



Ford F150
5 1/2', 6 1/2' & 8' Boxes

1/16
HJ32004, Rev 2

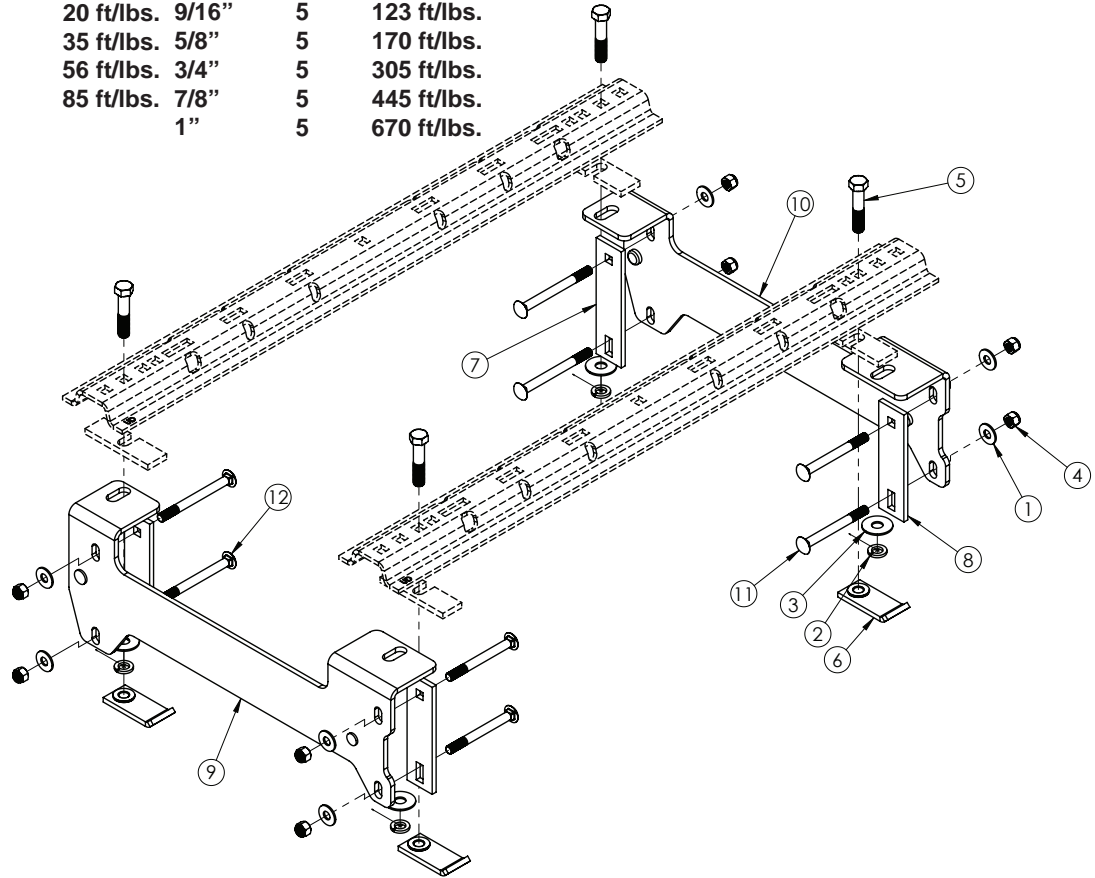


BOLT TORQUE SPECIFICATIONS

STANDARD BOLTS:

Size	Grade	Torque	Size	Grade	Torque
5/16"	5	20 ft/lbs.	9/16"	5	123 ft/lbs.
3/8"	5	35 ft/lbs.	5/8"	5	170 ft/lbs.
7/16"	5	56 ft/lbs.	3/4"	5	305 ft/lbs.
1/2"	5	85 ft/lbs.	7/8"	5	445 ft/lbs.
			1"	5	670 ft/lbs.

FRAME BRACKET



8552004 PARTS LIST

REF. NO.	PART NO.	QTY.	DESCRIPTION
1.	00085	8	1/2" Flat Washer
2.	00248	4	5/8" Lock Washer
3.	00477	4	5/8" Flat Washer
4.	02178	8	1/2" Nylon Lock Nut
5.	04215	4	5/8" x 3" Hex Bolt Gr.5
6.	14251-95	4	Plated Nut Bar
7.	14284-76	2	Front Carriage Bolt Plate
8.	14285-76	2	Rear Carriage Bolt Plate
9.	14372-76	1	Frame Bracket Driver Side
10.	14373-76	1	Frame Bracket Passenger Side
11.	14376	4	1/2" x 5" Carriage Bolt
12.	14381	4	1/2" x 5 1/2" Carriage Bolt Gr.5

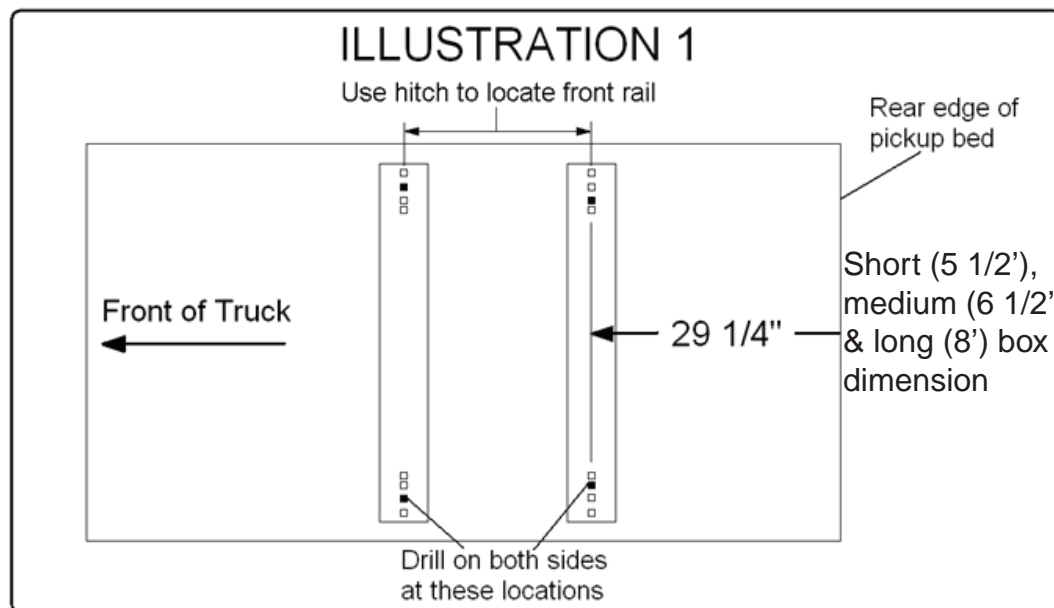
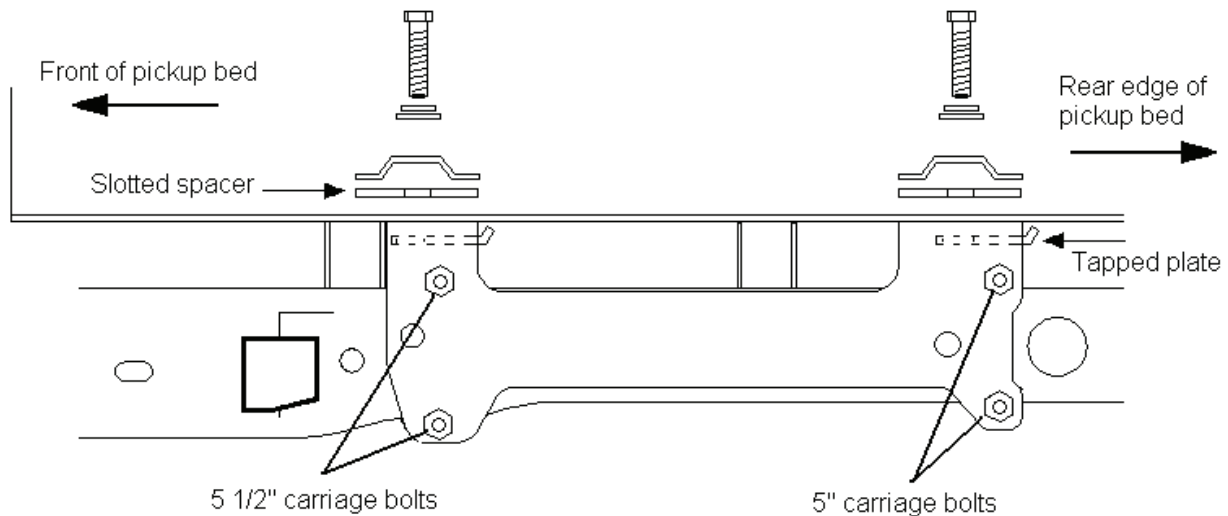
Please order replacement parts by **PART NO.** and **DESCRIPTION.**

ASSEMBLY
OPERATION
REPLACEMENT PARTS

READ complete manual CAREFULLY
BEFORE attempting operation.

Doing Our Best to Provide You the Best

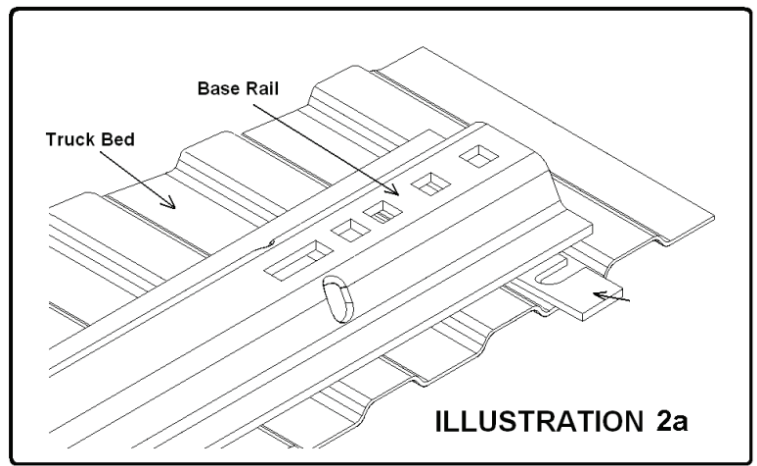
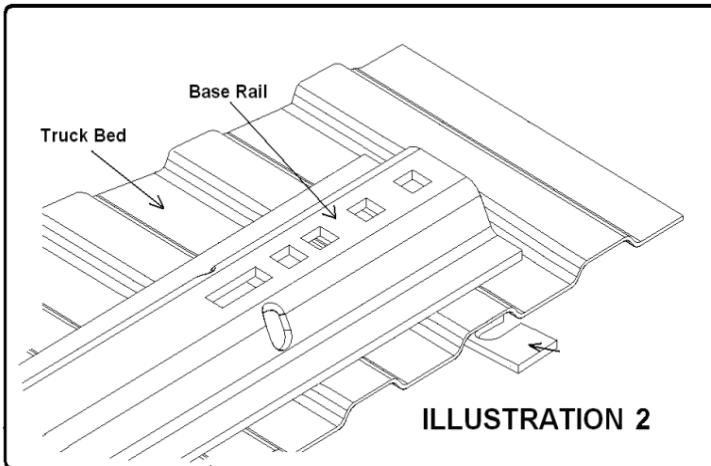
Directly over axle on 5 1/2', 6 1/2' & 8' applications



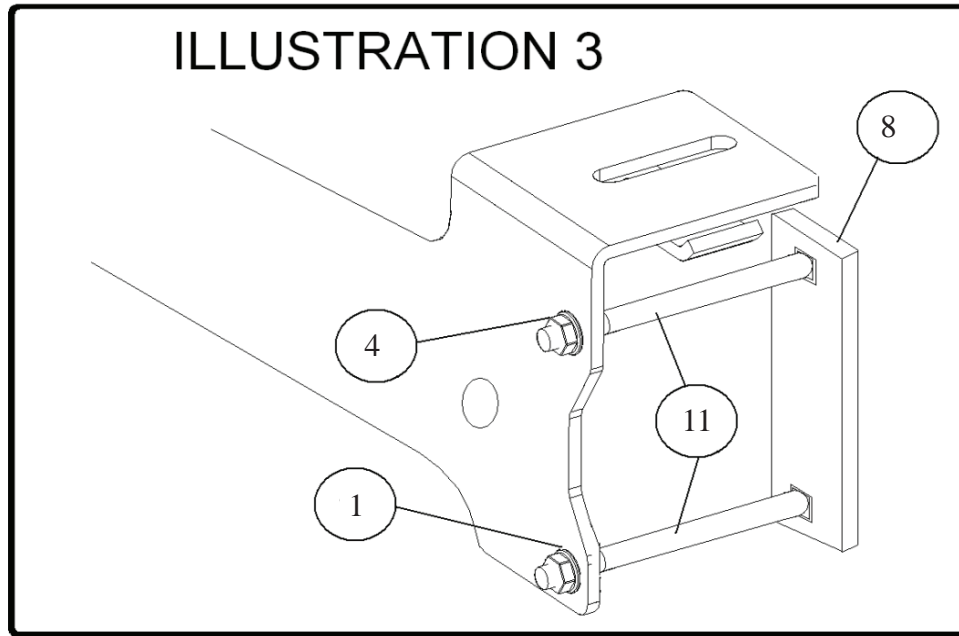
CAUTION: Do not install base rails over plastic bed liners. Plastic bed liners must be cut out of the way. Rails may be installed on spray in liners.

NOTE: Consult spray liner installer for recommended curing time.

1. Fully assemble the 5th wheel hitch on a flat, level surface and pin into the base rails (assembly instructions come with hitch components). Place assembled hitch in truck bed between the wheel wells..
2. Position the base rails in truck bed as shown in Illustration 1 (previous page). When hitch is correctly positioned in the bed and the base rails are parallel, check below the bed before drilling holes to see all wiring, brake lines and other obstructions are moved out of the way and will not be contacted by the drill. Start by drilling one hole and place a 5/8" x 3" (04215) bolt, 5/8" lock washer (00248) and 5/8" flat washer (00477) down through the hc after drilling and before drilling next hole. This will help to stop base rails from shifting during drilling.



3. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a slotted spacer plate in this location as shown in Illustration 2. If the corrugation is DOWN at this location, place the slotted spacer plate in the bed, under the base rail as shown in Illustration 2a.
4. Position the left (14372-76) and right (14373-76) frame brackets up against the outer surface of the truck frame with the mounting tabs positioned over the frame and under the bed. The frame brackets will align themselves in existing frame holes using the 3/4" and 7/8" guide pins that are welded onto each bracket. The brackets should be in line with previously drilled holes in bed where the 5/8" x 3" bolts are coming down through the bed.
5. Make sure the frame brackets are tight against the flat side of truck frame and underneath the surface of the truck bed with bolts extending down through slotted holes in frame bracket tabs. Thread bolts into tapped plates (14251-95). Position tapped plates with bent portion pointed up towards under side of truck bed and with bent ends of tapped plates towards the tailgate end of truck bed. See drawing on second page.
6. Securely bolt the frame brackets into place under the truck bed. Be sure they are tight against the side of the truck frame. Tighten the 5/8" bolts according to the chart on front page.



7. Place the two carriage bolt plates (14284-76) and (14285-76) along with the carriage bolts from the inside of the truck frame and use 1/2" flat washers (00085) and 1/2" nylon lock nuts (00248) to attach to frame bracket. See Illustration 3. Ensure that the 5 1/2" long carriage bolts (14381) are used on the forward mounting holes and the 5" carriage bolts (14376) are used on the rear mounting holes.
NOTE: If carriage bolts rub on gas tank, loosen gas tank, push gas tank over and tighten gas tank straps.
8. Tighten all bolts according to chart on front page. Failure to tighten bolts as described may result in fastener loss or failure.

Demco