



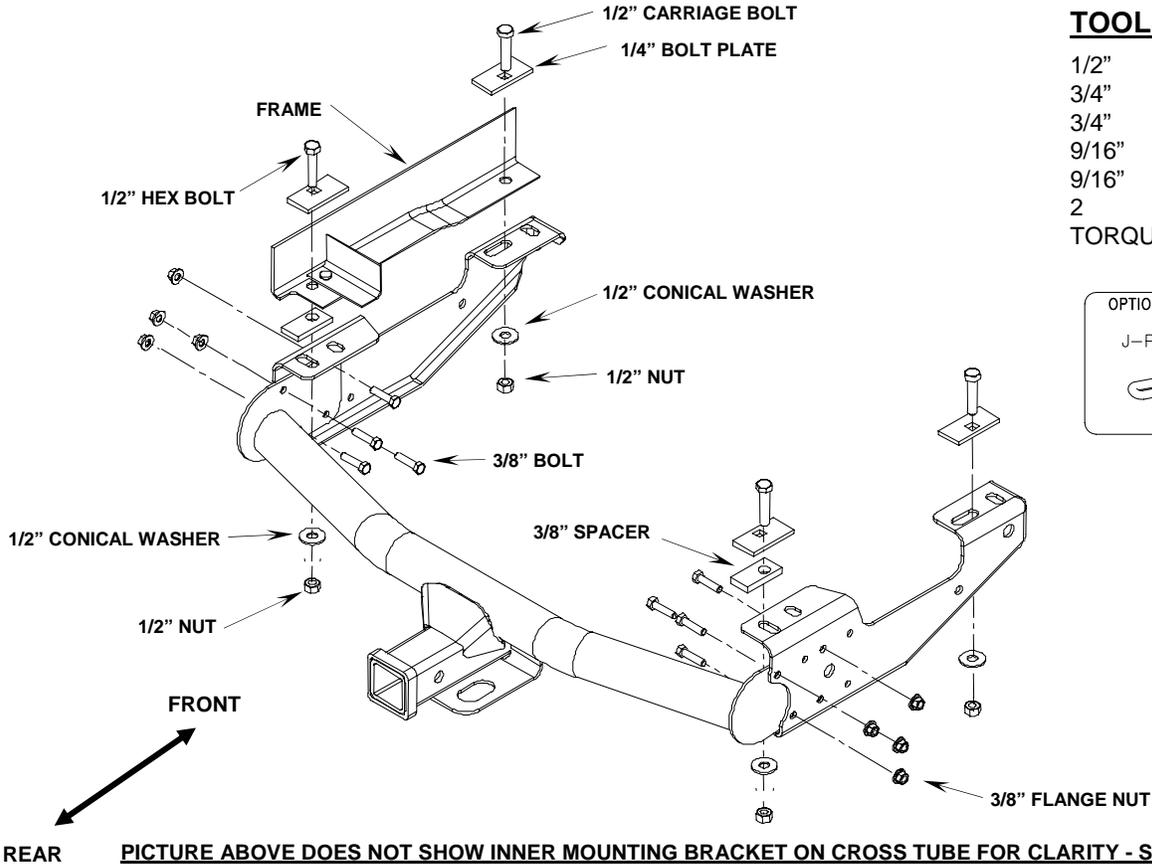
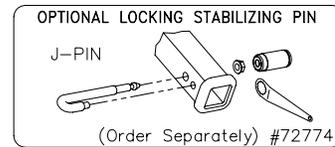
# INSTALLATION INSTRUCTIONS

## UNIVERSAL PICK-UP

Product No.  
**37069**

### TOOLS REQUIRED

1/2"	DRILL BIT
3/4"	SOCKET
3/4"	WRENCH
9/16"	SOCKET
9/16"	WRENCH
2	CLAMPS
	TORQUE WRENCH



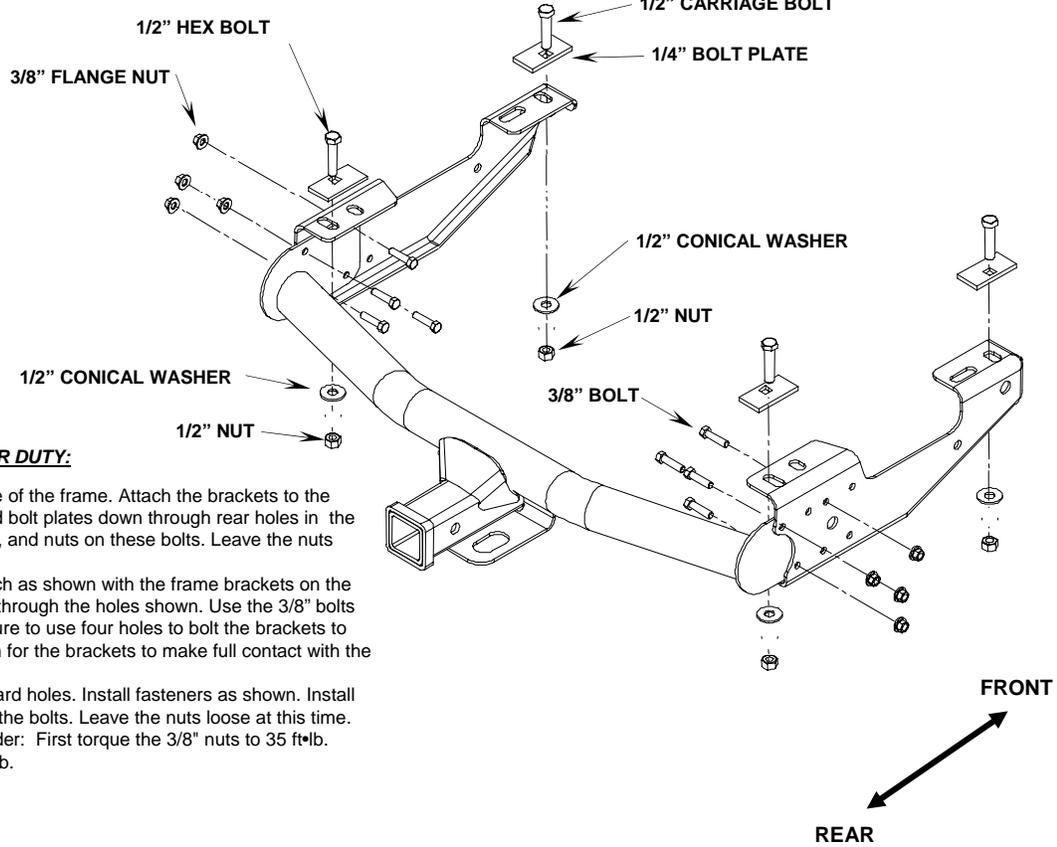
### 1973-1996 Ford Full Size Pickup & 1997 F-250 Heavy Duty / F-350 Heavy Duty:

1. Assemble the three pieces of the hitch together on the floor before attaching it to the truck. Using 3/8" bolts, and flange nuts, bolt the brackets to the center section as shown. Place the brackets on the outside of the center section. Bolt through the holes shown in the illustration. Leave the bolts loose enough to center brackets on truck frame. **NOTE:** Be sure to use four holes to bolt each bracket to the center section.
2. Clamp the hitch to the frame with a 3/8" thick spacer between the hitch and the frame at the rear. Align the ends of the brackets with the end of the frame as shown.
3. Using the holes in the bracket as a guide, drill 1/2" diameter holes into the frame at the locations shown.
4. Insert 1/2" bolts with bolt plates down through the frame and into the bracket. Place a 3/8" thick spacer between the frame and the bracket at each rear mounting hole. Install conical washers and nuts on the bolts.
5. Tighten the nuts in the following order. First torque the 3/8" nuts to 35 ft•lb.. Then torque the 1/2" nuts to 70 ft•lb..

**NOTE: SIDE BRACKETS WILL DEFLECT WHEN TIGHTENED**

**TOOLS REQUIRED**

- 3/4" SOCKET
- 3/4" WRENCH
- 9/16" SOCKET
- 9/16" WRENCH
- 1/2" DRILL BIT
- TORQUE WRENCH



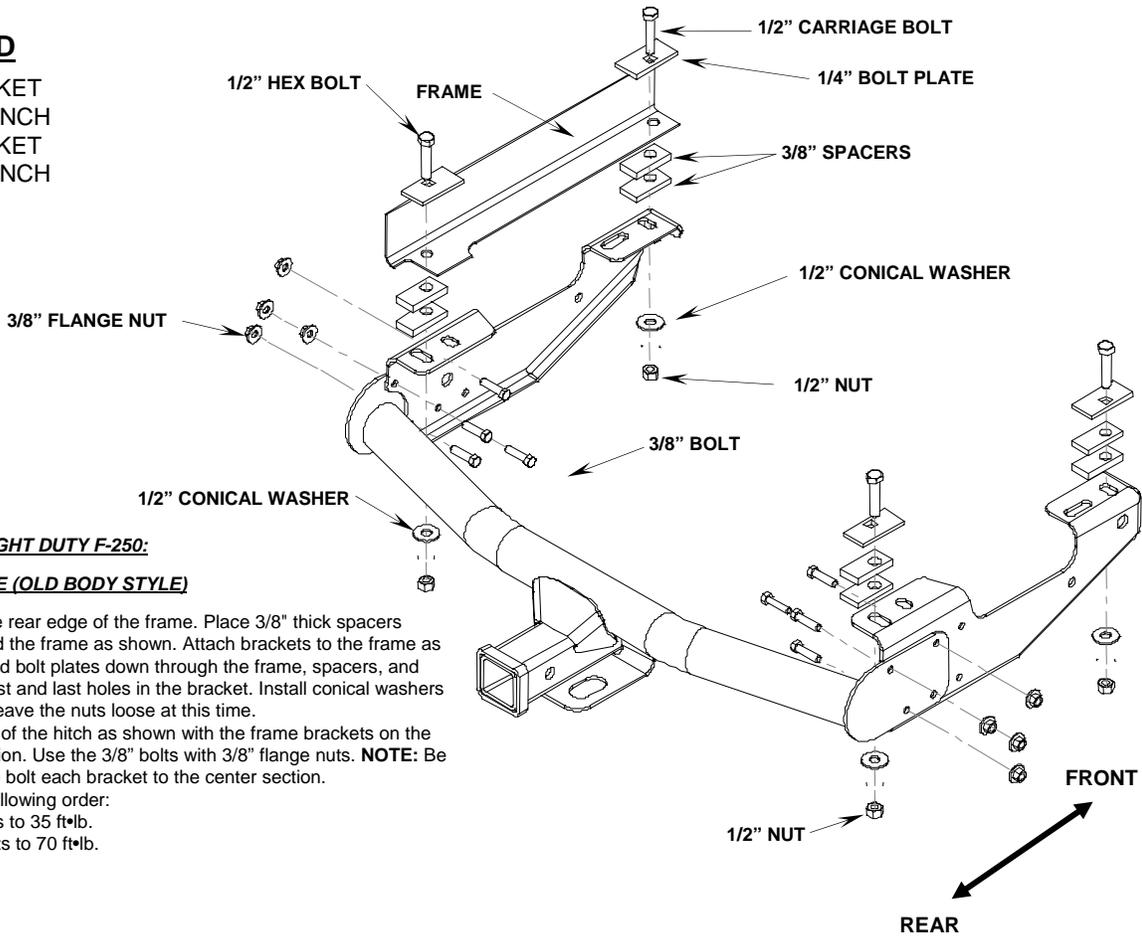
**1998-2004 FORD F-250 & F-350 SUPER DUTY:**

1. Align the bracket with the rear edge of the frame. Attach the brackets to the frame as shown with 1/2" bolts and bolt plates down through rear holes in the frame. Install 1/2" conical washers, and nuts on these bolts. Leave the nuts loose at this time.
2. Install the center section of the hitch as shown with the frame brackets on the outside of the center section. Bolt through the holes shown. Use the 3/8" bolts with 3/8" flange nuts. **NOTE:** Be sure to use four holes to bolt the brackets to the center section. Tighten enough for the brackets to make full contact with the center section.
3. With the 1/2" drill, drill the two forward holes. Install fasteners as shown. Install 1/2" conical washers, and nuts on the bolts. Leave the nuts loose at this time.
4. Tighten the nuts in the following order: First torque the 3/8" nuts to 35 ft•lb. Then torque the 1/2" nuts to 70 ft•lb.

**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

**TOOLS REQUIRED**

- 3/4" SOCKET
- 3/4" WRENCH
- 9/16" SOCKET
- 9/16" WRENCH
- TORQUE WRENCH



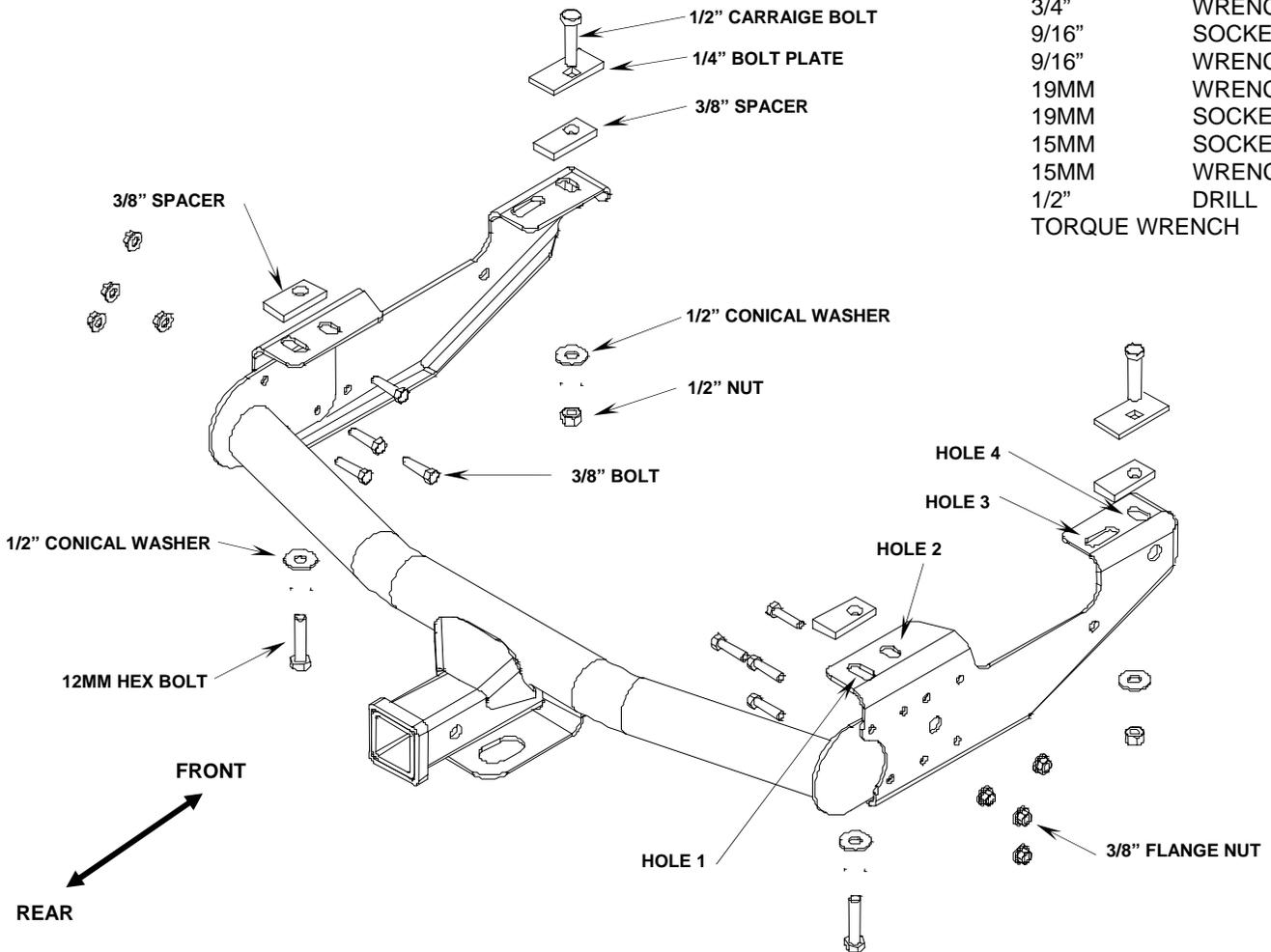
**1997-2003 FORD F-150 & LIGHT DUTY F-250:**

**2004 FORD F-150 HERITAGE (OLD BODY STYLE)**

1. Align the bracket with the rear edge of the frame. Place 3/8" thick spacers between the bracket and the frame as shown. Attach brackets to the frame as shown with 1/2" bolts and bolt plates down through the frame, spacers, and bracket. Bolt into the first and last holes in the bracket. Install conical washers and nuts on the bolts. Leave the nuts loose at this time.
2. Install the center section of the hitch as shown with the frame brackets on the inside of the center section. Use the 3/8" bolts with 3/8" flange nuts. **NOTE:** Be sure to use four holes to bolt each bracket to the center section.
3. Tighten the nuts in the following order: First torque the 3/8" nuts to 35 ft•lb. Then torque the 1/2" nuts to 70 ft•lb.

## TOOLS REQUIRED

3/4"	SOCKET
3/4"	WRENCH
9/16"	SOCKET
9/16"	WRENCH
19MM	WRENCH
19MM	SOCKET
15MM	SOCKET
15MM	WRENCH
1/2"	DRILL
	TORQUE WRENCH



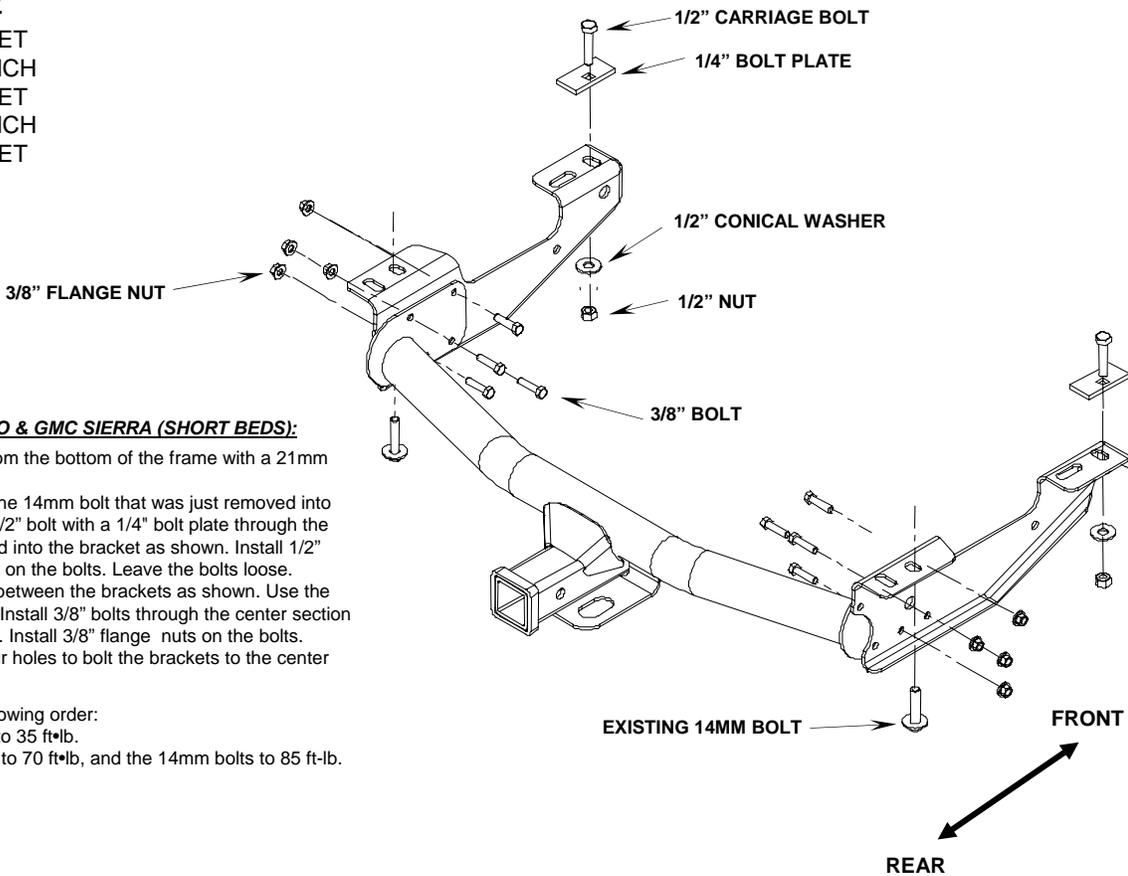
**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

### 1988-2000 CHEVY & GMC (CLASSIC):

1. Remove the 12mm diameter bolts at the end of the frame. Some vehicles have an 8mm diameter bolt on the passenger's side. Remove the bolt and reinstall it with the head on the bottom of the frame.
2. If your vehicle has rivets on the bottom of the frame, you will need to install one 3/8" thick spacer between the frame and the bracket at each bolting location. These are needed for clearance between the bracket and the rivet head. The bracket can not be bolted directly against the rivets.
3. Using the supplied 12mm diameter bolt, 1/2" conical washer and fasten the bracket to the frame where the 12mm diameter factory bolt was removed. See the illustration. For short beds use hole 2. For long beds use hole 1. **NOTE: SOME DUAL PIPE EXHAUST SYSTEMS WILL HIT THE BRACKET. THE EXHAUST WILL NEED TO BE MODIFIED.**
4. (Short Beds): Insert 1/2" bolts with bolt plates down through the 1" diameter holes in the frame and into the holes (4) in the bracket. Install a 1/2" flat washer, lock washer and nut on each bolt. Leave the nuts loose at this time.
5. (Long Beds): Insert 1/2" bolts with bolt plates down through the 1" diameter holes in the frame and into the holes (3) in the bracket. (On some models the forward hole may be 1/2".) Install a 1/2" conical washer and nut on each bolt. Leave the nuts loose at this time.
6. Place the center section between the brackets as shown. The spare tire may need to be loosened. Bolt through the center section and the bracket with 3/8" bolts, and 3/8" flange nuts. **NOTE: Be sure to use four holes to bolt the brackets to the center section.**
7. Tighten the nuts in the following order:  
First torque the 3/8" nuts to 35 ft•lb.  
Then torque the 1/2" nuts to 70 ft•lb, and the 12mm bolts to 75 ft•lb.
8. Retighten the spare tire if it was loosened.
9. Be sure that the spare tire is not rubbing against the brake hose. If needed, bend the bracket that the hose mounts to a little so that you have clearance between the tire and the brake hose.

**TOOLS REQUIRED**

- 3/4" SOCKET
- 3/4" WRENCH
- 9/16" SOCKET
- 9/16" WRENCH
- 21MM SOCKET
- TORQUE WRENCH



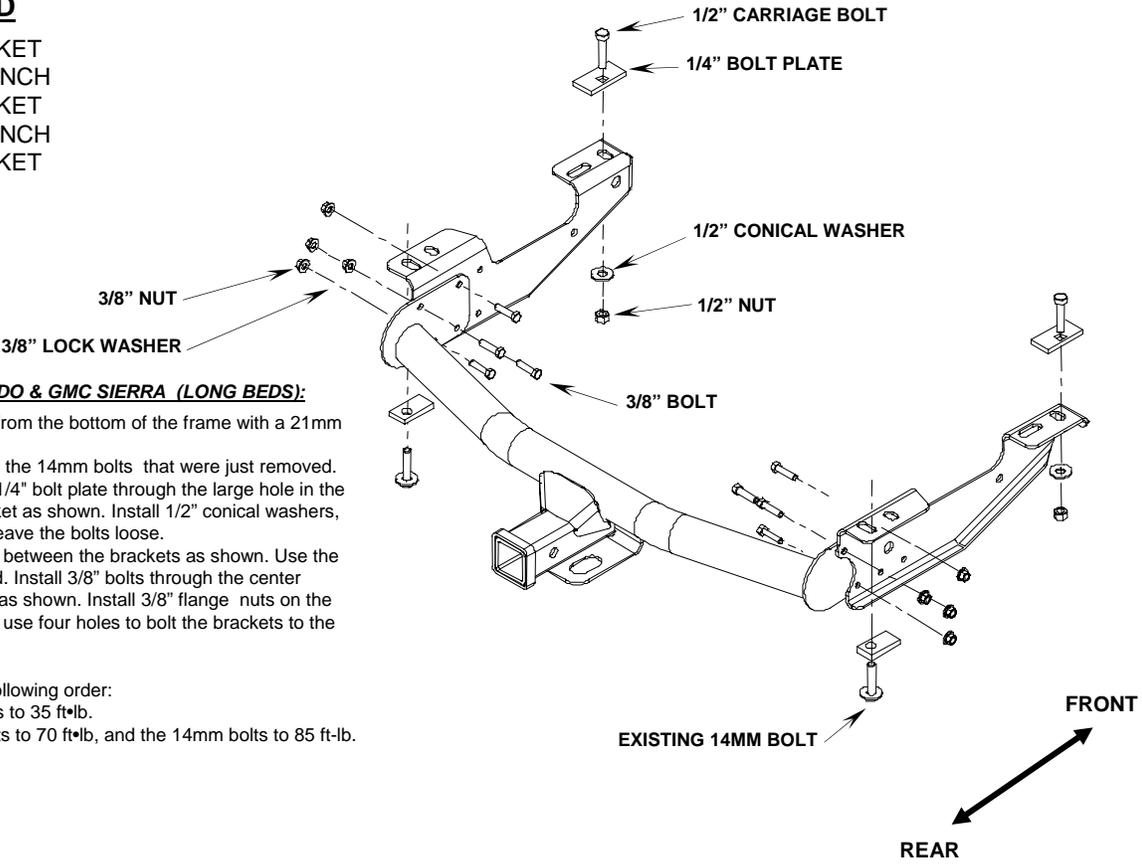
**1999-2005 CHEVY SILVERADO & GMC SIERRA (SHORT BEDS):**

1. Remove the 14mm bolt from the bottom of the frame with a 21mm socket.
2. Bolt the brackets on with the 14mm bolt that was just removed into the hole shown. Insert a 1/2" bolt with a 1/4" bolt plate through the large hole in the frame and into the bracket as shown. Install 1/2" conical washers, and nuts on the bolts. Leave the bolts loose.
3. Install the center section between the brackets as shown. Use the bolting location indicated. Install 3/8" bolts through the center section and the bracket as shown. Install 3/8" flange nuts on the bolts. **NOTE:** Be sure to use four holes to bolt the brackets to the center section.
4. Tighten the nuts in the following order:  
First torque the 3/8" nuts to 35 ft•lb.  
Then torque the 1/2" nuts to 70 ft•lb, and the 14mm bolts to 85 ft•lb.

**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

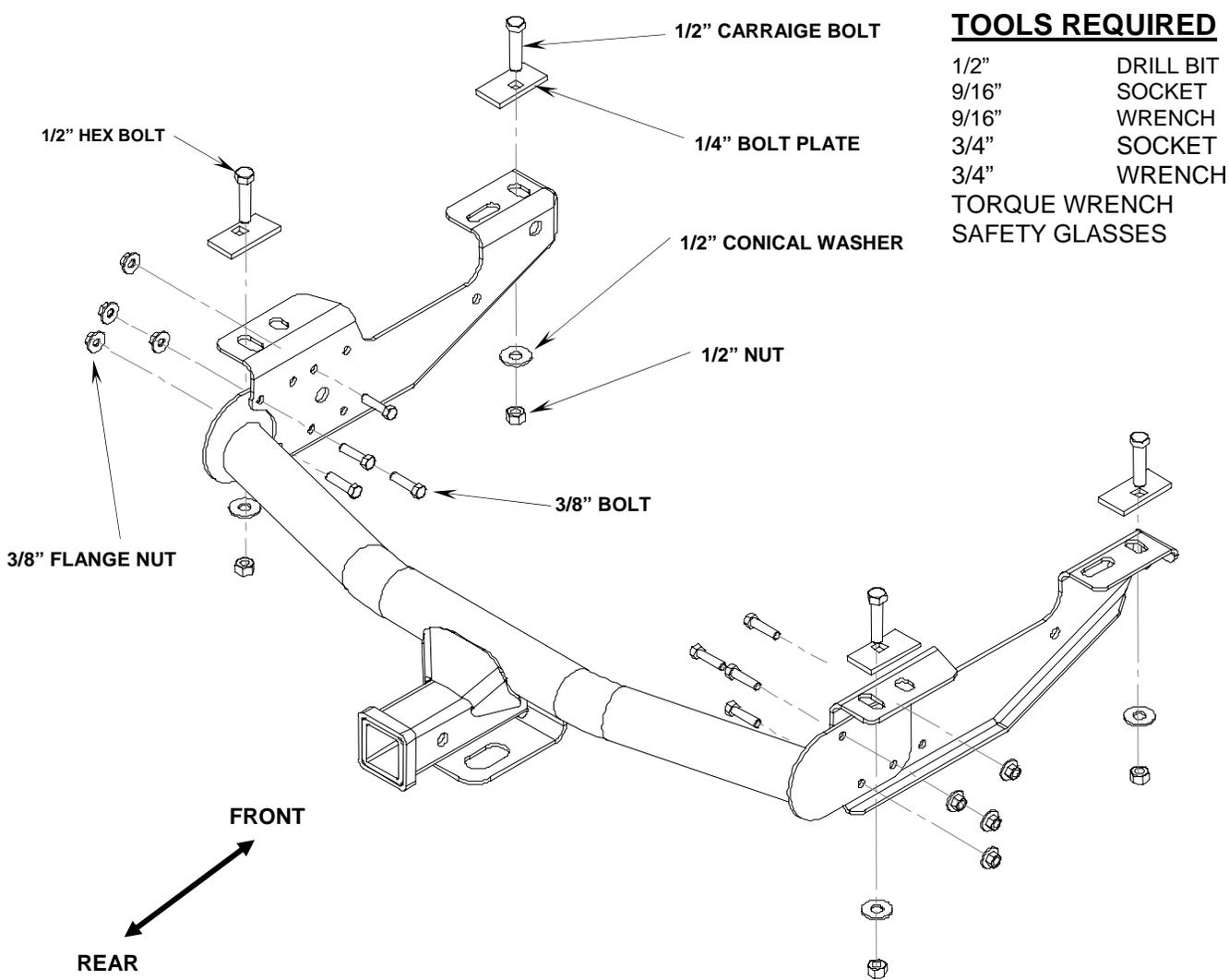
**TOOLS REQUIRED**

- 3/4" SOCKET
- 3/4" WRENCH
- 9/16" SOCKET
- 9/16" WRENCH
- 21MM SOCKET
- TORQUE WRENCH



**1999-2005 CHEVY SILVERADO & GMC SIERRA (LONG BEDS):**

1. Remove the 14mm bolt from the bottom of the frame with a 21mm socket.
2. Bolt the brackets on with the 14mm bolts that were just removed. Insert a 1/2" bolt with a 1/4" bolt plate through the large hole in the frame and into the bracket as shown. Install 1/2" conical washers, and nuts on the bolts. Leave the bolts loose.
3. Install the center section between the brackets as shown. Use the bolting location indicated. Install 3/8" bolts through the center section and the bracket as shown. Install 3/8" flange nuts on the bolts. **NOTE:** Be sure to use four holes to bolt the brackets to the center section.
4. Tighten the nuts in the following order:  
First torque the 3/8" nuts to 35 ft•lb.  
Then torque the 1/2" nuts to 70 ft•lb, and the 14mm bolts to 85 ft•lb.



**TOOLS REQUIRED**

- 1/2" DRILL BIT
- 9/16" SOCKET
- 9/16" WRENCH
- 3/4" SOCKET
- 3/4" WRENCH
- TORQUE WRENCH
- SAFETY GLASSES

**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

**2000-2005 TOYOTA TUNDRA :**

1. Use existing hole at the rear of the frame and install the 1/2" bolts through the bolt plates and into the frame. With the 1/2" conical washer and 1/2" nut, bolt the brackets to the frame. Leave the bolts loose enough to center bracket on frame of truck. Do not install fasteners in the forward hole in the brackets at this time.
2. Install the center section to the brackets as shown. Use the bolting location indicated. Install 3/8" bolts through the center section and the bracket as shown. Install 3/8" flange nuts on the bolts.
3. Using the forward most holes in the brackets as a guide drill a 1/2" hole and install the 1/2" bolts with 1/4" bolt plates through the frame and brackets. Then install the 1/2" conical washers and 1/2" nuts.

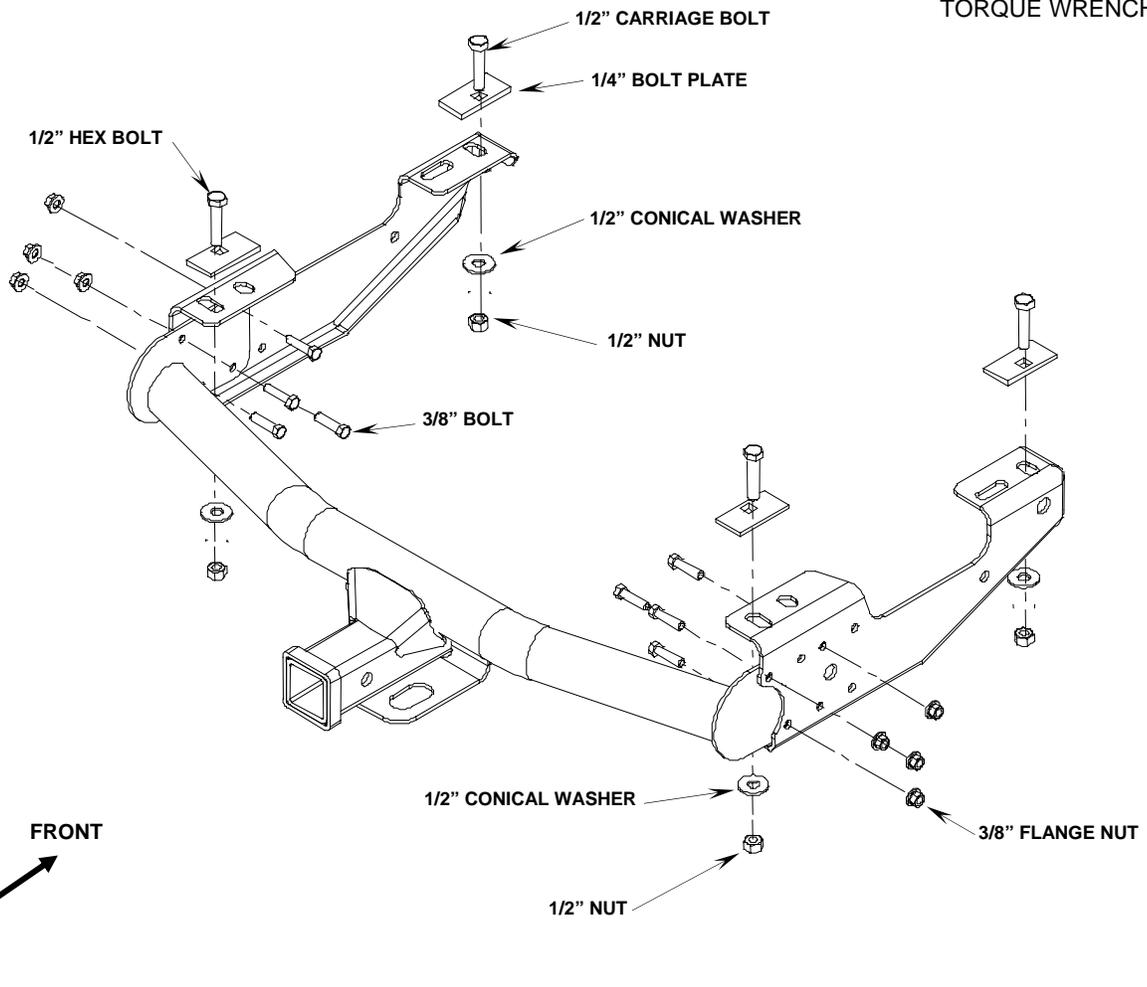
**NOTE:** Be sure to use four holes to bolt the brackets to the center section.

4. Tighten the nuts in the following order:  
 First torque the 3/8" nuts to 35 ft•lb.  
 Then torque the 1/2" nuts to 70 ft•lb.

***NOTE: SIDE BRACKETS MAY DEFLECT WHEN TIGHTENED***

## TOOLS REQUIRED

3/4"	SOCKET
3/4"	WRENCH
9/16"	SOCKET
9/16"	WRENCH
	TORQUE WRENCH



**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

### 1971-1993 Dodge Pick Up:

1. Insert a 1/2" bolt with a 1/4" bolt plate down through the 1" diameter hole at the end of the frame. Do this on both sides. Fasten the frame brackets as shown, to the frame with 1/2" conical washers and nuts. Leave the bolts loose enough to center bracket on frame of truck.

NOTE; On some special frames all holes will have to be drilled as followed.

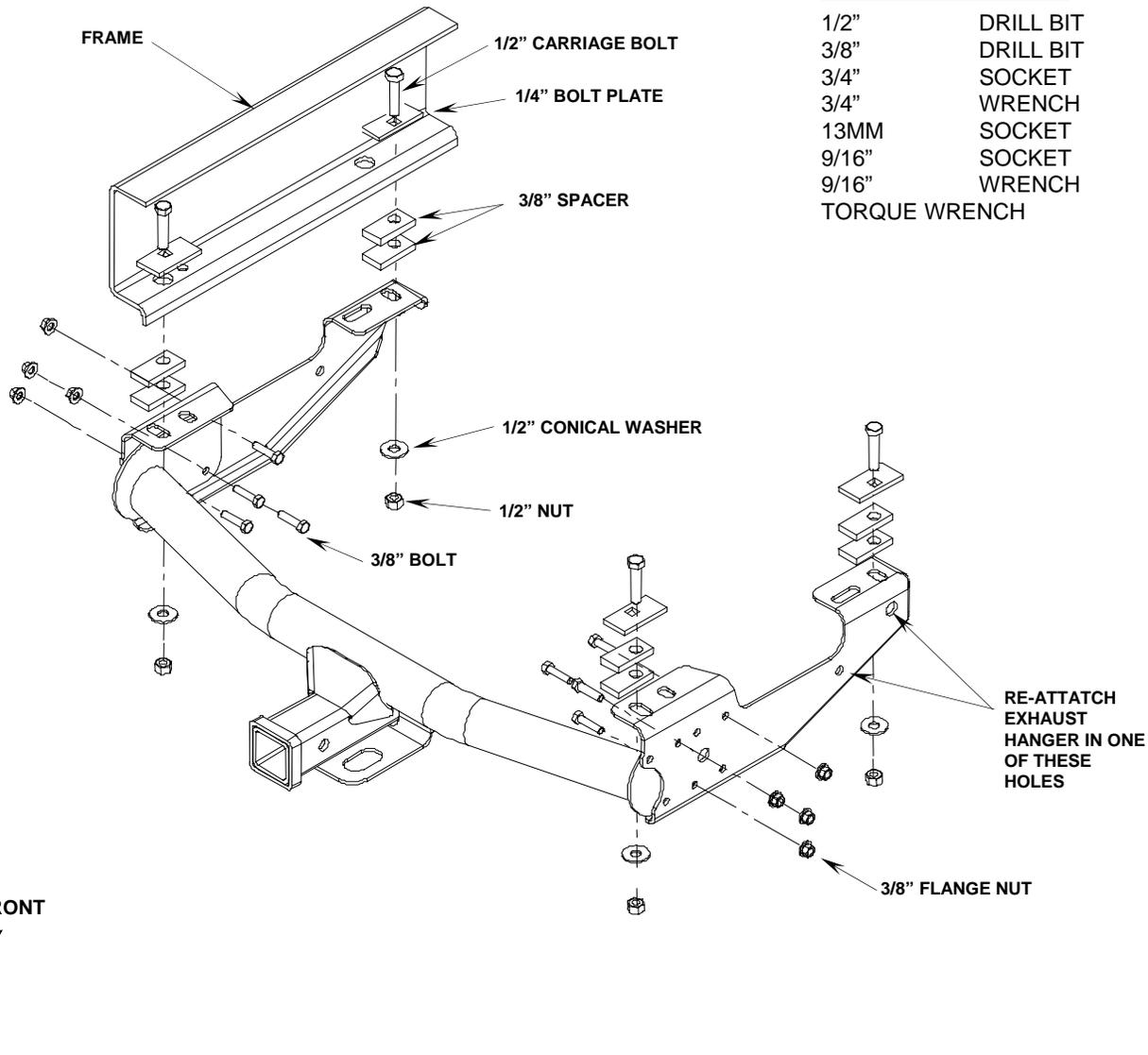
Loosely attach parts as noted in step 2. Clamp hitch to frame so the first and last hole in bracket is able to be used as drill guides to the frame.

2. Install the center section between the brackets as shown. Bolt through the center section and the brackets with 3/8" bolts, and 3/8" flange nuts. Use the holes shown. Leave the nuts finger tight at this time. Some spare tire carriers may need to be modified if the hitch hits the carrier. **NOTE:** Be sure to use four holes to bolt the brackets to the center section.
3. Using the hole in the bracket as a guide, drill a 1/2" diameter holes through the frame. Use the farthest front hole. Do this on both sides.
4. Insert 1/2" bolts with 1/4" bolt plates down through the frame and the bracket. Install 1/2" conical washers and nuts on the bolts.
5. Tighten the nuts in the following order:  
First torque the 3/8" nuts to 35 ft•lb.  
Then torque the 1/2" nuts to 70 ft•lb.

**NOTE: SIDE BRACKETS WILL DEFLECT WHEN TIGHTENED**

## TOOLS REQUIRED

1/2"	DRILL BIT
3/8"	DRILL BIT
3/4"	SOCKET
3/4"	WRENCH
13MM	SOCKET
9/16"	SOCKET
9/16"	WRENCH
	TORQUE WRENCH



**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

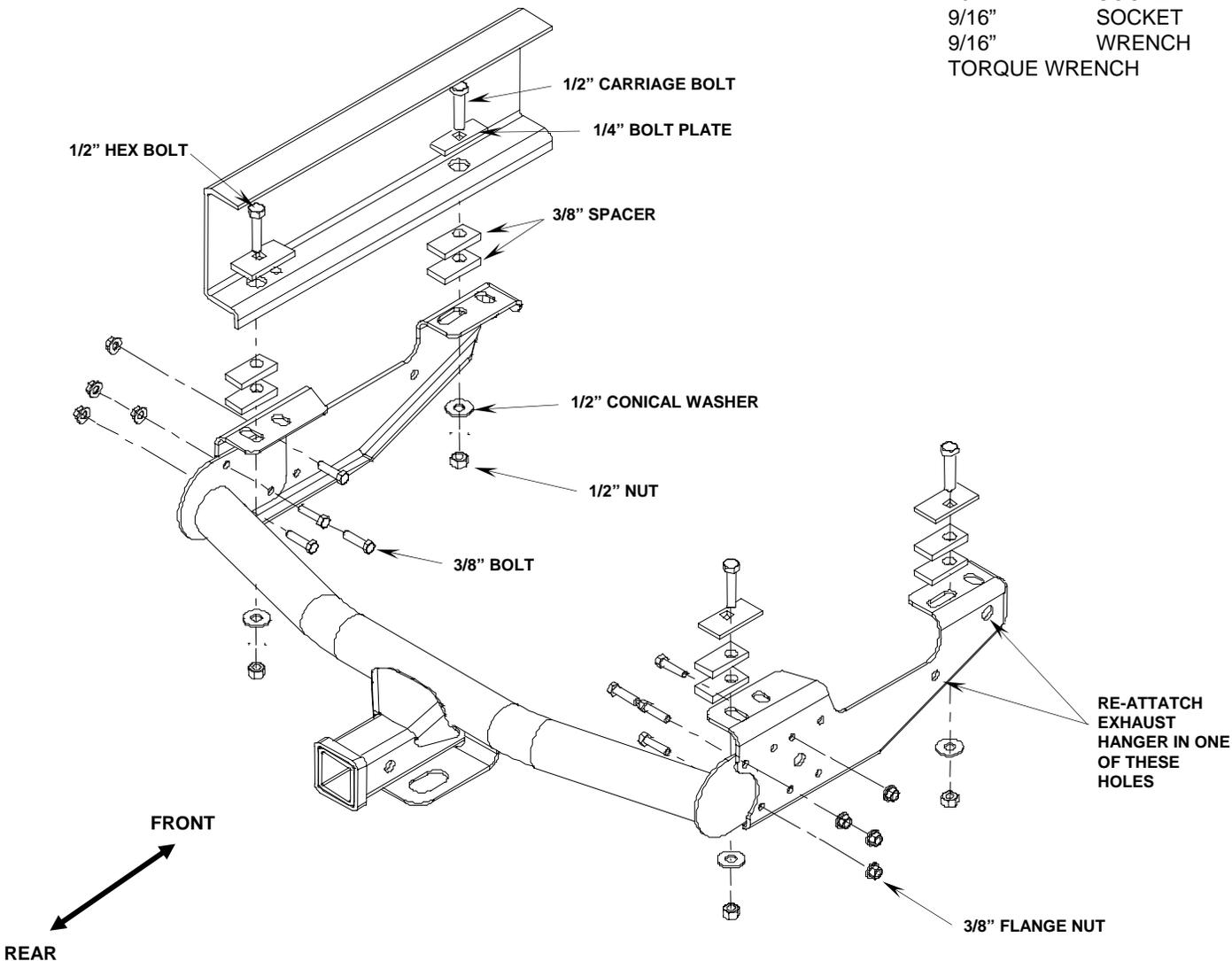
**1994-2001 Dodge Pick Up Short Bed - All Models:**

**2002 Dodge Pick Up Short Bed 2500 & 3500 Series ONLY:**

1. The spare tire may need to be loosened for installation.
2. Bolt the brackets to the frame as shown with a 1/2" bolt and 1/4" bolt plate inserted through the 1" diameter hole in the end of the frame. Install two 3/8" thick spacers between the frame and brackets at the rear bolting locations. Install 1/2" conical washers and nuts on the bolts. **NOTE:** For some models, the exhaust hanger will need to be unbolted from the frame.
3. Install the center section between the brackets as shown. Use the hole pattern that works best for your truck. Insert 3/8" bolts through the center section and the brackets. Install 3/8" flange nuts on the bolts. Finger tighten the bolts at this time. **NOTE:** Be sure to use four holes to bolt each bracket to the center section.
4. Using the hole in the bracket as a guide, drill a 1/2" hole through the frame. Use the hole shown in the diagram. Install 1/2" bolts with bolt plates into the holes. Be sure to insert two 3/8" thick spacers between the frame and the brackets. Install 1/2" conical washers and nuts on the bolts.
5. If the exhaust hanger was removed, drill a 3/8" hole through the hanger and attach it to the hitch bracket in one of the holes provided in the bracket. Use the 3/8" hardware provided to re-attach the exhaust hanger.
6. Tighten the nuts in the following order:  
First torque the 3/8" nuts to 35 ft•lb.  
Then torque the 1/2" nuts to 70 ft•lb.
7. If the spare tire was loosened, retighten it now.

## TOOLS REQUIRED

3/8"	DRILL BIT
3/4"	SOCKET
3/4"	WRENCH
13MM	SOCKET
9/16"	SOCKET
9/16"	WRENCH
	TORQUE WRENCH



**PICTURE ABOVE DOES NOT SHOW INNER MOUNTING BRACKET ON CROSS TUBE FOR CLARITY - SHOWN ON PAGE 9**

**1994-2001 Dodge Pick Up Long Bed - All Models:**

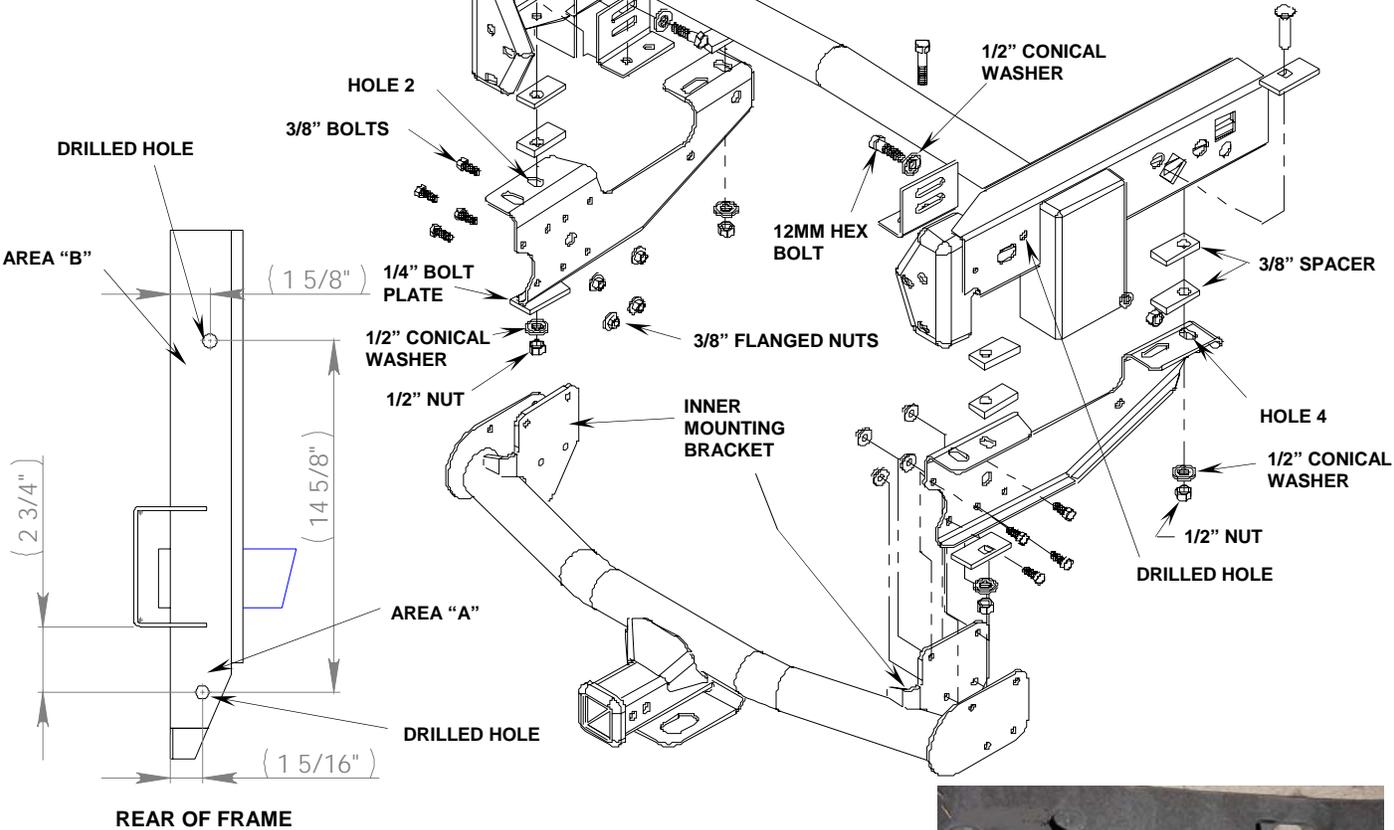
**2002 Dodge Pick Up Long Bed 2500 & 3500 Series ONLY:**

1. The spare tire may need to be loosened for installation.
2. Bolt the brackets to the frame as shown with a 1/2" bolt and 1/4" bolt plate inserted through the 1" diameter hole in the end of the frame. Install two 3/8" thick spacers between the frame and brackets at the rear bolting locations. Install 1/2" conical washers and nuts on the bolts. **NOTE:** For some models, the exhaust hanger will need to be unbolted from the frame.
3. Install the center section between the brackets as shown. Use the hole pattern that works best for your truck. Insert 3/8" bolts through the center section and the brackets. Install 3/8" flange nuts on the bolts. Finger tighten the bolts at this time. **NOTE:** Be sure to use four holes to bolt each bracket to the center section.
4. Insert a 1/2" bolt with a 1/4" bolt plate through the 1" hole in the frame and into the bracket as shown. Insert two 3/8" thick spacers between the frame and the bracket. Install a 1/2" conical washer and nut on the bolt. Do this on both sides.
5. If the exhaust hanger was removed, drill a 3/8" hole through the hanger and attach it to the hitch bracket in one of the holes provided in the bracket. Use the 3/8" hardware provided to re-attach the exhaust hanger.
6. Tighten the nuts in the following order:  
First torque the 3/8" nuts to 35 ft•lb.  
Then torque the 1/2" nuts to 70 ft•lb.
7. If the spare tire was loosened, retighten it now.



## TOOLS REQUIRED

1/4" & 9/16	DRILL BIT
3/4"	SOCKET
3/4"	WRENCH
18MM	WRENCH
19MM	SOCKET
9/16"	SOCKET
9/16"	WRENCH
	TORQUE WRENCH



**REAR OF FRAME  
(VIEW OF BOTTOM PASSANGER SIDE FRAME)**



### 2004 - 05 FORD F-150 (NEW BODY STYLE) WITHOUT VIBRATION DAMPENER ON FRAME

1. Lower spare tire for ease of installation.
2. Apply masking tape to the bottom of frame in area "A" and area "B". Same on both frame rails .
3. Measure from the outside of the frame inward 1 5/16" and make a line the length of area "A".
4. Measure from the outside of the frame inward 1 5/8" and make a line the length of area "B".
5. Measure from rear of spring shackle 2 3/4" and make a mark in area "A" . From that mark, measure 14 5/8" forward and make a mark in area "B".
6. Hold side bracket up to bottom of frame. Double check hole 2 and 4 in side bracket for proper line up with marks. If they don't line up, adjust the marks in area "B".
7. Center punch and pilot drill with 1/4" drill bit . Total of 4 holes ( 2 per frame rail).
8. Enlarge the pilot hole with 9/16" drill bit.
9. Loosely install side brackets as shown. Include the angle reinforcement on the inside of the frame and blocks under the frame.
10. Install the cross tube assembly between the side brackets and secure it with (4) 3/8" bolts per side.
11. Tighten the 3/8" crosstube bolts first to 35 ft•LB. Then tighten the 1/2" frame mounting bolts to 70 ft•LB.
12. Using the top slot of the frame angle reinforcement placed inside the frame in step 8. Drill a 1/2" hole in the side of the frame as far forward as slot will permit.
13. Install the M-12 fasteners through the frame side as shown and tighten to 75 ft•LB .
14. Raise spare tire.