



HITCH RECEIVER OEM INSTALLATION MANUAL

LIPPERT
COMPONENTS®

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Introduction

The following accessory hitch kits are designed to be installed only on trailers previously and specifically prepared for the installation. Installation of any hitch kit on trailers not previously prepared for the installation will result in voiding the warranties of the hitch and the frame.

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| • 2" Accessory Hitch Receiver | Max Load Rating: 300 lbs (136 kg) |
| • Bike Rack Hitch Receiver | Max Load Rating: 150 lbs (68 kg) |
| • 1 1/4" Bolt-On Hitch Receiver | Max Load Rating: 150 lbs (68 kg) |
| • Boat Hitch Receivers 70 1/2" & 71 1/2" | Max Load Rating: 300 lbs (136 kg)
Max Towing Capacity 3,000 lbs (1361 kg) |
| • Boat Hitch Receiver 73 1/2" & 74 1/2" | Max Load Rating: 350 lbs (159 kg)
Max Towing Capacity 3,500 lbs (1587 kg) |

Safety

Read and understand all instructions and observe all safety labels before performing any product installation.

WARNING

DO NOT exceed the maximum load or tongue weight rating of any hitch kit. Exceeding maximum load or weight ratings can create a hazardous condition that may result in possible death, serious personal injury or severe product and/or property damage, including voiding of the warranty.

WARNING

DO NOT use an accessory hitch kit, that is not designed for towing, to tow any trailer or other vehicle. Use of a hitch kit not designed for towing can create an unstable condition resulting in possible death, serious personal injury or severe product and/or property damage, including voiding of the warranty.

WARNING

Failure to remove flammable objects, obstructions or additional components prior to a welding operation may create a hazardous condition that could result in possible death, serious personal injury or severe product or property damage.

CAUTION

Always wear eye protection when performing this installation procedure. Other safety equipment to consider would be hearing protection, gloves, and possibly a full face shield, depending on the nature of the installation procedure.

CAUTION

Moving parts can pinch, crush or cut. Keep clear and use caution.

Resources Required

- 1-2 people, depending on task
 - 7/8" socket or adjustable wrench
 - 9/16" socket or adjustable wrench
 - Torque wrench
- Jack stands
 - Welder
 - Safety glasses

Installation

2" Accessory Hitch Receiver



Part #	Description
341633	2" Accessory Hitch, Black - 69"
691020	2" Accessory Hitch, Black - 69" (with offset receiver)
430666	2" Accessory Hitch, Black - 72"
799970	2" Accessory Hitch, Black - 72.5"
328676	2" Accessory Hitch, Black - 75"

Hardware Required

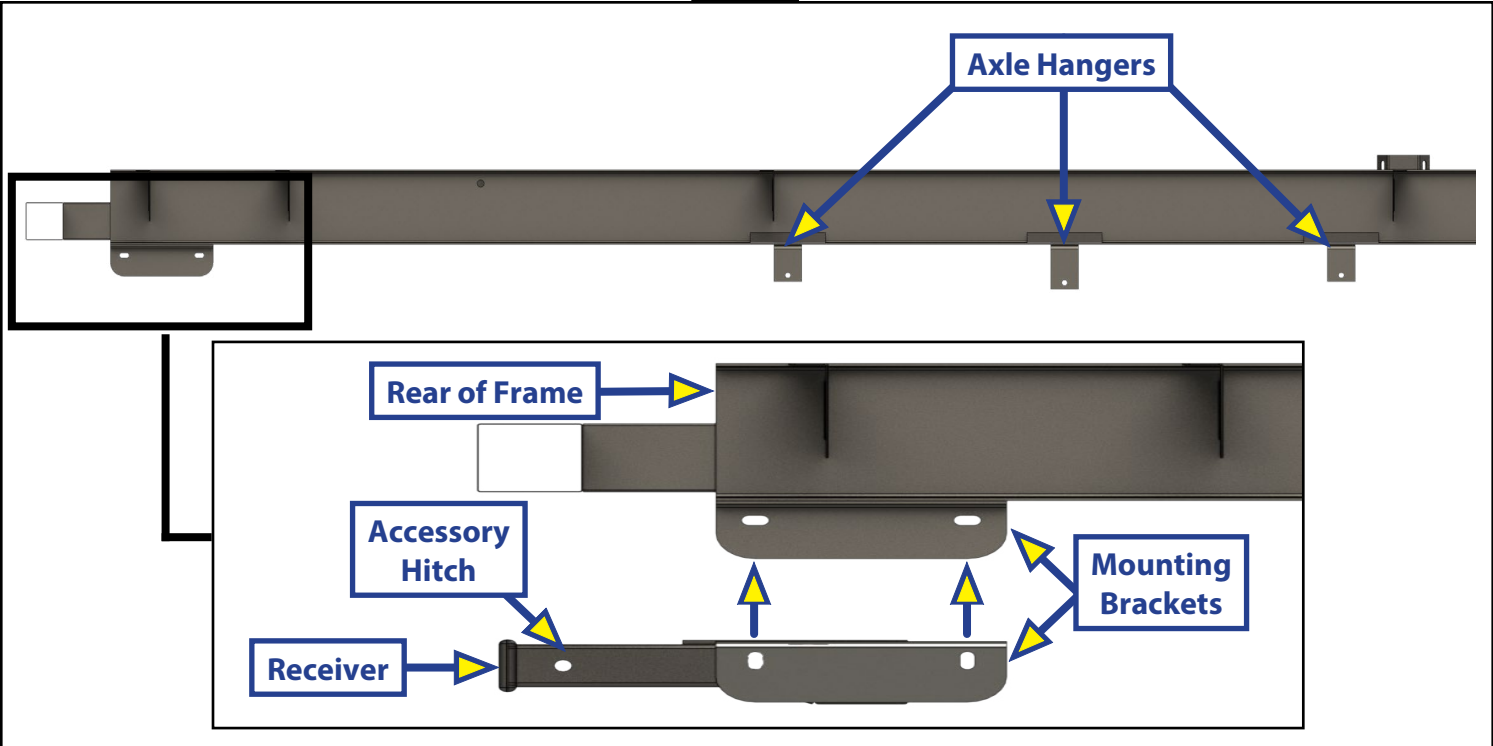
- 1/2"-13 x 1 1/2" hex bolt, GR5 Zn (4)
 - 1/2" flat washers, SAE (8)
- 1/2"-13 nylon locking nuts (4)

Assembly Instructions

1. Locate one of the accessory hitch mounting brackets at the rear of the trailer frame (Fig. 1).
2. Position the accessory hitch so that the mounting holes on the hitch are aligned with the holes in the mounting bracket on the frame (Fig. 1). As needed, use a jack stand or an additional person to assist in aligning mounting bracket holes.

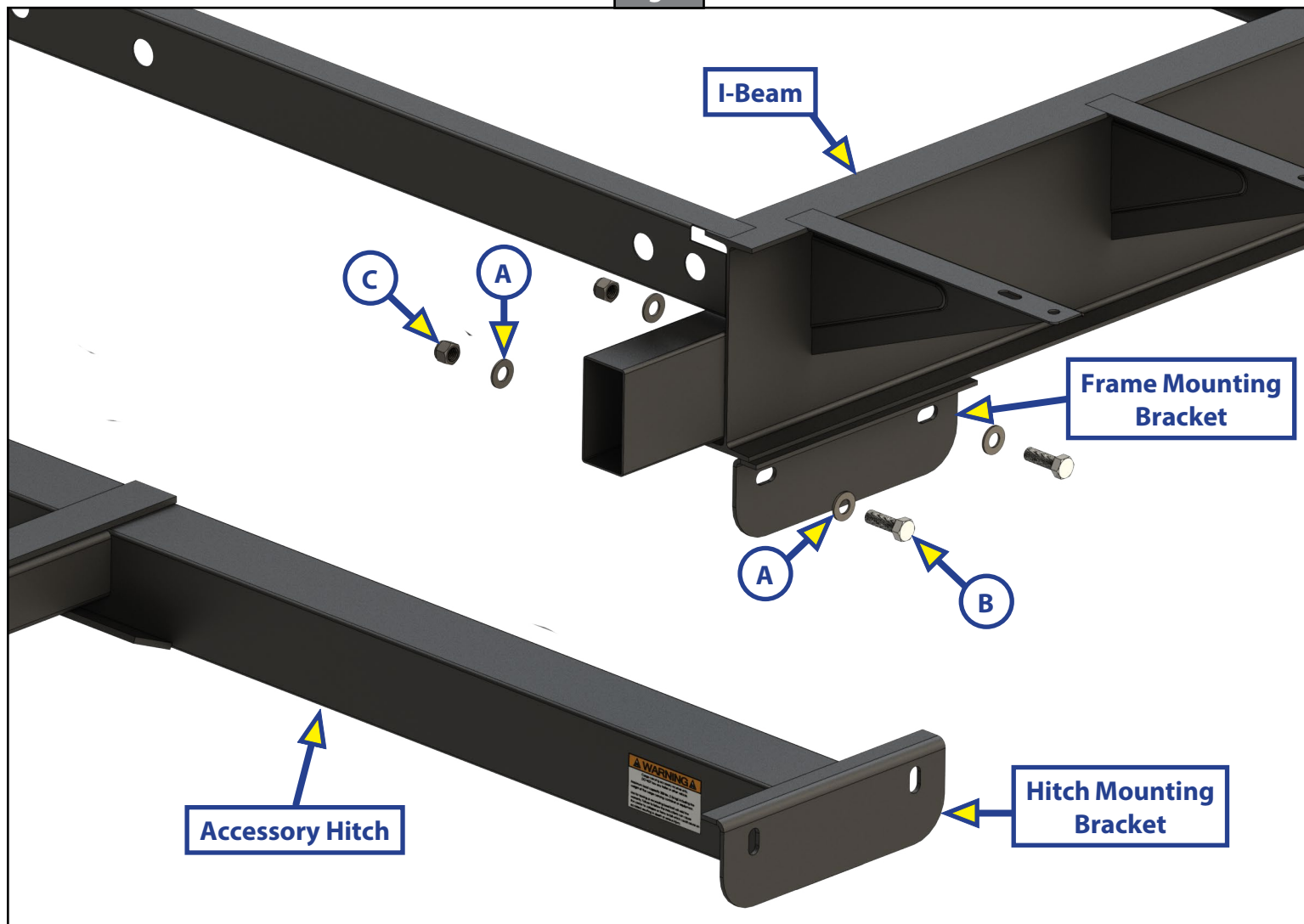
NOTE: The receiver (Fig. 1) of the accessory hitch should be facing the rear of the trailer.

Fig. 1



3. Place one $\frac{1}{2}$ " flat washer (Fig. 2A) onto a $\frac{1}{2}$ " - 13 x 1 $\frac{1}{2}$ " hex bolt (Fig. 2B).
4. Starting from the outside of the frame, insert the hex bolt assembly through a frame mounting bracket hole and through its mating hitch mounting bracket hole.
5. Place another $\frac{1}{2}$ " flat washer (Fig. 2A) onto the $\frac{1}{2}$ " hex bolt, then thread a $\frac{1}{2}$ " - 13 nylon locking nut (Fig. 2C) onto the hex bolt to secure the mounting brackets.

Fig. 2



6. Repeat steps 3-5 for the other mounting bracket hole.
7. Align frame and hitch mounting brackets, then tighten the $\frac{1}{2}$ " nylon locking nuts with a $\frac{7}{8}$ " wrench. Torque nuts 85-90 ft-lbs to secure assembly.
8. Repeat steps 1-7 for the mounting brackets on the other side.

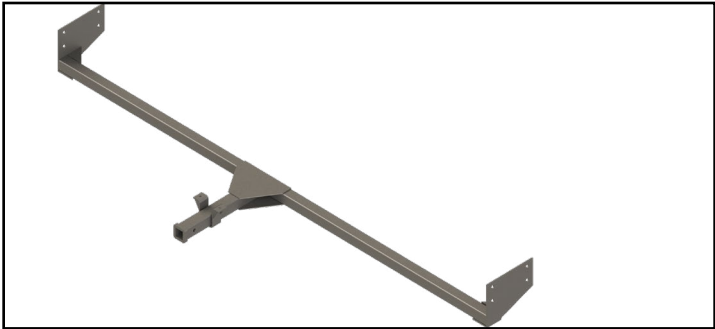
Bike Rack /Accessory Hitch Receiver



Part #	Description
148945	Bike Rack Hitch Receiver - 65 5/16"



Part #	Description
178684	Bike Rack Hitch Receiver - 68 5/8"



Part #	Description
181674	Bike Rack Hitch Receiver - 79"



Part #	Description
240220	1 1/4" Bolt-On Receiver, Black - 68 3/8"

Hardware Required

- 3/8"-16 x 1" hex bolt, tap GR5 Zn (8)
- 3/8" flat washers, SAE (16)
- 3/8"-16 nylon locking nuts (8)

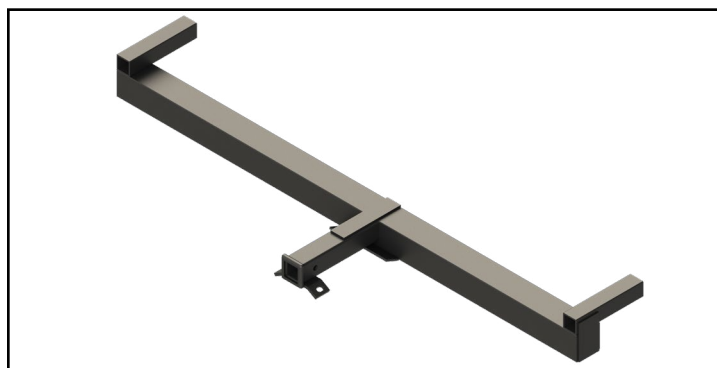
Pre-assembly Instructions

There are multiple frames that can accommodate these bike rack hitch receivers, so first determine that the frame is the right size for the hitch and that it has correct mounting bracket welded to the frame for the type of hitch being installed.

Assembly Instructions

1. Locate the accessory hitch mounting brackets at the rear of the frame.
2. Position the accessory hitch so that the mounting holes on the hitch are aligned with the holes in the mounting bracket on the frame. As needed, use a jack stand or an additional person to assist in aligning mounting bracket holes. The receiver of the hitch should be facing the rear of the trailer.
3. Place one $\frac{3}{8}$ " flat washer onto a $\frac{3}{8}$ "-16 x 1" hex bolt.
4. Starting from the outside of the frame, insert the bolt assembly through a frame mounting bracket hole and through its mating hitch mounting bracket hole.
5. Place another $\frac{3}{8}$ " flat washer onto the $\frac{3}{8}$ "-16 x 1" hex bolt, then thread a $\frac{3}{8}$ "-16 nylon locking nut onto the hex bolt to secure the mounting brackets.
6. Repeat steps 3-5 for the other mounting bracket hole.
7. Align frame and hitch mounting brackets, then tighten the $\frac{3}{8}$ "-16 nylon locking nuts with a $\frac{9}{16}$ " wrench. Torque nuts 85-90 ft-lbs to secure assembly.
8. Repeat steps 1-7 for the mounting brackets on the other side.

Boat Hitch Receiver



Part #	Description
125851	Boat Hitch Receiver, Weld-on - 70 1/2"
168425	Boat Hitch Receiver, Weld-on - 72 1/2"
344927	Boat Hitch Receiver, Weld-on - 73 1/2"



Part #	Description
273372	Boat Hitch Receiver, Weld-on - 74 1/2"

Procedures

NOTE: Some components have been removed for clarity.

NOTE: Installation may be performed with the chassis upside down.

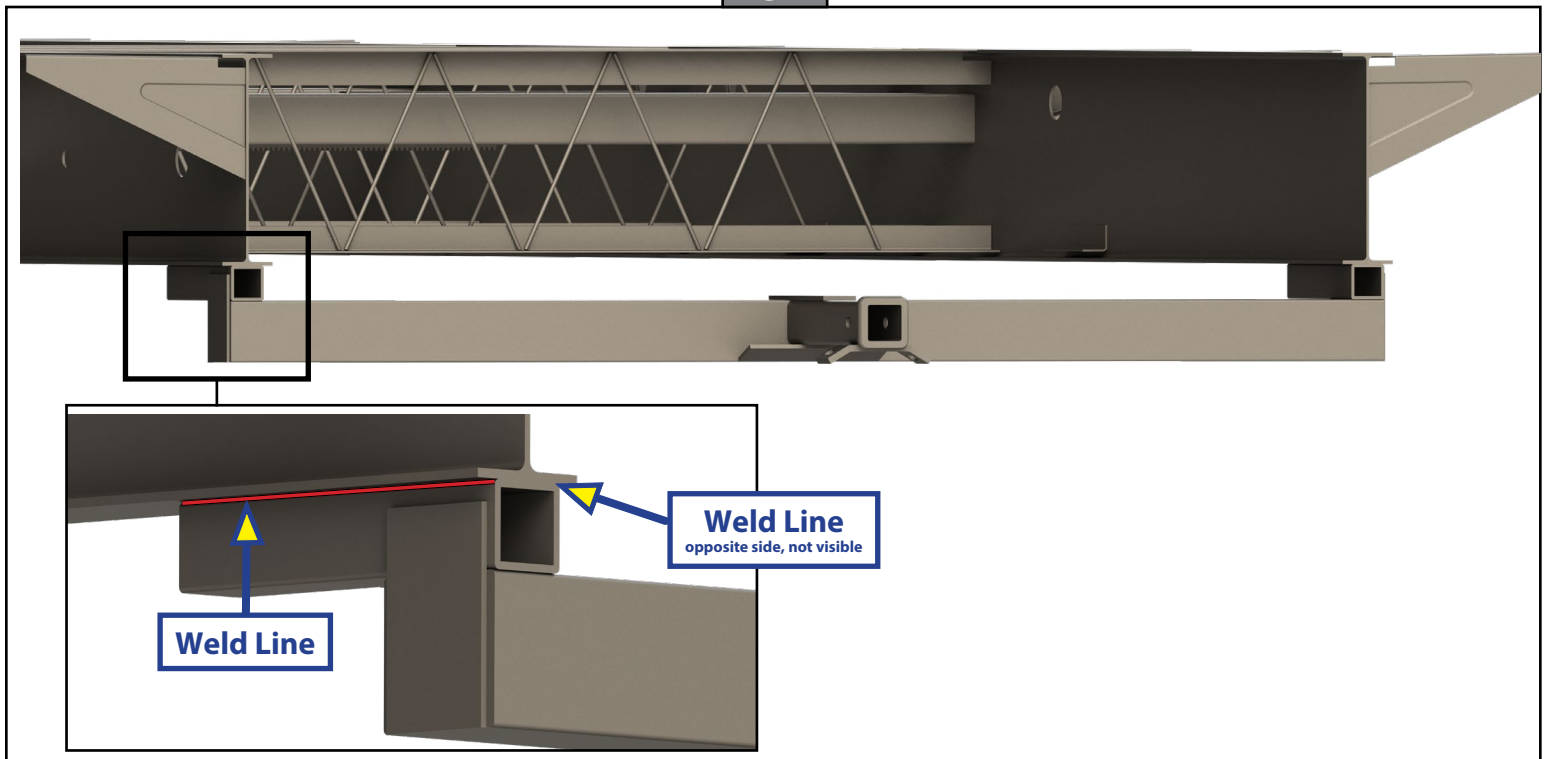
NOTE: Solid red-black lines in figures refer to using a welder to add frame components per instructions and image references.

1. Position the hitch so that the front of the hitch arms are aligned with the edges of the frame I-beams. As needed, use a jack stand or an additional person to assist with alignment.

NOTE: The receiver of the hitch should be facing the rear of the trailer.

2. Weld the top of the hitch receiver to the underside of I-beams of the frame (Fig. 3). Repeat on the other side.
3. After the welds have cooled, clean the weld areas.

Fig. 3





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