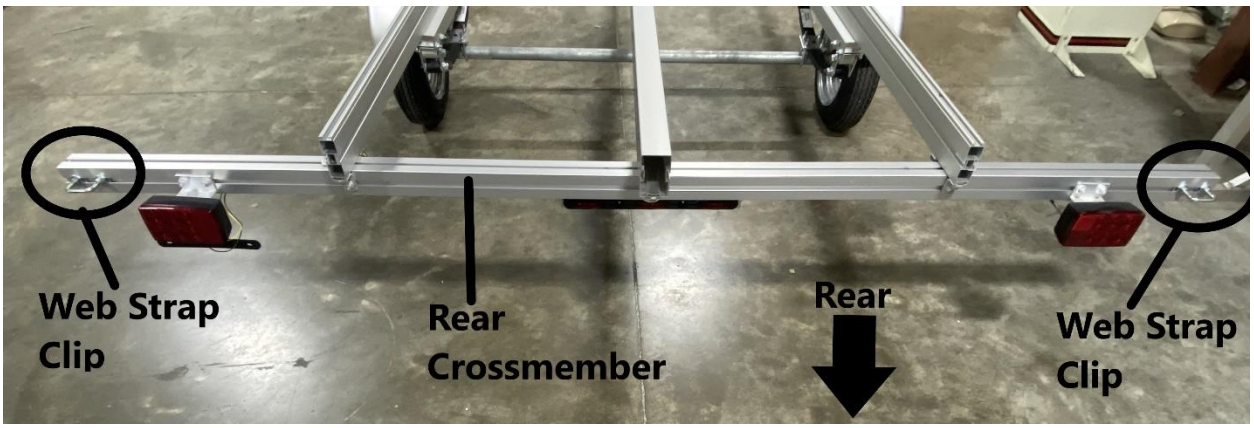
Locate the four web strap clips.



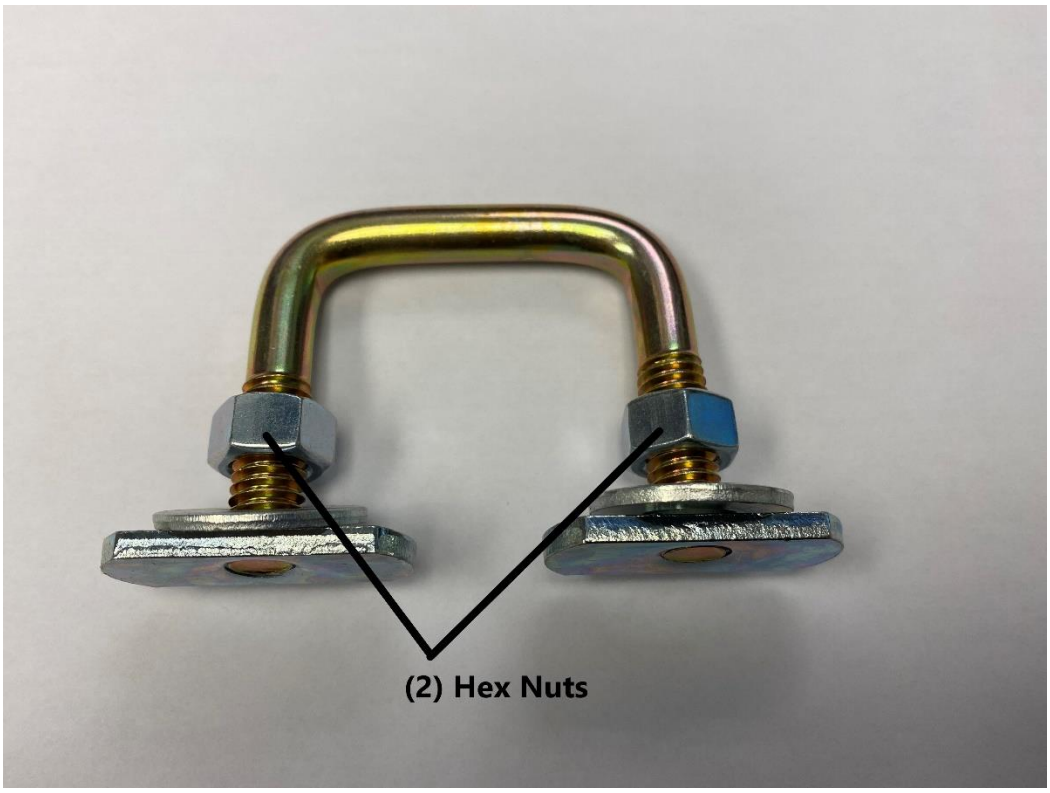
Before installing a web strap clip, make sure that the tab weld nut is flush with the end of the U-bolt.



Install (2) web strap clips to the front crossmember as shown.



Install the remaining (2) web strap clips to the rear crossmember as shown.



Tighten the (2) hex nuts on each web strap clips using a 9/16" wrench. Final position will be determined when the boat is on the trailer.

Finished trailer

The trailer is now assembled. Connect the flat four prong harness to the tow vehicle and confirm that all lights are in working order. Connect the safety cables to the tow vehicle in a crossing pattern. Connect the coupler to the hitch ball and confirm that the size of the coupler matches the hitch ball. Use a lock to confirm the coupler is locked in place. Torque the lug nuts after 20 miles to 80 foot pounds.