

# Flatbed



Complete Kit part # 61 components displayed.

Build up with options: US Style Rear Bumper and Wood Deck When installing the wood deck: Assemble the aluminum deck and side rails according to the instructions. The checker plate deck panel needs to have 3/8" removed from the rear deck area leaving the two small sides intact (see photo). This allows clearance for the tail light housings when using the US style rear bumper #1004. Assemble the rear tandem wheels, tires and axle carrier plates according to the instructions. Now remove the entire assembly with the carrier plates attached to the springs and set aside for reinstallation later. Now install the deck on the chassis upside down temporarily, using two screws. Installing the king pin carrier plate: We recommend that it be slid forward in the chassis until the tapered ramp on the front is slightly past the edge of the deck (see photo). Drill new mounting holes (using an 1/8" or 3mm drill bit) through the aluminum chassis and deck plate using the king pin carrier plate for alignment (see photo). This is best accomplished by drilling one hole and temporarily inserting a bolt to hold it in alignment while drilling the second hole. Disassemble the king pin carrier plate and the deck from the chassis. The two new 3mm holes in the deck plate must now be drilled out to 1/2" to allow the nut on the king pin carrier plate attachment bolts to recess into the deck plate. King pin location: US style would be to mount the king pin into the front hole using the longer bolts supplied with the wood deck kit. At this point you must make a choice, which cannot be easily changed. The large king pin is for Complete Kit and the small king pin is for the professional 5th wheel, #700. When the wood deck is glued in place you cannot get at the nut to change this. Your other option is to install the king pin in the center hole which will retain the nut and allow you to change king pins at anytime. Reassemble the chassis, the deck plate upside down to the chassis. Now install the wiring according to the instructions and our photo and finish installing the king pin carrier plate. Installing #1004 US Style Rear Bumper: Use #130 as seen on page 4, Illustration Bild 4.1. The rear bumper mounting angle plate is now mounted to the new US style bumper, short side up to the bumper, and long side into the chassis at the rear. Make any file adjustments as necessary for a good fit. You will now need to drill two new holes through the chassis and deck using the angle mount as a guide (see photo). Finish trailer assembly using the original instructions as necessary, with tail light hookup completed the rear wheel assembly can be reinstalled. This will finish the assembly of the trailer with the rear bumper. It may now be turned upright and install the wood deck as per instructions supplied with the deck kit # 1012.

# Photo Captions

## Flatbed Assembly

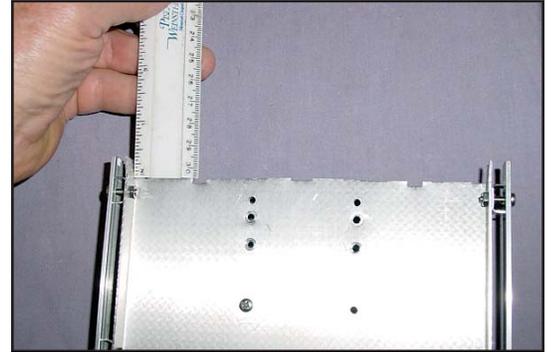
### Step 1

Apply safety tape to side rails and install on deck



### Step 2

Cut 3/8" from rear of deck leaving sides



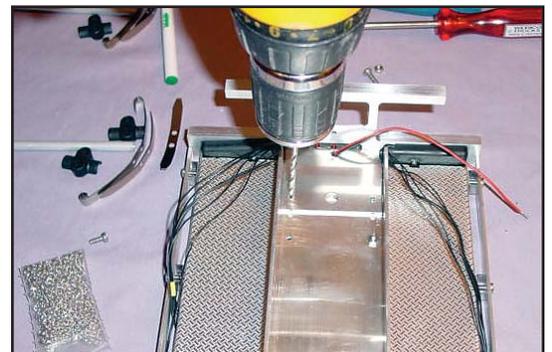
### Step 3

Assemble the new US style rear bumper. Note the position of the mounting plate. (Complete Kit part # 130, illustration 4.1, page 4) You may need to drill a hole for the LED wires. Note the color code shrink tubing on the light bulb leads. Red-break, White-tail, and yellow for turn. You may purchase shrink tubing at Radio Shack or supplied from the pro-builders kit, part # 1200.



### Step 4

Temporarily attach the deck to the chassis and fit the new rear bumper. Use a file to make adjustments for any places that do not fit properly. Using the bumper adapter plate, part # 130 drill the two holes for mounting it through the chassis end deck. Set parts aside the later assembly.



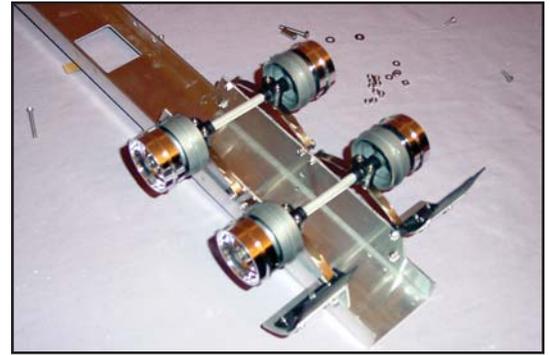
### Step 5

To give the trailer the longer US look slide the king pin carrier plate forward in the chassis till the ramp is extended just past the deck plate. Drill three holes using the carrier plate as a guide through the front and rear mounting holes and the center king pin mounting hole. Hint; drill one hole first and install a bolt then drill the rear hole and then the center hole. Disassemble chassis and deck. The 3 new holes you drilled in the deck need to be enlarged to  $\frac{1}{4}$ ". DO NOT ENLARGE THE THREE NEW HOLES IN THE CHASSIS. Set these parts aside for later use.



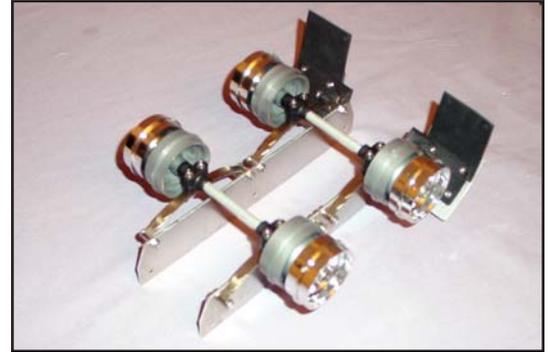
### Step 6

Assemble the rear tandems as per the instructions supplied with the kit, then remove the tandems as a unit by removing the six bolts from the carrier plates, set the tandems aside.



### Step 7

The rear tandems removed as an assembly.



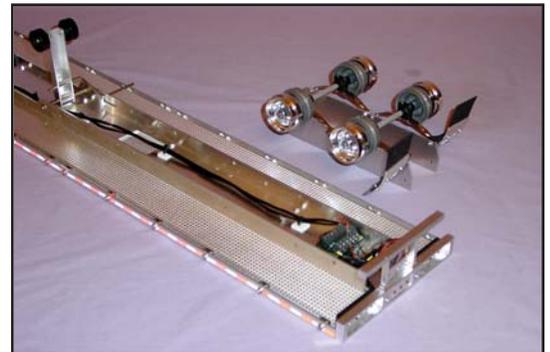
### Step 8

Reassemble the chassis to the deck and the rear bumper. Install the PC board holder and then the PC board into the holder running the wire leads forward. At this point install standard landing gear or optional upgrade part # 424, not shown. Reinstall the king pin carrier plate in its new location, coil trailer light wires under the king pin plate as needed, see Complete Kit instructions. As this point you must make two decision, first to use the Complete Kit king pin (large) for plastic 5th wheel or the Pro king pin (small) for the aluminum 5th wheel part #700. Second decision is king pin location; in the standard center hole or for more set back of the trailer, on the 5th wheel in the front hole. This choice is not changeable after installing the optional wood deck, part# 1012. Next, hook up tail light wires as per instructions in kits (trailer and rear bumper).



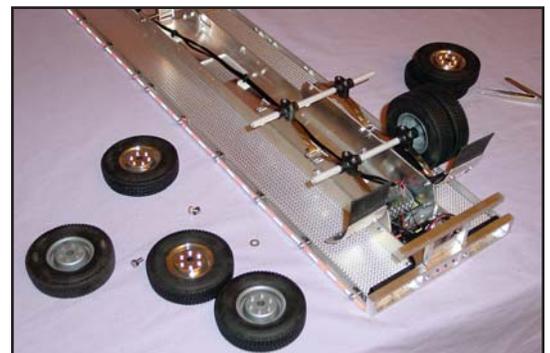
### Step 9

Chassis and deck assembled and wired ready for rear tandems.



### Step 10

Install tandem axle assembly without wheels and tires, then reinstall wheels and tires.



### Step 11

Use silicone sealer glue to install the taillight cover angle.



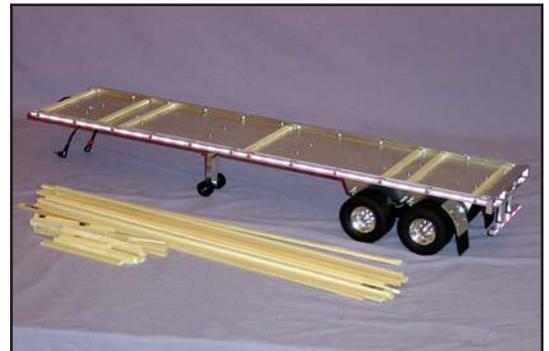
### Step 12

Completed trailer awaiting wood deck with 7 cross bars glued in place.



### Step 13

Flatbed with wood deck kit.



### Step 14

Note notches in side planks to clear side rail bolts. Also see Instructions to establish plank installation. If you wish to stain your planks, this should be done before assembly and allow 12 hours to dry. Do not stain glue side of planks.



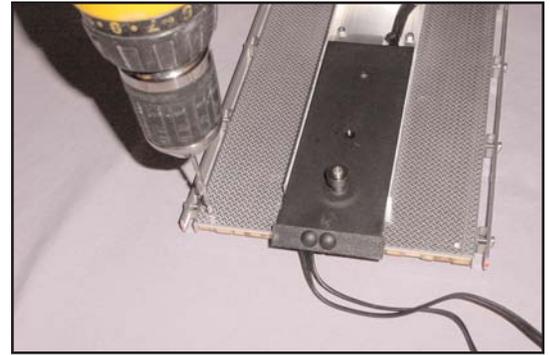
### Step 15

All planks glued in place and front angle waiting for installation.



### Step 16

Install front angle. Drill the two outer boltholes from the bottom of the trailer using an 1/8" bit.



### Step 17

Drill the two inner holes with 1/8" bit only through the wood. Install the two short bolts, these are dummies and may need glue if the wood does not hold secure.



### Step 18

Finish trailer with optional wood deck and US style rear bumper.