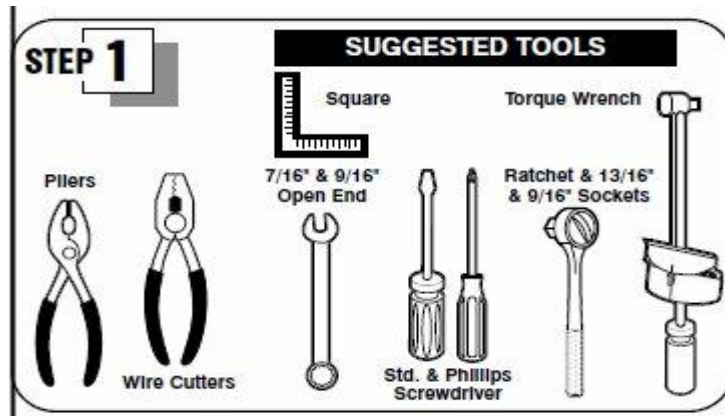


# SUT-250L



## 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.



Side rails, rear cross member, diagonal rails, and tongue section with coupler.



Skid and safety hitch cables.



Axle assembly, springs and U bolt hardware.



Fenders and mounting hardware



Wheels



Hull support rods

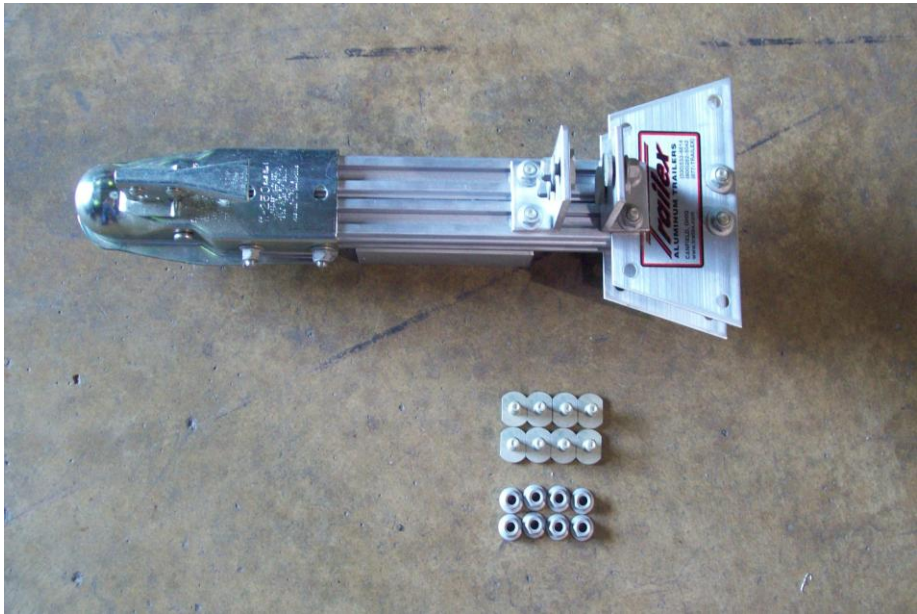


Winch stand post

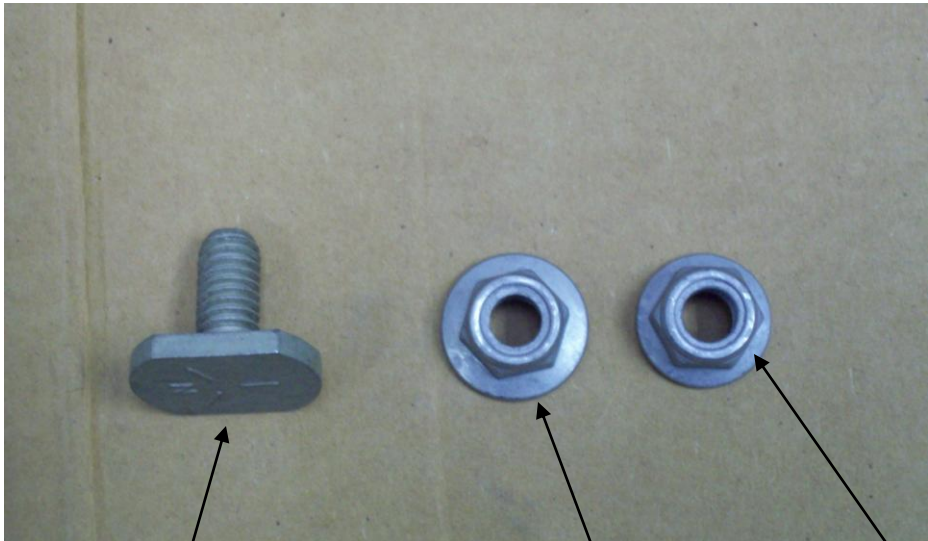


Lights, brackets, harness, and hardware

# Installation of tongue section and side rails



Locate tongue section 8 T-bolts and 8 large flange nuts.



T-bolt

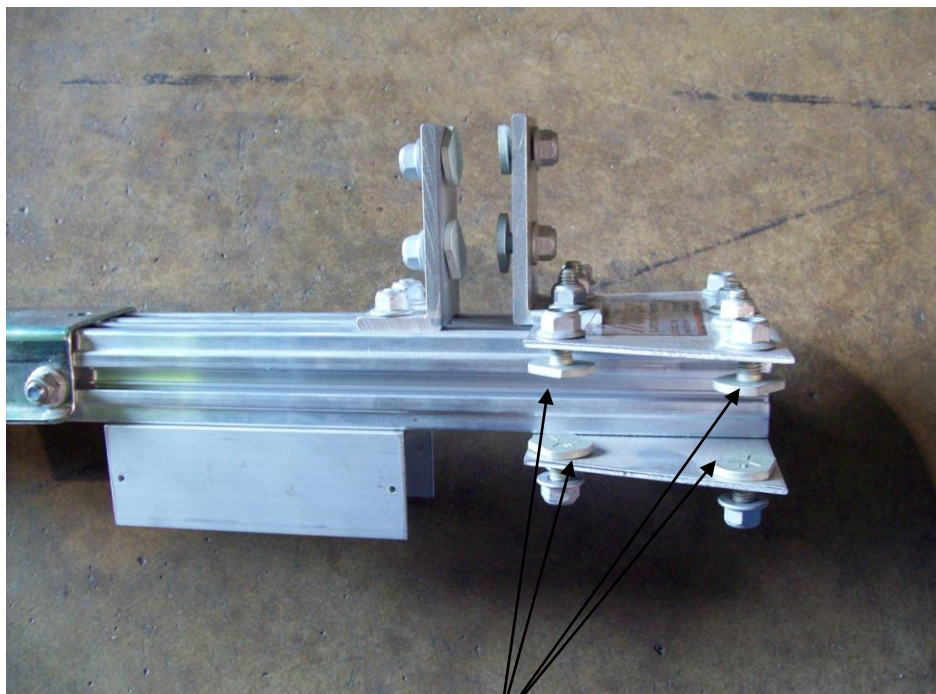
Large flange nut

Small flange nut



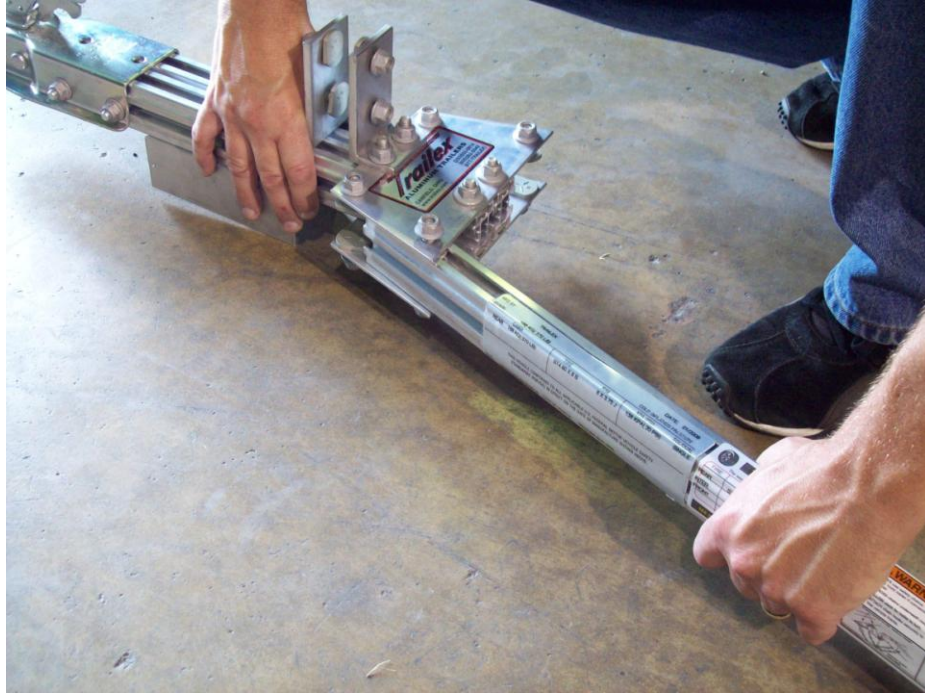
Left front rail

Locate the two front diagonal side rails.

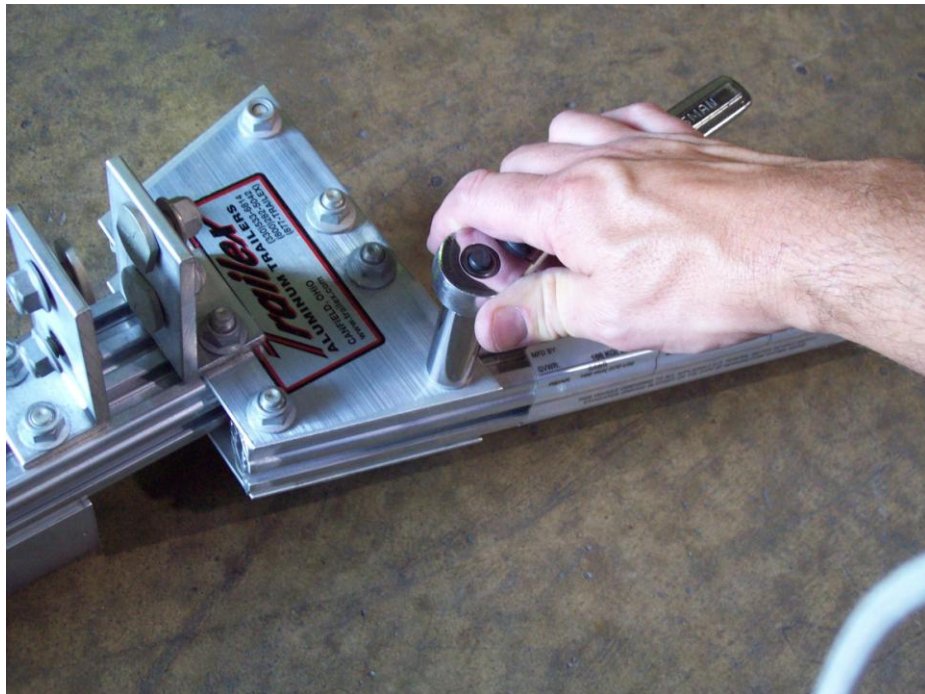


T-bolts and nuts

Install the T-bolts and large flange nuts on the upper and lower apex plate as shown.



Slide left diagonal rail with vin # into T-bolts on apex plate.



Position diagonal rail as shown and tighten nuts.



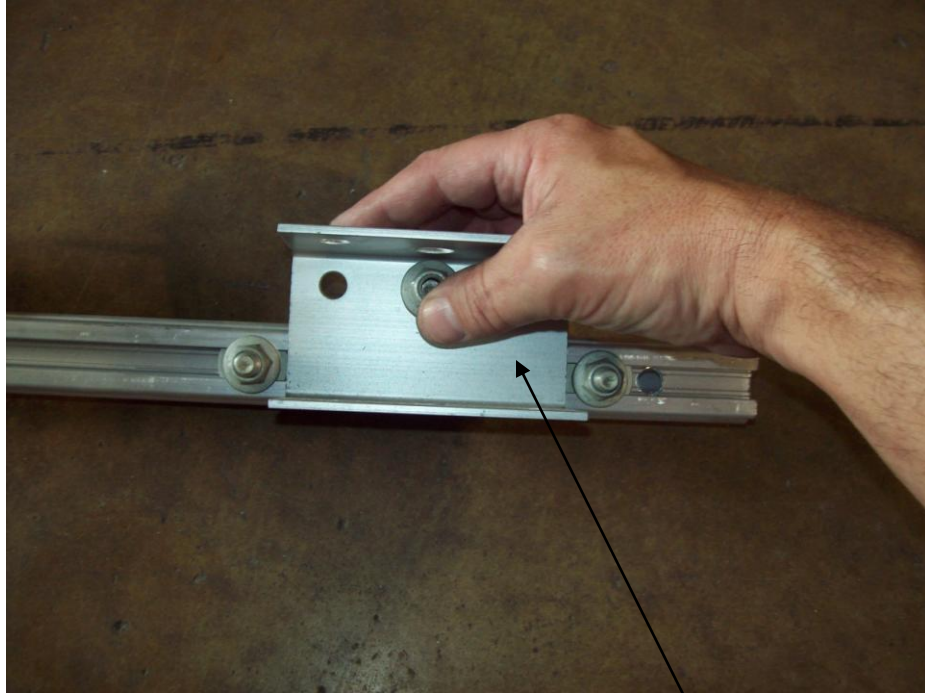




Take T-bolts off the bottom of cross member at both ends.



Install T-bolts in the middle hole on both rear sub rail clips.

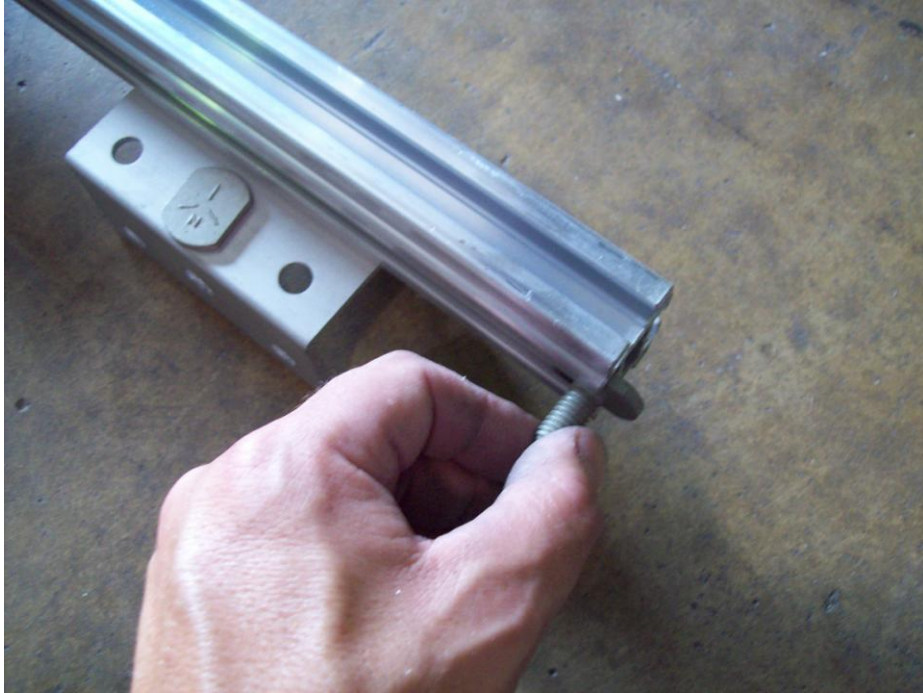


Under side of sub rail clip

Install nuts on T-bolts but do not tighten.



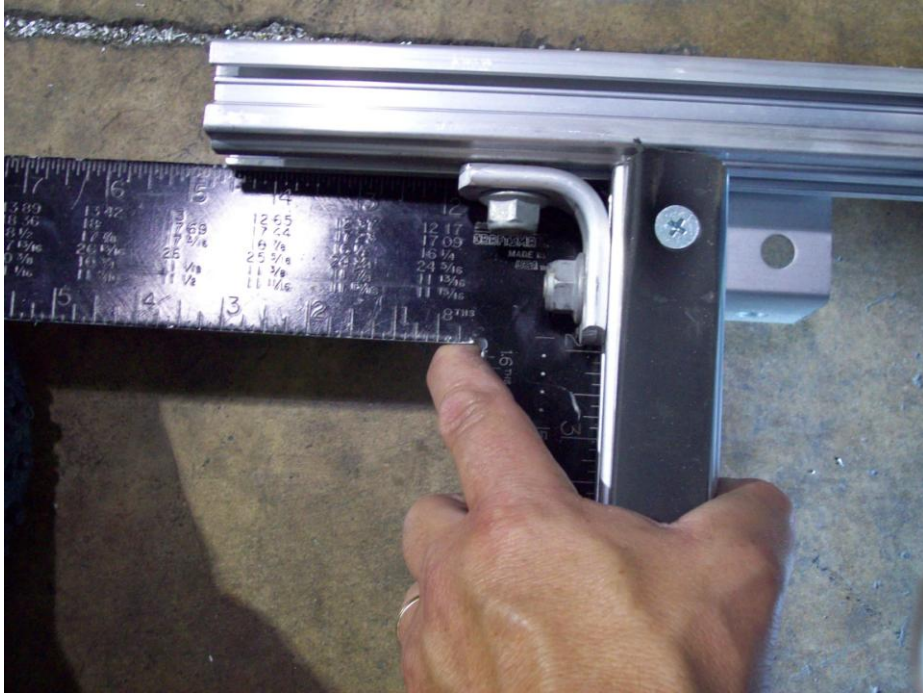
Take T-bolts and nuts off angle bracket on rear cross member.



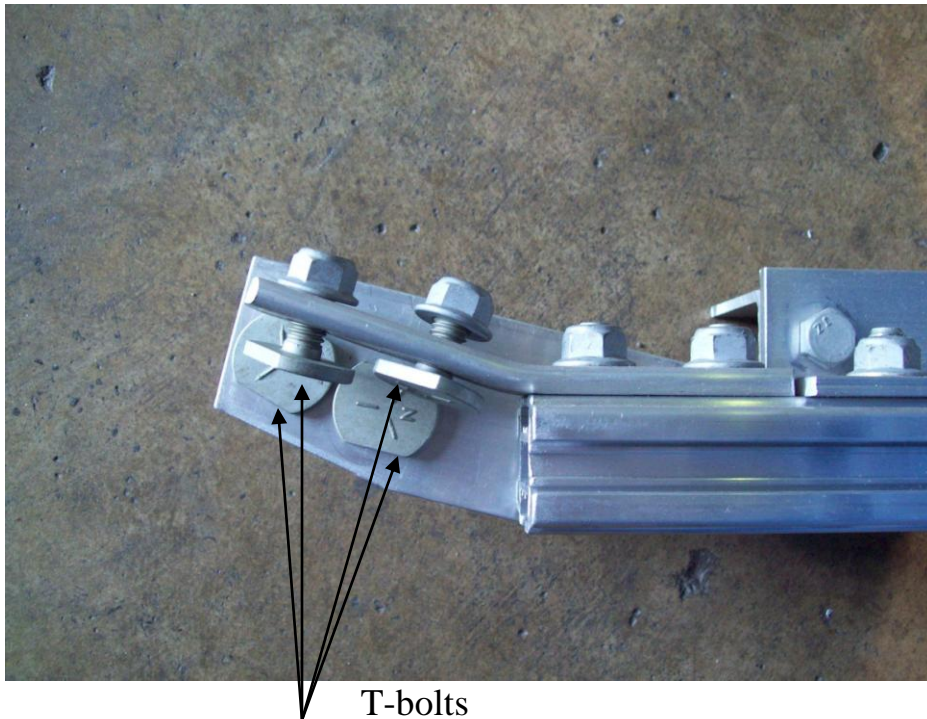
Install T-bolts on the inside of the rear cross member.



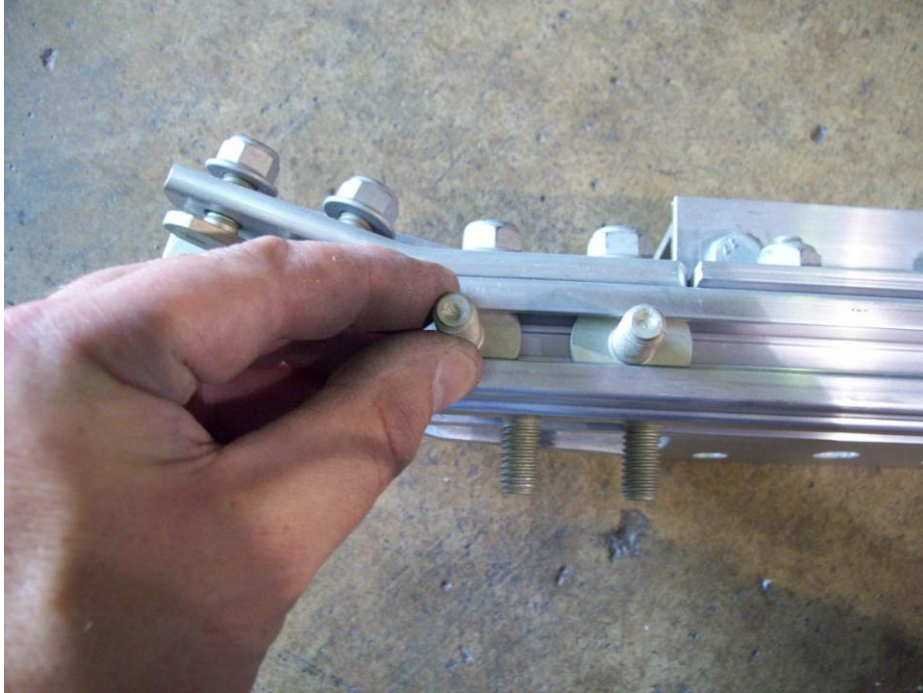
Slide cross member into the T-bolts on the rear side rail. Then repeat the process for other side.



Square up frame and then tighten nuts.



Install T-bolts and nuts in bottom and side plates as shown. Do not tighten nuts at this point.



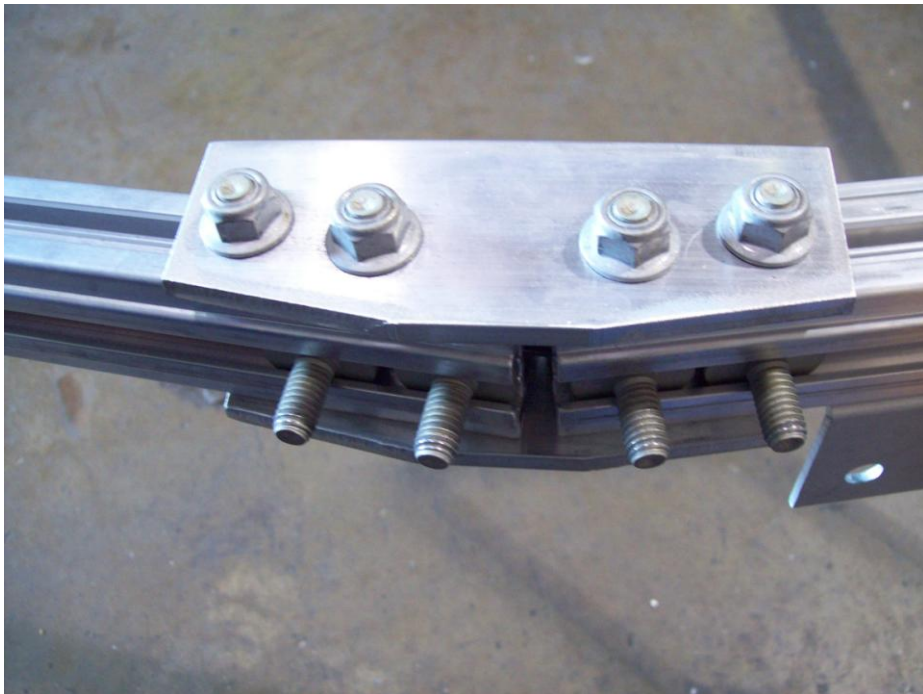
Install two T-bolts on the side and top of the side rail.



Install two T-bolts on the side and top of the rear diagonal rail.



Locate the two top elbow plates.

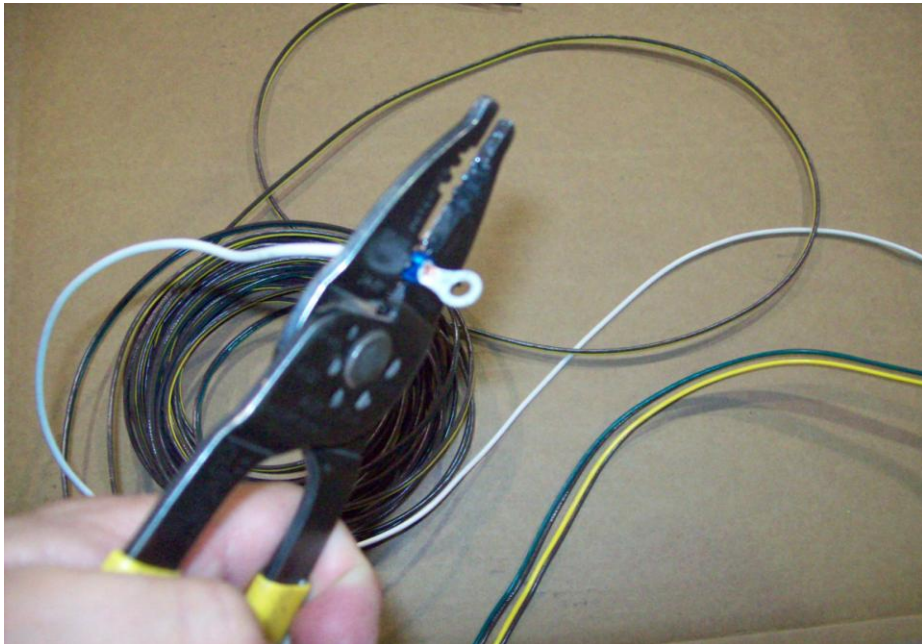


Install the top elbow plates and just snug the nuts down to leave a little movement in the diagonal rails. The nuts will be tightened later in the assembly process.

## Installation of wiring harness

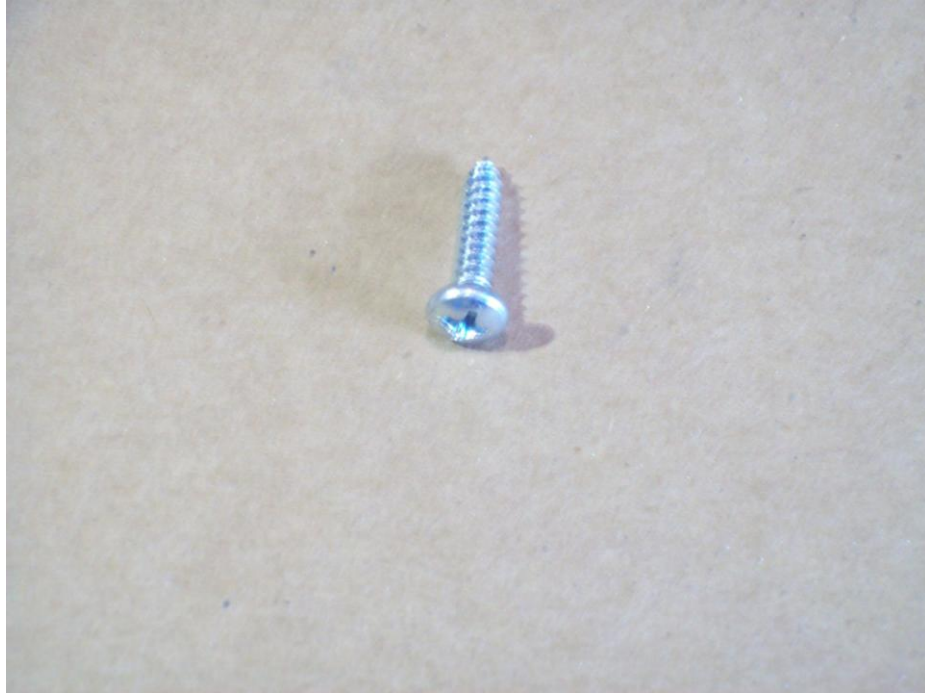


Locate harness and ring terminal.

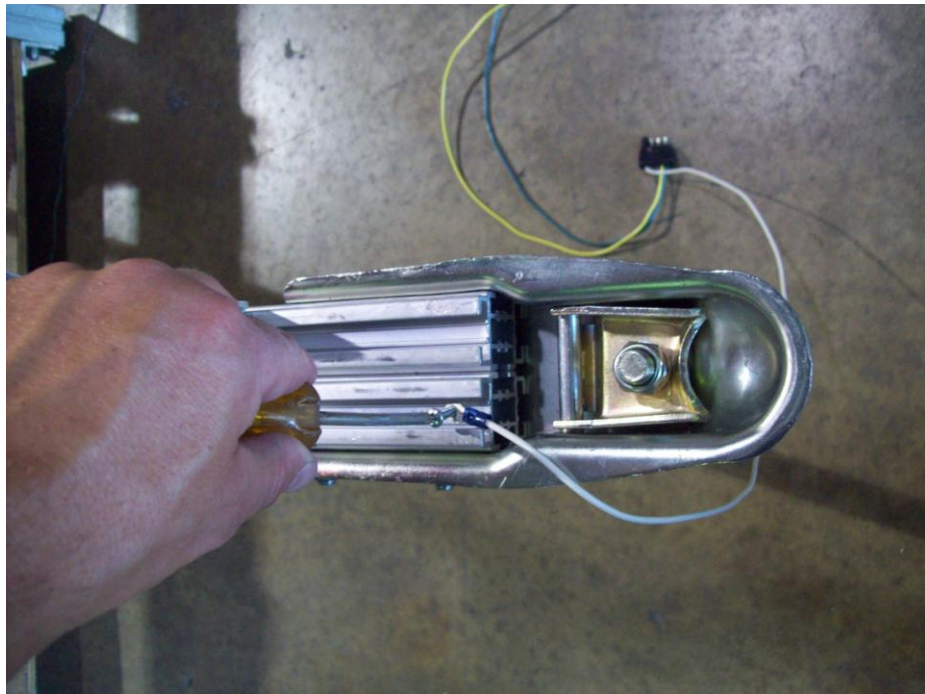


Take the white ground wire and strip a ¼" of the case off and install the ring terminal.

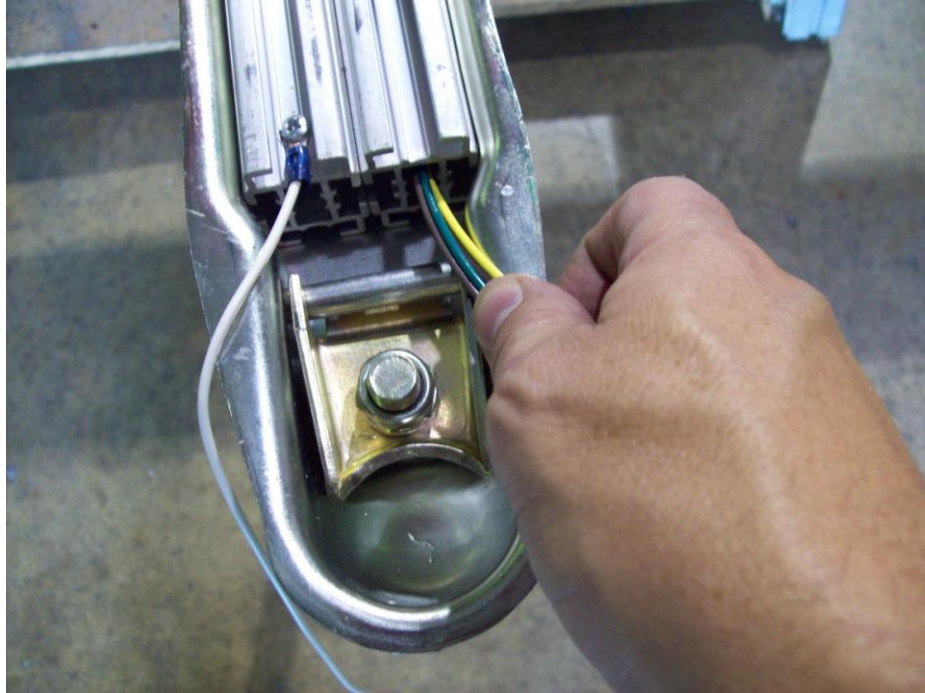




Locate one Phillips screw to install ground wire.



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



Slide harness through the center of the right side extrusion until it comes out the back. Do not slide it through the side with the ground screw in it. Also make sure to keep about 34" of harness in front on the coupler.

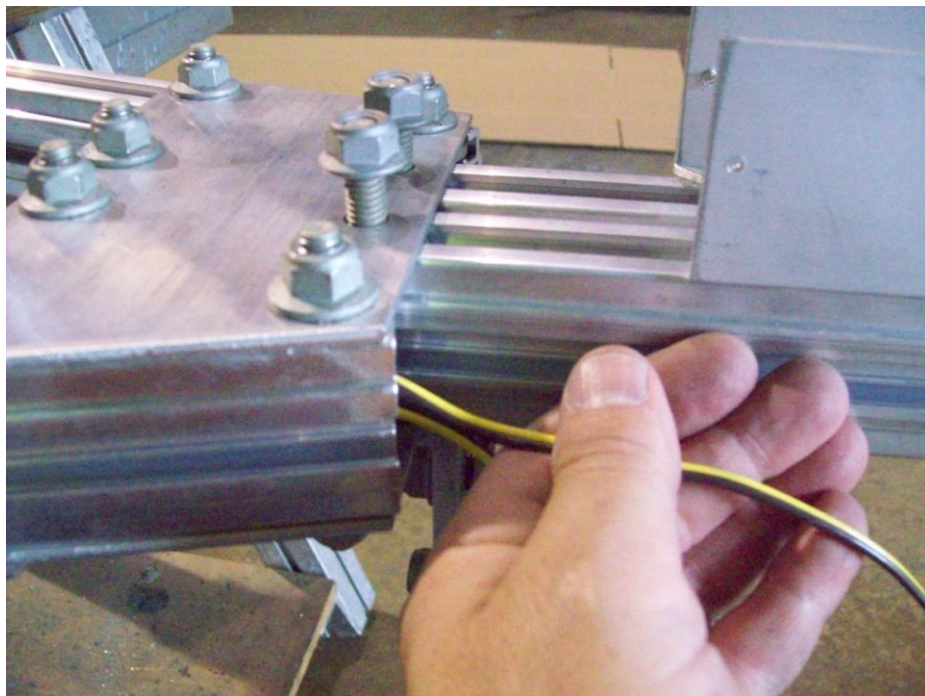


Pull the harness out the back of the extrusion.

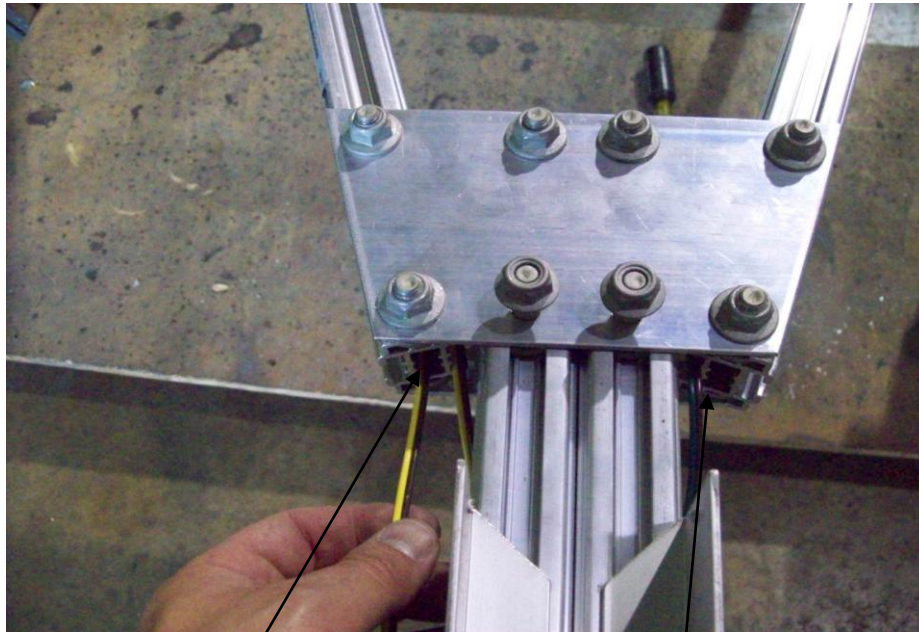


Green & brown      Shown up side down      Yellow & brown

Run the wires back towards the front between the tongue section and the diagonal rails as shown.

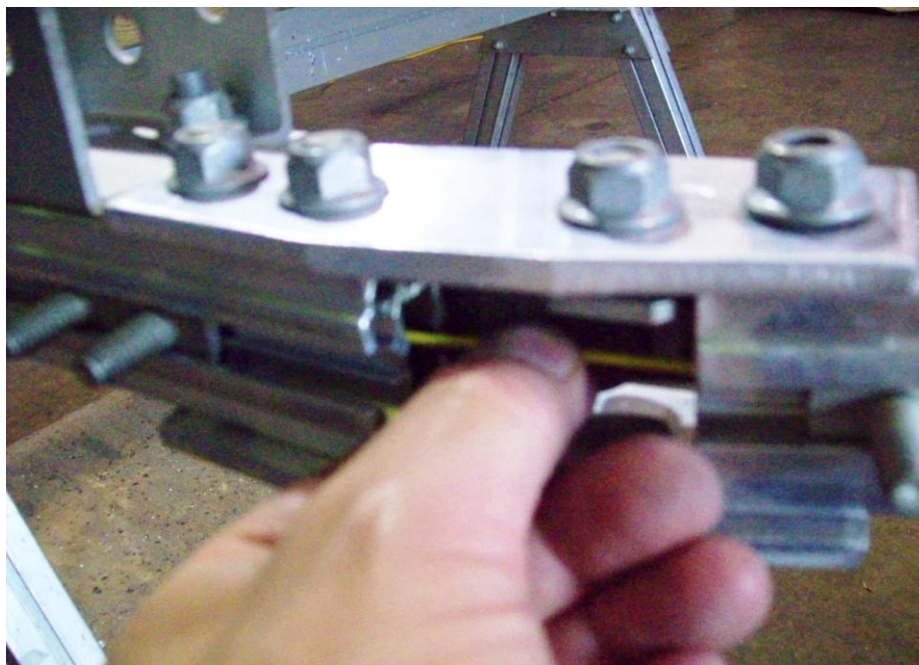


Pull each harness all the way through towards the coupler.



Yellow & brown      Shown up side down      Green & brown

Then slide each harness through the center of the diagonal rails to the elbow plates.

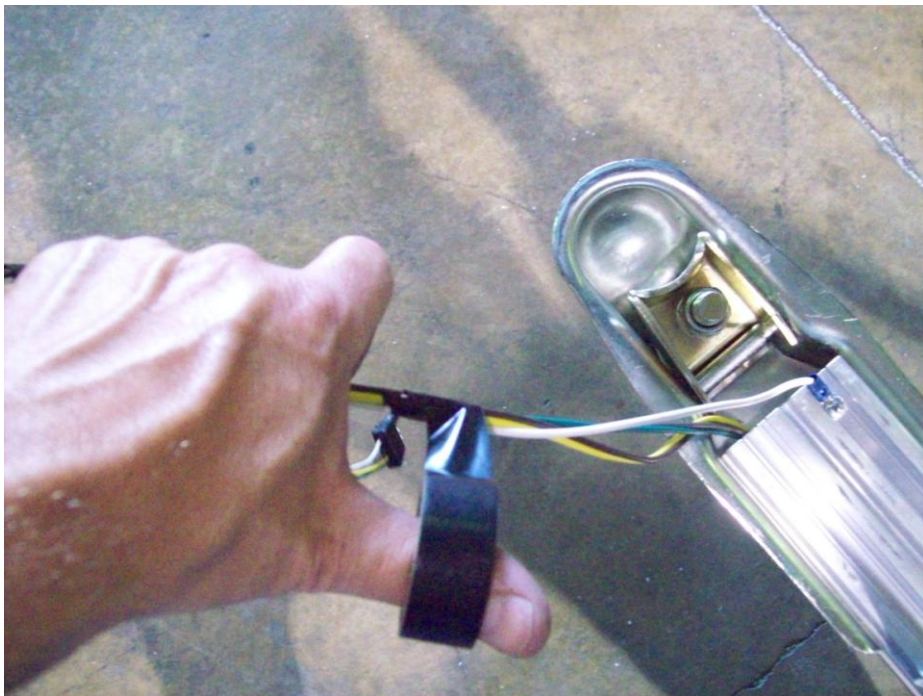


Separate the diagonal and side rails enough to slide harness through the side rails to the back of the trailer.

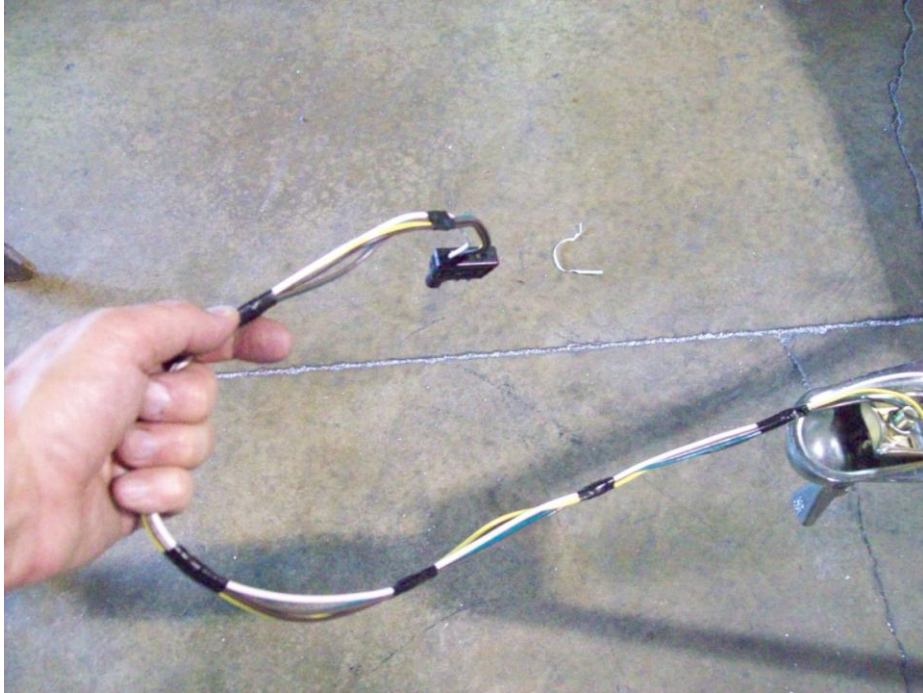


Shown up side down

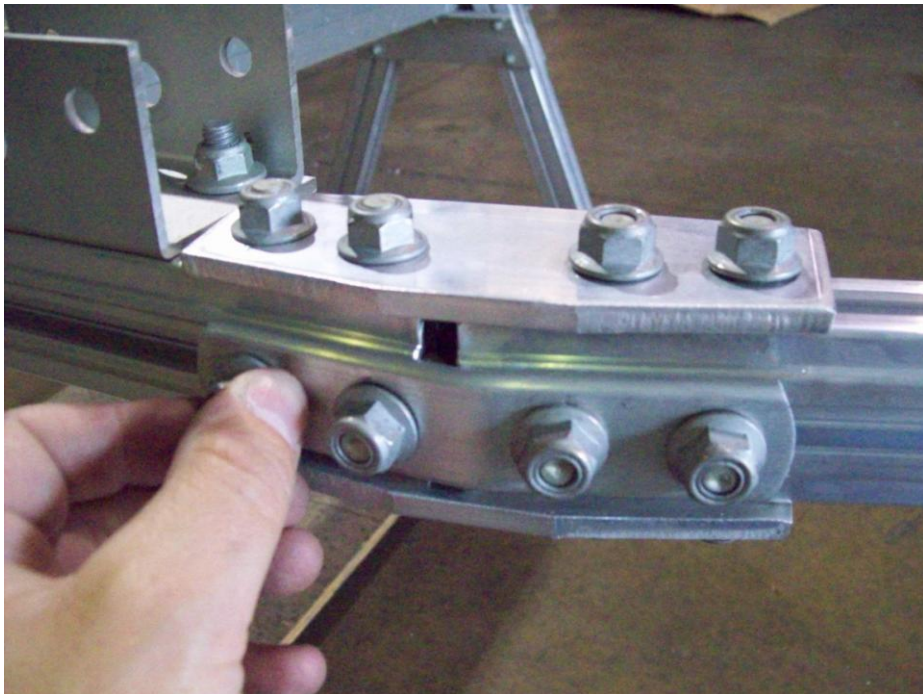
Pull both wires out the back of each side rail.



Make sure to leave about 34" of harness in front of the coupler. Then tape harness and ground wire together with electrical tape.



Harness should look like this when finished.

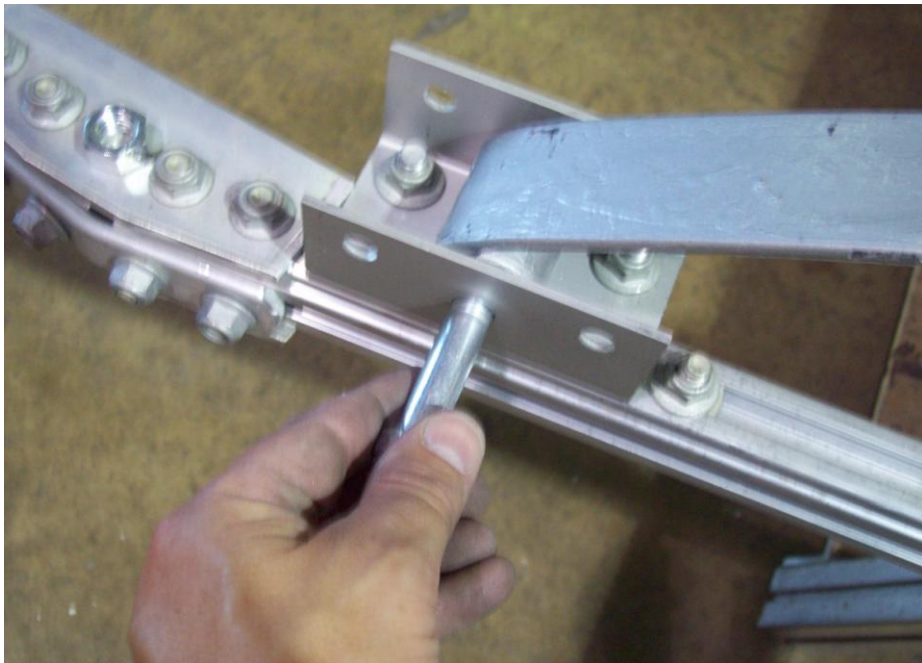


Now add the outside elbow plates to both side of the trailer and push rails back in place. At this point tighten all nuts.

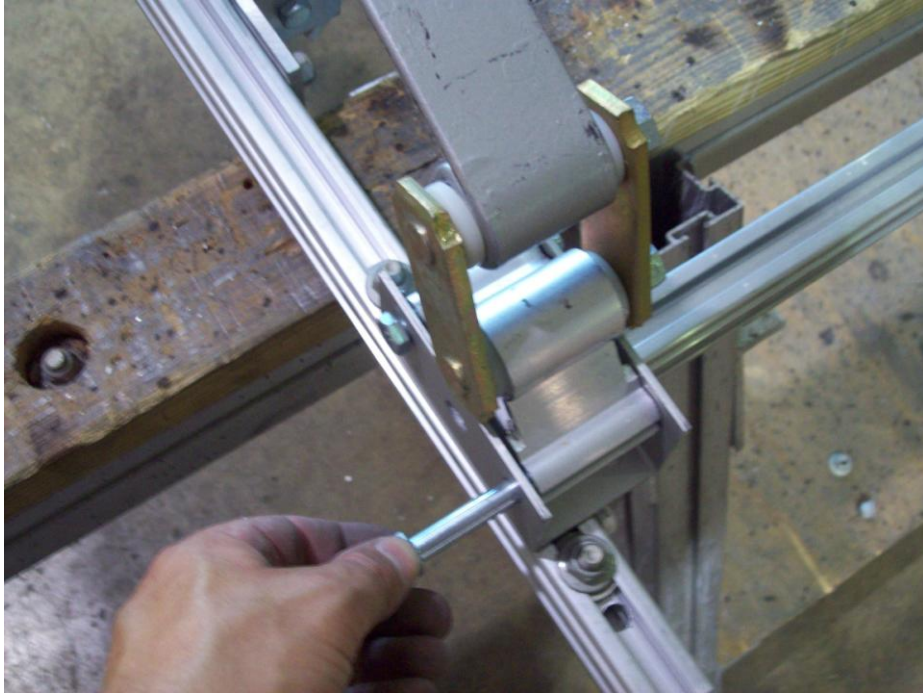
## Spring Installation



Locate the two spring assemblies.



Remove the bolt from the front spring eye and install the spring into the spring hanger in the center hole with the nut toward 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. These nuts can be tightened at this time.



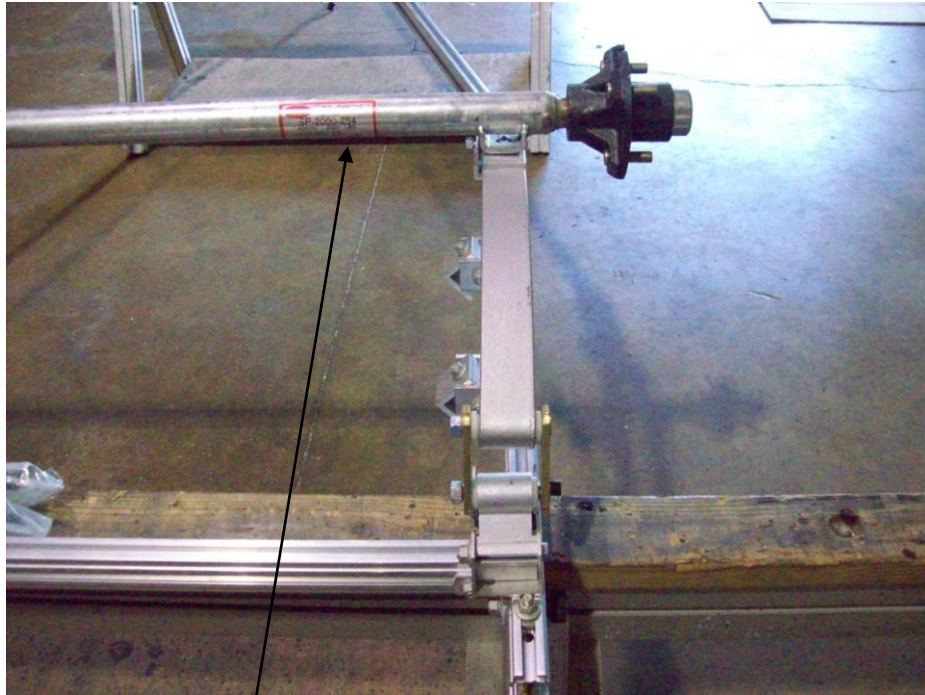


Springs should look like this when assembled.

## Axle Installation

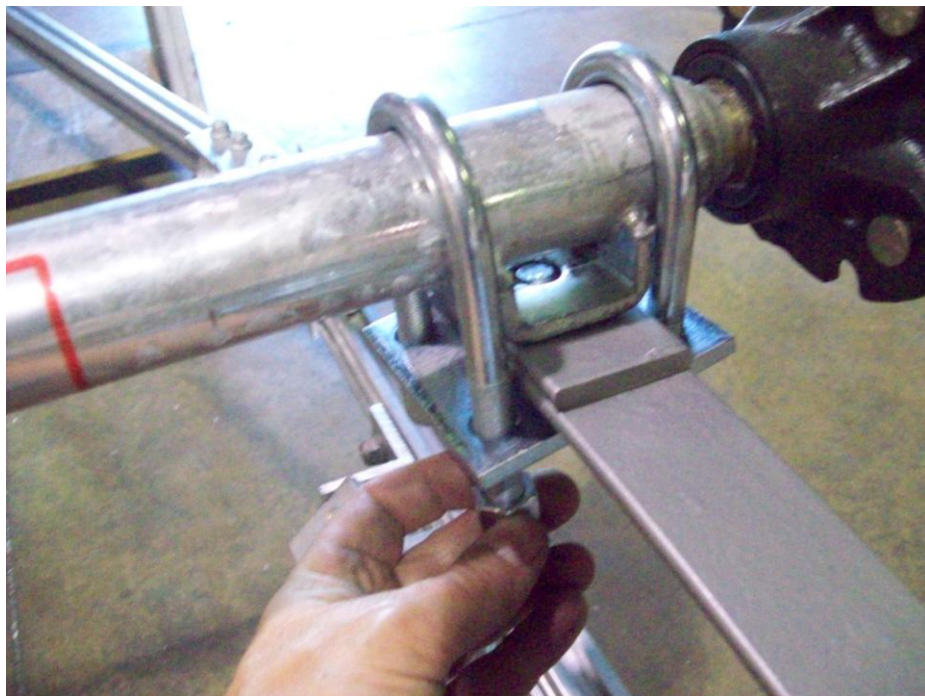


Locate axle and U-bolt hardware.



Serial plate

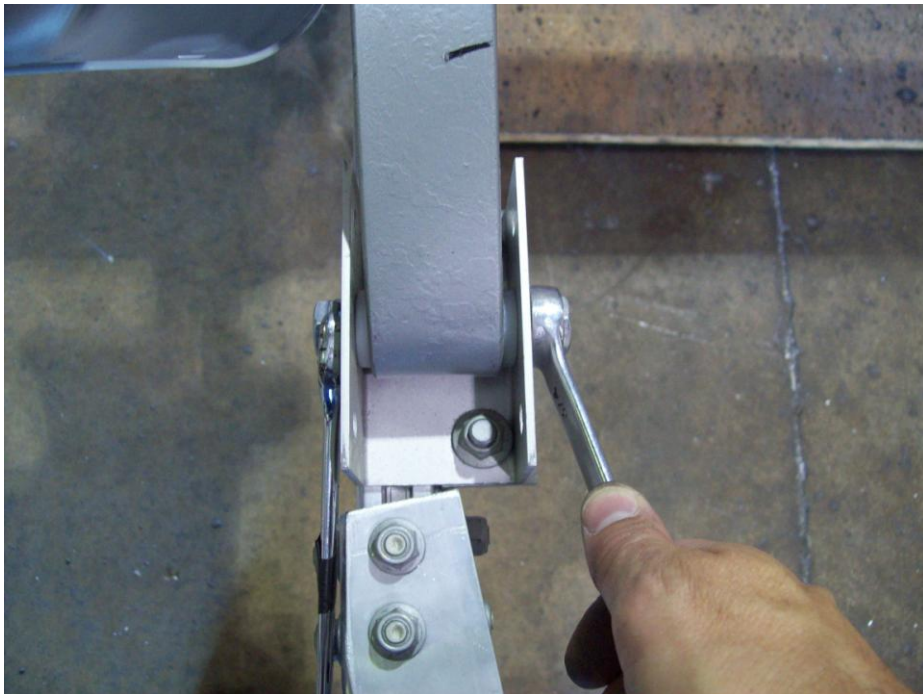
Install the axle as shown on the springs. Make sure the locating studs on the springs are in the holes on the axle's spring seat. Face the axle's serial plate toward the rear of the trailer to protect it from debris.



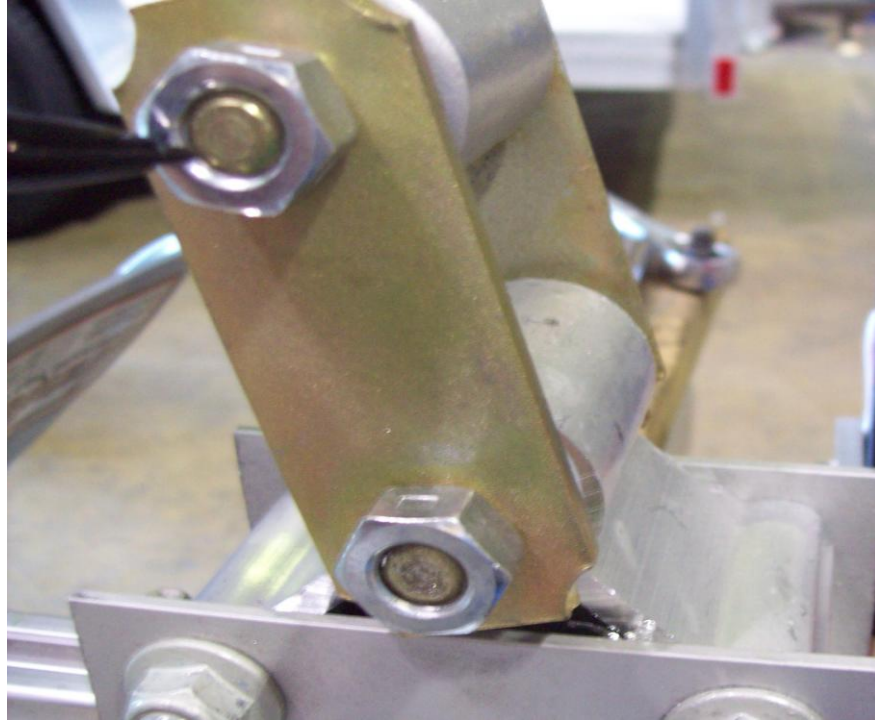
Install the U-bolts and tie plates as shown.



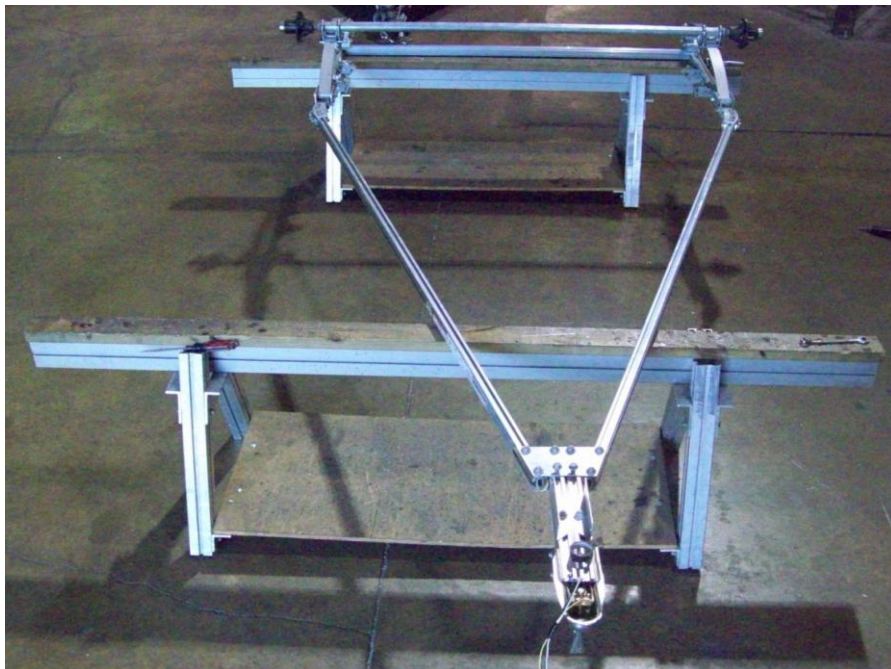
Install the nuts and tighten them evenly.



Go back and tighten all of the spring mounting nuts that were left loose previously.



Note: The threads on the shackle link will not protrude through the shackle nut when it is properly installed. This is normal. The indentations on the flat sides of the nuts are the locking mechanism. Do not over tighten as this will not allow the suspension to move properly.

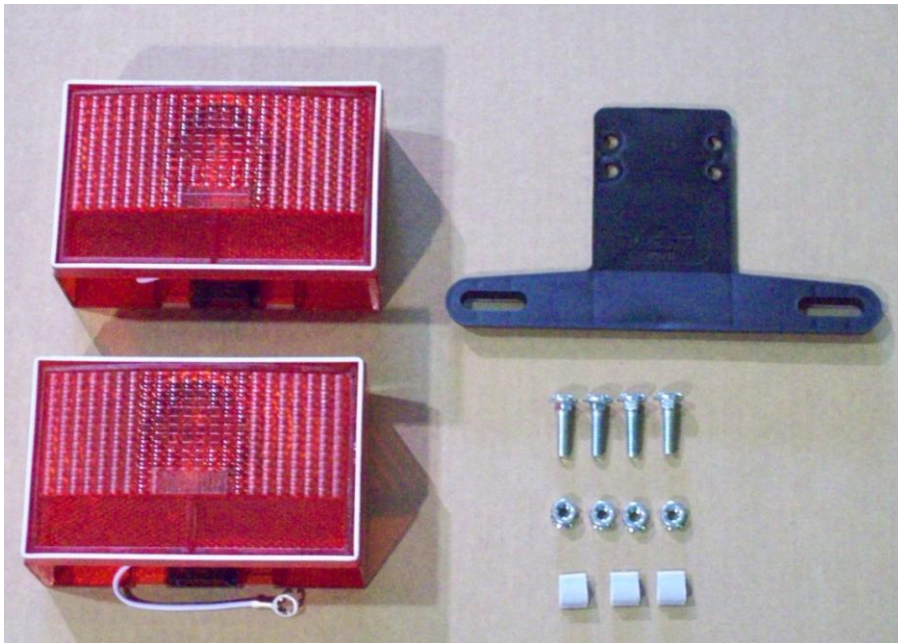


Your trailer should look like this at this point.

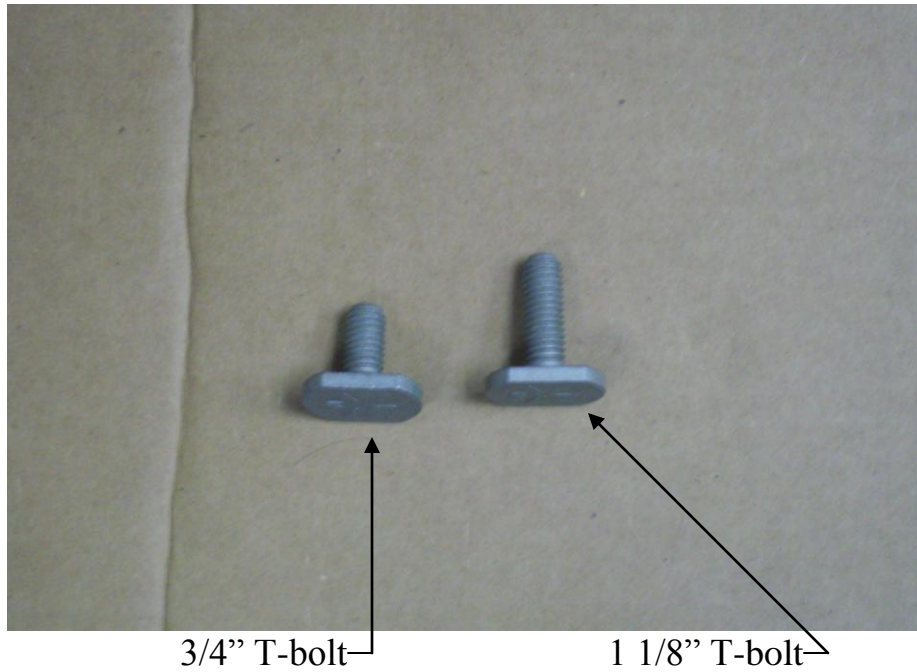
## Installation of lights



Locate the tail light brackets.



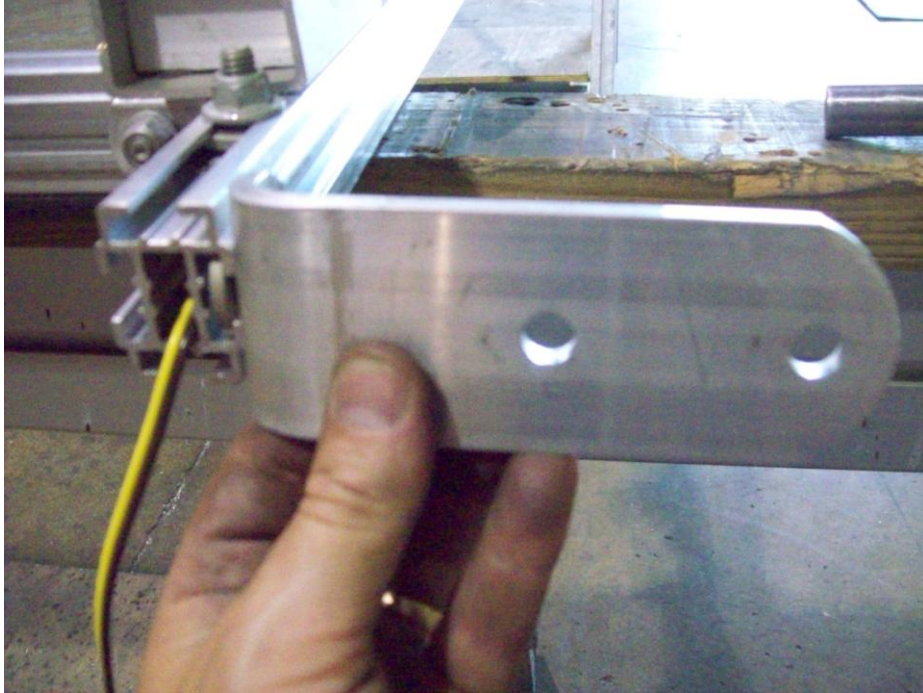
Locate the tail lights, carriage bolts, nuts and license plate bracket.



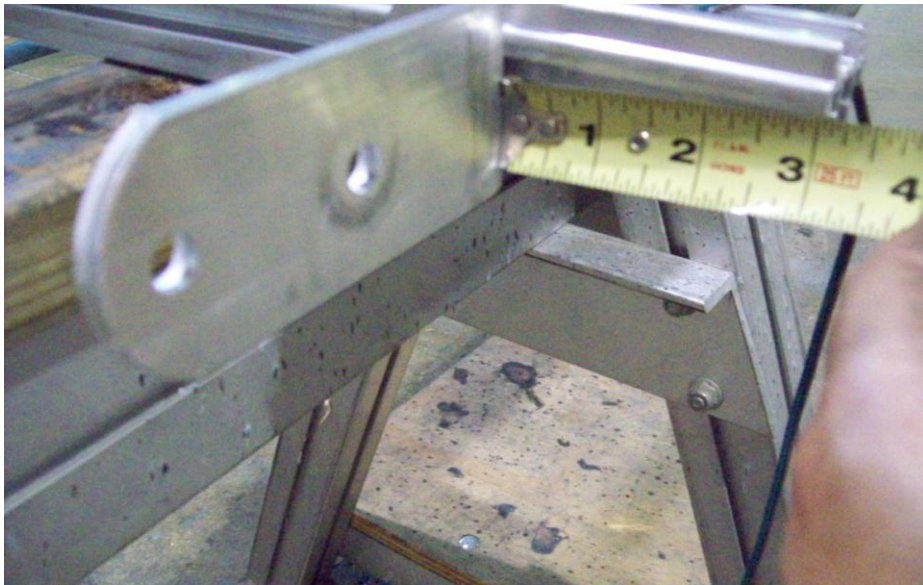
Locate the four 1 1/8" T-bolt from the fender hardware bag.



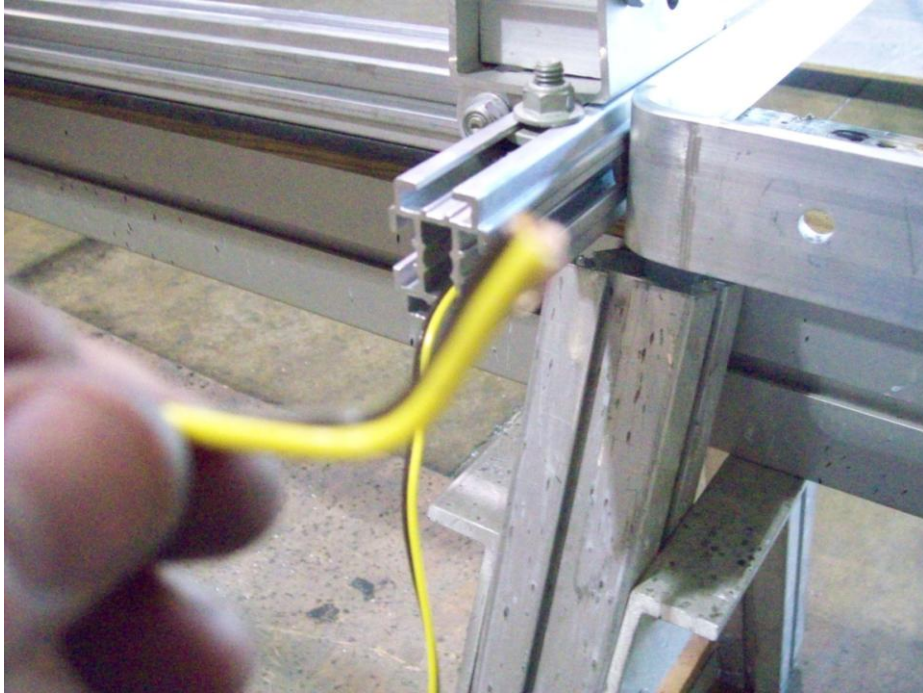
Install two 1 1/8" T-bolt in the back of each side rail facing out. These will be used later to install the fenders.



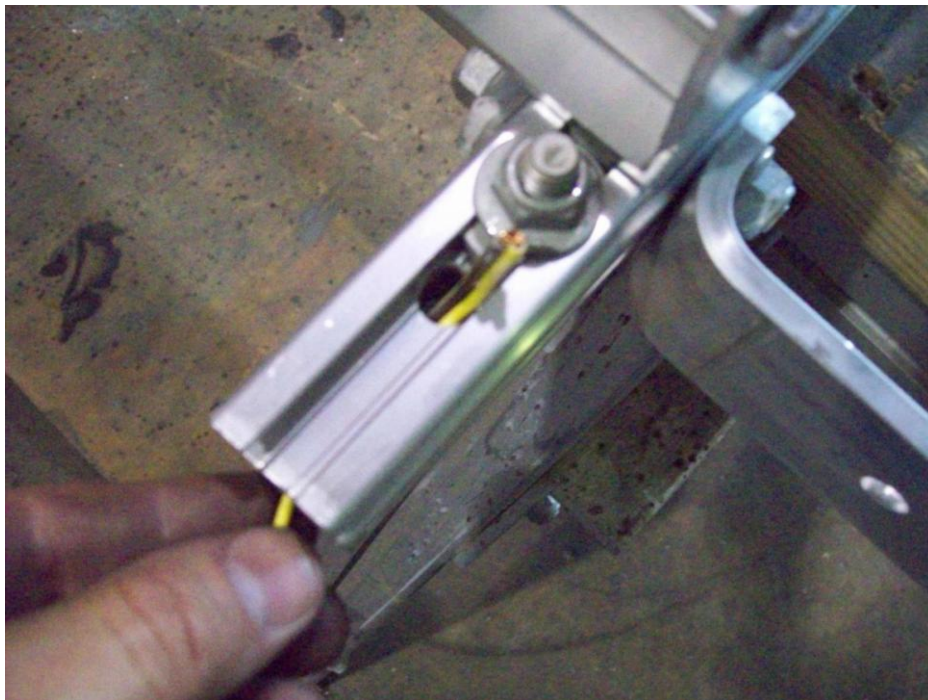
Install tail light brackets at the back of the side rail using  $\frac{3}{4}$ " T-bolts.



Position tail light bracket 3" from the rear of the side rail.

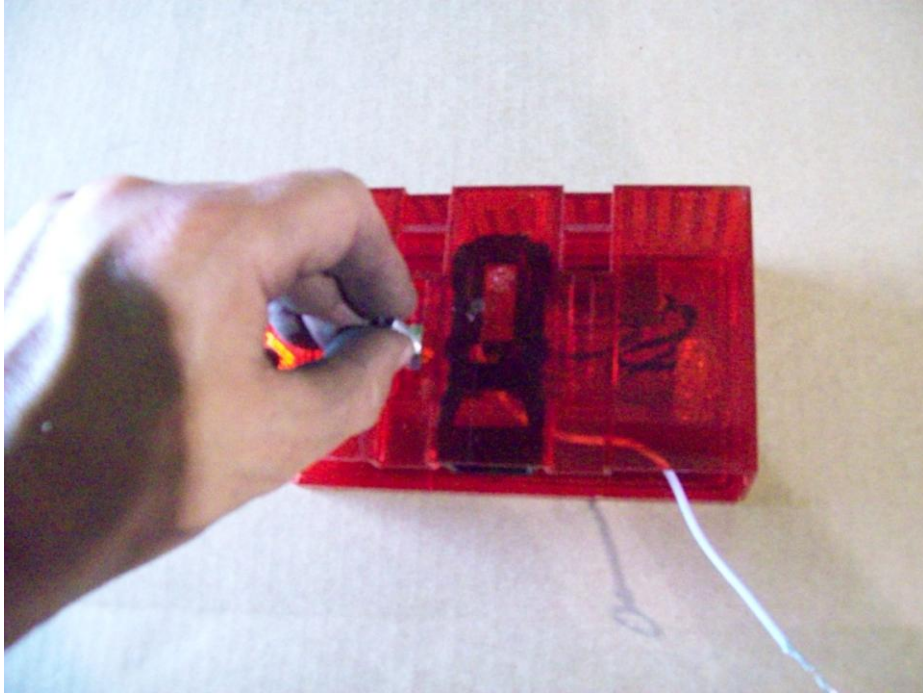


Make a little 90 degree bend in the end of the harness this will to help get the harness through the hole.



Run harness through the hole drilled on the bottom of the side rail and carefully pull through not to damage the harness.

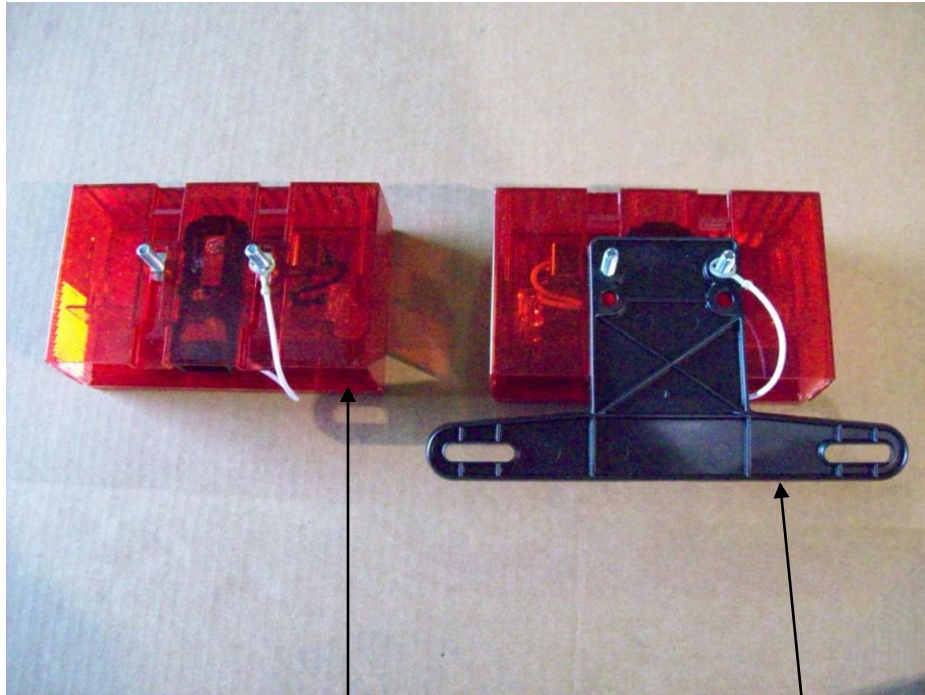




Slide the carriage bolts into the slots in the back of the tail lights.



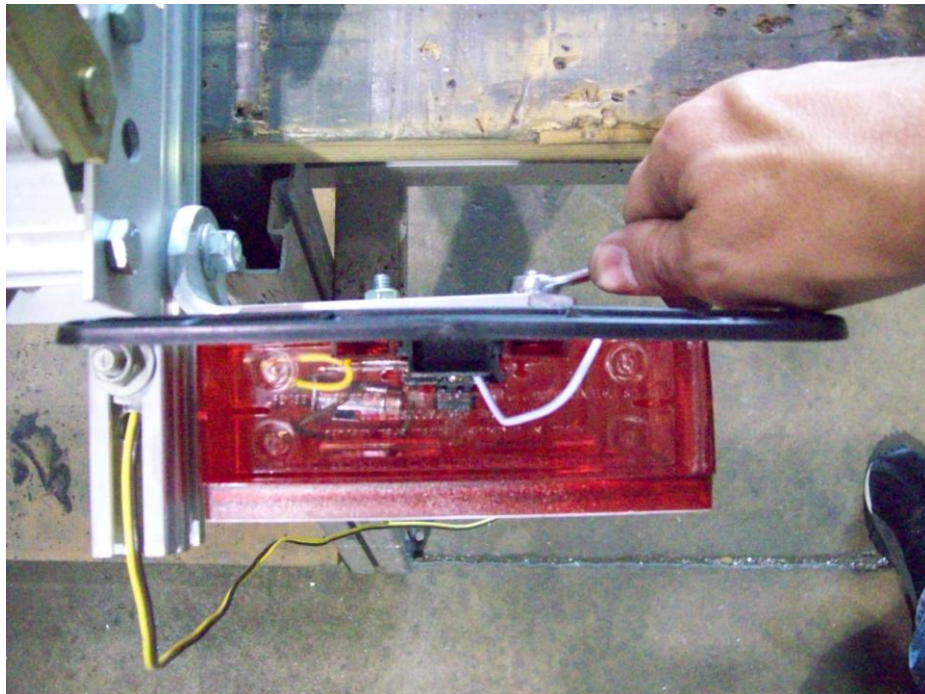
Place ground wire over top of carriage bolt.



Passenger side

Driver's side

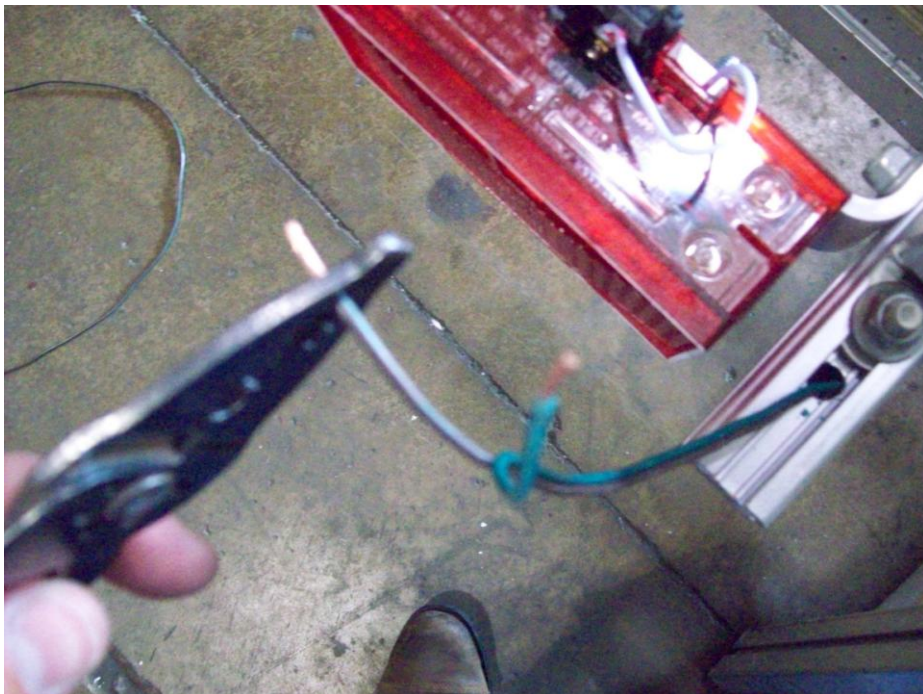
Install license plate holder on left tail light.



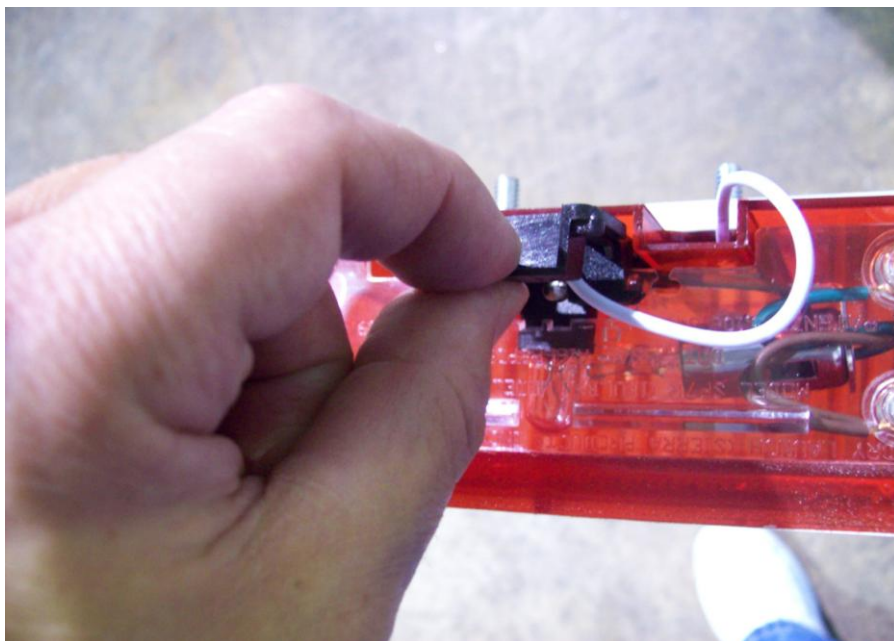
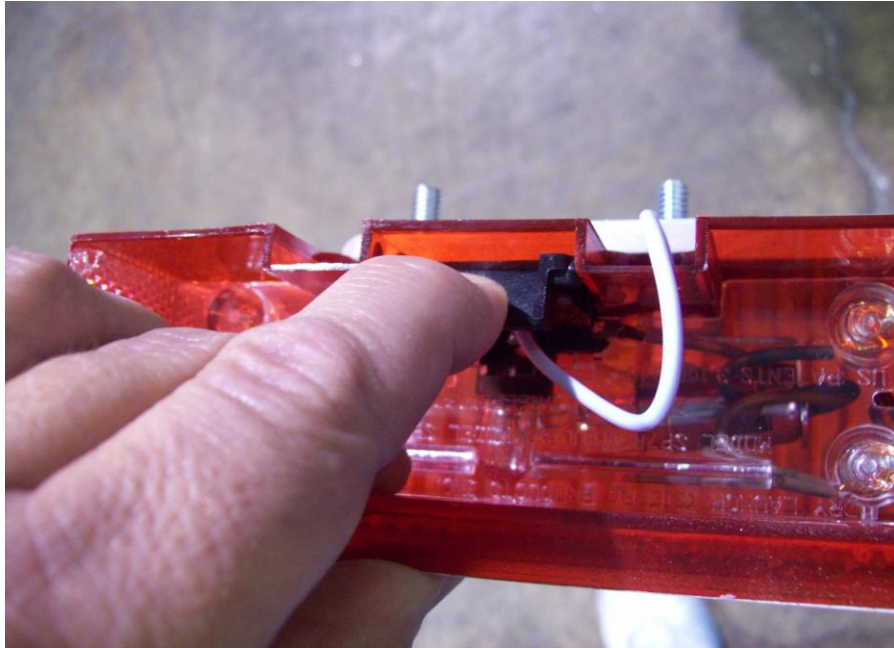
Install the left tail light with the license plate holder between the light and the bracket. Repeat for the other side. Then make sure to tighten nuts but don't over tighten them.



From the end of the harness cut approximately 45" off the harness. Repeat this step for other side.



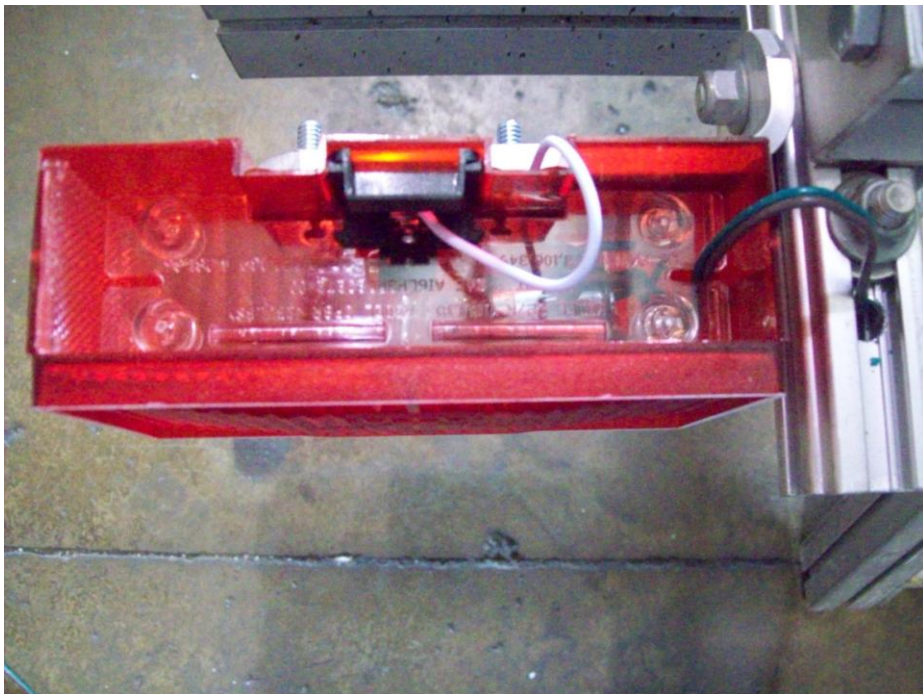
Separate the brown wire from the green wire then strip  $\frac{1}{4}$ " of insulation from the wire.



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.



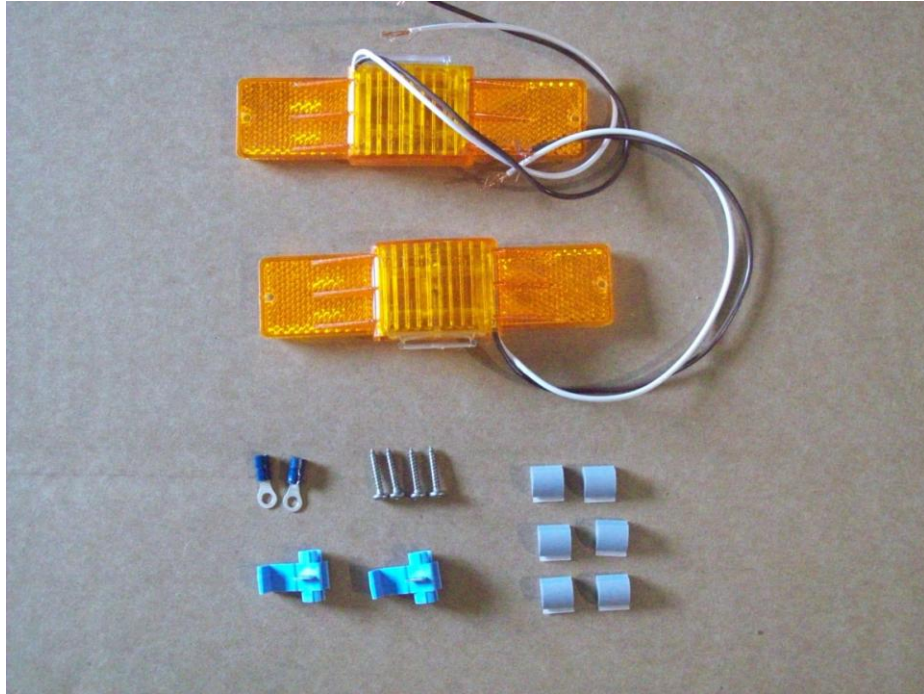
Loosen the wire retaining screws and install the color matching wires from the wire harness onto the corresponding retaining screws.



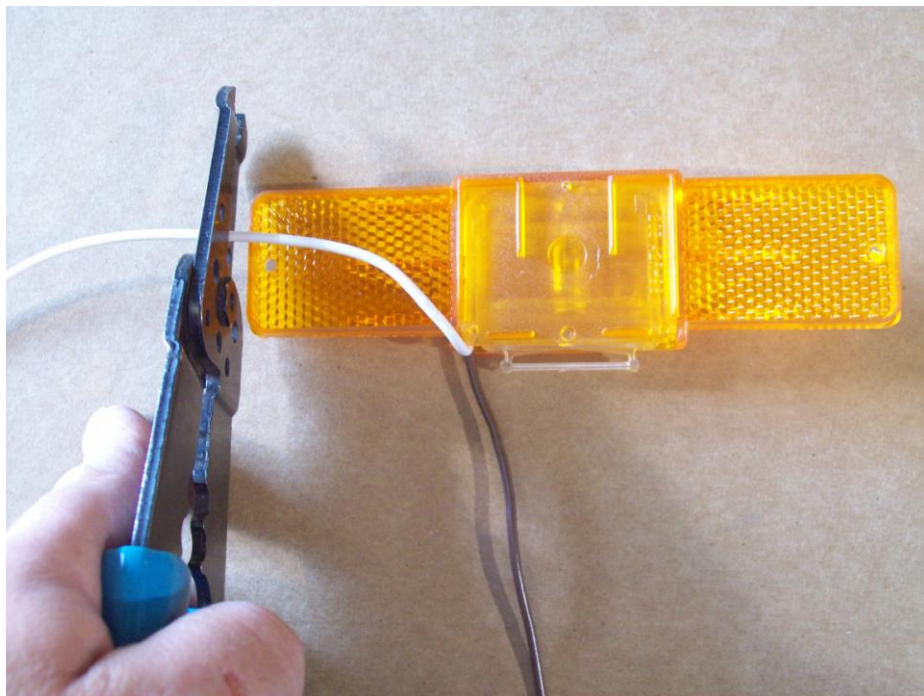
Passenger side shown

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. Repeat this process for the other side.

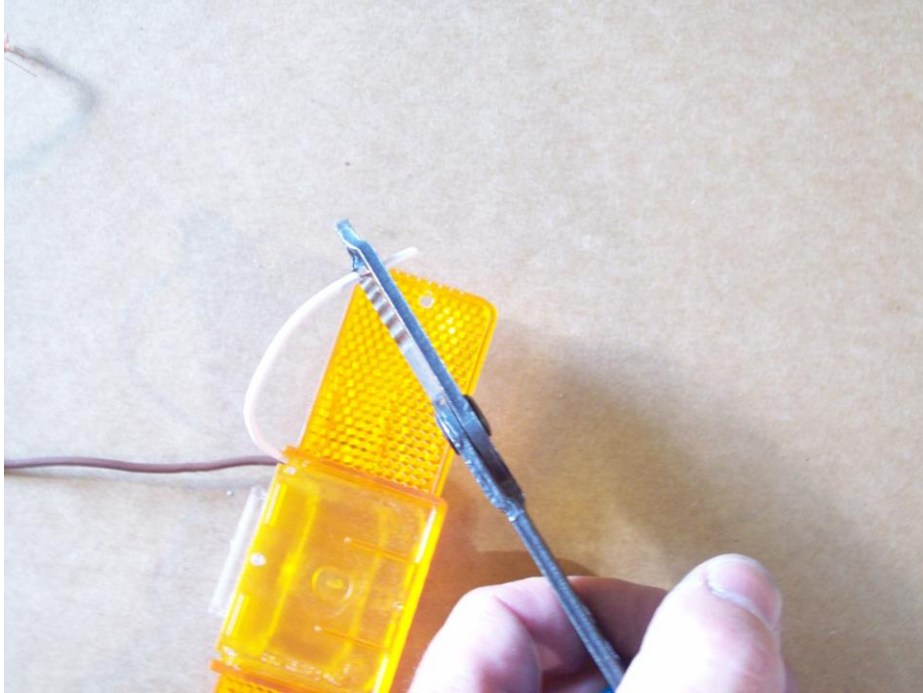
## Running lights bracket and skid



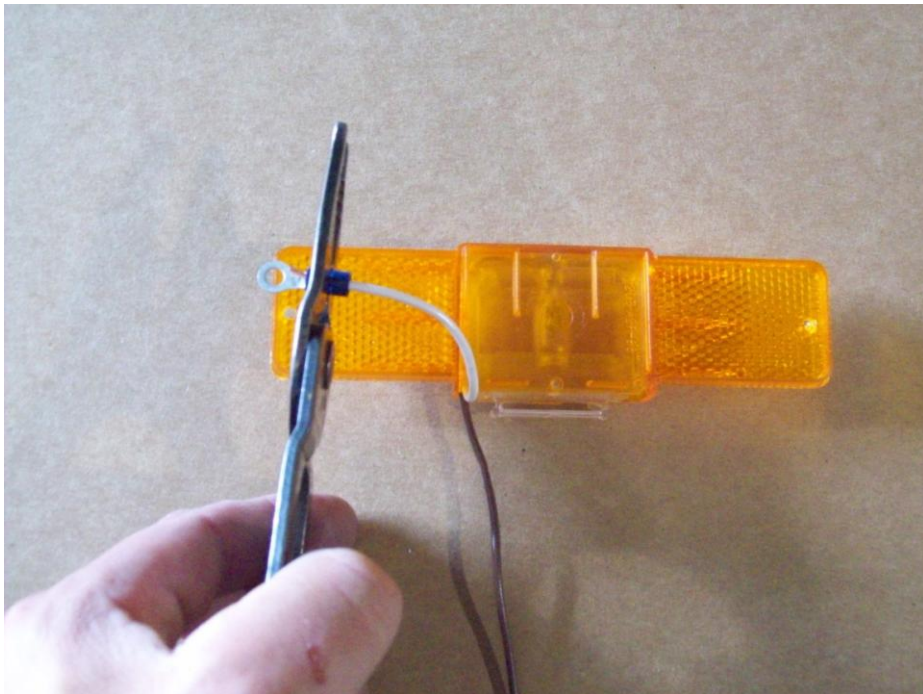
Locate the two amber running lights, four small Philips screws, adhesive backed clamps, two ring terminals, and two blue connectors.



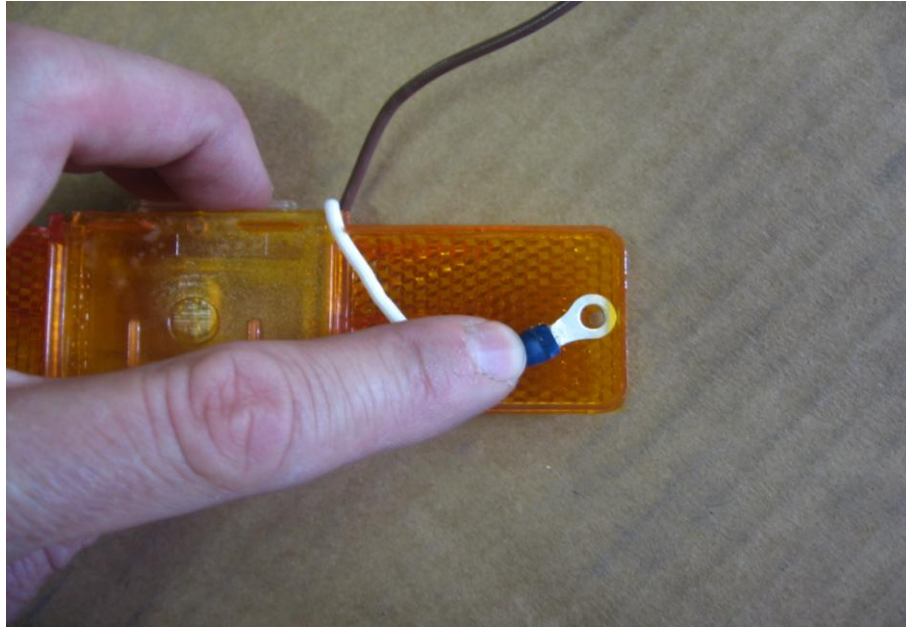
Cut approximately 8 ½" off of the white wires on both running lights.



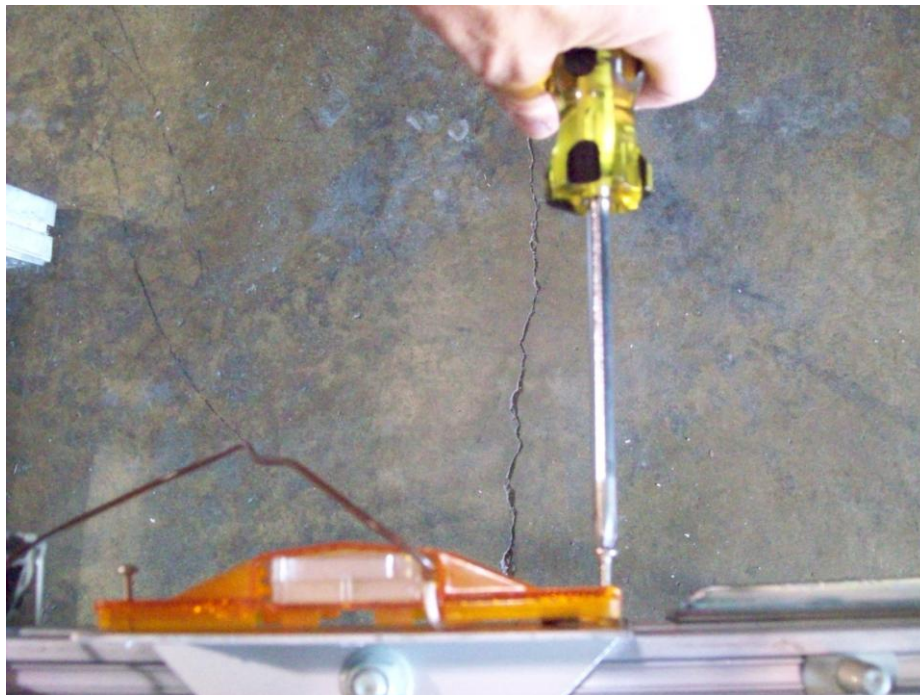
Strip 1/4" of insulation from the wire.



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

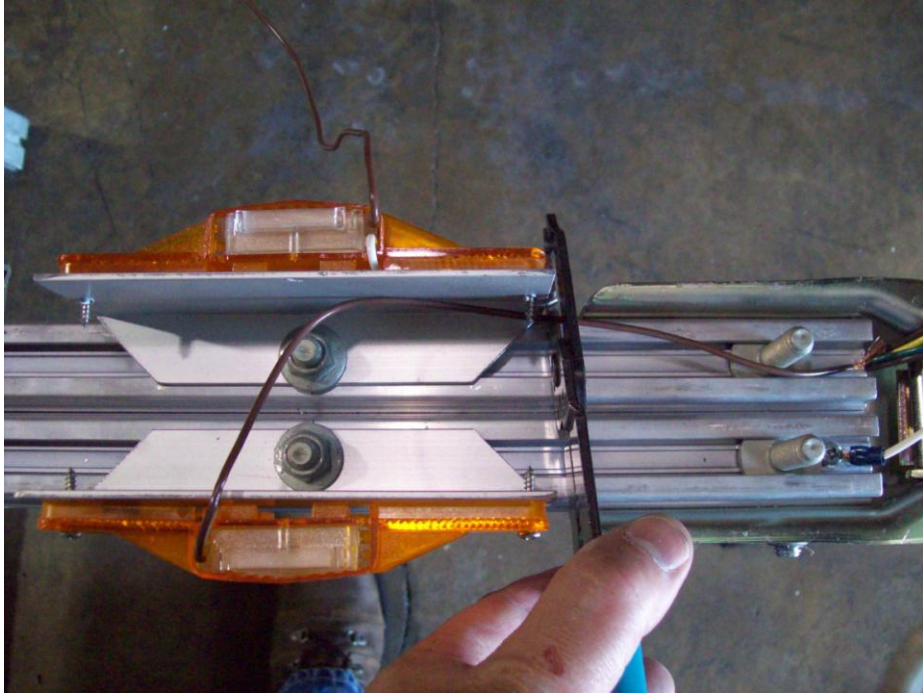


Align the ring terminals with the screw hole nearest the wire on the back of the running light. Make sure the wire is routed through the gap on the back of the light so it does not become pinched when the light is installed.



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!**

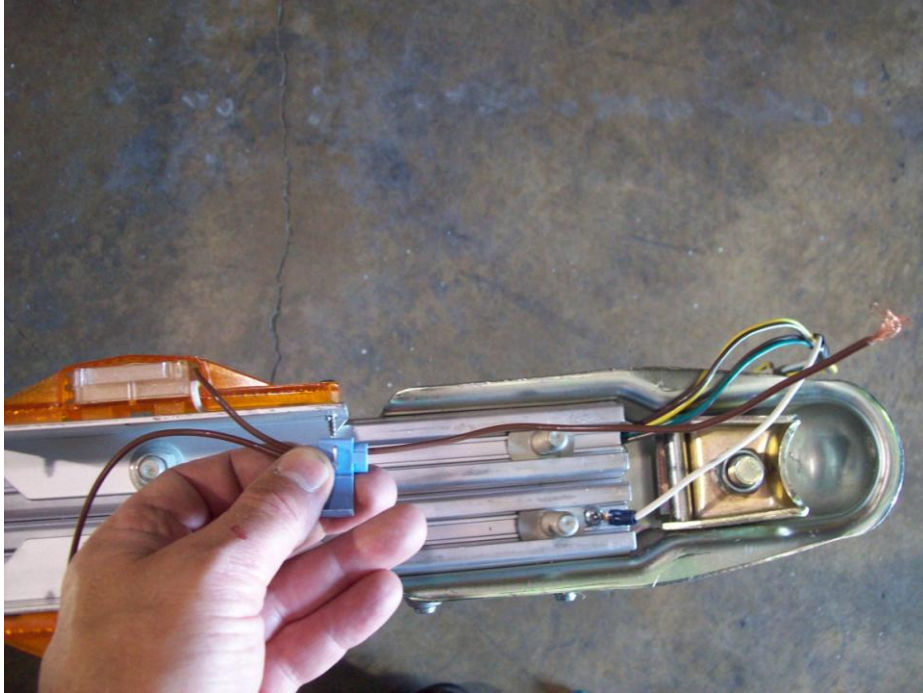




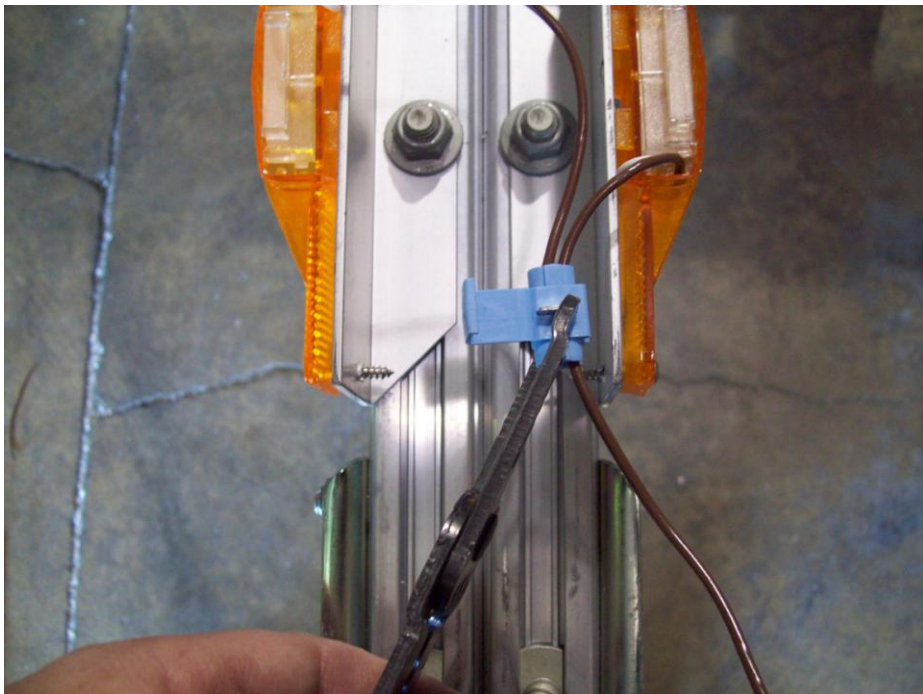
Cut 6" off of the brown wire on the left (driver's side) running light. Do not strip the wire!



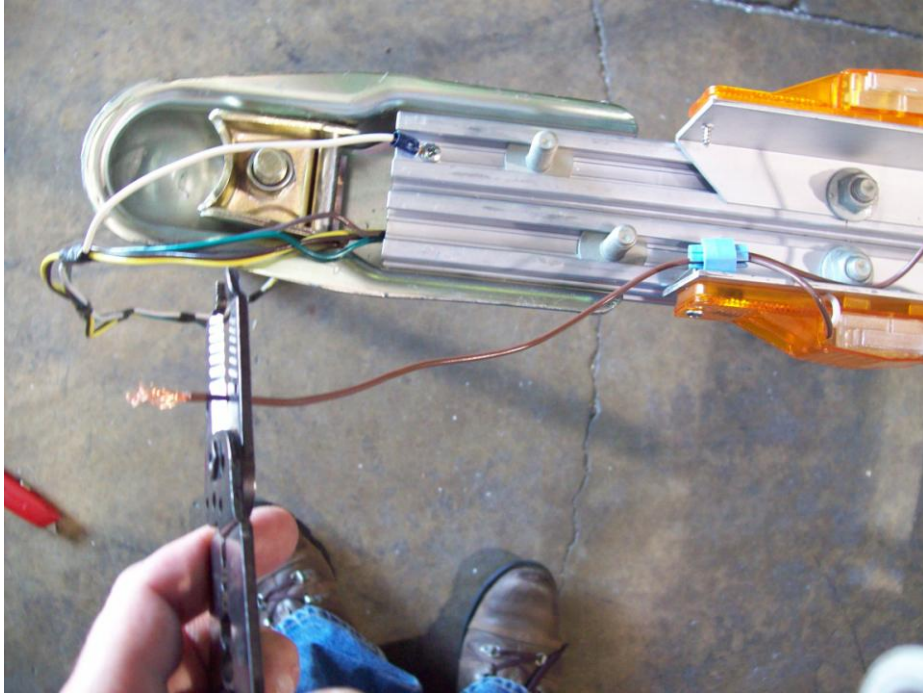
Insert brown wire that has been cut into the hole in the connector closest to the hinge. This hole does not pass all the way through. The wire should go in about  $\frac{1}{2}$ ".



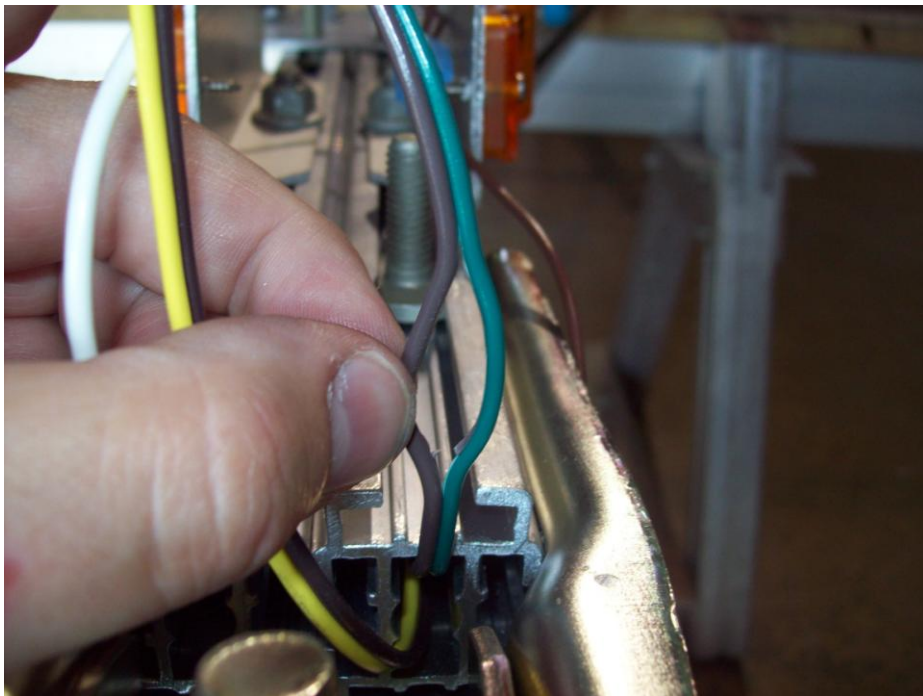
Pass the other wire through the remaining open slot in the connector at a point close to the running lights.



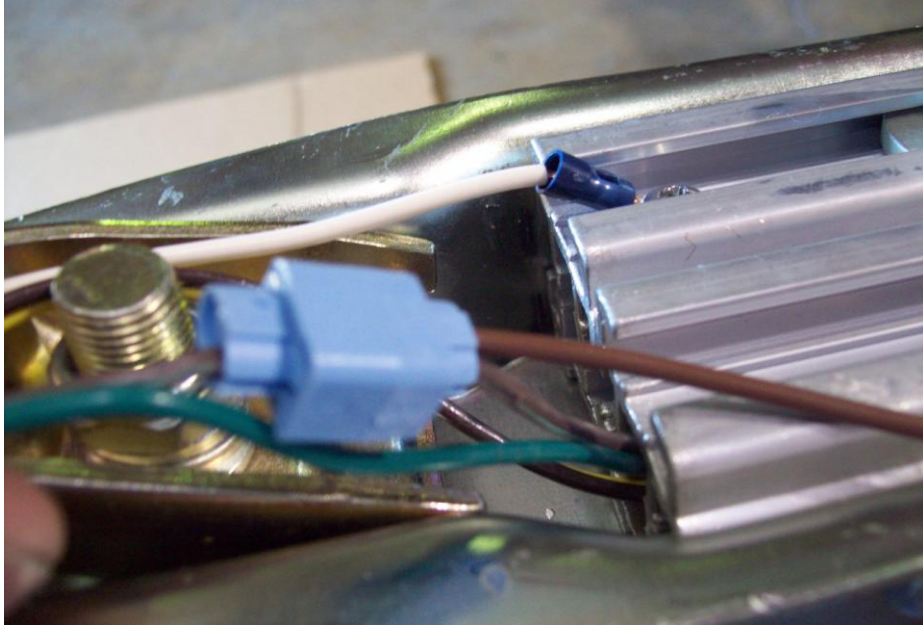
Use pliers to push the metal spade down until it is flush with the plastic. This is what makes the electrical connection between the two wires. Close the plastic cover of the connector over the spade until it snaps into position.



Cut about  $\frac{3}{4}$ " off the end of the exposed strands of the brown wire on the right (passenger side) running light.



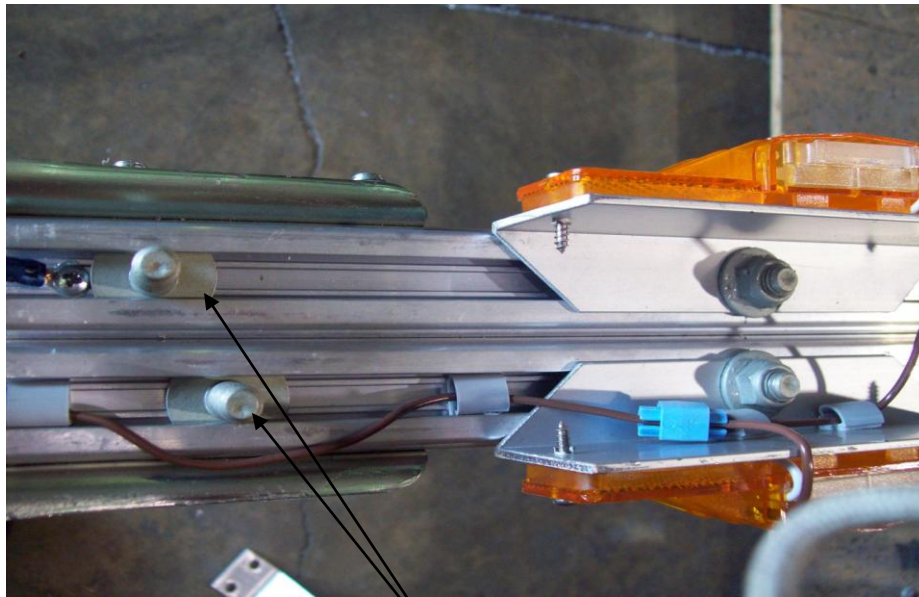
Measure about 33" back from the front plug on the green/brown wire. Then carefully separate the green from the brown wire with a razor to be able to attach the connector.



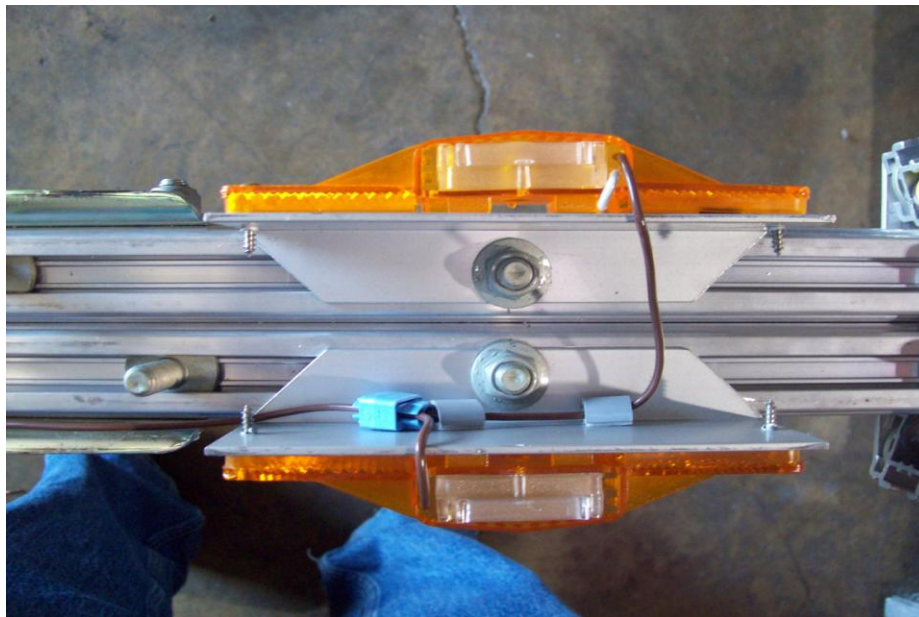
Insert the brown wire from the harness through the open slot in the connector. The green wire will rest just outside the connector. Insert the brown wire from the running lights into the closed side of the connector and close the spade and cover as previously described. This will make the connection from the main harness to both running lights.



Locate the skid and remove the two T-bolts that are attached to the cables. These will be inserted into the bottom of the tongue.



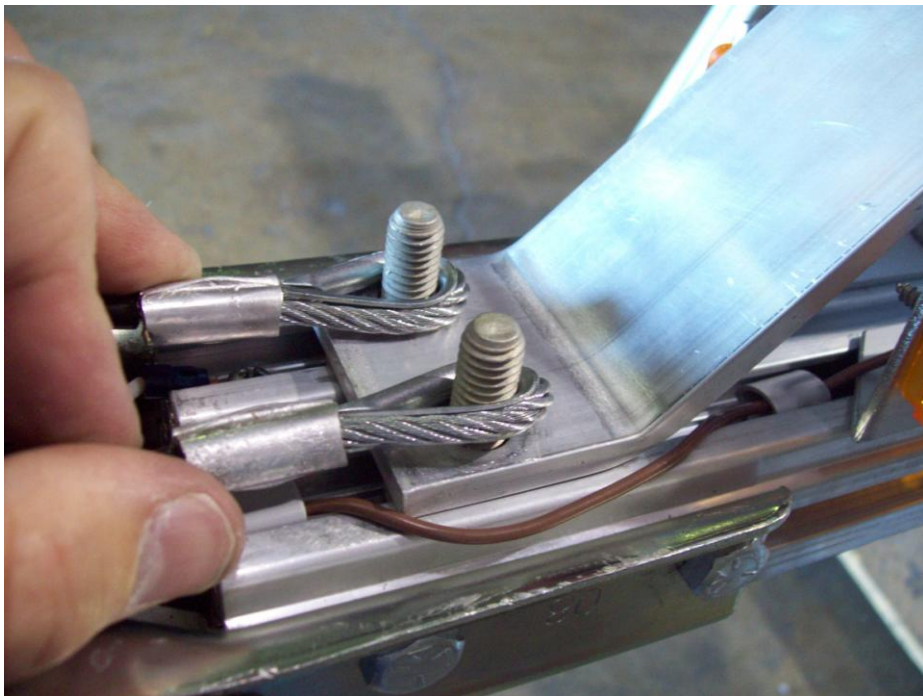
T-bolts



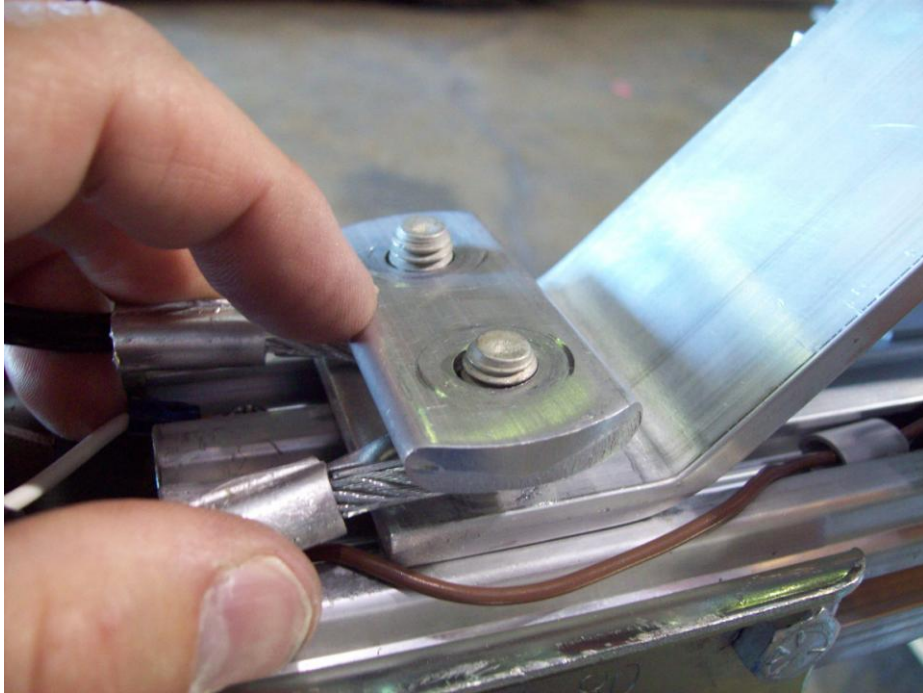
Install two T-bolts in the front of the bottom of the tongue as shown. Then locate the adhesive backed clamps. Install them as shown and run brown wire from the running lights through them.



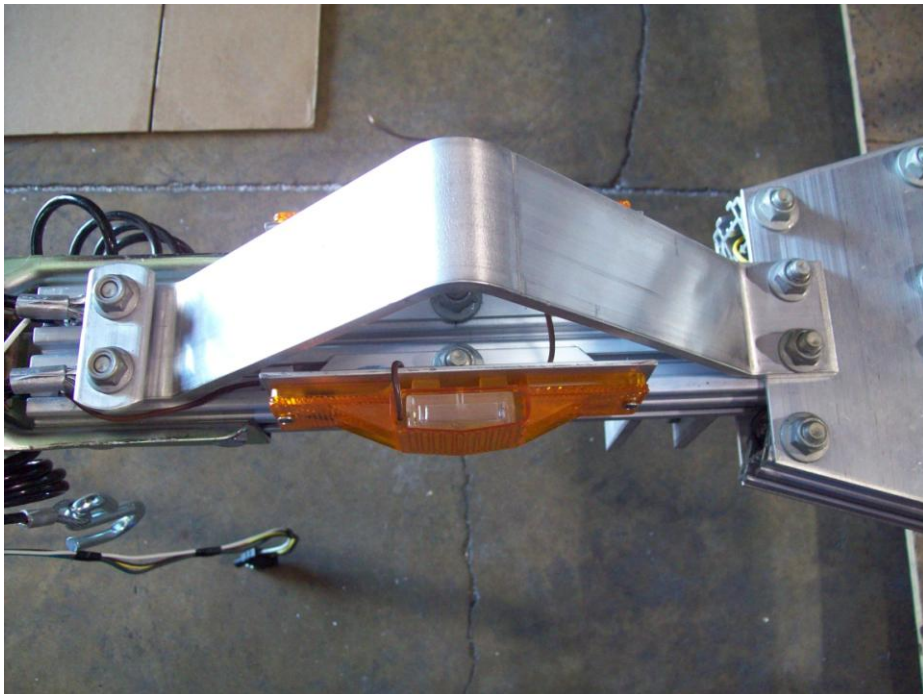
Install the skid plate on the T-bolts on the apex plate and the two T-bolts on the tongue section.



Install cables over top of the T-bolts.



Put safety cable plate on top of cables as shown.



Install nuts on skid plate and tighten.

## Fender installation



Locate fender and hardware.



Install two rubber washers over the 1 1/8" T-bolts on the side rail. Then repeat process for other side.





Install two steel washers over rubber washers then repeat for other side.



Install fender, steel washers, and nuts then repeat for other side.



Then center fender up with axle.



Then tighten nuts on both sides.



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.

## Web strap clip installation



Locate 2 web strap clips

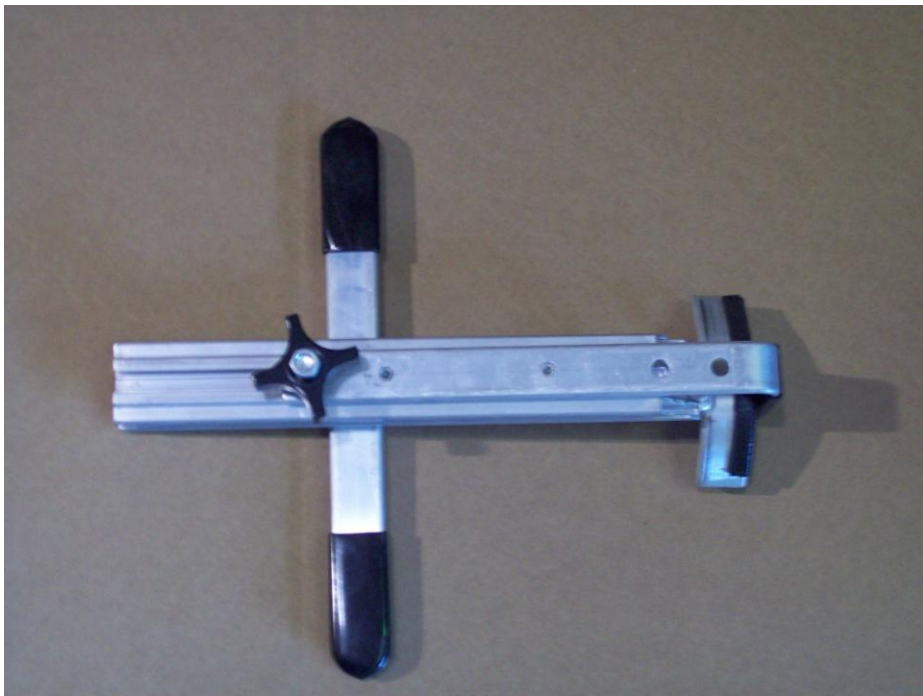


Install web strap clips on the top of each side rail and side forward.

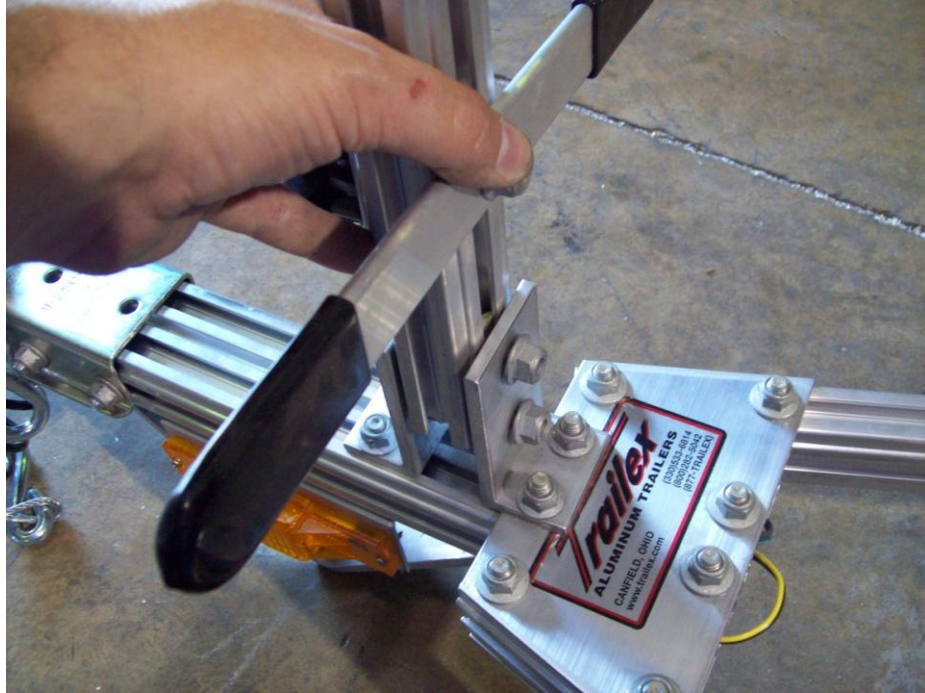


Once forward in position as shown tighten nuts.

## Bow support installation



Locate bow support.



Align base of bow support with T-bolt and side on.

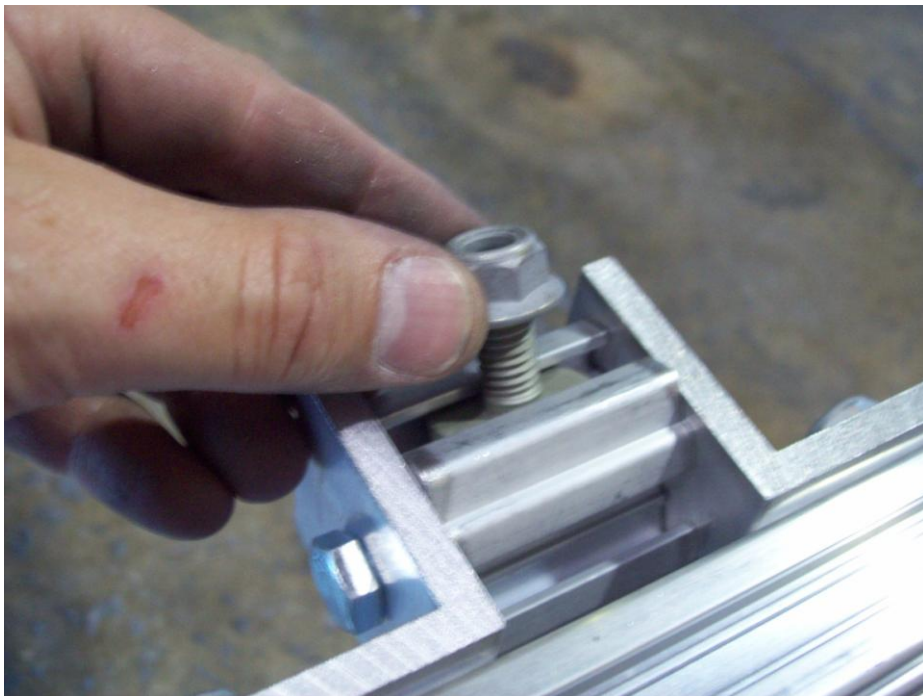


Once in place tighten all nuts.

## Hull support rod installation



Locate the two hull support rods.



Remove the nuts from the swivel mounts to accept the hull support guide plates.



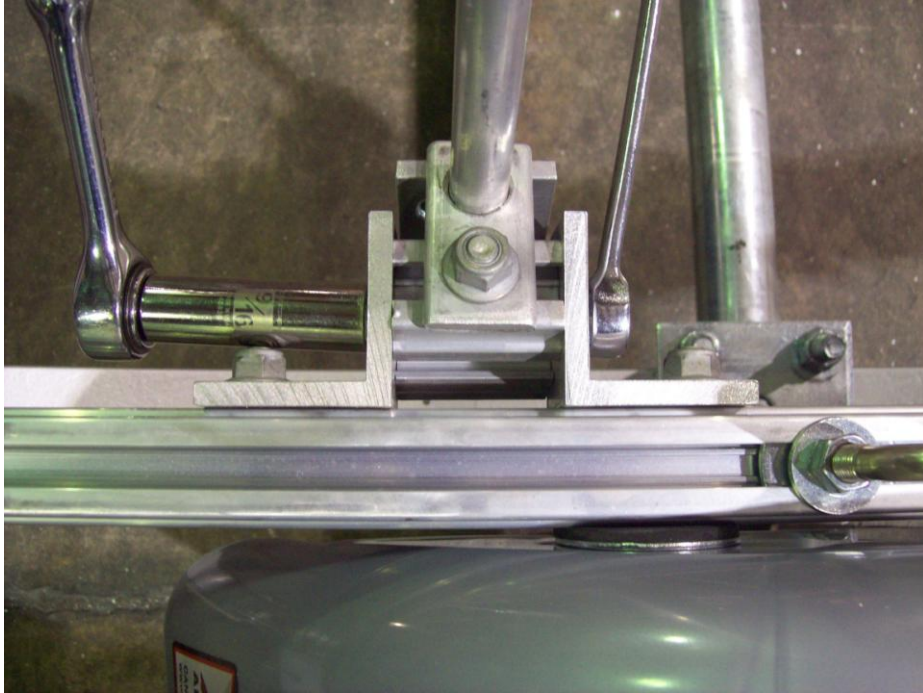
Guide plate  $\triangle$

Insert hull support rods into swivel mounts and slide guide plate over bolt as shown.



Once in place reinstall nuts and tighten.





The swivel mounts for hull support rods will have to be adjusted to accommodate the boat once on the trailer then tighten nuts.



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

## Finished trailer



Shown with optional bearing buddy and swivel bow





Shown with optional bearing buddy and swivel bow

