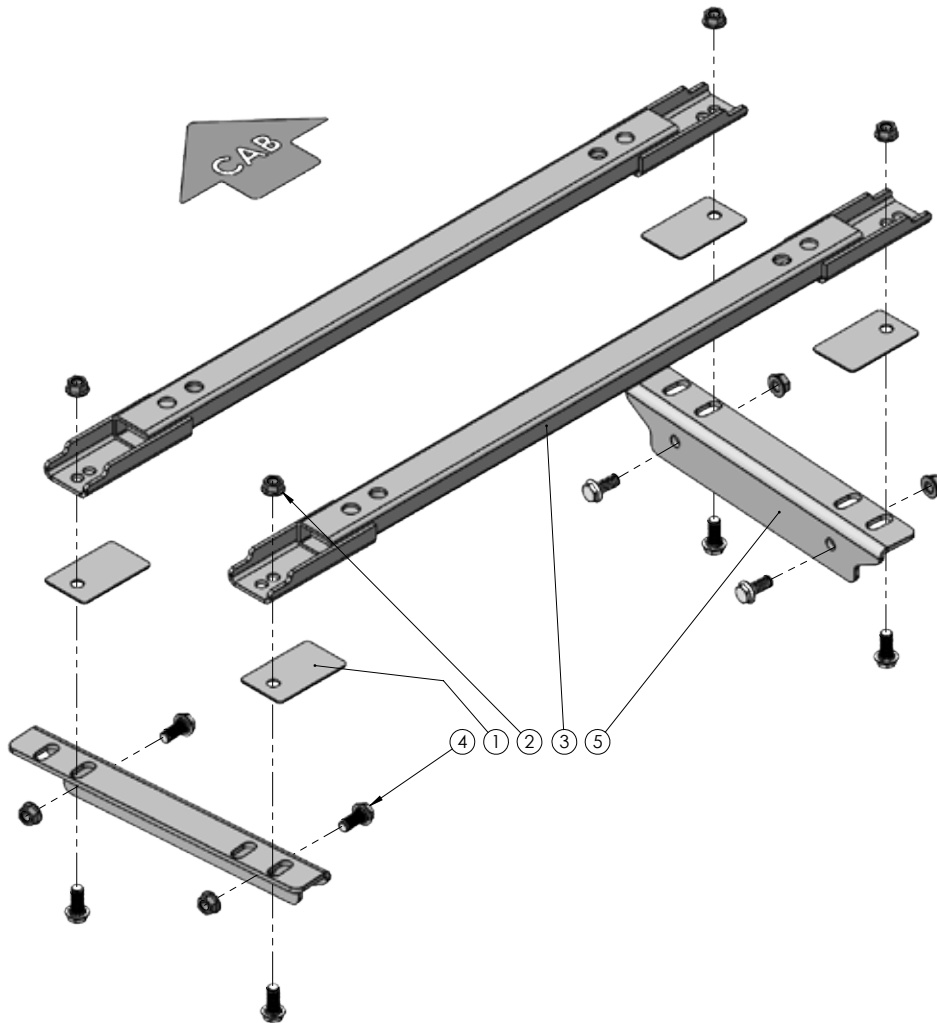


## FRAME BRACKET 8551012

Chevy/GMC 2500 HD & 3500 HD 6-1/2' & 8' Box



ITEM	PART #	QTY	DESCRIPTION
1	<b>14274-76</b>	4	UM BASE RAIL SHIM, .13 THK
2	<b>14340</b>	8	NUT .625 NC SERRATED FLG. HEX
3	<b>15783-76</b>	2	UMS BASE RAIL, 2 HOLE MNT
4	<b>16690</b>	8	BOLT, .625NC X 1.50 SERR FLG HEX HD
5	<b>16856-76</b>	2	FRAME BRACKET
-	<b>14335</b>	4	CAPLUG 2.25 ROUND (NOT SHOWN)
-	<b>14210</b>	1	5/8" FISH WIRE (NOT SHOWN)
-	<b>12329</b>	2	LOCTITE (NOT SHOWN)

Please order replacement parts by PART NO. and DESCRIPTION.

## INTRODUCTION

### 8551012 GENERAL ASSEMBLY & INSTALLATION INSTRUCTIONS

#### WARRANTY POLICY, OPERATOR MANUALS & REGISTRATION

Go online to [www.demco-products.com](http://www.demco-products.com) to review Demco warranty policies, operator manuals and register your Demco product.

## READ THROUGH THE ENTIRE MANUAL BEFORE BEGINNING INSTALLATION!

**NOTE:** If you **DO NOT** have a Demco Frame Bracket Installation Template use Drawing #1 and Table #1 to find your pick-ups box length and measurements. If you **DO** have a Template use Drawing #2 and Table #2.

**IF EQUIPPED WITH A HEAT SHIELD, FIND HEAT SHIELD INSTRUCTIONS IN MANUAL BEFORE DRILLING ANY HOLES. IF THERE ARE NO INSTRUCTIONS ON THE HEAT SHIELD, PROCEED WITH THE INSTALLATION.**

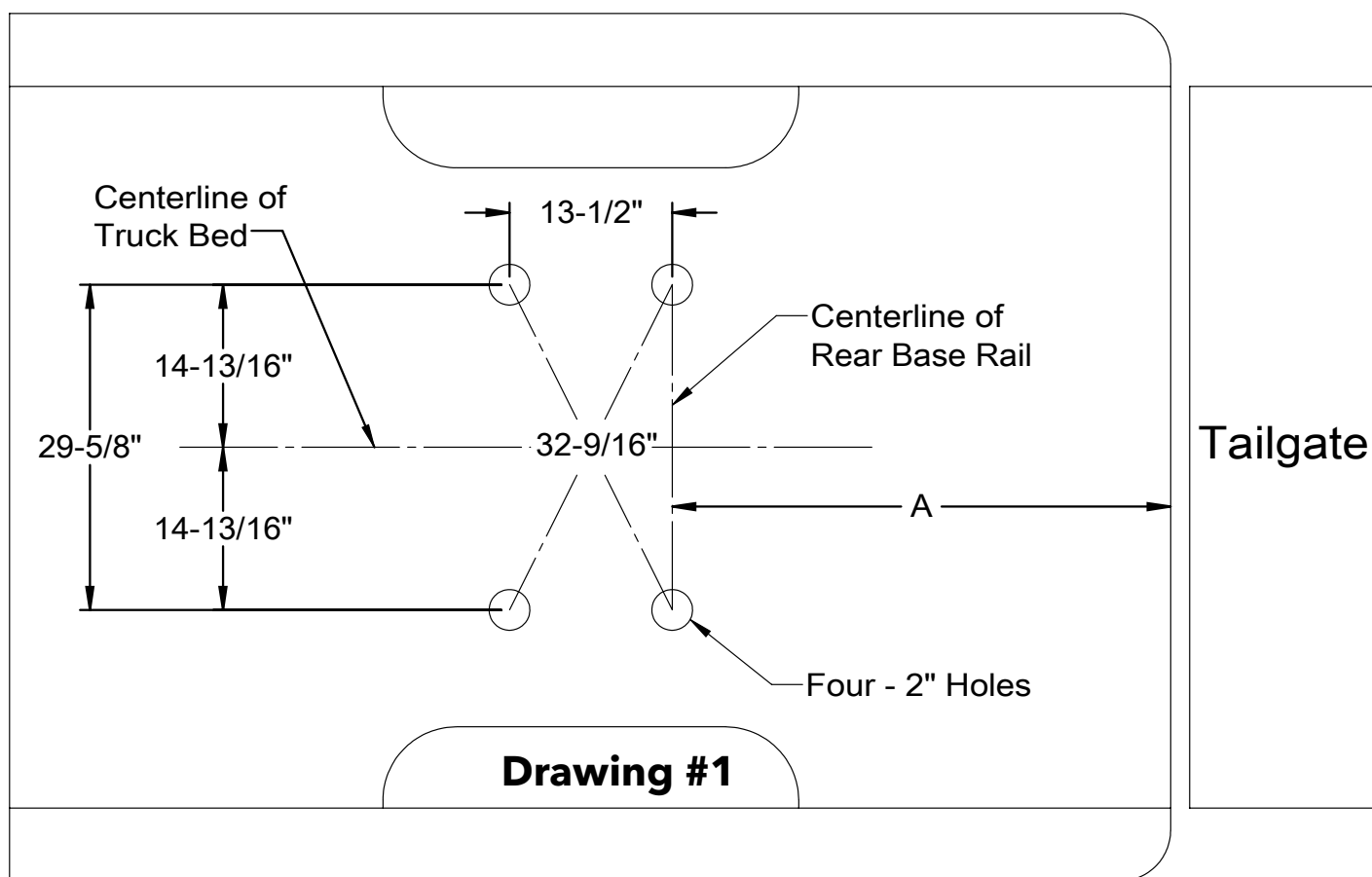
**HIGH IMPORTANCE! BEFORE ANY DRILLING IS DONE. MAKE SURE, THERE ARE NO OBSTRUCTIONS UNDER THE BOX!**

#### Truck Bed Drilling Instructions Without Template:

1. Start by measuring the distance stated in **TABLE #1** for the particular **BOX LENGTH** of the truck. Measure from the end of bed (tailgate) 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.
2. Measure and find the center of the truck bed and draw a line from the front to the rear of the bed.
3. Measure 14 13/16" to either side of the middle center line slightly ahead of the fender well and slightly behind the fender well.
4. Draw a line between these two points. Do the same on the other side.
5. 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.
6. 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.
7. Check the hole marks from side to side and make sure they are exactly 29 5/8" apart from each other.
8. 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".
9. 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.
10. 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).

**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.			



**Table #1**

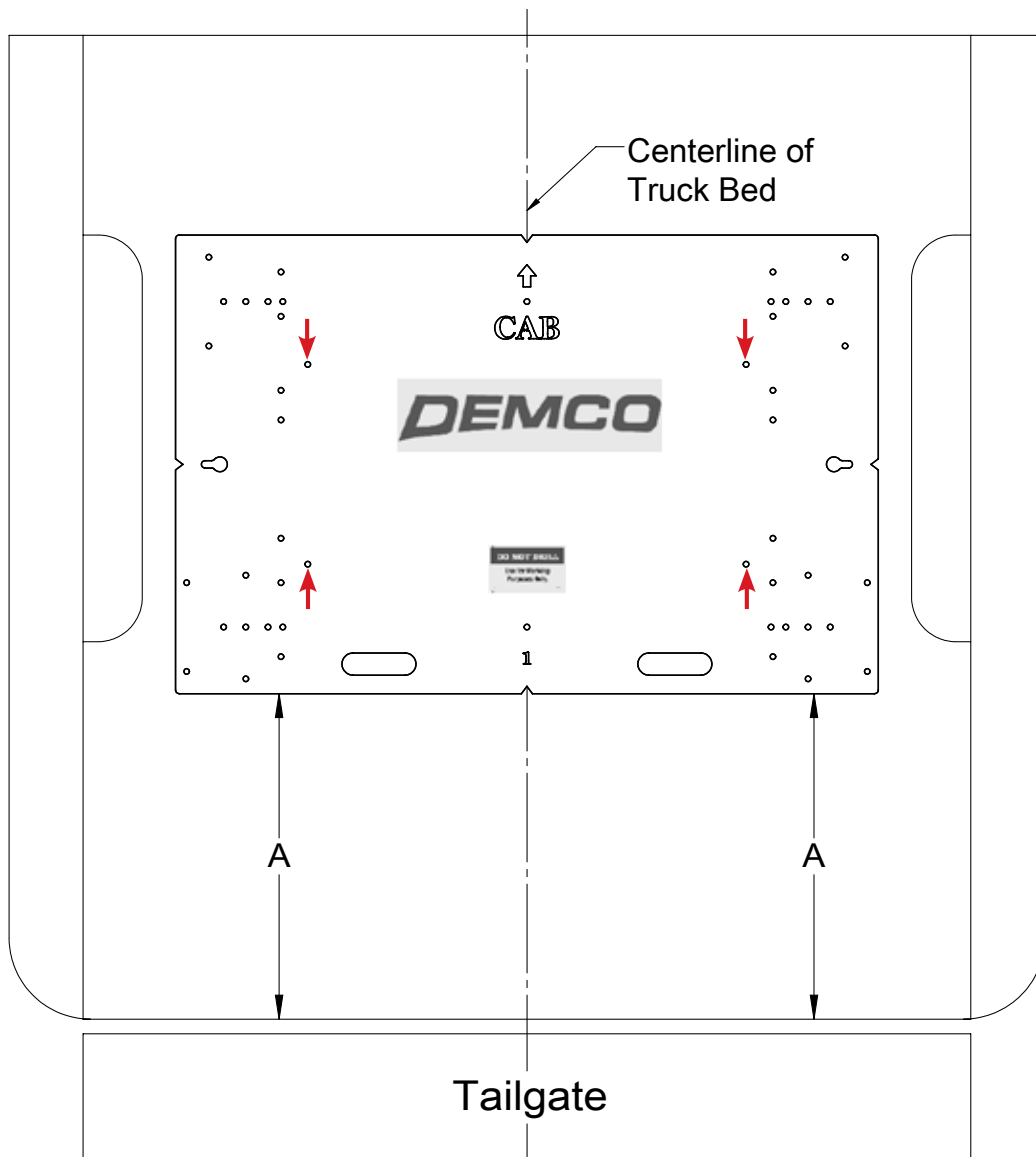
BOX LENGTH	DIMENSIONS	MEASUREMENT
6-1/2'	A	*34-7/8"
8'	A	*38"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

# Installation

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## 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 #2 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.



**Drawing #2**

BOX LENGTH	DIMENSIONS	MEASUREMENT
6-1/2'	A	*26-1/8"
8'	A	*29-1/4"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

# Installation

## Frame Bracket Installation

1. Fully assemble the 5th wheel hitch on a flat, level surface.

**NOTE:** Assembly instructions come with hitch components.

2. Remove the rear tires.
3. If equipped, remove the rear wheel well liners.
4. Slide base rails in position below the bed so that they are resting on top of the frame. Center the base rail holes under the 2" holes that were drilled in the bed of the truck.
5. Place assembled hitch in the bed of the truck, center the locking pins in the 2" holes.
6. Lock the hitch into the base rails. Make sure the holes in the base rail and the locking pins are centered in the 2" holes.

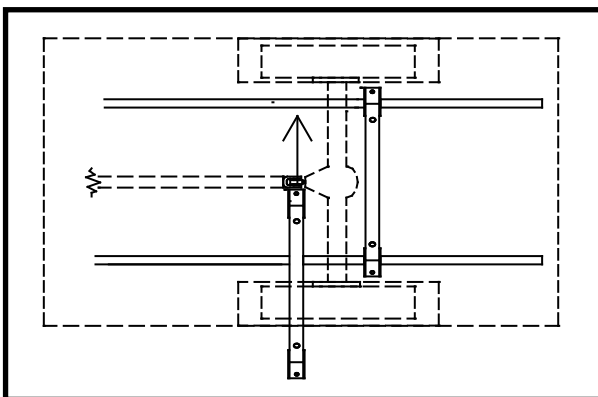


7. Remove bolt from the front side of the heat shield as shown and cut off tab that the bolt was holding down.

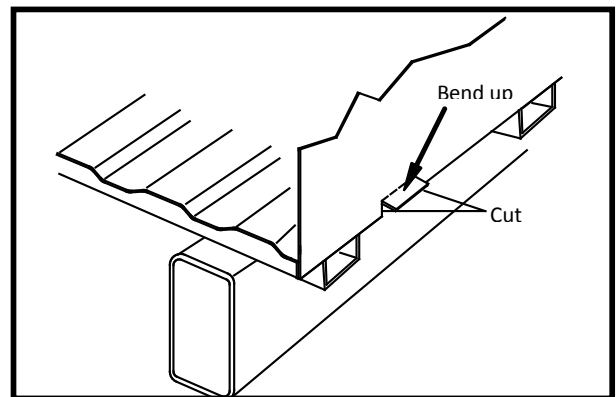
## Base Rail Installation:

**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.**

- 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). Lower and bolt the box back to the frame. Position base rails under holes drilled in bed.
- 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). Insert base rails (with locking pin holes up) and span across and rest on top of each side of the frame (drawing #3). Bend the sheet metal back down and position rails under holes drilled in bed.

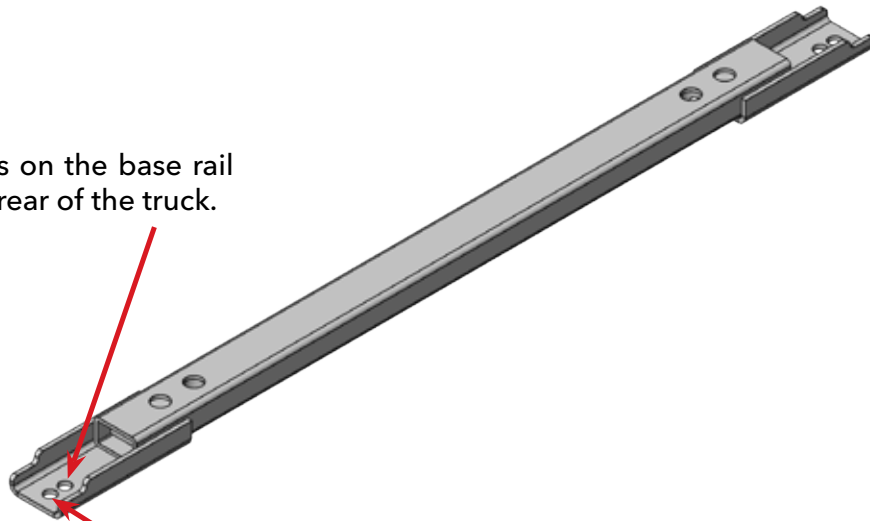


**Drawing #3**



**Drawing #4**

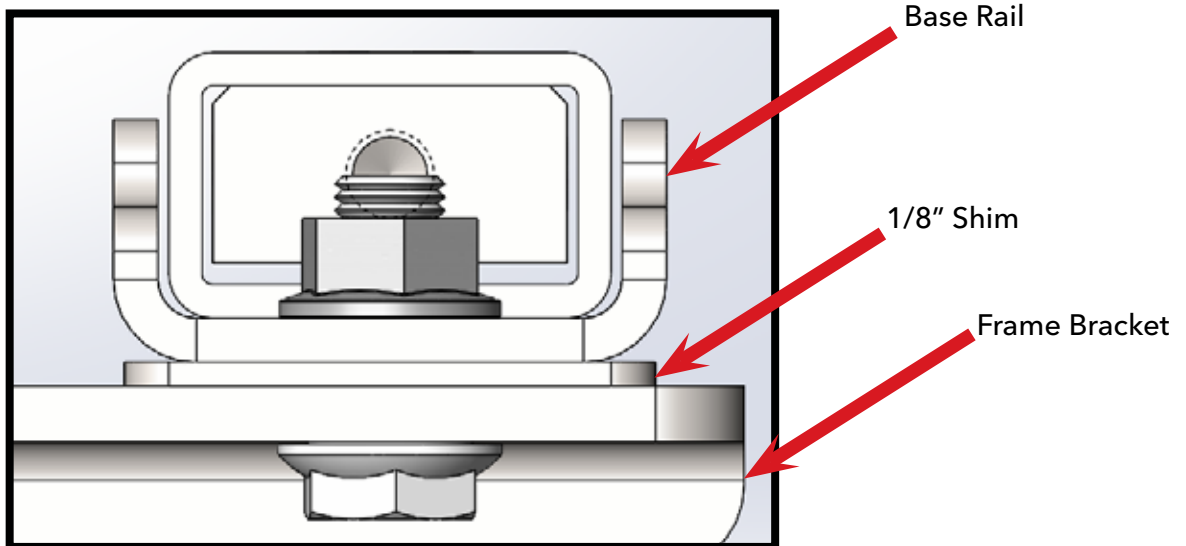
Use these holes on the base rail  
closest to the rear of the truck.



Use these holes on the base rail  
closest to the front of the truck.

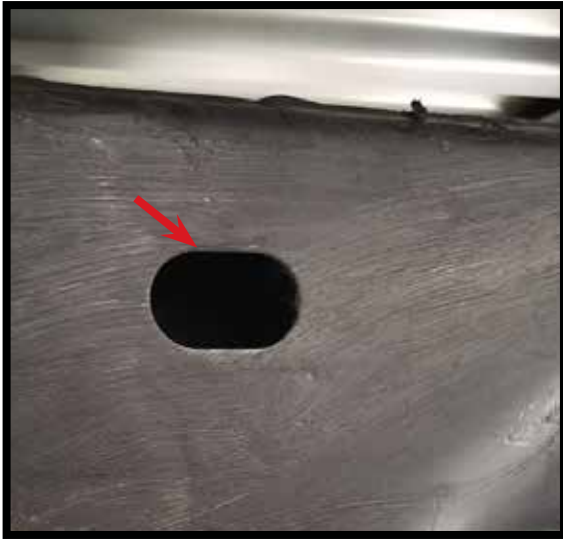
8. As shown in the picture below. Install the 1/8" shims and attach the frame brackets to the base rails and Install a 5/8" x 1.50" serrated head bolt up through the bottom end of frame bracket through the base rail and loosely tighten the 5/8" serrated nut.

**NOTE:** Use the picture above on which hole to choose.



9. Slide the frame brackets up tight to the bottom of the base rail. Clamp the frame brackets to the sides of the frame.
10. Using the holes in the frame brackets as a guide, drill the holes in the frame with a 11/16" drill bit.

**NOTE:** A pilot hole maybe needed.



**Outside of frame:** One of the access holes is on the outside of frame. This access hole might have to be trimmed larger to fit the head of the bolt through.



**Inside of frame:** The other access holes are on the inside of frame. These holes are located right behind the bracket. No trimming is need, but you may have to move some steel lines out of the way to fish the bolts through.

11. Using the 5/8" fish wire, fish the 5/8" serrated head bolts through one of the access holes in the frame. See pictures above.
- 12 Tighten all 5/8" serrated nuts. LOCTITE and torque all the nuts to the chart located on the top of page 3.
13. Re-install the rear wheels and rear wheel well liners (if removed), double check all fasteners for tightness..
14. Unlock and lift the hitch assembly out of the box to make sure it can be removed and inserted with relative ease.

# DEMCO

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**Demco warranty policies, operator manuals, and product registration  
can be found online:**

**[www.demco-products.com](http://www.demco-products.com)**

