Installation Instructions

5613500 **Gooseneck Flip Ball Hitch**

Flatbed Kit
3/4-Ton & 1-Ton Trucks for all Manufactures & Models

⚠ WARNING

Fuel lines, brake lines, and electrical wires are located along the frame of the truck. When positioning the gooseneck flip ball hitch, care must be taken to avoid damaging these components.

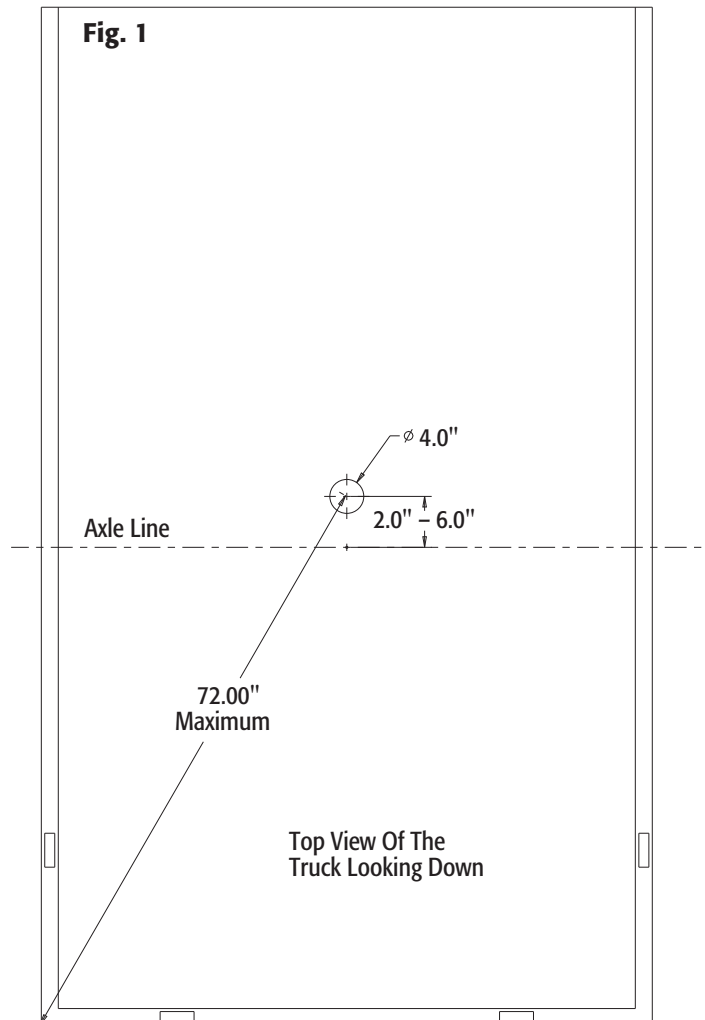**⚠ WARNING**

Before installing the gooseneck flip ball hitch, check for adequate turning clearance of the front of your trailer and the truck cab

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⚠ WARNING

On 2WD trucks, remove the ball from the socket when carrying heavy loads. Under load, the ball may contact the differential, causing damage.

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1. This hitch is design to use 1/8 inch floor plate. Thicker floor is desirable, but thinner is not recommended.
2. When welding the hitch, avoid excessive heat to prevent distortion. Welding on the side of the hitch plate is recommended. Do not weld on the center-socket itself.
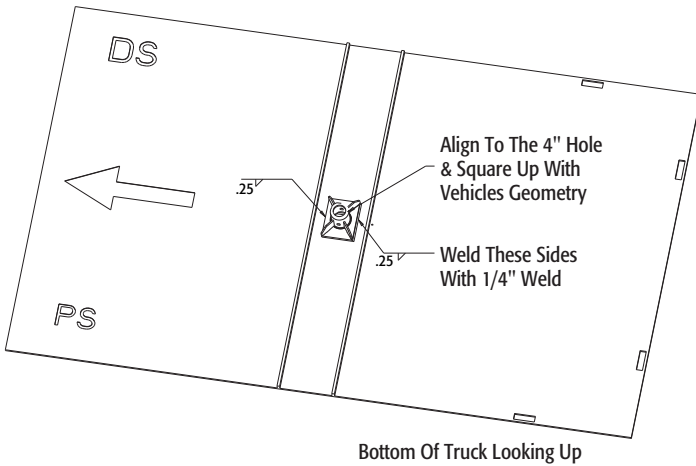
Fig. 1

Ø 4.0"

Axle Line

2.0" – 6.0"

72.00"
Maximum

Top View Of The
Truck Looking Down

3. Locate the center of the receiver socket and add 2 to 6 inches. Make sure the distance of the hole toward the rear-corner of the flat bed is less than 72 inches. This distance will enable the turning clearance to avoid unnecessary rubbing and scratching
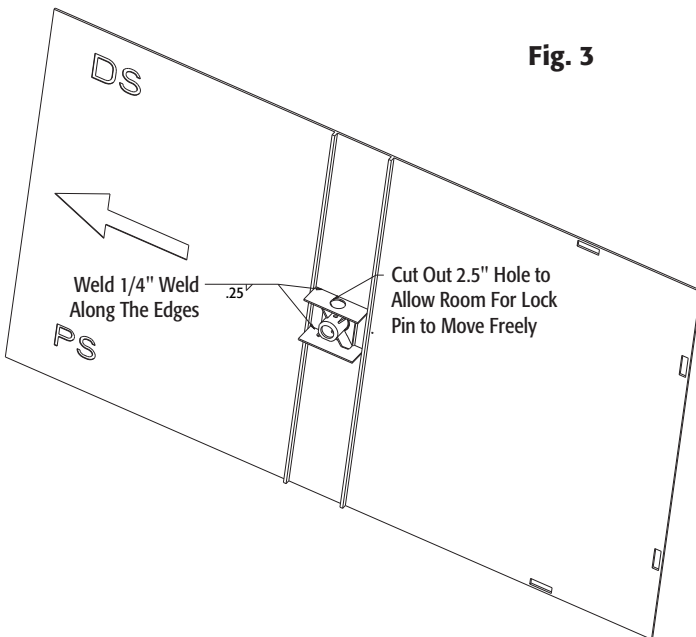
4. Mark and cut out the 4 inch hole.

Fig. 2

DS

PS

.25"

.25"

Align To The 4" Hole & Square Up With Vehicles Geometry

Weld These Sides With 1/4" Weld

Bottom Of Truck Looking Up

5. Fit the hitch through the 4 inch hole just cut. Push the hitch against the floor to make sure the surface is flat with the bed. Weld the two sides that do not have the latch pin holes onto the flat bed. Make sure the latch pin holes aligned squarely toward the driver side.
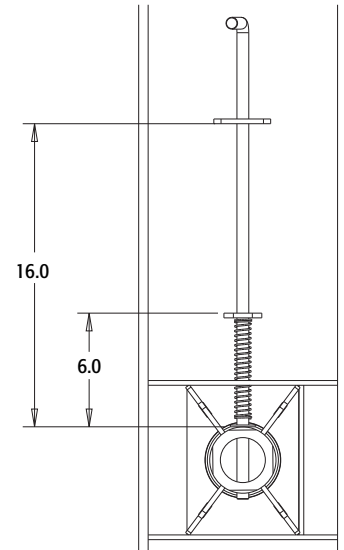
6. Add the Center Braces, 4" x L length of the cross bar on the truck. 1/4 inch material is recommended (2 center braces are not included with this hitch). Also, cut a 2.5 inch hole to allow access for the 5/8 inch lock pin to engage onto the socket. Weld all around the brace.

Fig. 3

DS

PS

.25"

Weld 1/4" Weld Along The Edges

Cut Out 2.5" Hole to Allow Room For Lock Pin to Move Freely

7. Install the spring onto the long latch pin handle through the guide-plate and the slot-plate. Compress the spring between the washer on the latch pin handle and the pin guide to about 6 inches from the edge of the socket diameter. Weld it to the flat bed. Measure the lot-plate to about 16 inches from the edge of the socket and weld it to the flat bed.
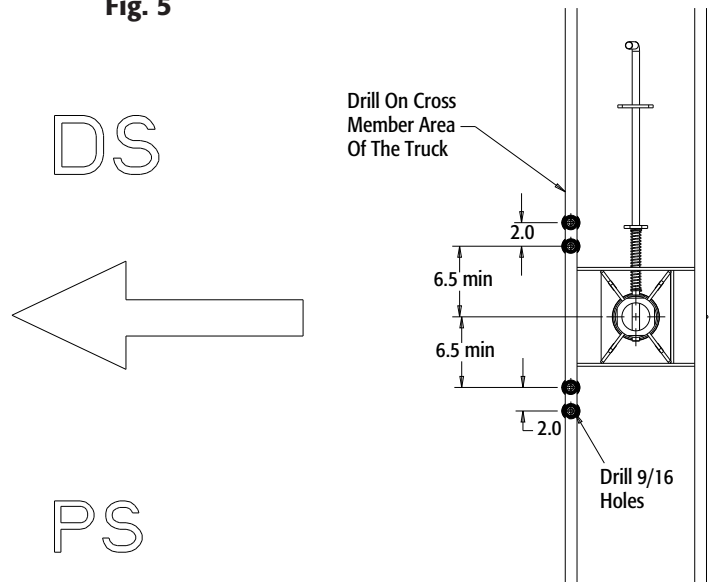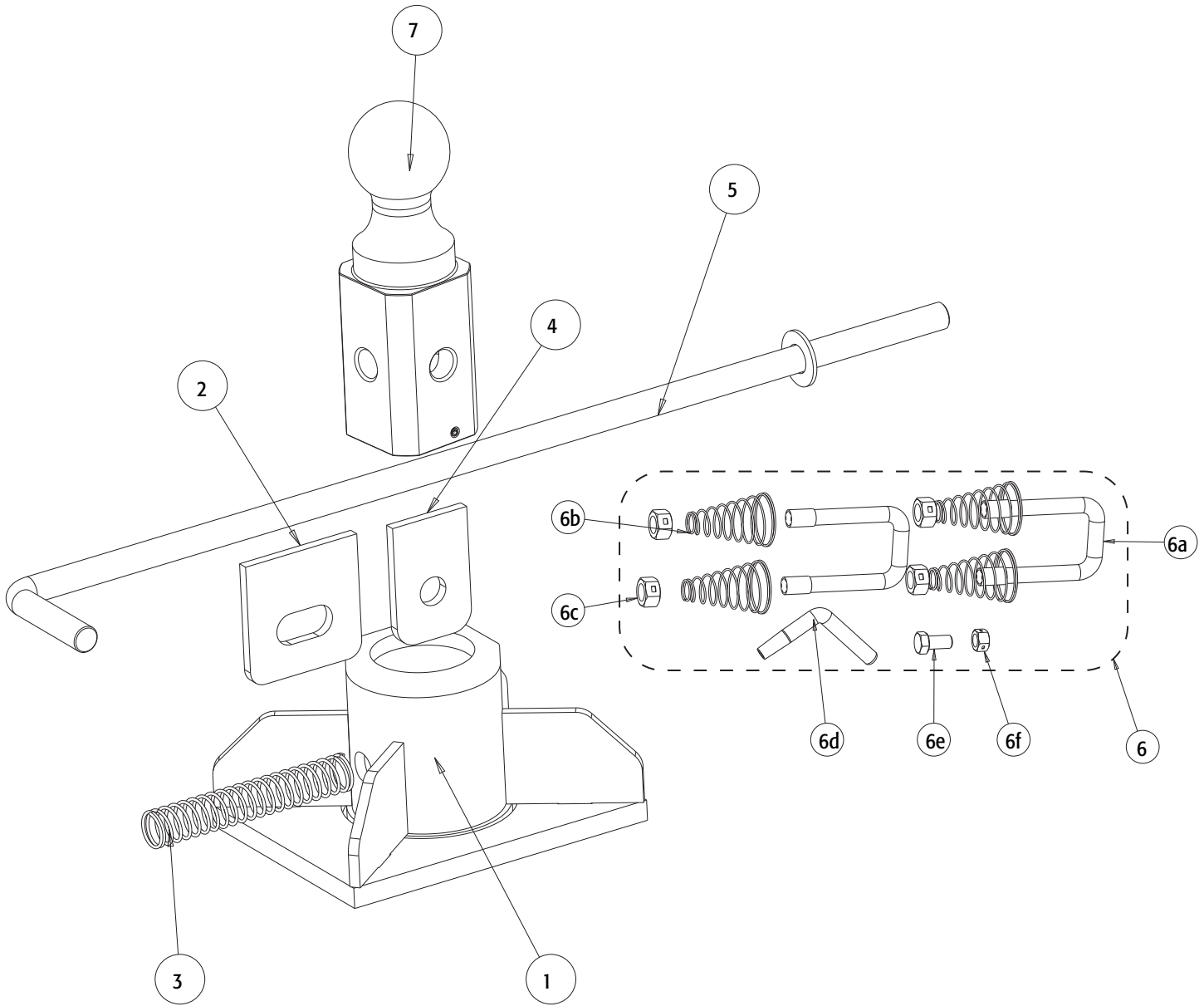
Fig. 4

16.0

6.0

8. Install the safety chain u-bracket just a little bit ahead of the center socket. Measure 6.5" to the left and 6.5" to the right of the center of the socket. Using the u-channel as a guide, mark and drill four 9/16" holes.

9. Drop the u-bracket through the newly drilled holes. Insert the four triangular Springs onto the u-brackets and secure it with the proper ½ inch fasteners provided.

Fig. 5

DS

PS

Drill On Cross Member Area Of The Truck

2.0

6.5 min

6.5 min

2.0

Drill 9/16 Holes

Repair Parts - Gooseneck Hitch Assembly

Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3021778	1	Hitch Weldment, Flatbed, Flip-Over
2	3022781	1	Guide, Handle with Slot
3	3018207	1	Spring Compression
4	3022780	1	Guide, Handle with Round Hole
5	3022873	1	Lever, Long Twisting Pin
6	3021719	1	Hardware Kit, Center Section
6a	3018214	2	U-Bolt, Square, Zinc ,Special
6b	3018215	4	Spring, Compression, Taper Coil
6c	–	4	Nut, Center Lock, Hex 1/2-13 ZN
6d	3018212	1	Sleeve, Vinyl, 1/4 x 4, Black
6e	–	1	Screw, 3/8-16 x 3/4 CAP
6f	–	1	Nut, Hex, 3/8-16 Center Lock, ZP
7	3018195	1	Ball, Flip Over, with Pin

WARRANTY

Buyers Products Co. warrants all truck/trailer hardware manufactured or distributed by it, to be free from defects in material and workmanship for a period of one year from date of shipment. Parts must be properly installed and used under normal conditions. Any product which has been altered, including modification, misuse, accident or lack of maintenance will not be considered under warranty. Normal wear is excluded. The sole responsibility of Buyers Products Co. under this warranty is limited to repairing or replacing any part or parts which are returned, prepaid, and are found to be defective by Buyers Products Co. Authorization from Buyers Products Co. must be obtained before returning any part. No charges for transportation or labor performed on Buyers' products will be allowed under this warranty.