

# 25' Flex Trail

## Assembly Directions



# 25' Flex Trail

## Parts Sheet

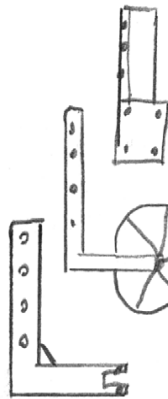
|     |                             |
|-----|-----------------------------|
| 5   | Heavy 5' Wick Tubes         |
| 6   | Wheels on Brackets          |
| 1   | 12 'Main Tongue             |
| 1   | 5' Main Frame               |
| 1   | Hitch                       |
| 2   | Braces                      |
| 2   | Long Braces                 |
| 2   | Short angle braces          |
| 2   | 5' wings                    |
| 2   | 5' Wings (hole on each end) |
| 2   | Wing Holder                 |
| 2   | Brace Plate                 |
| 6   | Wheel Brackets              |
| 6   | Muffler Clamps              |
| 4   | Long Muffler Clamps         |
| 4   | Hinges                      |
| 4   | Brace Holders               |
| 1   | SMV sign                    |
| 1   | 2" flat steel for SMV sign  |
| 10  | Round 3" u-bolts            |
| 4   | 3/8 x 3 1/2 bolts           |
| 12  | 1/2 x 3 1/2 bolts           |
| 16  | 1/2 "Lock nuts              |
| 4   | 1/2 x 1 1/2 bolts           |
| 16  | Pins                        |
| 16  | Hair Pins                   |
| 1   | 3/4" Locking Bolt           |
| 43  | Square 2" u-bolts           |
| 110 | 3/8 "Flange Nuts            |
| 2   | 1/4 x 1 bolts               |
| 2   | 1/4 nuts                    |

## Assembly Directions:

1. Bolt the 12' main tongue to the 5' main frame with 4 – ½ x 3 ½ “ Bolts and ½” lock nuts. Make sure that it is in the centre of the main frame, to ensure that it will pull straight.



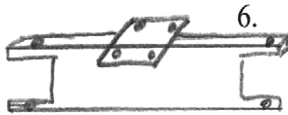
2. Bolt on the cross braces with 4 – 3/8 x 3 ½ “ bolts to the main tongue and u-bolts onto the main frame. (make sure you measure from the front of the tongue to the ends of the main frame,(left and right side) to make sure the frame will pull straight when you are towing the unit).



3. Bolt on 2 wheel brackets using 2 – u-bolts and the 3/8” flange nuts. Place approx. 4 ½ “ in from the end. (they should be placed for your row width, and if there is no row width, place close to the end)

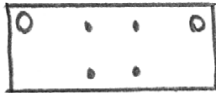
4. Slide in the wheels (that are mounted onto their bracket) and secure with a pin and a hair pin.

5. Slide in the hitch into the front of the main tongue and secure with a pin and a hair pin. The locking bolt goes here and when tightened secures the hitch more snugly.

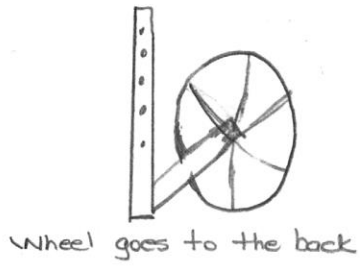
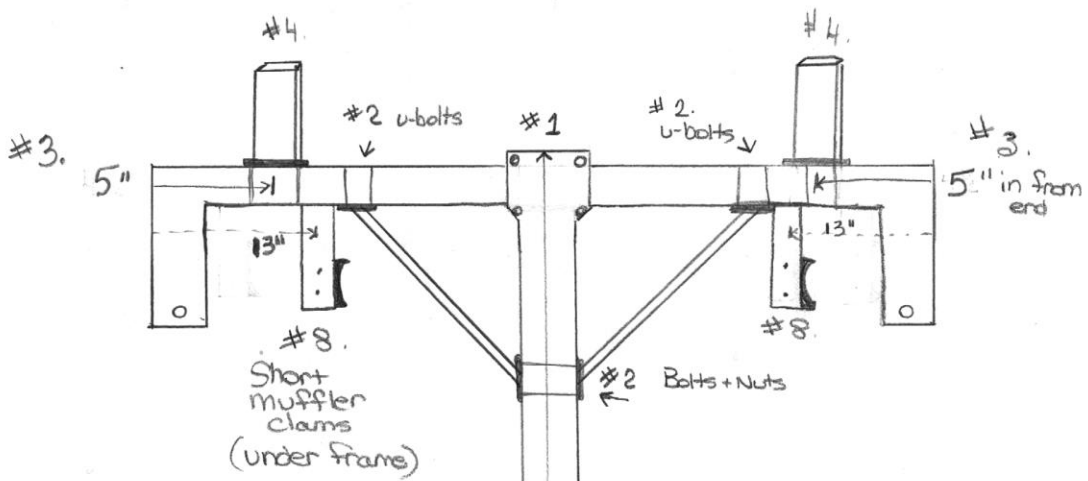


6. Bolt on the wing holders to the main tongue.(they go underneath the tubing on the underside) Use 2 – u-bolts and the 3/8 “ flange nuts. The first one goes 136 ½ “ measured from the main frame. The measurement is from the flat plate on the tongue to the center of the wing holder. The second one also goes on the underside of the tubing. The measurements are 95” to the center of the wing holder.

7. The brace plates measurements are 67” and 129 ½ “. The plate gets u-bolted onto the top side of the tubing, look at the picture to determine which way the plate goes on. The 87” brace gets bolted onto the plate that is at the 67” mark and the 175” brace gets bolted onto the plate that is at the 129 ½” plate. They get bolted on with a ½ x 1 ½” bolt and lock nut. Once you have the wings on you will see where the other end of the brace goes.



8. Take 2 – of the shorter muffer clamps and u-bolt them 13” in from the end of the tubing.



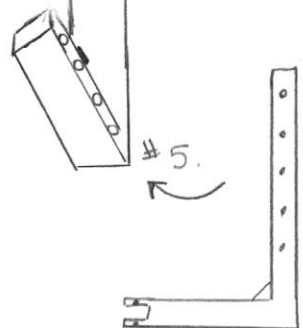
#7. 67" in from end.

(All measurements are from the end to the centre of plate)

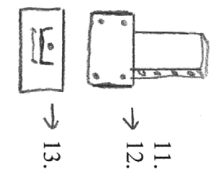
#6. 95" from the end.

#7. 129 1/2" from the end.

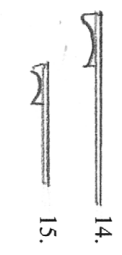
#6. 136" from end.



9. Add the first set of wings, the ones with a hole in each end, using the hinges. Bolt on with the 1/2 x 3 1/2" bolts and the 1/2 in lock nuts.
10. Bolt on the wheel holders using u-bolts and 3/8" flange nuts. The wheel holder goes on the back side of the tubing. Follow the diagram for the measurements. Slide in the wheels (that are mounted to their bracket) and secure with a pin and a hair pin. The wheel goes to the back.



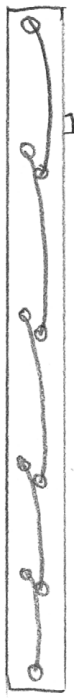
11. Now add the next set of wings, bolt on the hinge and the wing with 2 - 1/2 x 3 1/2 bolts and lock nuts.
12. Bolt on the wheel holder using u-bolts and 3/8" flange nuts. The wheel holder goes on the back side of the tubing. Follow the diagram for the measurements. Slide in the wheels and secure with a pin and a hair pin. The wheel goes to the back.
13. Bolt on the brace holders with 2 - u-bolts and 3/8" flange nuts. Follow the diagram for the measurements. It is mounted onto the front side of the wings. The brace goes into the brace holder and is secured with a pin and a hair pin.

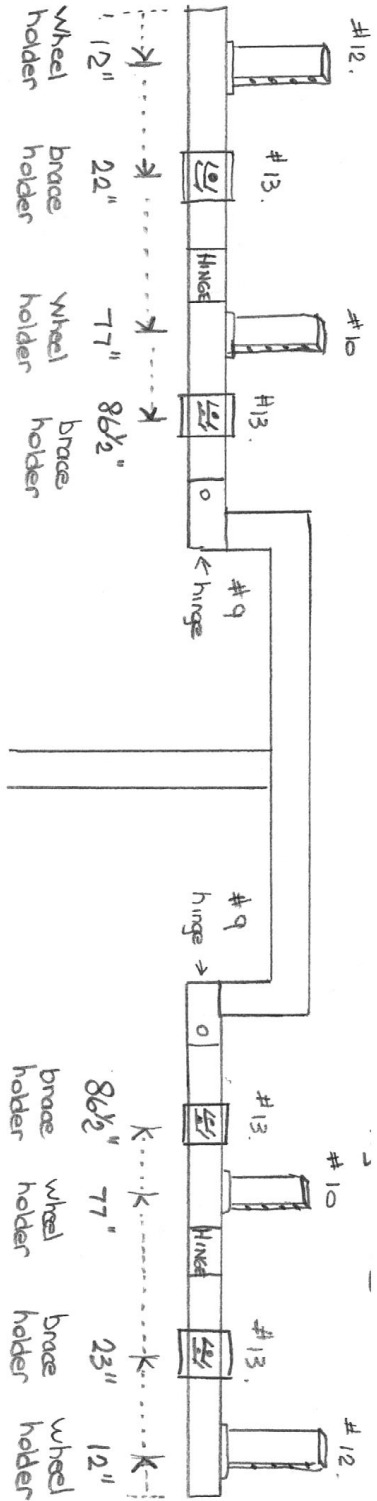


14. Bolt on the long muffer clamps (u-bolt to the under side of the tubing) with a u-bolts and 3/8" flange nuts. The four long ones go on the center wing.
15. Bolt on the short muffer clamps (u-bolt to the under side of the tubing) with a u-bolt and 3/8" flange nuts. Follow the diagram for the measurements.
16. You are now ready to bolt on the wick tubes. The fill cap goes to the top, the ropes face forward. Use the round u-bolt to mount these. They slip around the wick tube and get fastened to the muffer clamps. Do not faster to tight, it should be snug but not tight.

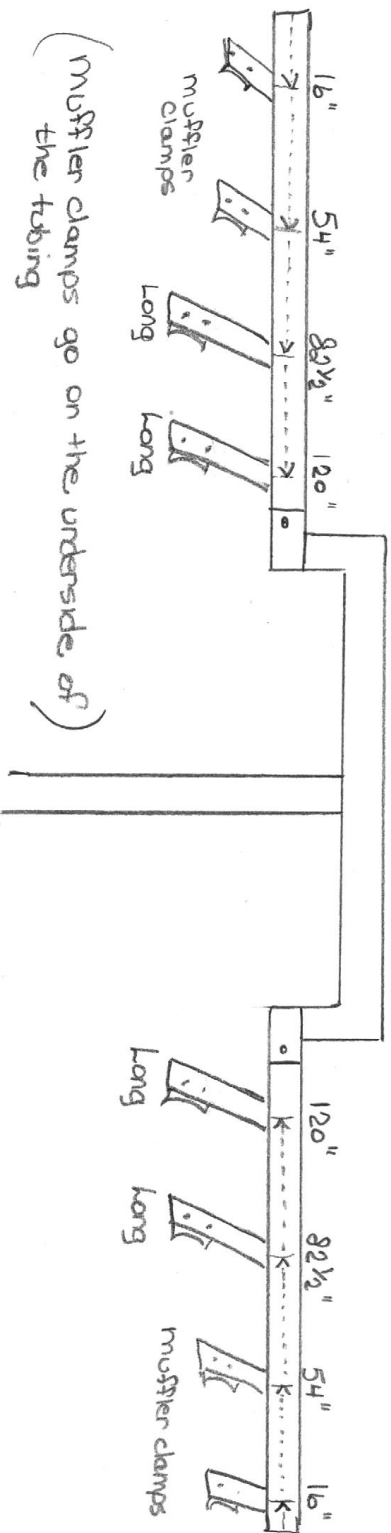
SLIGHT ADJUSTMENTS MAY HAVE TO BE MADE, FOR PROPER FIT.

17. When you want to fold up for transport you have to pull the pin on the braces and slide the brace to the center of the unit (straight back). Do that to both of the braces and then lock the wings into the wing holders securing with a pin and a hair pin. Always hook the unit to your tractor before putting the wings into the wing holders.





All measurements go to the centre of the bracket.  
 Wheel brackets go on the back side of the wings  
 brace holders go on the front side of the wings



(Muffler clamps go on the underside of the tubing)  
 Slight Adjustments may have to be made