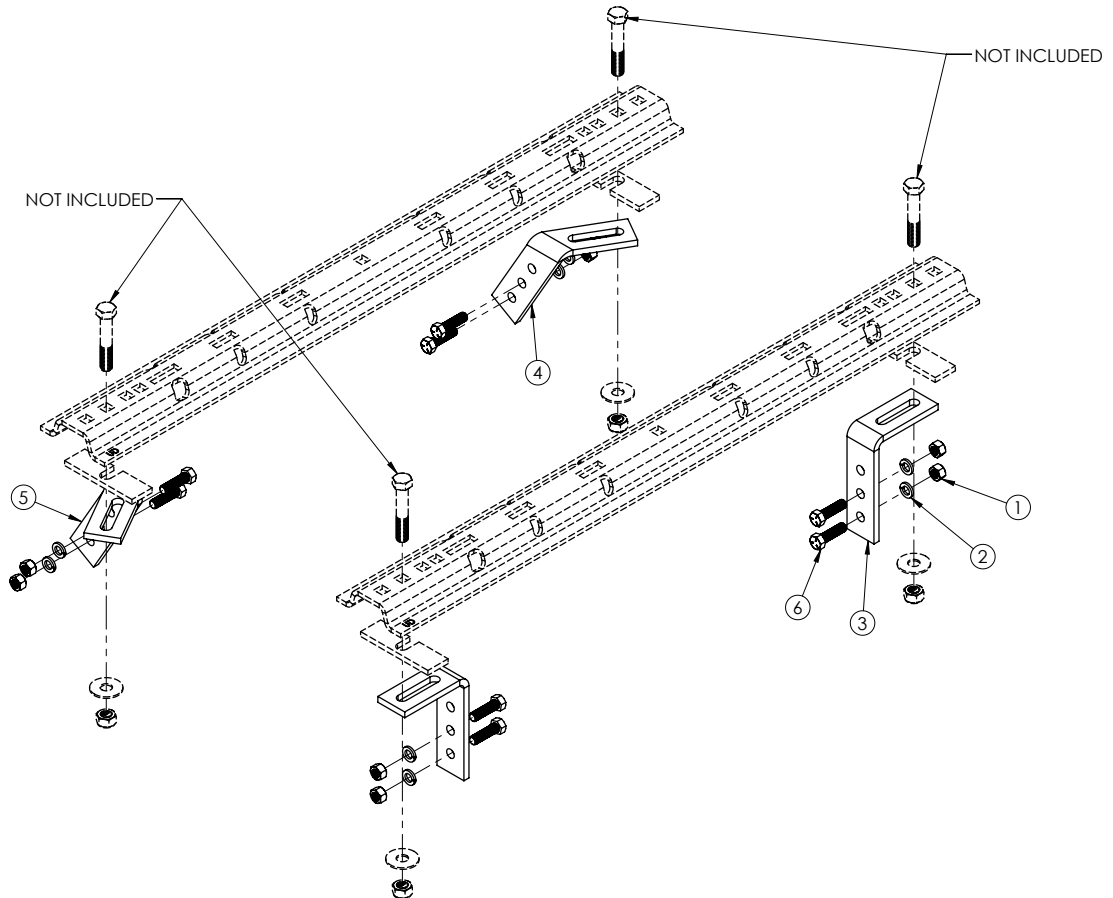


## FRAME BRACKET 8552005

Ford & Dodge



ITEM	PART #	QTY	DESCRIPTION
1	<b>00083</b>	8	NUT, .50NC HEX
2	<b>00084</b>	8	WASHER, .50 LOCK
3	<b>14189-76</b>	2	FRAME BRACKET
4	<b>14194-76</b>	1	411AL FRAME BRACKET PASSENGER SIDE
5	<b>14195-76</b>	1	411AR FRAME BRACKET DRIVER SIDE
6	<b>14266</b>	8	BOLT, .50NC X 1-3/4" HEX KNURL GR.5
7	<b>14238</b>	1	FISH WIRE .50 (NOT SHOWN)

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

# Installation

## 8552005 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

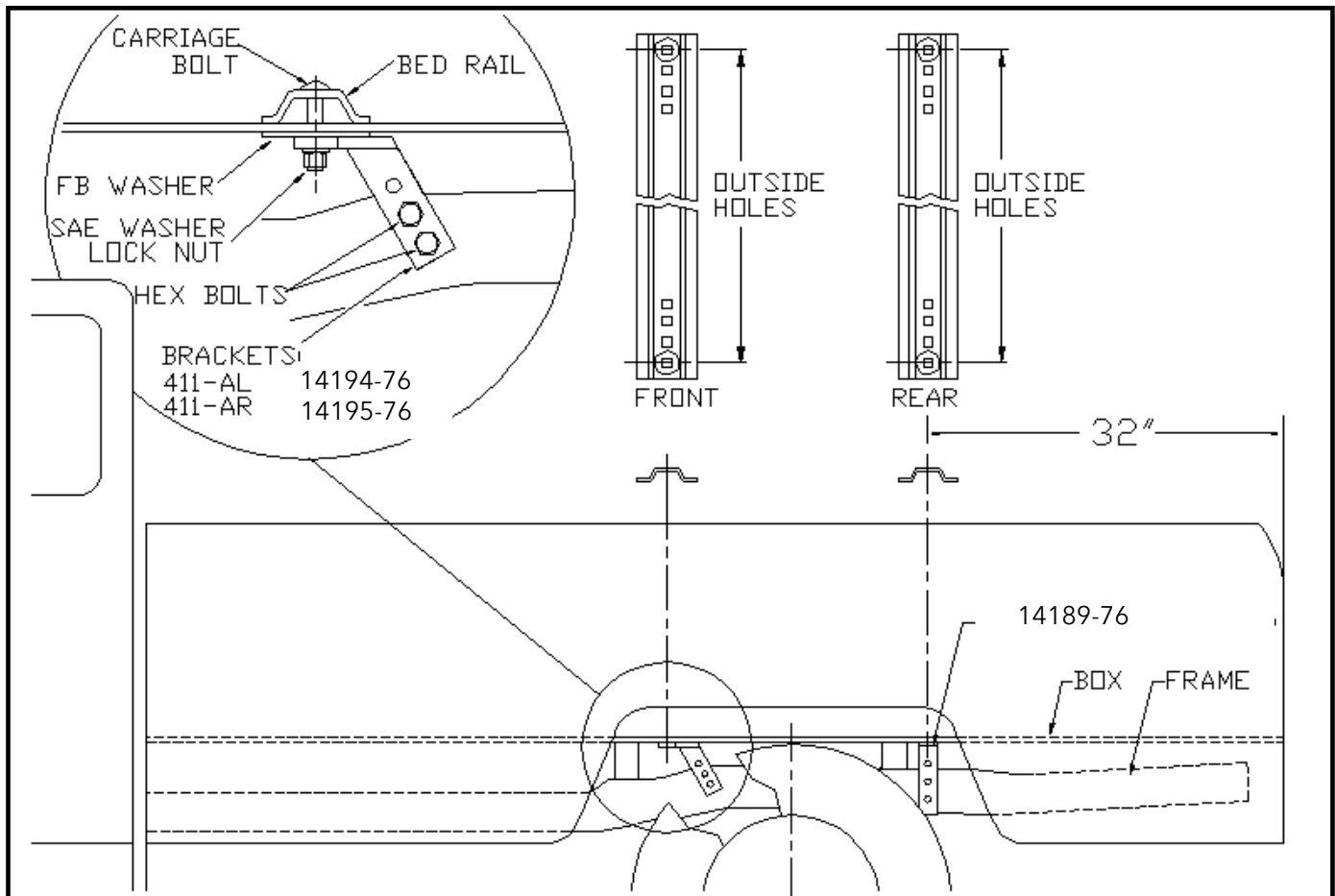
STANDARD BOLTS			METRIC BOLTS		
Size	Grade	Torque	Size	Grade	Torque
5/16"	5	18 ft/lbs.	8mm	8.8	23 ft/lbs.
3/8"	5	30 ft/lbs.	10mm	8.8	45 ft/lbs.
7/16"	5	50 ft/lbs.	12mm	8.8	78 ft/lbs.
1/2"	5	75 ft/lbs.	14mm	8.8	125 ft/lbs.
5/8"	5	150 ft/lbs.	16mm	8.8	160 ft/lbs.
3/4"	5	290 ft/lbs.			

**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.

**FORD:**           **1973-1988 F SERIES (6-1/2' & 8' BOXES)**  
                      **1989-1996 F150/F250 (6-1/2' & 8' BOXES)**



## INSTALLATION

1. a. Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.  
b. Set hitch into back of truck, center it side to side.  
c. Measure 32" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstruction (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown.  
b. Insert two bolts.  
c. Drill two 5/8" holes in REAR BED RAIL, OUTSIDE POSITION. Insert two bolts.
4. a. Under box, place 2" wide flat bar, the 411AL, 411AR and 411 frame brackets, flat washers and lock nuts onto bolts.  
b. Press each bracket tight against frame member; tighten nuts snug against box.
5. a. Pilot drill\* and drill 1/2" hole into truck frame, at two places thru holes each frame bracket -- BE CAREFUL OF ELECTRIC OR FLUID LINES behind frame members.  
b. Brackets will be bolted onto frame by drilling frame and fishing knurl bolt through frame with fish wire (14238) and attach with hex nut and lock washer on outside of bracket.  
c. **TIGHTEN ALL BOLTS ACCORDING TO BOLT TORQUE SPECIFICATIONS.**

\* To pilot drill: Use 1/2" drill bit or transfer punch to mark center. Drill thru with 1/4" drill.

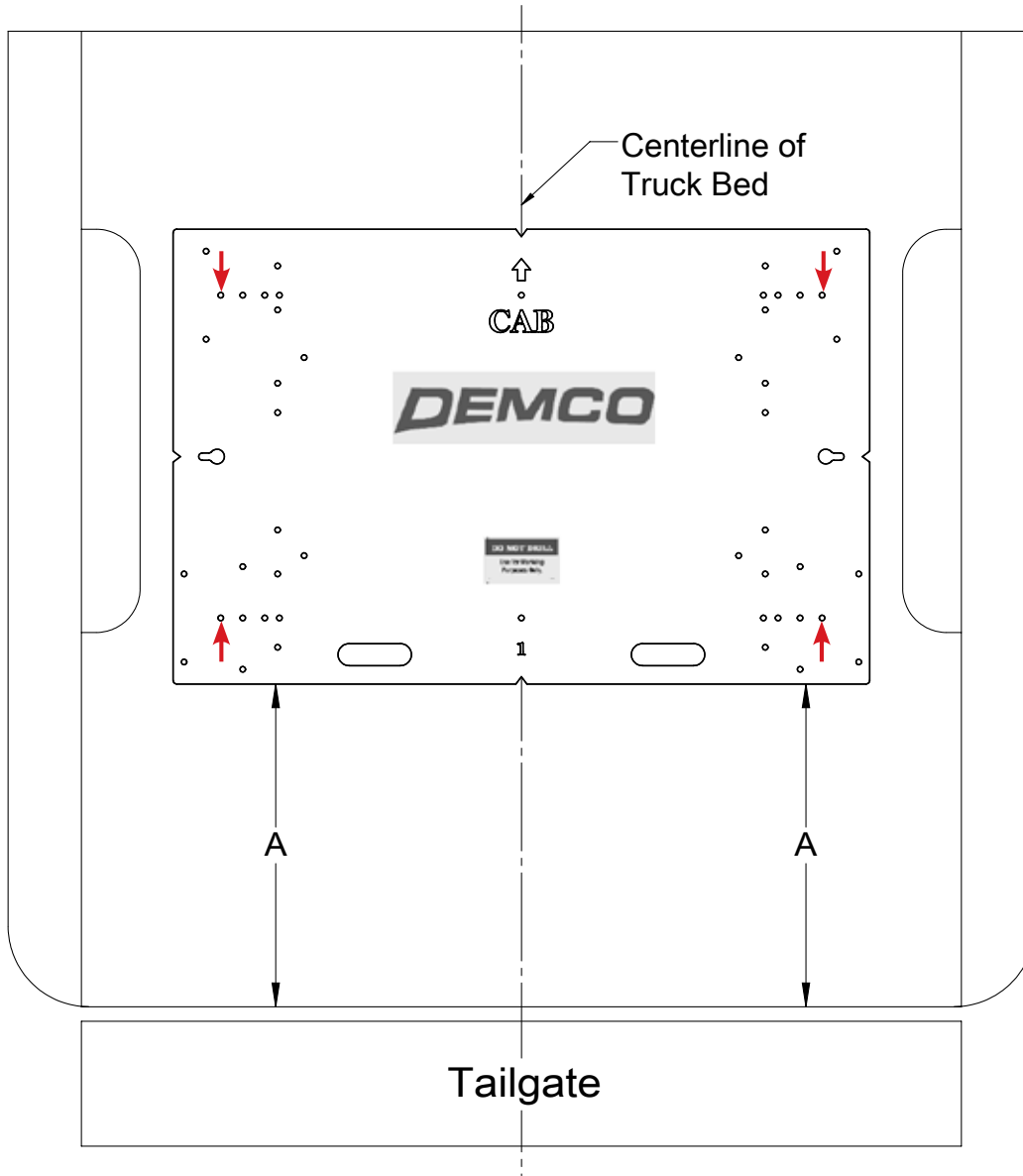
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### Truck Bed Drilling Instructions with Template

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 #1** 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.

# Installation

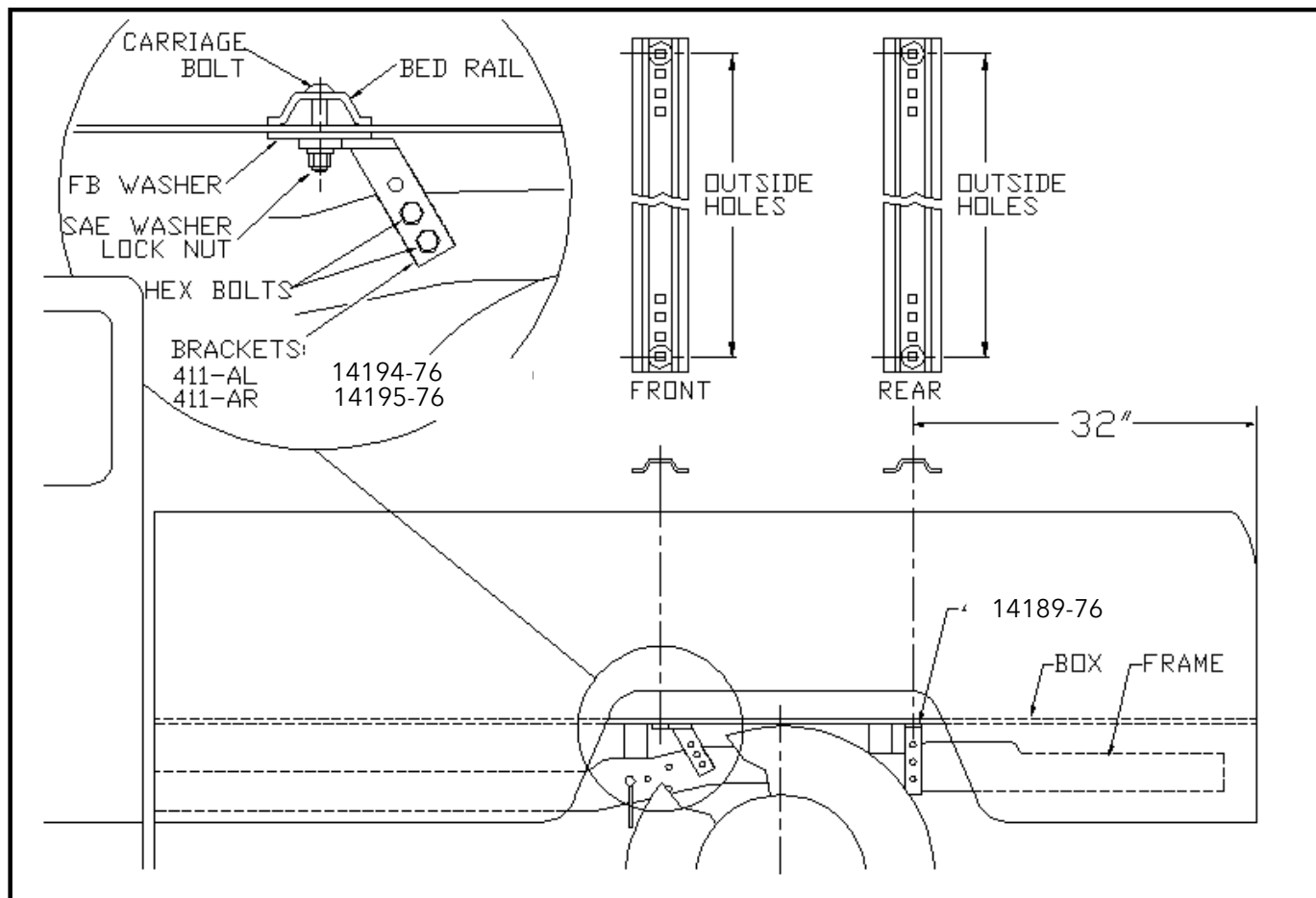
## Truck Bed Drilling Instructions with Template



**Drawing #1**

BOX LENGTH	DIMENSIONS	MEASUREMENT
FORD 1973-1988 F SERIES		
6-1/2'	A	*27-1/2"
8'	A	*27-1/2"
FORD 1989-1996 F150/F250		
6-1/2'	A	*27-1/2"
8'	A	*27-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

**FORD: 1992-1998 F350 (8'BOX)  
1997-1998 F250 "HEAVY DUTY" (6-1/2' & 8' BOXES)**



## INSTALLATION

1.
  - a. Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
  - b. Set hitch into back of truck, center it side to side.
  - c. Measure 32" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstruction (frame members, etc.).
3.
  - a. Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown.
  - b. Insert two bolts.
  - c. Drill two 5/8" holes in REAR BED RAIL, OUTSIDE POSITION. Insert two bolts.
4.
  - a. Under box, place 2" wide flat bar, the 411AL, 411AR and 411 frame brackets, flat washers and lock nuts onto bolts (4 places).
  - b. Press each bracket tight against frame member; tighten nuts snug against box.
5.
  - a. Pilot drill\* and drill 1/2" hole into truck frame, at two places thru holes each frame bracket -- BE CAREFUL OF ELECTRIC OR FLUID LINES behind frame members.
  - b. Brackets will be bolted onto frame by drilling frame and fishing knurl bolt through frame with fish wire and attach with hex nut and lock washer on outside of bracket.
  - c. **TIGHTEN ALL BOLTS ACCORDING TO BOLT TORQUE SPECIFICATIONS.**

\* To pilot drill: Use 1/2" drill bit or transfer punch to mark center. Drill thru with 1/4" drill.

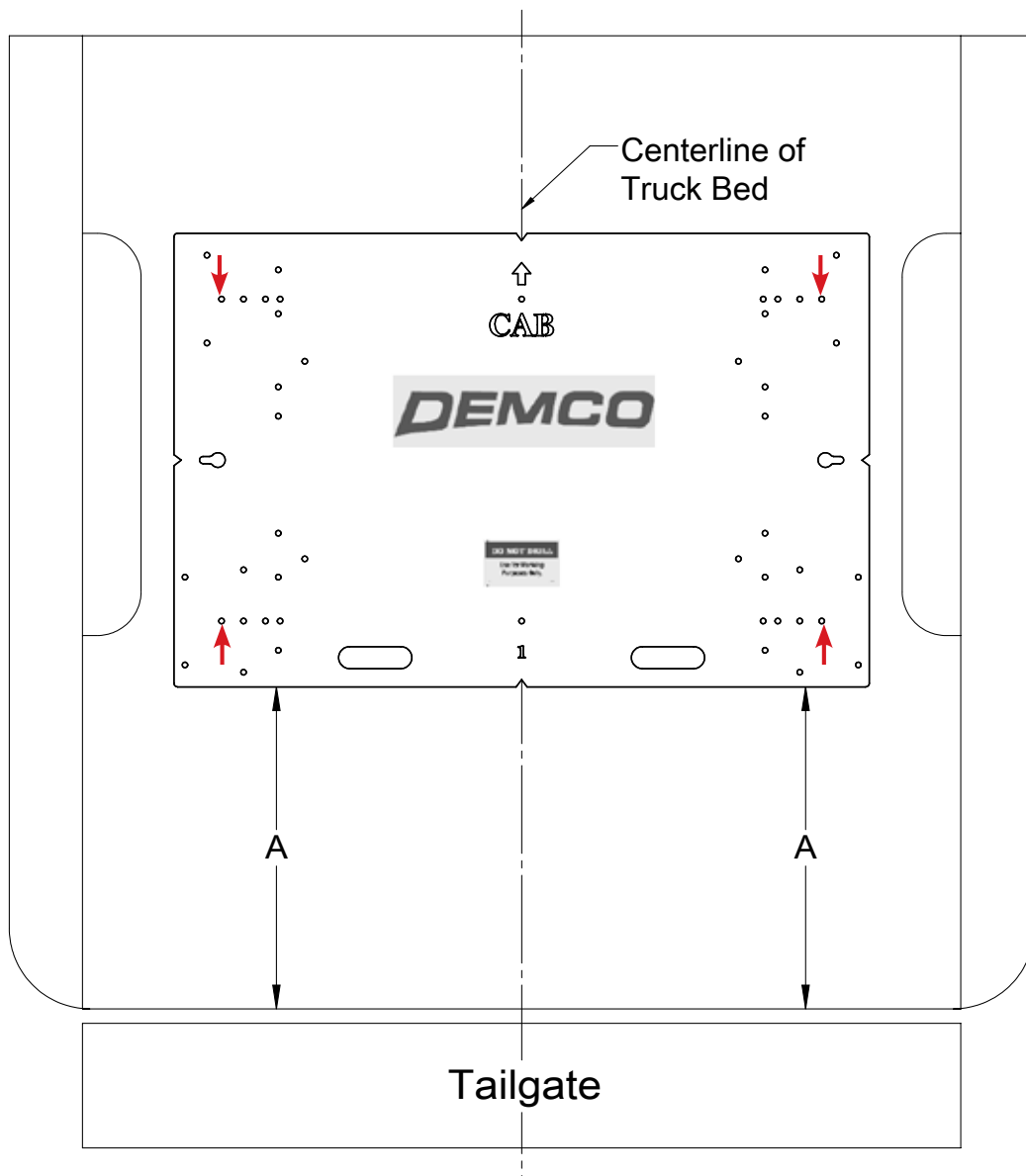
## Installation

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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 #1** 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

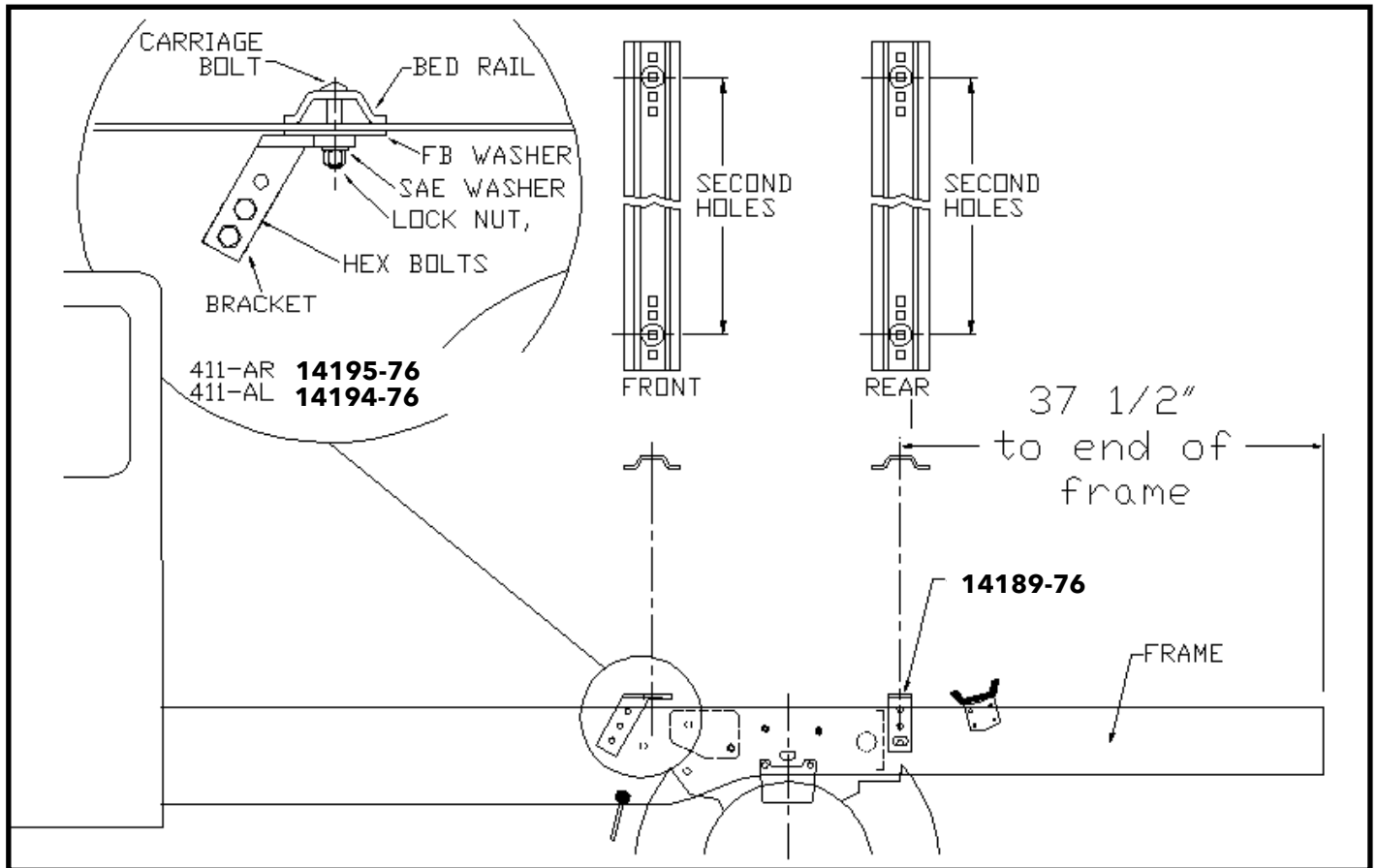


Drawing #1

BOX LENGTH	DIMENSIONS	MEASUREMENT
FORD 1992-1998 F350		
8'	A	*27-1/2"
FORD 1997-1998 F250 "HEAVY DUTY"		
6-1/2'	A	*27-1/2"
8'	A	*27-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

# Installation

FORD 2000-2007 F450 & F550 "SUPER DUTY"



## INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
  - Set hitch into back of truck, center it side to side.
  - Measure 37 1/2" from back edge of truck **frame** to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstruction (gas line, wiring, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
  - Insert two 5/8" x 3 1/2" bolts.
  - Drill two 5/8" holes in REAR BED RAIL, SECOND HOLE POSITION. Insert two 5/8" x 3 1/2" bolts.
- Under box, place 2" wide flat bar, the 411AL, 411AR and 411 frame brackets, flat washers and lock nuts onto bolts (4 places).
  - Press each bracket tight against frame member; tighten nuts snug against box.
- Pilot drill\* and drill 1/2" hole into truck frame, at two places thru holes each frame bracket -- BE CAREFUL OF ELECTRIC OR FLUID LINES behind frame members.
  - Brackets will be bolted onto frame by drilling frame and fishing knurl bolt through frame with fish wire and attach with hex nut and lock washer on outside of bracket.
  - TIGHTEN ALL BOLTS ACCORDING TO BOLT TORQUE SPECIFICATIONS.**

\* To pilot drill: Use 1/2" drill bit or transfer punch to mark center. Drill thru with 1/4" drill.

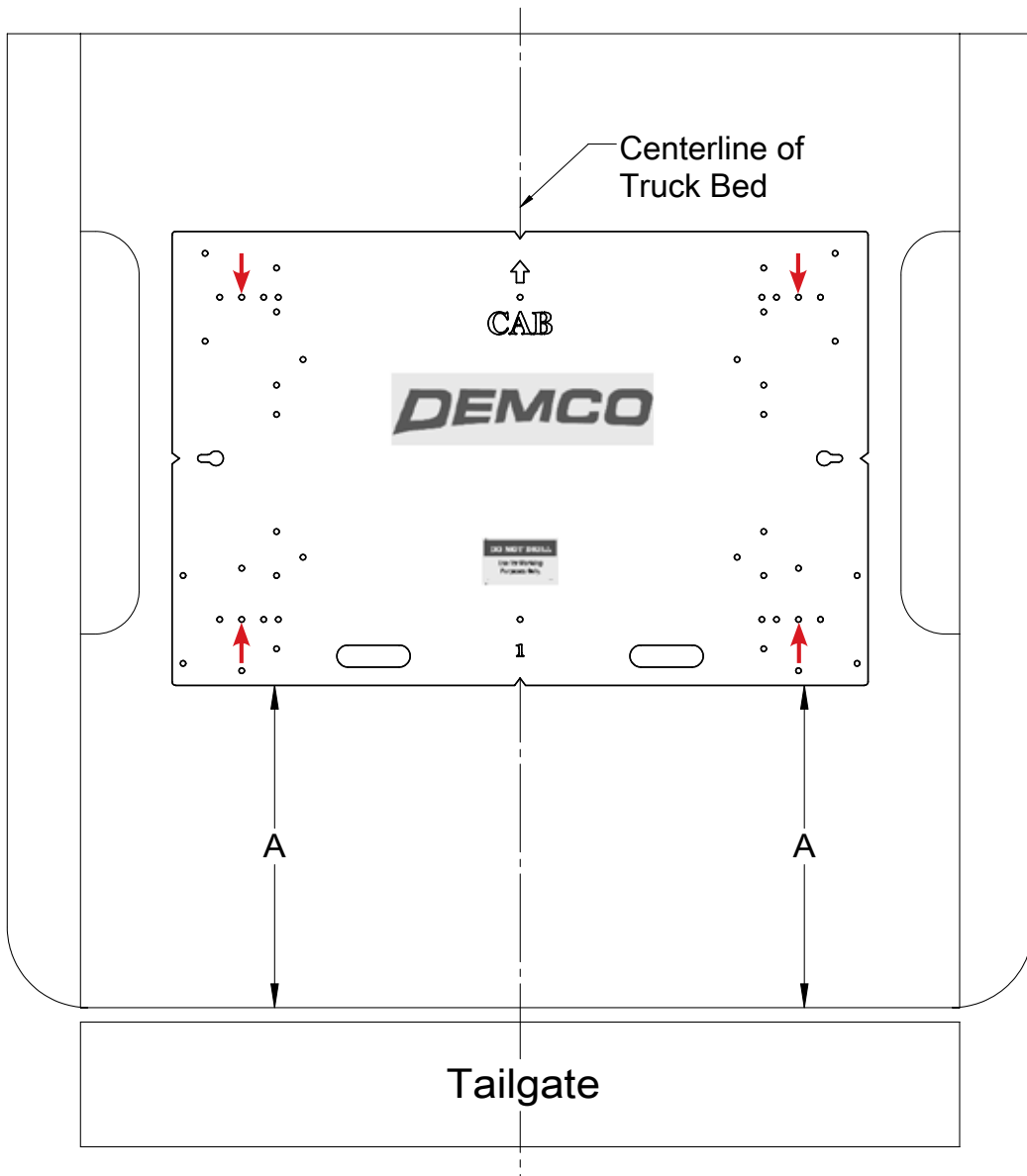


**Truck Bed Drilling Instructions with Template**

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 #1** 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.

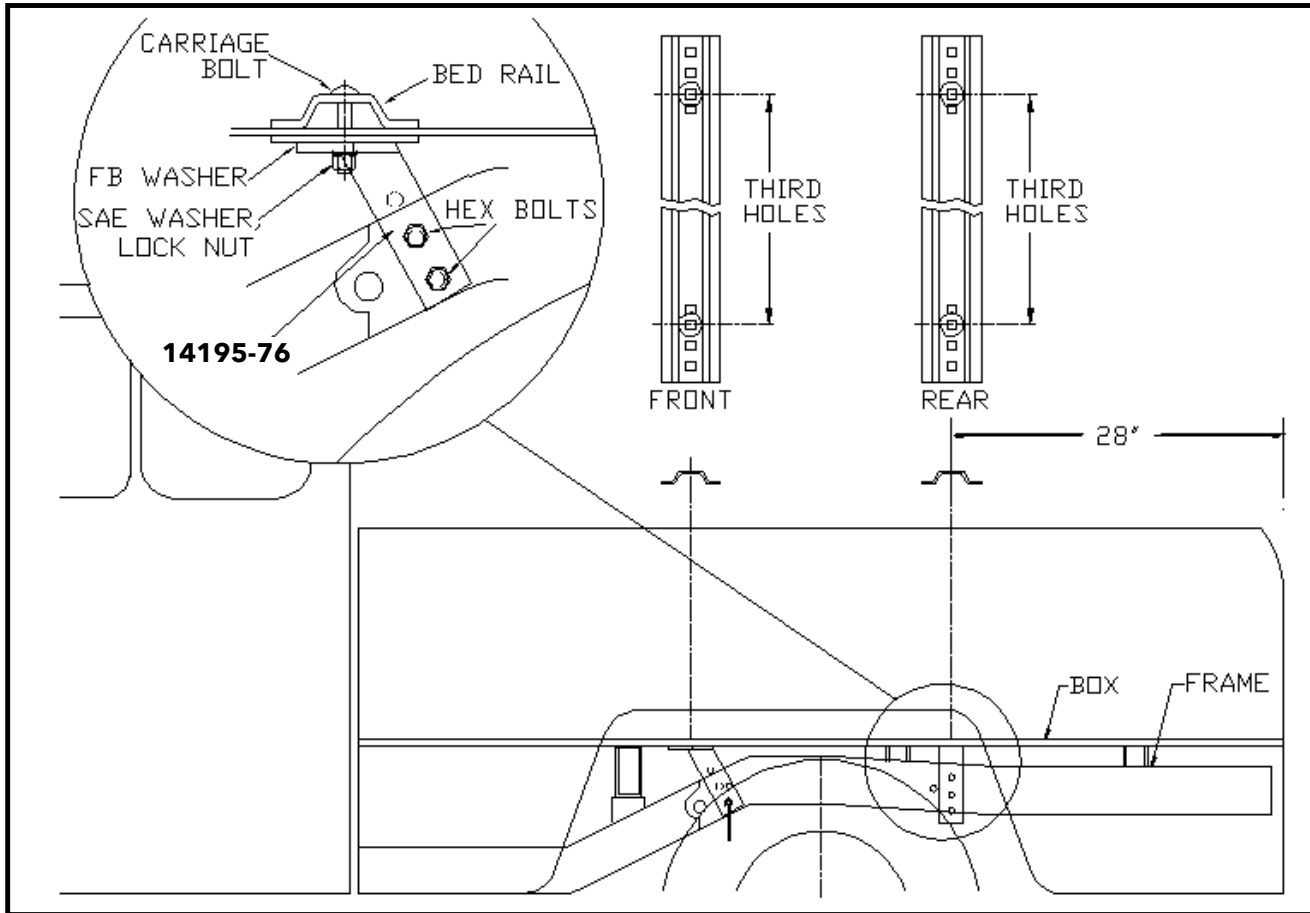
# Installation

## Truck Bed Drilling Instructions with Template



**Drawing #1**

BOX LENGTH	DIMENSIONS	MEASUREMENT
FORD 2000-2007 F450 & F550 "SUPER DUTY"		
	A	*33"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

**DODGE: 2003-2004 DAKOTA (6-1/2' BOX DOES NOT INCLUDE QUAD CAB)****INSTALLATION**

1. a. Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.  
b. Set hitch into back of truck, center it side to side.  
c. Measure 28" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstruction (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, THIRD HOLE POSITION, as shown - **NOTE:** use OUTSIDE hole locations instead, front and rear, if desired.  
b. Insert two bolts. \*\* (5/8" x 3" hex head Gr.5 bolts can be substituted instead of using the bolts because of space restrictions under the box. This will allow the bolts to be easily tightened from up top).  
c. Drill two holes in REAR BED RAIL, THIRD HOLE POSITION. Insert two bolts.
4. a. Under box, place 2" wide flat bar, the 411AL, 411AR and 411 frame brackets, flat washers and lock nuts onto bolts (4 places).  
b. Press each bracket tight against frame member; tighten nuts snug against box.
5. a. Pilot drill\* and drill 1/2" hole into truck frame, at two places thru holes each frame bracket -- BE CAREFUL OF ELECTRIC OR FLUID LINES behind frame members.  
b. Brackets will be bolted onto frame by drilling frame and fishing knurl bolt through frame with fish wire and attach with hex nut and lock washer on outside of bracket.  
c. **TIGHTEN ALL BOLTS ACCORDING TO BOLT TORQUE SPECIFICATIONS.**

\* To pilot drill: Use 1/2" drill bit or transfer punch to mark center. Drill thru with 1/4" drill.

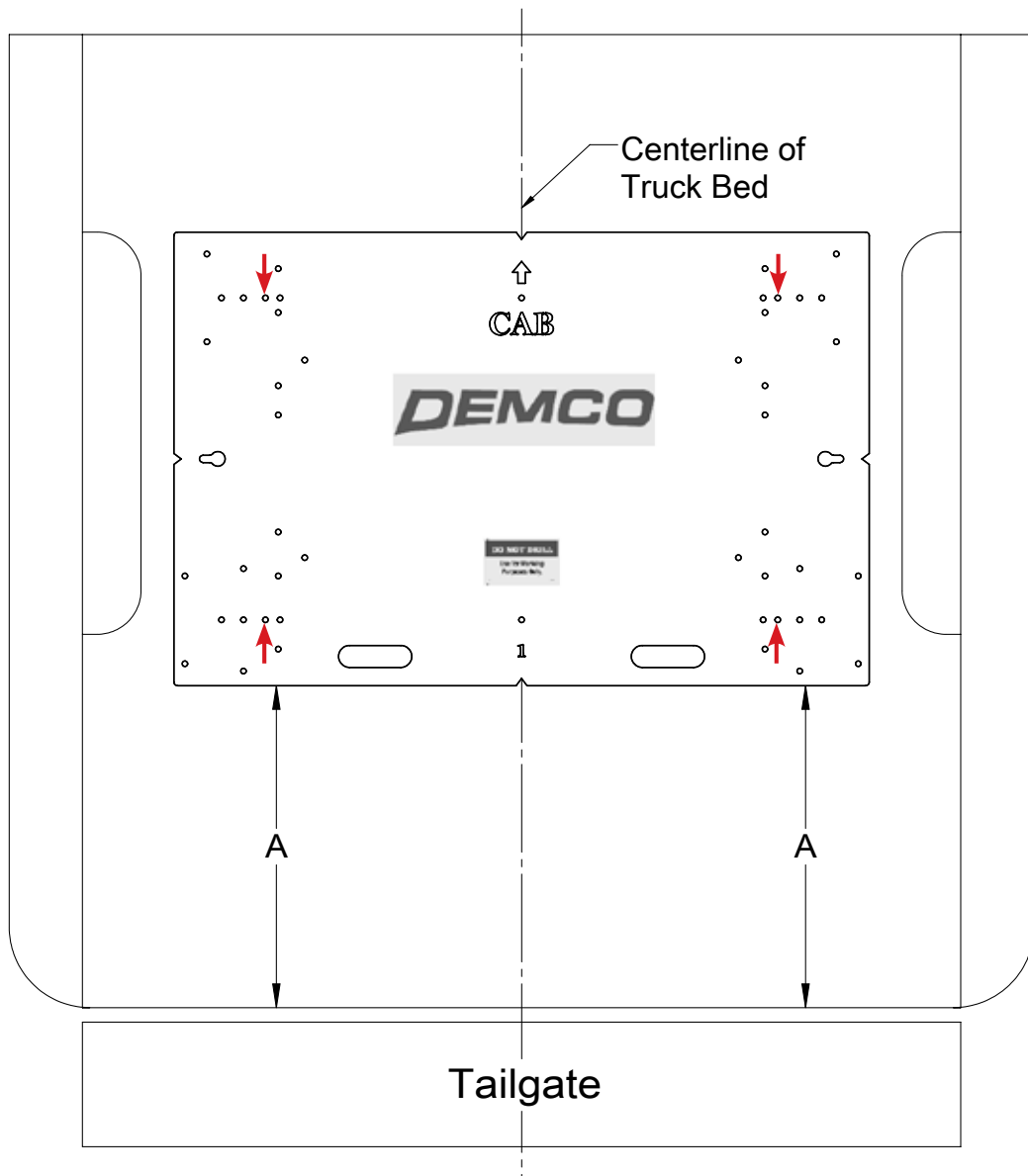
# Installation

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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 #1** 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 #1

BOX LENGTH	DIMENSIONS	MEASUREMENT
DODGE 2003-2004 DAKOTA		
6-1/2'	A	*23-1/2"
*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)**

