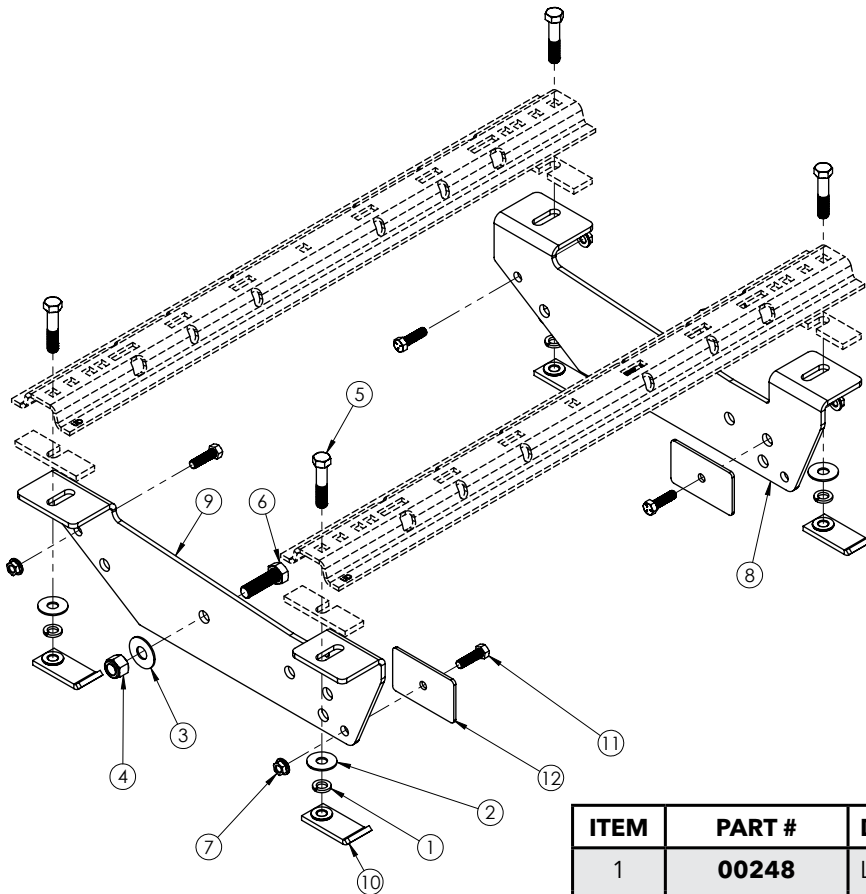


## FRAME BRACKET 8552002

Ford F250, F350 & F450



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

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

# Installation

## 8552002 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.

#### BOLT TORQUE SPECIFICATIONS

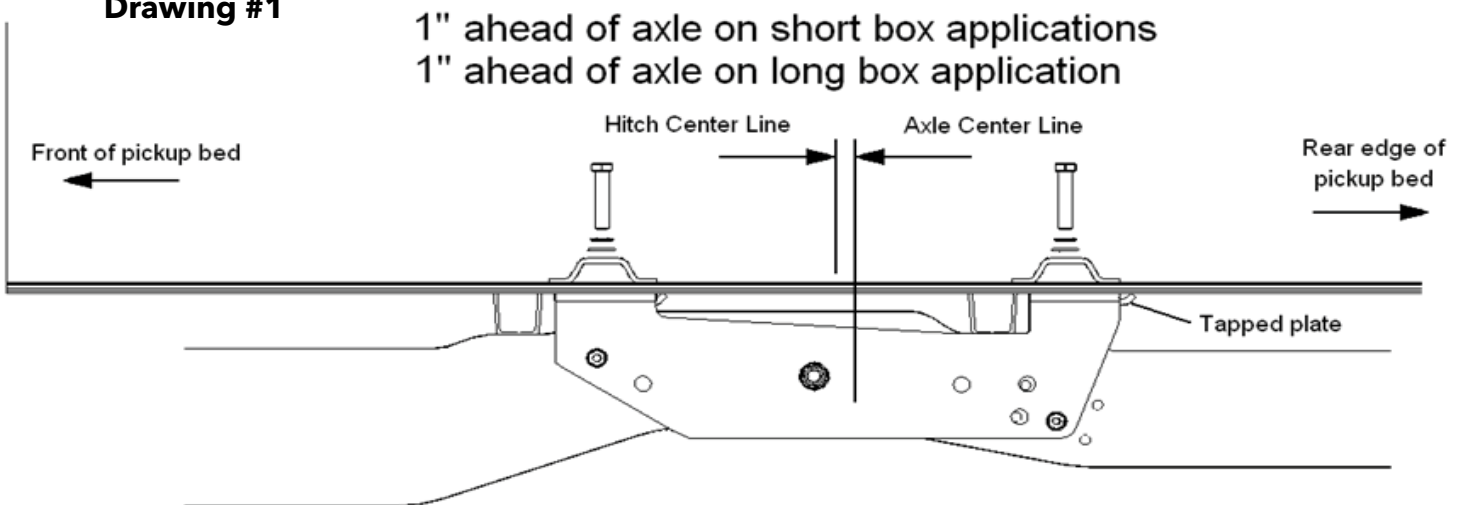
| STANDARD BOLTS |       |             | METRIC BOLTS |       |             |
|----------------|-------|-------------|--------------|-------|-------------|
| Size           | Grade | Torque      | Size         | Grade | Torque      |
| 5/16"          | 5     | 18 ft/lbs.  | 8mm          | 8.8   | 23 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. |              |       |             |

**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.

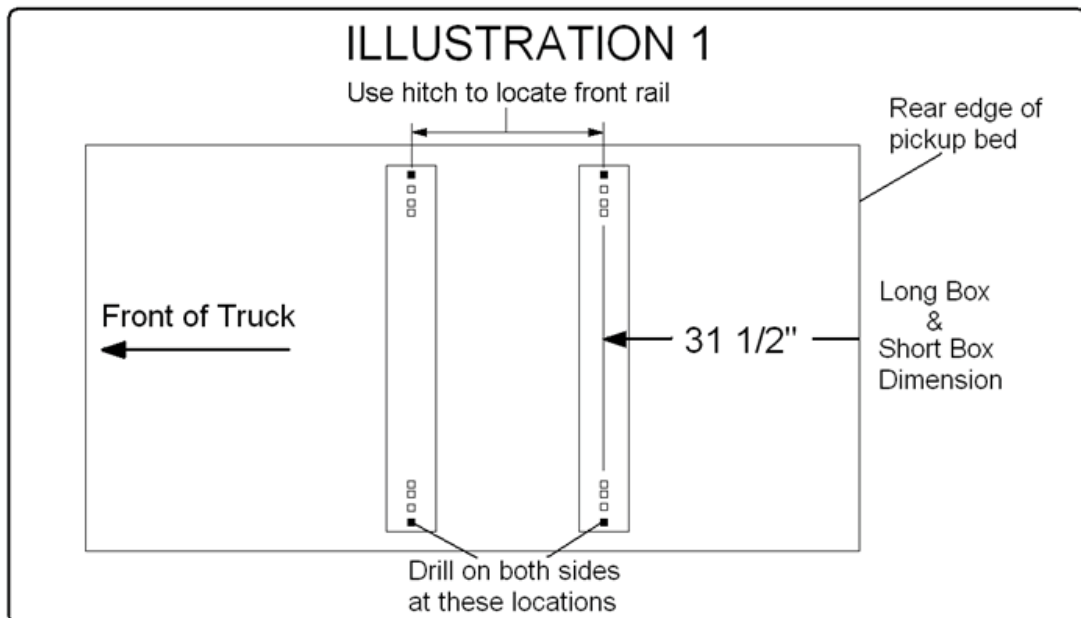
**NOTE:** All metal surfaces that come in contact with the aluminum body need to have vinyl placed in between to prevent corrosion.

**NOTE:** Consult spray liner installer for recommended curing time.

Drawing #1

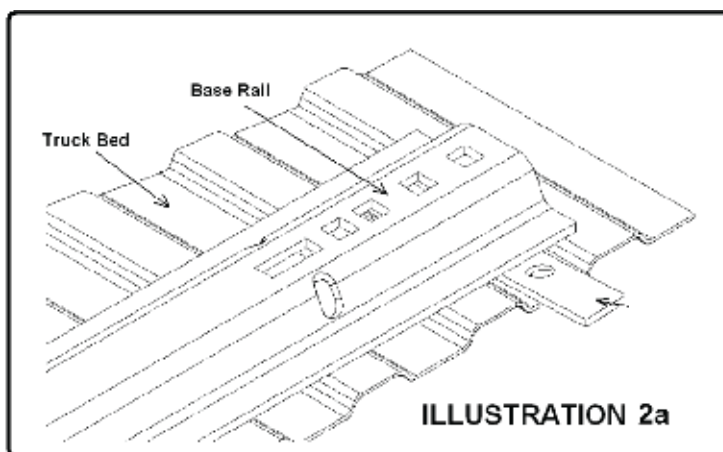
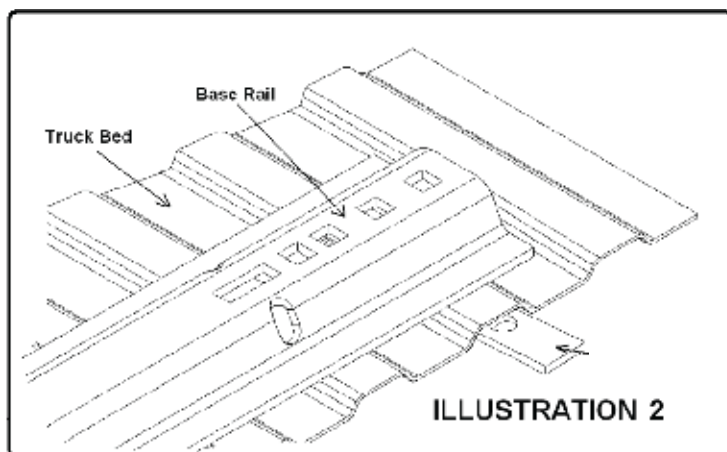


#### ILLUSTRATION 1



## FORD: 2005-2010 F250 & F350 "SUPER DUTY" (6-1/2' & 8' BOXES) 2008-2010 F450 "SUPER DUTY" (6-1/2' & 8' BOXES)

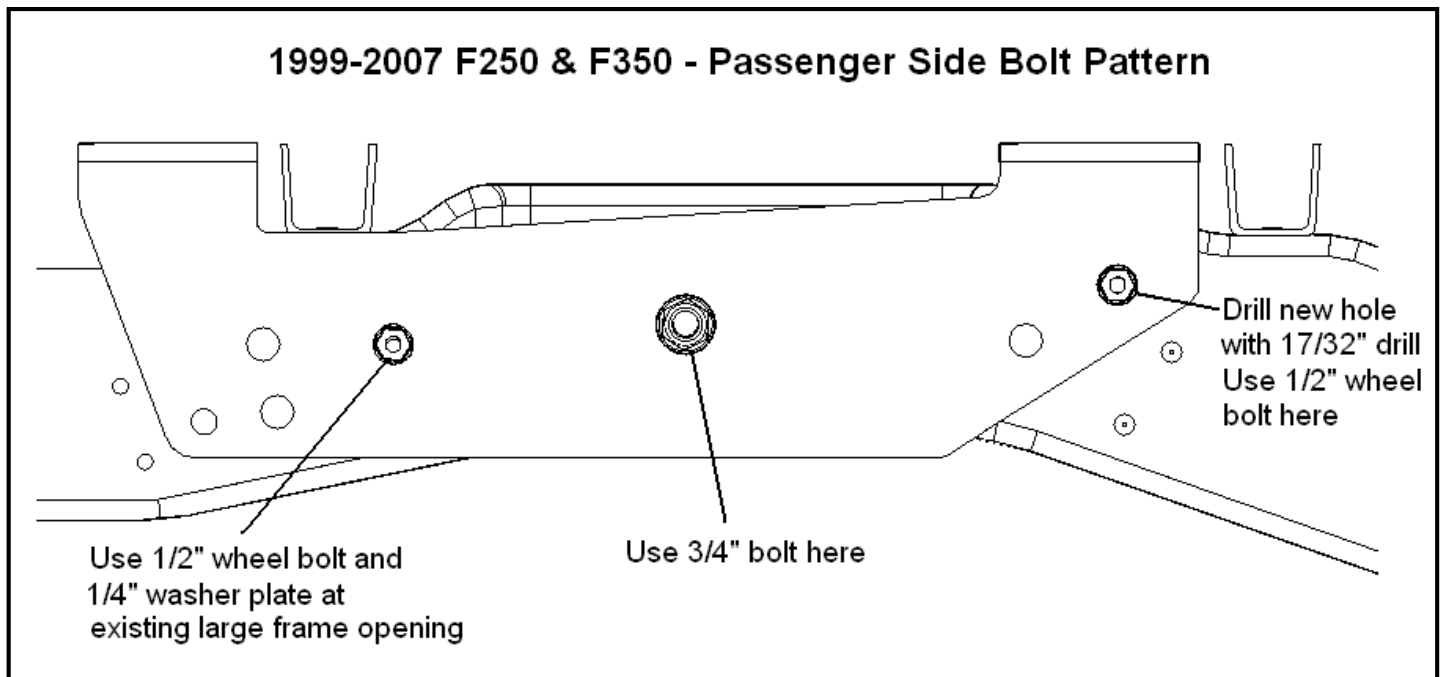
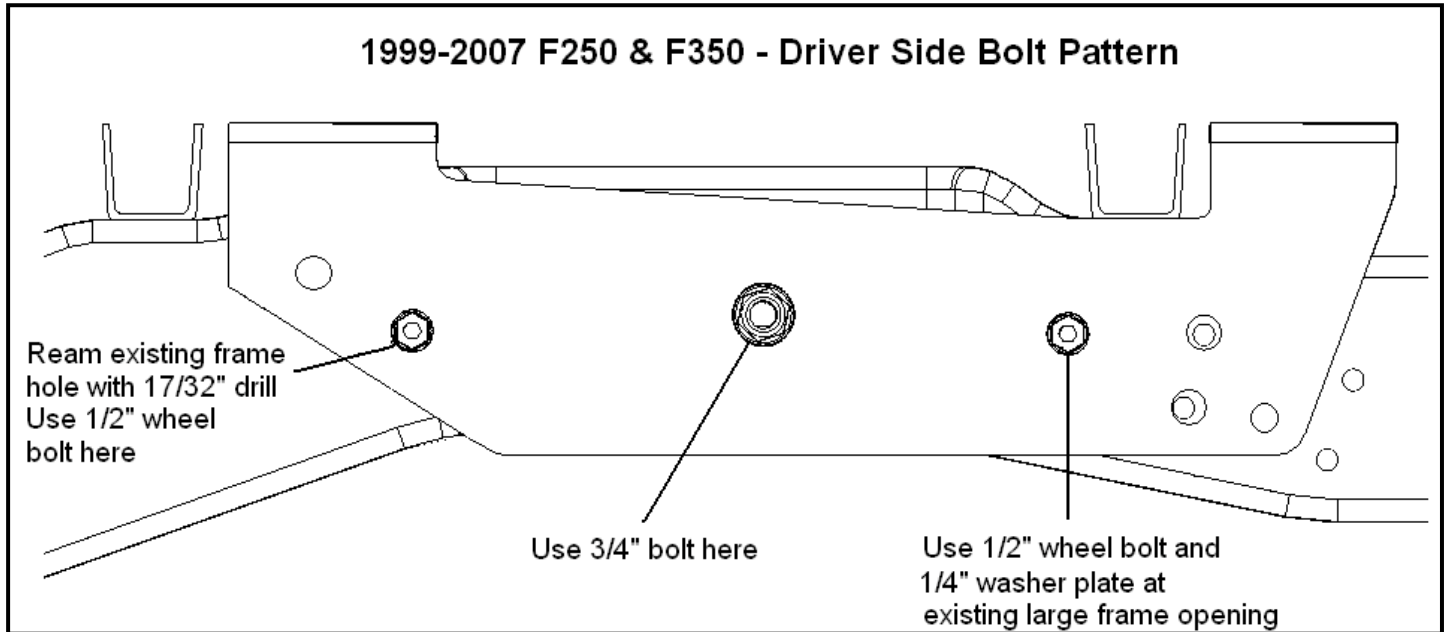
1. Fully assemble the 5th wheel hitch on a flat, level surface and pin into the base rails (assembly instructions come with hitch components). Place assembled hitch in truck bed between the wheel wells..
2. Position the base rails in truck bed as shown in **Illustration 1** (previous page). When hitch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

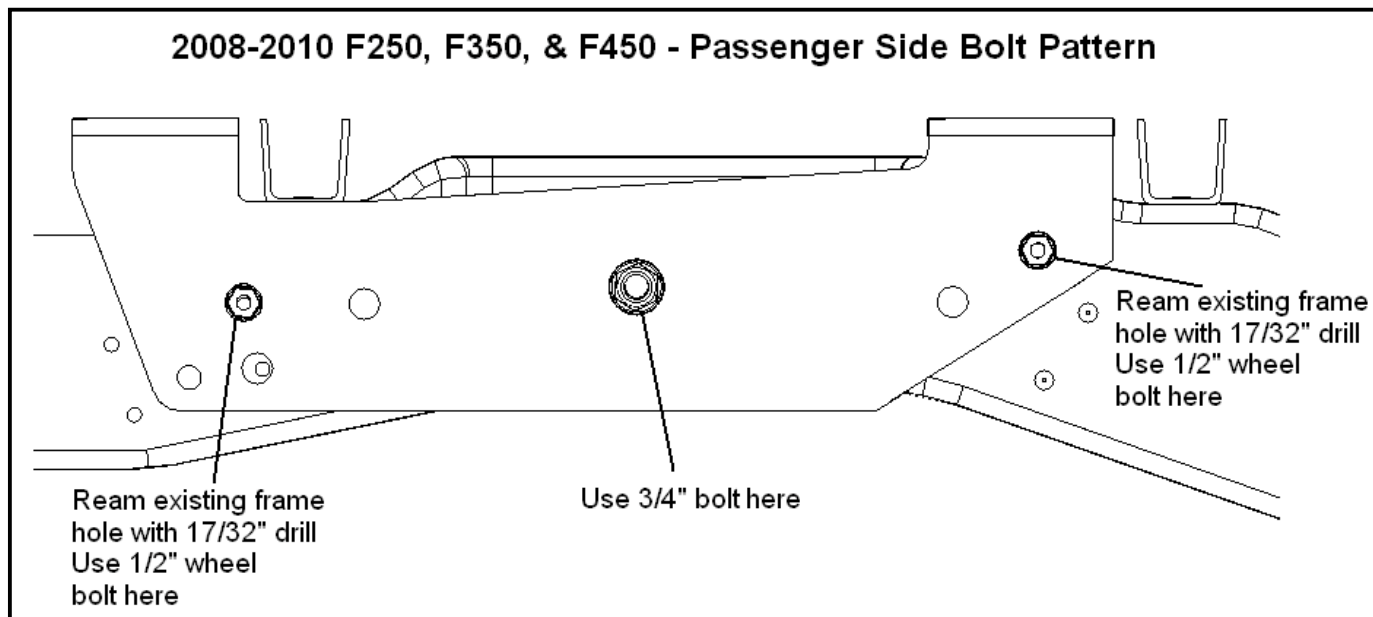
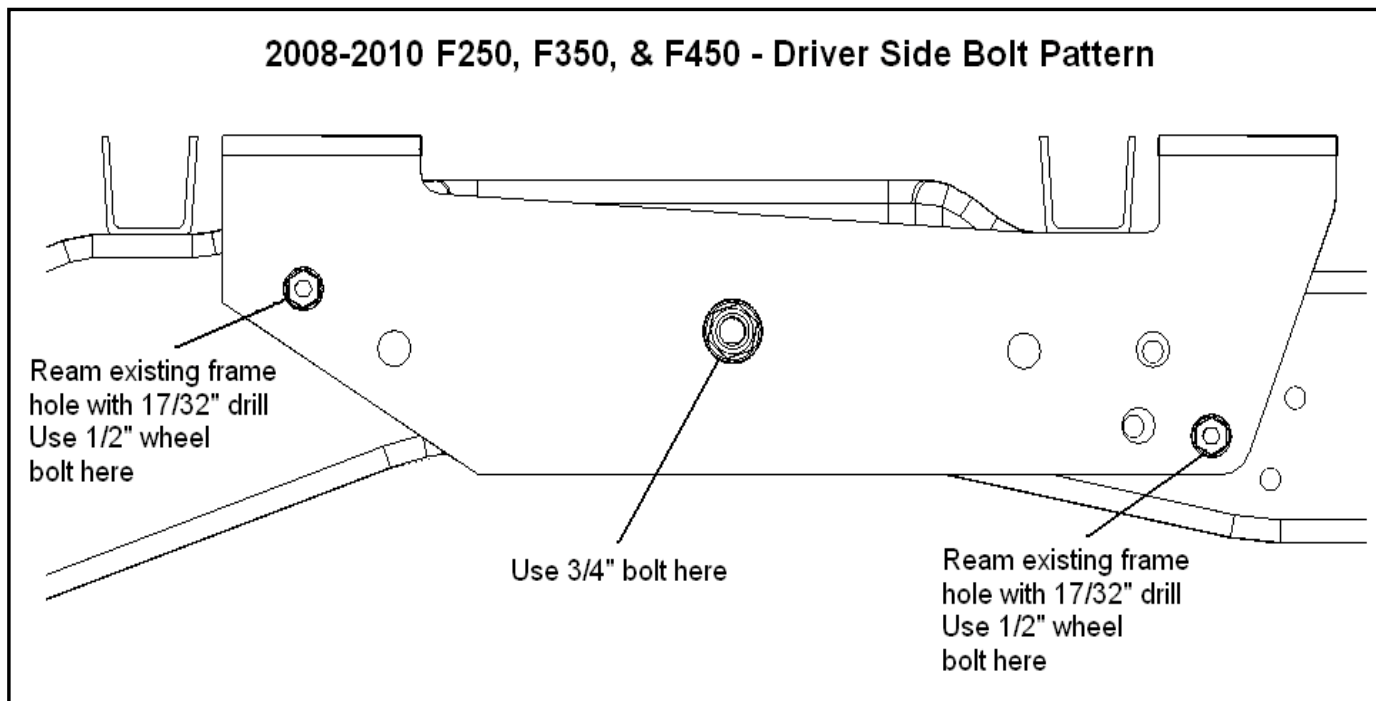


3. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a slotted spacer plate in this location as shown in **Illustration 2**. If the corrugation is DOWN at this location, place the slotted spacer plate in the bed, under the base rail as shown in Illustration 2a.
4. Position the left and right 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. 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 #1**.
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 **BOLT TORQUE SPECIFICATIONS**.
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.

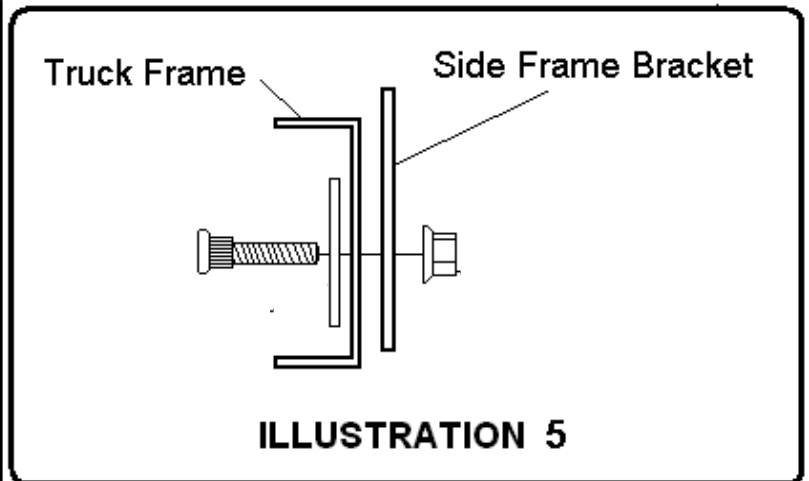
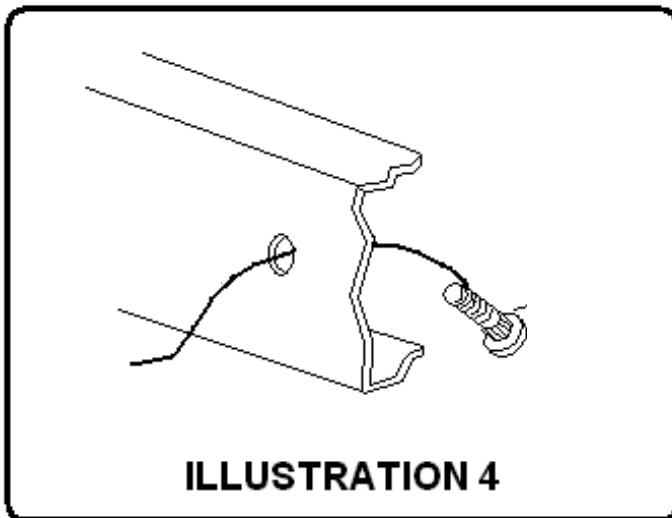
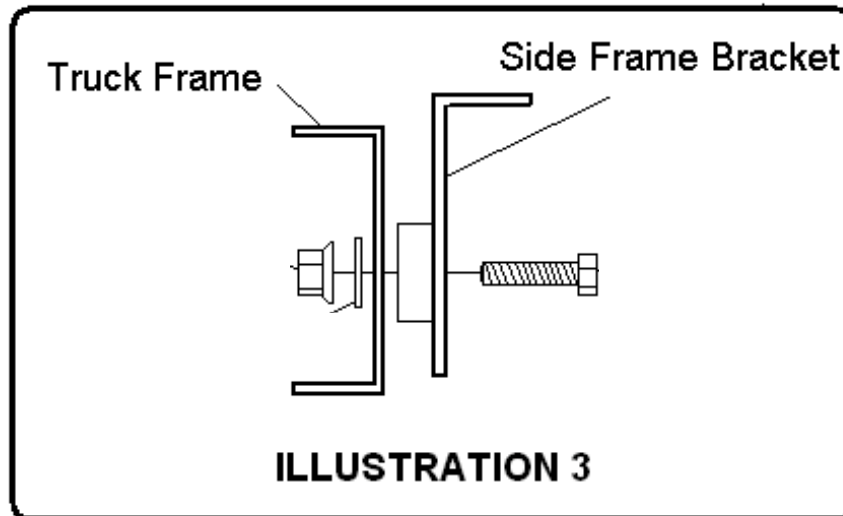
# Installation

## 2005-2010 Pickup Models



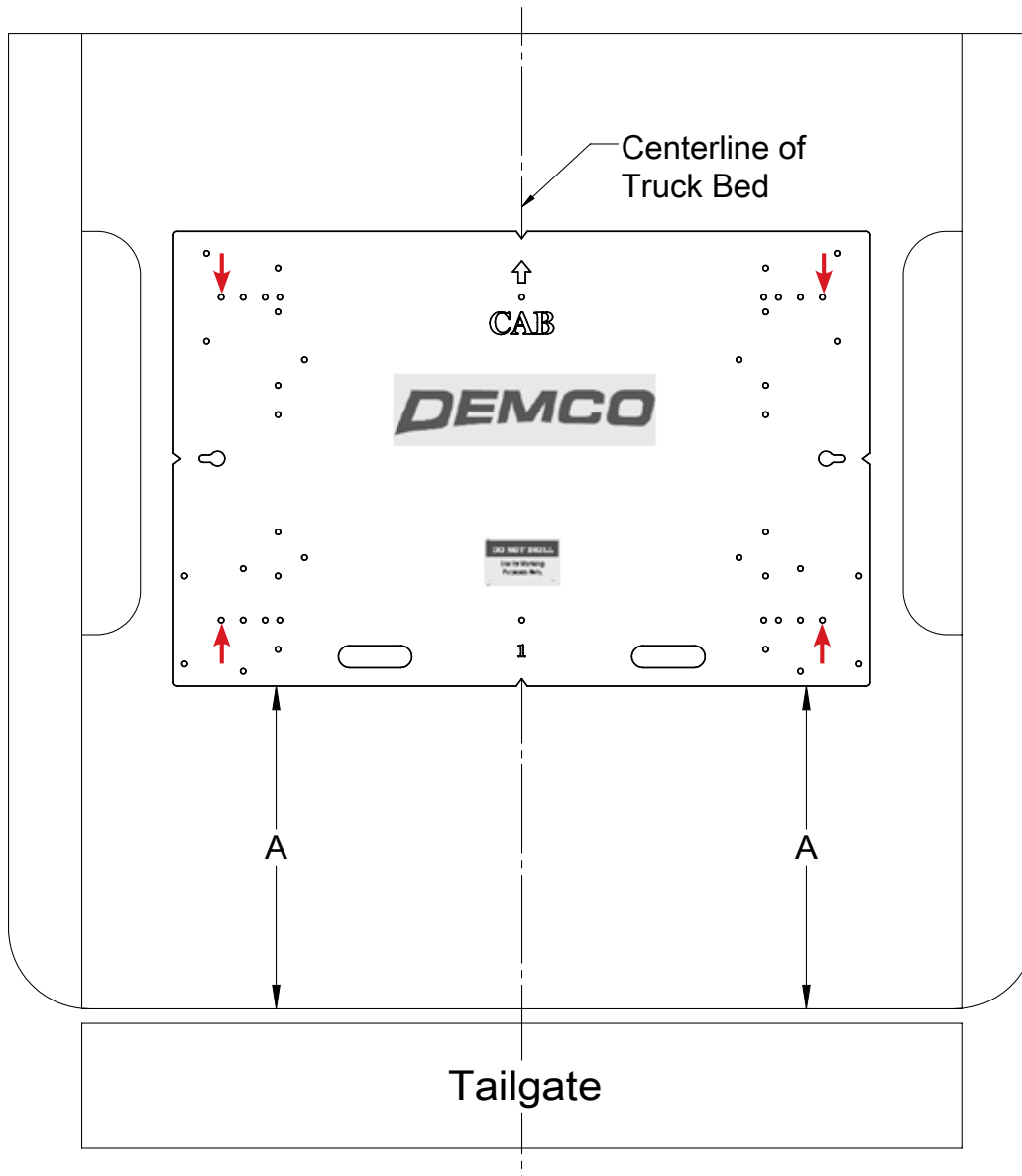


8. Before drilling any holes in the frame, check the inside of the frame to be sure that there are no wires, brake lines or other obstructions in the frame that may contact the drill. Each of the frame brackets must be attached to the side frame of the truck with a special 1/2" knurled bolt at the forward 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 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 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 **BOLT TORQUE SPECIFICATIONS**. Failure to tighten bolts as described may result in fastener loss or failure.

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 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 5/8" drill bit.  
**NOTE:** A pilot hole may need to be drilled.
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 |
|--|------------|-------------|
| FORD 2005-2010 F250 & F350 "SUPER DUTY"        |            |             |
| 6-1/2'   | A          | *27"        |
| 8'   | A          | *27"        |
| FORD 2008-2010 F450 "SUPER DUTY"               |            |             |
| 6-1/2'   | A          | *27"        |
| 8'   | A          | *27"        |
| *ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX |            |             |

# DEMCO

4010 320th St., Boyden, IA. 51234

Phone: (712) 725-2311

Fax: (712) 725-2380

Toll Free: 1-800-54DEMCO (1-800-543-3626)

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

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

