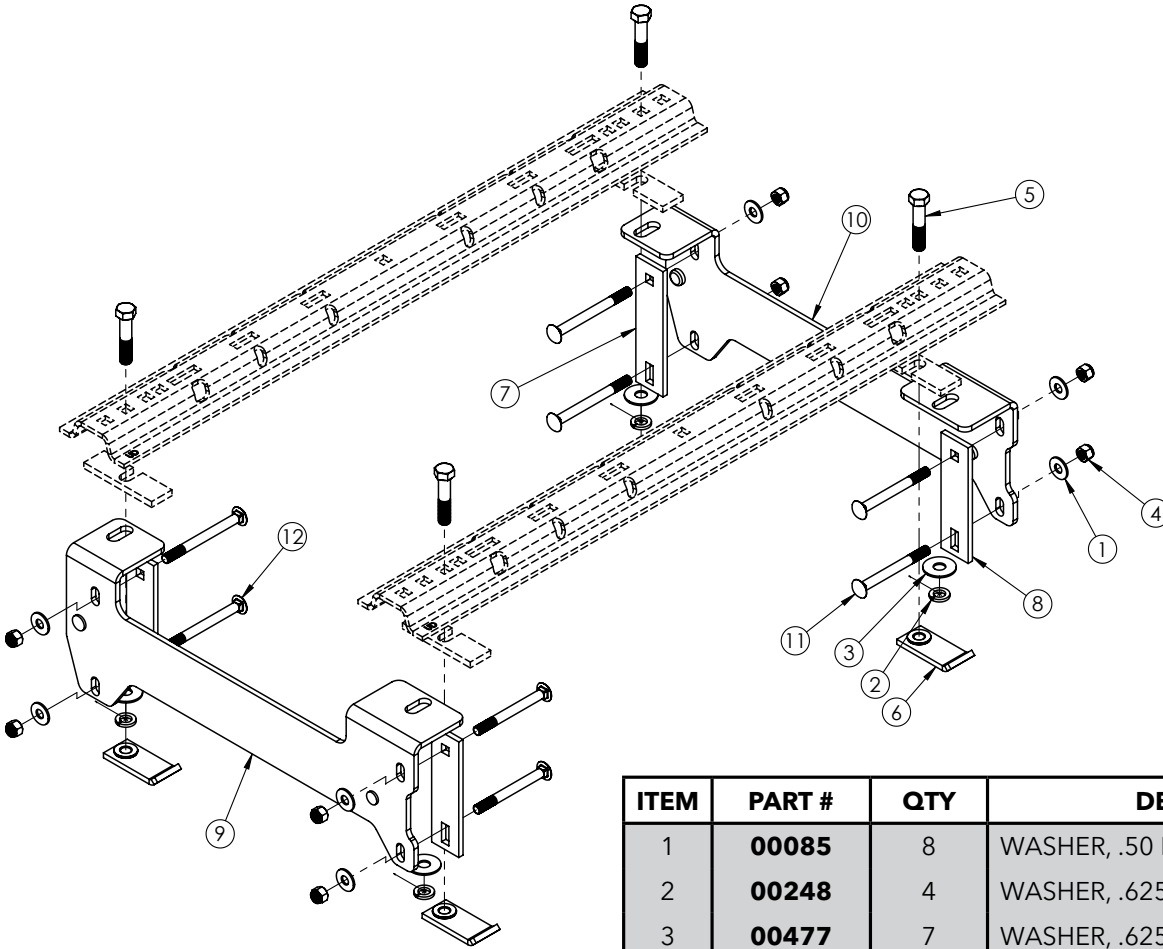


## FRAME BRACKET 8552004

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



ITEM	PART #	QTY	DESCRIPTION
1	<b>00085</b>	8	WASHER, .50 FLAT
2	<b>00248</b>	4	WASHER, .625 LOCK
3	<b>00477</b>	7	WASHER, .625 FLAT
4	<b>02178</b>	8	NUT, .50 NYLON LOCK
5	<b>04215</b>	4	BOLT, .625 X 3" HEX GR.5
6	<b>14251-95</b>	4	PLATED NUT BAR
7	<b>14284-76</b>	2	FRONT CARRIAGE BOLT PLATE
8	<b>14285-76</b>	2	REAR CARRIAGE BOLT PLATE
9	<b>14372-76</b>	1	FRAME BRACKET DRIVER SIDE
10	<b>14373-76</b>	1	FRAME BRACKET PASSENGER SIDE
11	<b>14376</b>	4	BOLT, .50 X 5" CARRIAGE
12	<b>14381</b>	4	BOLT, .50 X 5-1/2" CARRIAGE GR.5

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

# Installation

## 8552004 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

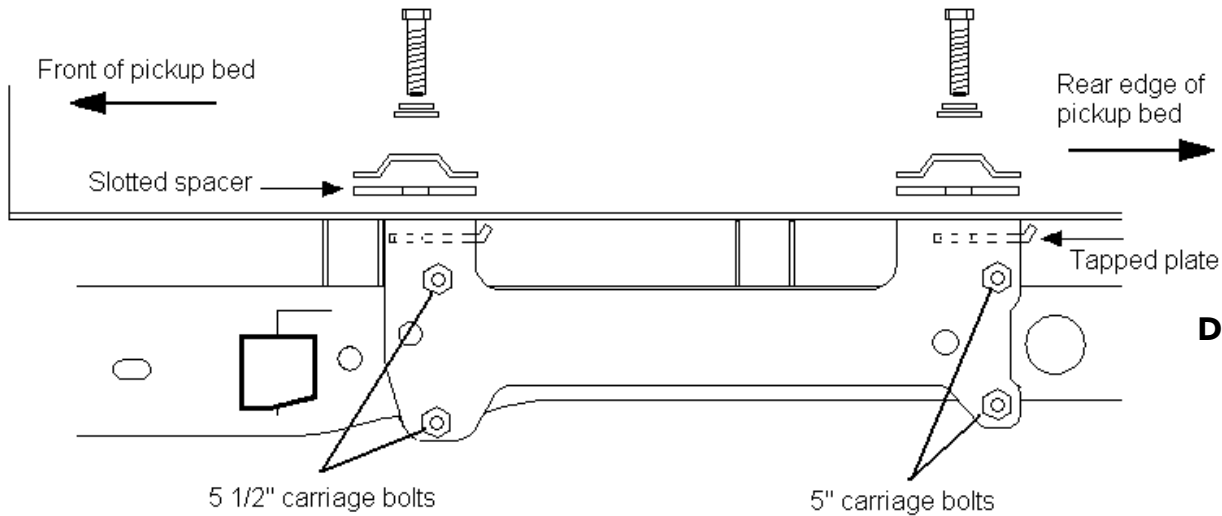
STANDARD BOLTS			METRIC BOLTS		
Size	Grade	Torque	Size	Grade	Torque
5/16"	5	18 ft/lbs.	8mm	8.8	23 ft/lbs.
3/8"	5	30 ft/lbs.	10mm	8.8	45 ft/lbs.
7/16"	5	50 ft/lbs.	12mm	8.8	78 ft/lbs.
1/2"	5	75 ft/lbs.	14mm	8.8	125 ft/lbs.
5/8"	5	150 ft/lbs.	16mm	8.8	160 ft/lbs.
3/4"	5	290 ft/lbs.			

**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.

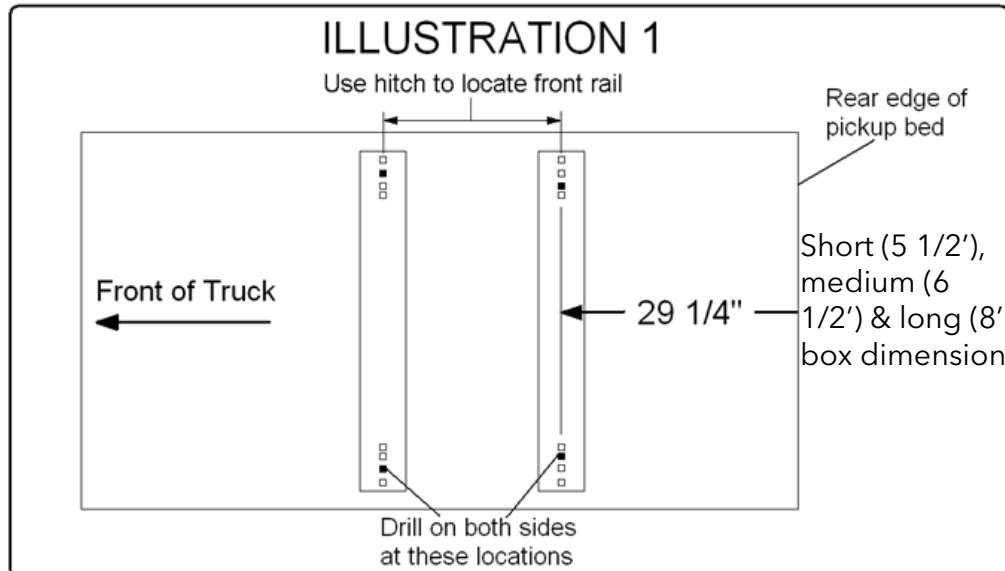
**NOTE:** All metal surfaces that come in contact with the aluminum body need to have vinyl placed in between to prevent corrosion.

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

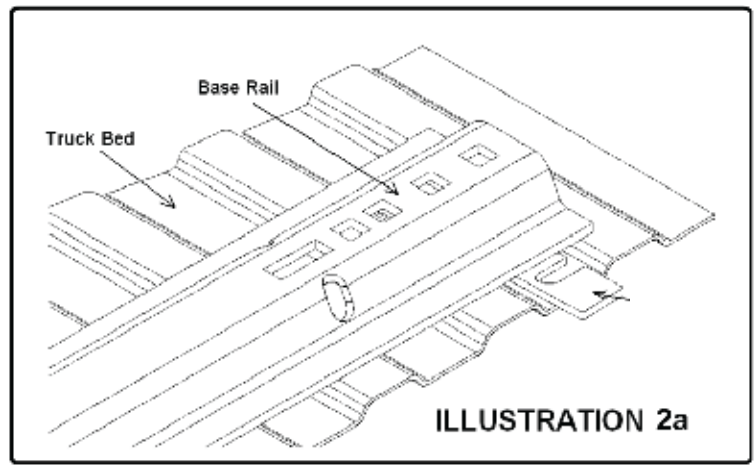
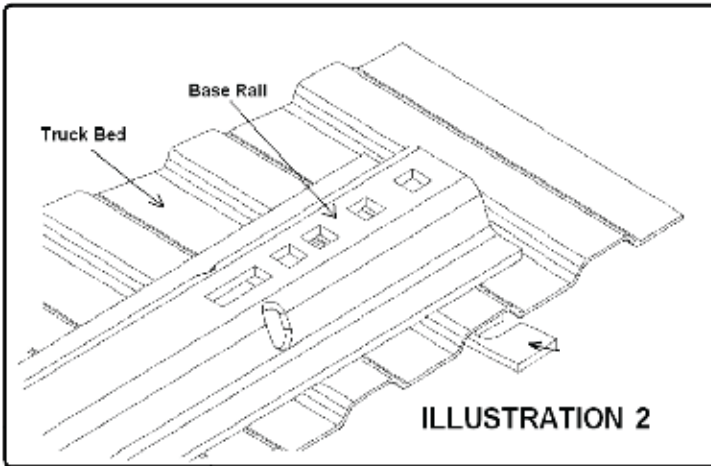
## Directly over axle on 5 1/2', 6 1/2' & 8' applications



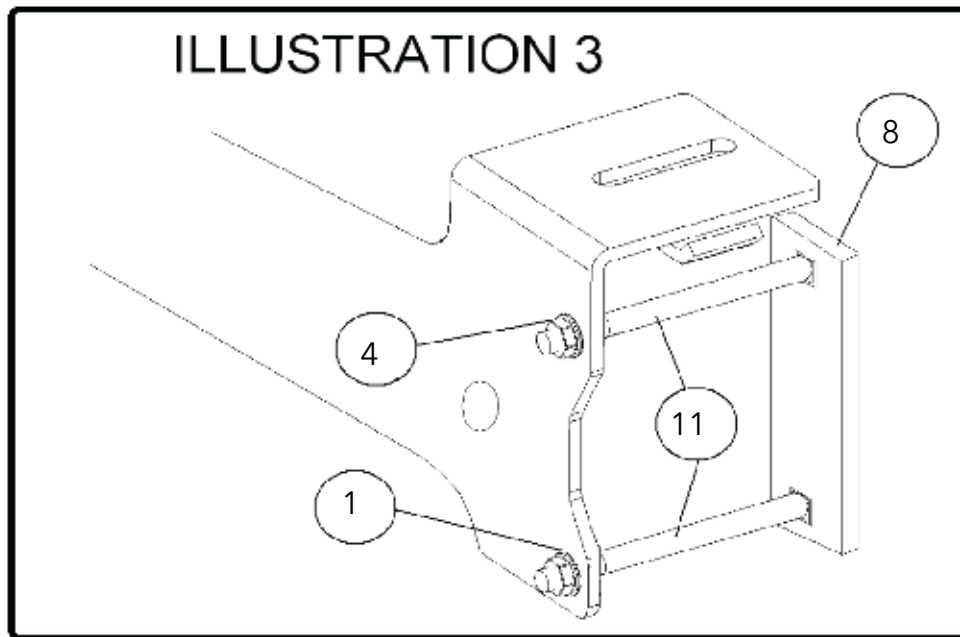
**Drawing #1**



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**. 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 over the frame and under the bed. The frame brackets will align themselves in existing frame holes using the 3/4" and 7/8" guide pins that are welded onto each bracket. The brackets should be 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 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**.

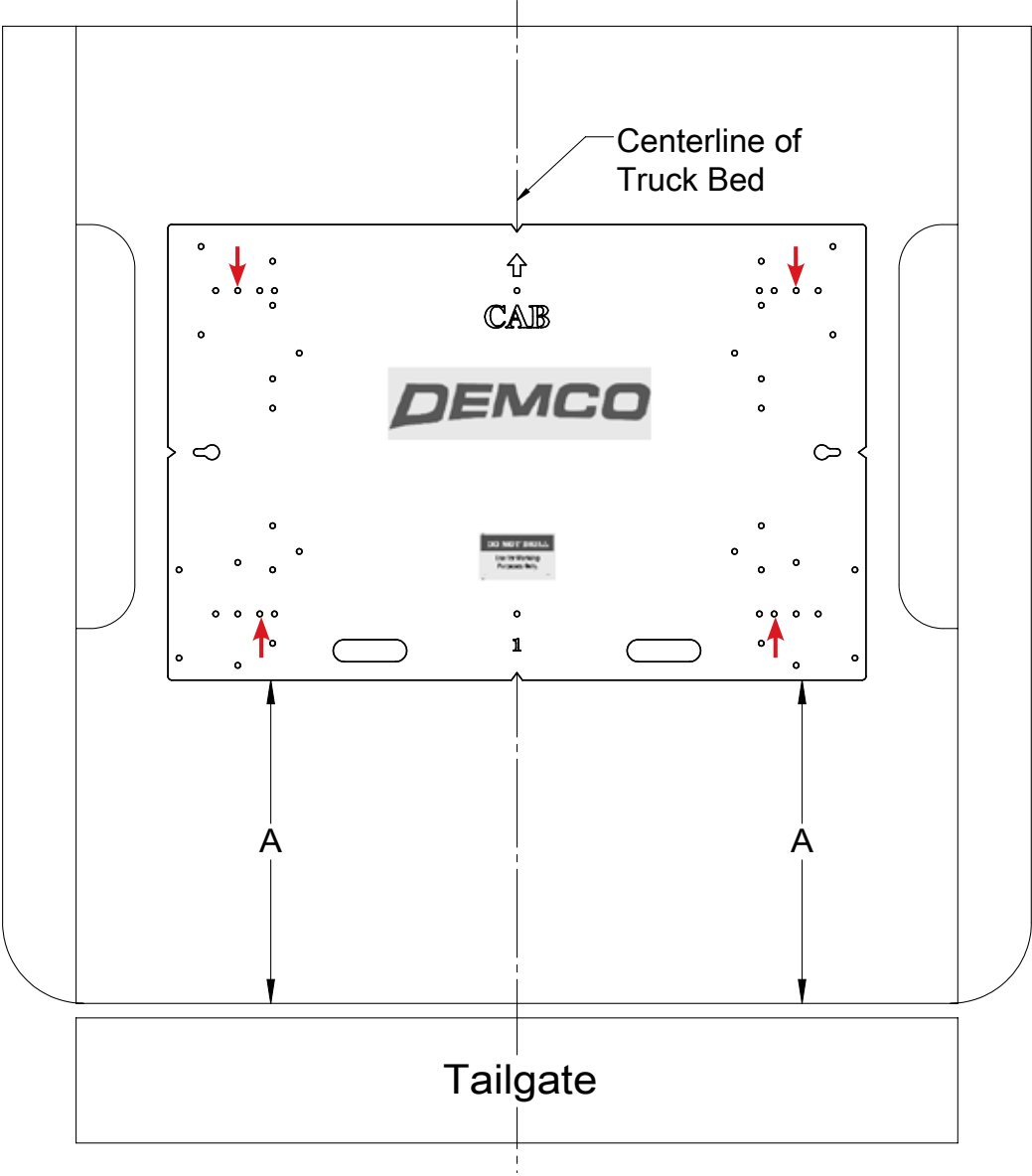


7. Place the two carriage bolt plates and along with the carriage bolts from the inside of the truck frame and use 1/2" flat washers and 1/2" nylon lock nuts to attach to frame bracket. **See Illustration 3.** Ensure that the 5 1/2" long carriage bolts are used on the forward mounting holes and the 5" carriage bolts are used on the rear mounting holes. **NOTE: If carriage bolts rub on gas tank, loosen gas tank, push gas tank over and tighten gas tank straps.**
8. Tighten all bolts according to **BOLT TORQUE SPECIFICATIONS.** Failure to tighten bolts as described may result in fastener loss or failure.

### 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 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.

Truck Bed Drilling Instructions with Template



Drawing #2

BOX LENGTH	DIMENSIONS	MEASUREMENT
FORD F150		
5-1/2'	A	*24-3/4"
6-1/2'	A	*24-3/4"
8'	A	*24-3/4"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

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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)**

