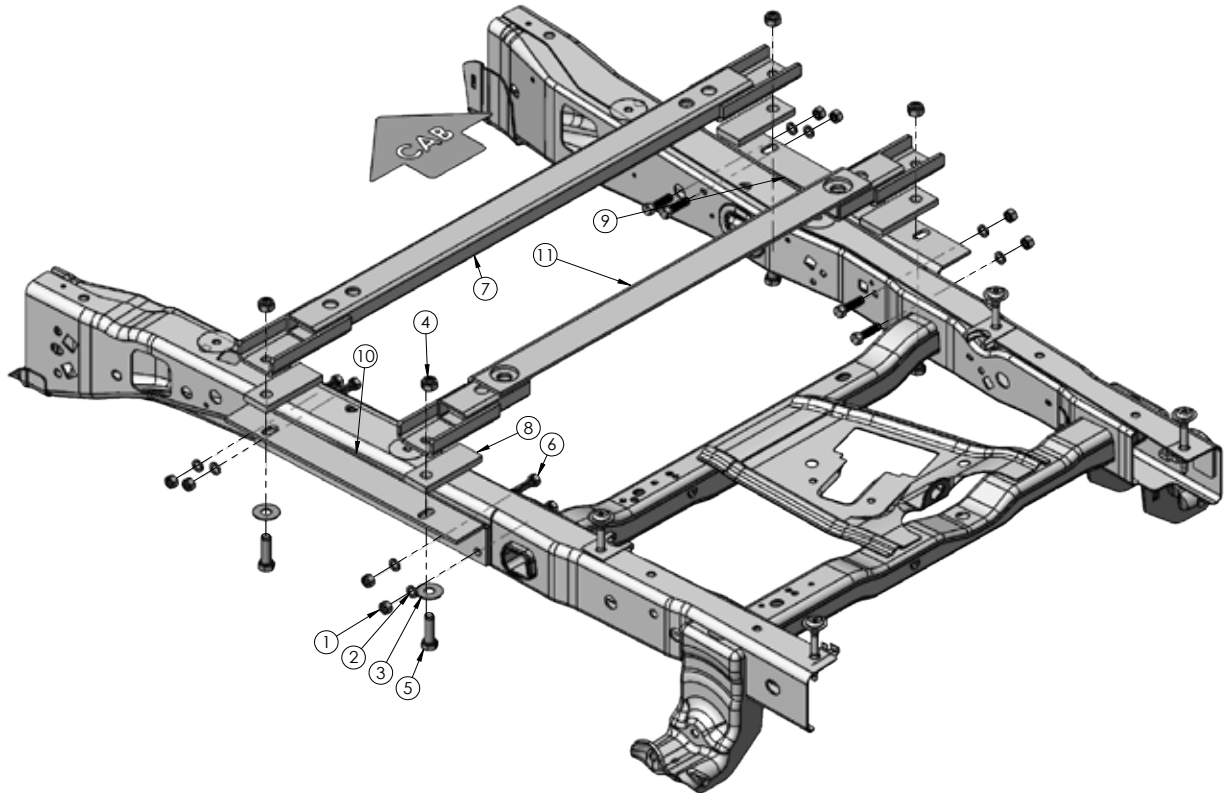


FRAME BRACKET 8551001

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



ITEM	PART #	QTY	DESCRIPTION
1	00083	8	NUT, .50 HEX
2	00084	8	WASHER, .50 LOCK
3	00477	4	WASHER, .625 FLAT
4	02587	4	NUT, .625 HEX LOCK
5	00290	4	BOLT, .625NC X 2 HEX GR.5
6	14266	8	BOLT, .50NC X 1.75 HEX KNURLED GR.5
7	14267-76	1	UMS BASE RAIL
8	14292-76	4	SHIM
9	14379-76	1	FRAME BRACKET PASSENGER SIDE
10	14380-76	1	FRAME BRACKET DRIVER SIDE
11	14382-76	1	UMS REAR BASE RAIL
12	14238	1	.50 FISH WIRE (NOT SHOWN)
13	14335	4	CAP PLUG (NOT SHOWN)

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

Installation

8551009 General Assembly & Install Instructions

WARRANTY POLICY, OPERATOR MANUALS & REGISTRATION

Go online to www.demco-products.com to review Demco warranty policies, operator manuals and register your Demco product.

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.			

Please consult vehicle owner's manual for 5th wheel towing instructions.

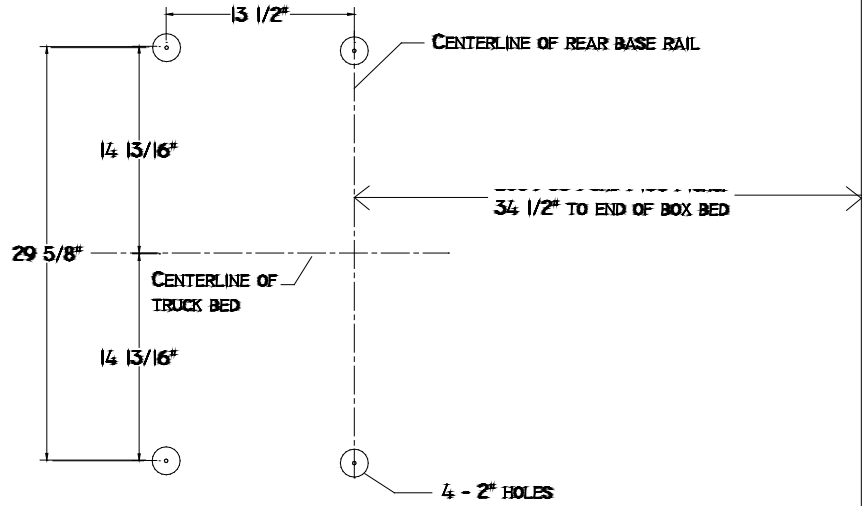
Hitch Assembly:

1. Place the base rails on a flat level surface. Insert and lock the side rail plates into the base rail holes as shown in the supplied hitch instructions.
2. Loosely bolt the saddle bracket and the two cross brackets to the side rails using the fasteners provided with the hitch.
3. Tighten all bolts according to the bolt torque specification chart.
4. Unlock and remove the hitch assembly from the base rails and put to the side for later.

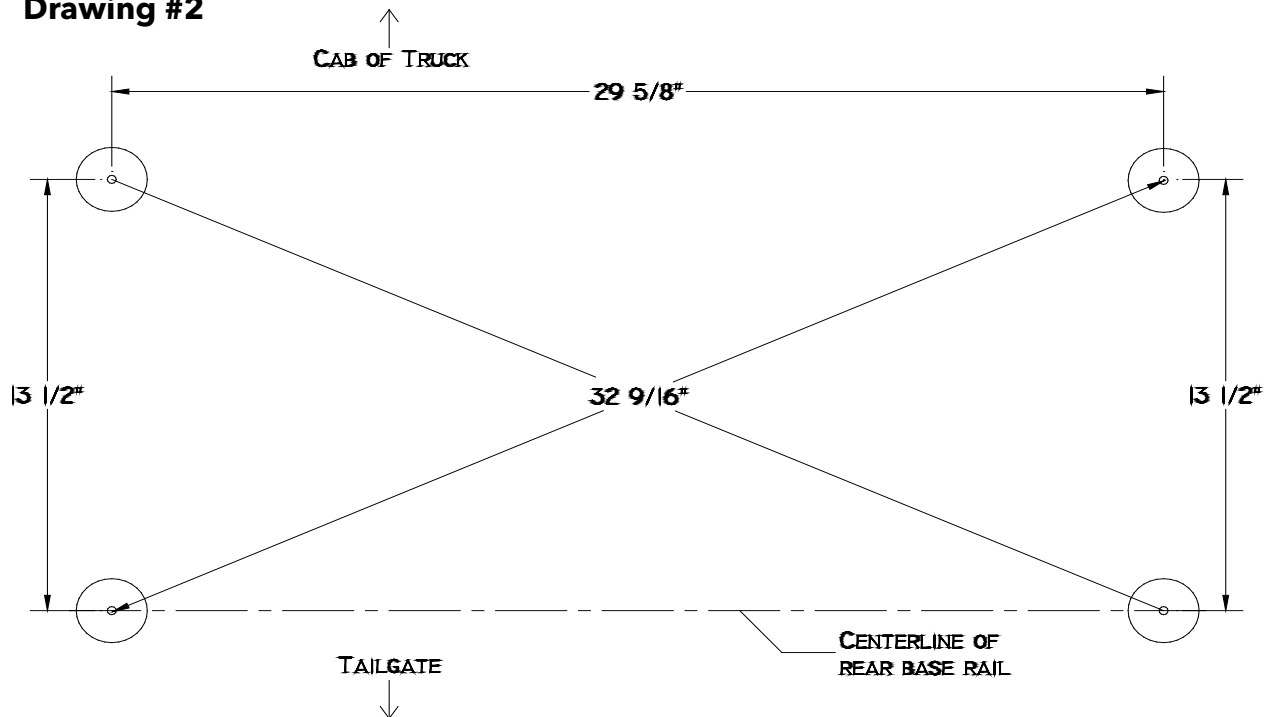
Truck Bed Drilling Instructions:

1. Use the measurements shown on the drill hole measurement chart to mark out the four holes that will be drilled through the truck bed.
2. Start out by measuring the distance stated for the particular **BOX LENGTH** of truck you are doing the installation on (refer to page 3) from the end of the bottom of the truck bed (tailgate end) to a point on the left side of center of the bed and mark it. Do the same on the right side of center of the bed and mark it. Draw a line across the bed using these two marks as a reference.
3. Measure out and find the center of the truck bed and draw a line from the front to the rear of the bed.
4. Measure out 14 13/16" to either side of the middle center line slightly ahead of the fender well and slightly behind the fender well.
5. Draw a line between these two points. Do the same on the other side.
6. Measure out (towards the cab) 13 1/2" from the points where the line that goes across the bed intersects with the two lines that are 14 13/16" off the center running the length of the bed. Mark these two points.
7. There should now be four spots marked out for drilling. Double check that the rear to hole marks are exactly the distance stated for the box length of truck you are doing the installation on (refer to box length on chart) from end of the bed and that the front holes marks are exactly 13 1/2" forward of those marks.
8. Check the hole marks from side to side and make sure they are exactly 29 5/8" apart from each other.
9. Finally, check for square by measuring diagonally from opposite corners **Drawing #1**. The measurement should be the same both ways. It should measure 32 9/16".
10. After all the hole marks have been double checked for proper placement, use a center punch and hammer to mark out the spots for drilling.
11. Drill the holes using a 2" hole saw. Deburr the holes using a small file and apply some touch up paint to match color (not supplied).

Drawing #1



Drawing #2

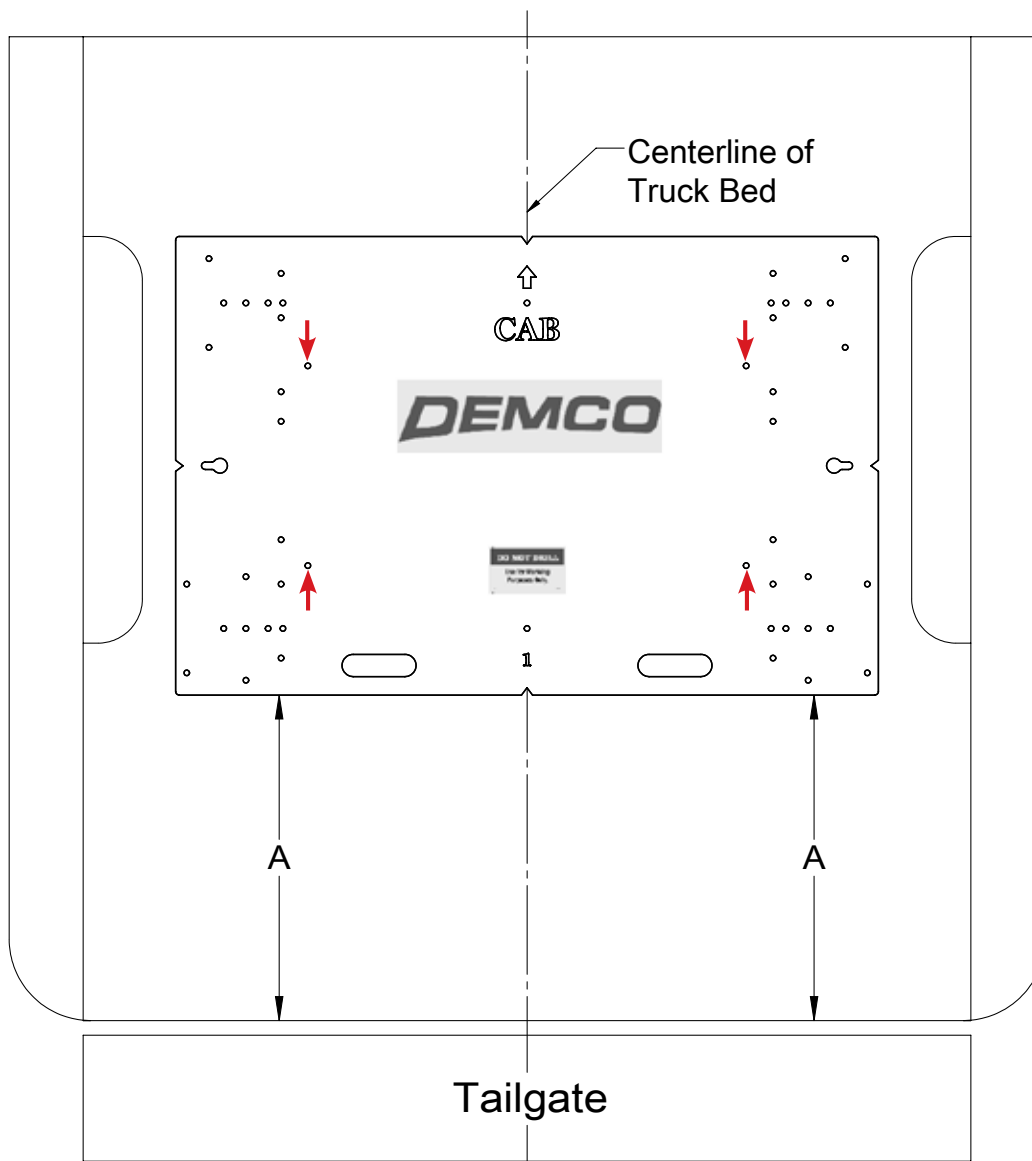


Installation

Truck Bed Drilling Instructions with Template

1. Place the template in the box and center the template between the wheel wells.
2. **IF NEEDED, TAPE THE TEMPLATE DOWN.**
3. Measure from the back of the box to the template on the passengers side and drivers side to insure that the template is square. See drawing #2 and table on page 5 for measurements.
4. Locate which holes you will be drilling, by the ones marked with a red arrow.
5. Take a 3/8" locating punch and mark the holes to be drilled.
6. **BEFORE YOU DRILL, MAKE SURE THAT THE TEMPLATE DID NOT MOVE, AND THAT THERE ARE NO OBSTRUCTIONS IN THE WAY.**
7. Remove the template and drill the four marked holes with a 2" hole saw.
8. Deburr each hole.
9. Touch up the bare metal with some paint that matches the box of the truck.

Truck Bed Drilling Instructions with Template



Drawing #2

BOX LENGTH	DIMENSIONS	MEASUREMENT
5-1/2'	A	*25-3/4"
6-1/2'	A	*25-3/4"
8'	A	*25-3/4"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

Base Rail Installation

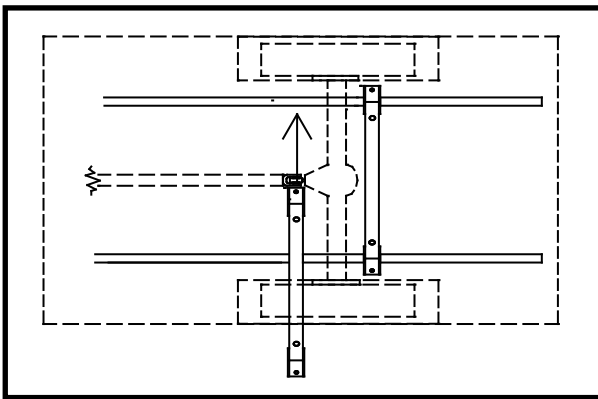
IF the base rails are unable to be slid into position because of insufficient space by the lip of the box bed, then use one of the following two methods to install the base rails.

1. A) Remove the mounting bolts that attach the box to the truck frame on one side only. Raise and block the box high enough so the base rails can be inserted (with locking pin holes up) and span across and rest on top of each side of the frame (Drawing #3 below). Lower and bolt the box back to the frame. Position base rails under holes drilled in bed.

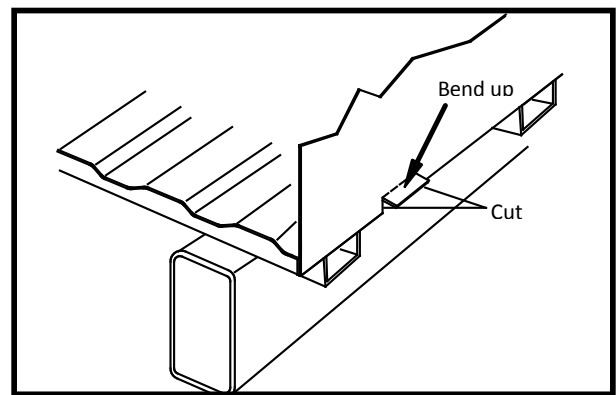
OR

- B) Locate a spot on both sides of the box support cross members on either side of the truck and cut and bend up a 3 1/2" wide section of the sheet metal lip where the bed and the fender well of the box join (Drawing #4 below). Insert base rails (with locking pin holes up) and span across and rest on top of each side of the frame (Drawing #3 below). Bend the sheet metal back down and position rails under holes drilled in bed.

IMPORTANT: Ensure that the shorter base rail with the angled crossbar is in the position closest to the tailgate with the vertical side of the angle beside the box cross member (drawing #5). Angle allows clearance for motor/pump assembly.

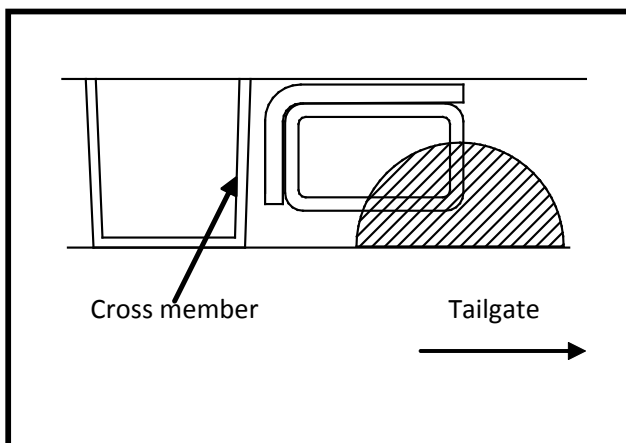


Drawing #3

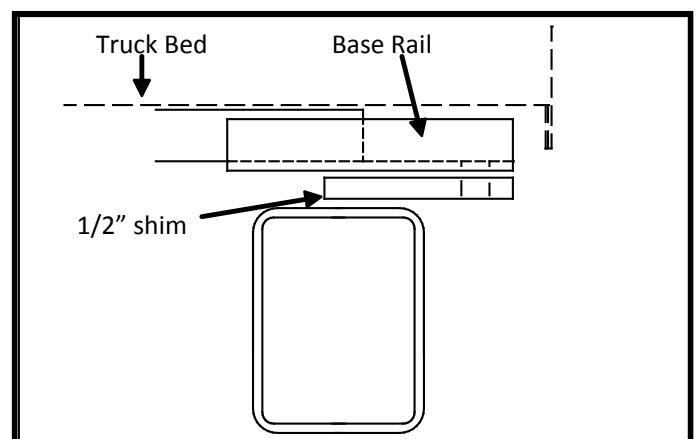


Drawing #4

2. With base rails in position below the bed and the base rail holes centered under the holes that were drilled in the bed of the truck, position one of the 1/2" thick shims under each end of the base rails between them and the top of the frame. Re-install and lock the hitch assembly into the base rails from the topside of the box.

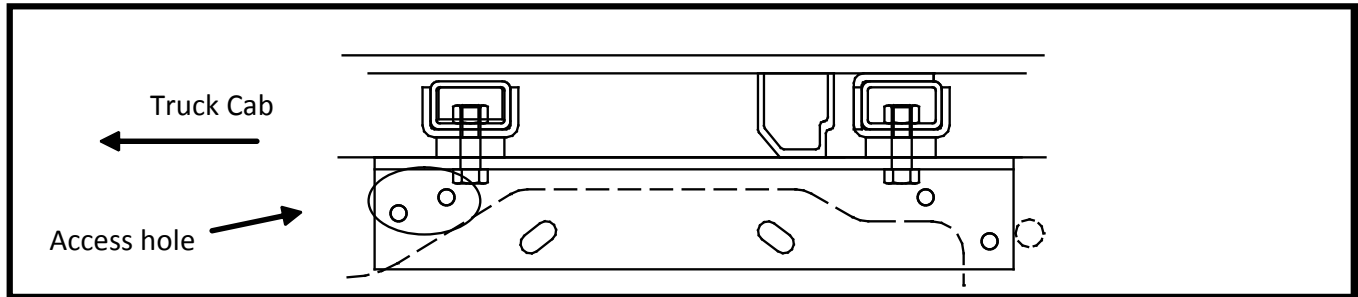


Drawing #5



Drawing #6

3. Measure and center the entire hitch assembly side to side and front to back so that it is as close to center of the holes in the bed.
4. Attach the frame brackets to the base rails with the end of the frame bracket that has the pair of holes that are closed to each other, towards the cab of the truck (Drawing #7). Fasten with the 5/8" x 2" bolts and secure with a 5/8" flat washer and 5/8" lock nut

**Drawing #7**

5. Tighten the bolts to the base rails ensuring that the frame bracket is up against the truck frame.
6. Using the holes in the frame bracket plates as a guide, drill the frame in the four mounting holes on each frame bracket with a 1/2" or 33/64" drill bit. You may want to drill smaller pilot holes to make drilling easier. It is best to insert a 1/2" x 1 3/4" knurl bolt (#14266) into the drilled hole using the fish wire provided, through the access hole. Secure on the outside of the frame bracket with a flange nut. Do this after the first hole is drilled to ensure there is no shifting of the hitch while drilling the next hole(s).
7. Tighten all bolts.
8. Re-install the rear wheels (if removed), double check all fasteners for tightness, and lower truck (if raised).
9. Unlock and lift the hitch assembly out of the box to make sure it can be removed and inserted with relative ease. If there was any shifting during installation that caused any binding, simply loosen the 4 bolts that attach the base rail to the frame brackets and realign the base rail and retighten.
10. Ensure the side rail locking pins are turned and secured in the locked position with the safety pins. Install the hitch head to the saddle bracket.

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**Demco warranty policies, operator manuals, and product registration
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