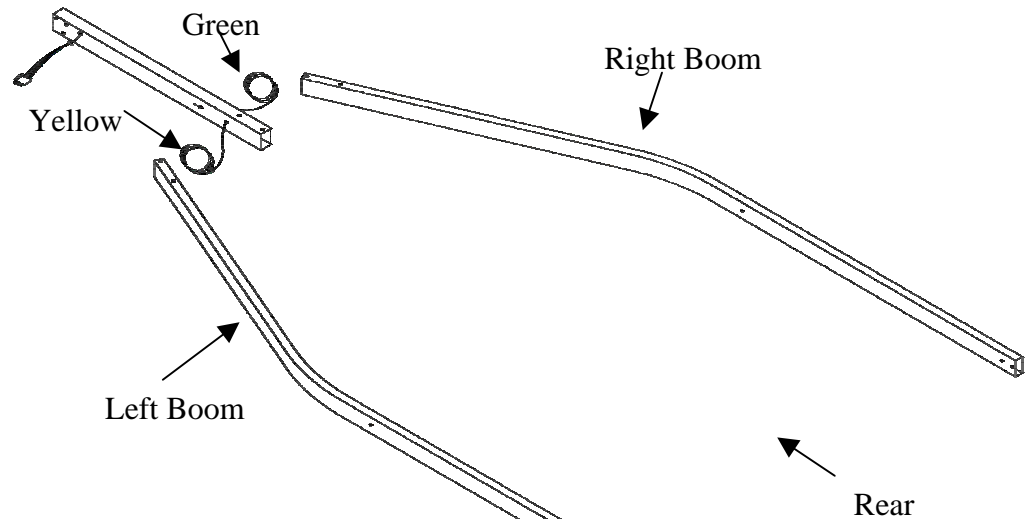


# How to assemble and wire a trailer.

## Wire the Tongue

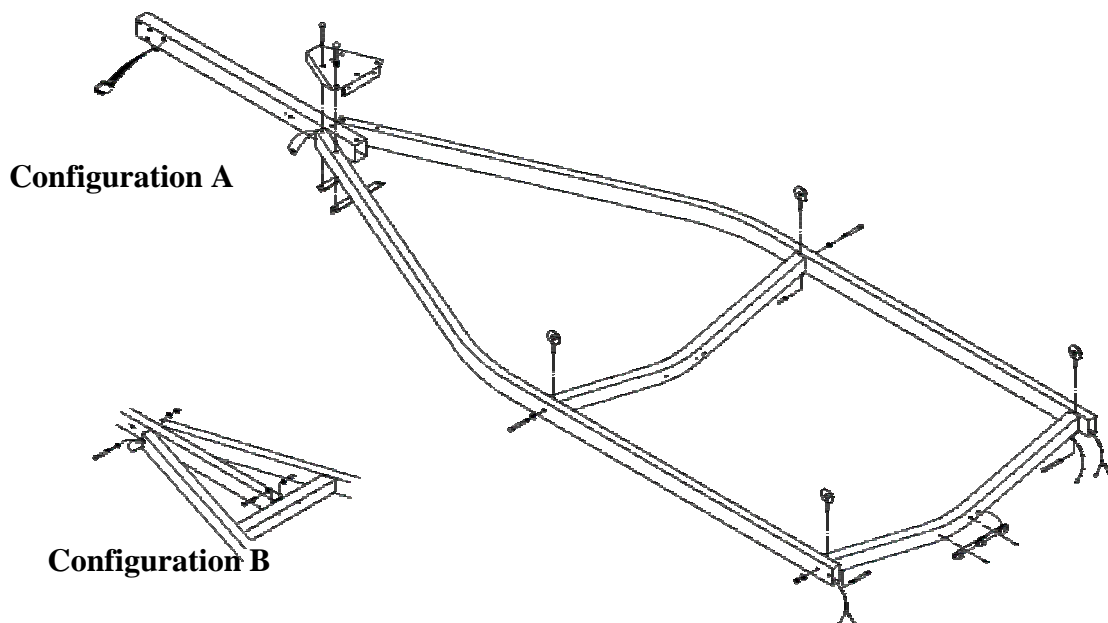
Feed wires through grommets where and when applicable (all holes)

- ◆ Feed the two ends of the wire harness through the large hole in the front, left, side of the tongue. Leaving about 24" of wire hanging out of the hole.
- ◆ Feed the green wire through the hole in the right rear of the tongue.
- ◆ Feed the yellow wire through the hole on the left rear end of the tongue.



## Assemble the Tongue, Booms & Crossmembers

- ◆ There are many types of Boom to Tongue joints, these are the two most common. See figure below.



- ◆ In configuration A, line up the holes in the tongue, boom, boom to tongue plate and mounting straps and place in carriage bolts.

- ◆ In configuration B, line up the holes from the booms through the tongue. To place the bolt through the holes, you will need to move the end of the booms inward to create better access/straight line between the booms and tongue.

Do not tighten the bolts until the crossmembers are in place.

- ◆ Run the green wire down the right boom (passenger side)
- ◆ Run the yellow wire down the left boom (drivers side) leaving the excess wire hanging out the back of the booms.

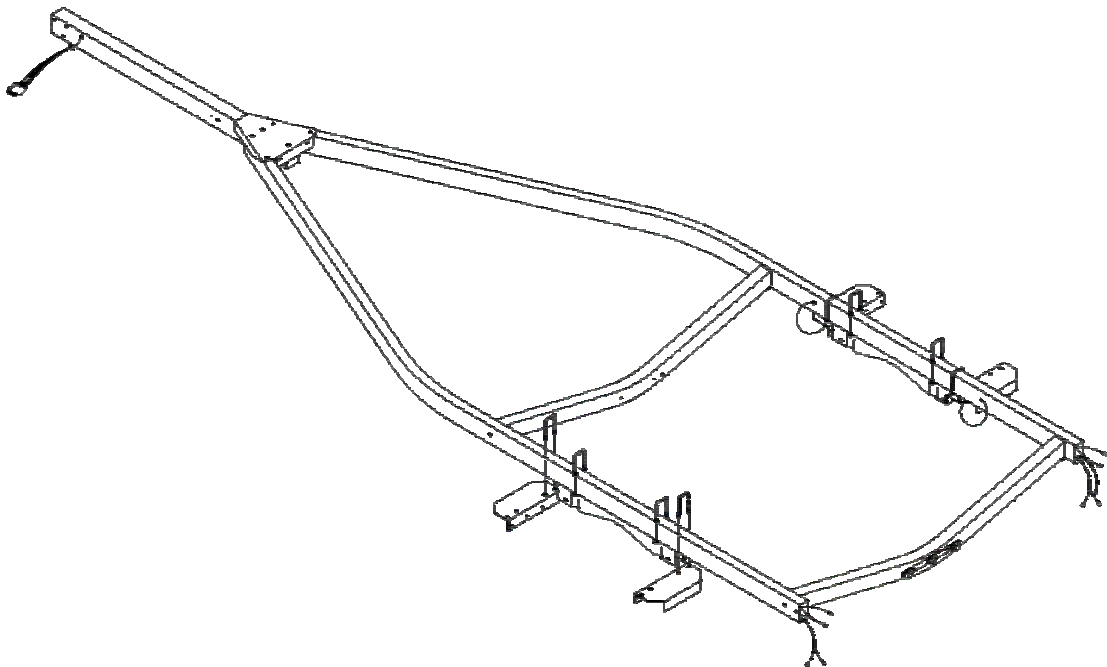
### **Mounting the Crossmembers.**

Note: Before mounting the crossmember, mount and feed the wire for the three light bar when applicable.

- ◆ Now that the booms and tongue are in place. Bolt the crossmembers in place front to back. Note: if this is a bunk application, make sure the crossmember are locked, by placing a bolt or bracket under the crossmember at the boom.

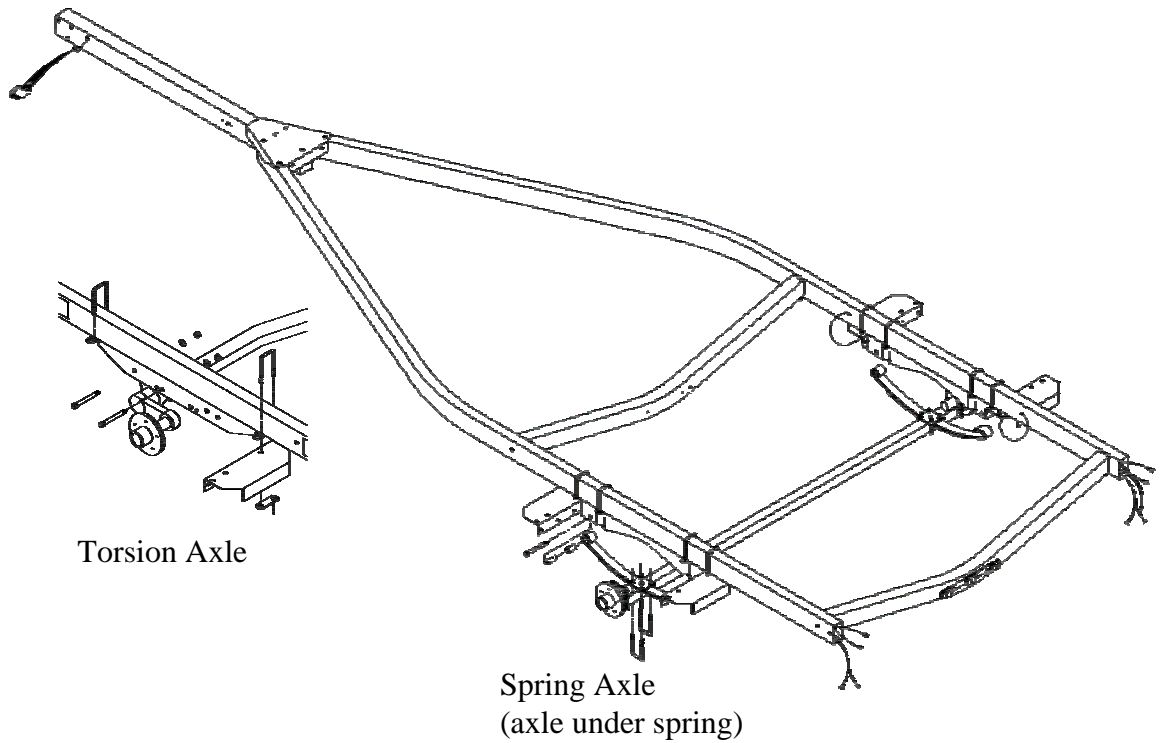
### **Spring/Torsion Hanger and Step Mounting**

- ◆ Place U-Bolts over the boom and mount the Spring/Torsion Hanger under boom.
- ◆ Attach the Steps with U-bolt.
- ◆ Do not tighten U-bolts until springs are mounted to the hangers.
- ◆ Feed the wire for the four clearance light to the back of the booms, where applicable. (Amber lights on the front of steps, red light on the rear.)



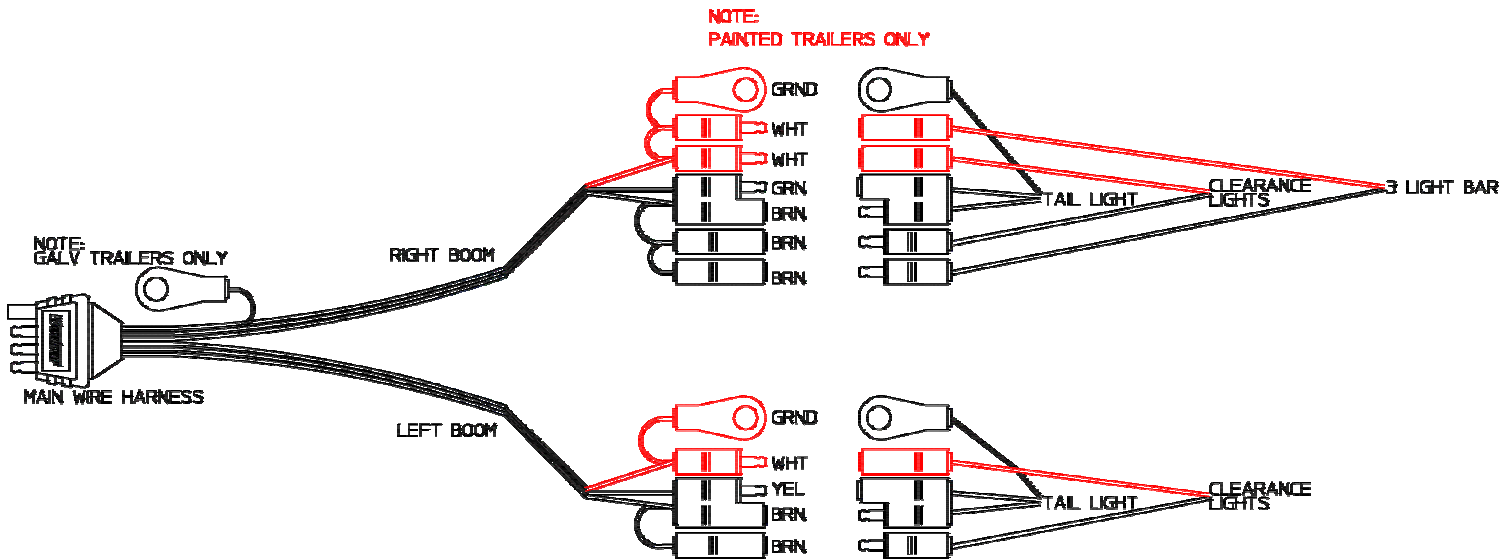
## Mounting Spring/Torsion Axle

- ◆ Mounting a spring axle where the axle is mounted on top of the spring. Mount the springs to the axle, then mount the springs/axle to the spring hangers on the trailer.
- ◆ Mounting a spring axle where the axle is mounted under the spring. Mount the springs to the spring hangers on the trailer, then mount the axle to the springs.
- ◆ Mounting a torsion axle. Mount the axle, by matching the forward hole of the torsion axle with the forward hole of the torsion hanger, place bolt, and then rotate the axle so that the rear holes on the torsion axle matches rear holes in the torsion hanger place the bolt.



## How to Connect the Wires and Taillights

- ◆ Now that the wires (main wire harness, clearance lights and 3 light bar) pulled to the back of the boom, we need to connect them to the taillights. See figure below.
- ◆ The white ground wires, indicated here in red, are available on painted trailers only.
- ◆ After connecting all of the plugs place the two metal ground wire together and on one of the bolts that mount the taillights to the taillight-mounting bracket.
- ◆ Note: The two metal grounds must come in contact with each other and the metal taillight mounting bracket to be grounded.



## How to Wire the Tongue Clearance Lights

- ◆ Now that the taillights are connected and mounted, it is time to wire and mount the tongue clearance lights. With a hook or wire locate the main wire harness in the tongue, through the large hole (approx. Ø.75) on the sides of tongue. Pull about 6" of wire out of the hole. Separate the brown wire from the yellow or green wire. If a painted trailer you must also separate the white wire from the yellow or green.
- ◆ Note: Do not cut the plastic insulation around the wires, thus exposing the wires.
- ◆ Using the scotch lock, crimp the brown wire from the wire harness to the brown wire for the clearance light. Repeat the process for a painted trailer, with the white wire from the wire harness.
- ◆ Feed the other end of the clearance wires through the tongue and out the opposite side. Now plug in both clearance lights, stuff back in excess wire and mount the clearance lights.

