



Assembly, Installation, Operation and Maintenance Instructions

Ford F350 SD 4 Bolt Custom Installation Bracket Kit.

P/N: 33094

Dealer / Installer:	Provide a copy of these Instructions to the end user of this product. These Instructions provide important operating and safety information for proper usage of this product. Demonstrate the proper use of the product with the end user. Have the end user demonstrate that they understand the proper use of the product.
End User:	Read and follow all instructions included in this manual. Ask your Dealer / Installer for assistance if you do not understand the proper use of the product. Never remove any decals from the product.

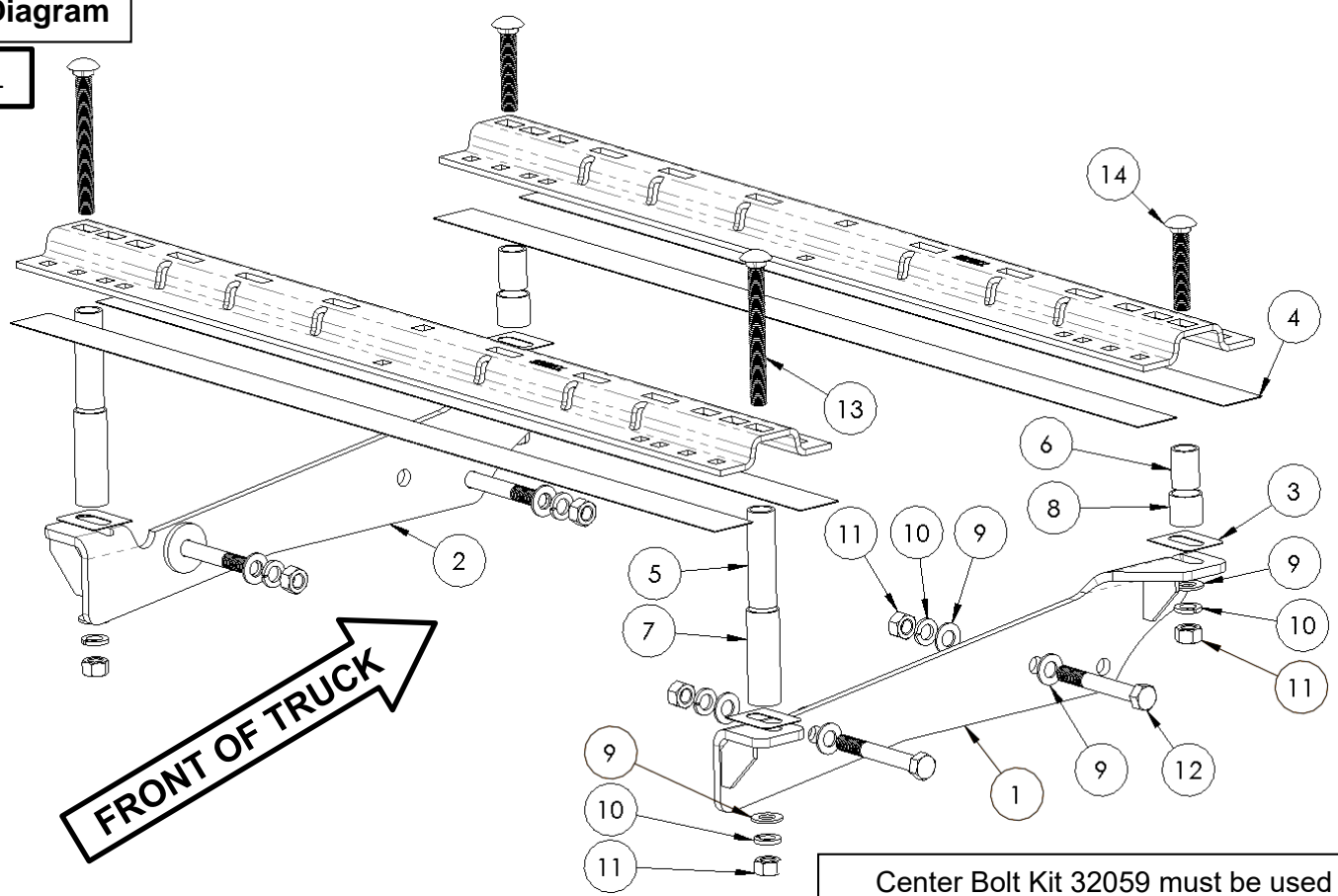
Use with 10 bolt 30686 base rails ONLY. Base Rails are not included with this kit.

Caution: You must remove backing paper on rubber insulator pads to properly install. Once backing paper is removed and the rubber pads are installed; it is PERMANENT and cannot be removed. ONLY remove backing paper and install to the brackets and base rails. DO NOT install rubber insulator pads directly to the truck bed.

WARNING! Never exceed the towing capacity of the tow vehicle.

Parts Diagram

Figure: 1



- TOOLS**
- 3/16 drill
 - 1-5/16" Circular Hole Saw
 - 15/16" Socket & Open End Wrench
 - Torque Wrench

Hardware Torque Values:
5/8" to 150 lb-ft

Center Bolt Kit 32059 must be used when towing with 26K hitch, Goose Neck or a Maneuvering System (not included).

Do NOT use with base rail # 31323.

NO	DESCRIPTION	QTY	NO	DESCRIPTION	QTY
1	PS BRACKET ASSEMBLY	1	8	NYLON TUBE, WEAR RESISTANCE, SHORT	2
2	DS BRACKET ASSY	1	9	WASHER, 5/8 Ø.656 ID X Ø1.25 OD X .094 THK	12
3	RUBBER BRACKET INSULATOR	4	10	LOCKWASHER 5/8, Ø.647 ID X Ø1.079 OD X .156 THK	8
4	BASE RAIL INSULATOR	4	11	NUT, HEX 5/8 -11, GR5, ZINC	8
5	REAR SPACER	2	12	BOLT, HEX HEAD 5/8 -11 X 5", GR5, BZ	4
6	FRONT SPACER	2	13	BOLT, CARRIAGE, 5/8-11 X 6.00, GR5, BZ	2
7	NYLON TUBE, WEAR RESISTANCE, TALL	2	14	BOLT, CARRIAGE 5/8-11 X 3-1/2" GR 5, BZ	2

1. The following instructions should be used to mount the fifth wheel. Care and attention to detail will ensure a quick quality installation. Check parts against parts list to become familiar with parts in kit. (See Fig. 1)
2. Lower or removal of spare tire will give more room. Remove wheel well liner to allow access to truck frame.

WARNING:

If the truck is raised, be sure that the truck is properly blocked and restrained to prevent the truck from falling. Failure to do so may result in the truck suddenly falling, causing death or serious injury.

3. Do **NOT** install mounting rails over plastic bed liners. Plastic bed liners must be cut out of the way. Base rails may be installed on spray in liner. **Note: Consult installer for recommended curing time.**
4. Use only the supplied bolts, nuts and washers to install this kit. All bolts and nuts are Grade 5 unless specified otherwise.
5. Specific instructions for most commonly used vehicles are included. Each frame bracket must be bolted to the vehicle frame with two bolts.

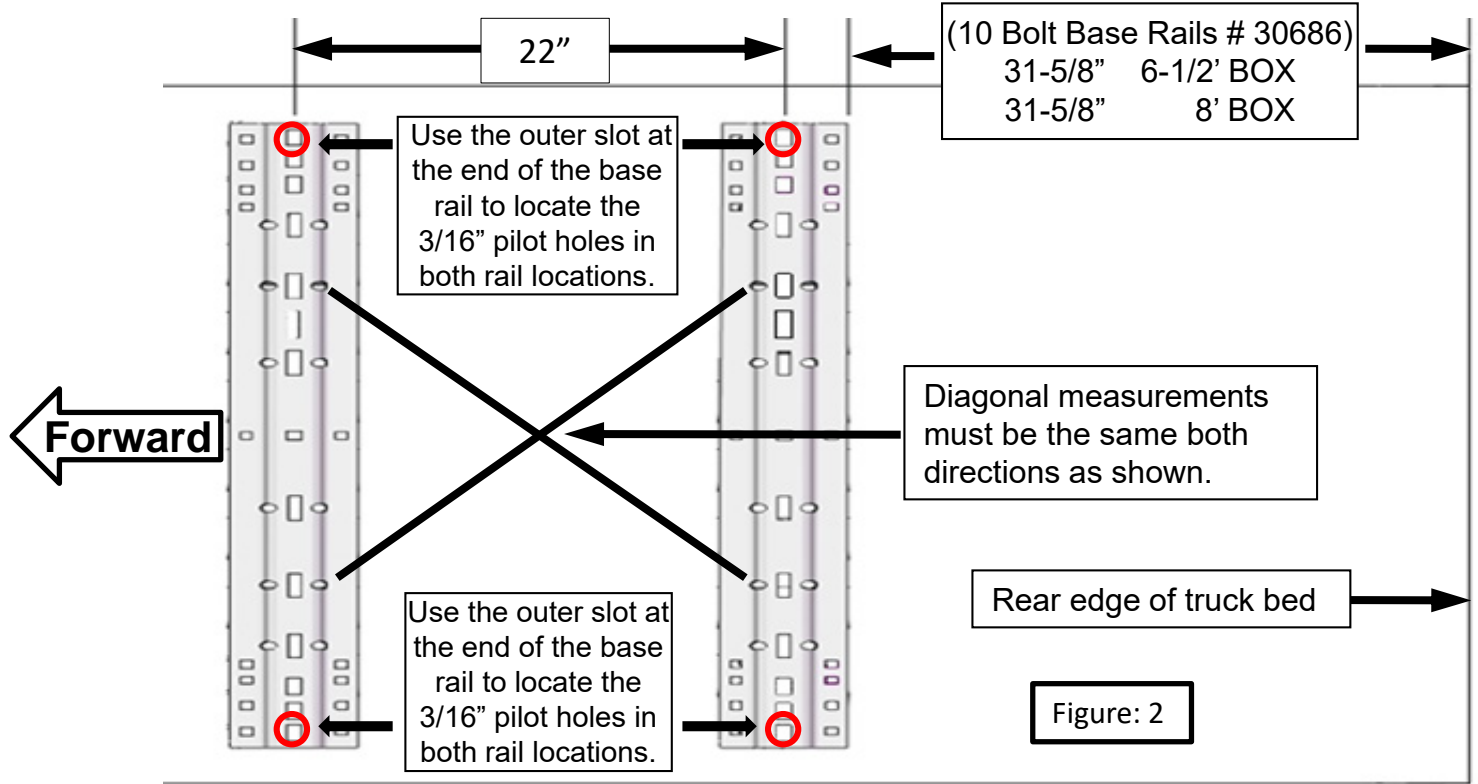
CAUTION:

These instructions are guidelines only. Actual installation is the responsibility of the installer and the owner. Always measure truck and trailer before installing hitch to be sure that there is clearance at the cab and at the bumper to allow for turns.

6. Measurements are given from Rear Edge of truck bed to rear edge of the base rail closest to the Rear Edge of truck for most vehicle applications (See Fig. 2).
7. Apply the base rail insulator strips (#4) on the bottom of each end of rail correctly to protect aluminum bed from corrosion as shown in fig.1 & 5. Be sure to cover the entire bottom of the base rail with the base rail insulators. Center hitch between fender wells and make sure rails are square. Adjust position of rails until both diagonal measurements are the same. (See Fig. 2 & 3). Position the 5th wheel uprights between the bed rails so that the tabs in the base of each upright will fit into the slots in the ends of the bed rails. Secure the uprights in place with the rail hitch pins and hair pins supplied with the 5th wheel installation kit. Securely attach 5th wheel cross member to uprights. On most applications, the 5th wheel assembly should be positioned so that it is approximately centered over the truck axle and between the wheel wells on the bed floor.

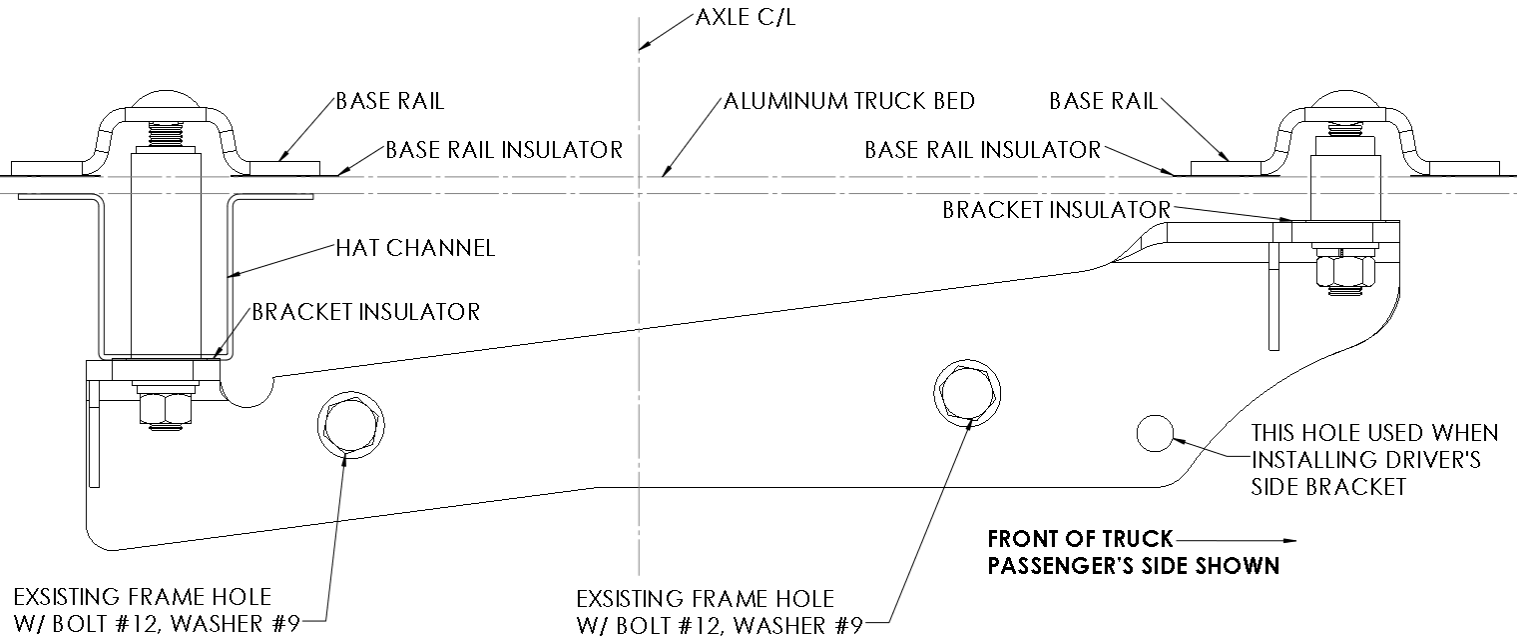
CAUTION:

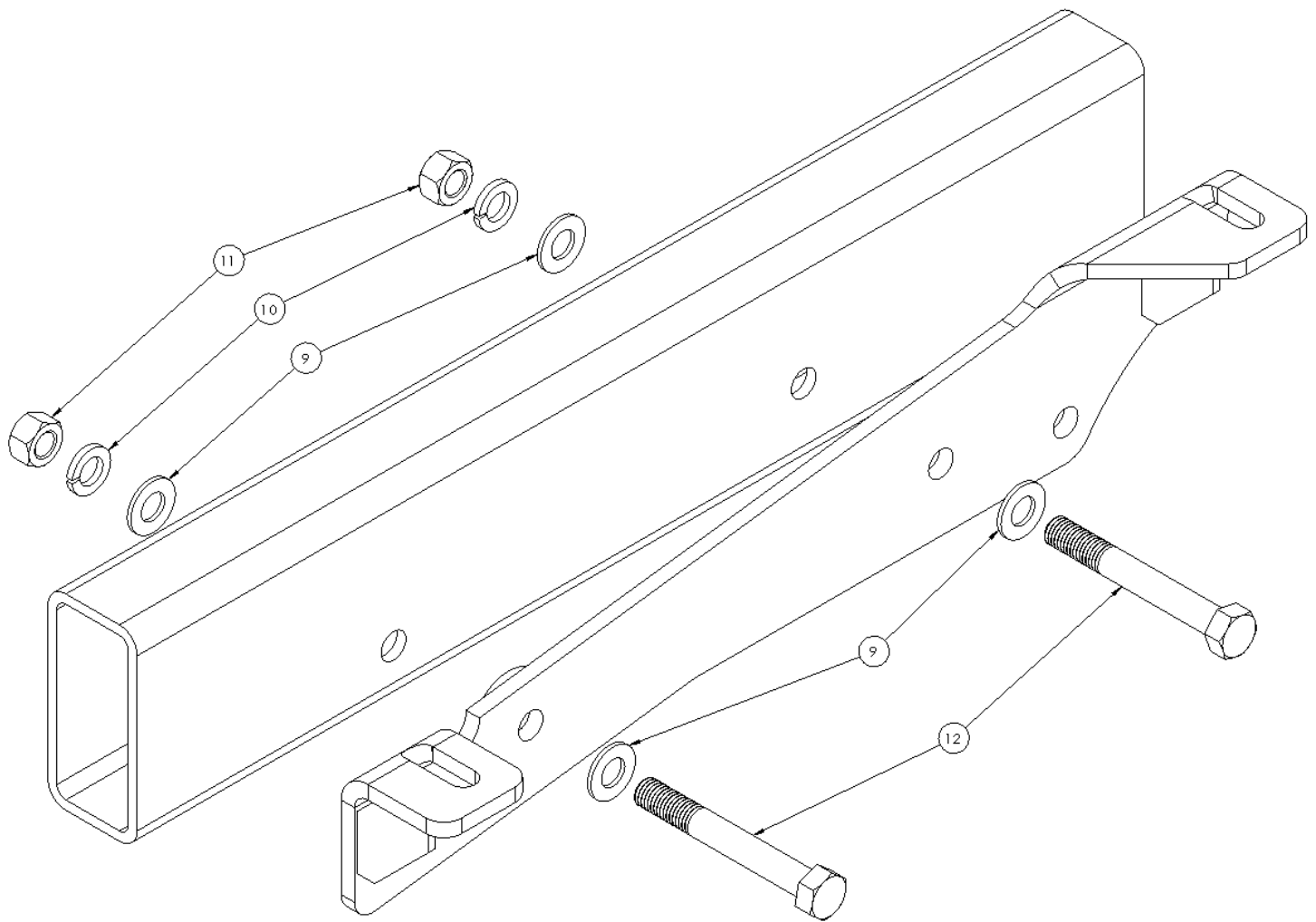
Check for obstructions before drilling. Failure to do so could result in damaged fuel or brake lines, structural members, etc. HUSKY TOWING PRODUCTS does its best to communicate tow vehicle manufacturer changes; however, it is ultimately the responsibility of the installer to prevent damage due to installation.



- Drill 4 holes identified in Fig. 2. (Hole location will vary for individual vehicle applications.) Drill all pilot holes with 3/16" drill. Always use sharp drill bits.

Figure: 3





**Passenger's Side Front Bracket
Shown**

WARNING:
DO NOT lubricate threads. It may cause bolt failure.

Figure: 4

9. Install frame brackets to the frame using appropriate hardware and tighten snug, but do not torque at this time (See figure 4).
Confirm the pilot holes that were drilled in the bed in the previous step are in line with the flange bolt holes in the brackets before drilling the larger holes.
10. When satisfied with the alignment of the pilot holes, remove the brackets and enlarge the 3/16" holes with the 1-5/16" circular hole saw. Drill completely through the truck bed, but do not drill into the frame.

CAUTION:
Check for obstructions before drilling. Failure to do so could result in damaged fuel or brake lines, structural members, etc. HUSKY TOWING PRODUCTS does its best to communicate tow vehicle manufacturer changes; however, it is ultimately the responsibility of the installer to prevent damage due to installation.

12. Remove any rough edges or burrs created by the circular hole saw, and clear away any metal shavings from the installation area
13. Remove the backing paper and place rubber bracket insulators (#3) on top of both bolt flanges of the driver's and passenger's side brackets as shown in fig. 5A.
14. Re-install the Passenger's and Driver's side mounting brackets. Torque all hardware to 150 ft-lbs

Figure 5A

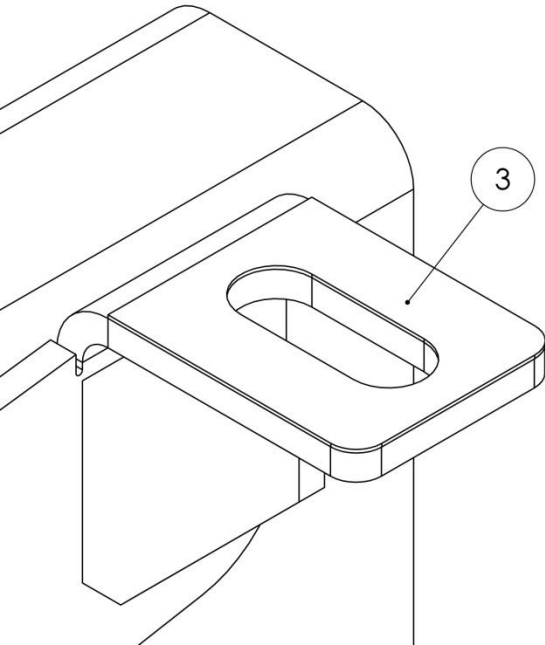
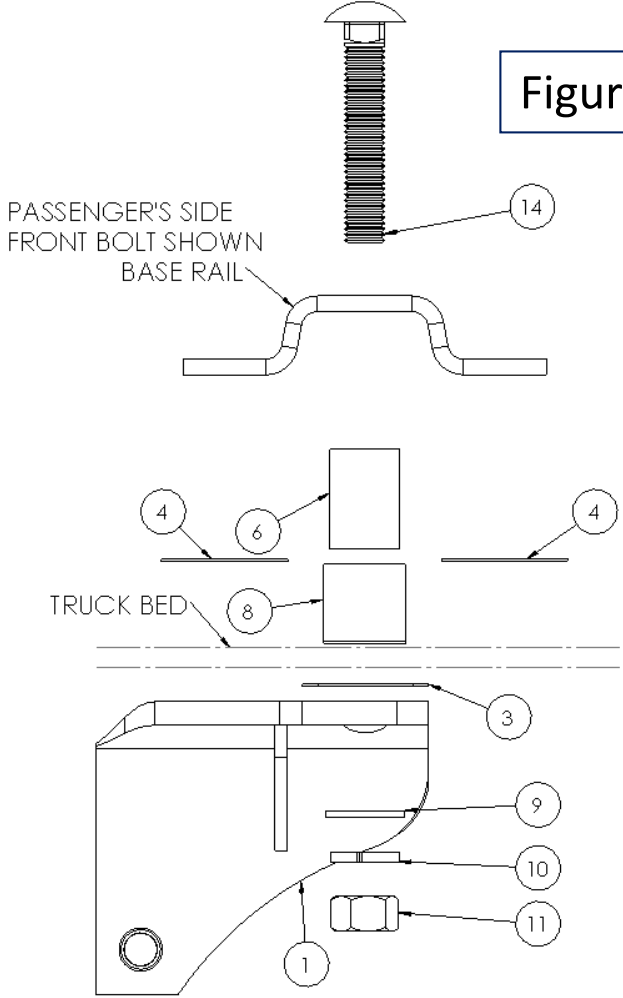


Figure 5B



15. Install the spacer tubes and nylon wear tubes, through the 1-5/16" holes drilled previously. The tubes and spacers will be resting directly on the mounting bracket bolt flanges (See Figure 5B). It is important to use the nylon tubes to prevent corrosion.
16. Position the bed rails over the holes and install the carriage bolts through the rails and spacer tubes.
17. Install washers, lock washers and nuts onto the carriage bolts. Torque all hardware to 150 ft-lbs.
18. Reinstall spare tire and wheel well liner if removed.
19. Re torque all hardware after 1000 miles

Warranty Terms:

5 Year Limited Warranty:

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Husky Towing Products and LKQ Specialty Products Group make no guarantees or warranties for products not manufactured by LKQ Specialty Products Group. Such products are covered solely under any applicable warranty of the manufacturer. It is always recommended that the operating instructions and guarantee instructions provided by the manufacturer are followed.

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The Warranty applies only to LKQ Specialty Products Group products which are found to be defective in manufacturing or material. This warranty does not apply to normal wear and tear of the finished placed on LKQ Specialty Products Group products.

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