



**ASSEMBLY  
INSTRUCTION MANUAL**  
KIT TRAILERS

Please read and follow the assembly instructions in this manual or watch the online videos.

Before using your trailer, carefully review the owner's manual. Keep both manuals for future reference.



48-048-K08



48-072-K08



48-048-K08/K012



60-096-K012



48-048-KU08



48-072-KU08



48-096-KU08/KU012



60-096-KU012



## Thank you for choosing Westbrook Trailers!

Thank you for choosing our kit trailer to meet your hauling needs. This guide will help you assemble your trailer with clear step-by-step instructions. While it covers the assembly process, it's essential to review the Owner's Manual for important towing and hauling safety precautions.

To make your experience even smoother, scan the QR code or visit the link provided to watch our detailed assembly video. We're here to support you every step of the way!



If you have any questions or need assistance, our customer support team is here to help.

Contact Info

Phone: 866-857-1445

Email: [support@westbrooktrailers.com](mailto:support@westbrooktrailers.com)

**Welcome to the Westbrook family, and happy hauling!**



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## **Important Safety Information**

Before you begin assembling your trailer, please take the time to carefully read and understand these instructions. Following the steps closely is essential for your safety and the safety of others. Skipping or improperly following the instructions can lead to serious injuries.

### **SAFETY FIRST**

- The edges of the trailer frame can be sharp, it is **IMPORTANT** to always wear the provided safety gloves when handling the material during unboxing and the assembly process.
- We recommend having two people assemble the trailer since you will need to flip the frame of the trailer during the assembly.
- Modifying the trailer's structure can make it unsafe and void your warranty. Any changes must comply with DOT and NHTSA regulations and maintain the trailer's gross vehicle weight rating (GVWR).

### **Important Documents**

The registration documentations for the trailer are enclosed in a brown envelope on the outside of box #1.

If you haven't received this documentation, please contact us at 866-857-1445 with the serial # indicated on the label of each boxes.

It includes:

**USA**



**CANADA**



It is the customer's responsibility to obtain the registration information specific to their province or state. Please ensure that you are aware of and comply with any local regulations regarding trailer registration and requirements in your area. We recommend contacting your local motor vehicle department for detailed instructions on how to complete the registration process.

## **Understanding & Unboxing Your Kit**

This manual provides assembly instructions for all eight kit trailer models, including:

- Flat-Bed Kit Trailers: 4x4, 4x6, 4x8, and 5x8 models
- Utility Kit Trailers: 4x4, 4x6, 4x8, and 5x8 models, featuring plank floors and Galvalume side rails

All hardware needed to assemble the flat-bed trailer kit is included with the flat-bed kit shipment.

The hardware for the plank floor and rails will be shipped in their respective boxes.

Before you begin assembling, please open and unpack all your boxes to confirm that you've received all the parts for your kit. Please refer to Appendix 6 for a complete parts listing and a breakdown of how the parts are shipped. Note that the boxing method may vary.

If you find any missing or damaged parts, please contact us at:

**Phone:** 866-857-1445

**Email:** support@westbrooktrailers.com

Be sure to include the trailer's VIN or the serial number found on the label of each box.

### **The instructions explain two different types of flooring that could be installed in our trailers:**

- **Plank floor:** This refers to steel planks that are installed on the trailer's frame. The instructions suggest that if you plan to use a plank steel floor, you should install it before completing the trailer's assembly because it will be easier to do so at that stage.
- **Plywood floor:** If you decide to install a plywood floor instead of a plank floor, the process is different. The instructions suggest that you should continue assembling the trailer frame as if you weren't installing the floor at that point, meaning you can finish assembling the trailer without worrying about the floor. The plywood floor can be installed after the entire trailer is fully assembled, so it doesn't need to be in place while you're constructing the frame.

## **Preparing for Assembly**

Before starting the assembly of your trailer, ensure you have a clear, level workspace large enough to accommodate the trailer. While our instructions are designed for assembly on the ground, using sawhorses or other supports to elevate the trailer can make the process easier and more comfortable.

**Safety Note:** Personal Protective Equipment (PPE), such as gloves and long sleeves, is required during assembly, as the edges of the frame can be sharp. Additionally, certain steps will require two people, as the trailer will need to be flipped to continue assembly.

### **To complete the assembly, you'll need the following tools**

- Wrench:  $\frac{9}{16}$ ,  $\frac{3}{4}$ ",  $\frac{7}{8}$ "
- $\frac{3}{8}$  drive Ratchet with the following size sockets: 10mm,  $\frac{3}{8}$ ",  $\frac{1}{2}$ ",  $\frac{9}{16}$ ",  $\frac{13}{16}$ ",  $\frac{7}{8}$ ",  $\frac{7}{16}$ " deep socket
- Phillips Screwdriver
- Standard Drill
- Robertson #2 drill bit (for floor assembly only)
- Torque Wrench
- Knife
- Rubber Mallet
- Pliers
- Gloves (included)

Scan the QR code provided in this manual to access our step-by-step assembly video for further guidance. On this link you will find the following videos.

- 4x4 & 4x6 Kit Trailer Video
- 4x8 Kit Trailer Video
- 5x8 Kit Trailer Video



## Step 1 - Stake Pocket & Grommet Installation

**Note:** All the channels have been labeled on the inside with the item code for easy reference.

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501171	ELECTRICAL GROMMET	2	4	8 or 12	10
500255	4FT WIDE CROSS-CHANNEL*	1	2	4 or 6*	
504602	5FT WIDE CROSS-CHANNEL				5
504471	STAKE POCKET	8	8	7	7
501073	1/4 X 3/4" HEX BOLT	32	32	36	36
501081	1/4 LOCKING NUT	32	32	36	36
504467	RAMP MOUNTING BRACKET*			2*	2*

\* Two cross-channels for the 4x8 kit will be in the floor box.

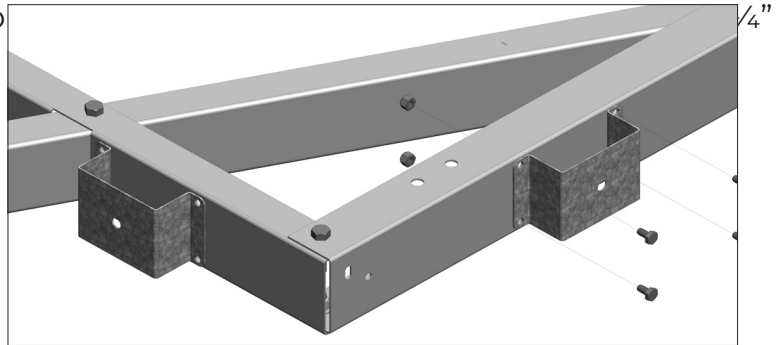
\* Ramp Mounting bracket are in the ramp box

### Install Stake Pockets & Ramp Mounting Bracket:

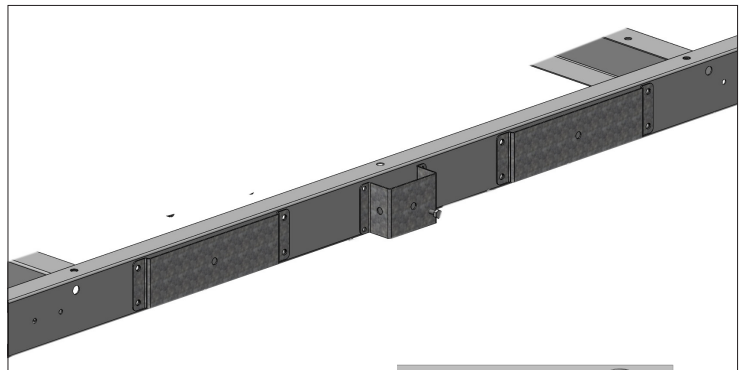
1. Take all the channel with the pre-drilled stake pocket holes.
2. Align each stake pocket to the pre-drilled holes and secure them using 1/4" x 3/4" hex bolts and 1/4" lock nut
3. Tighten the nuts with a 7/16" deep socket.

**Models with Rear Ramp Gate:** If your model includes a **rear gate**. On the back channel, instead of installing two stake pockets, install one in the center, then align the ramp mounting brackets to the pre-drilled holes and secure them with 1/4" lock nuts with a 7/16" deep socket.

**Stake Pockets**



**Ramp Plates**  
Only applicate with  
**Rear Ramp Gate**



### Installed Grommets

1. Take the cross-channel(s) and install the electrical grommets on both ends. (Do not install the grommet on the tongue channel at this point)



## **Step 2. Frame Assembly**

As you build the frame for your 4x4, 4x6, 4x8, or 5x8 model, make sure to follow the instructions and diagram that match your specific size. Each frame size has its own section. If your model does not include a plank floor but you plan to install a plywood floor, follow the instructions for "no plank floor." Pay careful attention to the prompt in your instructions to ensure you're following the correct steps for your model.

### **Step 2a - 4 x 4 - Frame Assembly**

#### **Layout the frame as shown in Figure 2a.**

1. Position the front channel, the one with two vertical slots, at the front.
2. Place the side channels on each side, with square holes facing down, ensuring the marker light holes face the front as shown on Figure 2a.
3. Position the rear channel at the back, with the three holes facing upward.
4. Lay the cross-channel in the center of the frame, with the opening facing the back

#### **Assemble the frame using the following hardware and steps below:**

- **Top:**  $\frac{3}{8}$  x 1- $\frac{1}{2}$ -inch hex flange bolts and nuts (Item#501049 & 501031)
- **Bottom:**  $\frac{3}{8}$  x  $\frac{3}{4}$ -inch hex bolts and nuts (Item#501033 & 501031)

**IMPORTANT:** Only hand-tighten the hardware during the frame assembly or until you have completed the tongue assembly portion. If you fully tighten the hardware at this step, you will need to go back and loosen before installing the tongue.

1. At the front corner, overlap the passenger side channel over the front channel (as shown in Figure 2a) and hand-tighten at the bottom only **Note:** You will secure the top when installing the plank floor. If you're not installing a plank floor, hand-tighten the top as well.
2. Take a cross channel and insert it into passenger side channel as shown in Figure 2a, then hand-tighten on top and at the bottom.
3. Slide the rear channel over the passenger and driver side channels and hand-tighten the bottom only. **Note:** You will secure the top when installing the plank floor. If you're not installing a plank floor, hand-tighten the top as well.
4. You can now secure the driver's side by repeating the same steps taken on the passenger side.

ITEM #	PARTS DESCRIPTION	QTY (PLANK FLOOR)	QTY
501049	3/8 X 3/4 HEX FLANGE BOLT	6	6
501033	3/8 X 1 1/2 HEX BOLT (FULL THREAD)	2	6
501031	3/8 FLANGE LOCK NUT	8	12
500254	FRONT CHANNEL	1	1
500255	4FT WIDE CROSS CHANNEL	1	1
500256	REAR CHANNEL	1	1
500251	4' DRIVER SIDE CHANNEL	1	1
500297	4' PASSENGER SIDE CHANNEL	1	1

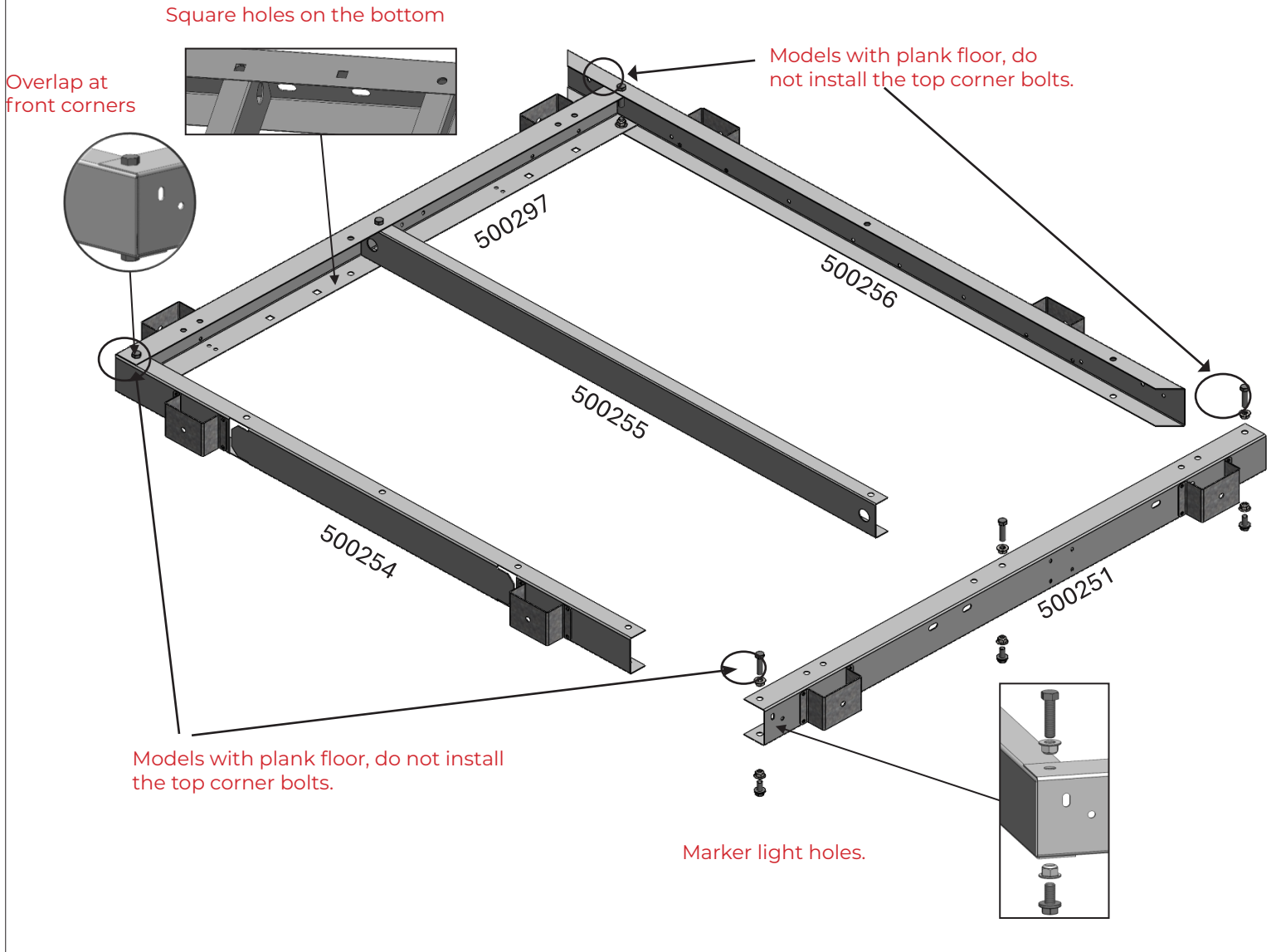


The edges of the trailer can be sharp. To prevent injury, wear the provided safety gloves.



For your security do not stand inside the frame during assembly.

Figure 2a



## Step 2b - 4 x 6 - Frame Assembly

### Layout the frame as shown in the Figure 2b.

1. Position the front channel, the one with two vertical slots, at the front.
2. Place the side channels on each side, with square holes facing down, ensuring the marker light holes face the front as shown on Figure 2b.
3. Position the rear channel at the back, with the three holes facing up.
4. Lay the two cross-channels in the center of the frame, with the opening facing back.

### Assemble the frame using the following hardware and steps below:

- **Top:**  $\frac{3}{8}$  x 1- $\frac{1}{2}$ -inch hex flange bolts and nuts (Item#501049 & 501031)
- **Bottom:**  $\frac{3}{8}$  x  $\frac{3}{4}$ -inch hex bolts and nuts (Item#501033 & 501031)

**Important Note:** Only hand-tighten the hardware during the frame assembly or until you have completed the tongue assembly portion. If you fully tighten the hardware at this step, you will need to go back and loosen before installing the tongue.

1. At the front corner, overlap the passenger side channel over the front channel (as shown in Figure 2b) and hand-tighten at the bottom only.  
**Note:** You will secure the top when installing the plank floor. If your not installing a plank floor, hand-tighten the top as well.
2. Align the first cross channel with the top pre-drilled hole as shown in Figure 2b. Hand-tighten the top only.  
**Note:** The bottom will be secured, when we install the axle.
3. Align the second cross channel with the top pre-drilled hole, as shown in Figure 2b. Hand-tighten on the top only.  
**Note:** The bottom will be secured, when we install the axle.
4. Slide the rear channel over the passenger and driver side channels and hand-tighten the bottom only.  
**Note:** You will secure the top when installing the plank floor. If you're not installing a plank floor, hand-tighten the top as well.
5. You can now secure the driver's side by repeating the same steps taken on the passenger side.

ITEM #	PARTS DESCRIPTION	QTY (PLANK FLOOR)	QTY
501049	3/8 X 3/4 HEX FLANGE BOLT	4	4
501033	3/8 X 1 1/2 HEX BOLT (FULL THREAD)	4	8
501031	3/8 FLANGE LOCK NUT	8	12
500254	FRONT CHANNEL	1	1
500255	4FT WIDE CROSS CHANNEL	2	2
500256	REAR CHANNEL	1	1
500252	6' DRIVER SIDE CHANNEL	1	1
500298	6' PASSENGER SIDE CHANNEL	1	1

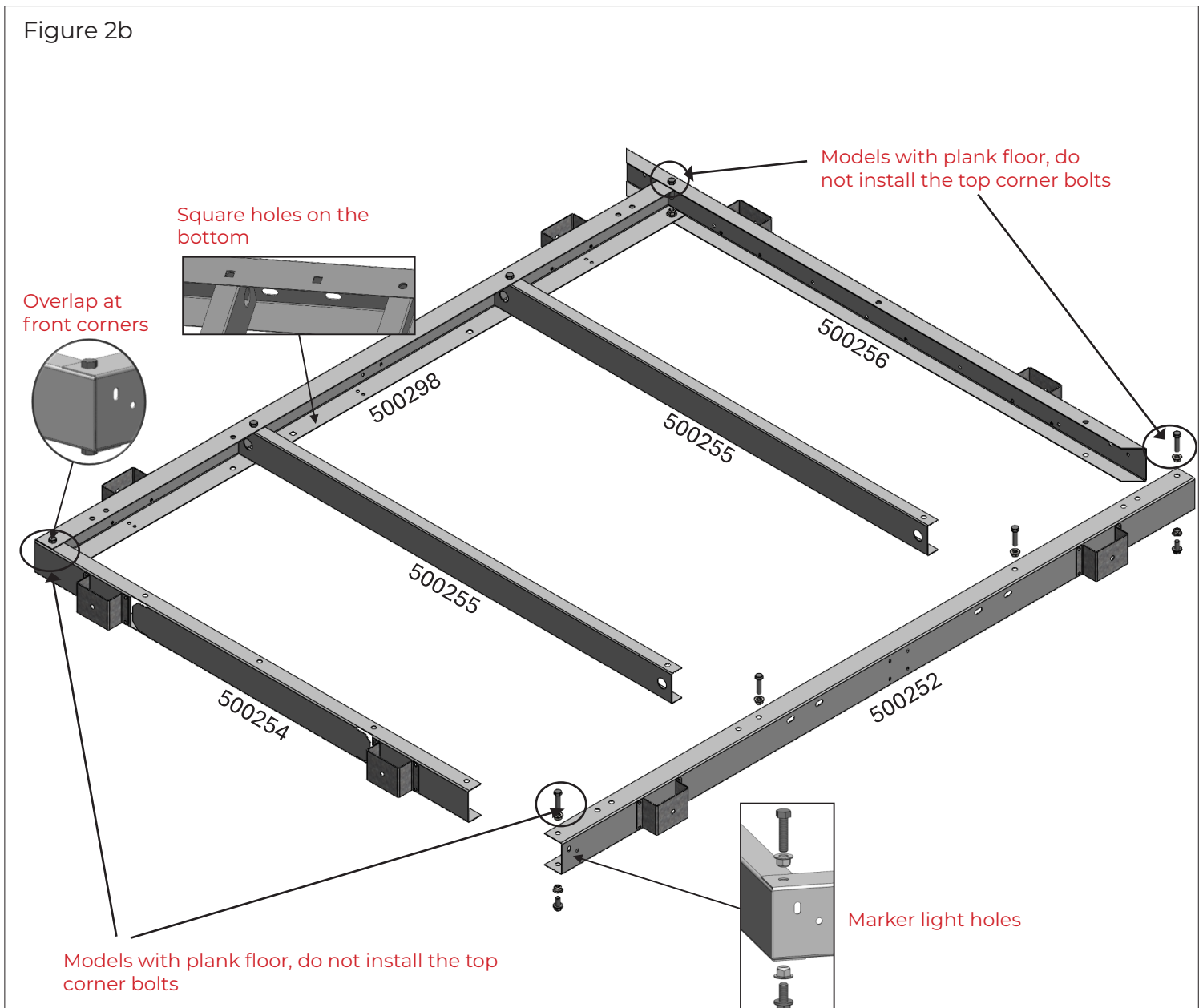


The edges of the trailer can be sharp. To prevent injury, wear the provided safety gloves.



For your security do not stand inside the frame during assembly.

Figure 2b



## Step 2c - 4 x 8 - Frame Assembly

### Layout the frame as shown in Figure 2c.

1. Position the front channel, the one with two vertical slots, at the front of the trailer.
2. Take the front and back passenger side channels. The side-channel with the marker-light holes is the front end of the trailer. Place them with the square holes facing down.
3. Do the same for the driver's side.
4. Take the short connection channels and place one on the outside of the frame on each side of the trailer.
5. Position the rear channel at the back, with the three holes facing upward.
6. Lay the six cross-channels in the center of the frame, with the opening facing the back.  
**Note:** If you are not installing a floor, you only need four cross-channels.

### Assemble the frame using the following hardware and steps below:

- **Top:**  $\frac{3}{8}$  x 1- $\frac{1}{2}$ -inch hex flange bolts and nuts (Item#501049 & 501031)
- **Bottom:**  $\frac{3}{8}$  x  $\frac{3}{4}$ -inch hex bolts and nuts (Item#501033 & 501031)

**Important Note:** Only hand-tighten the hardware during the frame assembly or until you have completed the tongue assembly portion. If you fully tighten the hardware at this step, you will need to go back and loosen before installing the tongue.

1. At the front corner, overlap the passenger side channel over the front channel (as shown in Figure 2c) and hand-tighten at the bottom only. **Note:** You will secure the top when installing the plank floor. If you're not installing a plank floor, hand-tighten the top as well.
2. Join the first cross-channel to the side of the passenger frame (as shown in Figure 2c), and hand-tighten at the top and bottom.
3. Slide the short connection channel over the two passenger side channels, aligning it to the pre-drilled holes at the bottom and only four holes will align on top.
4. Align the next cross-channel to the first hole of the short connection channel, and hand-tighten at the top only.  
**Note:** The bottom will be secured later during the axle installation.
- 5. IF YOU ARE NOT INSTALLING A PLANK FLOOR, SKIP THIS STEP.** Align two cross-channels back-to-back in the center of the connection channel, (as shown in Figure 2c), and hand-tighten at the top and bottom.
6. Place the next cross-channel into the last hole of the short connection channel and hand-tighten at the top only.  
**Note:** The bottom will be secured later during the axle installation.
7. Place the last cross-channel, facing the back, into the fourth last hole and hand-tighten at the top and bottom.
8. You can now secure the driver's side by repeating the same steps done on the passenger side
9. Slide the rear channel over the passenger and driver side channels and hand-tighten the bottom only **Note:** We will secure the top when installing the plank floor. If you're not installing a plank floor, hand-tighten the top as well.

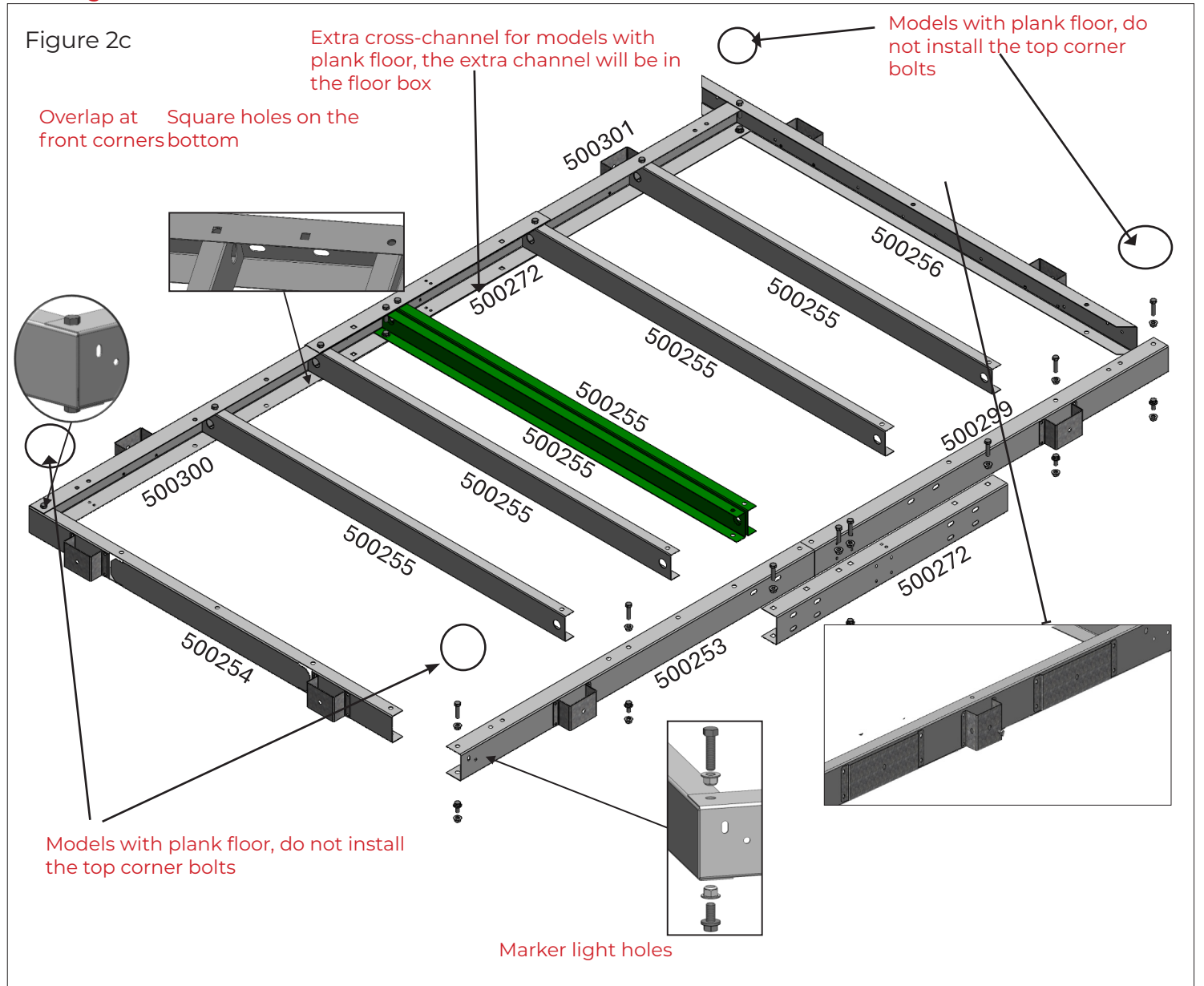
ITEM #	PARTS DESCRIPTION	QTY (PLANK FLOOR)	QTY
501049	3/8 X 3/4 HEX FLANGE BOLT	12	8
501033	3/8 X 1 1/2" HEX BOLT (FULL THREAD)	12	12
501031	3/8 NYLON INSERT HEX FLANGE Lock nut	24	20
500254	FRONT CHANNEL	1	1
500255	4FT CROSS CHANNEL	6	4
500256	REAR CHANNEL	1	1
500253	4' FRONT DRIVER SIDE CHANNEL	1	1
500272	CONNECTION CHANNEL	2	2
500299	4' REAR DRIVER SIDE CHANNEL	1	1
500300	4' FRONT PASSENGER SIDE CHANNEL	1	1
500301	4' REAR PASSENGER SIDE CHANNEL	1	1



The edges of the trailer can be sharp. To prevent injury, wear the provided safety gloves.



For your security do not stand inside the frame during assembly.



## Step 2d - 5 x 8 - Frame Assembly

### Layout the frame as shown in Figure 2d.

1. Position the front channel, the one with two vertical slots, at the front of the trailer.
2. Take the front and back passenger side channels. The side channel with the marker-light holes is the front end of the trailer. Place both with the square holes facing down
3. Do the same for the driver's side.
4. Take the short connecting channels and place one on the outside of the frame on each side of the trailer.
5. Position the rear channel at the back, with the three holes facing upward.
6. Lay the five cross-channels in the center of the frame, the first two cross-channels facing the front and the next three, with the opening facing the back.

### Assemble the frame using the following hardware and steps below:

- Top:  $\frac{3}{8}$  x 1- $\frac{1}{2}$ -inch hex flange bolts and nuts (Item#501049 & 501031)
- Bottom:  $\frac{3}{8}$  x  $\frac{3}{4}$ -inch hex bolts and nuts (Item#501033 & 501031)

**Important Note:** Only hand-tighten the hardware during the frame assembly or until you have completed the tongue assembly portion. If you tighten the hardware at this time you will need to go back and loosen to install the tongue.

1. At the front corner, overlap the passenger side channel over the front channel (as shown in Figure 2d) and hand-tighten at the bottom only.  
**Note:** You will secure the top when installing the plank floor. If you're not installing a plank floor, hand-tighten the top as well.
2. Slide the short connection channel over the two passenger side channels. Align it to the pre-drilled holes at the bottom and only four holes will align on the top.
3. Align the first cross-channel with the first hole of the connection channel, ensuring the opening faces forward. **DO NOT HAND-TIGHTEN it at this stage.**  
**Note:** The top will be secured when you install the tongue channels, and the bottom will be secured when you install the axle.
4. Place the next two cross-channels back to back into the next holes of the short connection channel, (as shown in Figure 2d), and hand-tighten at the top and bottom.
5. Place the fourth cross-channel into the last hole of the short connection channel and hand-tighten at the top only.  
**Note:** The bottom will be secured later during the axle installation.
6. Place the last cross-channel, facing the back, into the fourth last hole of the side channel, and hand-tighten at the top and bottom.
7. You can now secure the driver's side by repeating the same steps taken on the passenger side.
8. Slide the rear channel over the passenger and driver side channels and hand-tighten the bottom only. **Note:** You will secure the top when installing the plank floor. If your not installing a plank floor, hand-tighten the top as well.

ITEM #	PARTS DESCRIPTION	QTY (PLANK FLOOR)	QTY
501049	3/8 X 3/4" HEX FLANGE BOLT	12	12
501033	3/8 X 1 1/2" HEX BOLT (FULL THREAD)	8	12
501031	3/8 NYLON INSERT HEX FLANGE Lock nut	20	24
504599	FRONT CHANNEL	1	1
504602	5FT WIDE CROSS CHANNEL	5	5
504600	REAR CHANNEL	1	1
500253	4' FRONT DRIVER SIDE CHANNEL	1	1
500299	4' REAR DRIVER SIDE CHANNEL	1	1
500300	4' FRONT PASSENGER SIDE CHANNEL	1	1
500301	4' REAR PASSENGER SIDE CHANNEL	1	1
500272	CONNECTION CHANNEL	2	2

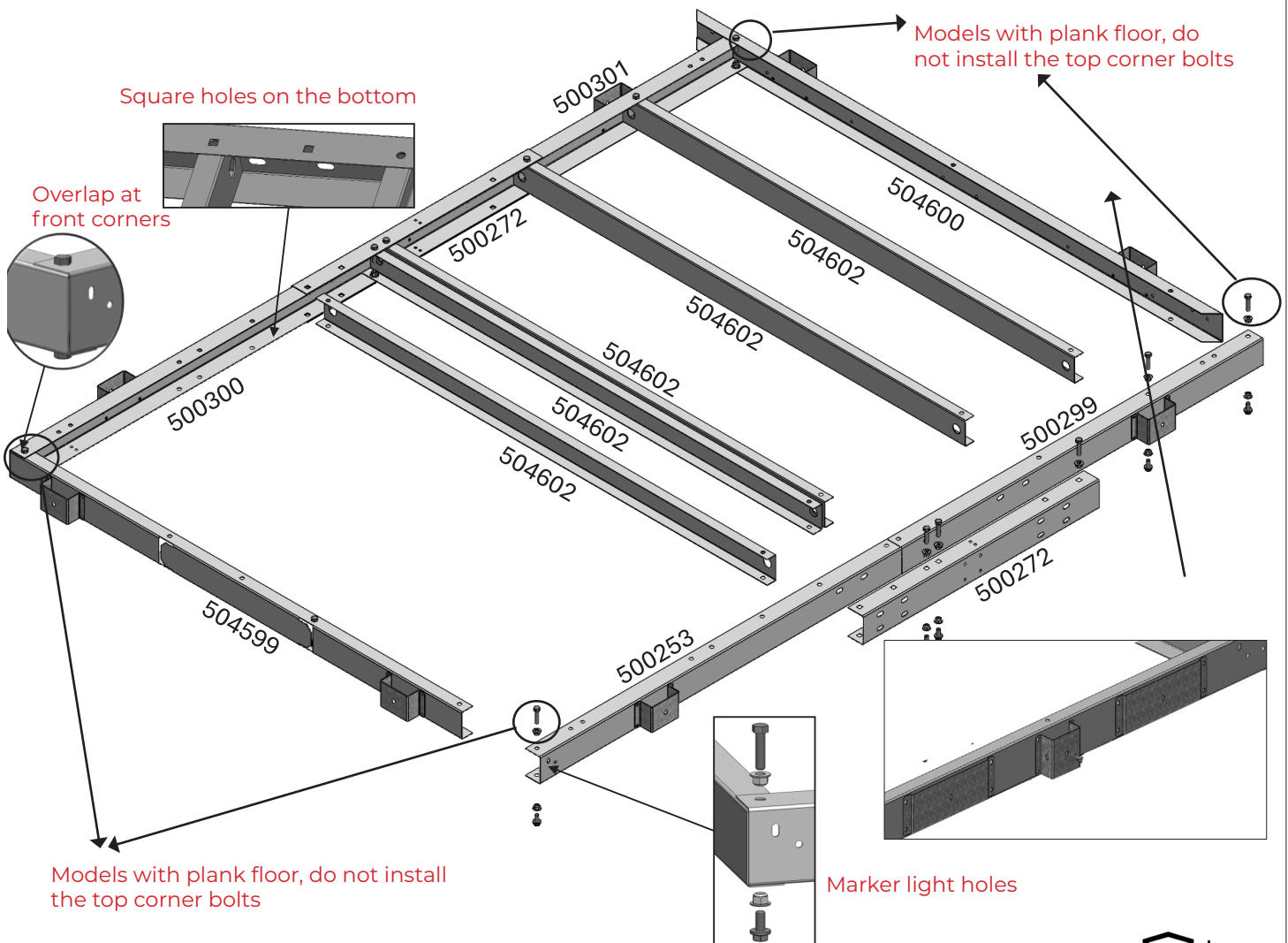


The edges of the trailer can be sharp. To prevent injury, wear the provided safety gloves.



For your security do not stand inside the frame during assembly.

Figure 2d



### Step 3 - Tongue Assembly

ITEM #	DESCRIPTION	4 FT	5 FT
500257	TONGUE CHANNEL FOR 4 FT TRAILER	2	
504601	TONGUE CHANNEL FOR 5 FT TRAILER		2
504623	TONGUE CROSS CHANNEL		1
501049	$\frac{3}{8}$ X $\frac{3}{4}$ " HEX FLANGE BOLT	4	4
501033	$\frac{3}{8}$ X 1 $\frac{1}{2}$ " HEX BOLT (FULL THREAD) (** Varies if installing plank floor)	2 or 4	4 or 6
501031	$\frac{3}{8}$ NYLON INSERT HEX FLANGE LOCK NUT (** Varies if installing plank floor)	6 or 8	8 or 10
501171	ELECTRICAL WIRE GROMMET	4	4

**Note:** If the holes don't line up, it's likely because the bolts are tightened, and the frame is out of square. Loosen the bolts and adjust the frame until everything lines up properly.

#### Position the Tongue Channels & Grommet Installation:

1. Take the two tongue channels and slide each one through a vertical slot on the front channel.
2. Install the electrical grommets onto both tongue channels. Note: The front grommets are a tight fit.

#### Secure the 4x4, 4x6 and 4x8 Tongue Channels to the Frame:

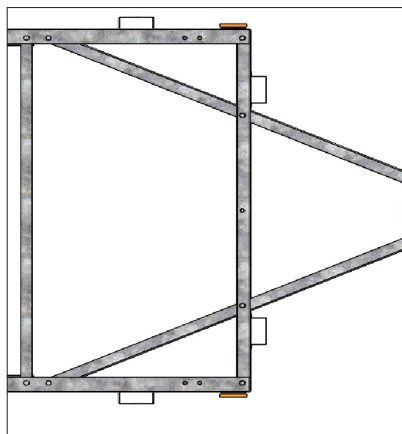
1. Hand-tighten tongue channels to the side channel, at the pre-drilled hole in front of the first cross-channel, using  $\frac{3}{8}$  x 1  $\frac{1}{2}$  bolts and  $\frac{3}{8}$  lock nuts at the top, and  $\frac{3}{8}$  x  $\frac{3}{4}$  bolts and  $\frac{3}{8}$  lock nuts at the bottom.
2. Hand-tighten the tongue channels to the front channel at the bottom only, using the  $\frac{3}{8}$  x  $\frac{3}{4}$  bolts and nuts. **Note:** You'll secure the top once the floor is installed. If you're not installing a floor, you can also hand-tighten the top with the  $\frac{3}{8}$  x 1  $\frac{1}{2}$  bolts and lock nuts.

#### Secure the 5x8 Tongue channel to the frame:

1. Align the tongue channels and the first cross-channel with the first hole of the connection channel, ensuring the opening of the cross-channel faces forward. Hand-tighten all three channels at the top using  $\frac{3}{8}$  x 1  $\frac{1}{2}$  bolts and lock nuts. **Note:** The bottom will be secured once the axle is installed.
2. Hand-tighten the tongue channels to the front channel at the bottom only, using  $\frac{3}{8}$  x  $\frac{3}{4}$  bolts and nuts. **Note:** The top will be secured once the floor is installed. If you're not installing a floor, you can also hand-tighten the top using  $\frac{3}{8}$  x 1  $\frac{1}{2}$  bolts and lock nuts.
3. Place the shorter tongue cross-channel between the two tongue channels. Secure it at the top using  $\frac{3}{8}$  x 1  $\frac{1}{2}$  bolts and  $\frac{3}{8}$  lock nuts, and at the bottom using  $\frac{3}{8}$  x  $\frac{3}{4}$  bolts and  $\frac{3}{8}$  lock nuts.

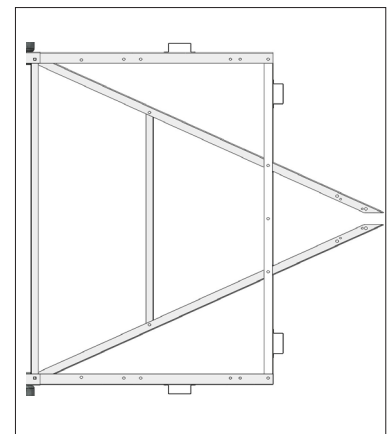
#### 4ft wide trailers

The tongue channels are secured at the fourth holes of each side channels.



#### 5ft wide trailers

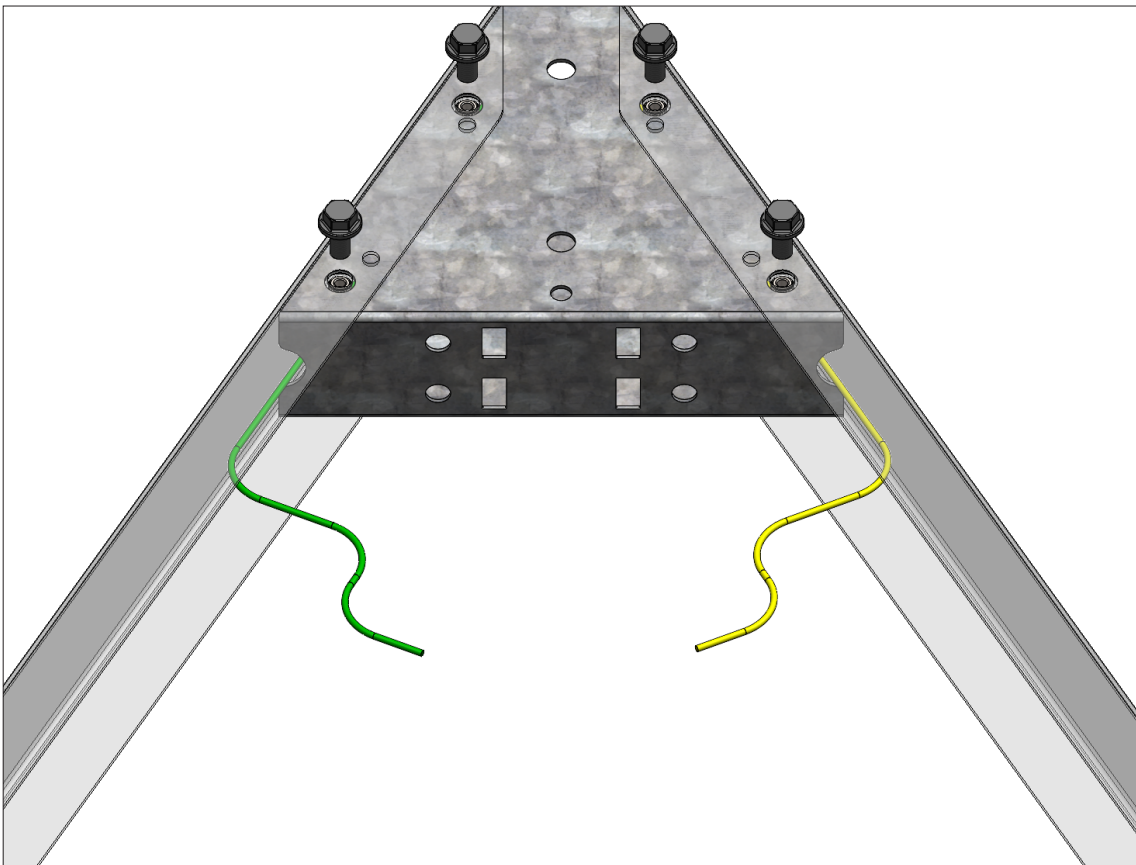
The tongue channels are secured at the fifth hole of each side channel, with a short connection channel and the first cross-channel.



## Step 4 - Tongue Connection Support Installation

ITEM #	DESCRIPTION	4 FT
504162	V-CONNECTION BRACKET	1
501049	$\frac{3}{8}$ X $\frac{3}{4}$ " HEX FLANGE BOLT	4
500512	4 WAY FLAT 20' WIRE HARNESS	1

1. Position the tongue connection bracket with the threaded holes facing up, but don't slide it fully into place.
2. Separate the wires from the harness and feed them through, starting from the tongue channel to the corner of the frame (refer to the diagram below)
  - Yellow and brown wire on the driver's side
  - Green and brown wire on the passenger's side
  - Do not pull the white wire through, you will secure it to the coupler channel later.
3. Take the V-connection bracket and slide it into position by inserting it into the opposite channel, making sure the wires are not pinched. Once the bracket aligns with the pre-drilled holes, secure it using  $\frac{3}{8}$ " x  $\frac{3}{4}$ " flange bolts and a  $\frac{9}{16}$  socket.
4. Tighten all bolts of the trailer frame using a  $\frac{9}{16}$  socket and wrench.  
**Note:** If you are installing a plank floor, you should not have any top bolts on the front and back channels of the trailer, only at the bottom. The top bolts will be installed when we secure the floor to the frame.

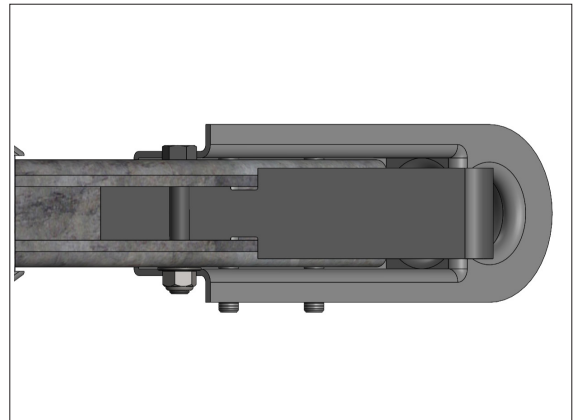


## Step 5 - Coupler, Hitch and Safety Chains

ITEM #	DESCRIPTION	ALL
504163	LONG COUPLER CHANNEL	1
504198	TONGUE SUPPORT FOOT - CHANNEL TONGUE	1
500805	1 7/8 COUPLER CLASS I	1
500804	SAFETY CHAIN - 3/16 X 4' (CLASS I)	1
501031	3/8 NYLON INSERT LOCKING NUT	3
501023	3/8 X 2-1/2" HEX BOLT	1
501024	3/8 X 3" HEX BOLT	2
501060	1/2 X 3 1/2" HEX BOLT	2
501056	1/2 NYLON INSERT LOCKING NUT	2

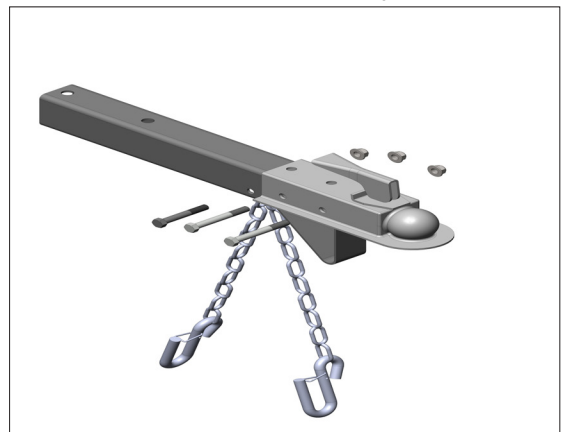
### Install the Safety Chain to the Coupler:

1. Place the long coupler channel with the opening facing up.
2. Take the safety chain and find the center link.
3. Insert the 3/8 x 2-1/2 bolt through the third hole of the coupler channel and center link of the chain, and hand-tighten with 3/8 lock nut.



### Install the Coupler to the Channel:

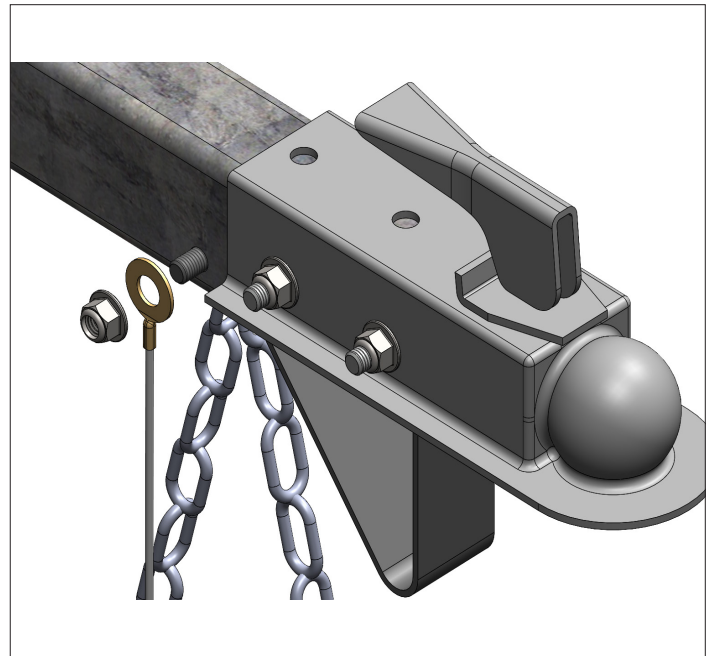
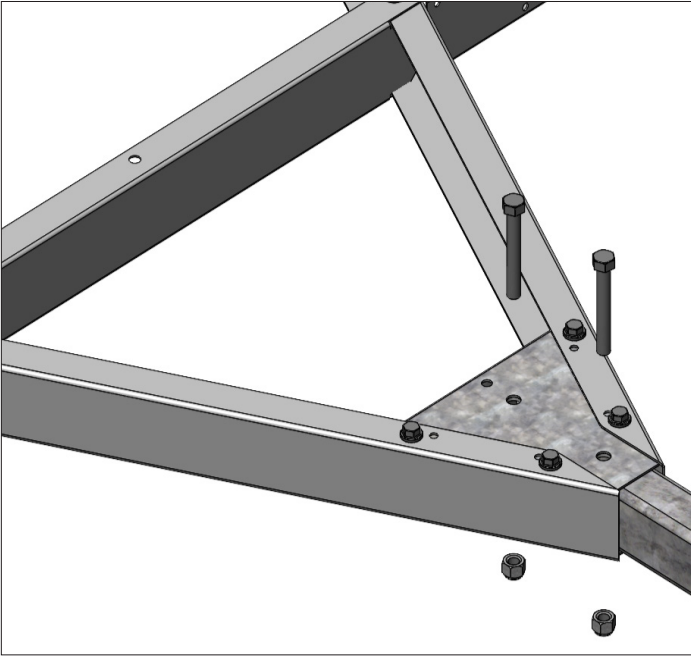
1. Put the coupler on the channel and secure it with 3/8 x 3 bolts and 3/8 lock nuts using a 9/16 socket and wrench, ensuring the tongue foot doesn't move but the coupler spring releases.
2. Pull the excess wire through the connection bracket, all the way through the back channel, leaving enough wire at the front to connect the white wire to the coupler.



### Secure the Assembled Coupler Channel to the Frame:

1. Slide the assembled coupler channel into the tongue connection, avoiding pinched wiring. Align the holes and secure with  $\frac{1}{2}$  x  $3\frac{1}{2}$  bolts and  $\frac{1}{2}$  lock nuts, tightening with a  $\frac{3}{4}$  socket and wrench.
2. Remove the  $\frac{3}{8}$  lock nut from the chain bolt. Place ring terminal of the ground white wire on the bolt and secure holding the  $\frac{9}{16}$  wrench on the nut and  $\frac{9}{16}$  socket on the bolt head.

**Do not over tighten as you may damage the ring terminal.**



## Step 6 - Floor Assembly Instructions

As you assemble the floor for your model size, follow the instructions and diagrams corresponding to your specific size. For the 4x4 & 4x6, refer to 6a, and for the 4x8 & 5x8, refer to 6b.

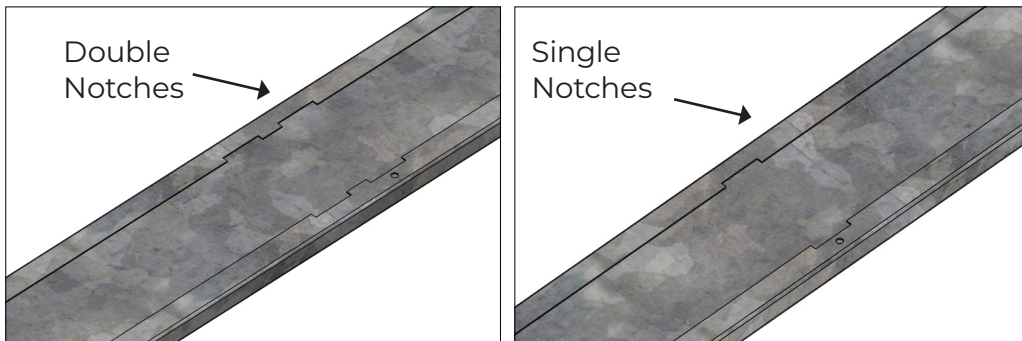
### Step 6a - Floor Assembly Instructions for 4ft & 6ft plank floors

ITEM#	ITEM DESCRIPTION	4' X 4'	4' X 6'
504736	4FT U CHANNEL FOR FLOOR PLANK	2	2
504738	4FT GALVALUME FLOOR PLANK	9	
504739	6FT GALVALUME FLOOR PLANK		9
501181	#10 X 3/4 IN PAN HEAD SCREW ZINC	36	36
501031	3/8 NYLON INSERT LOCKING NUT	7	7
501049	3/8 X 3/4" HEX FLANGE BOLT	7	7

**NOTE:** All your hardware for floor assembly and installation is in your floor box. With the help of another person, move the frame out of the way to begin the installation of the floor. The floor should be assembled where you will complete the assembly of the trailer.

#### Layout the planks.:

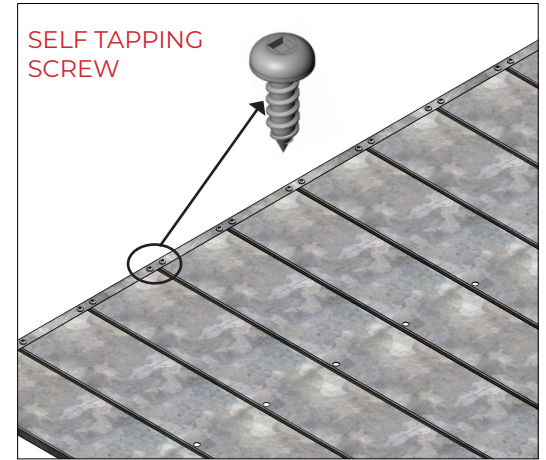
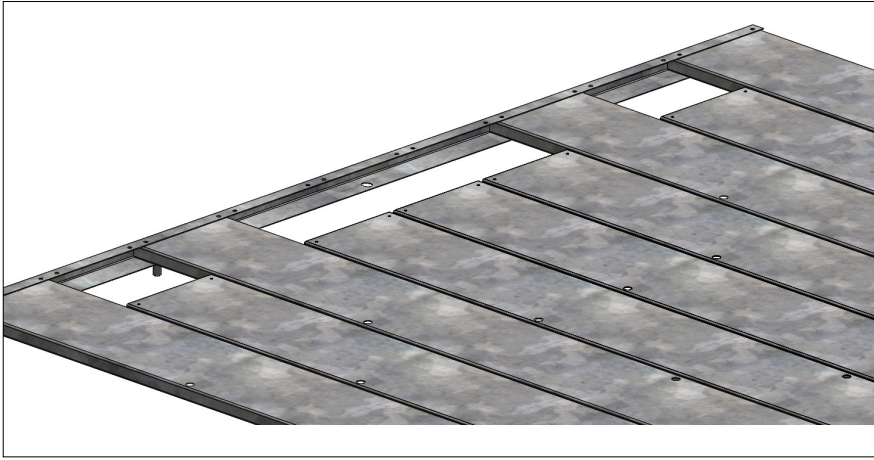
1. Lay out the 9 floor planks side by side on the ground, ensuring the double notches underneath each plank are aligned at the front.
2. Place a u-channel at the front and back end of the floor.



#### Front of the floor:

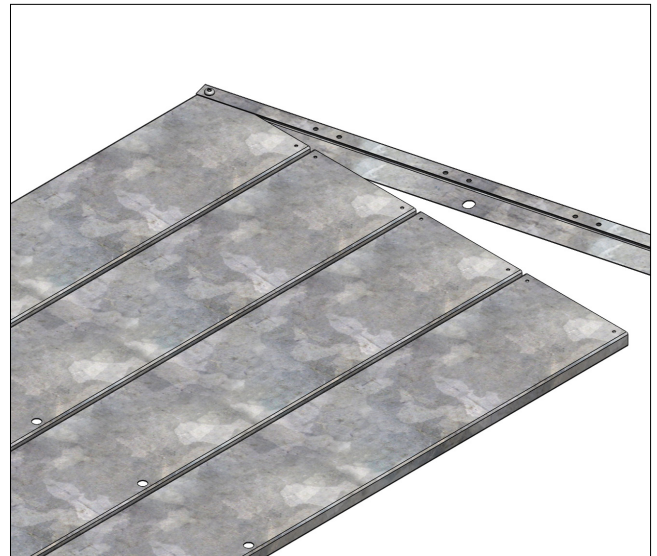
1. Take the U-channel and insert a 3/8 x 3/4 bolts in each of the four pre-drilled holes, skipping the middle hole. Hand-tighten the bolts with 3/8 nuts to hold them in place until you install the floor on the trailer.
2. To position the planks inside the channel, you will need to start with four planks only. Starting with the first, locate the first bolt and slide the plank around it until it's in place. Then do the same with the remaining 3 planks.
3. Slide the remaining 5 planks in the u-channel until all are aligned.
4. Secure the planks to the U-channel using self-tapping screws.





### Back of the floor:

1. Take the second u-channel and insert  $\frac{3}{8} \times \frac{3}{4}$  flange bolts in the two outer holes and the middle hole, then hand-tighten the bolts with  $\frac{3}{8}$  nuts.
2. Place U-channel at the back edge of the planks on the ground and secure one corner of the U-channel with a self-tapping screw to allow it to pivot for easier alignment.
3. Place each plank at the very edge of the U-channel.
4. Once all planks are slightly inserted, slide them fully into the U-channel and fasten them securely with self-tapping screws.
5. Flip the floor over and place it where you plan to complete the assembly.



## Step 6B - Floor Assembly Instructions for 8ft plank floors

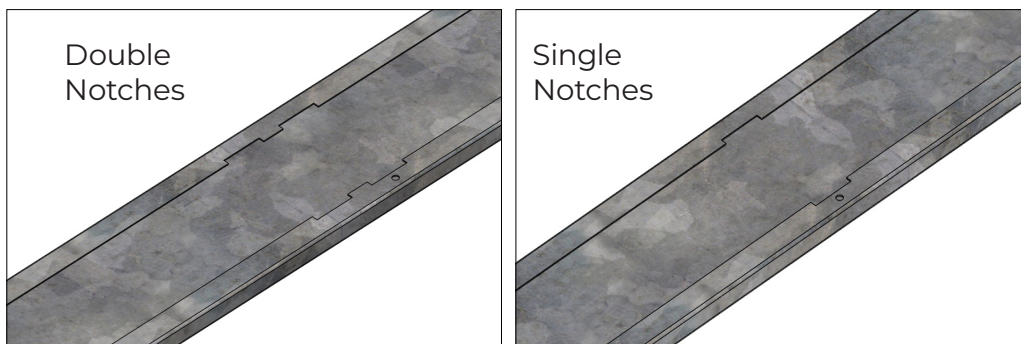
ITEM#	ITEM DESCRIPTION	4' x 8'	5' x 8'
501031	3/8 NYLON INSERT LOCKING NUT	7	7
501049	3/8 X 3/4" HEX FLANGE BOLT	7	7
501181	#10 X 3/4 IN PAN HEAD SCREW ZINC	36	44
504736	4FT U CHANNEL FOR FLOOR PLANK	2	
504737	5FT U CHANNEL FOR FLOOR PLANK		2
504740	8FT GALVALUME FRONT FLOOR PLANK	9	11
504741	8FT GALVALUME REAR FLOOR PLANK	9	11

**NOTE:** All your hardware for floor assembly and installation is in your floor box. With the help of another person, move the frame out of the way to begin the installation of the floor. The floor should be assembled where you

will complete the assembly of the trailer.

### Layout the planks:

1. Separate the floor planks into two types: those with double notches underneath and the one with a single notch.
2. Place the planks with double notches at the front of the trailer, ensuring the notches are all lined up towards the front of the trailer.
3. Position the plank with a single notch at the back of the trailer, aligning it in the same direction as the front planks.
4. Place a u-channel at the front and back end of the floor.



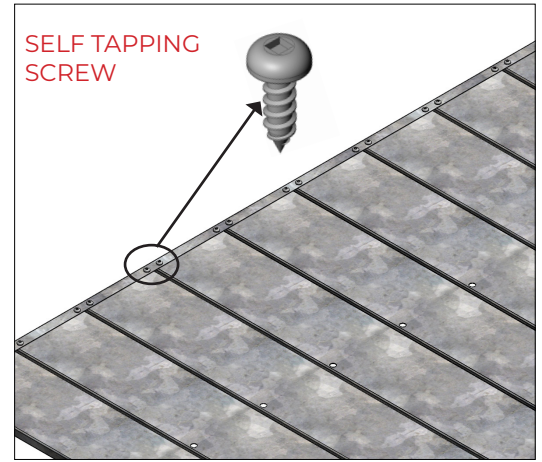
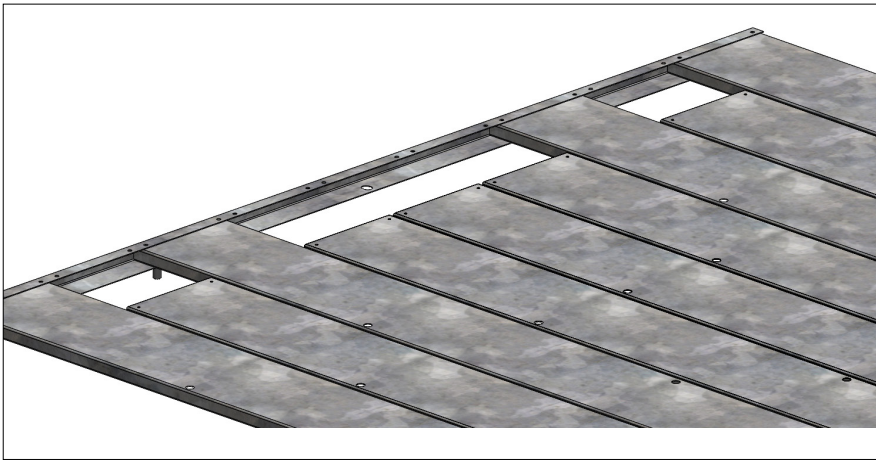
### Front of the floor:

1. Take the U-channel at the front and insert a 3/8 x 3/4 bolts facing down in each of the four pre-drilled holes, skipping the middle hole facing down.
2. Hand-tighten the bolts with 3/8 nuts to hold them in place until you install the floor on the trailer.

**Note:** These are the bolts that will attach the frame.

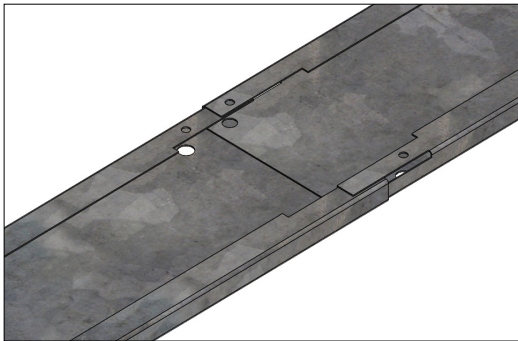
3. To position the planks inside the channel, you will need to start with four planks only. Starting with first, locate the first bolt and slide the plank around it until it's in place. Then do the same with the remaining 3 planks.
4. Slide the remaining 5 planks in the u-channel until all are aligned.
5. Secure the planks to the U-channel using self-tapping screws.





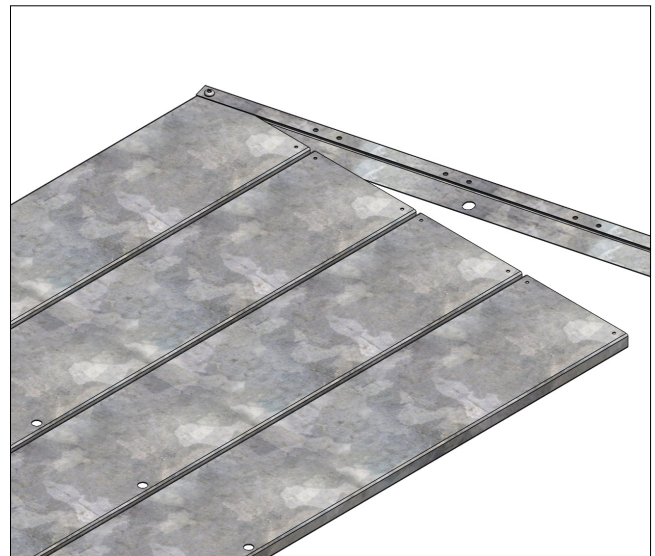
### Secure the front planks to the back planks:

1. Slide each back plank into the front plank using the side cutout, ensuring the back plank overlaps properly. Making sure that the holes line up perfectly and do not overlap. No cut edges should be visible. (see figure below)



### Back of the floor:

1. Take the second u-channel at the back of the trailer and insert  $\frac{3}{8} \times \frac{3}{4}$  bolts in the two outer holes and the middle hole, then hand-tighten the bolts with  $\frac{3}{8}$  nuts.
2. Place the U-channel at the back edge of the planks on the ground and secure one corner of the U-channel with a self-tapping screw to allow it to pivot for easier alignment.
3. Place each plank at the very edge of the U-channel.
4. Once all planks are slightly inserted, slide them fully into the U-channel and fasten them securely with self-tapping screws.

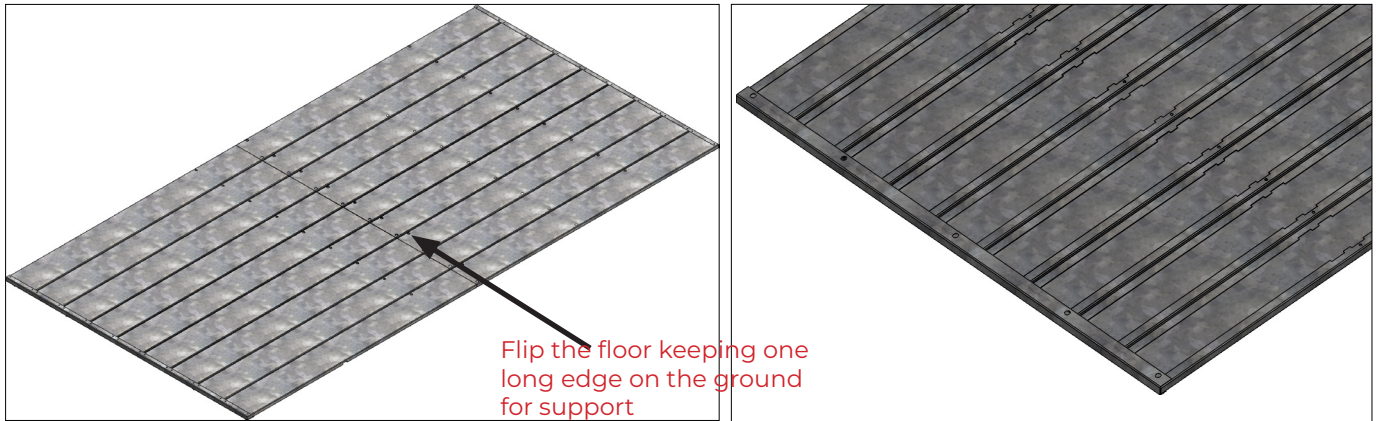


## Step 6c - Secure Floor and V-Connection Bracket

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501100	5/16 UNC X 1/2" CUTTING SCREW	4	4	4	4

### Secure the floor:

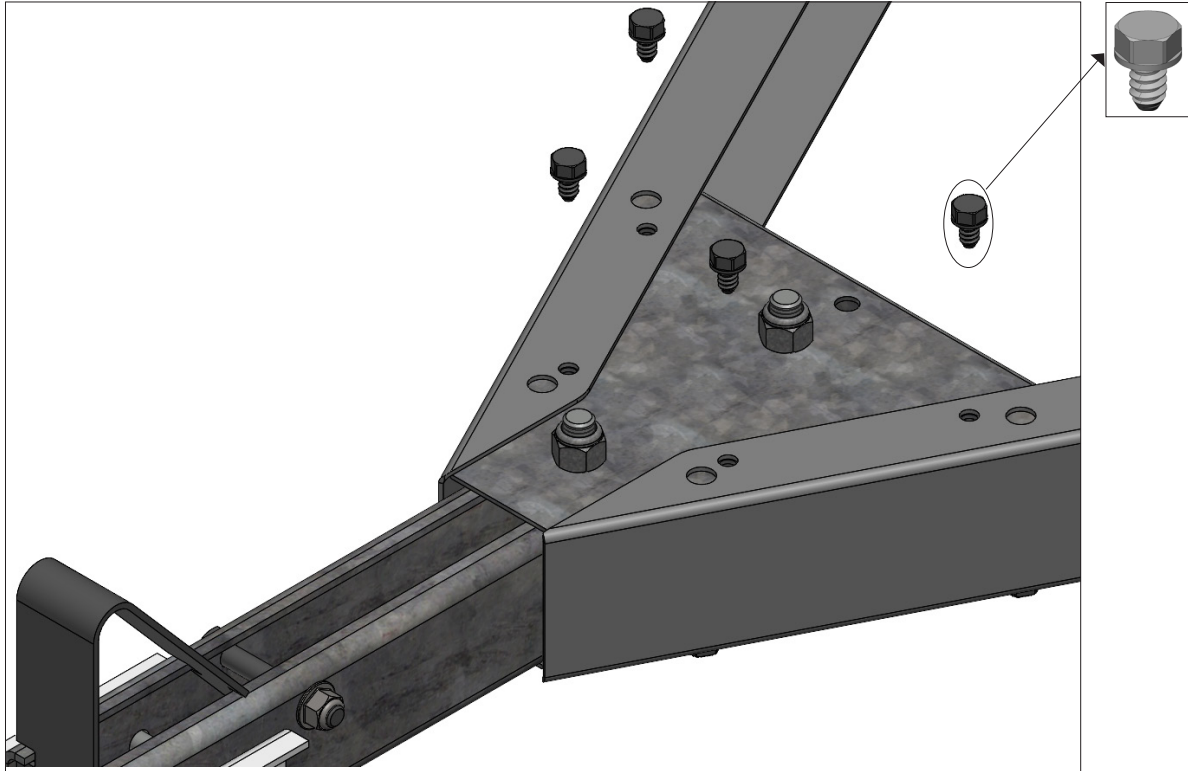
1. Flip the floor and place it in the area where you will be finishing the assembly.
2. Remove the 7 nuts from the front and back u-channels.
3. Using a punch, ensure the 4 holes on the front channel and the 3 holes on the back channel are completely aligned.
4. Set the frame upside-down on top of the floor lining up front 4 holes and the back 3 holes.
5. Place all nuts on the 7 floor bolts and secure the floor to the frame with 3/8 lock nuts.  
**Note:** If you are assembling a 4x8 and 5x8 floor, make a snug fit, as you may need to go back once installed to ensure the floor is squared to the trailer frame.



**Secure the V-Connection:**

1. Secure the tongue V-connection to the four pre-drilled holes of the tongue channel using the cutting screws using a ½ socket.

**Note:** If not already done, secure all remaining bolts of the frame.

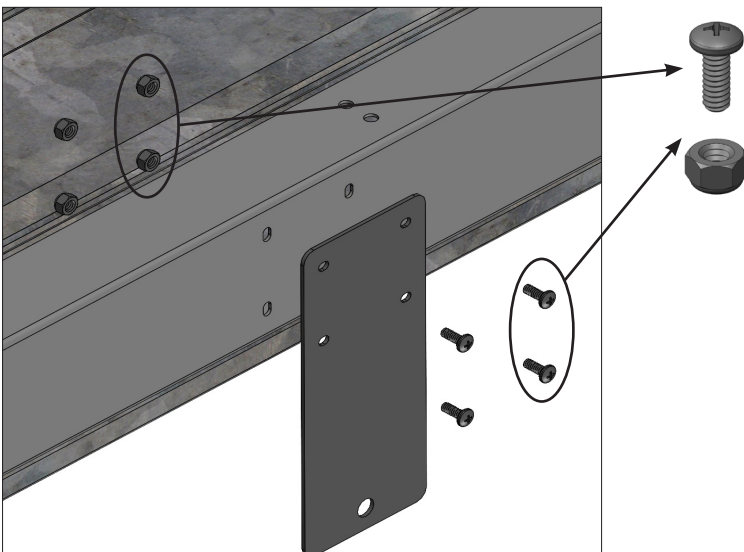
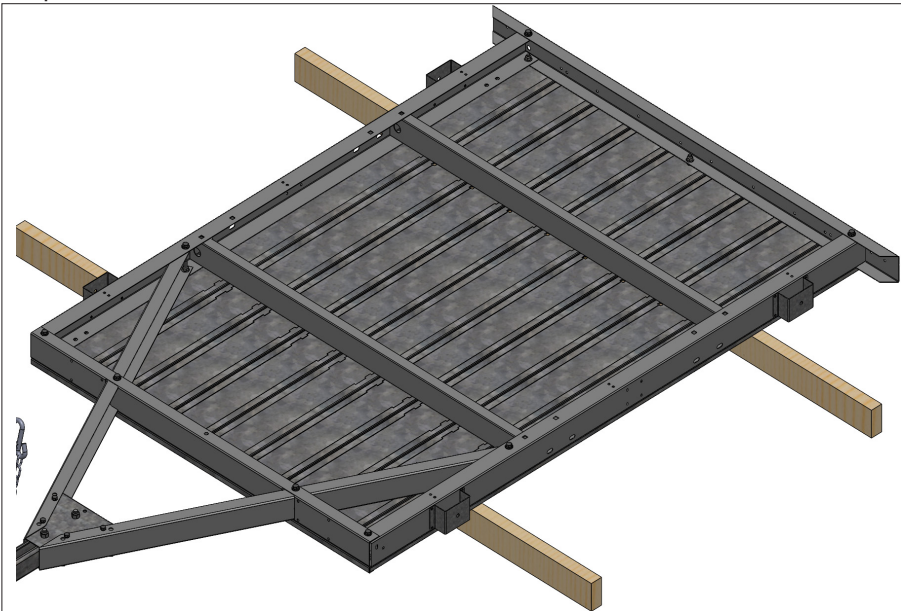


## Step 7a - Fender Support Plate Installation

ITEM #	DESCRIPTION	QTY
501091	#10 X ½" PHILLIPS #2 MACHINE SCREW	8
501092	#10 LOCKING NUT	8
504447	FENDER PLATE - if equipped with 8" wheels	2
504476	FENDER PLATE - if equipped with 12" Wheels	2

**Note:** If you're working on the ground, elevate the trailer 4-5 inches to provide sufficient clearance for the fender plate installation. If you're not installing a plank floor, no elevation is needed; you will have access to install the fender plate after flipping the trailer and can do so when you're ready to install the fenders.

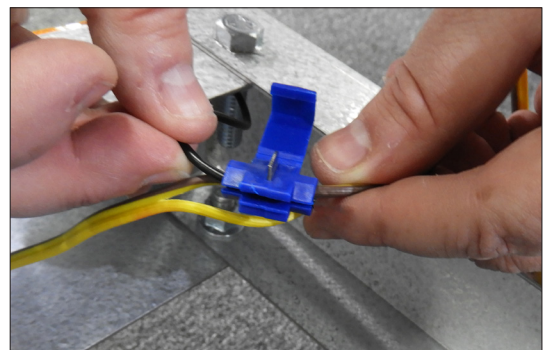
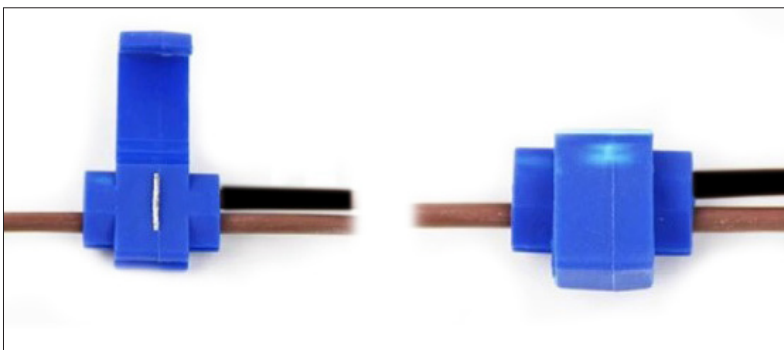
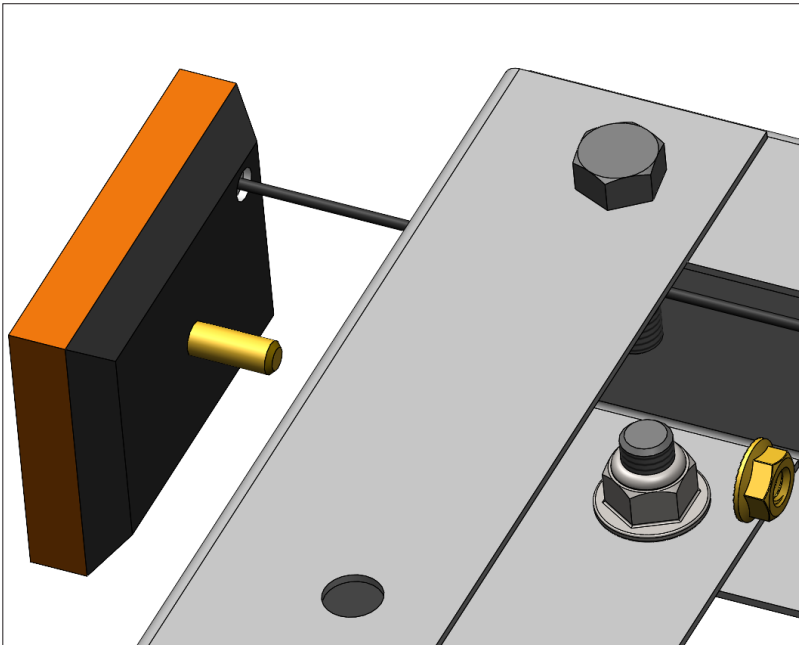
1. Line up the fender support plate with the frame.
2. Secure it in place with machine screws #10 and #10 lock nuts, using a  $\frac{3}{8}$  socket and a Phillips screwdriver. If the holes are not perfectly aligned use a punch to align them.
3. Repeat on the other side.



## Step 7b - Marker Light Installation

ITEM #	DESCRIPTION	QTY
503079	8" CABLE TIE	6
500558	WIRE CONNECTOR	2
500515	AMBER MARKER LIGHT	2

1. Take one amber marker light and remove the nut at the back.
2. Place one of the lights in the pre-drilled holes and secure it to the frame. Secure using a 10mm socket.
3. Starting on the driver's side, carefully separate the yellow and green wires near the marker light using a knife. Be careful not to expose any wiring.
4. Push the brown wire into the channel of the blue wire connector.
5. Slide the marker light wire into the connector's opening, ensuring no wire sticks out.
6. Use pliers to squeeze the metal blade of the connector until it's tight. Check that the blade is fully in place and close the cover.
7. Repeat steps on the other side.
8. Using the zip-ties, secure the wiring in the frame.



## Step 8a – Mount Axle Bracket to Frame

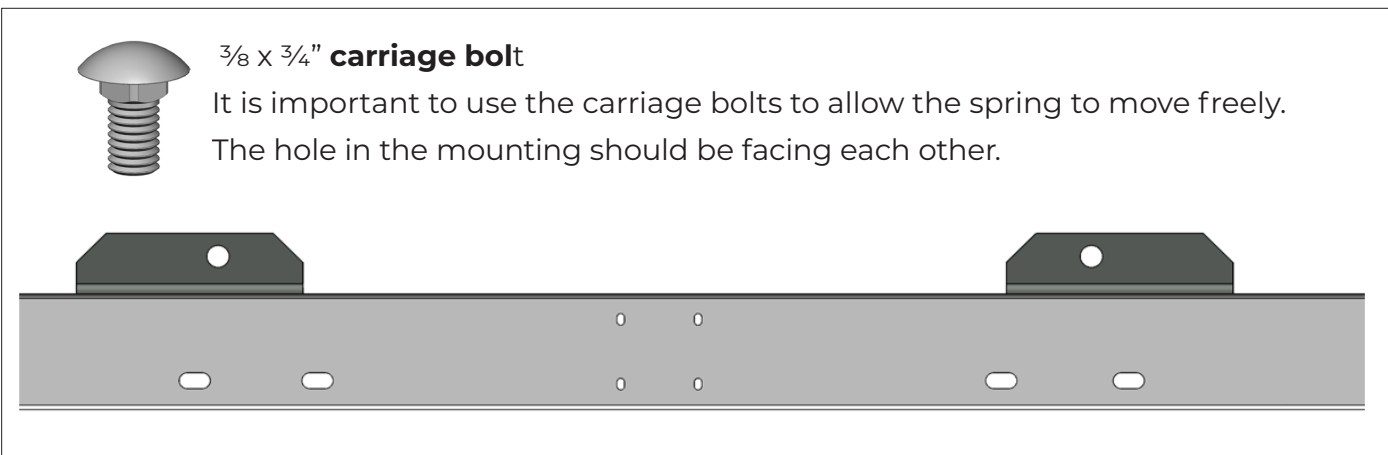
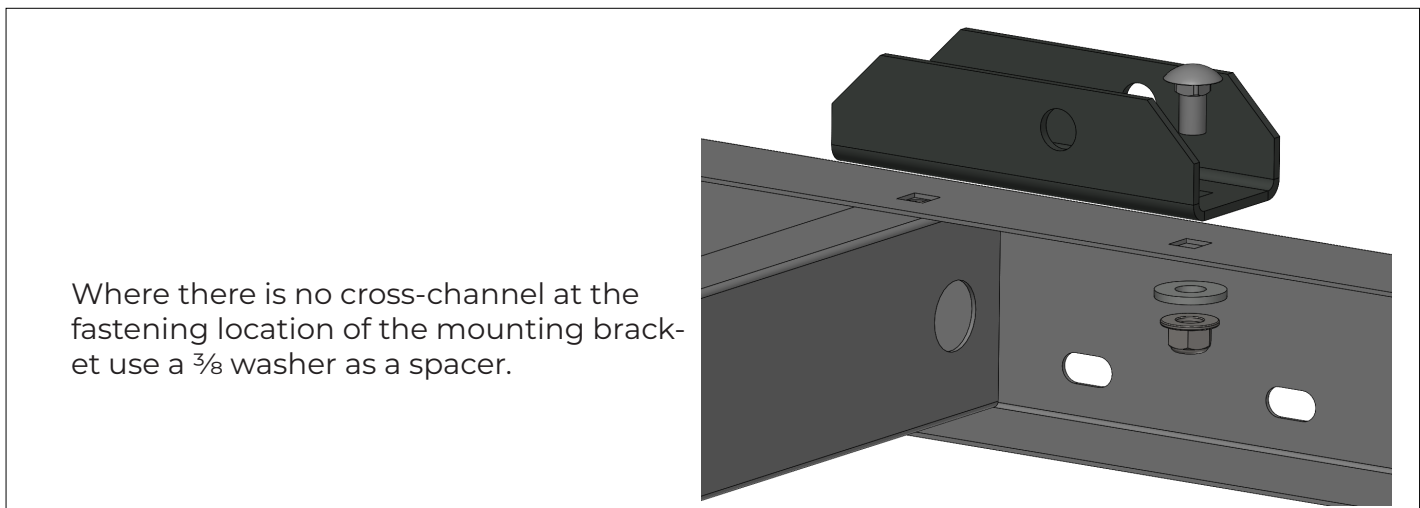
ITEM #	DESCRIPTION	4X4	4X6, 4X8 & 5X8
500259	LEAF SPRING MOUNTING BRACKET	4	4
501031	$\frac{3}{8}$ -16 NYLON INSERT HEX FLANGE LOCK NUT	8	8
501036	$\frac{3}{8}$ X $\frac{3}{4}$ " CARRIAGE BOLT	8	8
501032	$\frac{3}{8}$ " FLAT WASHER	8	6

### Secure the Leaf Spring Mounting Brackets:

**Important Note:** All bolts should be tight before proceeding with the axle assembly.

1. Place the leaf spring mounting brackets to the square holes on each side of the frame, making sure the round holes of the brackets are oriented closest to the center.
2. Secure with a  $\frac{3}{8}$  x  $\frac{3}{4}$ " carriage bolt and a  $\frac{3}{8}$  lock nut using a  $\frac{9}{16}$ " socket. If there's no cross-channel where you're mounting the bracket, use a washer as a spacer.

**Note:** It is important to use the carriage bolts to allow the spring to move freely.

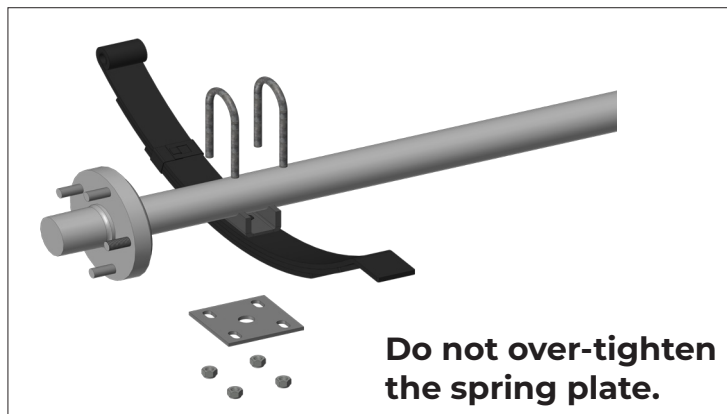


## Step 8b – Assemble & Mount the Axle

ITEM #	DESCRIPTION	4X4, 4X6 & 4X8	5X8
500047	4' STRAIGHT AXLE	1	
504617	5' STRAIGHT AXLE		1
500809	750 LB. SPRINGS	2	2
500260	LEAF SPRING AXLE MOUNT PLATE	2	2
500814	3/8-16 U-BOLT	4	4
501031	3/8-16 NYLON INSERT HEX FLANGE LOCK NUT	8	8
501065	9/16-18 UNF X 3" HEX BOLT	4	4
501066	9/16-18 UNF NYLON INSERT LOCKING NUT	4	4

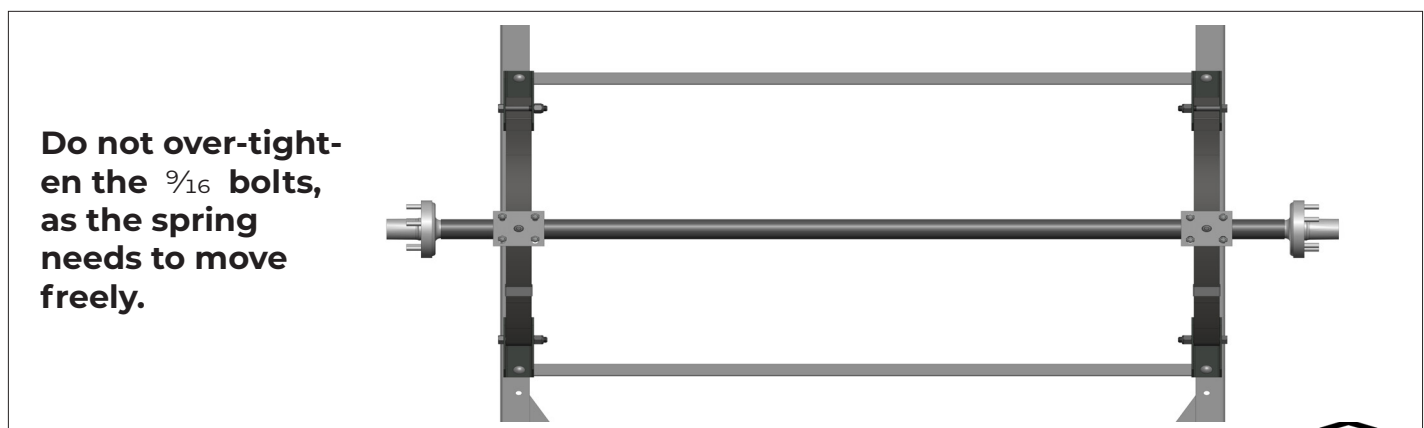
### Assemble the Axle:

1. Lay your axle down, ensuring the welded u-brackets are facing up.
2. Place one spring on top of the axle, ensuring the bolt lines up with the center hole of the U-brackets and that both springs face the same direction.
3. Place two U-bolts around the axle at both sides of the spring.
4. Take a mounting plate and place it on top of the u-bolts with the oval holes facing front to back
5. Secure but do not tighten it with 3/8 lock nuts and repeat to the other side.



### Mount the Axle to the Frame:

1. Lay the axle with springs into the mounting brackets, ensuring the spring's eye is toward the front and the flat side towards the back.
2. Secure each spring with 9/16 hex bolts and nuts using a 7/8 socket and wrench at the front and back of the spring.
3. Do not overtighten; you want the springs to be able to move a bit.
4. Tighten all the U-bolts securely.



## Step 9 – Screw down floor, Fender & wheel installation

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501177	#10 X 3/4 IN SELF-DRILLING PAN HEAD SCREW	18	18	45	55

### Flip the trailer

**Caution:** When flipping the frame, make sure to get help from at least one other person and follow all safety guidelines. The trailer will be very heavy at this stage. If you are assembling a 8ft trailer we highly recommend having more than 2 people move the trailer as it is very heavy at this point.

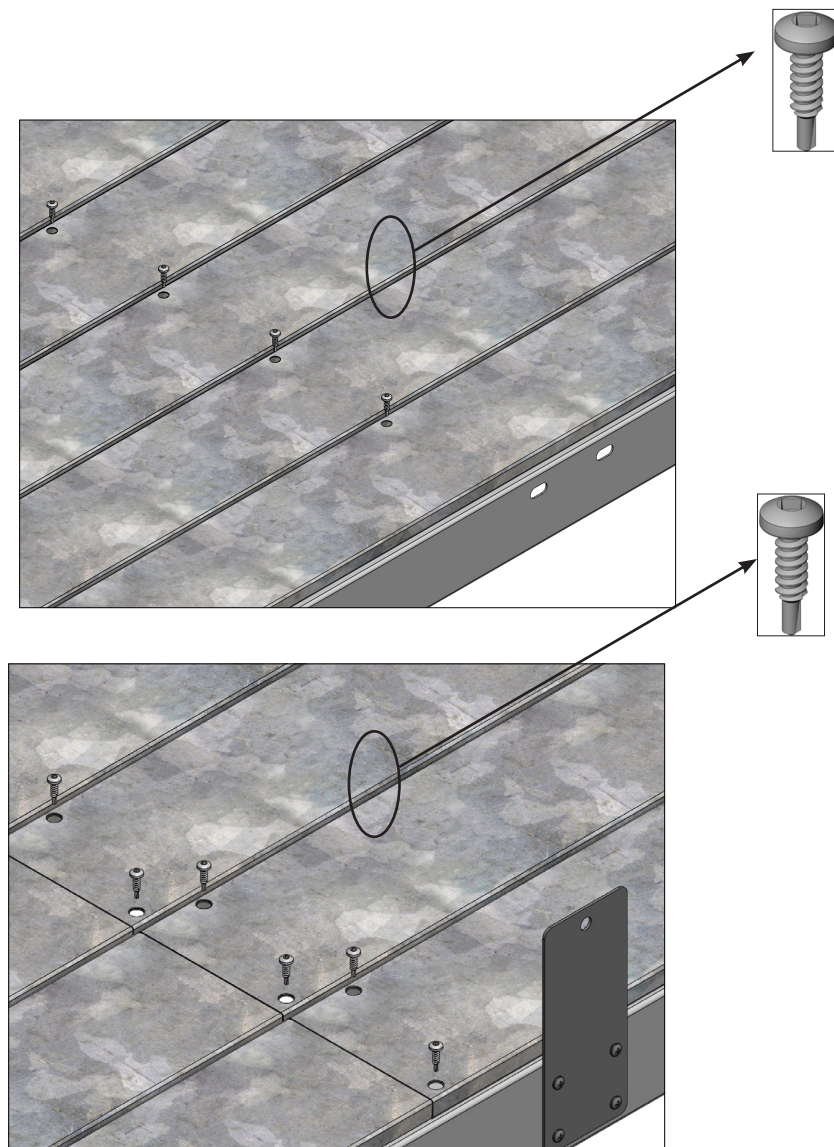
### Secure the floor to the frame

#### 4x4 & 4x6

1. Secure the floor to the frame by screwing it into place with the cutting screw using an impact driver.

#### 4x8 & 5x8

1. Ensure the center holes are completely aligned.
2. Secure the floor to the frame by screwing it into place with the cutting screw using an impact driver
3. Now you can tighten the 7 floor bolts (back & front channel)



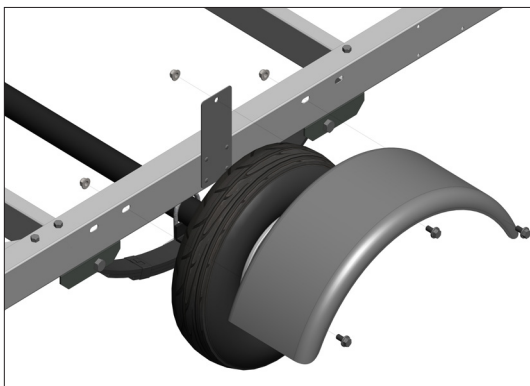
ITEM #	DESCRIPTION	QTY
501091*	#10 X 1/2" PHILLIPS #2 MACHINE SCREW*	8
501092*	#10 LOCKING NUT*	8
501049	3/8 X 3/4" HEX FLANGE BOLT	6
501031	3/8 NYLON INSERT LOCKING NUT	6
501001	1/2" WHEEL NUTS	10
<b>WITH 8" WHEELS</b>		
500258	8" FENDER	2
500841	4.80 X 8 LRC TIRE & WHEEL	2
504447*	FENDER PLATE - 8"*	2
<b>WITH 12" WHEELS</b>		
504212	12" FENDER	2
500844	4.80 X 12 LRC TIRE & WHEEL	2
504476*	FENDER PLATE - 12"*	2

**\*Fender plate support: If you have already installed them, skip these steps\***

1. Line up the fender support plate with the frame.
2. Secure it in place with machine screws #10 and #10 lock nuts, using a 3/8 socket and a Phillips screwdriver. If the holes are not perfectly aligned use a punch to align them.
3. Repeat on the other side.

**Fender & Wheel Installation:**

1. Place the fender on top of the fender plate. Hand-tighten the top hole with a 3/8" x 3/4" hex flange bolt and 3/8" lock nut, making sure the nut is inside the fender.
2. Then, place the tire onto the hub and secure it to the rim using 1/2" wheel nuts and a 13/16" socket. Tighten the wheel nuts to 95 ft-lbs. in a star pattern  
**Note:** The tapered end of the lug nuts should face the rim, as shown in the picture below.
3. Hand-tighten the other two holes to the frame using 3/8" x 3/4" hex flange bolts and 3/8" lock nuts.
4. Once everything is in place, tighten all the fender bolts with a 9/16" socket and wrench.
5. Repeat these steps for the other side.

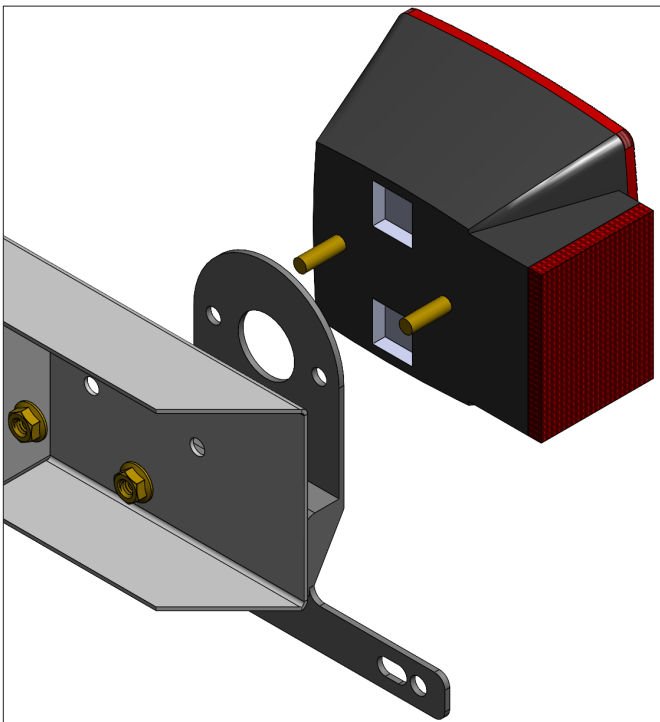


## Step 10 - Wiring & Lights & Affix VIN label

ITEM #	DESCRIPTION	4' x 4'	4'x6' & 4'x8' & 5'x8'
500512	4 WAY FLAT 20' WIRE HARNESS	1	1
503079	8" CABLE TIE	4	6
500513	TAILLIGHT LEFT/DRIVER SIDE	1	1
500514	TAILLIGHT RIGHT/PASSENGER SIDE	1	1
500516	PLASTIC LICENSE BRACKET	1	1

### Wire the Trailer:

1. At the back of the trailer, cut the wire leaving about 6 inches, then strip  $\frac{1}{4}$  inch of the wire insulation and twist the copper wire. Do this for both sides.
2. Next, plug each wire into the matching hole on the back of each taillight, and then secure the lights to the frame
3. Attach the license plate holder to the driver's side, along with the taillight.
4. Push any extra wire back into the frame and use zip ties to keep it in place through the holes.
5. Always test the lights before using the trailer.



### Affix VIN label & overlay:

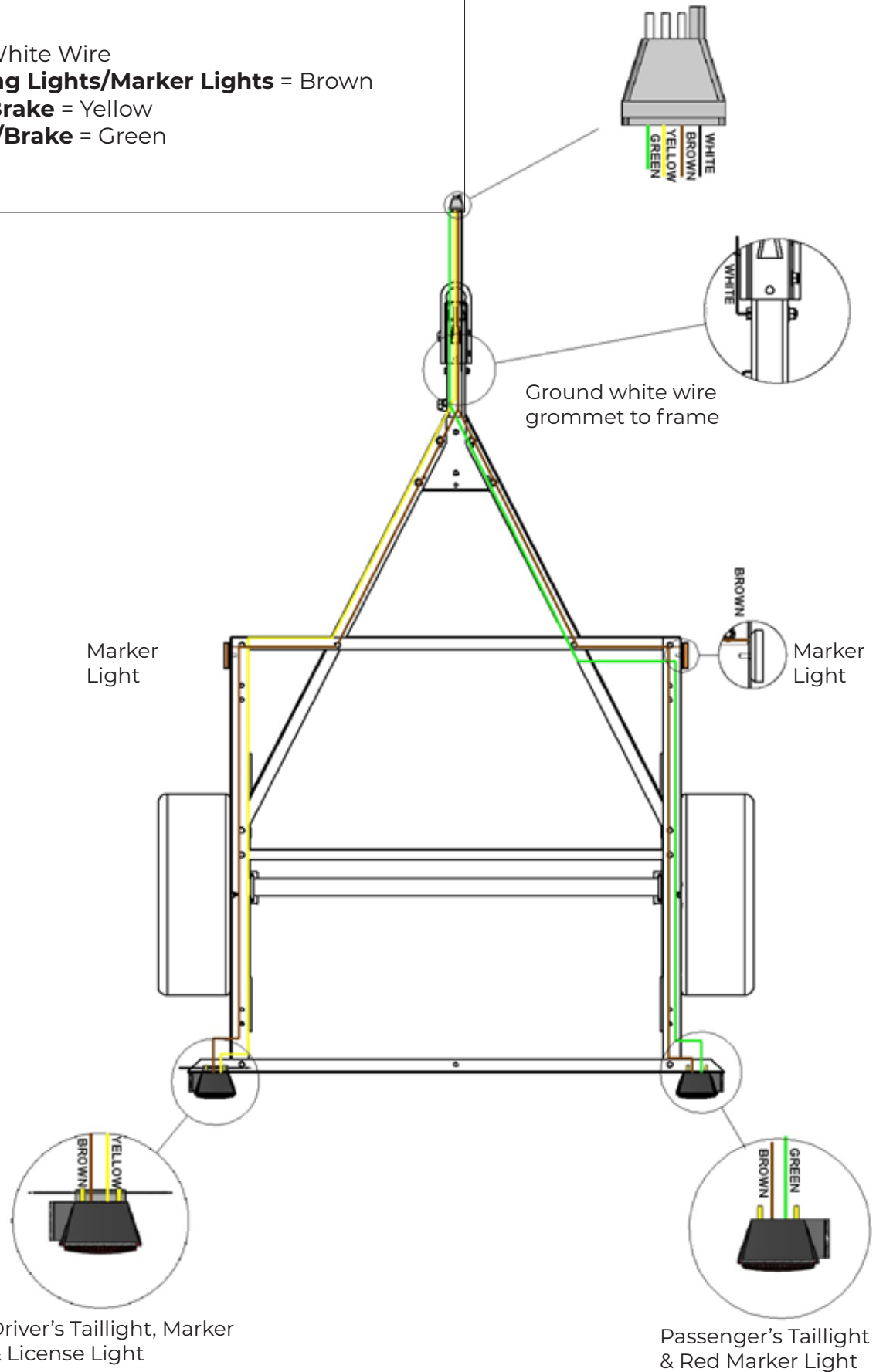
#### VIN = Vehicle Information Number

1. Finally, affix the VIN label on the driver's side of the tongue channel, and place the clear overlay on top.

## Wiring Diagram

### Function:

- **Ground** = White Wire
- **Tail/Running Lights/Marker Lights** = Brown
- **Left Turn/Brake** = Yellow
- **Right Turn/Brake** = Green

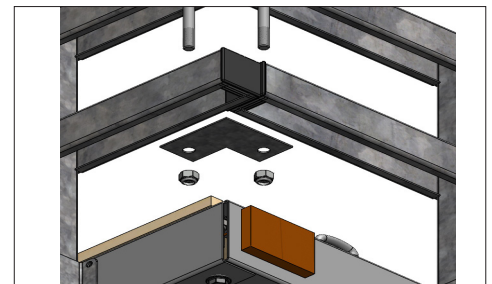
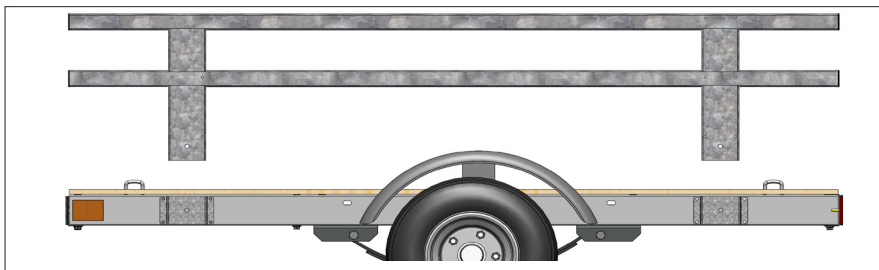


## Step 11 - Rail side installation

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501023	3/8-16 X 2-1/2" HEX BOLT	8	8	4	4
501031	3/8-16 NYLON INSERT HEX FLANGE LOCKNUT	16	16	10	10
501049	3/8-16 X 3/4" HEX FLANGE BOLT	8	8	6	6
501094	#14 X 1/2" TAPPING SCREW PAN HEAD			8	8
501176	3/8X4IN BENT HITCH PIN CLEAR ZINC			1	1
501179	3/8X6-16IN EYEBOLT FOR RAMP ZINC			2	2
501180	3/8 KNOB NUT 4 ARM FOR RAMP			2	2
504659	4' FRONT/BACK RAIL	2	2	1	
504662	4' RAMP RAIL REAR GATE			1	
504667	8' FRONT SIDE RAIL WITH 12" WHEELS			2	2
504670	8" REAR SIDE RAIL WITH 12" WHEELS			2	2
504673	8' RAIL SIDE CONNECTION PART			4	4
504675	8' FRONT SIDE RAIL WITH 8" WHEELS			2	2
504676	8" REAR SIDE RAIL WITH 8" WHEELS			2	2
504677	6' SIDE RAIL (LEFT/RIGHT)		2		
504685	4' SIDE RAIL (LEFT/RIGHT)	2			
504690	5' FRONT/BACK RAIL				1
504693	5' RAMP RAIL GATE				1
504699	L BRACKET	4	4	2	2

### Mounting Side/Back Rails: (4x4 & 4x6 - No Ramp Gate)

1. Start by taking one of the side rails and inserting the side posts into the stake pockets, lining them up with the stake pocket holes. The rails should fit snug, so you may need to use a rubber mallet to help align everything properly.
2. Secure each side post with a 3/8-16 x 3/4" hex bolt and 3/8-16 locknut. Repeat the process for all remaining side rails.
3. For each corner, attach an L bracket to the bottom rail and fasten it with a 3/8-16 x 2-1/2 hex bolt and a 3/8-16 hex locknut. Use a 9/16 socket to tighten the bolts



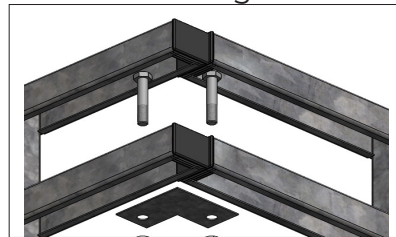
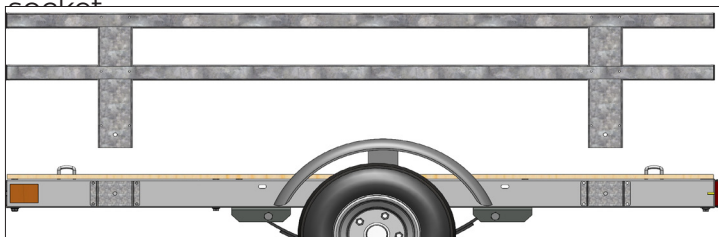
### Assemble 4x8 & 5x8 Side Rails:

1. Begin by sliding both connection channel pieces into the open ends of one half of the side rail. Ensure that each piece is facing the same direction.
2. Align the connection channels with the pre-drilled holes on the side rail. Use #14 x 1/2" pan head self-tapping screws to secure each channel in place.
3. Take the other half of the side rail and insert it into the same connection channels and secure it the same way.
4. Flip the assembled side rail over to the opposite side.
5. Finally, follow the same steps to assemble the opposite side rails



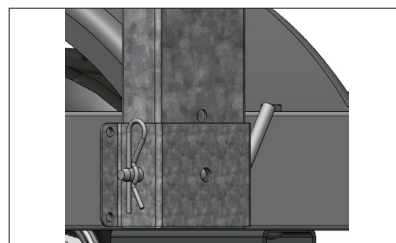
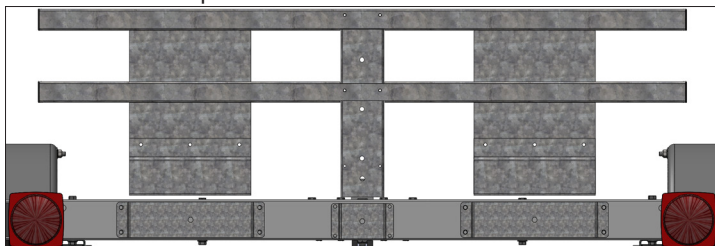
### Mounting Side Rails: (with Ramp Gate)

1. Take one of the rail sides and insert the side posts of one rail into the stake pockets, ensuring they align with the stake pocket holes. If necessary, use a rubber mallet to ensure a snug fit.
2. Secure each side post using a 3/8-16 x 3/4 hex bolt and a 3/8-16 locknut.
3. Repeat this process for the second side rail and the front rail.
4. Position the L-brackets at each front corner of the bottom rail.
5. Secure each bracket with a 3/8-16 x 2-1/2 hex bolt and a 3/8-16 hex flange locknut. Tighten using a 9/16 socket.



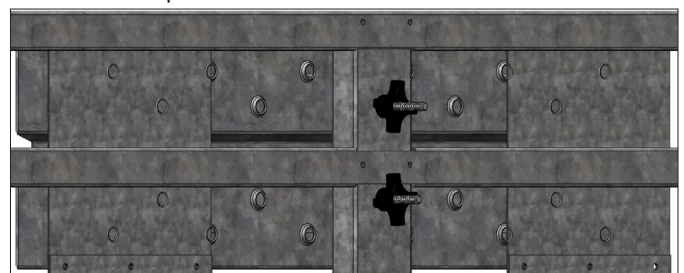
### Install Back Rail with Ramp Gate:

1. Slide the back rail into the ramp stake pockets.
2. Secure the gate by sliding a hitch pin through the center stake pocket and gate post, then fasten it with the R-Clip.



### Position and Secure Ramps:

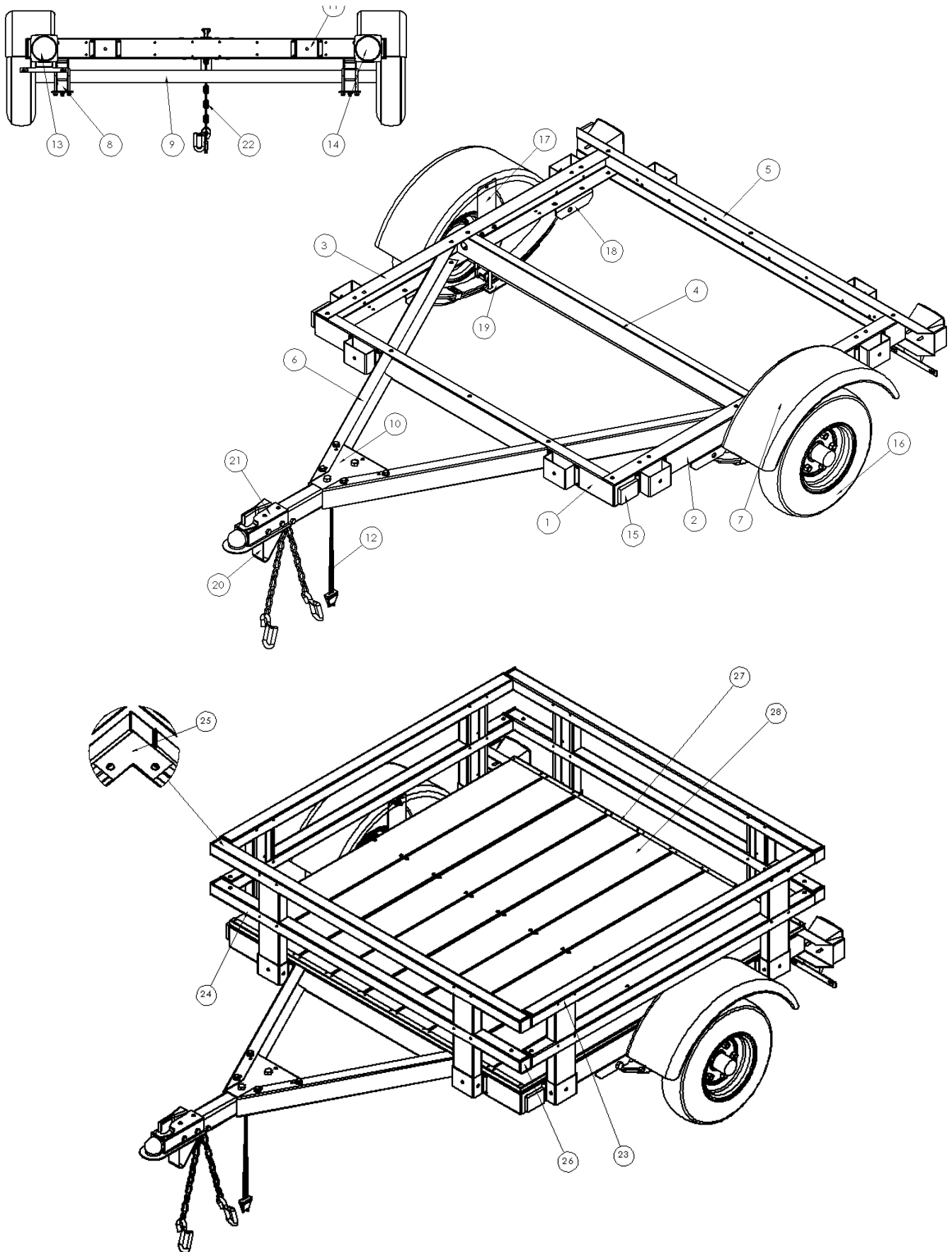
1. Place the ramps behind the gate, ensuring the openings of the ramps face forward.
2. Insert the eye bolts through the countersink holes on the ramps.
3. Secure the eye bolts tightly using the knob nuts.



## Appendix 1a - 4 x 4 Kit Trailer Diagram & Parts Breakdown

ITEM#	PART#	DESCRIPTION
1	500254	FRONT CROSS CHANNEL
2	500251	4' OUTER CHANNEL_DS
3	500297	4' OUTER CHANNEL_PS
4	500255	CROSS CHANNEL
5	500256	REAR CROSS CHANNEL
6	500257	TONGUE CHANNEL
7	500258	FENDER
8	504653	LEAF SPRING (750 LBS)
9	500047	AXLE (1500 LBS.)
10	504162	TONGUE CONNECTION BRACKET
11	504471	STAKE POCKETS
12	500512	MAIN WIRE HARNESS
13	500513 & 500516	STOP/TURN LIGHT DS WITH LICENSE PLATE BRACKET
14	500514	STOP/TURN LIGHT PS
15	500515	AMBER MARKER LIGHT
16	500841	TIRE AND WHEEL ASSY.
17	504447	FENDER PLATE
18	500259	LEAF SPRING MOUNTING BRACKET
19	500260	LEAF SPRING AXLE MOUNT PLATE
20	504198	TONGUE SUPPORT FOOT
21	500805	COUPLER
22	500804	SAFETY CHAIN
23	504684	SIDE RAIL
24	504674	FRONT/BACK RAIL
25	504699	L BRACKET
26	501175	1.75" SQUARE TUBE CAP
27	504736	4FT U CHANNEL FOR FLOOR PLANK
28	504738	4FT KIT TRAILER GALVALUME FLOOR PLANK

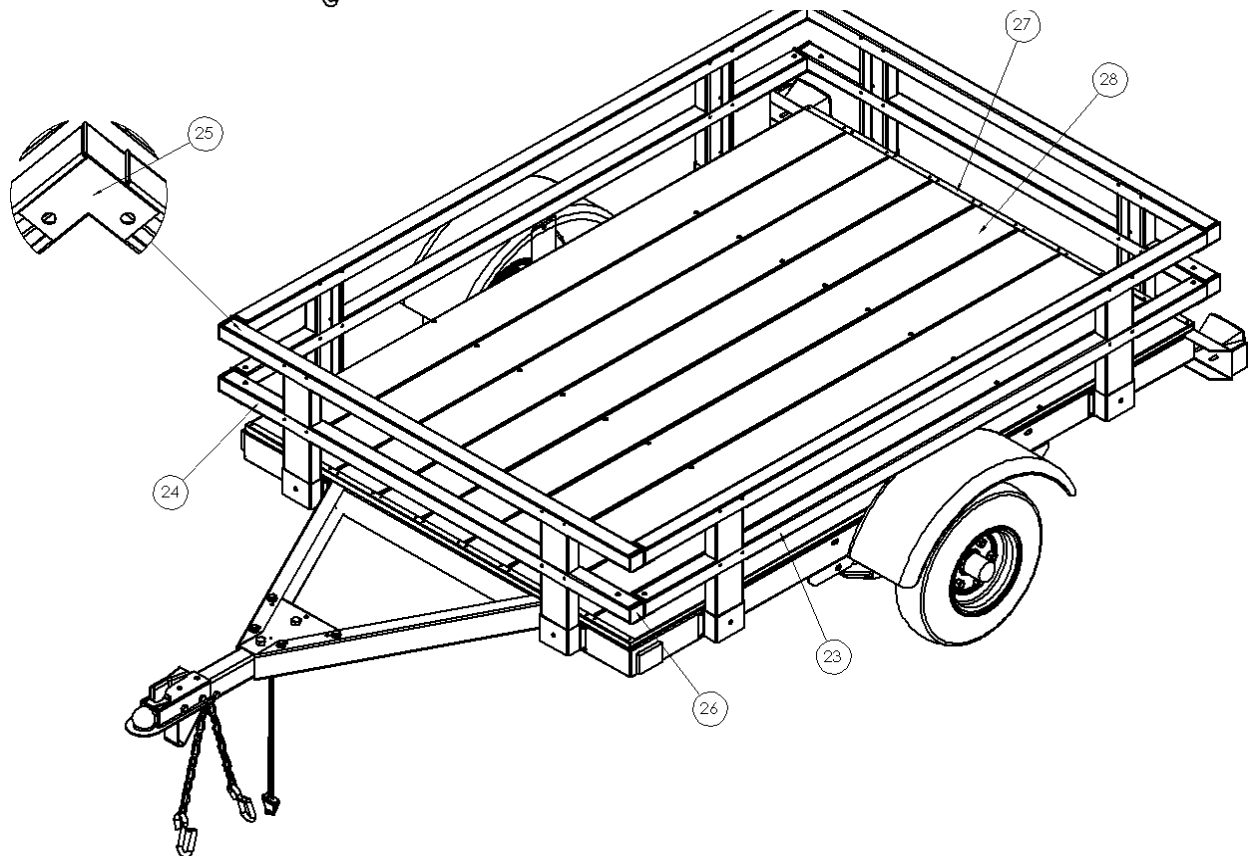
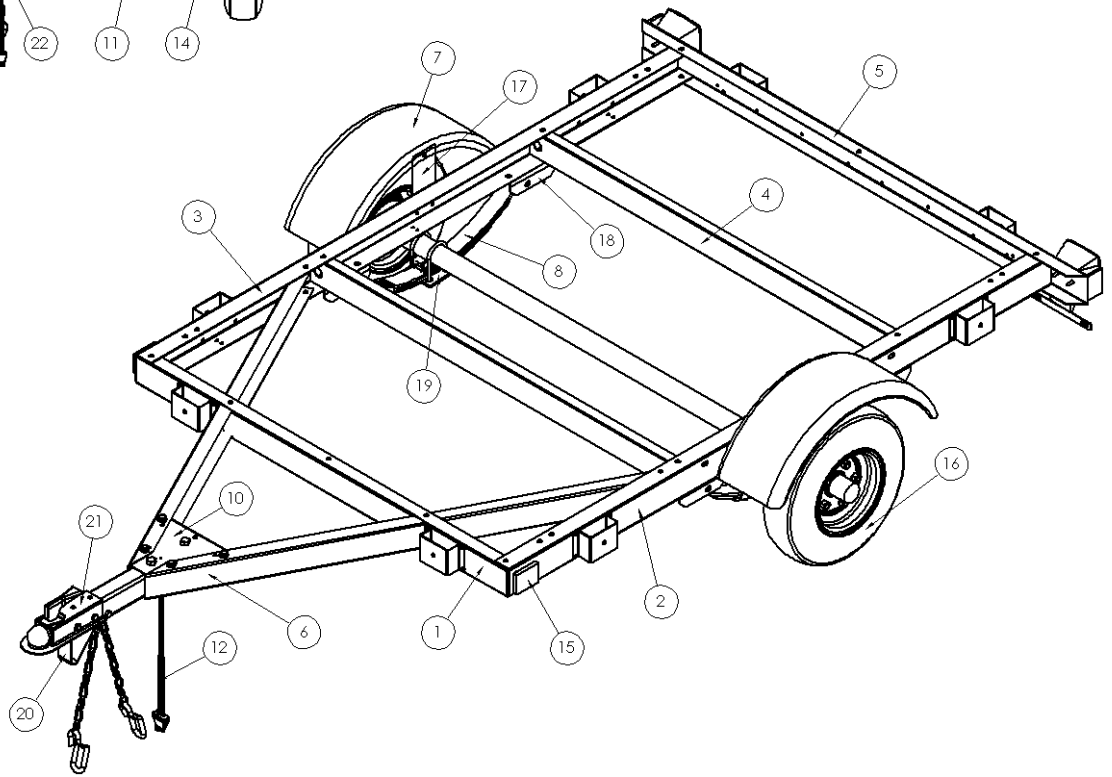
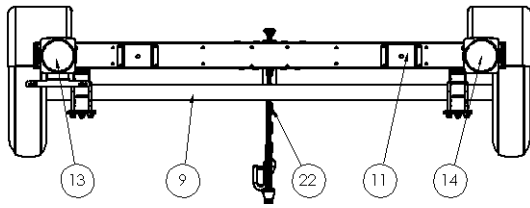
# 4 x 4 Kit Trailer Diagram



## Appendix 1b - 4 x 6 Kit Trailer Diagram & Parts Breakdown

ITEM#	PART#	DESCRIPTION
1	500254	FRONT CROSS CHANNEL
2	500252	6" OUTER CHANNEL_DS
3	500298	6' OUTER CHANNEL_PS
4	500255	CROSS CHANNEL
5	500256	REAR CROSS CHANNEL
6	500257	TONGUE CHANNEL
7	500258	FENDER
8	504653	LEAF SPRING (750 LBS)
9	500047	AXLE (1500 LBS.)
10	504162	TONGUE CONNECTION BRACKET
11	504471	STAKE POCKETS
12	500512	MAIN WIRE HARNESS
13	500513 & 500516	STOP/TURN LIGHT_DS WITH LICENSE PLATE BRACKET
14	500514	STOP/TURN LIGHT_PS
15	500515	AMBER MARKER LIGHT
16	500841	TIRE AND WHEEL ASSY.
17	504447	FENDER PLATE
18	500259	LEAF SPRING MOUNTING BRACKET
19	500260	LEAF SPRING AXLE MOUNT PLATE
20	504198	TONGUE SUPPORT FOOT
21	500805	COUPLER
22	500804	SAFETY CHAIN
23	504684	SIDE RAIL
24	504674	FRONT/BACK RAIL
25	504699	L BRACKET
26	501175	1.75" SQUARE TUBE CAP
27	504736	4FT U CHANNEL FOR FLOOR PLANK
28	504739	6FT KIT TRAILER GALVALUME FLOOR PLANK

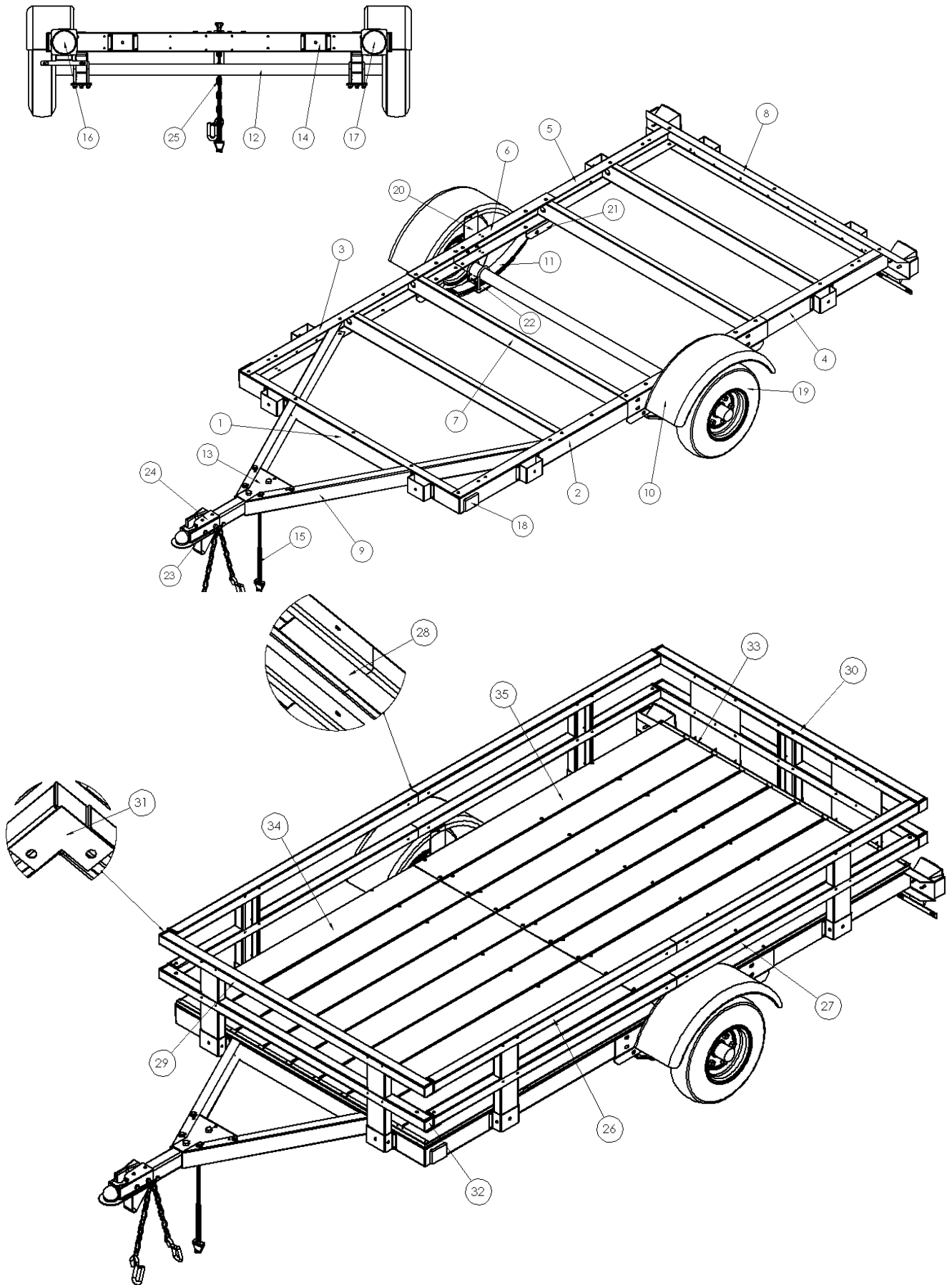
# 4 x 6 Kit Trailer Diagram



## Appendix 1c - 4 x 8 Kit Trailer Diagram & Parts Breakdown

ITEM#	PART#	DESCRIPTION
1	500254	FRONT CROSS CHANNEL
2	500253	4' OUTER CHANNEL FRONT_DS
3	500300	4' OUTER CHANNEL FRONT_PS
4	500299	4' OUTER CHANNEL REAR_DS
5	500301	4' OUTER CHANNEL REAR_PS
6	500272	OUTER CONNECTION CHANNEL
7	500255	CROSS CHANNEL
8	500256	REAR CROSS CHANNEL
9	500257	TONGUE CHANNEL
10	504258 (8" TIRE) 504212 (12" TIRE)	FENDER
11	504653	LEAF SPRING (750 LBS)
12	500047	AXLE (1500 LBS.)
13	504162	TONGUE CONNECTION BRACKET
14	504471	STAKE POCKETS
15	500512	MAIN WIRE HARNESS
16	500513 & 500516	STOP/TURN LIGHT DS WITH LICENSE PLATE BRACKET
17	500514	STOP/TURN LIGHT PS
18	500515	AMBER MARKER LIGHT
19	500841 (8" TIRE) 500844 (12" TIRE)	TIRE AND WHEEL ASSY.
20	504447 (8" TIRE) 504476 (12" TIRE)	FENDER PLATE
21	500259	LEAF SPRING MOUNTING BRACKET
22	500260	LEAF SPRING AXLE MOUNT PLATE
23	504198	TONGUE SUPPORT FOOT
24	500805	COUPLER
25	500804	SAFETY CHAIN
26	504675 (8" TIRE) 504667 (12" TIRE)	8' FRONT SIDE RAIL
27	504676 (8" TIRE) 504670 (12" TIRE)	8' REAR SIDE RAIL
28	504673	8' RAIL SIDE CONNECTION PART
29	504659 (8" TIRE) 504710 (12" TIRE)	FRONT/BACK RAIL
30	504701 (8" TIRE) 504707 (12" TIRE)	RAMP RAIL GATE
31	504699	L BRACKET
32	501175	1.75" SQUARE TUBE CAP
33	504736	4FT U CHANNEL FOR FLOOR PLANK
34	504740	8' KIT TRAILER GALVALUME FRONT FLOOR PLANK
35	504741	8' KIT TRAILER GALVALUME REAR FLOOR PLANK

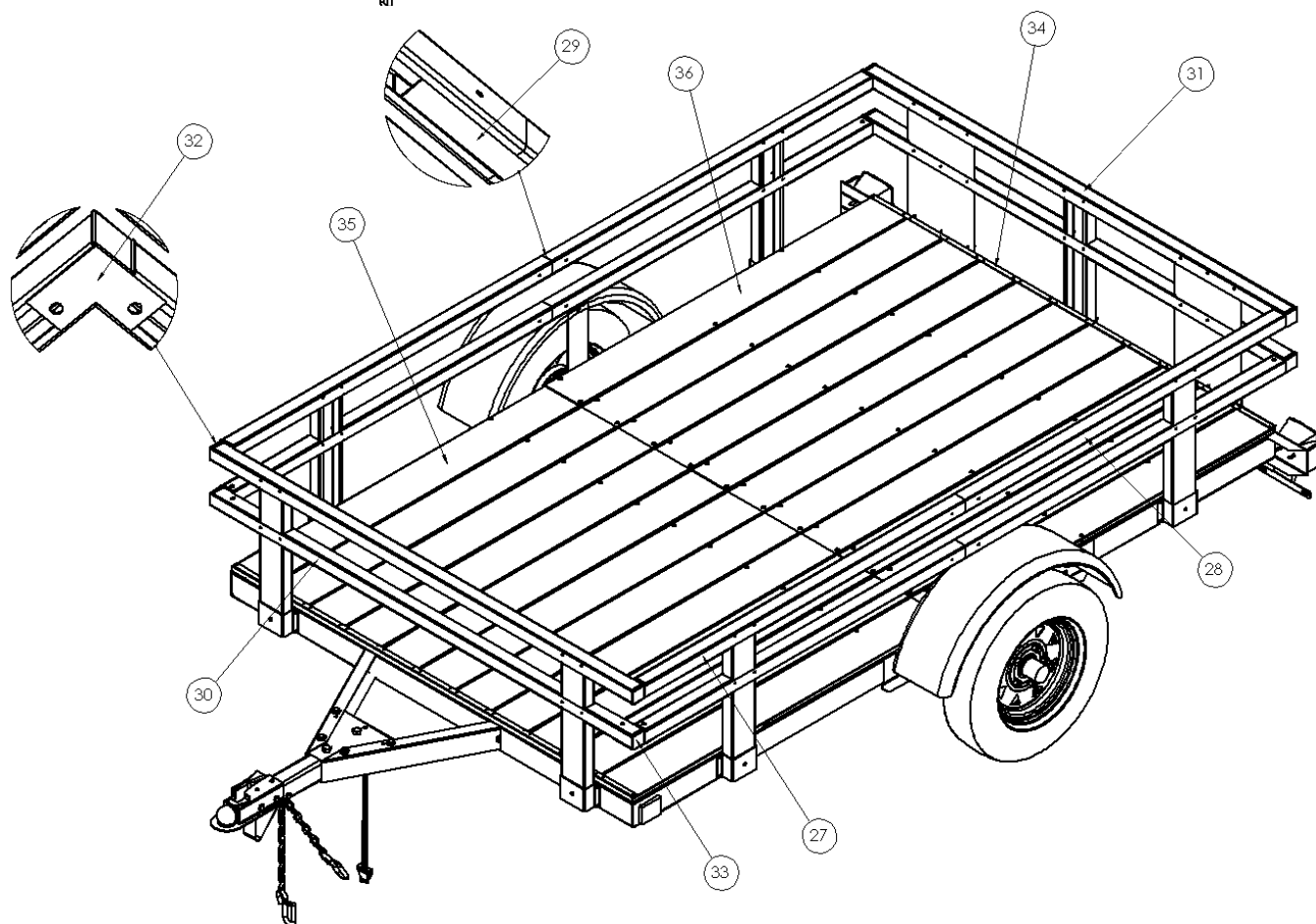
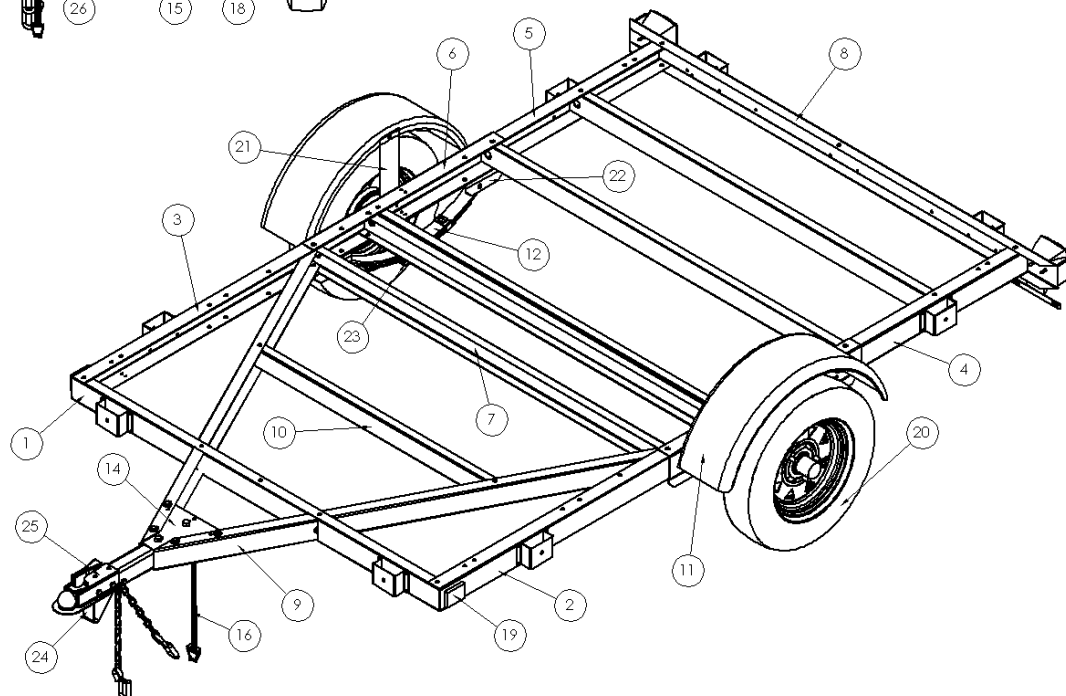
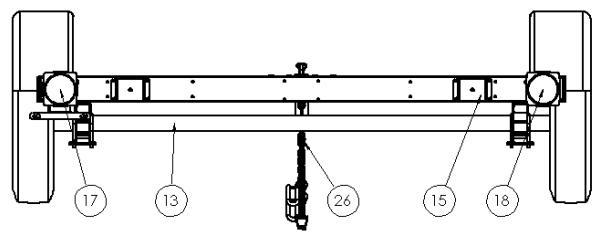
# 4 x 8 Kit Trailer Diagram



## Appendix 1d- 5 x 8 Kit Trailer Diagram & Parts Breakdown

ITEM#	PART#	DESCRIPTION
1	504599	FRONT CROSS CHANNEL
2	500253	4' OUTER CHANNEL FRONT_DS
3	500300	4' OUTER CHANNEL FRONT_PS
4	500299	4' OUTER CHANNEL REAR_DS
5	500301	4' OUTER CHANNEL REAR_PS
6	500272	OUTER CONNECTION CHANNEL
7	504602	CROSS CHANNEL
8	504600	REAR CROSS CHANNEL
9	504601	TONGUE CHANNEL
10	504623	TONGUE CROSS CHANNEL
11	504212	FENDER
12	504653	LEAF SPRING (750 LBS)
13	504617	AXLE (2000 LBS.)
14	504162	TONGUE CONNECTION BRACKET
15	504471	STAKE POCKETS
16	500512	MAIN WIRE HARNESS
17	500513 & 500516	STOP/TURN LIGHT DS WITH LICENSE PLATE BRACKET
18	500514	STOP/TURN LIGHT PS
19	500515	AMBER MARKER LIGHT
20	500844	TIRE AND WHEEL ASSY.
21	504476	FENDER PLATE
22	500259	LEAF SPRING MOUNTING BRACKET
23	500260	LEAF SPRING AXLE MOUNT PLATE
24	504198	TONGUE SUPPORT FOOT
25	500805	COUPLER
26	500804	SAFETY CHAIN
27	504667	8' FRONT SIDE RAIL
28	504670	8' REAR SIDE RAIL
29	504673	8' RAIL SIDE CONNECTION PART
30	504690	FRONT/BACK RAIL
31	504693	RAMP RAIL GATE
32	504633	L BRACKET
33	501175	1.75" SQUARE TUBE CAP
34	504737	5FT U CHANNEL FOR FLOOR PLANK
35	504740	8' KIT TRAILER GALVALUME FRONT FLOOR PLANK
36	504741	8' KIT TRAILER GALVALUME REAR FLOOR PLANK

# 5 x 8 Kit Trailer Diagram



## Appendix 2 - Parts Listing

### HARDWARE SHIP w/Frame of the trailer

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
500814	3/8" U-BOLT	4	4	4	4
501001	1/2" WHEEL NUT	10	10	10	10
501023	3/8" X 2-1/2" HEX BOLT	1	1	1	1
501024	3/8" X 3" HEX BOLT	2	2	2	2
501031	3/8" HEX FLANGE LOCK NUT	61	61	61	61
501032	3/8" FLAT WASHER	8	8	8	8
501033	3/8" X 1 1/2" HEX BOLT	20	20	20	20
501036	3/8" X 3/4" CARRIAGE BOLT	8	8	8	8
501049	3/8" X 3/4" HEX FLANGE BOLT	26	26	26	26
501056	1/2" LOCKING NUT	2	2	2	2
501060	1/2" X 3 1/2" HEX BOLT	2	2	2	2
501065	9/16 UNF X 3" HEX BOLT	4	4	4	4
501066	9/16 UNF LOCKING NUT	4	4	4	4
501073	1/4 X 3/4" HEX BOLT	32	32	32	32
501081	1/4 NYLON INSERT LOCKING NUT	32	32	32	32
501091	#10 X 1/2" PHILLIPS #2 SCREW	8	8	8	8

### LIGHTS

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501000	5/16 X 1/2" CUTTING SCREW	4	4	4	4
500513	TAILLIGHT LEFT/DRIVER SIDE	1	1	1	1
500514	TAILLIGHT RIGHT/PASSENGER SIDE	1	1	1	1
500515	AMBER MARKER LIGHT	2	2	2	2
500516	PLASTIC LICENSE BRACKET	1	1	1	1
500512	4 WAY FLAT 20' WIRE HARNESS	1	1	1	1
500558	WIRE CONNECTOR	2	2	2	2
503079	8" CABLE TIES	4	6	4	4

### METAL

500259	LEAF SPRING MOUNTING BRACKET	4	4	4	4
500260	LEAF SPRING AXLE MOUNT PLATE	2	2	2	2
500805	1 7/8" COUPLER	1	1	1	1
504162	5' TONGUE CONNECTION BRACKET	1	1	1	1
504163	LONG COUPLER CHANNEL	1	1	1	1
504198	TONGUE SUPPORT FOOT	1	1	1	1
504447	FENDER PLATE FOR KIT WITH 8" WHEELS	2	2	2	2
504476	FENDER PLATE FOR KIT WITH 12" WHEELS				
504471	STAKE POCKET	8	8	8	8

### SPRING

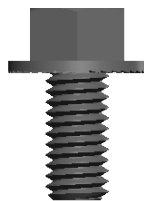
500809	750 LB. SLIPPER SPRING	2	2	2	2
504617	5' STRAIGHT AXLE				1

# Hardware Quick Reference Guide



Item#500814  
3/8 U-Bolt

Item#501049  
3/8 x 3/4  
Hex Flange Bolt



Item#501036  
3/8 x 3/4  
Carriage Bolt



Item#501023  
3/8 x 2-1/2  
Hex Bolt



Item#501024  
3/8 x 3  
Hex Bolt



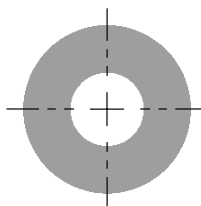
Item#501033  
3/8 x 1-1/2  
Hex Bolt



Item#501031  
3/8 Locking Nut



Item#501032  
3/8 Flat Washer



Item#501073  
1/4 x 3/4  
Hex Bolt



Item#501179  
3/8X6-16 Eyebolt  
Zinc Plated



Item#501060  
1/2 x 3-1/2  
Hex Bolt



Item#501065  
9/16 x 3 UNF  
Hex Bolt



Item#501056  
1/2 Locking Nut



Item#501091  
#10 x 1/2 Phillips  
Machine Screw



Item#501081  
1/4 Nylon Insert  
Locking Nut



Item#501066  
9/16 UNF  
Locking Nut



Item#501092  
#10 Locking Nut



Item#501180  
3/8 Knob Nut  
4 Arm



Item#501101  
1/2 Wheel Nut



Item#501100  
5/16 x 1/2  
Cutting Screw



Item#501181  
#10 X 3/4  
Pan Head Screw



Item#501177  
#10 X 3/4 Self-drilling  
Pan Head Screw



Item#501176  
3/8X4 Hitch Pin  
with R-Clip Clear Zinc



Item#501094  
#14 X 1/2 Tapping  
Screw Pan Head



## Appendix 2 - Parts Listing

FRAME BOX					
ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
500047	4' STRAIGHT AXLE	1	1	1	
500251	4' DRIVER SIDE CHANNEL	1			
500252	6' DRIVER SIDE CHANNEL		1		
500253	4' FRONT DRIVER SIDE CHANNEL			1	1
500254	4' FRONT CHANNEL	1	1	1	
500255	4' CROSS CHANNEL	1	2	4	
500256	4' REAR CHANNEL	1	1	1	
500257	TONGUE CHANNEL FOR 4 FT WIDE TRAILER	2	2	2	
500272	CONNECTION CHANNEL (4X8)			2	2
500297	4' PASSENGER SIDE CHANNEL	1			
500298	6' PASSENGER SIDE CHANNEL		1		
500299	4' REAR DRIVER SIDE CHANNEL			1	1
500300	4' FRONT PASSENGER SIDE CHANNEL			1	1
500301	4' REAR PASSENGER SIDE CHANNEL			1	1
504162	5' TONGUE CONNECTION BRACKET	1	1	1	1
504599	5' FRONT CHANNEL				1
504600	5' REAR CHANNEL				1
504601	TONGUE CHANNEL FOR 5 FT WIDE TRAILER				2
504602	5' CROSS CHANNEL				5
504623	TONGUE CROSS CHANNEL				1

RAMPS BOX					
ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501073	1/4-20 X 3/4" HEX BOLT	8	8	8	8
501081	1/4-20 NYLON INSERT LOCKING NUT	8	8	8	8
504466	GALVALUME RAMP (LENGTH AND WIDTH)		2	2	2
504467	RAMP STACK POCKET		2	2	2

## Appendix 2 - Parts Listing

ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
501023	3/8-16 X 2-1/2" HEX BOLT	8	8	4	4
501031	3/8-16 NYLON INSERT HEX FLANGE LOCKNUT	16	16	10	10
501049	3/8-16 X 3/4" HEX FLANGE BOLT	8	8	6	6
501094	#14 X 1/2" TAPPING SCREW PAN HEAD			8	8
501176	3/8X4IN BENT HITCH PIN CLEAR ZINC			1	1
501179	3/8X6-16IN EYEBOLT FOR RAMP ZINC			2	2
501180	3/8 KNOB NUT 4 ARM FOR RAMP			2	2
504659	4' FRONT/BACK RAIL	2	2	1	
504662	4' RAMP RAIL REAR GATE			1	
504667	8' FRONT SIDE RAIL WITH 12" WHEELS			2	2
504670	8" REAR SIDE RAIL WITH 12" WHEELS			2	2
504673	8' RAIL SIDE CONNECTION PART			4	4
504675	8' FRONT SIDE RAIL WITH 8" WHEELS			2	2
504676	8" REAR SIDE RAIL WITH 8" WHEELS			2	2
504677	6' SIDE RAIL (LEFT/RIGHT)		2		
504685	4' SIDE RAIL (LEFT/RIGHT)	2			
504690	5' FRONT/BACK RAIL				1
504693	5' RAMP RAIL GATE				1
504699	L BRACKET	4	4	2	2

FLOOR BOX					
ITEM#	ITEM DESCRIPTION	4' x 4'	4' x 6'	4' x 8'	5' x 8'
500255	4FT CROSS-CHANNEL			2	
504736	4FT U CHANNEL FOR FLOOR PLANK	2	2	2	
501049	3/8 X 3/4 HEX FLANGE BOLT			4	
501033	3/8 X 1 1/2 HEX BOLT (FULL THREAD)			4	
501031	3/8 FLANGE LOCK NUT			8	
504738	4X4 GALVALUME FLOOR PLANK	9			
504739	4X6 GALVALUME FLOOR PLANK		9		
504740	4x8 & 5x8 GALVALUME FRONT FLOOR PLANK			9	11
504741	4x8 & 5x8 GALVALUME REAR FLOOR PLANK			9	11
504737	5FT U CHANNEL FOR FLOOR PLANK				2
501177	#10 X 3/4 IN SELF-DRILLING PAN HEAD SCREW	18	18	45	55
501181	#10 X 3/4 IN PAN HEAD SCREW ZINC	36	36	36	44

## Appendix 3 - Boxes Breakdown

### **4x4 & 4x6 Trailer Kits**

#### **Flat-Bed (Open Frame)**

- **Box 1:** Tires, fenders, lights, small metal parts, leaf springs, hardware for frame assembly, and registration documents (in a brown envelope on the outside of the box).
- **Box 2:** Axle and frame channels.

#### **Utility (RailSide)**

- **Box 3:** Floor planks and hardware for floor installation.
- **Box 4:** Rail sides and hardware for assembly. (Two boxes will be banded together.)

### **4x8 Trailer Kit**

#### **Flat-Bed Kit (Open Frame)**

- **Box 1:** Tires, fenders, lights, small metal parts, leaf springs, hardware for frame assembly, and registration documents (in a brown envelope on the outside of the box).
- **Box 2:** Axle and frame channels.

#### **Utility (RailSide)**

- **Box 3:** Rail sides and hardware for assembly. (Three boxes will be banded together.)
- **Box 4:** Floor planks, additional frame cross-channels, and hardware for floor installation.
- **Box 5:** Ramps, mounting brackets, and hardware.

### **5x8 Trailer Kit**

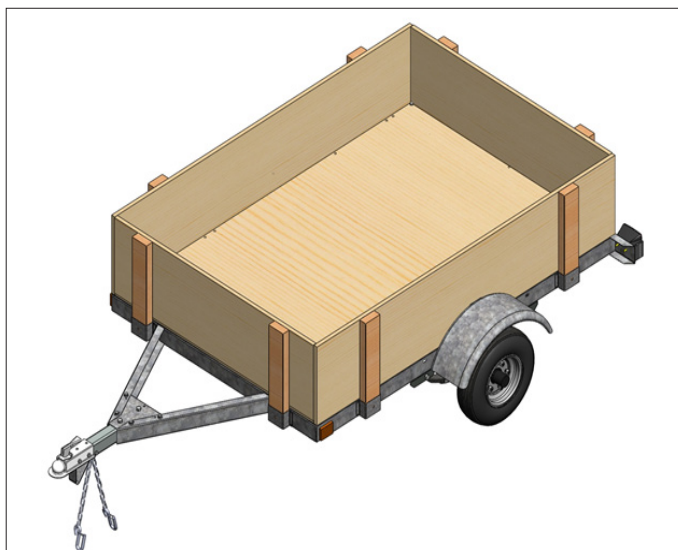
#### **Flat-Bed Kit (Open Frame)**

- **Box 1:** Tires, fenders, lights, small metal parts, hardware for frame assembly, and registration documents (in a brown envelope on the outside of the box).
- **Box 2:** Frame channels.
- **Box 3:** Axle and leaf springs.

#### **Utility (Railside)**

- **Box 4:** Rail sides and hardware for assembly. (Multiple boxes will be banded together.)
- **Box 5: Rail Side**
- **Box 6:** Floor planks and hardware for floor installation.
- **Box 7:** Ramps, mounting brackets, and hardware.

## Appendix 4 - Wood Side cut list



Cut List - Plywood  
(Wood not included)

- 4' x 4'
- 8pcs - 2x4 -18" (12ft -2x4 makes 8pcs)
  - 4pcs -  $\frac{3}{4}$  x 14- $\frac{3}{4}$ " x 48"
- 4' x 6'
- 8pcs - 2x4 -18" (12ft -2x4 makes 8pcs)
  - 2pcs -  $\frac{3}{4}$  x 14- $\frac{3}{4}$ " x 72"
  - 2pcs -  $\frac{3}{4}$  x 14- $\frac{1}{4}$ " x 48"
- 4' x 8'
- 8pcs - 2x4 -18" (12ft -2x4 makes 8pcs)
  - 2pcs -  $\frac{3}{4}$  x 14- $\frac{3}{4}$ " x 96"
  - 2pcs -  $\frac{3}{4}$  x 14- $\frac{1}{4}$ " x 48"
- 5' x 8'
- 8pcs - 2x4 -18" (12ft -2x4 makes 8pcs)
  - 2pcs -  $\frac{3}{4}$  x 14- $\frac{3}{4}$ " x 96"
  - 2pcs -  $\frac{3}{4}$  x 14- $\frac{1}{4}$ " x 60"



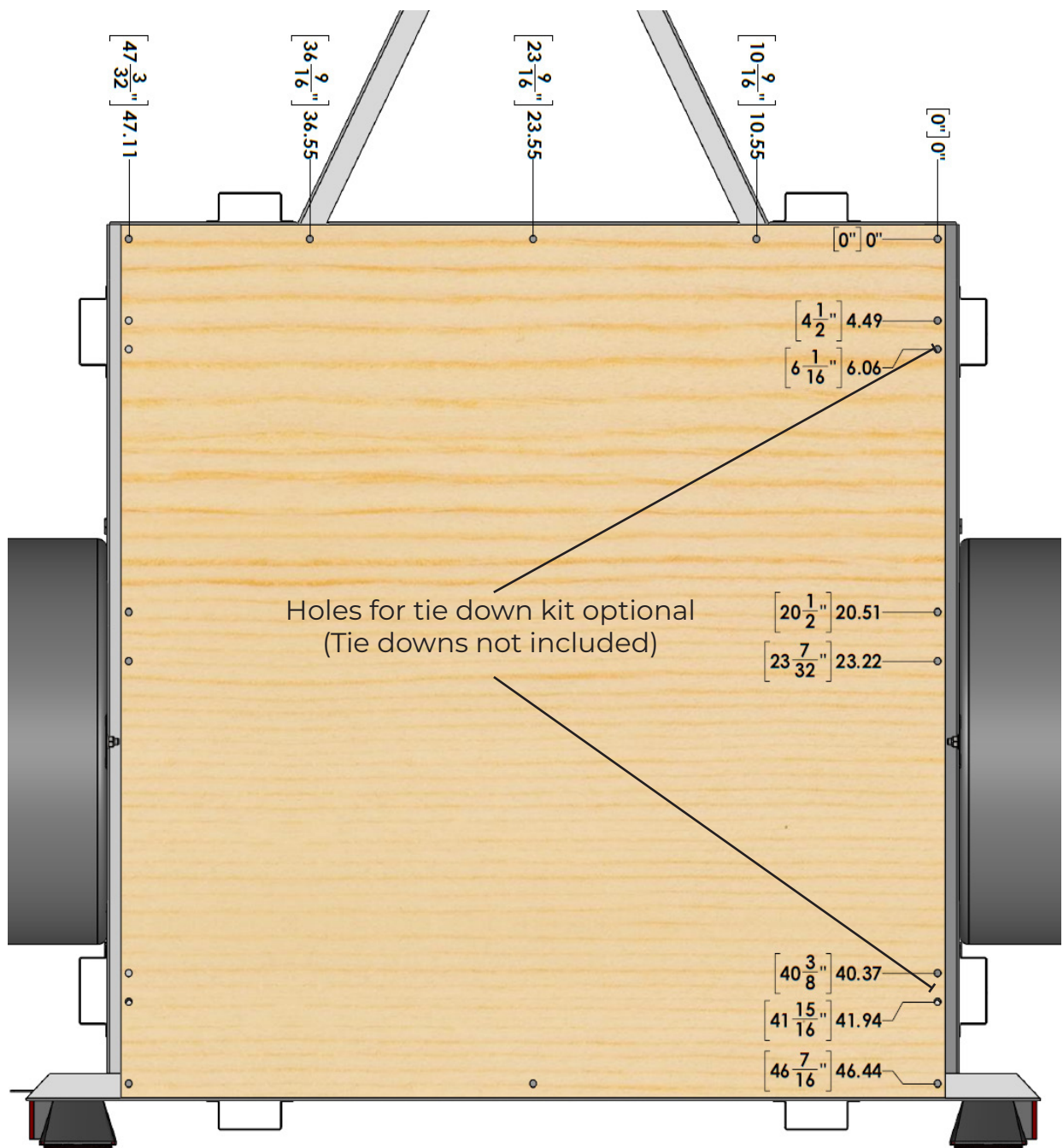
Cut List - Wood Plank  
(Wood not included)

- 4' x 4'
- 8pcs - 2x4 -18" (12ft -2x4 makes 8pcs)
  - 8pcs - 1x6 - 48"
- 4' x 6'
- 8pcs - 2x4 - 18" (12ft -2x4 makes 8pcs)
  - 4pcs - 1x6 - 72"
  - 4pcs - 1x6 - 48"
- 4' x 8'
- 8pcs - 2x4 - 18" (12ft -2x4 makes 8pcs)
  - 4pcs - 1x6 - 96"
  - 4pcs - 1x6 - 48"
- 5' x 8'
- 8pcs - 2x4 - 18" (12ft -2x4 makes 8pcs)
  - 4pcs - 1x6 - 96"
  - 4pcs - 1x6 - 60"

## Appendix 5a- 4ft x 4ft Plywood Drill Template

(Plywood not included)

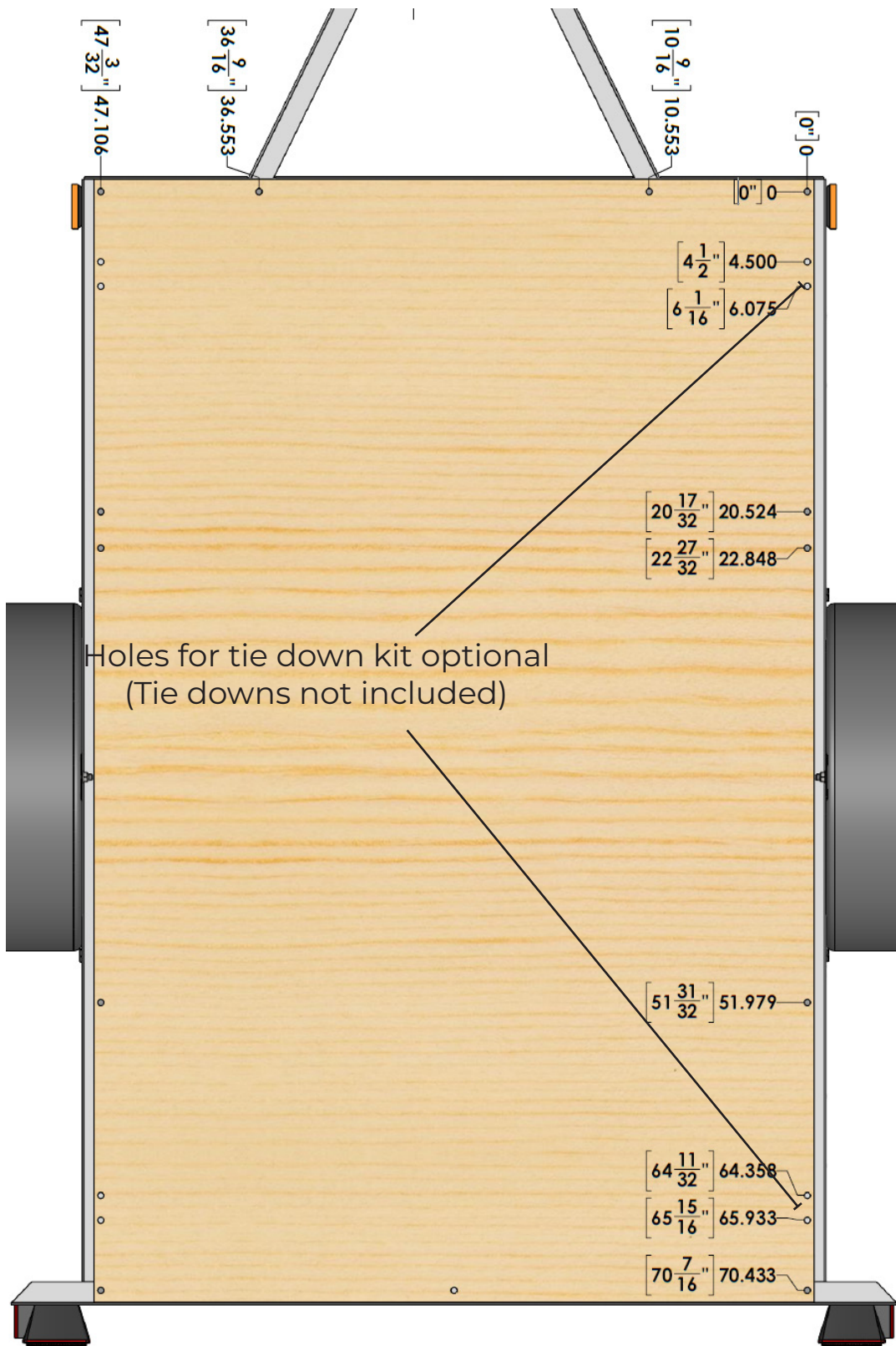
Drill  $\frac{3}{8}$  holes in plywood using the dimensions outlined below and use the  $\frac{3}{8}$  x 1- $\frac{1}{2}$  full thread hex bolts to secure to the frame.



## Appendix 5b - 4ft x 6ft Plywood Drill Template

(Plywood not included)

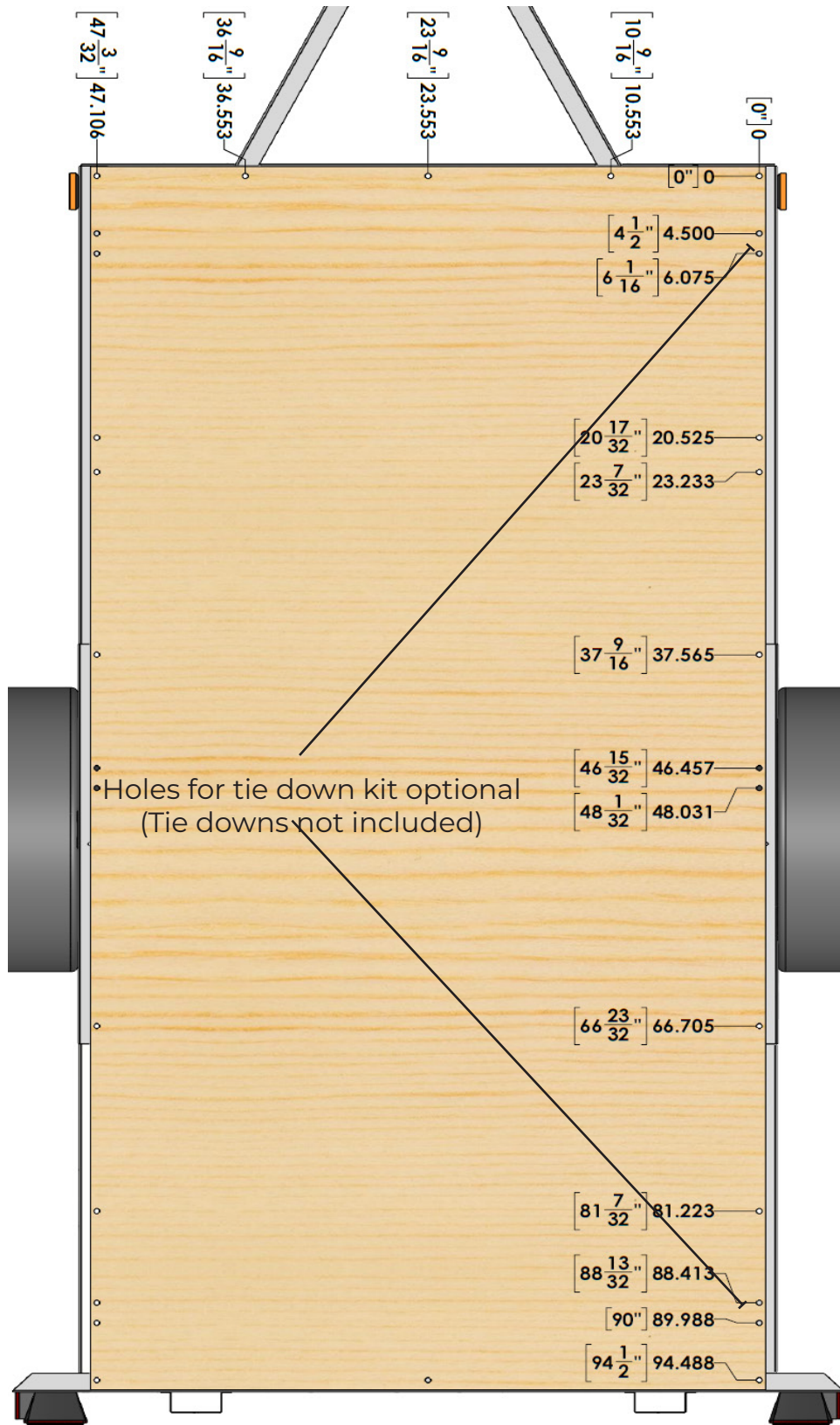
Drill  $\frac{3}{8}$  holes in plywood using the dimensions outlined below and use the  $\frac{3}{8}$  x 1- $\frac{1}{2}$  full thread hex bolts to secure to the frame.



## Appendix 5c - 4ft x 8ft Plywood Drill Template

(Plywood not included)

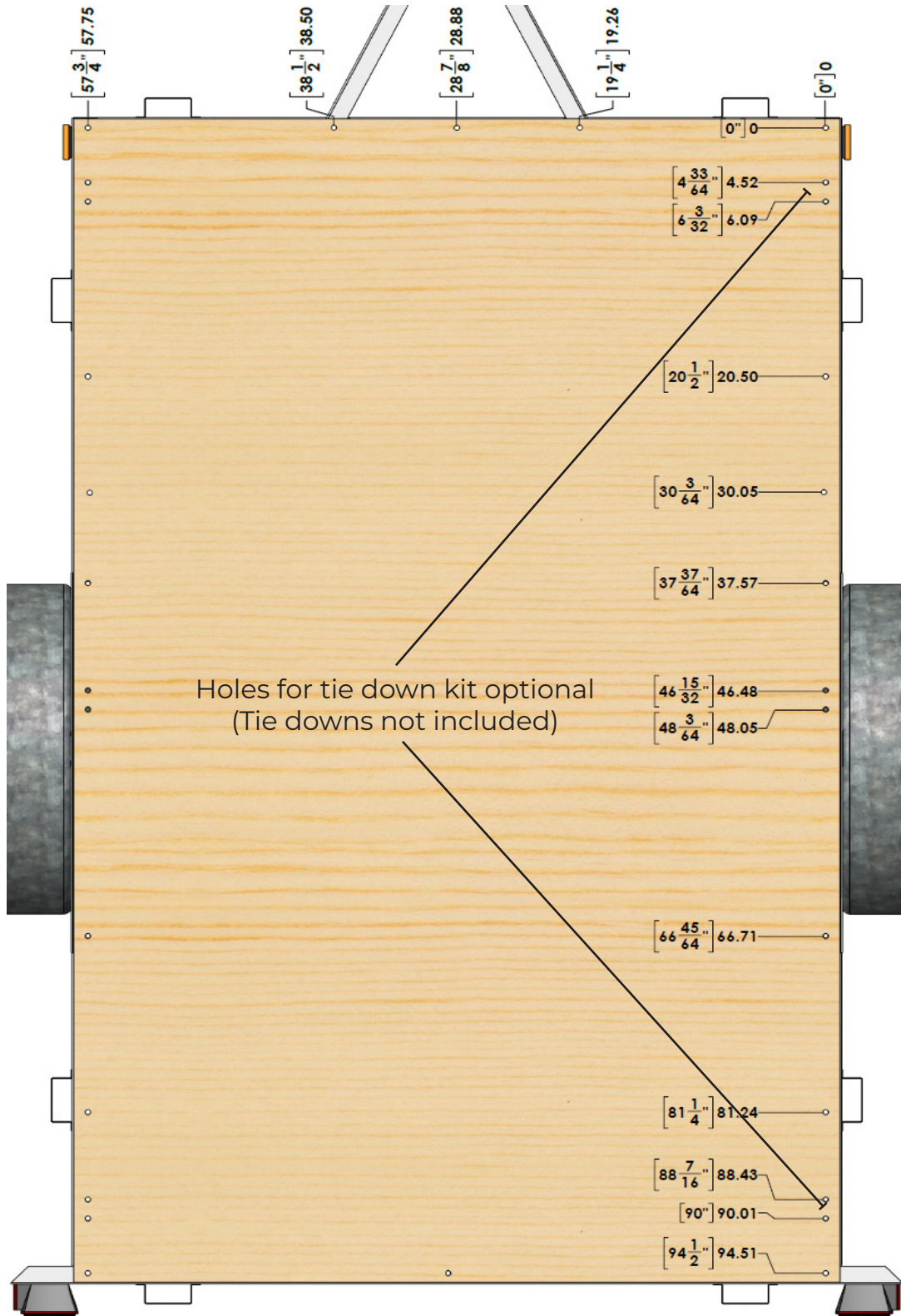
Drill  $\frac{3}{8}$  holes in plywood using the dimensions outlined below and use the  $\frac{3}{8}$  x 1- $\frac{1}{2}$  full thread hex bolts to secure to the frame.



## Appendix 5d - 5ft x 8ft Plywood Drill Template

(Plywood not included)

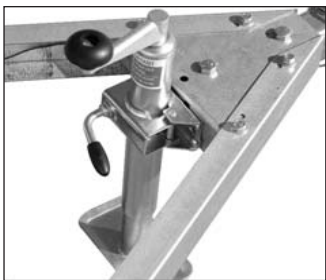
Drill  $\frac{3}{8}$  holes in plywood using the dimensions outlined below and use the  $\frac{3}{8}$  x 1- $\frac{1}{2}$  full thread hex bolts to secure to the frame.



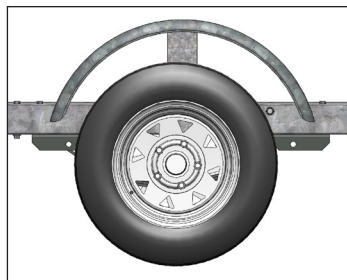


# Kit Trailers Accessories

[westbrooktrailers.com](http://westbrooktrailers.com)



Tongue Jack



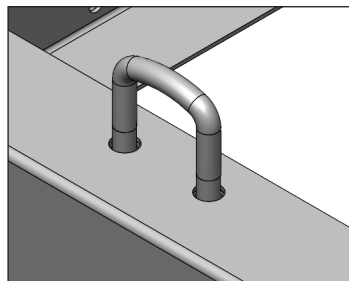
12" Wheel & Fender



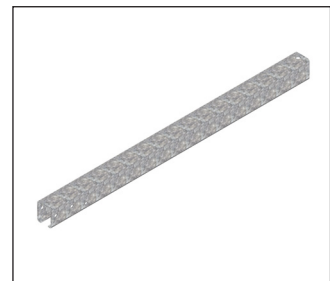
Ramps



Cargo Racks



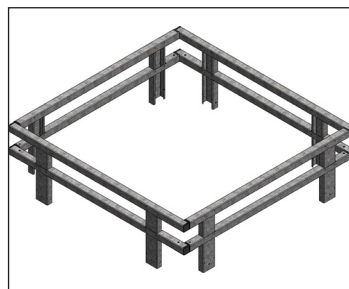
U bolt tie downs



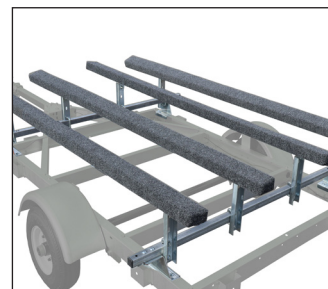
Tongue Extension



Tire bundle



Rail Sides Kit



Bunks Kit