



Ford F250, F350 & F450

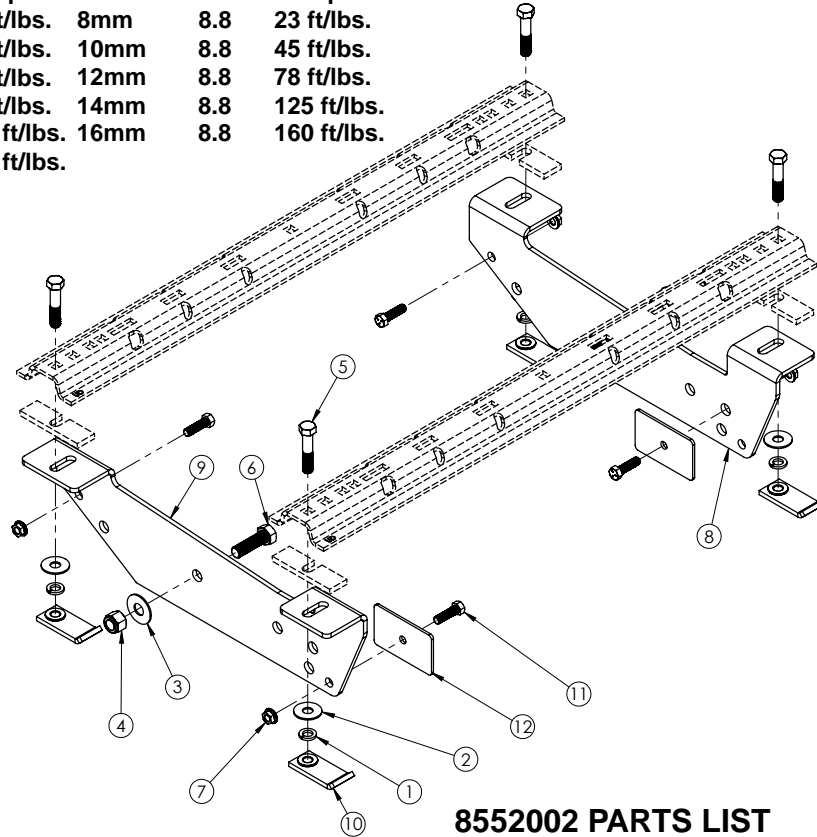
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HJ32002, Rev 2



BOLT TORQUE SPECIFICATIONS

STANDARD BOLTS			METRIC BOLTS		
Size	Grade	Torque	Size	Grade	Torque
5/16"	5	18 ft/lbs.	8mm	8.8	23 ft/lbs.
3/8"	5	30 ft/lbs.	10mm	8.8	45 ft/lbs.
7/16"	5	50 ft/lbs.	12mm	8.8	78 ft/lbs.
1/2"	5	75 ft/lbs.	14mm	8.8	125 ft/lbs.
5/8"	5	150 ft/lbs.	16mm	8.8	160 ft/lbs.
3/4"	5	290 ft/lbs.			

FRAME BRACKET



8552002 PARTS LIST

ITEM	PART #	DESCRIPTION	QTY
1	00248	LOCK WASHER, .625	4
2	00477	FLAT WASHER, .625	4
3	00492	FLAT WASHER, .750	2
4	02961	NUT, .750 NYLON LOCK	2
5	04215	BOLT .625 X 3 GR.5 HEX	4
6	05047	BOLT .750 X 2.5 GR.5 HEX	2
7	10379	NUT, .50 SERRATED FLANGE	4
8	14187-76	PASSENGER SIDE FRAME BRACKET	1
9	14188-76	DRIVER SIDE FRAME BRACKET	1
10	14251-95	UNLTD NUT BAR	4
11	14266	BOLT .50 X 1.750 GR.5 HEX KNURLED	4
12	14293-76	SHIM .1875	2
13	14238	FISH WIRE .50 (NOT SHOWN)	1

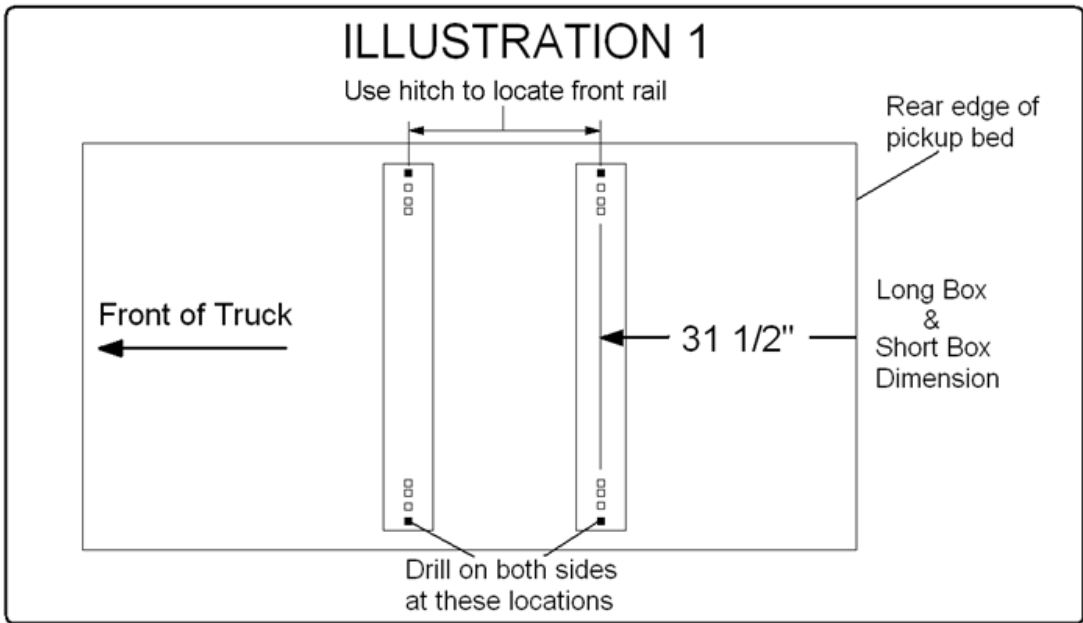
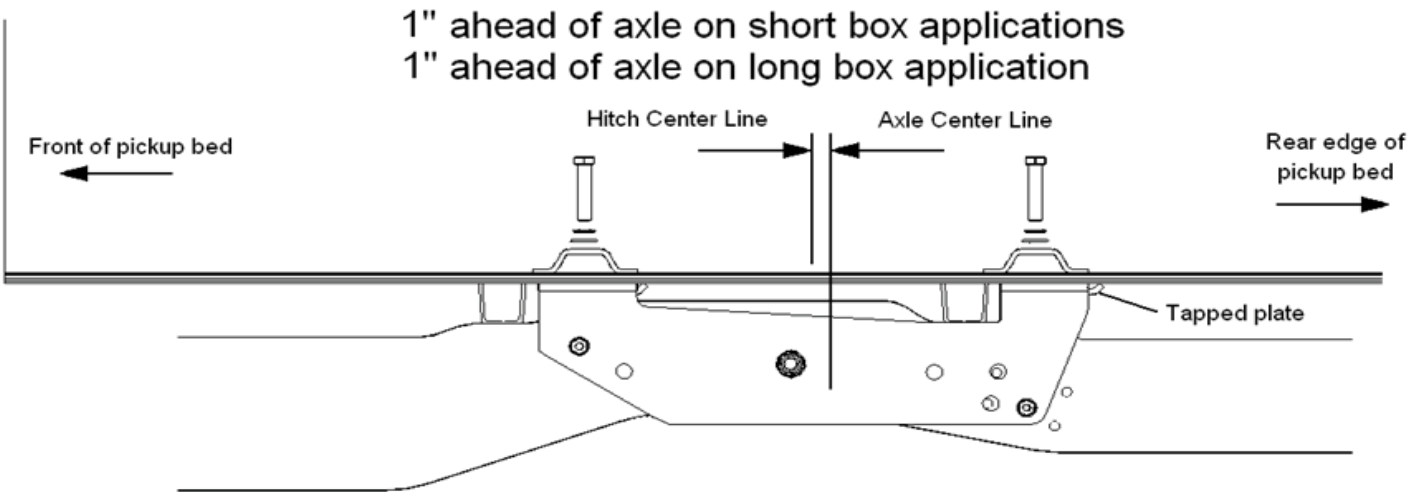
Please order replacement parts by PART NO. and DESCRIPTION

ASSEMBLY
OPERATION
REPLACEMENT PARTS

READ complete manual CAREFULLY
BEFORE attempting operation.

Doing Our Best to Provide You the Best

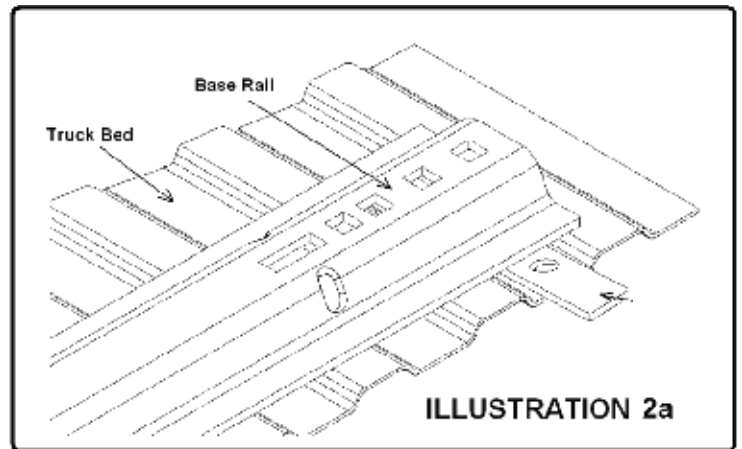
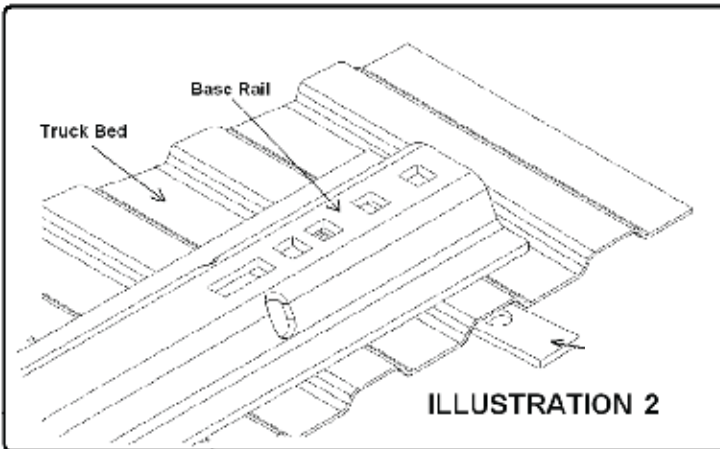
FORD: 2005-2010 F250 & F350 Super Duty (6 1/2' & 8' Box)
2008-2010 F450 Super Duty (6 1/2' & 8' Box)



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.

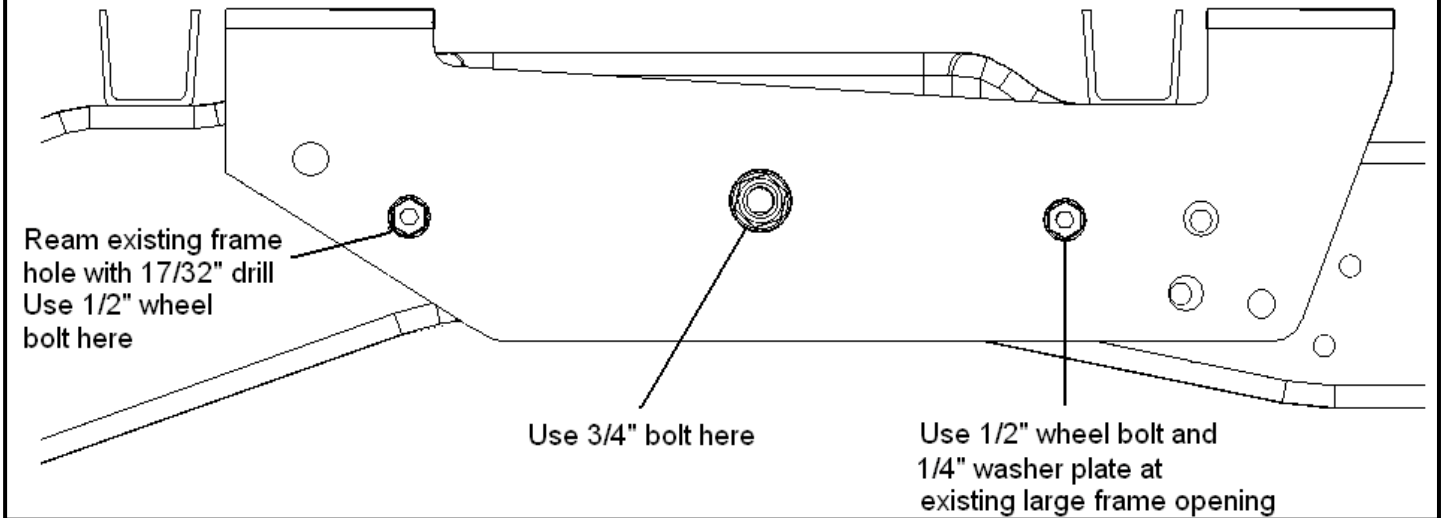
1. Fully assemble the 5th wheel hitch on a flat, level surface and pin into the base rails (assembly instructions come with hitch components). Place assembled hitch in truck bed between the wheel wells..
2. Position the base rails in truck bed as shown in Illustration 1 (previous page). When hitch is 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" bolt (04215), 5/8" lock washer (00248) and 5/8" flat washer (00477) down through the hole after drilling and before drilling next hole. This will help to stop base rails from shifting during drilling.



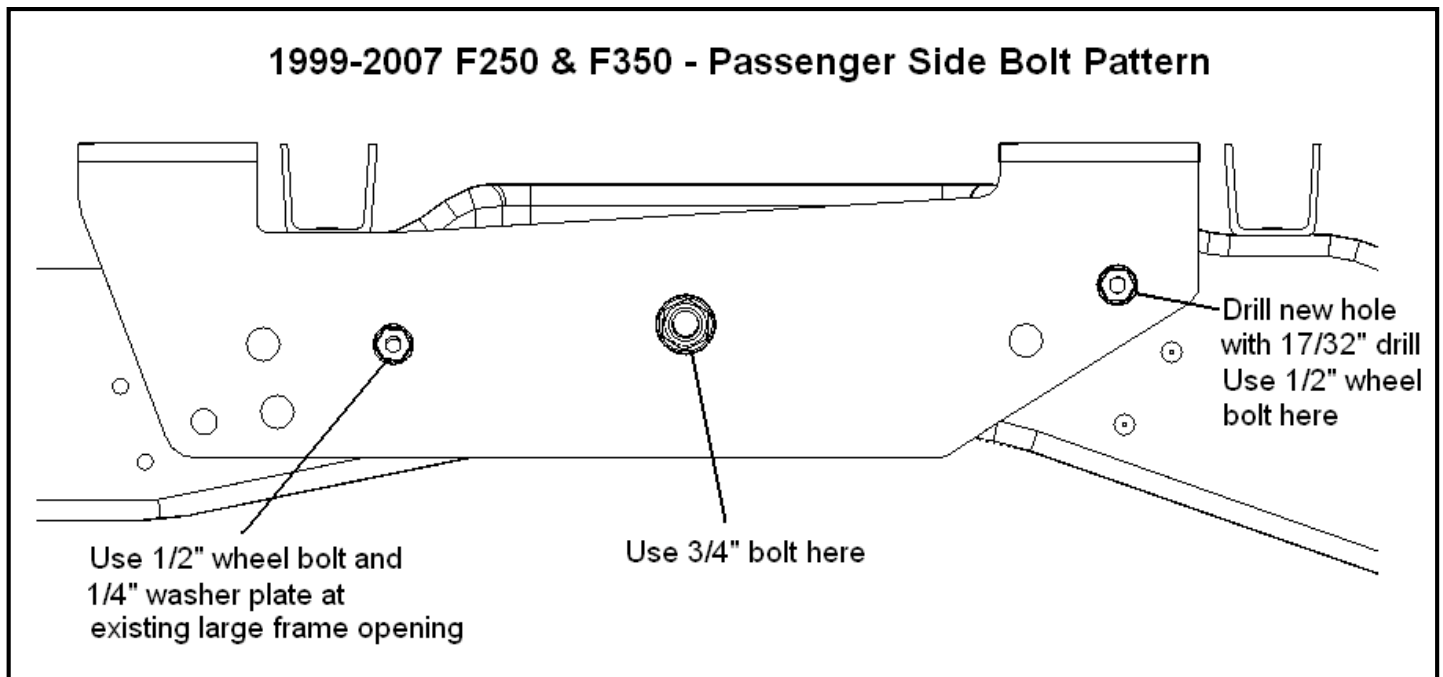
3. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a slotted spacer plate in this location as shown in Illustration 2. If the corrugation is DOWN at this location, place the slotted spacer plate in the bed, under the base rail as shown in Illustration 2a.
4. Position the left (14188-76) and right (14187-76) frame brackets up against the outer surface of the truck frame with the mounting tabs positioned away from the frame and under the bed 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 the 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. Depending on which year of truck the installation is for, use the illustrations on the following pages to determine which holes and bolts to use for fastening the frame brackets. Although this is stated to be a NO Drill application, some existing frame holes will require to be reamed out larger for mounting bolts. Also, one hole on the 2005-07 trucks will require a complete new hole to be drilled. **CAUTION:** Holes MUST be reamed or drilled with 17/32" diameter drill bit, so that the special knurl bolts will seat properly. If the holes are too small, the bolt may break. If the hole is too large, it will not grip properly.

2005 - 2010 Pickup Models

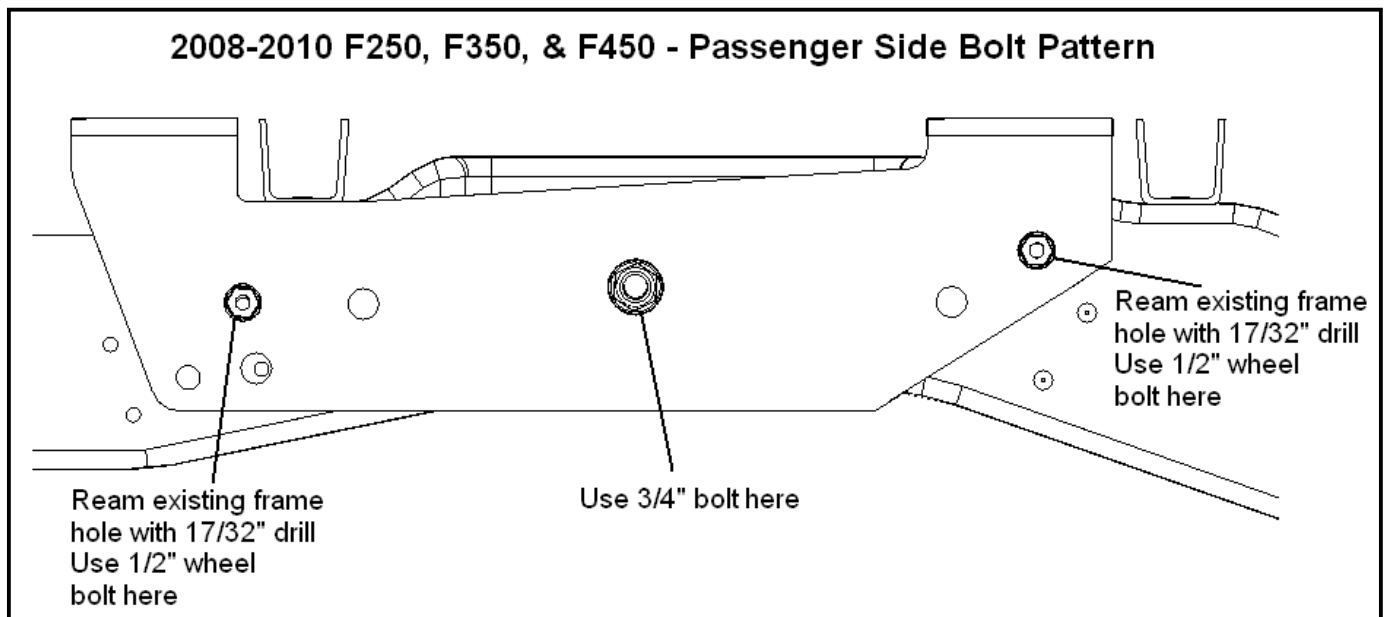
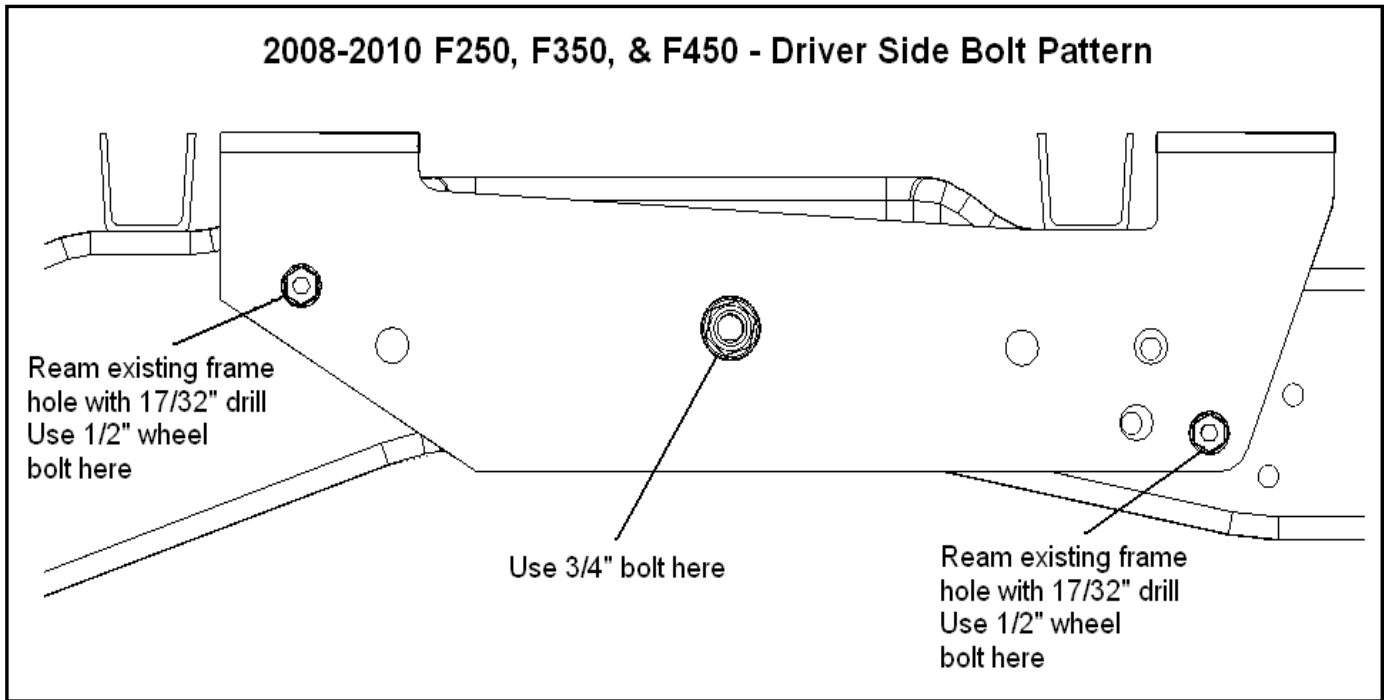
1999-2007 F250 & F350 - Driver Side Bolt Pattern



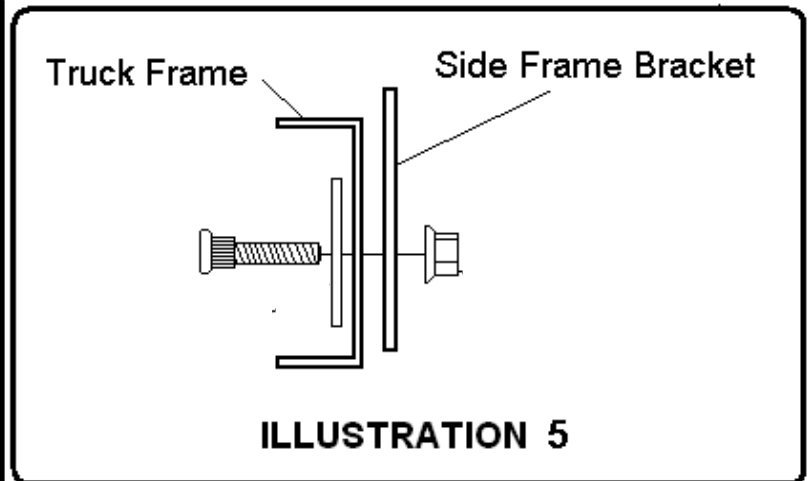
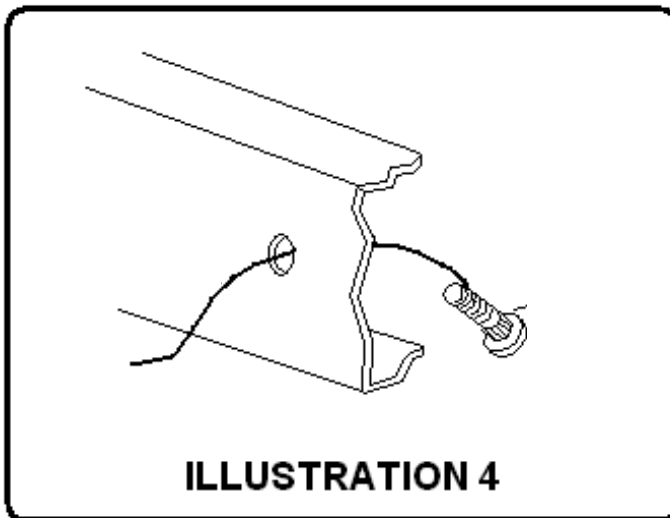
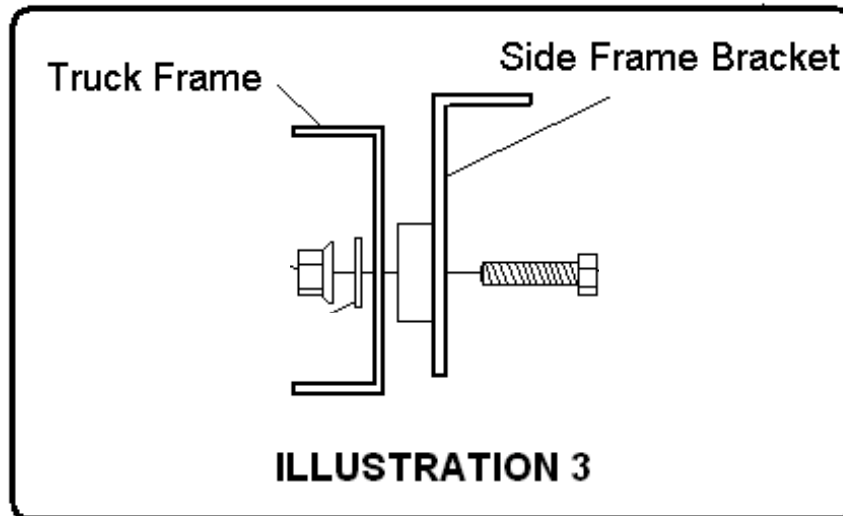
1999-2007 F250 & F350 - Passenger Side Bolt Pattern



2008 - 2010 Pickup Models



8. Before drilling any holes in the frame, check the inside of the frame to be sure that there are no wires, brake lines or other obstructions in the frame that may contact the drill. Each of the frame brackets must be attached to the side frame of the truck with a special 1/2" knurled bolt at the forward and rear holes and a 3/4" bolt in the middle hole. See Illustration 3 on next page.



9. Place the knurl bolts into the frame through the drilled hole at the front and rear holes of the frame brackets. Thread the fish wire (14238) over the end of the knurl bolt and pull through the frame and frame bracket. See Illustration 4. For 2005-2007 trucks where the bolt is being fastened at an existing large frame hole, place a 3/16" thick washer plate (14293-76) over the knurl bolt before placing through frame and brackets holes. See Illustration 5. Secure each bracket to the truck frame. The knurled portion of the bolts will lock into the frame holes as the nuts are tightened. Use of an air wrench will make installation easier. **NOTE:** The fish wire does not have to be used if there is easy access to place the bolts through frame and bracket by hand.
10. Tighten all bolts according to chart on front page. Failure to tighten bolts as described may result in fastener loss or failure.