**BEFORE INSTALLING** - **OVERHEAD LIFTING DEVICE**

An overhead-lifting device, such as chain falls, engine hoist, or cable come-a-long, can be used to lift the center section of the hitch in place. Lower a loop of rope or chain through the 4" hole in the truck bed floor and attach to the latch pin in the round hitch receiver tube in the center location.

Use the lifting device to raise the center section until the round hitch receiver tube that protrudes from the center section fits in the 4" hole in the truck bed floor. Maintaining upward pressure may facilitate fastening the crossmember to the center section, especially if the truck bed floor has been distorted downward from heavy use. If you use an overhead-lifting device, it should be disconnected before squaring the center section across the frame, installing the sideplates and torquing fasteners.

**WARNING**

Most trucks have FUEL LINES and/or BRAKE LINES and/or ELECTRICAL WIRES located along the frame rails where B&W Turnoverball™ will be installed. Check for the location of fuel lines, brake lines, and wires before installation. Be certain you will not damage fuel lines, brake lines or electrical wires when positioning hitch components, drilling holes, tightening fasteners, and lifting and lowering the truck bed. The fuel tank vent, located on top of the gas tank, can be easily damaged during the installation of the hitch components. Care must be taken when positioning the front crossmember and center section components.

**WARNING**

On short bed trucks, BEFORE INSTALLING THIS HITCH, check for adequate turning clearance between the front of all of your trailers and the truck cab.

**NO** DO NOT invert the ball in the socket when carrying heavy loads on 2 wheel drive trucks. The ball may hit the top of the differential.

**INSTALLATION INSTRUCTIONS**

**BRAKE CABLE & FUEL LINE BRACKET**

On trucks equipped with a gasoline engine it may be necessary to relocate a fuel line from the driver’s side frame will have to be relocated. Knock the mounting stud out of the frame and discard. A relocating bolt is furnished in the kit and will be installed later.

On trucks equipped with a gasoline engine it may be necessary to relocate a fuel line from the driver’s side frame will have to be relocated. Knock the mounting stud out of the frame and discard. A relocating bolt is furnished in the kit and will be installed later.

On 2008 and newer trucks we recommend removing the brake line and pushing it through the side plate and the frame then add a ¾" flat washer, lock nut and a ½" lock washer and nut. Next install a pipe spacer between the side plate and the frame and place a ¼ bolt through the hole in the pipe spacer, lock washer and nut. Repeat the process for the passenger side.

**CROSS MEMBER INSTALLATION**

On trucks equipped with a gasoline engine it may be necessary to relocate a fuel line from the driver’s side frame will have to be relocated. Knock the mounting stud out of the frame and discard. A relocating bolt is furnished in the kit and will be installed later.

On 2008 and newer trucks we recommend removing the brake line and pushing it through the side plate and the frame then add a ¾" flat washer, lock nut and a ½" lock washer and nut. Next install a pipe spacer between the side plate and the frame and place a ¼ bolt through the hole in the pipe spacer, lock washer and nut. Repeat the process for the passenger side.

**SAFETY NOTICE*****

On 2008 and newer trucks we recommend removing the spare tire heat shield to avoid injury.

**MARKING AND CUTTING 4 INCH HOLE IN TRUCK BED**

This will be reattached later.

**ON 2005 and newer trucks equipped with a diesel engine the tail pipe will need to be lowered. First remove the tail pipe bracket just behind the rear tire on the passenger side. This will be reattached later.

**STEPS 1-10**

1. **MARKING AND CUTTING 4 INCH HOLE IN TRUCK BED**

   Remove the heat shield located above the rear axle under the truck bed.

   **NOTE** In the bed flange in step 5. Make certain the angle of the oval holes is facing toward the cab. After sliding the angle in about half way it may need to be pushed further to ensure the inner hole in the relocated bracket.

2. **HEAT SHIELD REMOVAL**

   Remove the heat shield located above the rear axle under the truck bed.

3. **BRAKE CABLE & FUEL LINE BRACKET**

   On 2008 and newer trucks we recommend removing the brake line and pushing it through the side plate and the frame then add a ¾" flat washer, lock nut and a ½" lock washer and nut. Next install a pipe spacer between the side plate and the frame and place a ¼ bolt through the hole in the pipe spacer, lock washer and nut. Repeat the process for the passenger side.

4. **CROSS MEMBER INSTALLATION**

   On 2008 and newer trucks we recommend removing the brake line and pushing it through the side plate and the frame then add a ¾" flat washer, lock nut and a ½" lock washer and nut. Next install a pipe spacer between the side plate and the frame and place a ¼ bolt through the hole in the pipe spacer, lock washer and nut. Repeat the process for the passenger side.

5. **BED FLANGE MODIFICATION**

   Some models of trucks will allow the crossmembers to slide between the frame and bed without modification. If this is not possible a small notch needs to be made in the flange on the driver’s side of the truck. **(See diagram)** Locate the front truck bed cross member in the wheel well. Measure from the back of the cross member and make a mark at 1 ½" this measurement is important. This will be the center point for the notch that is needed. Mark and cut a 7/8" wide by 3/8" tall notch.

6. **CROSS MEMBER INSTALLATION**

   The 1108 mounting kit is supplied with two angle crossmembers. The rear crossmember has three notches and will be installed first. Slide the rear crossmember upward against the bed floor and forward against the bed crossmember. Continue to slide it back until it is about four inches behind the four inch hole that has been drilled in the bed. Next install the front angle in the same manner except for the leg of the angle with the oval holes should face the rear of the truck during installation. Slide it rearward just behind the shock bracket and leave until needed for installation. When installed correctly the two angle legs with the holes should be facing each other.

7. **INSTALL CLAMPING STRAP & SIDE PLATES**

   If the emergency brake cable has been removed from the frame, place a 5/16" carriage bolt (excluded) through the small square hole in the driver side strap plate and place a 5/16" nut loosely to hold in place. This will be the location for the emergency brake cable bracket. Next you will need to install the clamping strap and angle plate on the driver side of the truck. Take a side plate and orient the ¾" hole in the angle plate so that it is facing toward the cab. After sliding the angle in about half way it may need to be pushed further to ensure the inner hole in the relocated bracket.

8. **INSTALL THE CENTER SECTION**

   The center section is positioned between the cross members from beneath the truck, with the latch pin release handle on the driver side. A lifting device, as described on page 1 will help. The round hitch receiver that protrudes from the top of the center section must fit through the hole in the truck bed floor. Slide the angle crossmember (an adjustable wrench can be used to provide upward pressure if needed) and bolt together using six ½" x 1 ½" bolts. Place the bolts with a flat washer through the slots in the crossmember and through the holes in the center section and add a ¾" lock washer and nut. Next install the side plates to the angle cross members using a ½" x 1 ½" bolt through the side plate, through the angle and add a ⅛ flat washer, lock washer and nut.

9. **TIGHTEN HARDWARE**

   With all the center section to cross member bolts to 80 ft pounds. 2. Check to ensure the assembled center section is square with the frame. 3. Tighten the ⅛" side plate bolts to 120 ft pounds. 4. Tighten the bottom clamping strap bolts to side plate to 80 ft pounds. 5. Tighten the clamping strap studs to 60 ft pounds. 6. Tighten the side plate to angle bolts 80 ft pounds. If the emergency brake cable has been removed, take the 5/16" nut off the previously installed bolt. Place the emergency brake cable bracket over the bolt, replace the nut and tighten.

10. **INSTALL LATCH PIN RELEASE HANDLE**

    WARNING - IF PIN WILL NOT FUNCTION CORRECTLY IT IS NOT INSTALLED CORRECTLY.

    Install the handle underneath the truck by inserting it through the slot in the end of the center section toward the driver’s side rear tire as shown. Attach the handle to the latch pin as shown with the handle on the “cab side” of the square tab welded to the pin. This will be the center point for the notch that is needed. Mark and cut a 7/8" wide by 3/8" tall notch.

**END VIEW OF FRAME CHANNEL FROM DRIVERS SIDE**
**Parts List**

1. Front Crossmember  
2. Rear Crossmember  
3. Center Section  
4. Driver’s Side Sideplate  
5. Passenger’s Side Sideplate  
6. Safety Chain U-Bolts  
7. Latch Pin Handle  
8. - 2-5/16" Ball  
9. - Clamp Strap  
10. - Springs  
11. - 1/2" Lock nuts

**Model 1108R**

Ford Super Duty (1999 -2010)  
3/4 & 1 Ton, Short & Long Bed  
F-450 w/Factory Installed Bed

**STEP 11 – INSTALL SAFETY CHAIN U-BOLTS**

To install the safety chain U-bolts it is necessary to drill four ½" holes through the truck bed floor. Drill the holes from beneath the truck, through the two holes located on each side and closest to the round receiver tube in the center section. This will locate the safety chain U-bolt in the lowest point of the floor corrugation. After you drill the four holes clean the burrs from around the holes in the top of the bed then drop a U-bolt through each pair of holes. Place a spring and lock nut on each of the four legs. Tighten the nuts until flush with the bottom of the U-bolts.

**STEP 12 – RE-ATTACH EXHAUST**

On 2005 to present pickups equipped with a diesel engine, the exhaust will have to be lowered to allow clearance for the Turnoverball™ Hitch.

**2005 to 2007 Model Trucks**

On 2005 through 2007 Ford Super Duty Trucks with a diesel engine, the exhaust will have to be lowered at the rear exhaust bracket to allow clearance for the Turnoverball™ Gooseneck Hitch. See Diagrams 12A, 12B and 12C.

**2008 to Present**

On 2008 and newer Ford Super Duty Trucks with a diesel engine, the exhaust will have to be lowered at the rear exhaust bracket and can be lowered at the front exhaust bracket if needed to ease installation, allow adequate clearance for the exhaust and improve ground clearance at the end of the tail pipe. See Diagrams 12D, 12E, 12F.

**STEP 13 – RE-ENGAGE LATCH PIN HANDLE**

Retrace the latch pin by pulling the handle all the way out until it stops and then rotate it clockwise. Place the 2-5/16" Ball in the hitch receiver. Engage the latch pin by rotating the handle counterclockwise. Be certain the latch pin passes through the holes in the 2-5/16" Ball and fully engages through the hitch receiver. Remove and grease the square base of the 2-5/16" Ball.

**STEP 14 – Reinstall the spare tire heat shield and spare tire.**

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