



## **Assembly Manual**

4' x 4' - 4' x 6' - 4' x 8' Galvanized Kit Trailers

Carefully read and follow the assembly instructions in this manual.

Before using the trailer, carefully read the owner's manual.

Save both manuals for future reference.



***Congratulations on the purchase of your kit trailer. Thank you for choosing Westbrook.***

## **Safety Information**



- It is important to read and understand all the instructions. Failure to follow all assembly instructions may result in serious injury.
- The edges of the trailer frame can be very sharp. To prevent injury wear safety gloves (included) during assembly.
- It is recommended that you use two people to assemble your trailer since you will need to turn the trailer over twice to complete the assembly.
- Modification of the trailer structure can make the trailer unsafe and void your warranty. Any modifications made to the trailer must comply with DOT and NHTSA regulations and must not compromise the gross vehicle weight rating (GVWR) of the trailer.

## **Important Information**

- Included in your kit is the completed New Vehicle Information Sheet (NVIS) or Certificate of Origin and the VIN label. These are important documents and are required to register your trailer.
- If the NVIS form hasn't been completed, please contact us at 866-857-1445.
- Write the VIN of the trailer and the purchase date in the space below.
- Keep this manual and your receipt in a safe and dry place for future reference.

**Serial Number :2SSUB11A** \_\_\_\_\_

**Purchase Date:** \_\_\_\_\_

## **Step 1 - Unboxing your trailer & getting ready to assemble the trailer**

When unpacking, verify that you have all the parts listed in each section. If any parts are missing or broken, please contact us at 866-857-1445. When calling about your trailer, please have the VIN available.

The kit trailer is shipped in 3 boxes or 4 boxes containing the following parts:

Box # 1 - Axle box includes the axle and the frame channels

Box # 2 - Tire box includes tires, fenders, lights, small parts and hardware

Box # 3 - Slipper Springs

Box # 4 - Ramps

To ease the assembly process, gather the pieces you will need for each step and thoroughly read the assembly instructions for the step prior to assembly for the step. Before you begin, you need to prepare a large area to work.

## **Tools Required**



- Ratchet with Socket of
  - $\frac{3}{8}$ "
  - $\frac{1}{2}$ "
  - $\frac{9}{16}$ "
  - $\frac{7}{8}$ "
  - $\frac{13}{16}$ "
- $\frac{9}{16}$ ",  $\frac{3}{4}$ ",  $\frac{7}{8}$ " Wrench
- Phillips Screwdriver
- Pliers

## Step 2 - Hardware

Using the pictogram and the table below, make sure you have all the hardware and fasteners required before you begin assembling the trailer.

| ITEM # | DESCRIPTION                            | 4' x 4' | 4' x 6' | 4' x 8' |
|--------|--|---------|---------|---------|
| 500814 | 3/8-16 U-BOLT                          | 4       | 4       | 4       |
| 501049 | 3/8-16 X 3/4" HEX FLANGE BOLT          | 20      | 18      | 26      |
| 501033 | 3/8-16 X 1 1/2" HEX BOLT               | 10      | 13      | 20      |
| 501036 | 3/8-16 X 3/4" CARRIAGE BOLT            | 8       | 8       | 8       |
| 501031 | 3/8-16 NYLON INSERT HEX FLANGE LOCKNUT | 46      | 46      | 61      |
| 501023 | 3/8-16 X 2-1/2" HEX BOLT               | 1       | 1       | 1       |
| 501024 | 3/8-16 X 3" HEX BOLT                   | 2       | 2       | 2       |
| 501032 | 3/8" FLAT WASHER                       | 8       | 4       | 4       |
| 501060 | 1/2-13 X 3 1/2" HEX BOLT               | 2       | 2       | 2       |
| 501056 | 1/2-13 NYLON INSERT LOCKING NUT        | 2       | 2       | 2       |
| 501065 | 9/16-18 UNF X 3" HEX BOLT              | 4       | 4       | 4       |
| 501066 | 9/16-18 UNF NYLON INSERT LOCKING NUT   | 4       | 4       | 4       |
| 501091 | 10-24 X 1/2" PHILLIPS #2 MACHINE SCREW | 8       | 8       | 8       |
| 501092 | 10-24 NYLON INSERT LOCKING NUT         | 8       | 8       | 8       |
| 501100 | 5/16-18 UNC X 1/2" CUTTING SCREW WITH  | 4       | 4       | 4       |
| 501101 | 1/2" NF PRESS IN WHEEL STUD            | 10      | 10      | 10      |

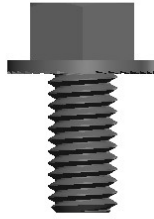
If your model includes stake pockets your kit will include the following additional hardware:

| ITEM # | DESCRIPTION                     | 4' X 4' | 4' X 6' | 4' X 8' |
|--------|---------------------------------|---------|---------|---------|
| 504471 | STAKE POCKET                    | 8       | 8       | 8       |
| 501073 | 1/4-20 X 3/4" HEX BOLT          | 32      | 32      | 32      |
| 501081 | 1/4-20 NYLON INSERT LOCKING NUT | 32      | 32      | 32      |

## Hardware



Item#501049  
3/8-16 x 3/4  
Hex Flange Bolt



Item#501036  
3/8-16 x 3/4  
Carriage Bolt



Item#501023  
3/8-16 x 2-1/2  
Hex Bolt



Item#501024  
3/8-16 x 2-1/2  
Hex Bolt



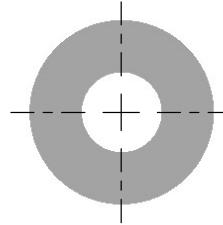
Item#501031  
3/8-16 Nylon Insert  
Locking Nut



Item#501033  
3/8-16 x 1-1/2  
Hex Bolt (full thread)

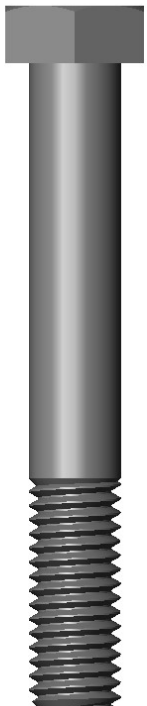


Item#501032  
3/8 Flat Washer



If your kit includes stake  
pockets  
Seulement si votre kit inclus  
les poches de mise

Item#501060  
1/2-13 x 3-1/2  
Hex Bolt



Item#501065  
9/16-18 UNF  
Hex Bolt



Item#501056  
1/2-13 Nylon Insert  
Locking Nut



Item#501066  
9/16-18 UNC Nylon  
Insert Locking Nut



Item#501001  
1/2" Wheel Nut



Item#501091  
10-24 x 1/2 Phillips  
Machine Screw



Item#501092  
10-24 Nylon Insert  
Locking Nut



Item#501100  
5/16-18 UNC x 1/2  
Thread Cutting Screw



Item#501073  
1/4-20 x 3/4  
Hex Bolt



Item#501081  
1/4-20 Nylon Insert  
Locking Nut





## Step 2 - Frame Assembly

Gather the components below and layout as per corresponding figure of your trailer.

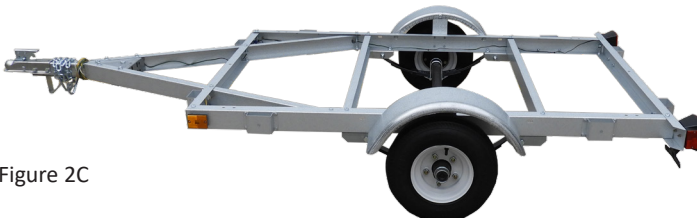
| ITEM # | PARTS DESCRIPTION                      | 4' x 4' | 4' x 6' | 4' x 8' |
|--------|--|---------|---------|---------|
|        |  | FIG. 2A | FIG. 2B | FIG. 2C |
| 501049 | 3/8-16 X 3/4" HEX FLANGE BOLT          | 6       | 4       | 6       |
| 501033 | 3/8-16 X 1 1/2" HEX BOLT (FULL THREAD) | 6       | 8       | 8       |
| 501031 | 3/8-16 NYLON INSERT HEX FLANGE LOCKNUT | 12      | 12      | 14      |
| 500254 | FRONT CHANNEL                          | 1       | 1       | 1       |
| 500255 | CROSS CHANNEL                          | 1       | 2       | 4       |
| 500256 | REAR CHANNEL                           | 1       | 1       | 1       |
| 500251 | 4' DRIVER SIDE CHANNEL (4X4)           | 1       |         |         |
| 500297 | 4' PASSENGER SIDE CHANNEL PS (4X4)     | 1       |         |         |
| 500252 | 6' DRIVER SIDE CHANEL (4X6)            |         | 1       |         |
| 500298 | 6' PASSENGER SIDE CHANNEL (4X6 )       |         | 1       |         |
| 500253 | 4' FRONT DRIVER SIDE CHANNEL (4X8)     |         |         | 1       |
| 500299 | 4' REAR DRIVER SIDE CHANNEL (4X8)      |         |         | 1       |
| 500300 | 4' FRONT PASSENGER SIDE CHANNEL (4X8)  |         |         | 1       |
| 500301 | 4' REAR PASSENGER SIDE CHANNEL (4X8)   |         |         | 1       |
| 500272 | CONNECTION CHANNEL (4X8)               |         |         | 2       |

4' x 4' - refer to figure 2A



- Model: 48-048-KO8
- GVW: 1000 Lbs.
- Payload: 850 Lbs.
- Bed Dimension: 4' x 4'
- Wheel Size: 4.80- 8 LRC
- Coupler: 1 7/8"
- Suspension: Leaf Spring

4' x 6' - refer Figure 2B



- Model/: 48-072-KO8
- GVW: 1000 Lbs.
- Payload: 800 Lbs.
- Bed Dimension: 4' x 6'
- Wheel Size: 4.80- 8 LRC
- Coupler/Attelage: 1 7/8"
- Suspension: Leaf Spring

4' x 8' - refer Figure 2C



- Model: 48-096-KO8
- GVW: 1230 Lbs.
- Payload: 1000 Lbs.
- Bed Dimension: 4' x 8'
- Wheel Size: 4.80- 8 LRC
- Coupler: 1 7/8"
- Suspension: Leaf Spring

(If your trailer kit includes stake pockets, please refer to page 18 prior to assembly)

Secure the top of the channel using item #501033 & 501031 and the bottom using item #501049 & 501031

- Front channel has two vertical slots
- Side channel square holes facing down.
- Back channel 3 holes facing up
- Cross-channels opening facing the rear



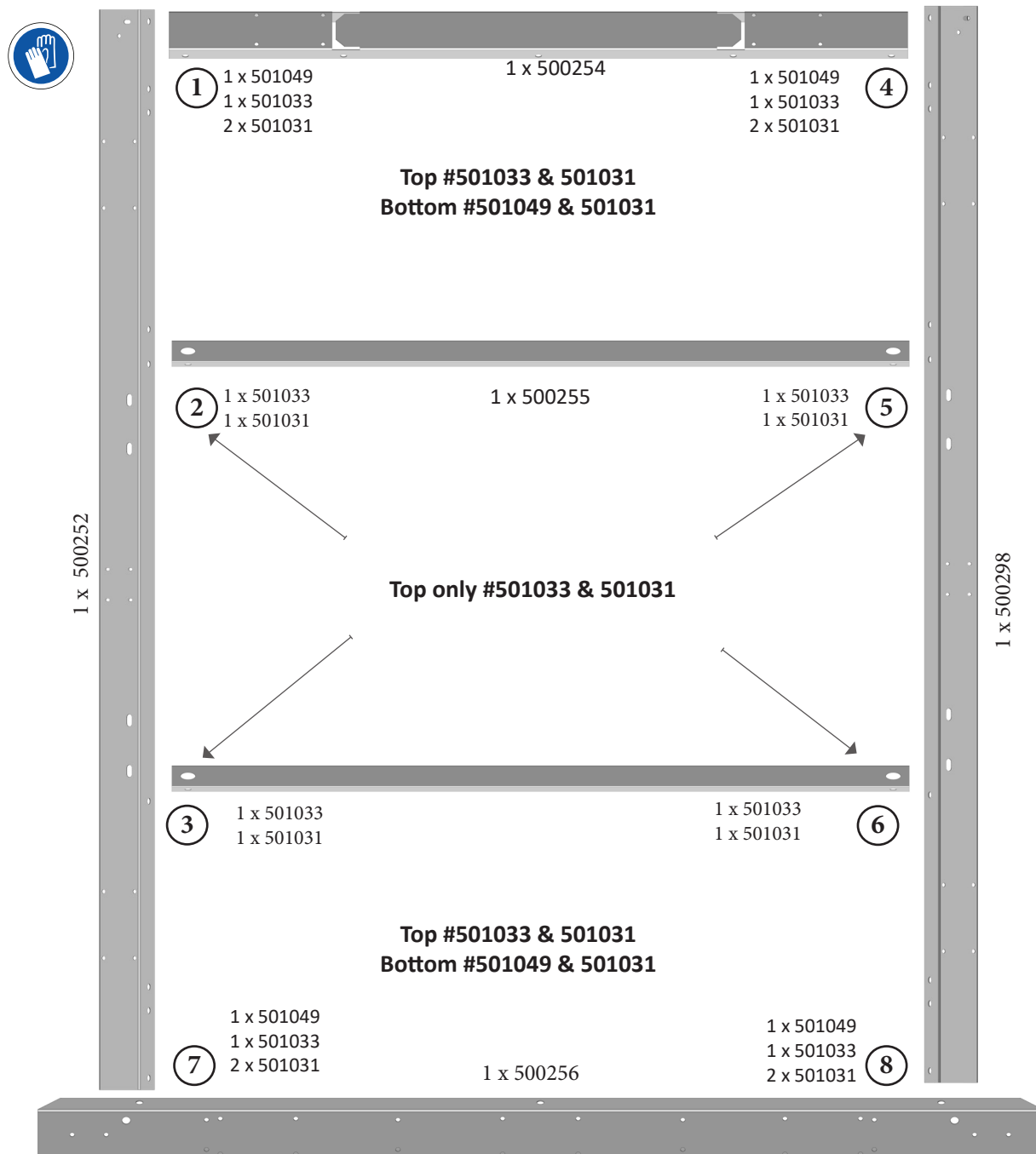
#### 4'x 6' Kit Trailer Frame - - Figure 2B

(If your trailer kit includes stake pockets, please refer to page 18 prior to assembly)

Loosely secure the frame in the numbered sequence below. **AT THIS POINT DO NOT TIGHTEN**

Secure the top of the channel using item #501033 & 501031 and the bottom using item #501049 & 501031

- Front channel has two vertical slots
- Side channel square holes facing down.
- Back channel 3 holes facing up
- Cross-channels opening facing the rear





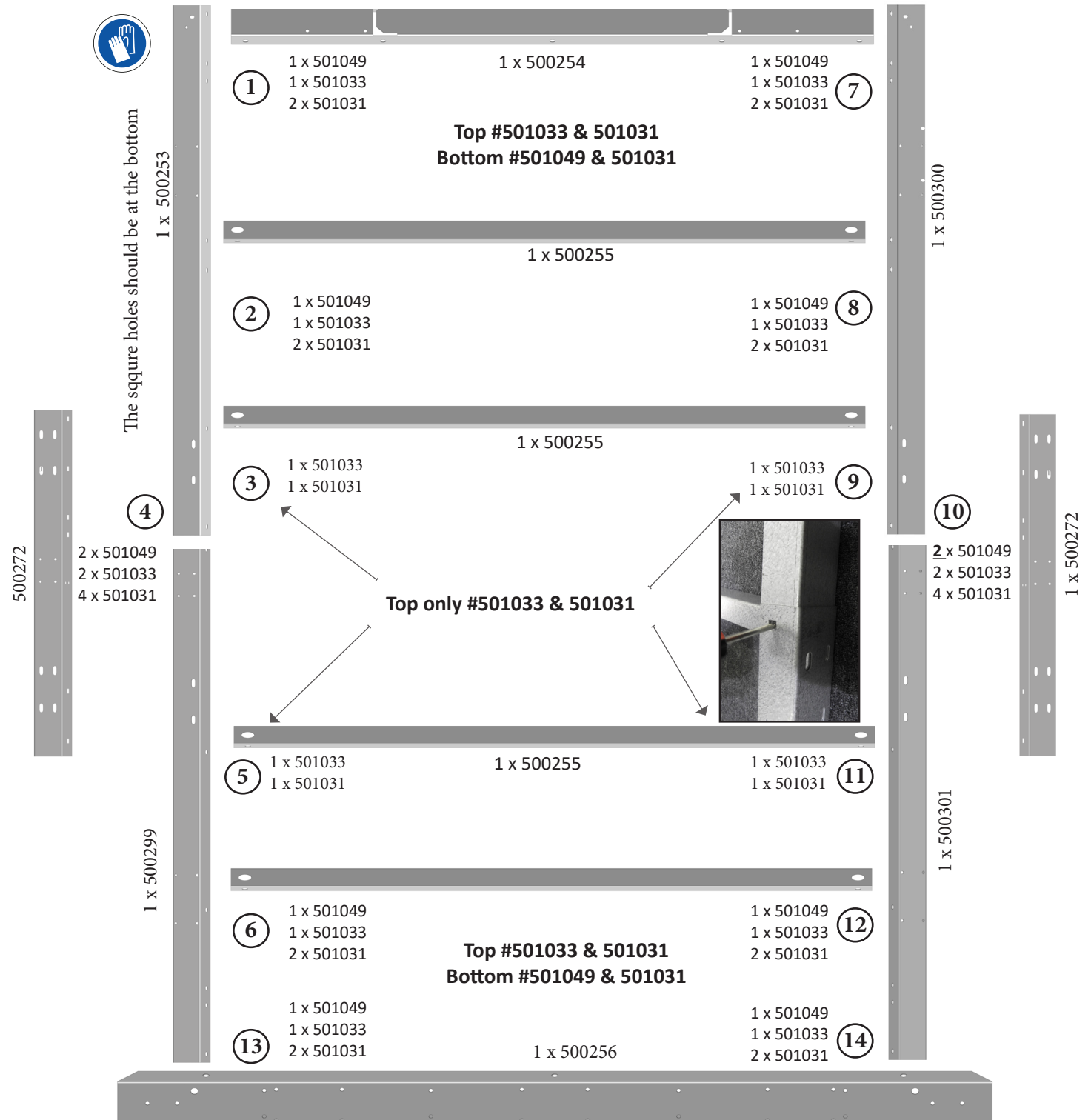
## 4'x 8' Kit Trailer Frame - Figure 2C

(If your trailer kit includes stake pockets, please refer to page 18 prior to assembly)

Loosely secure the frame in the numbered sequence below. **AT THIS POINT DO NOT TIGHTEN**

Secure the top of the channel using item #501033 & 501031 and the bottom using item #501049 & 501031

- Front channel has two vertical slots
- Side channel square holes facing down.
- Back channel 3 holes facing up
- Cross-channels opening facing the rear

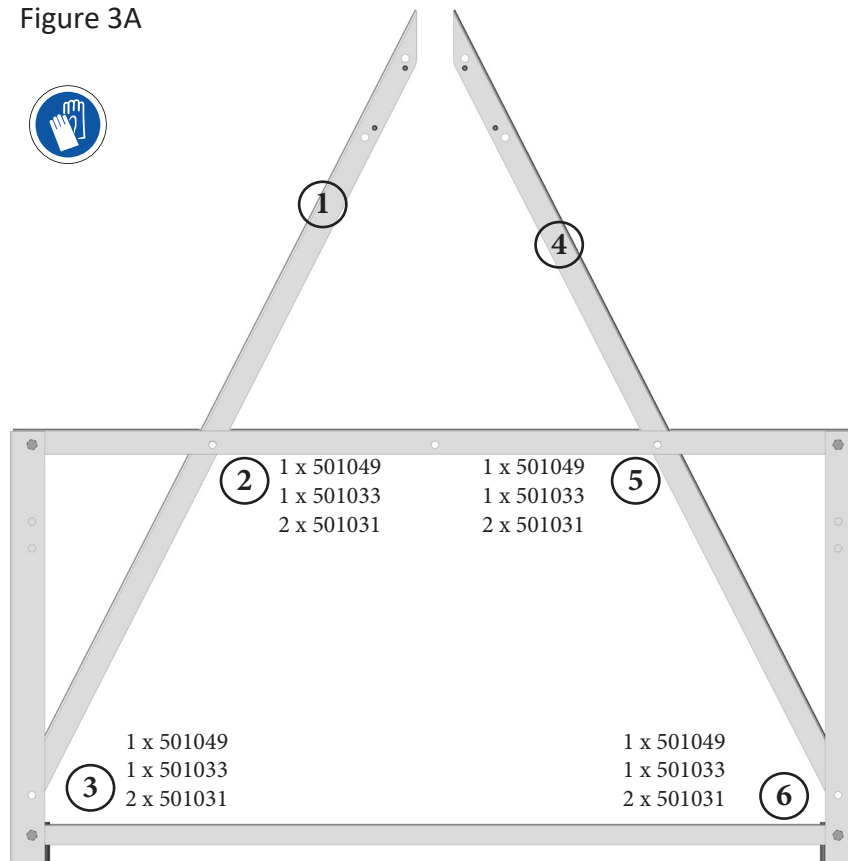


### Step 3 - Tongue Assembly

- Gather the components below and layout as illustrated in figure 3A
- Slide each tongue channel (Item#500527) into the front frame channel
- Loosely secure the top tongue channel using the hex bolt & nut, and the bottom using the hex flange bolt and nut\*\*\* **AT THIS POINT DO NOT TIGHTEN\*\*\***
- Affix the VIN label on the tongue front driver's side and cover the VIN label with UV protected overlay provided.

| ITEM # | DESCRIPTION                            | 4' x 4' | 4' x 6' | 4' x 8' |
|--------|--|---------|---------|---------|
| 500257 | TONGUE CHANNEL                         | 2       | 2       | 2       |
| 504162 | 5' - TONGUE CONNECTION BRACKET         | 1       | 1       | 1       |
| 501049 | 3/8-16 X 3/4" HEX FLANGE BOLT          | 8       | 8       | 8       |
| 501033 | 3/8-16 X 1 1/2" HEX BOLT (FULL THREAD) | 4       | 4       | 4       |
| 501031 | 3/8-16 NYLON INSERT HEX FLANGE LOCKNUT | 4       | 4       | 4       |
| 501100 | 5/16-18 UNC X 1/2" CUTTING SCREW WITH  | 4       | 4       | 4       |
| 500512 | 4 WAY FLAT 20' WIRE HARNESS            | 1       | 1       | 1       |

Figure 3A



### **Step 3 - Tongue Assembly**

- Feed each wire of the wire harness between the tongue channel and the cut outs on each side of the connection bracket. (FIGURE A)
  - Feed the yellow and brown on the driver's side
  - Feed the green and brown wire on the passenger's side
  - Do not pull the white wire through, you will secured it to the coupler channel once it's assembled.
- Slide the connection bracket into the tongue channel and secure the top of the channel using the hex flange bolt.
- At this point, you need to tighten the top of the frame.



**CAUTION! FLIPPING THE TRAILER OVER REQUIRES TWO PEOPLE**

- Using two people, flip the frame
- Tighten all the bottom bolts.
- Secure the bottom of the connection bracket with the cutting screws.



Figure 3A

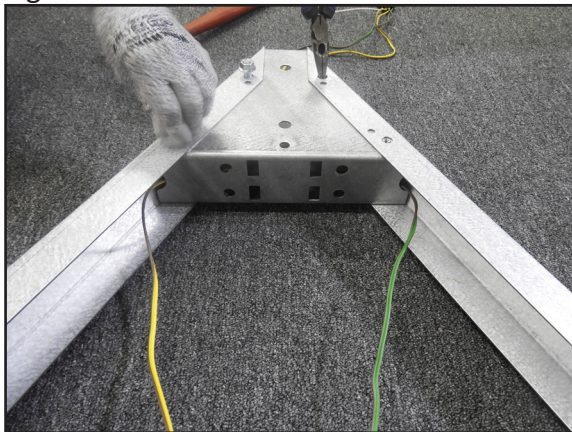
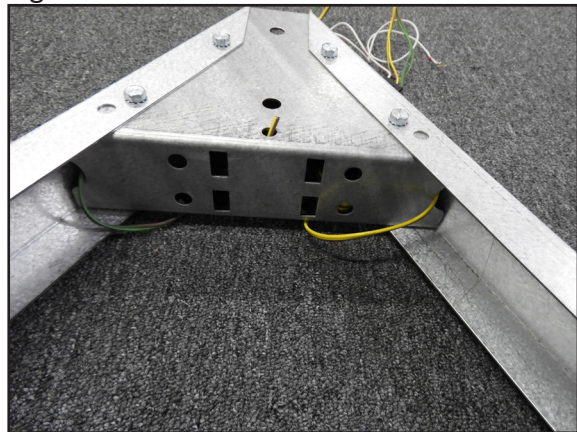


Figure 3B



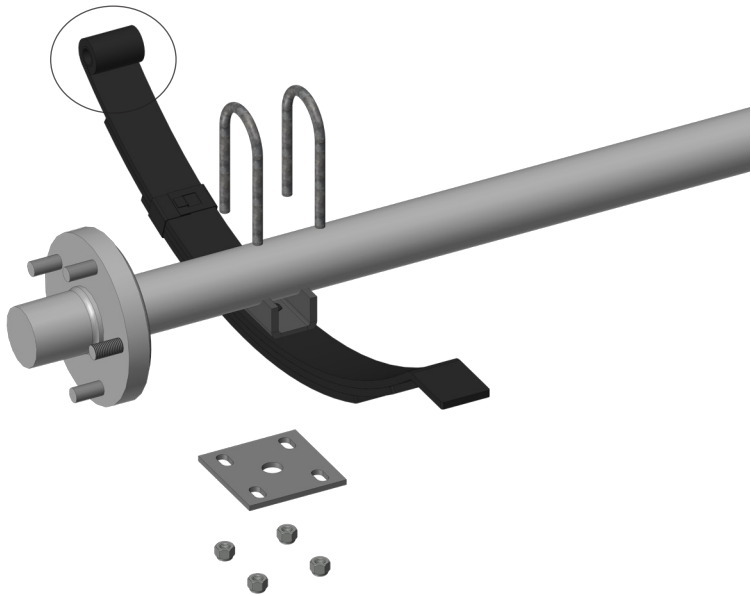
**Step 4 – Axle Assembly**

- Place the slipper spring (500809) on each end of the axle (500047) making sure it is nested in the hole of the axle bracket.
- Put the U-bolts (500814) through the mounting plate and secure using item #501031 for both springs. The axle support plate (500259) has slotted holes and should run the length of the leaf spring.

| ITEM # | DESCRIPTION                            | 4' x 4' | 4' x 6' | 4' x 8' |
|--------|--|---------|---------|---------|
| 500047 | 4' STRAIGHT AXLE                       | 1       | 1       | 1       |
| 500809 | 750 LB. SLIPPER SPRING                 | 2       | 2       | 2       |
| 500814 | 3/8-16 U-BOLT                          | 4       | 4       | 4       |
| 500259 | LEAF SPRING MOUNTING BRACKET           | 4       | 4       | 4       |
| 500260 | LEAF SPRING AXLE MOUNT PLATE           | 2       | 2       | 2       |
| 501031 | 3/8-16 NYLON INSERT HEX FLANGE LOCKNUT | 16      | 16      | 16      |
| 501036 | 3/8-16 X 3/4" CARRIAGE BOLT            | 8       | 8       | 8       |
| 501032 | 3/8" FLAT WASHER                       | 8       | 4       | 4       |
| 501065 | 9/16-18 UNF X 3" HEX BOLT              | 4       | 4       | 4       |
| 501066 | 9/16-18 UNF NYLON INSERT LOCKING NUT   | 4       | 4       | 4       |

Figure 4A

Eye



## **Step 5 – Mount the Axle**

- Place the leaf spring mounting bracket on the square holes of the outer channels. Ensure the bracket holes are facing towards each other. (Figure 5A) and tightly secure using item #501036 & 501031. If there is no cross channel at the fastening location use item#501032 washer to allow correct tightening. Repeat on other side.
- Place the axle into the mounting brackets on the frame of the trailer. It is important that the eye of the slipper spring is facing the front of the trailer and the slipper is facing the rear. (Figure 5B)
- Use the item#501065 & 501066 to secure to the spring to the brackets. Do not over-tighten as there needs to be movement in the spring.
- Using two people, flip the frame

**CAUTION! FLIPPING THE TRAILER OVER REQUIRES TWO PEOPLE**

Figure 5A

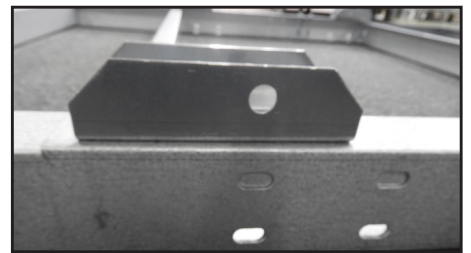
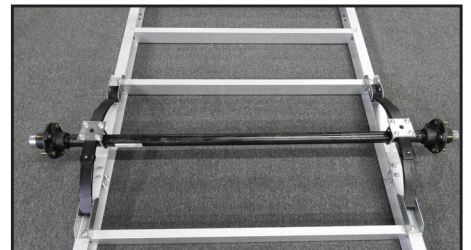
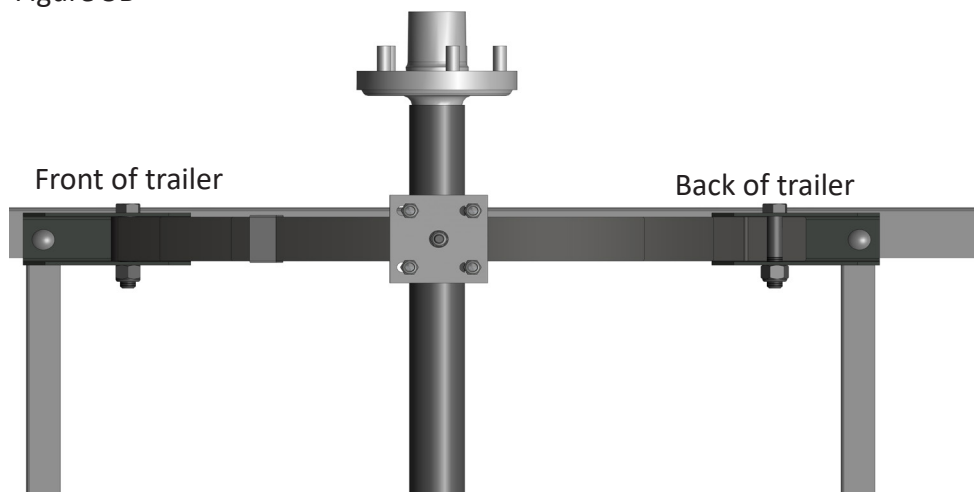


Figure 5B



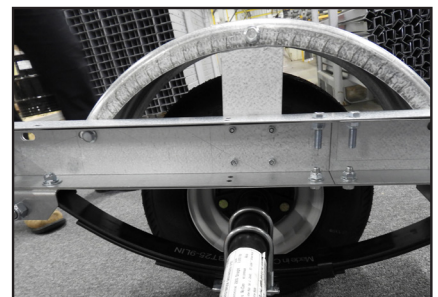
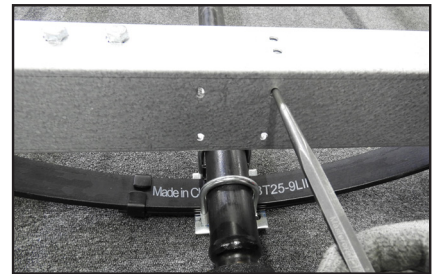
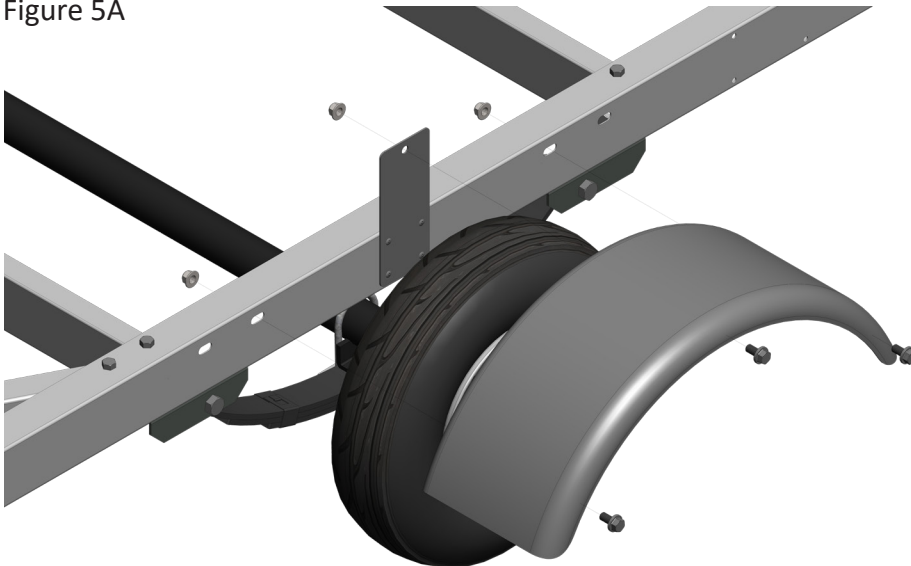


### Step 6— Fender & Wheels

- Align the fender support plate with the frame and secure with machine screw and nut. If the holes are not perfectly aligned use a punch to align them.
- Align the tire with the studs on the hub and secure to rim using item #501001
- Align the fender to the frame and fender support plate. Ensure the fender support plate is secured to the inside of the fender and secure both using item # 501049 & 501031
- Repeat for other side.

| ITEM #                     | DESCRIPTION                            | 4' x 4' | 4' x 6' | 4' x 8' |
|----------------------------|--|---------|---------|---------|
| 501091                     | 10-24 X 1/2" PHILLIPS #2 MACHINE SCREW | 8       | 8       | 8       |
| 501092                     | 10-24 NYLON INSERT LOCKING NUT         | 8       | 8       | 8       |
| 501049                     | 3/8-16 X 3/4" HEX FLANGE BOLT          | 6       | 6       | 6       |
| 501031                     | 3/8-16 NYLON INSERT LOCKING NUT        | 6       | 6       | 6       |
| 501001                     | 1/2" WHEEL NUTS                        | 10      | 10      | 10      |
| If equipped with 8" tires  |  |         |         |         |
| 500258                     | 8" FENDER                              | 2       | 2       | 2       |
| 500841                     | 4.80 X 8 LRC TIRE & WHEEL              | 2       | 2       | 2       |
| 504447                     | FENDER PLATE - 8"                      | 2       | 2       | 2       |
| If equipped with 12" tires |  |         |         |         |
| 504212                     | 12" FENDER                             | N/A     | 2       | 2       |
| 500844                     | 4.80 x 12 LRC TIRE & WHEEL             | N/A     | 2       | 2       |
| 504476                     | FENDER PLATE - 12"                     | N/A     | 2       | 2       |

Figure 5A



**Step 7 – Hitch and safety chains**

- Insert the tongue support foot into the coupler channel (Figure 6A)
- Loosely secure the chains using the item #501023 & 501031
- Secure the coupler to the channel using item #501021 & 501031making sure it’s tight enough that the tongue foot doesn’t move but the coupler spring releases
- Insert channel into the frame and secure with 501056 hex bolt and nut (Figure 6B)
- Remove the nut from the chain bolt and place the ground white wire on the bolt and refasten

| ITEM # | DESCRIPTION                          | 4’ x 4’ | 4’ x 6’ | 4’ x 8’ |
|--------|--------------------------------------|---------|---------|---------|
| 504163 | LONG COUPLER CHANNEL                 | 1       | 1       | 1       |
| 504198 | TONGUE SUPPORT FOOT - CHANNEL TONGUE | 1       | 1       | 1       |
| 500805 | 1 7/8” COUPLER CLASS I               | 1       | 1       | 1       |
| 500804 | SAFETY CHAIN - 3/16 X 4’ (CLASS I)   | 1       | 1       | 1       |
| 501031 | 3/8-16 NYLON INSERT LOCKING NUT      | 3       | 3       | 3       |
| 501023 | 3/8-16 X 2-1/2” HEX BOLT             | 1       | 1       | 1       |
| 501024 | 3/8-16 X 3” HEX BOLT                 | 2       | 2       | 2       |
| 501060 | 1/2-13 X 3 1/2” HEX BOLT             | 2       | 2       | 2       |
| 501056 | 1/2-13 NYLON INSERT LOCKING NUT      | 2       | 2       | 2       |

Figure 6A

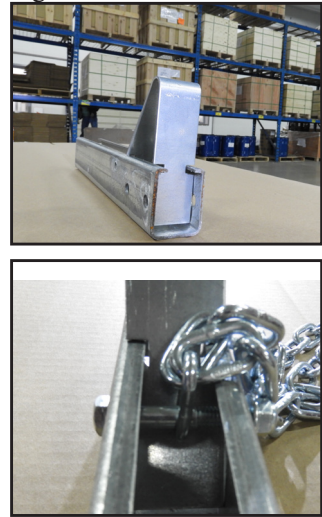
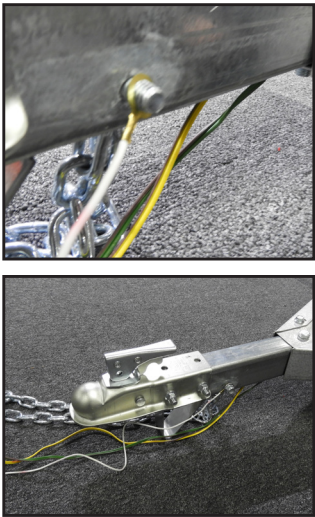
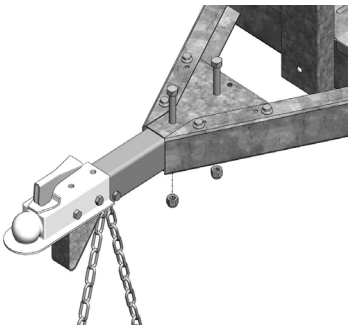
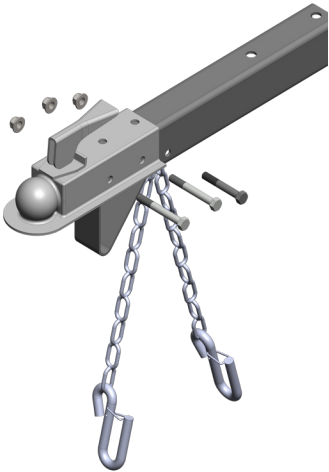


Figure 6B

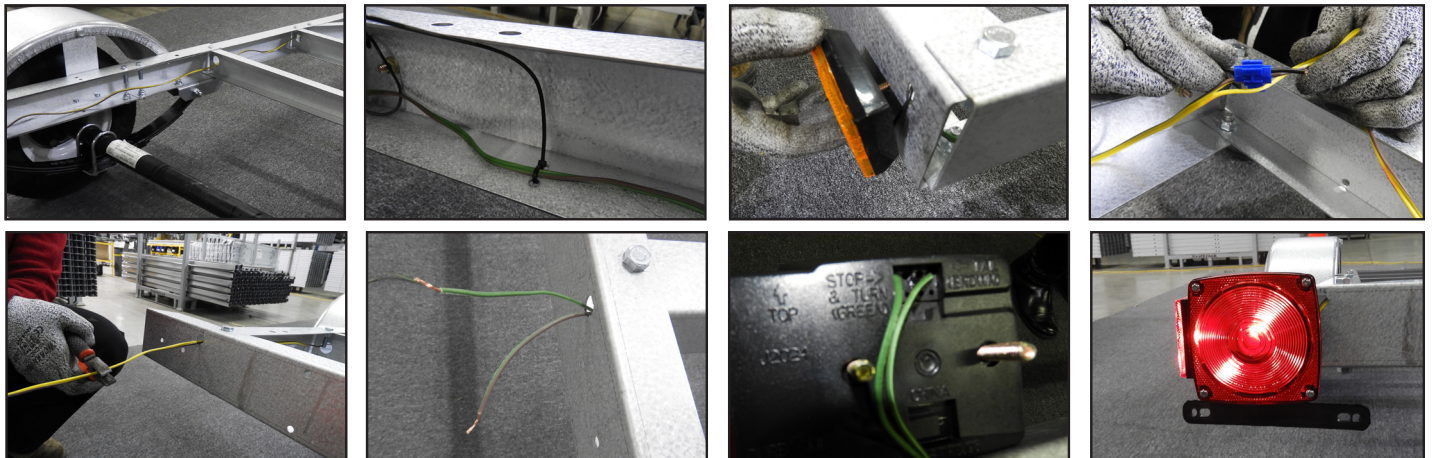




## STEP 8 – Wiring & Lights

- Feed the wire harness using the pre-cut holes all the way to the back.
- Secure the wire to the frame with the zip ties using the holes provided in the frame.
- Secure each marker light on the front side of frame.
- To make the electrical connection for the marker lights you will need to push the brown wire from the wire harness completely to the back of the wire connector. Once the brown wire is in place, slide in the marker light wire into the connector making sure no wire is coming out of the other side as this could cause a short.
- Squeeze the blade of the connector down with pliers. Make sure you squeeze tight enough to make a connection between both wires. Verify that the blade is all the way in place and close the cover.
- At the back of the trailer cut the wire leaving 6" then strip 1/4" section of each wire at the end of the wire harness and twist the cooper wire. Do this for both sides.
- Plug each wire to the corresponding hole in the back of each taillight, and secure the light to the frame.
- Secure the license plate holder on the driver side with taillight.

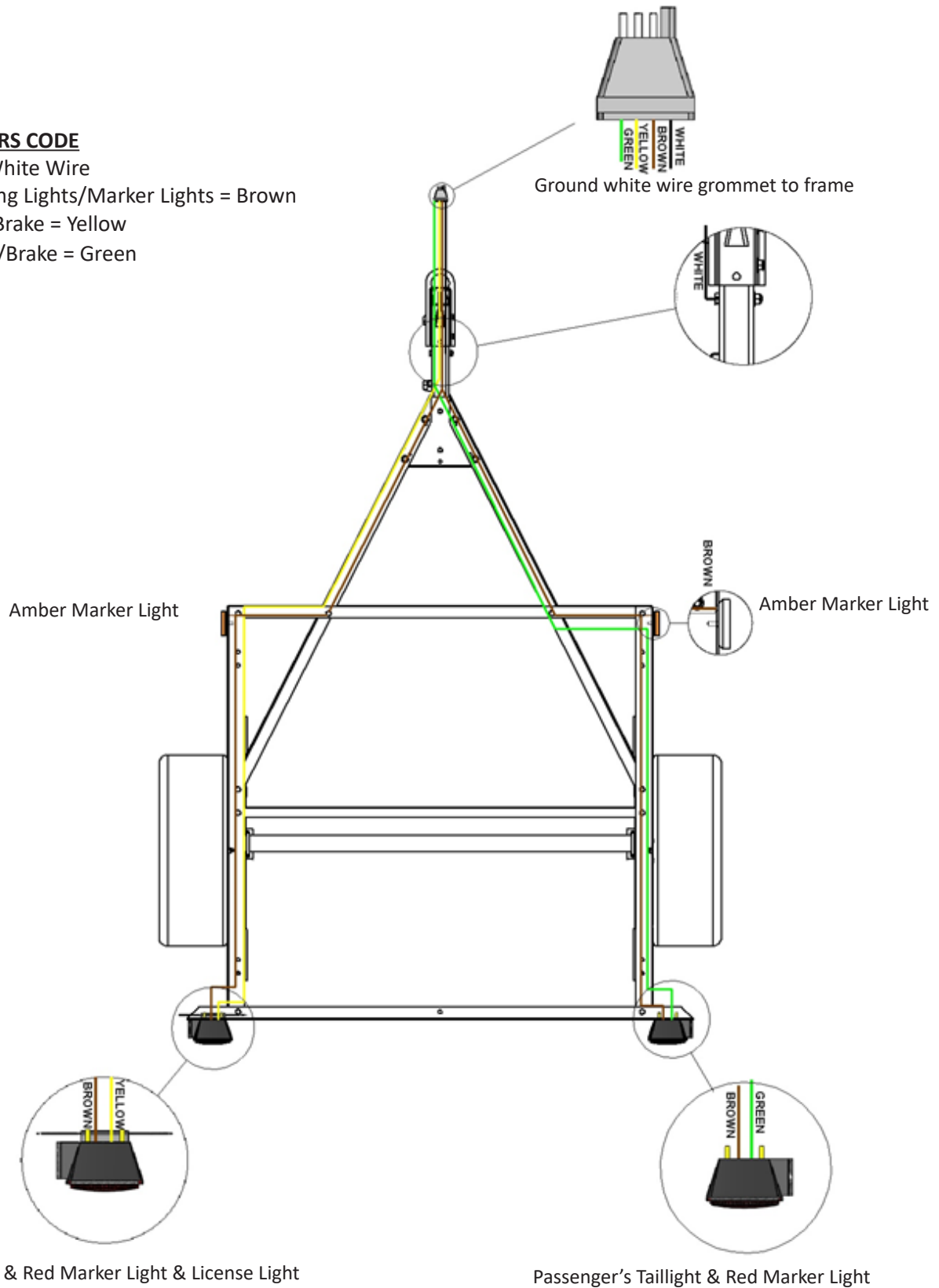
| ITEM # | DESCRIPTION                   | 4' x 4' | 4' x 6' | 4' x 8' |
|--------|-------------------------------|---------|---------|---------|
| 500512 | 4 WAY FLAT 20' WIRE HARNESS   | 1       | 1       | 1       |
| 503079 | 8" CABLE TIE                  | 4       | 6       | 4       |
| 500558 | WIRE CONNECTOR                | 2       | 2       | 2       |
| 500513 | TAILLIGHT LEFT/DRIVER SIDE    | 1       | 1       | 1       |
| 500514 | TAILLIGHT LEFT/PASSENGER SIDE | 1       | 1       | 1       |
| 500515 | AMBER MARKER LIGHT            | 2       | 2       | 2       |
| 500516 | PLASTIC LICENSE BRACKET       | 1       | 1       | 1       |



## Wiring Diagram

### WIRING COLORS CODE

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



Driver's Taillight & Red Marker Light & License Light

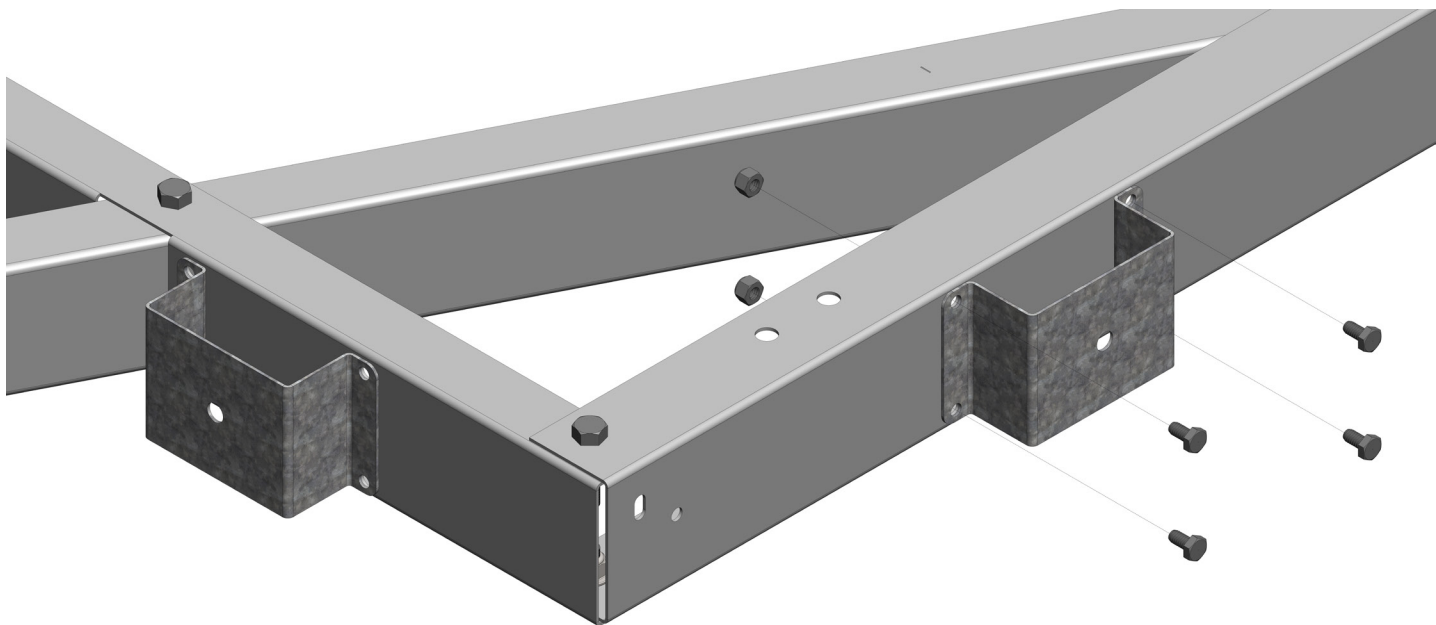
Passenger's Taillight & Red Marker Light

## STEP 9 – Stake Pocket Installation

- Line the stake pocket to the pre-drilled holes of the frame. There are eight locations.
- Use the 1/4" bolts and nuts to secure to the frame.
- This should be installed on the channel prior to assembling the frame.

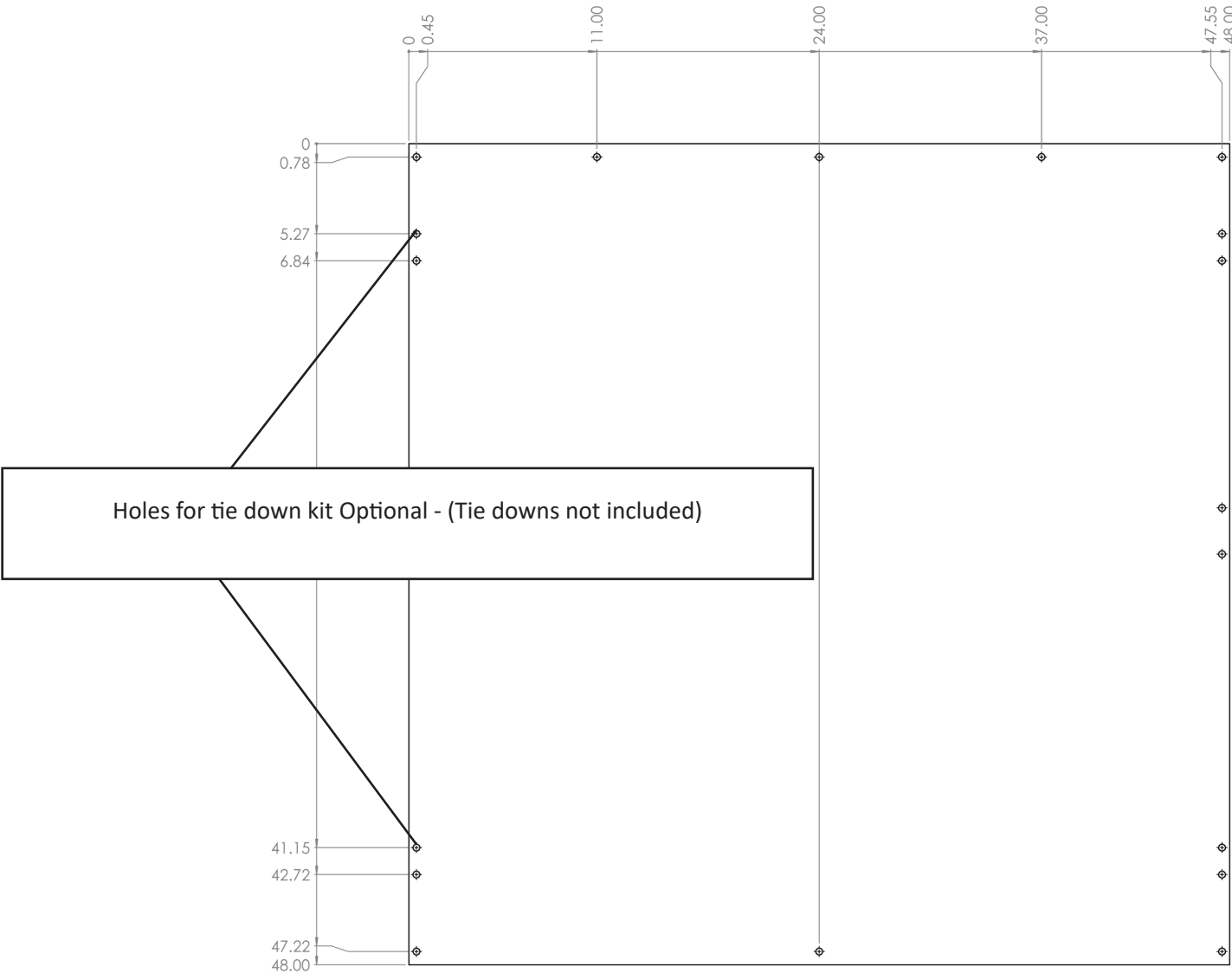
If your kit doesn't include the stake pocket, you can purchase them at [www.westbrooktrailerparts.com](http://www.westbrooktrailerparts.com)

| ITEM # | DESCRIPTION                     | 4' x 4' | 4' x 6' | 4' x 8' |
|--------|---------------------------------|---------|---------|---------|
| 504471 | STAKE POCKET                    | 8       | 8       | 8       |
| 501073 | 1/4-20 X 3/4" HEX BOLT          | 32      | 32      | 32      |
| 501081 | 1/4-20 NYLON INSERT LOCKING NUT | 32      | 32      | 32      |



**4ft x 4ft Plywood Drill Template**  
(Plywood not included)

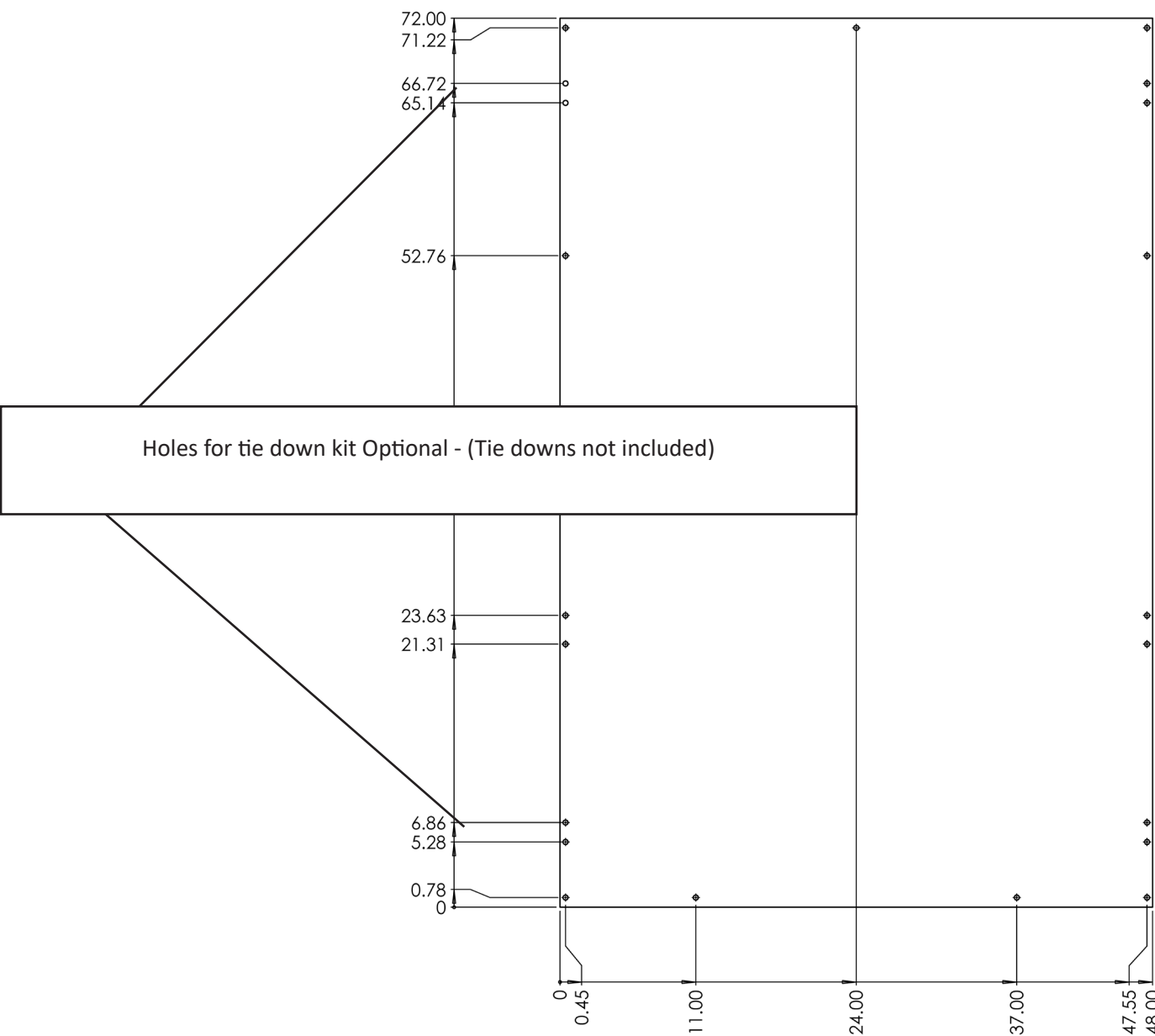
Drill 3/8” holes in plywood using the dimensions outlined below and use the 3/8” x 1-1/2” full thread hex bolts to secure to the frame.



**4ft x 6ft Plywood Drill Template**

(Plywood not included)

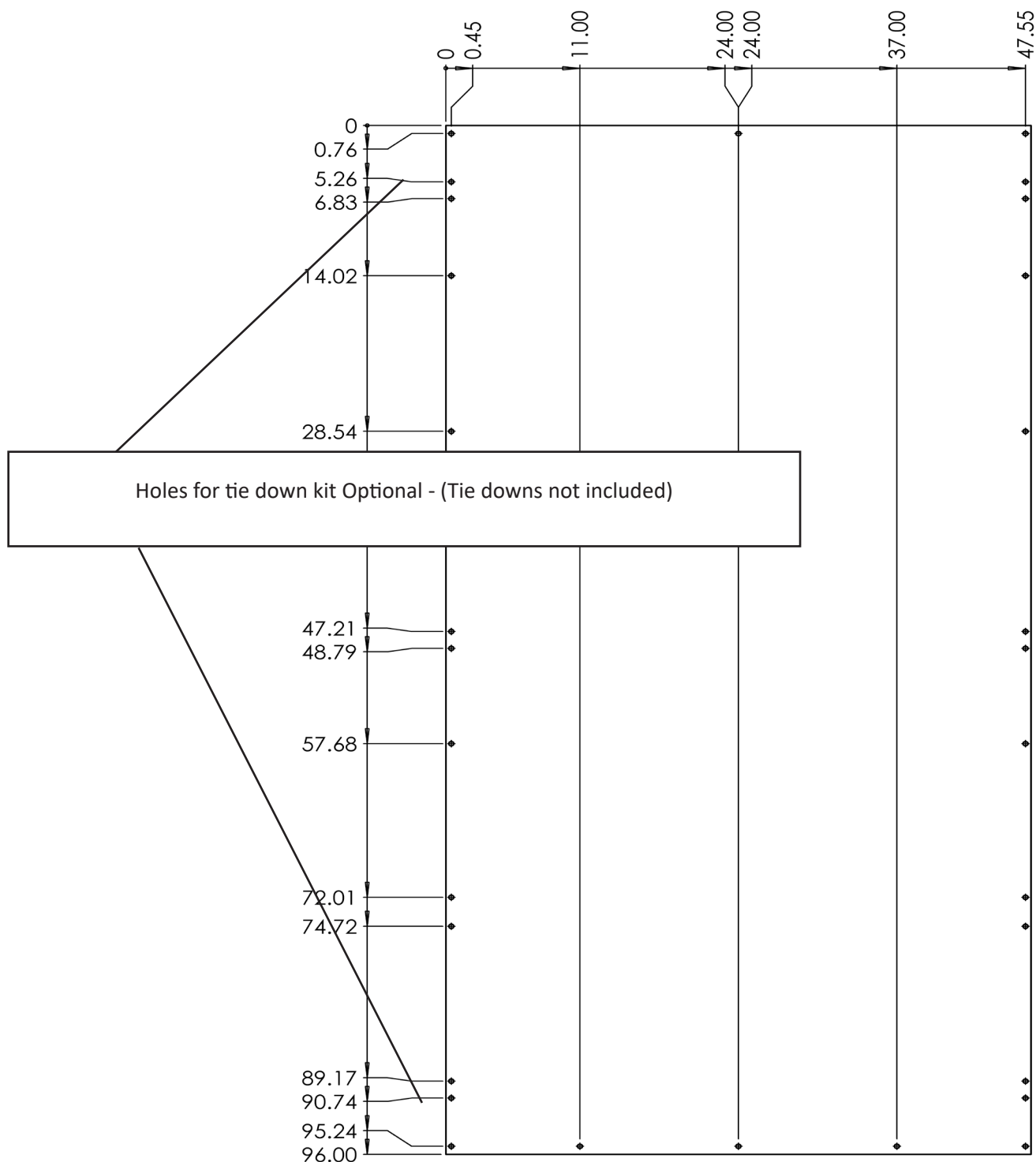
Drill 3/8" holes in plywood using the dimensions outlined below and use the 3/8" x 1-1/2" full thread hex bolts to secure to the frame.



### 4ft x 8ft Plywood Drill Template

(Plywood not included )

Drill 3/8" holes in plywood using the dimensions outlined below and use the 3/8" x 1-1/2" full thread hex bolts to secure to the frame.





### Cut List - Wood Plank (Wood not included)

4' x 4'

- a. 8pcs – 2x4 – 18" (12ft -2x4 makes 8pcs)
- b. 8pcs - 1x6 - 48"

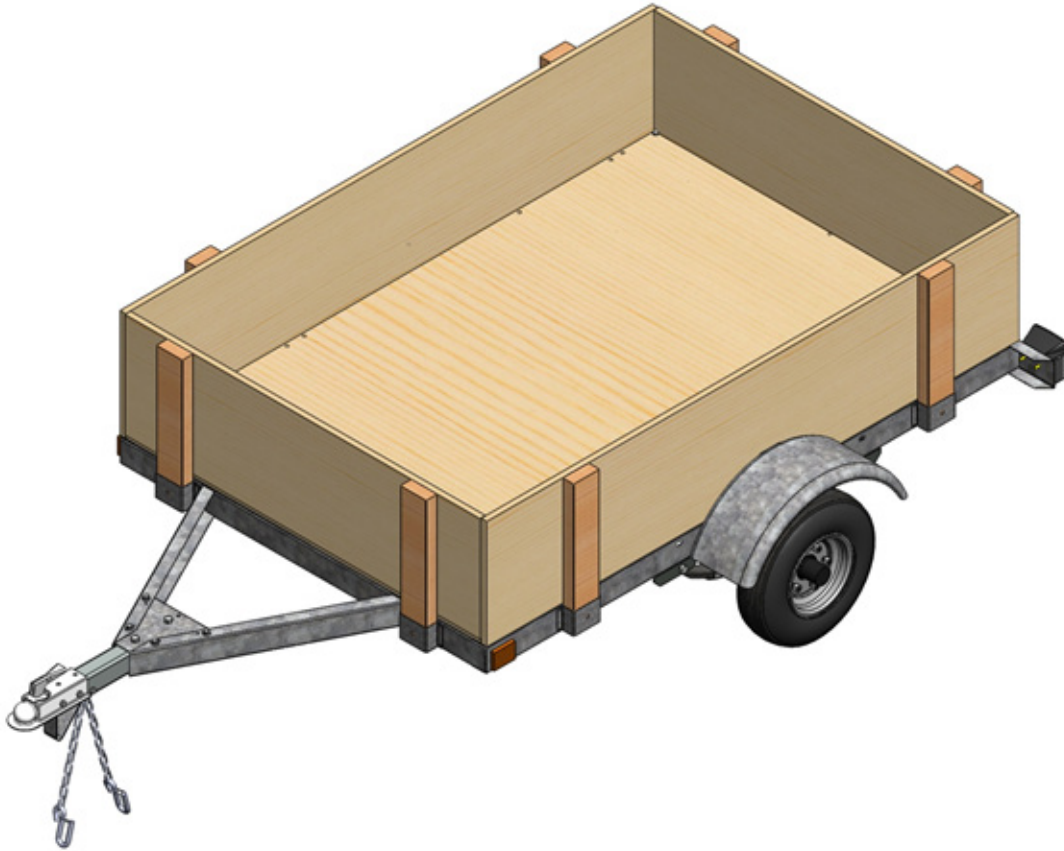
4' x 6'

- a. 8pcs – 2x4 – 18" (12ft -2x4 makes 8pcs)
- b. 4pcs – 1x6 – 72"
- c. 4pcs – 1x6 – 48"

4' x 8'

- a. 8pcs – 2x4 – 18" (12ft -2x4 makes 8pcs)
- b. 4pcs – 1x6 – 96"
- c. 4pcs – 1x6 – 48"





**Cut List - Plywood**  
(Wood not included)

4' x 4'

- a. 8pcs – 2x4 –18" (12ft -2x4 makes 8pcs)
- b. 4pcs – 3/4 x 14-3/4" x 48"

4' x 6'

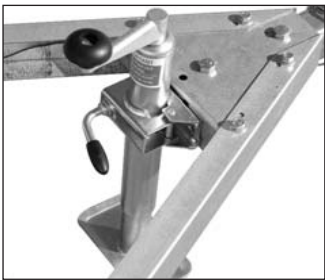
- a. 8pcs – 2x4 –18" (12ft -2x4 makes 8pcs)
- b. 2pcs – 3/4 x 14-3/4" x 72"
- c. 2pcs – 3/4 x 14-1/4" x 48"

4' x 8'

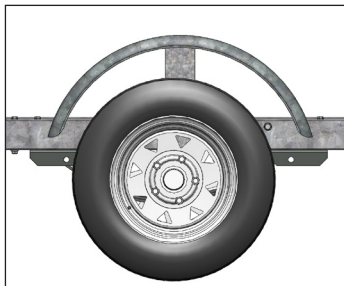
- a. 8pcs – 2x4 –18" (12ft -2x4 makes 8pcs)
- b. 2pcs – 3/4 x 14-3/4" x 96"
- c. 2pcs – 3/4 x 14-1/4" x 48"



## Trailer Accessories



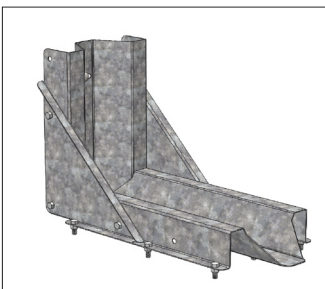
Tongue Jack



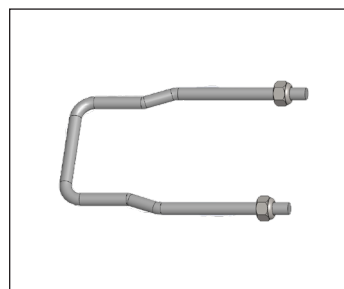
12" Wheel & Fender \*



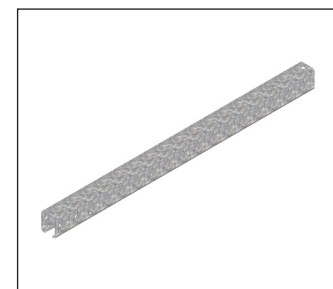
Ramps



Wheel Chock



Spare Tire U-Bolt Support



Tongue Extension