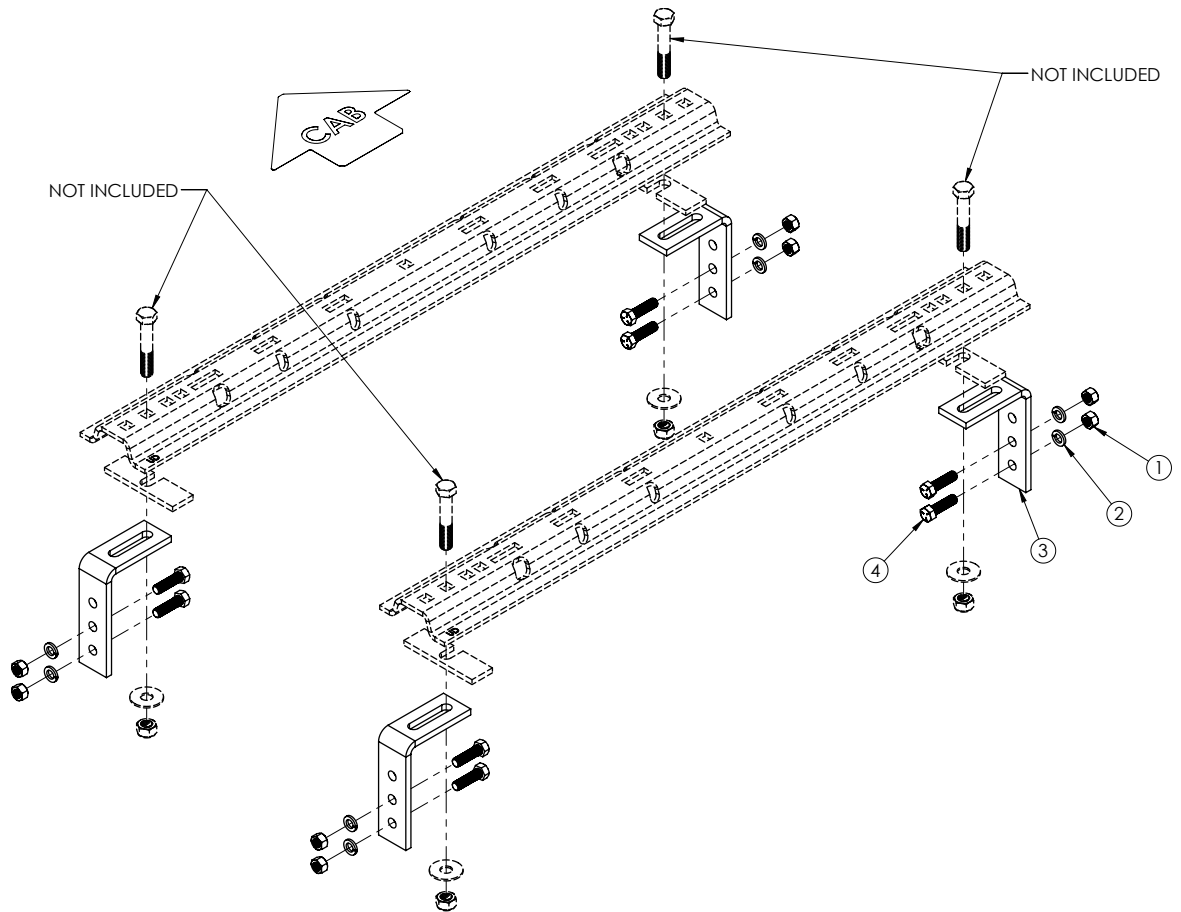


FRAME BRACKET 8552009

Ford, Chevrolet/GMC, Dodge & Toyota



ITEM	PART #	QTY	DESCRIPTION
1	00083	8	NUT, .50NC HEX
2	00084	8	WASHER, .50 LOCK
3	14189-76	4	411 FRAME BRACKET
4	14266	8	BOLT, .50NC X 1-3/4" HEX KNURLED GR.5
5	14238	1	FISH WIRE .50 (NOT SHOWN)

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

Introduction

8552009 General Assembly & Install Instructions

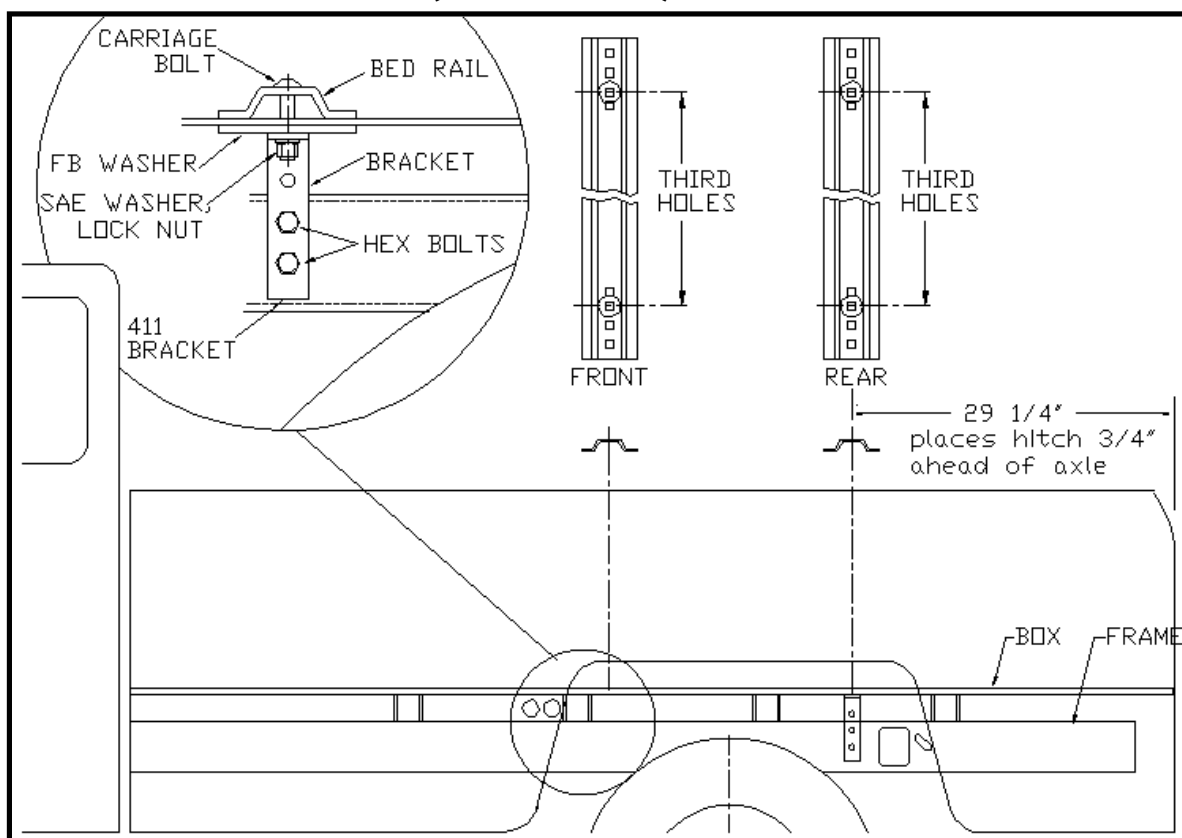
WARRANTY POLICY, OPERATOR MANUALS & REGISTRATION

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.			

**FORD: 1997-2003 F150 "LIGHT DUTY" (6-1/2' & 8' BOXES)
1997-2003 F250 "LIGHT DUTY" (6-1/2' & 8' BOXES)**



INSTALLATION

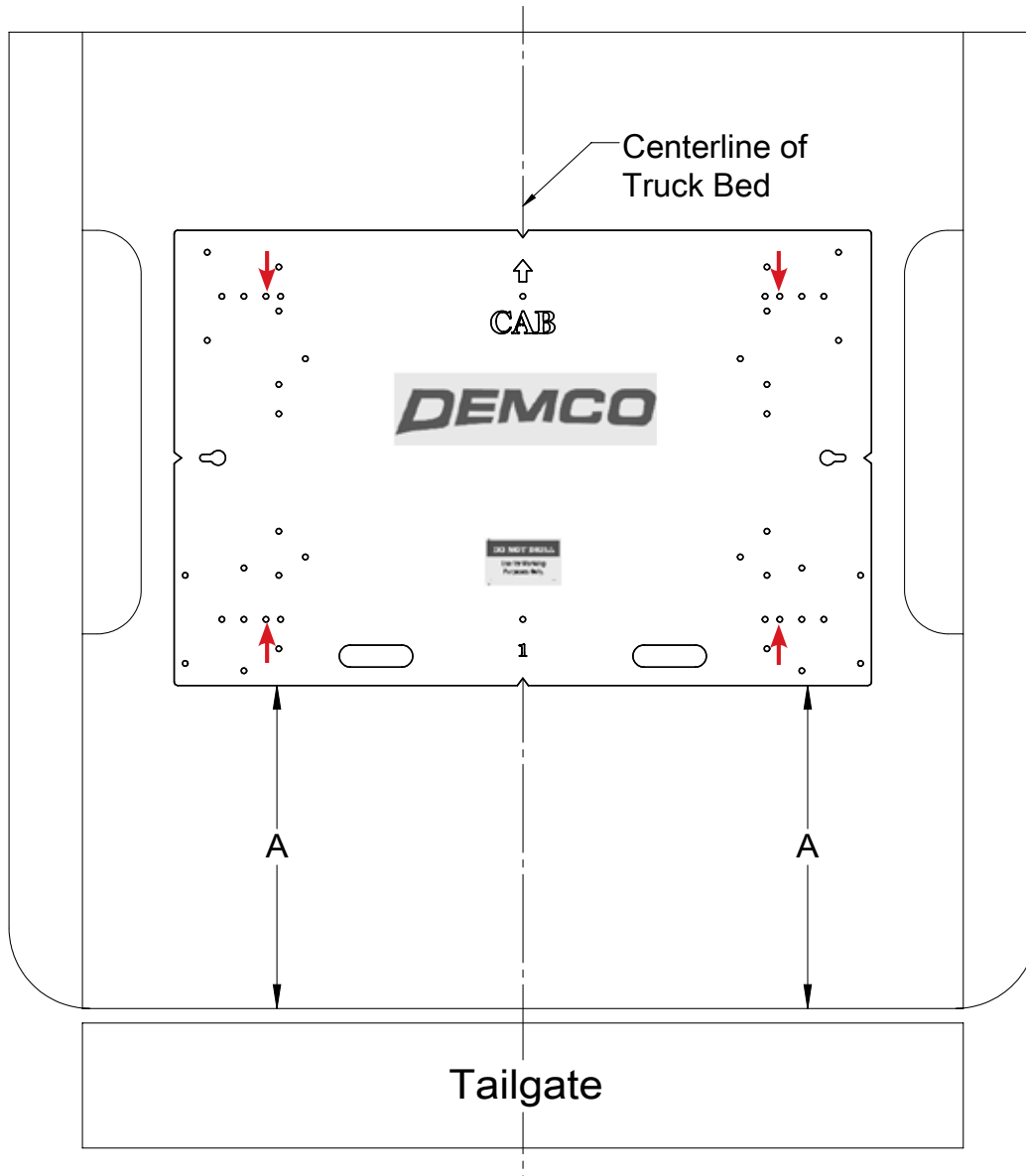
- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 29 1/4" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, THIRD HOLE POSITION, as shown. Drop in two bolts.
 - Drill two holes in REAR BED RAIL, THIRD HOLE POSITION. Drop in two bolts.
- Under box, loosely install washers (2" wide flat bar), 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" holes 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**.

**FORD: 1997-2003 F150 "LIGHT DUTY" (6-1/2' & 8' BOXES)
1997-2003 F250 "LIGHT DUTY" (6-1/2' & 8' BOXES)**

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.

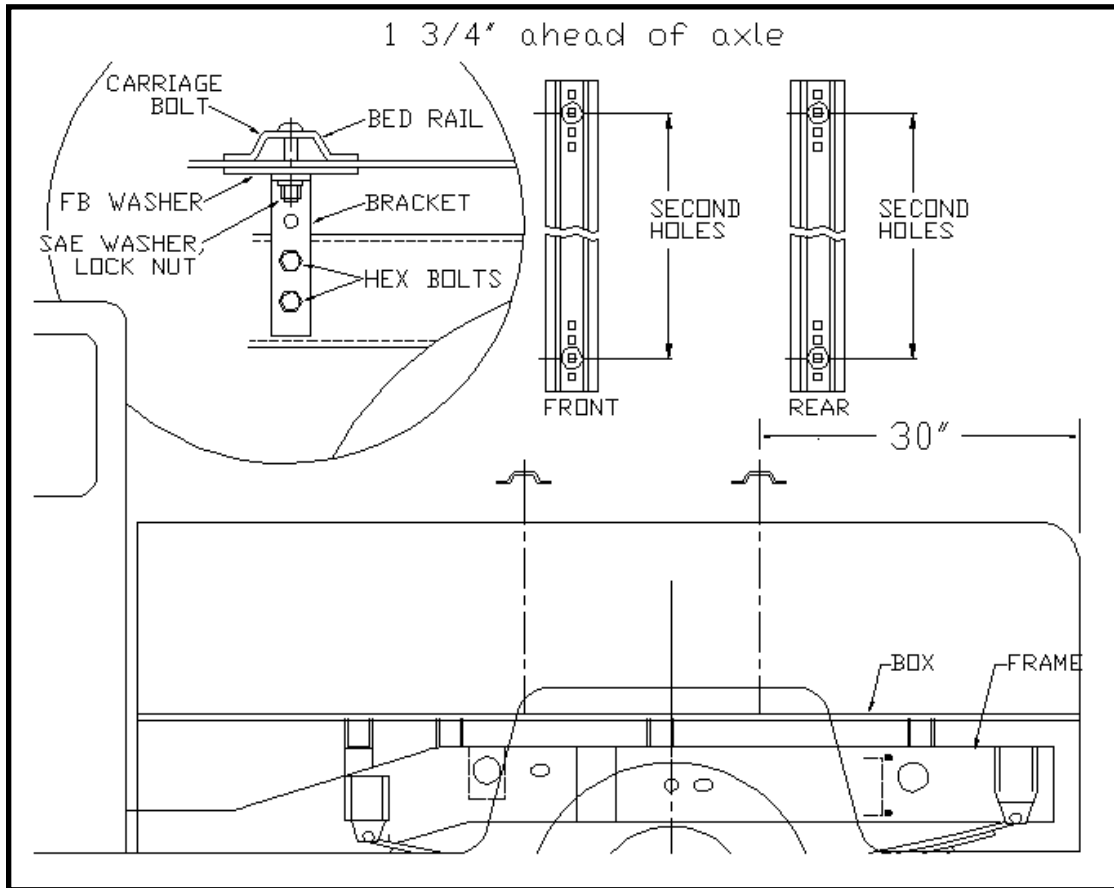
Truck Bed Drilling Instructions with Template



Drawing #1

BOX LENGTH	DIMENSIONS	MEASUREMENT
FORD 1997-2003 F150 "LIGHT DUTY"		
6-1/2'	A	*24-3/4"
8'	A	*24-3/4"
FORD 1997-2003 F250 "LIGHT DUTY"		
6-1/2'	A	*24-3/4"
8'	A	*24-3/4"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

CHEVROLET/GMC: 2001-2007 SILVERADO & SIERRA 2500 HD (6-1/2' BOX)



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 30" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
b. Drop in two bolts.
c. Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
4. a. Under box, place washers (2" wide flat bar) and frame brackets onto bolts.
b. Loosely install washers and lock nuts.
c. Press brackets tight against frame member; tighten nuts snug against box.
5. a. Pilot drill* and drill 1/2" holes 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**.

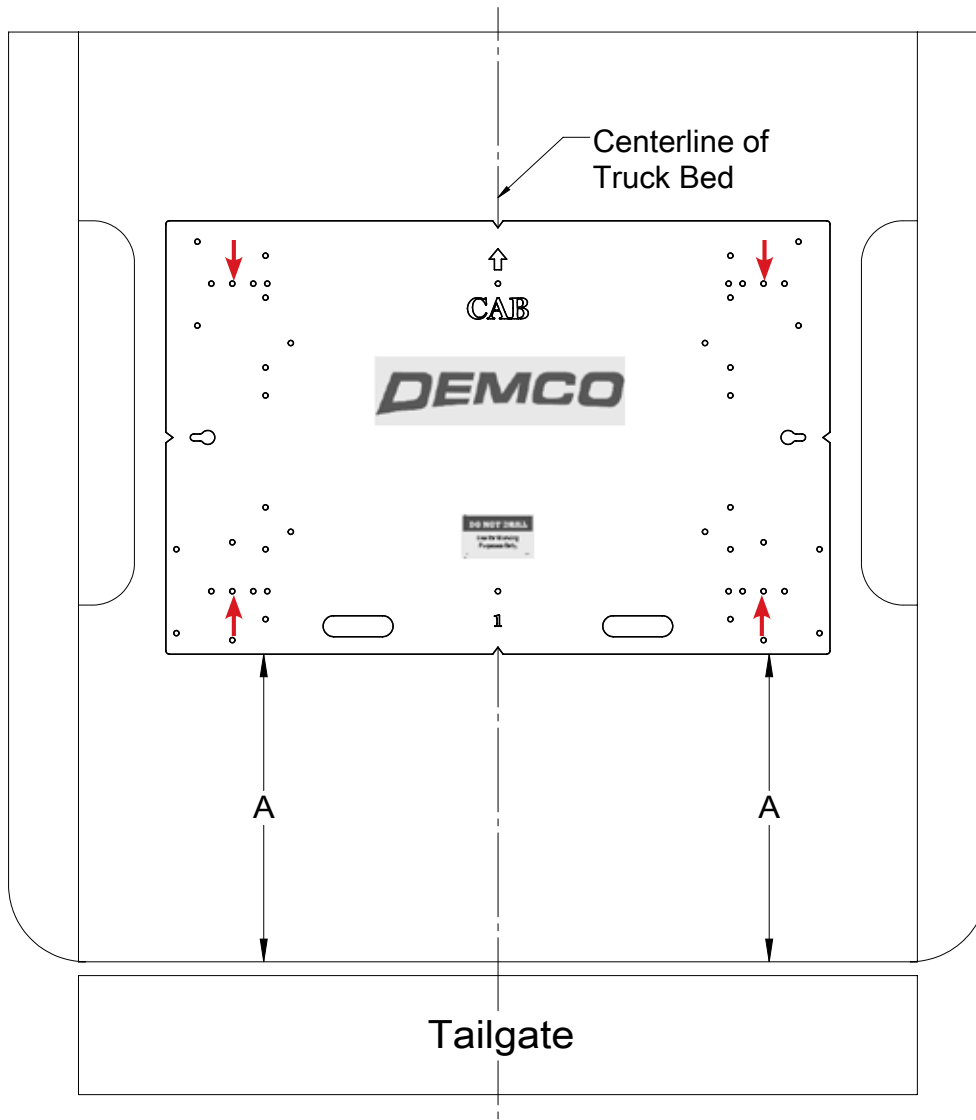
Installation

CHEVROLET/GMC: 2001-2007 SILVERADO & SIERRA 2500 HD (6-1/2' BOX)

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

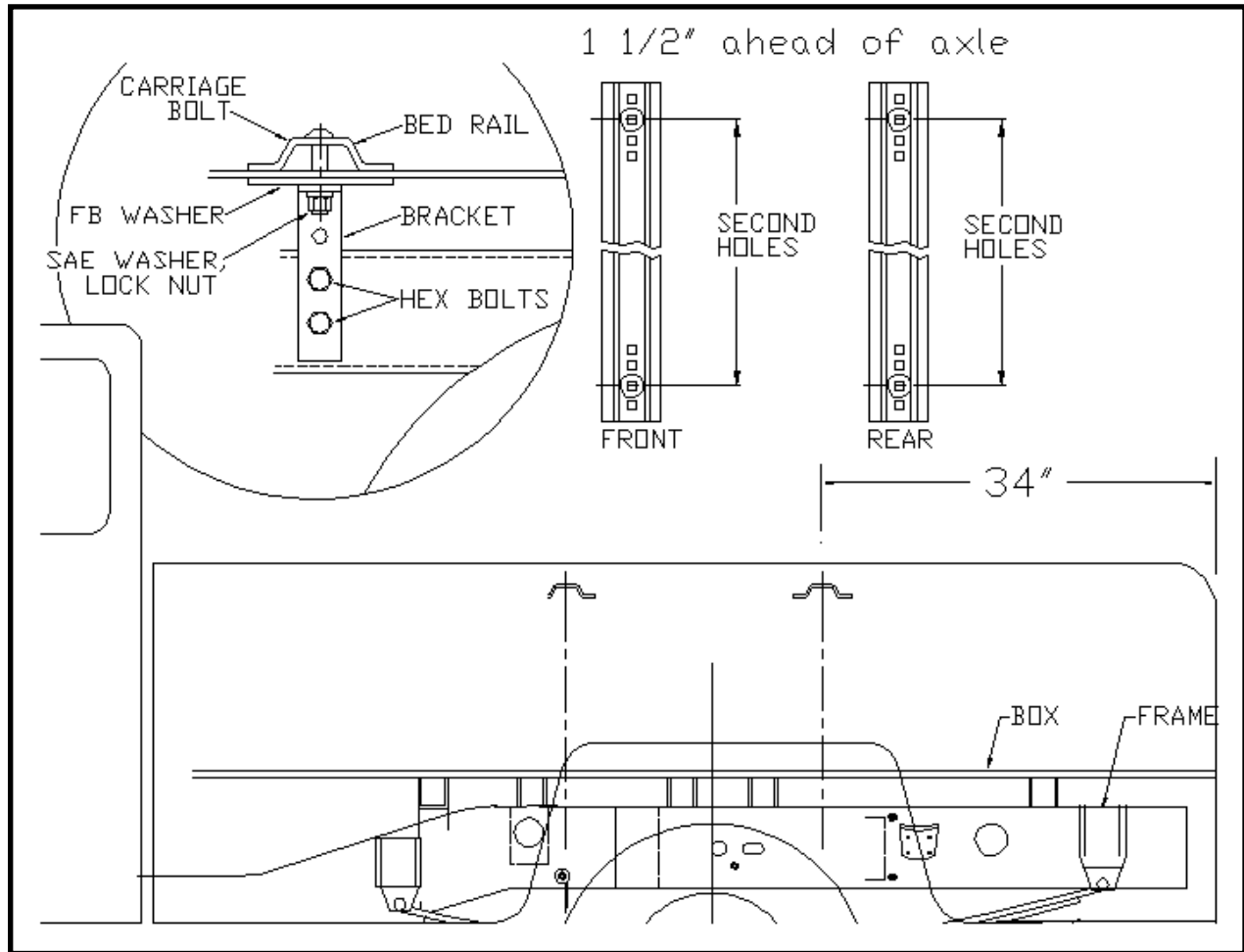


Drawing #2

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2001-2007 SILVERADO & SIERRA 2500 HD		
6-1/2'	A	*25-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

CHEVROLET/GMC: 2001-2007 SILVERADO & SIERRA 3500 HD (8' BOX)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 34" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - Drop in two bolts.
 - Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
- Under box, place washers (2" wide flat bar) and frame brackets onto bolts.
 - Loosely install washers and lock nuts.
 - Press brackets tight against frame member; tighten nuts snug against box.
- Pilot drill* and drill 1/2" holes 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**.

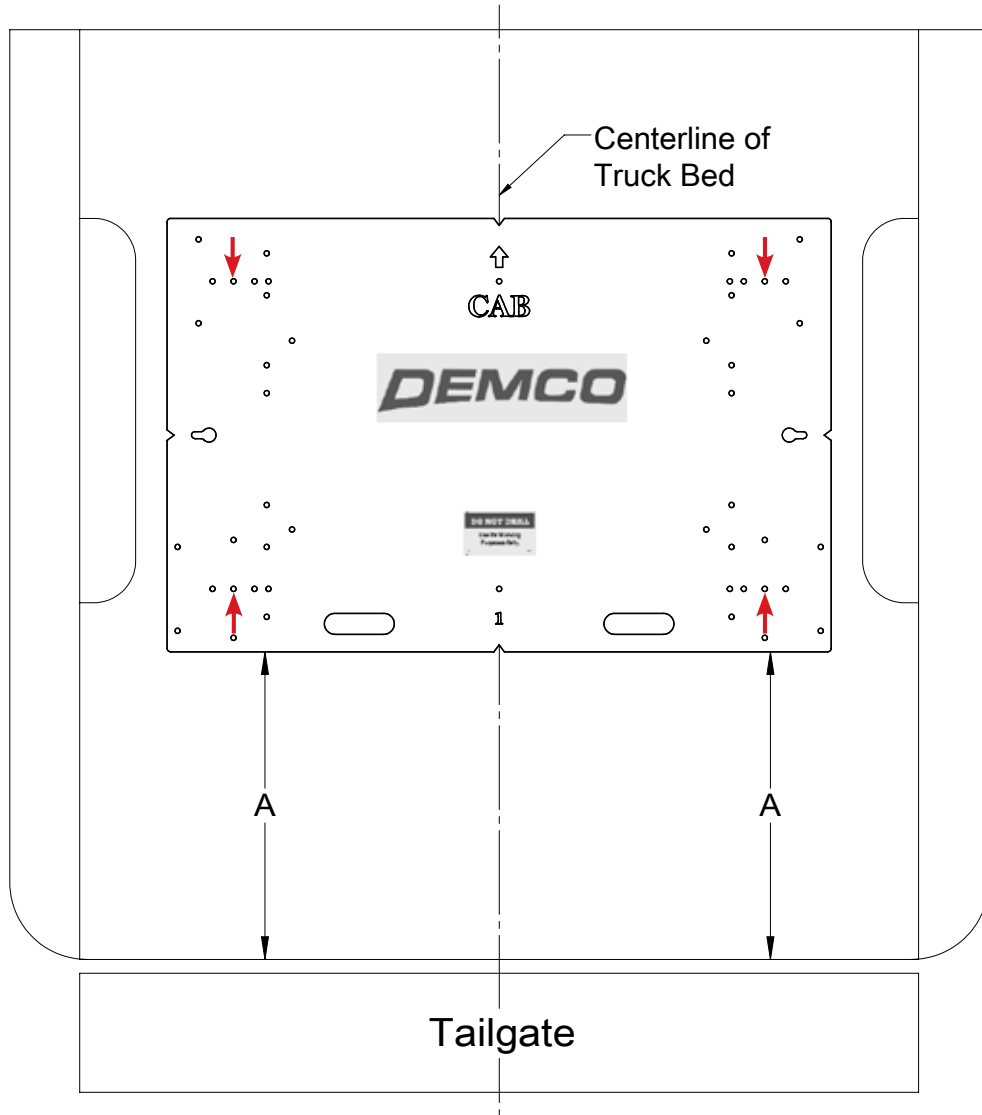
Truck Bed Drilling Instructions with Template

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 #3** 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

CHEVROLET/GMC: 2001-2007 SILVERADO & SIERRA 3500 HD (8' BOX)

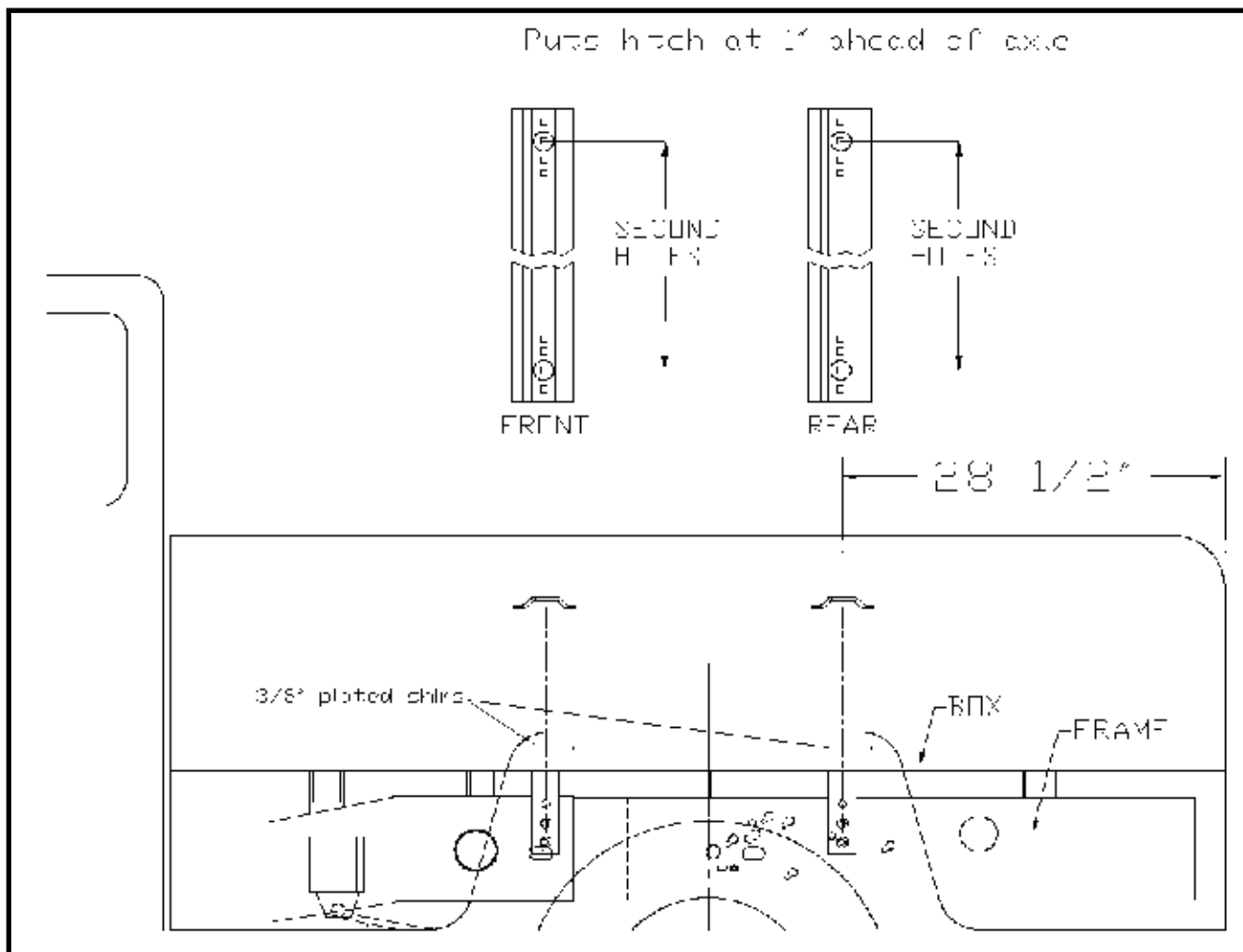
Truck Bed Drilling Instructions with Template



Drawing #3

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2001-2007 SILVERADO & SIERRA 3500 HD		
8'	A	*29-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 2500 HD (6-1/2' BOX NEW STYLE)



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 1/2" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3.
 - a. Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - b. Drop in two bolts.
 - c. Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
 - d. Place a plated shim under base rail in bed depression closest to each bolt (see above).
4.
 - a. Under box, place frame brackets onto bolts.
 - b. Loosely install washers and lock nuts.
 - c. Press brackets tight against frame member; tighten nuts snug against box.
5.
 - a. Pilot drill* and drill 1/2" holes 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.**

Installation

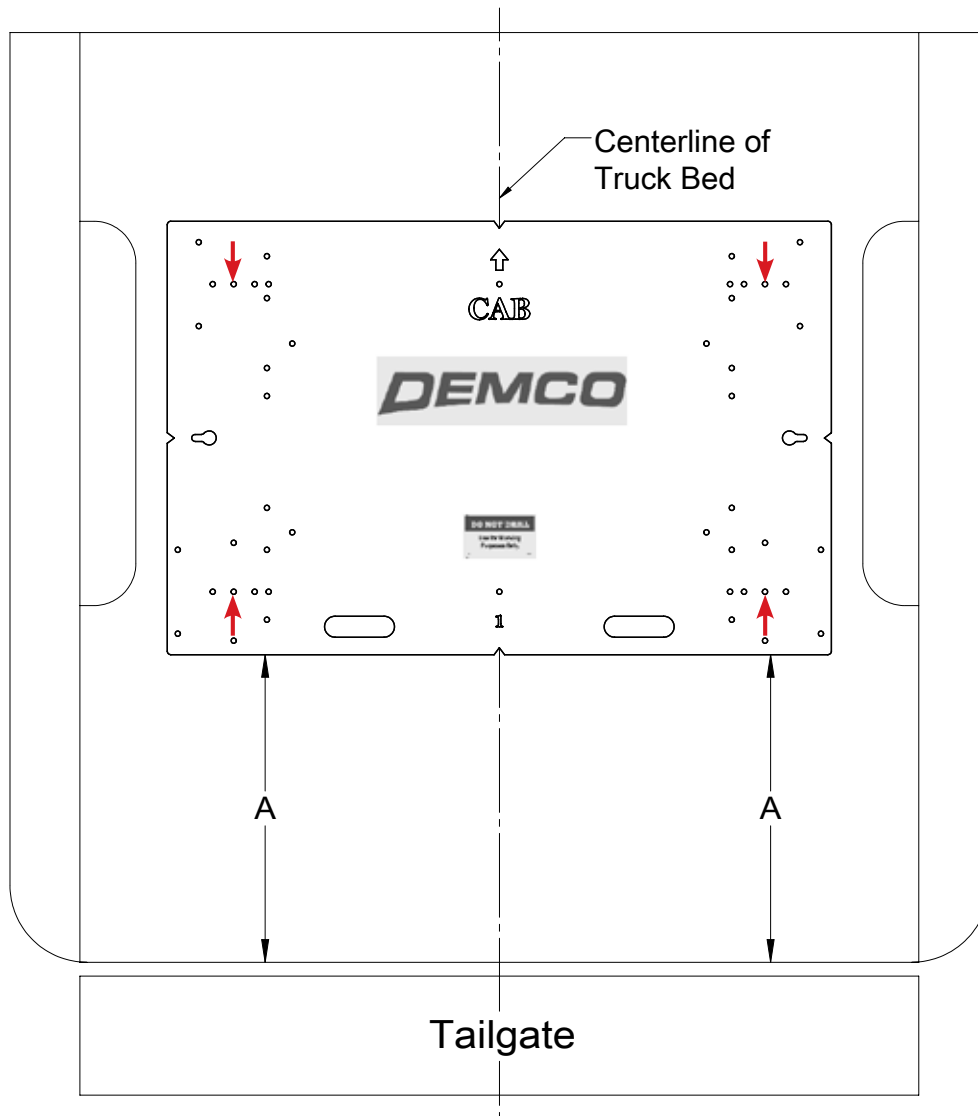
CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 2500 HD (6-1/2' BOX NEW STYLE)

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 #4** 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.

CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 2500 HD (6-1/2' BOX NEW STYLE)

Truck Bed Drilling Instructions with Template

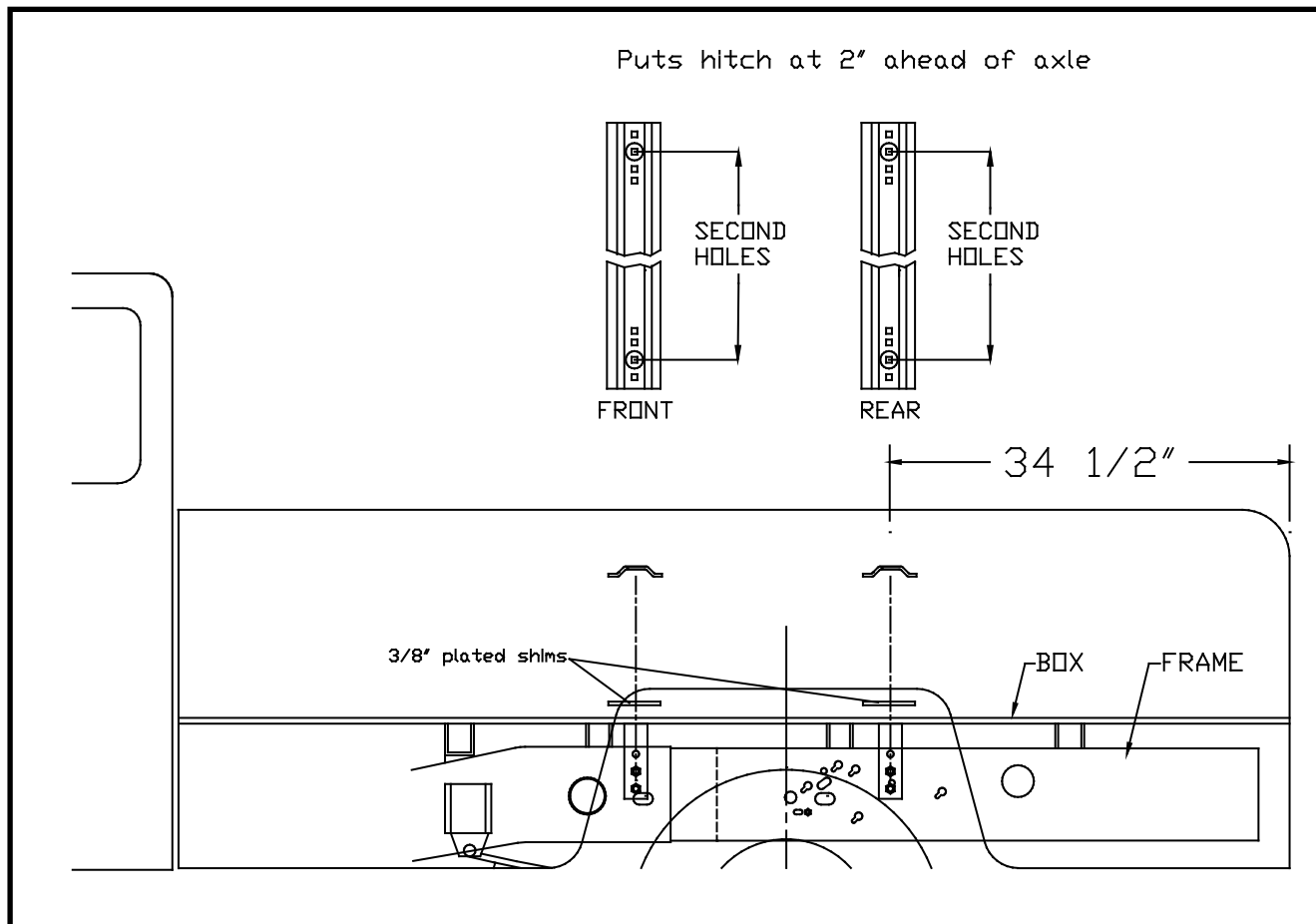


Drawing #4

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2007-2010 SILVERADO & SIERRA 2500 HD		
6-1/2' NEW STYLE	A	*24"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 2500 HD (8' BOX NEW STYLE)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 34 1/2" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - Drop in two bolts.
 - Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
 - Place a plated shim under base rail in bed depression closest to each bolt (see above).
- Under box, place frame brackets onto bolts.
 - Loosely install washers and lock nuts.
 - Press brackets tight against frame member; tighten nuts snug against box.
- Pilot drill* and drill 1/2" holes 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**.

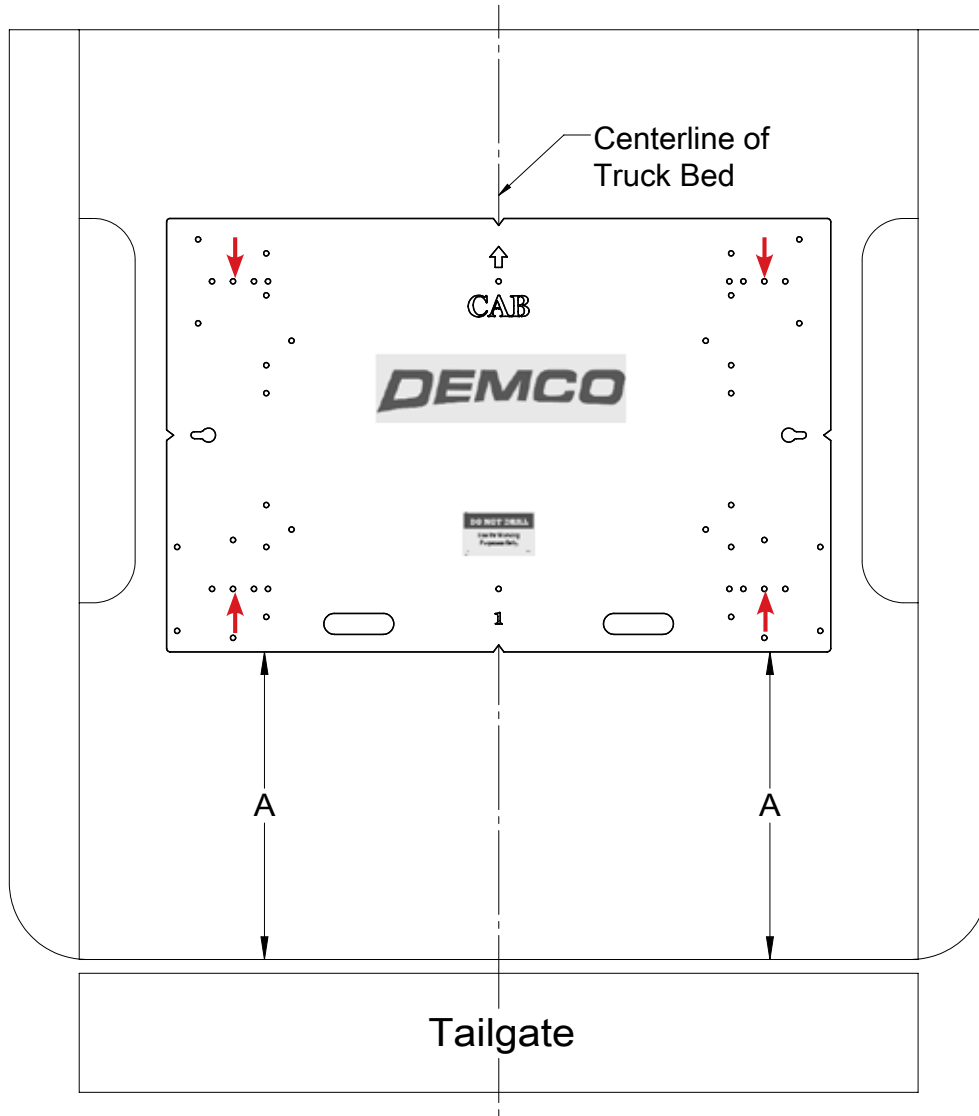
CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 2500 HD (8' BOX NEW STYLE)**Truck Bed Drilling Instructions with Template**

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 #5** 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

CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 2500 HD (8' BOX NEW STYLE)

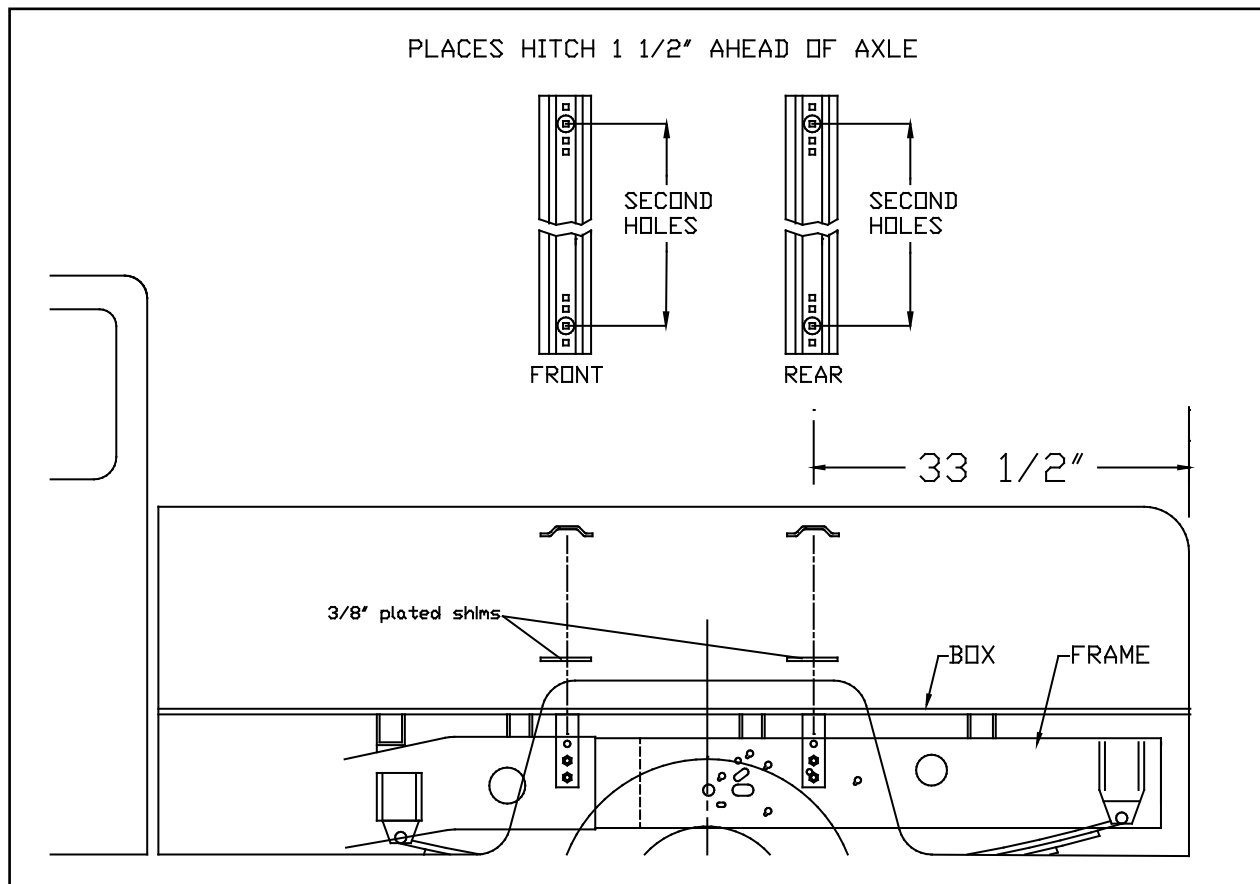
Truck Bed Drilling Instructions with Template



Drawing #5

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2007-2010 SILVERADO & SIERRA 2500 HD		
8' NEW STYLE	A	*30"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 3500 HD (8' BOX NEW STYLE)



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 33 1/2" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3.
 - a. Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - b. Drop in two bolts.
 - c. Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
 - d. Place a plated shim under base rail in bed depression closest to each bolt (see above).
4.
 - a. Under box, place frame brackets onto bolts.
 - b. Loosely install washers and lock nuts.
 - c. Press brackets tight against frame member; tighten nuts snug against box.
5.
 - a. Pilot drill* and drill 1/2" holes 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.**

Installation

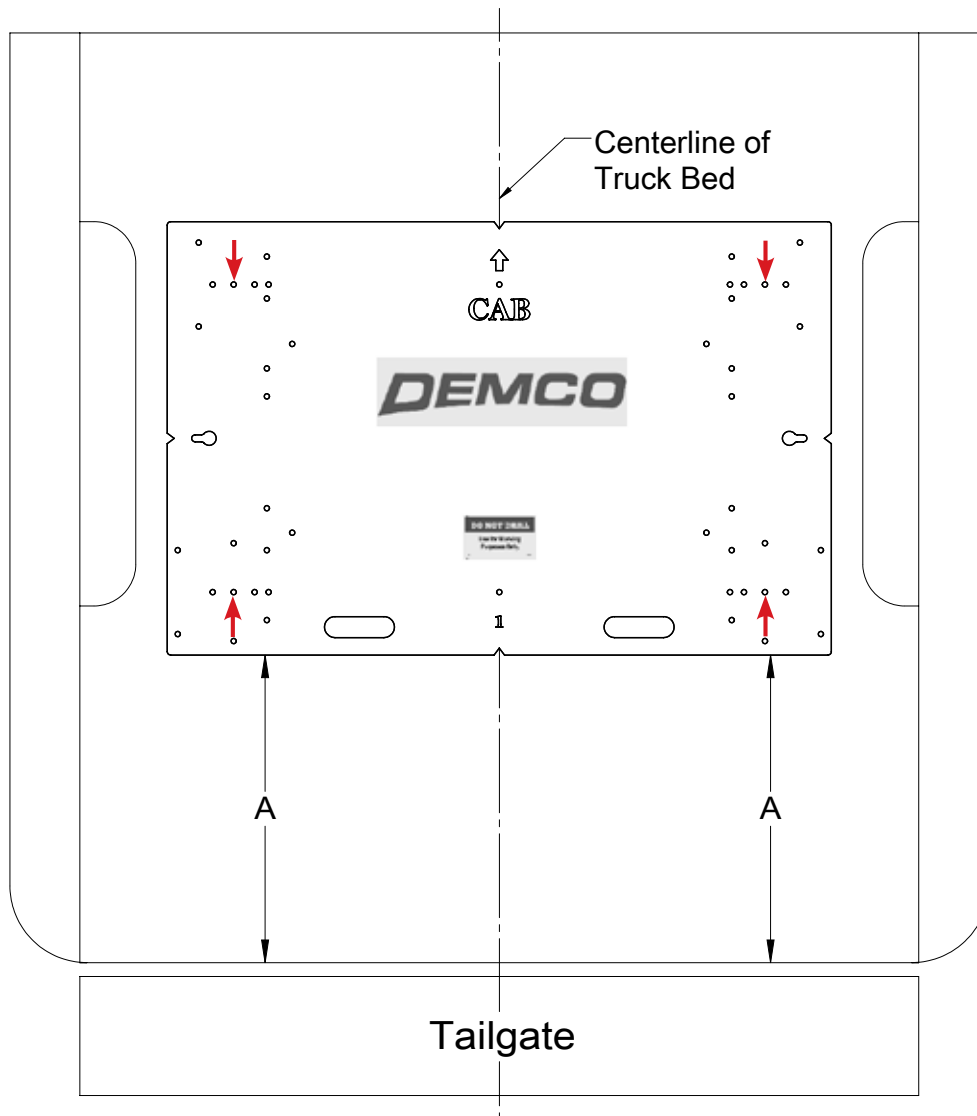
CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 3500 HD (8' BOX NEW STYLE)

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 #6** 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.

CHEVROLET/GMC: 2007-2010 SILVERADO & SIERRA 3500 HD (8' BOX NEW STYLE)

Truck Bed Drilling Instructions with Template

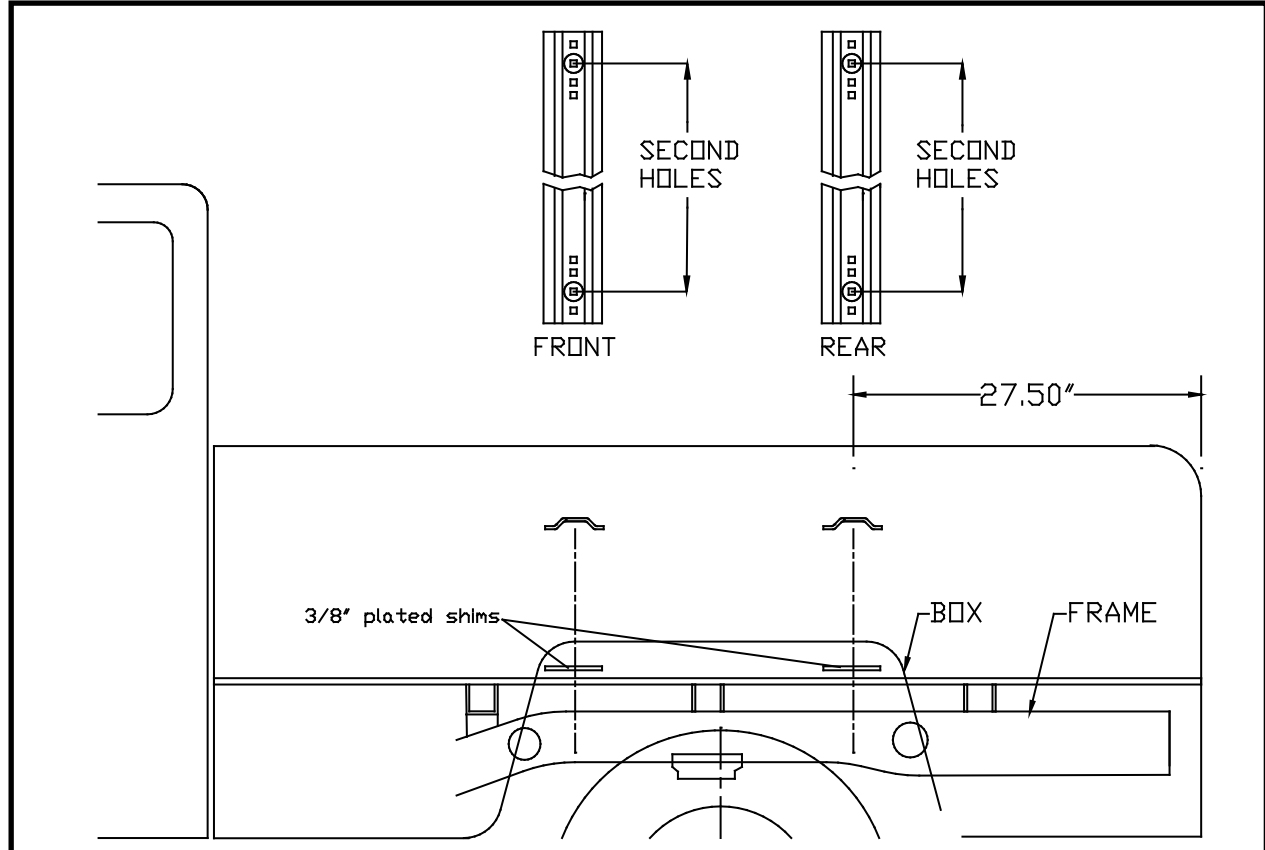


Drawing #6

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2007-2010 SILVERADO & SIERRA 3500 HD		
8' NEW STYLE	A	*29"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

CHEVROLET/GMC: 2007-2013 SILVERADO & SIERRA 1500 (5-1/2', 6-1/2' & 8' BOXES)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 27 1/2" for 5 1/2' & 6 1/2' box or 33 1/2" for 8' box from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - Drop in two bolts.
 - Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Slide 3/8" plated shims under base rails in valley closest to bolt at both ends.
- Under box, place washers (2" wide flat bar) and frame brackets onto bolt.
 - Loosely install washers and lock nuts.
 - Press brackets tight against frame member; tighten nuts snug against box.
- Brackets will be bolted onto frame by drilling frame and fishing knurl bolt thru frame with a fish wire and attach with hex nut and lock washer on outside of bracket. Use a 1/2" drill for holes. 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**.

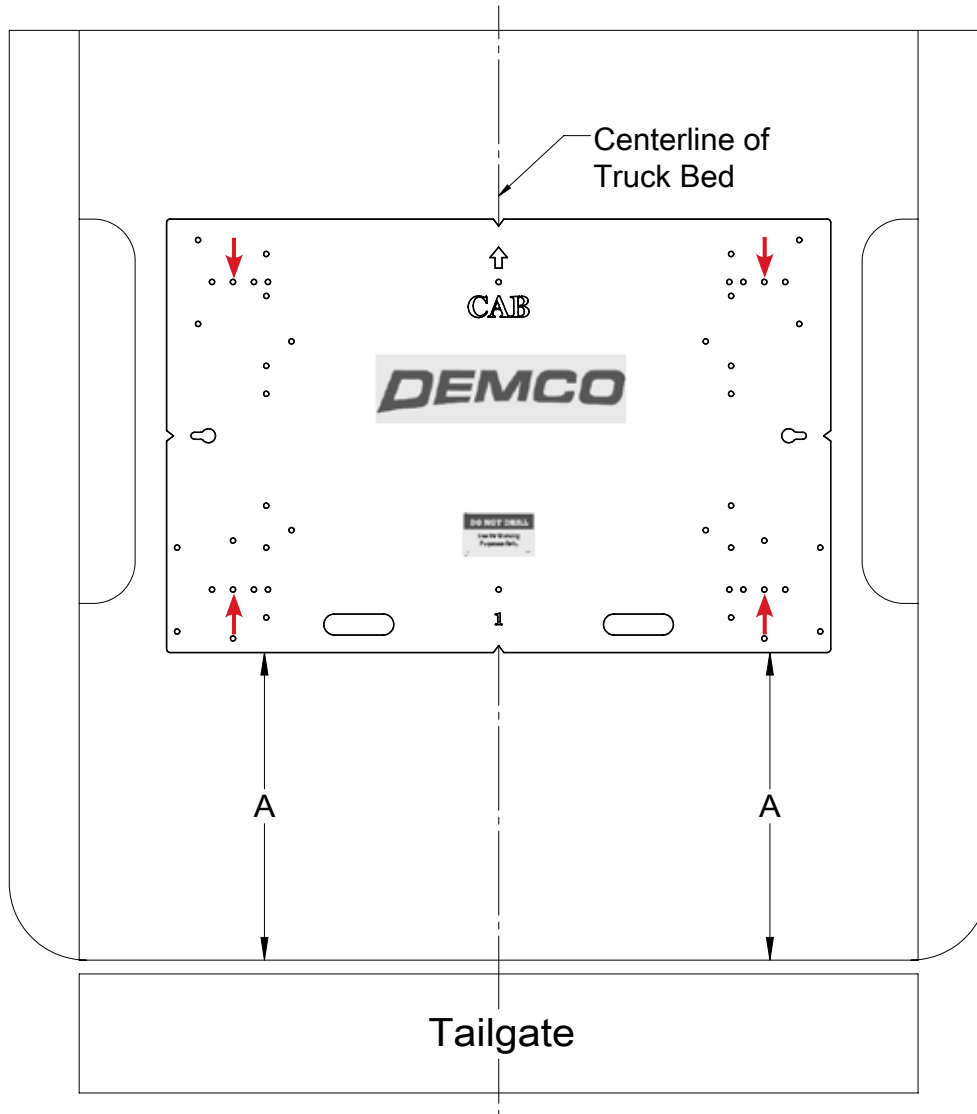
Truck Bed Drilling Instructions with Template

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 #7** 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

CHEVROLET/GMC: 2007-2013 SILVERADO & SIERRA 1500 (5-1/2', 6-1/2' & 8' BOXES)

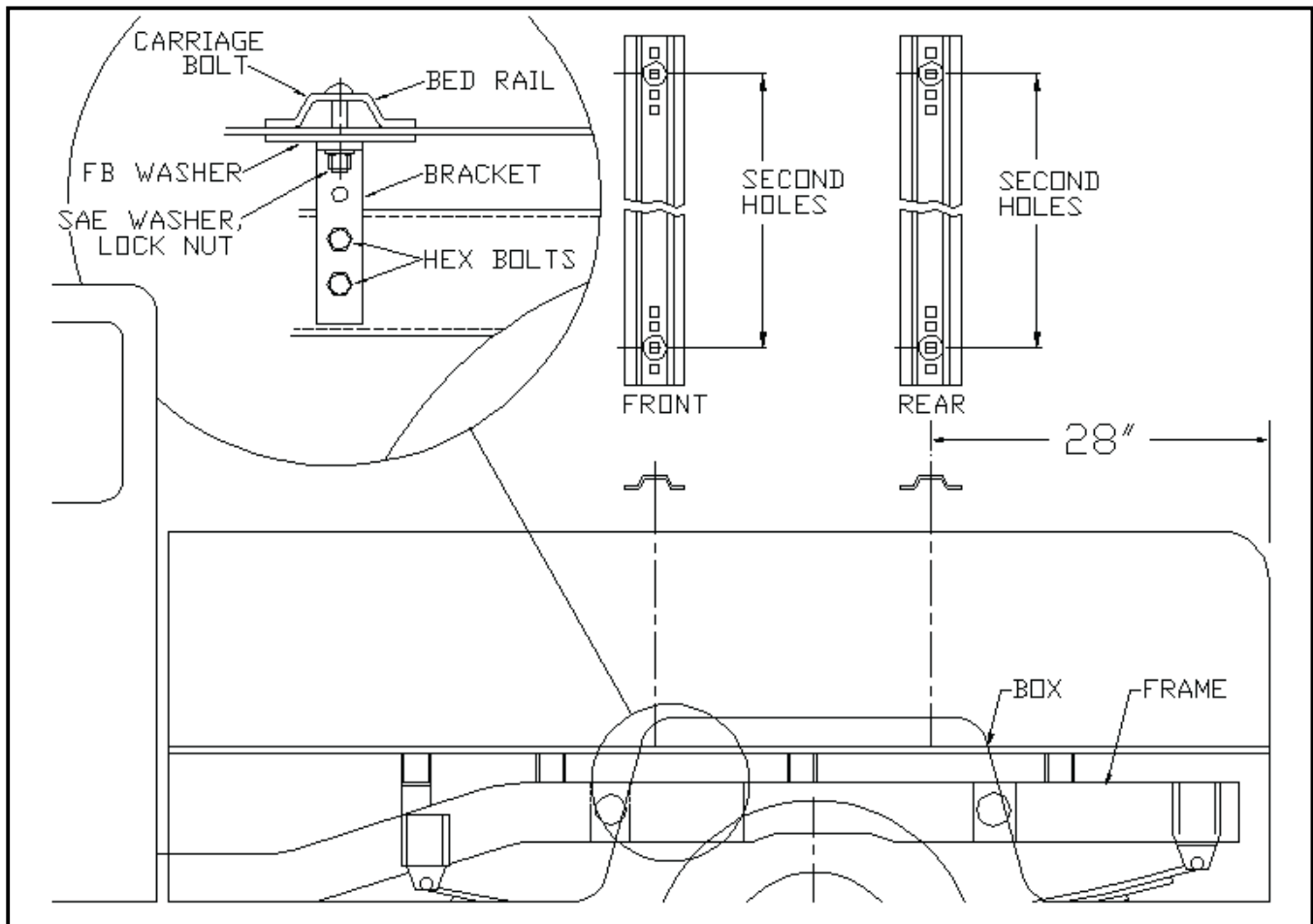
Truck Bed Drilling Instructions with Template



Drawing #7

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2007-2013 SILVERADO & SIERRA 1500		
5-1/2'	A	*23"
6-1/2'	A	*23"
8'	A	*29"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

**CHEVROLET/GMC: 1999-2007 SILVERADO & SIERRA 1500/1500HD (5-1/2' & 6-1/2' BOXES)
1999-2007 SILVERADO & SIERRA 2500 (6-1/2' BOX)**



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 obstructions (frame members, etc.).
3.
 - a. Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - b. Drop in two bolts.
 - c. Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
4.
 - a. Under box, place washers (2" wide flat bar) and frame brackets onto bolts.
 - b. Loosely install washers and lock nuts.
 - c. Press brackets tight against frame member; tighten nuts snug against box.
5.
 - a. Pilot drill* and drill 1/2" holes 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.**

Installation

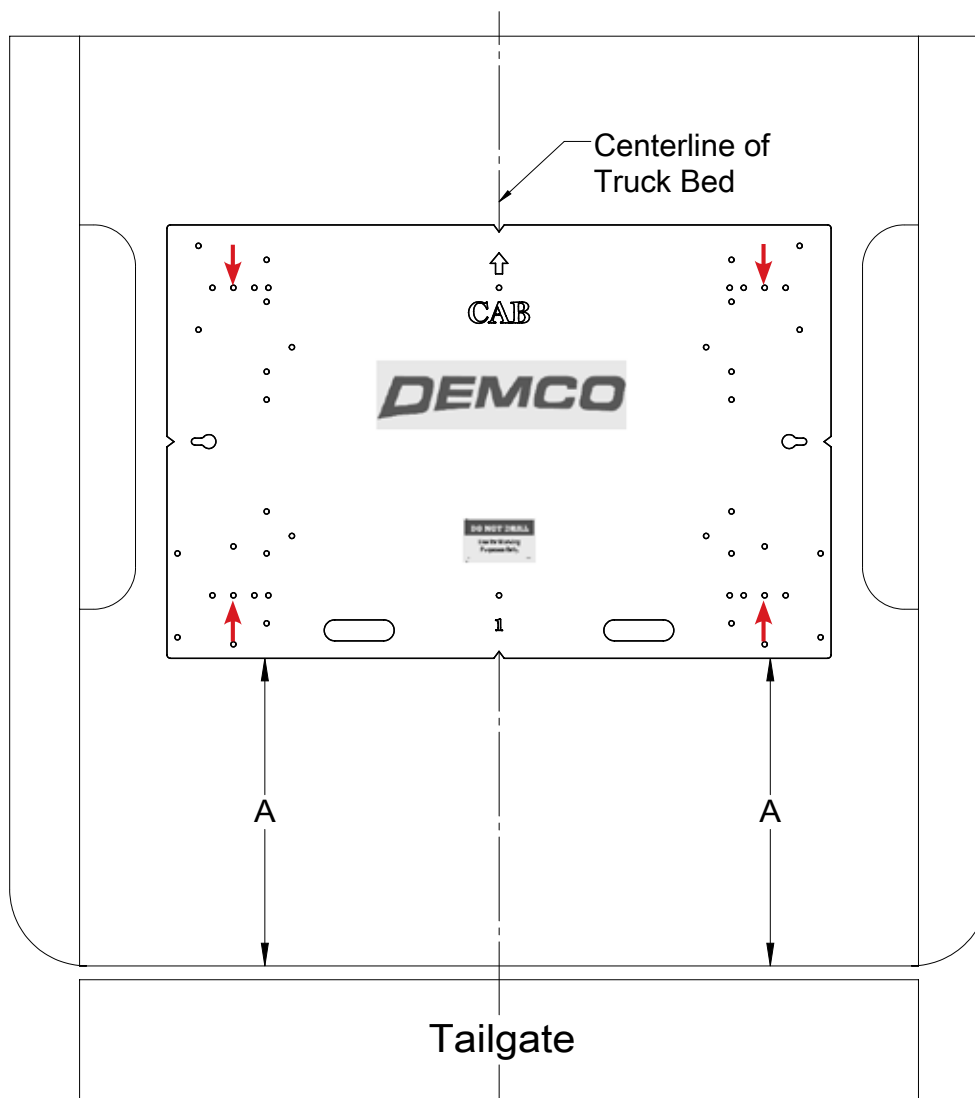
CHEVROLET/GMC: 1999-2007 SILVERADO & SIERRA 1500/1500HD (5-1/2' & 6-1/2' BOXES)
1999-2007 SILVERADO & SIERRA 2500 (6-1/2' BOX)

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 #8** 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.

**CHEVROLET/GMC: 1999-2007 SILVERADO & SIERRA 1500/1500HD (5-1/2' & 6-1/2' BOXES)
1999-2007 SILVERADO & SIERRA 2500 (6-1/2' BOX)**

Truck Bed Drilling Instructions with Template

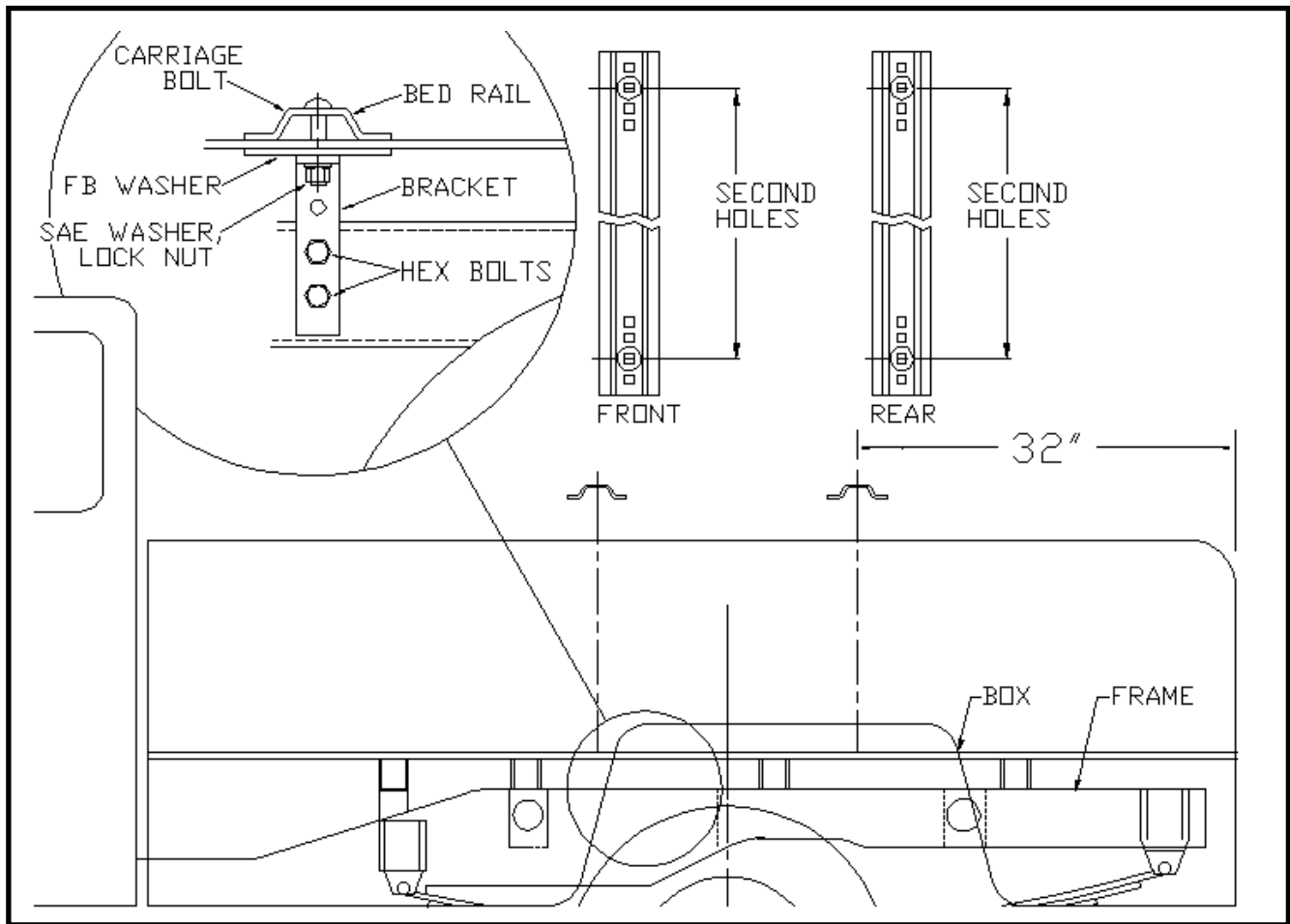


Drawing #8

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 1999-2007 SILVERADO & SIERRA 1500/1500HD		
5-1/2'	A	*23-1/2"
6-1/2'	A	*23-1/2"
CHEVROLET/GMC 1999-2007 SILVERADO & SIERRA 2500		
6-1/2"	A	*23-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

CHEVROLET/GMC: 1999-2007 SILVERADO & SIERRA 1500/2500 (8' BOX)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 32" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - Drop in two bolts.
 - Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
- Under box, place washers (2" wide flat bar) and frame brackets onto bolts.
 - Loosely install washers and lock nuts.
 - Press brackets tight against frame member; tighten nuts snug against box.
- Pilot drill* and drill 1/2" holes 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**.

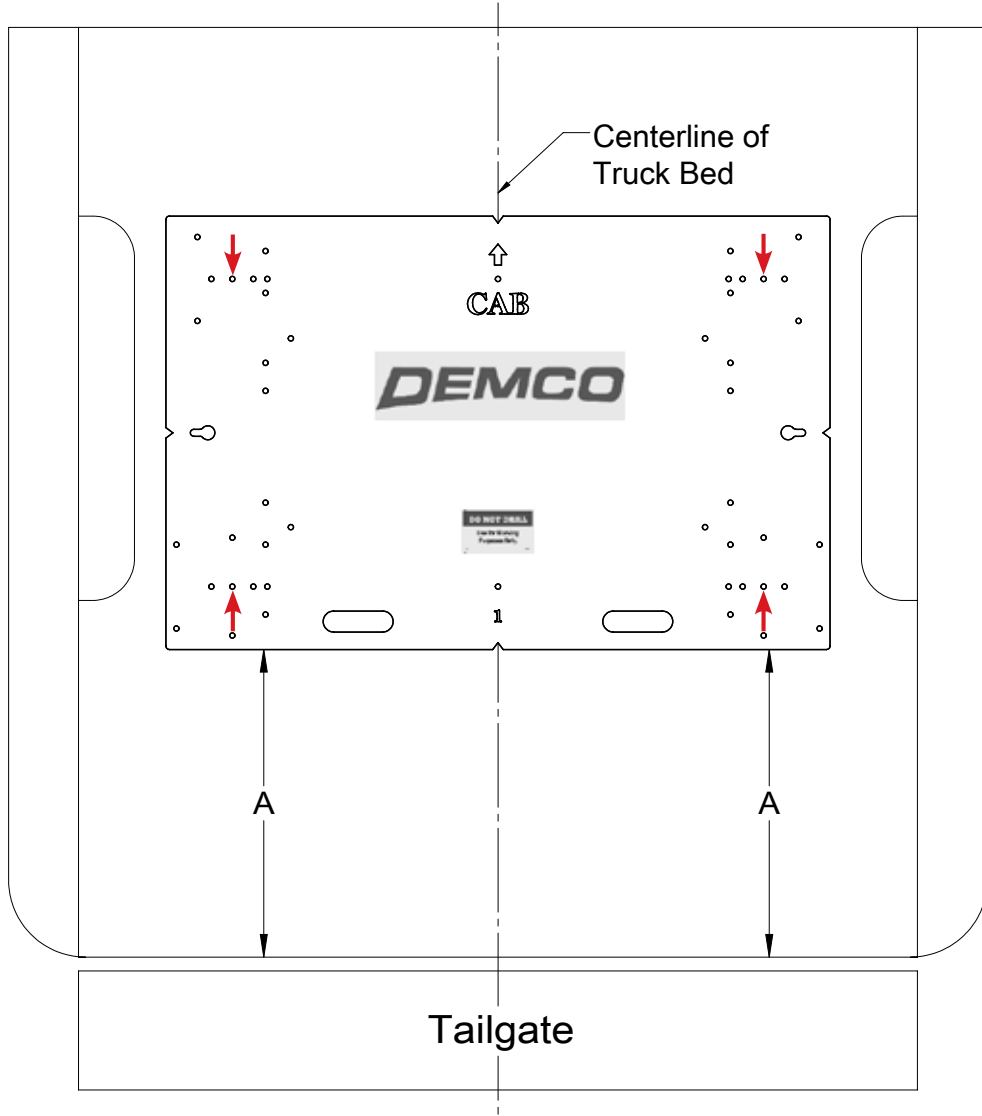
Truck Bed Drilling Instructions with Template

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 #9** 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

CHEVROLET/GMC: 1999-2007 SILVERADO & SIERRA 1500/2500 (8' BOX)

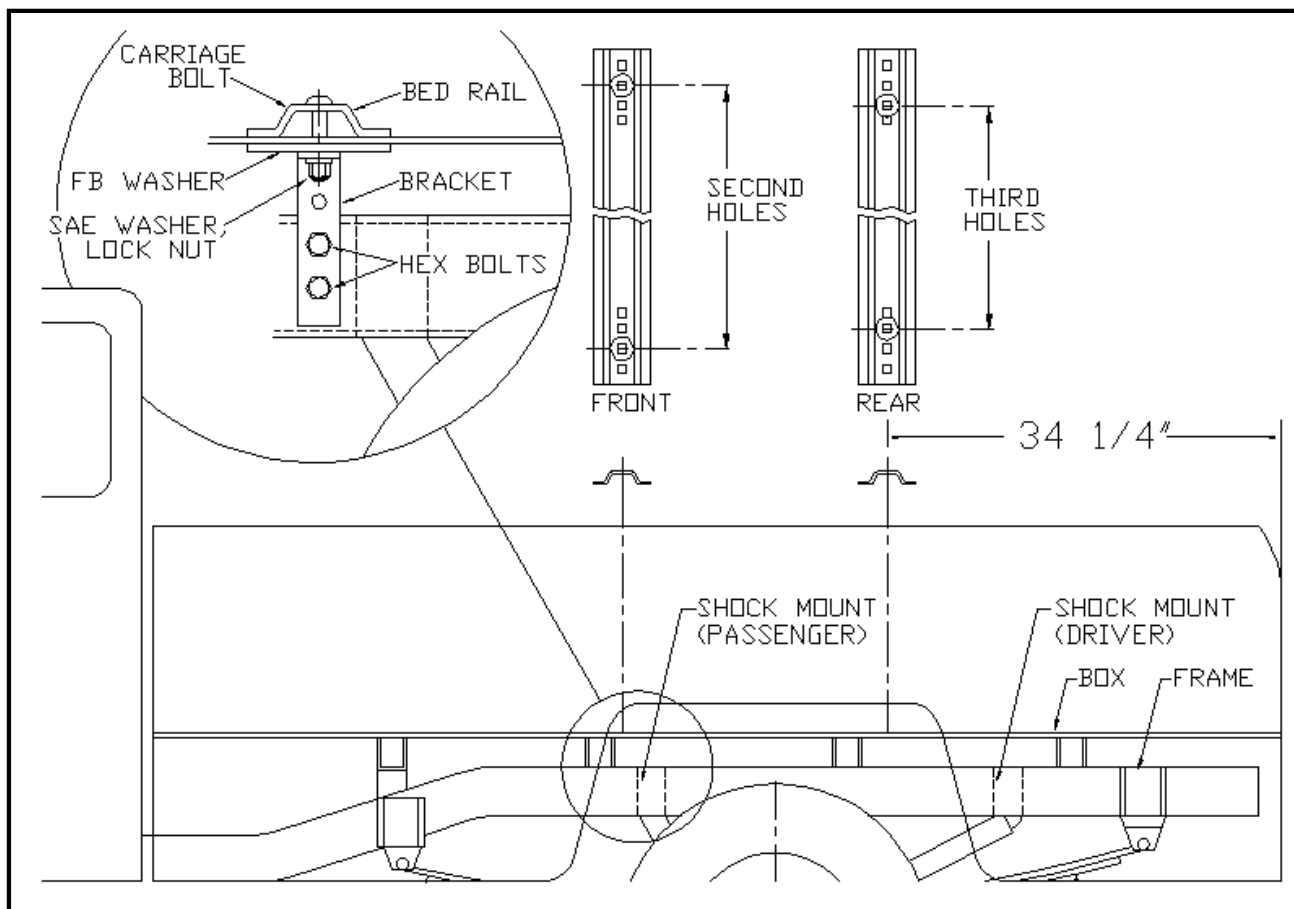
Truck Bed Drilling Instructions with Template



Drawing #9

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 1999-2007 SILVERADO & SIERRA 1500/2500		
8'	A	*27-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

CHEVROLET/GMC: 1988-1998 SILVERADO & SIERRA 1500/2500 (8' BOX) 1988-2000 SILVERADO & SIERRA 3500 (8' BOX)



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 34 1/4" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3.
 - a. Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - b. Drop in two bolts.
 - c. Drill two holes in REAR BED RAIL, THIRD HOLE POSITION. Drop in two bolts.
4.
 - a. Under box, place washers (2" wid flat bar) and frame brackets onto bolts.
 - b. Loosely install washers and lock nuts.
 - c. Press brackets tight against frame member; tighten nuts snug against box.
5.
 - a. Pilot drill* and drill 1/2" holes 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**.

Installation

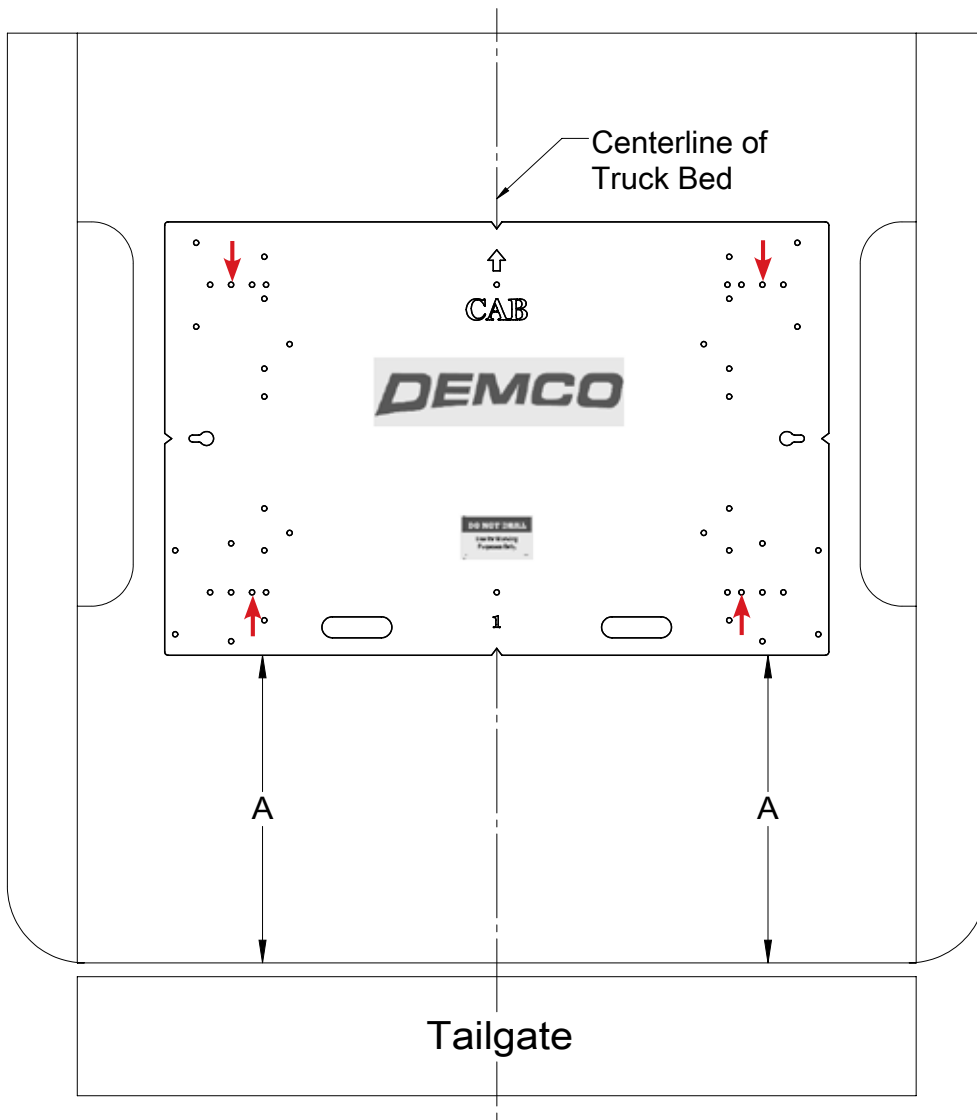
CHEVROLET/GMC: 1988-1998 SILVERADO & SIERRA 1500/2500 (8' BOX)
1988-2000 SILVERADO & SIERRA 3500 (8' BOX)

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 #10** 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.

**CHEVROLET/GMC: 1988-1998 SILVERADO & SIERRA 1500/2500 (8' BOX)
1988-2000 SILVERADO & SIERRA 3500 (8' BOX)**

Truck Bed Drilling Instructions with Template

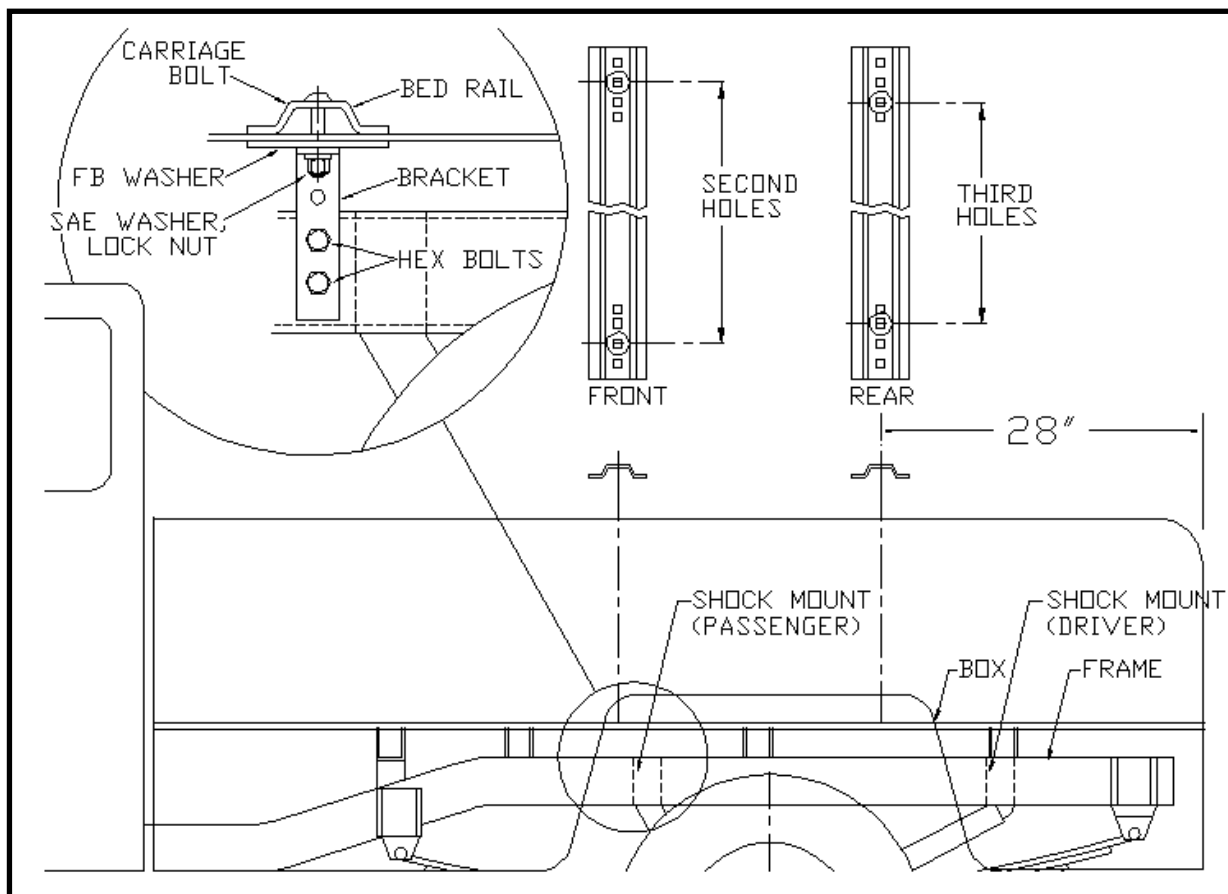


Drawing #10

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 1988-1998 SILVERADO & SIERRA 1500/2500		
8'	A	*29-3/4"
CHEVROLET/GMC 1988-2000 SILVERADO & SIERRA 3500		
8'	A	*29-3/4"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

CHEVROLET/GMC: 1988-1999 SILVERADO & SIERRA 1500 (5-1/2' & 6-1/2' BOXES)
1988-1999 SILVERADO & SIERRA 2500 (6-1/2' BOX)
2003-2007 1500 & 1500 HD (5-1/2' & 6-1/2' BOXES)
1998-2000 3500 (6-1/2' BOX)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 28" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - Drop in two bolts.
 - Drill two holes in REAR BED RAIL, THIRD HOLE POSITION. Drop in two bolts.
- Under box, place washers (2" wide flat bar) and frame brackets onto bolts.
 - Loosely install washers and lock nuts.
 - Press brackets tight against frame member; tighten nuts snug against box.
- Pilot drill* and drill 1/2" holes 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**.

CHEVROLET/GMC: 1988-1999 SILVERADO & SIERRA 1500 (5-1/2' & 6-1/2' BOXES)
1988-1999 SILVERADO & SIERRA 2500 (6-1/2' BOX)
2003-2007 1500 & 1500 HD (5-1/2' & 6-1/2' BOXES)
1998-2000 3500 (6-1/2' BOX)

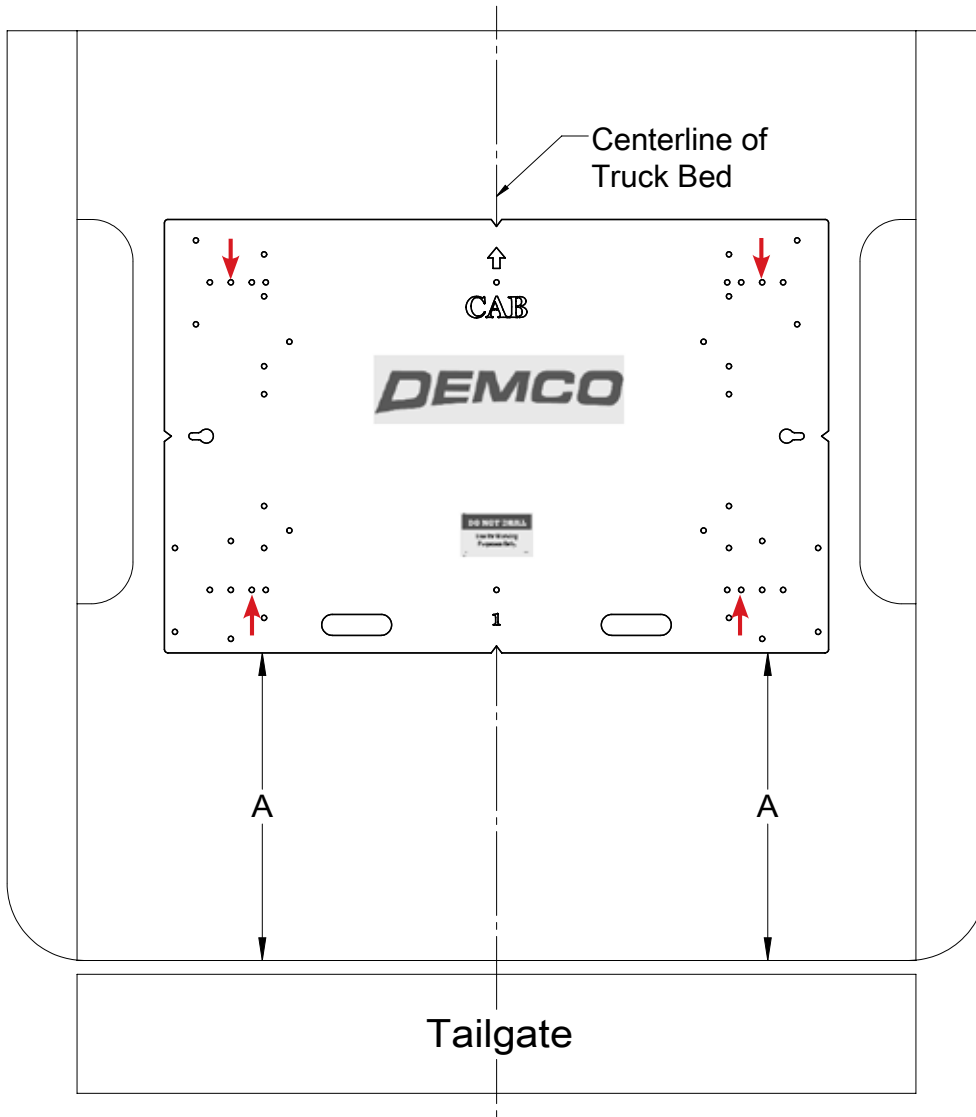
Truck Bed Drilling Instructions with Template

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 #11** 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

CHEVROLET/GMC: 1988-1999 SILVERADO & SIERRA 1500 (5-1/2' & 6-1/2' BOXES)
1988-1999 SILVERADO & SIERRA 2500 (6-1/2' BOX)
2003-2007 1500 & 1500 HD (5-1/2' & 6-1/2' BOXES)
1998-2000 3500 (6-1/2' BOX)

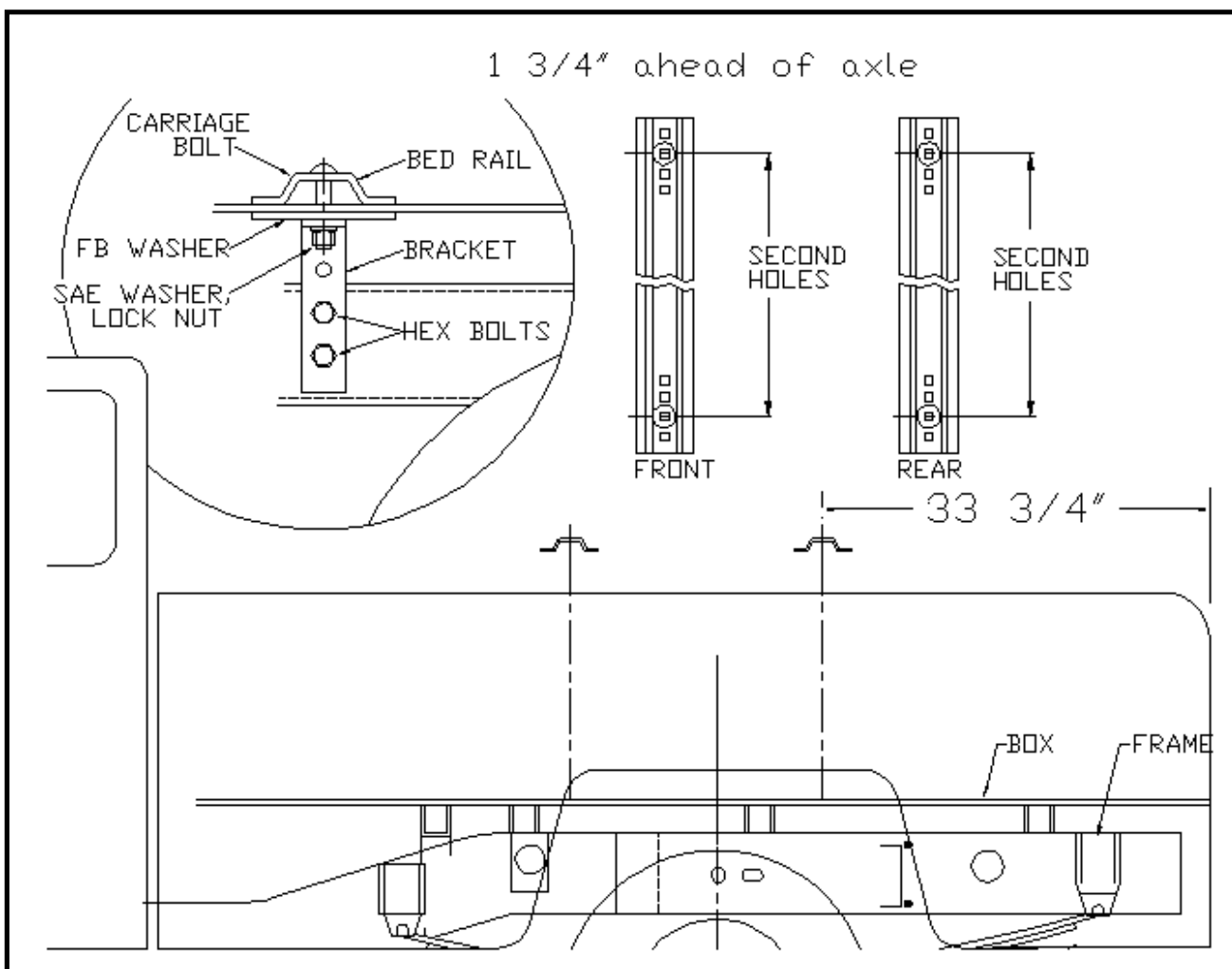
Truck Bed Drilling Instructions with Template



Drawing #11

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 1988-1999 SILVERADO & SIERRA 1500		
5-1/2'	A	*23-1/2"
6-1/2'	A	*23-1/2"
CHEVROLET/GMC 1988-1999 SILVERADO & SIERRA 2500		
6-1/2'	A	*29-3/4"
CHEVROLET/GMC 2003-2007 1500 & 1500 HD		
5-1/2'	A	*23-1/2"
6-1/2'	A	*23-1/2"
CHEVROLET/GMC 1998-2000 3500		
6-1/2'	A	*23-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

CHEVROLET/GMC: 2001-2007 SILVERADO & SIERRA 2500 HD (8' BOX)



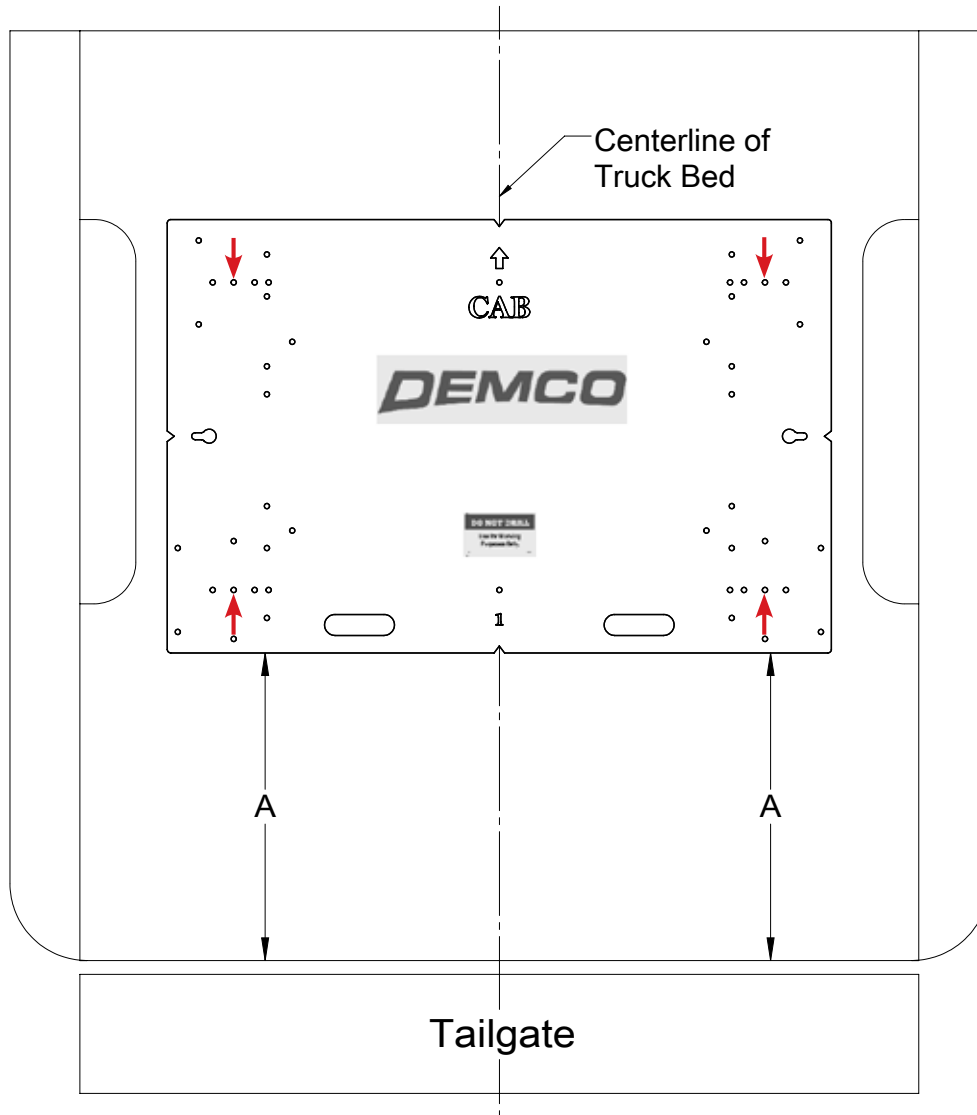
INSTALLATION

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 33 3/4" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3.
 - a. Drill two 5/8" holes thru FRONT BED RAIL, SECOND HOLE POSITION, as shown.
 - b. Drop in two bolts.
 - c. Drill two holes in REAR BED RAIL, SECOND HOLE POSITION. Drop in two bolts.
4.
 - a. Under box, place washers (2" wid flat bar) and frame brackets onto bolts.
 - b. Loosely install washers and lock nuts.
 - c. Press brackets tight against frame member; tighten nuts snug against box.
5.
 - a. Pilot drill* and drill 1/2" holes 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.**)

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 #12** 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



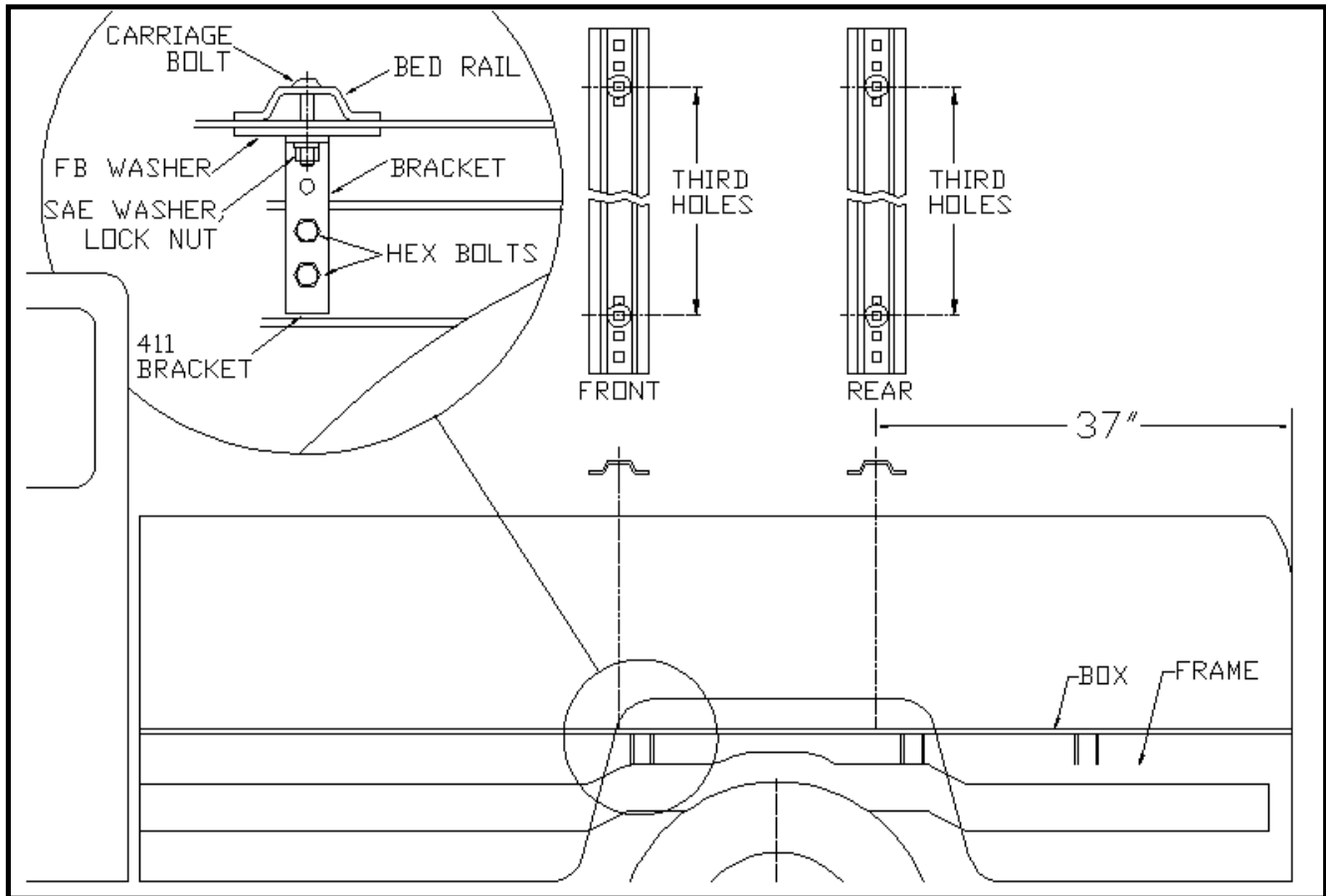
Drawing #12

BOX LENGTH	DIMENSIONS	MEASUREMENT
CHEVROLET/GMC 2001-2007 SILVERADO & SIERRA 2500 HD		
8'	A	*29-1/4"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

DODGE:

1993 & EARLIER RAM



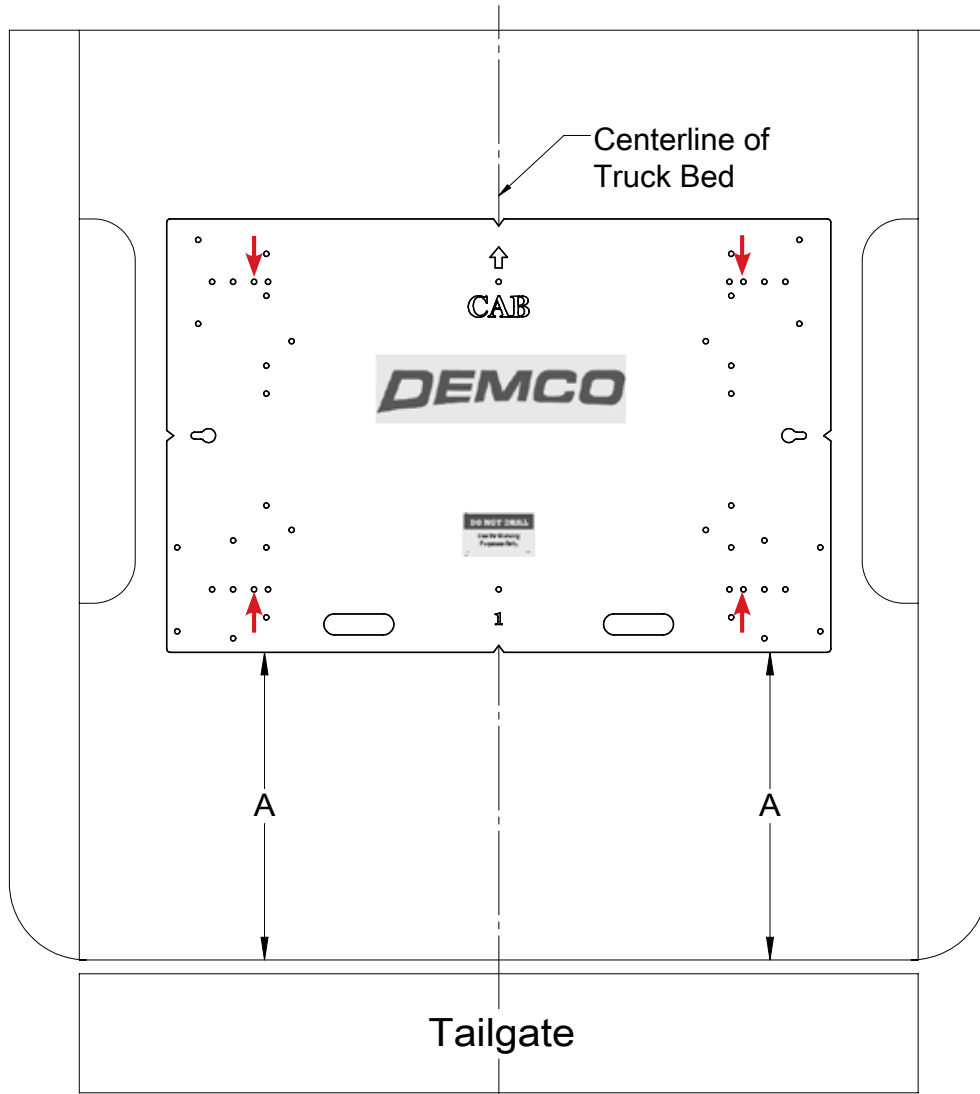
INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 37" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, THIRD HOLE POSITION, as shown.
 - Drop in two bolts.
 - Drill two holes in REAR BED RAIL, THIRD HOLE POSITION. Drop in two bolts.
- Under box, place washers (2" wid flat bar), 411 frame brackets, flat washer 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" holes 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**.

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 #13** 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.

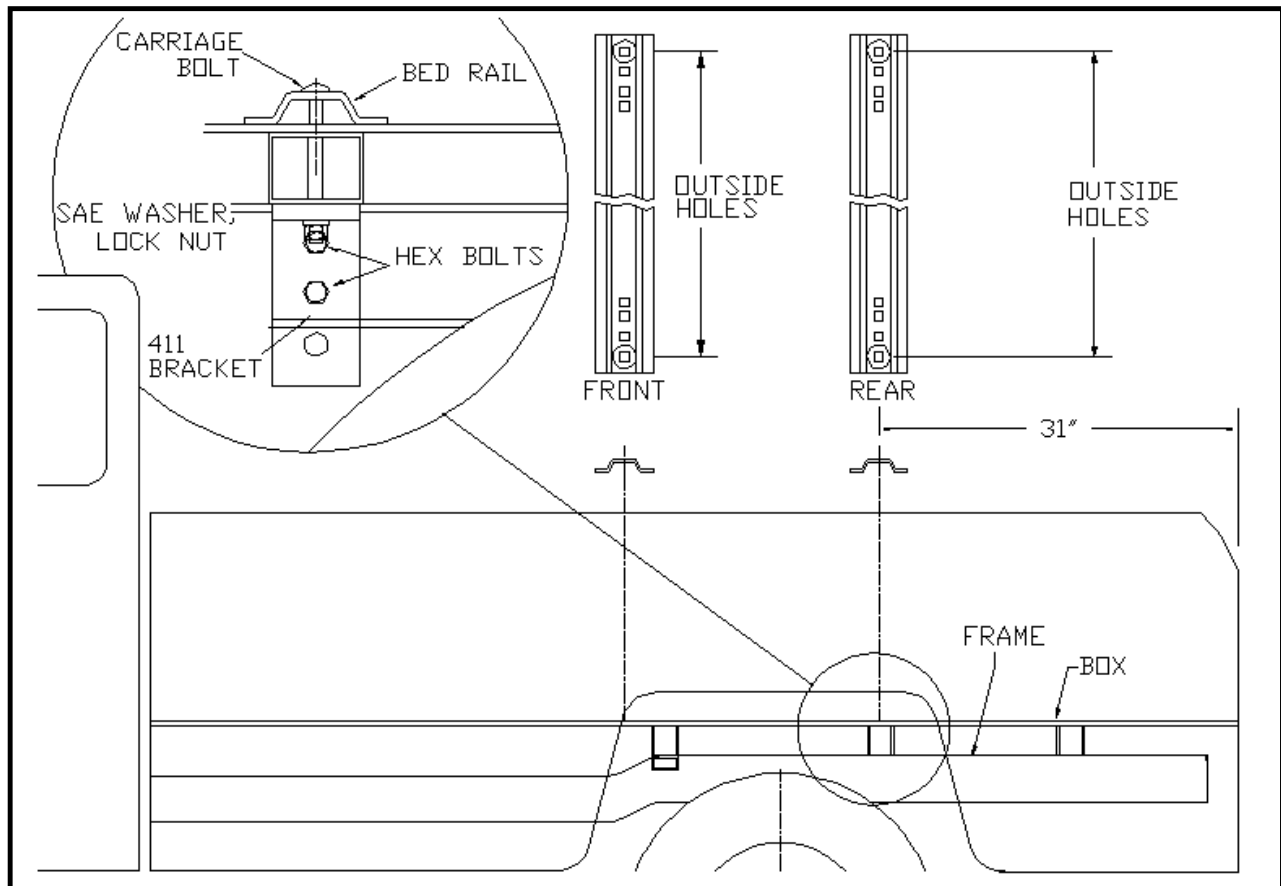
Truck Bed Drilling Instructions with Template



Drawing #13

BOX LENGTH	DIMENSIONS	MEASUREMENT
DODGE: 1993 & EARLIER RAM		
8'	A	*32-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

**DODGE: 1994-2001 RAM 1500 (5-1/2' & 6-1/2' BOXES)
1994-2002 RAM 2500/3500 (6-1/2' BOX)**



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 31" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown. Use OUTSIDE hole locations, front and rear. Drop in two bolts.
b. Drill two holes in REAR BED RAIL, OUTSIDE POSITION. Drop in two bolts. You will have to use two 5/8" x 5" long bolts to go through cross member.
4. a. Under box, place washers (2" wid flat bar), 411 frame brackets, flat washer 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" holes 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.**

Installation

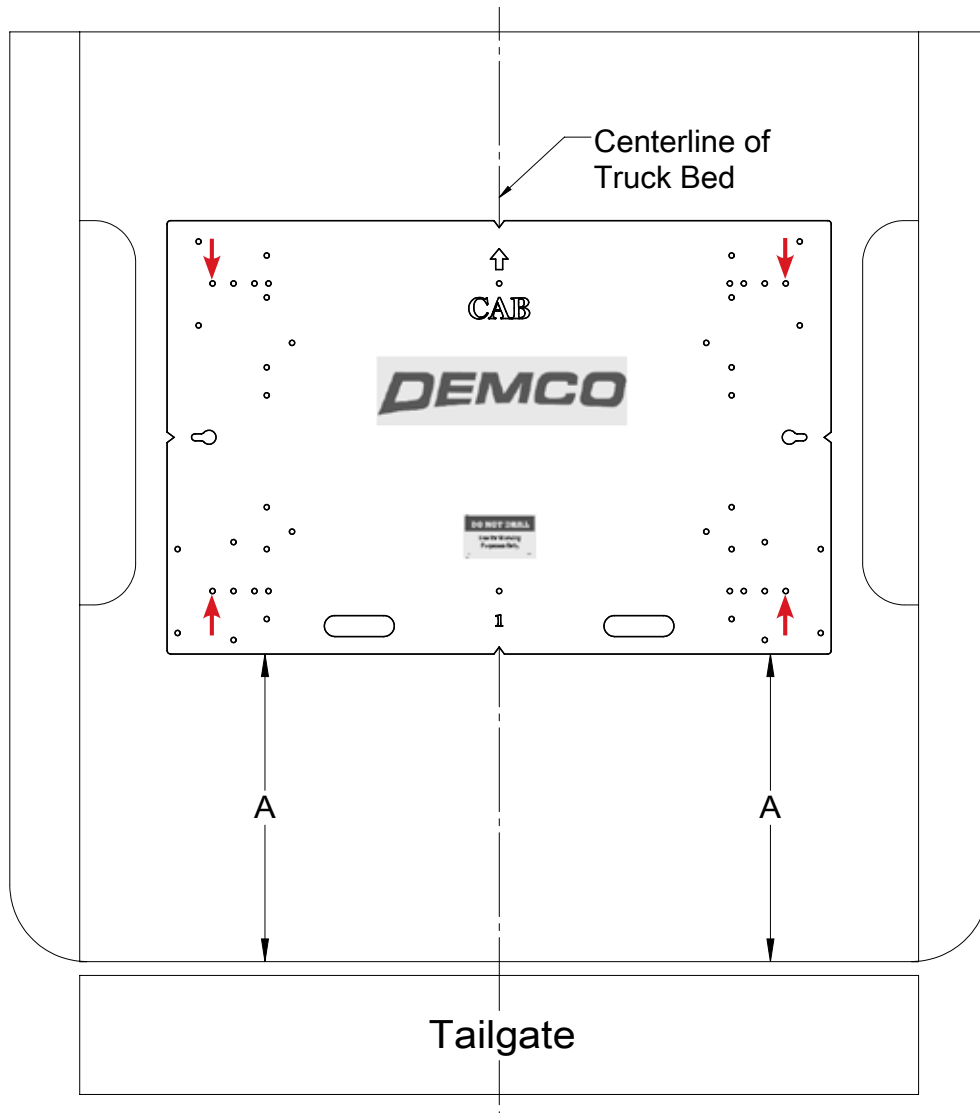
DODGE: **1994-2001 RAM 1500 (5-1/2' & 6-1/2' BOXES)**
 1994-2002 RAM 2500/3500 (6-1/2' BOXES)

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 #14** 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.

**DODGE: 1994-2001 RAM 1500 (5-1/2' & 6-1/2' BOXES)
1994-2002 RAM 2500/3500 (6-1/2' BOX)**

Truck Bed Drilling Instructions with Template

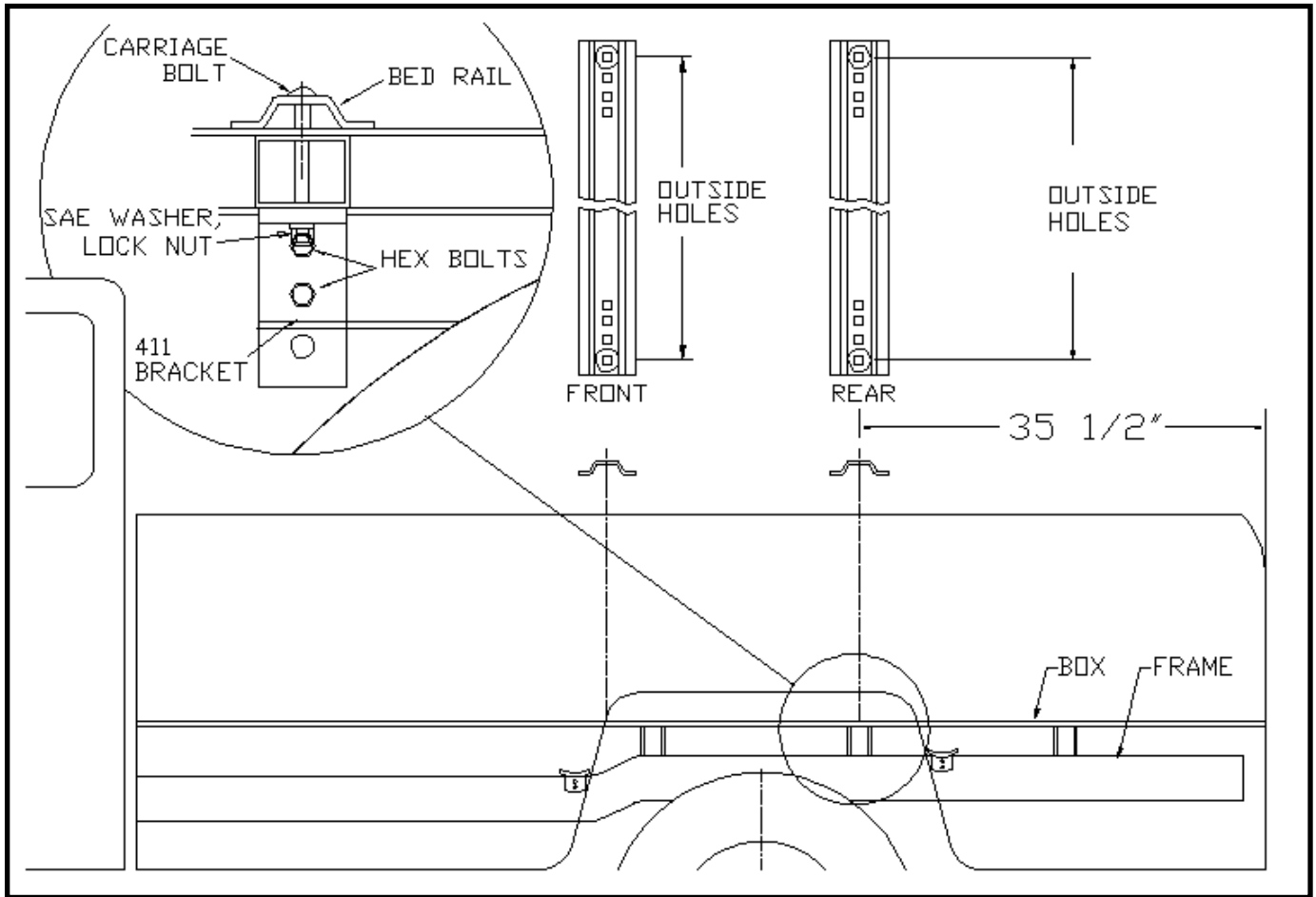


Drawing #14

BOX LENGTH	DIMENSIONS	MEASUREMENT
DODGE: 1994-2001 RAM 1500		
5-1/2'	A	*26-1/2"
6-1/2'	a	*26-1/2"
DODGE: 1994-2002 RAM 2500/3500		
6-1/2'	A	*26-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

DODGE: 1994-1997 RAM 1500/2500/3500 (8' BOX)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 35 1/2" from back edge of truck box to square hole centers in rear bed rail.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown. Use OUTSIDE hole locations, front and rear. Drop in two bolts.
 - Drill two holes in REAR BED RAIL, OUTSIDE POSITION. Drop in two bolts. You will have to use two 5/8" x 5" long bolts to go through cross member.
- Under box, place washers (2" wid flat bar), 411 frame brackets, flat washer 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" holes 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.**

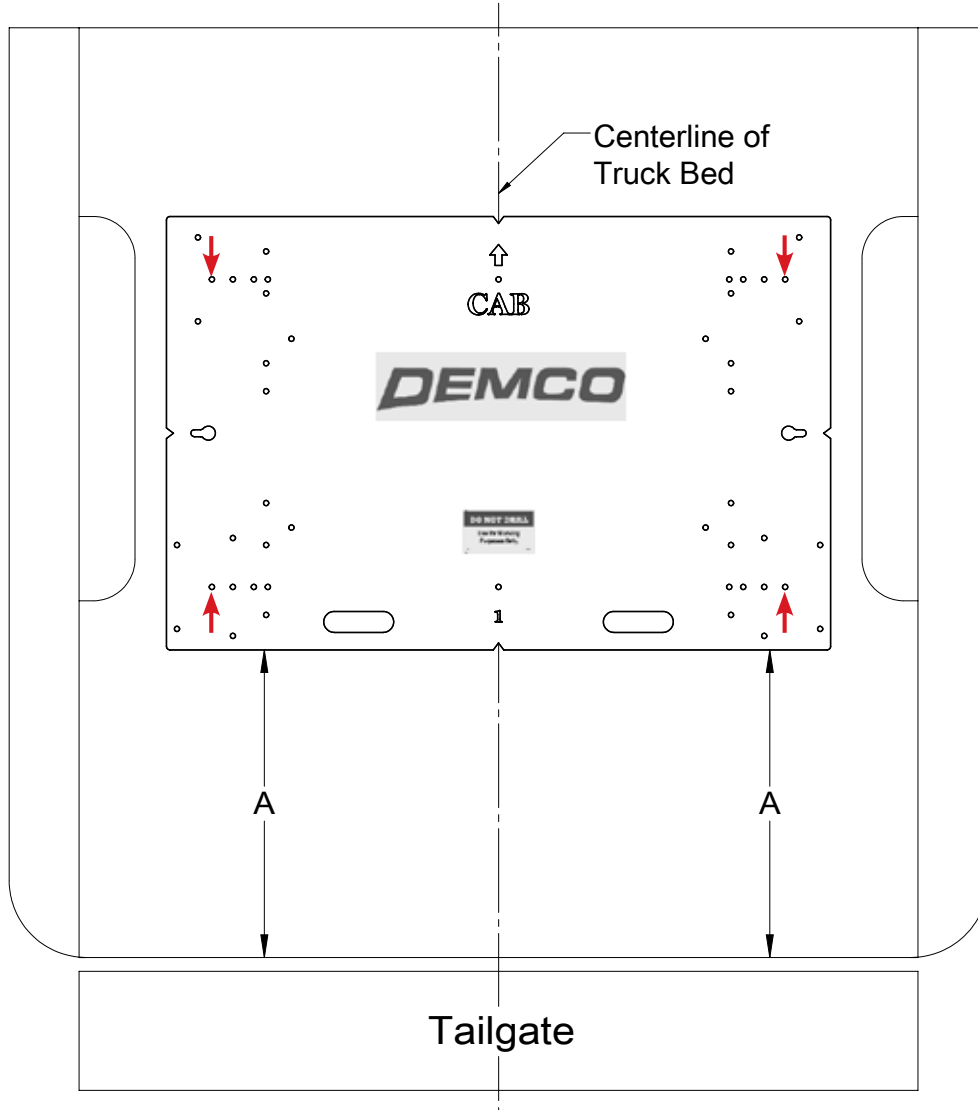
Truck Bed Drilling Instructions with Template

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 #15** 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

DODGE: 1994-1997 RAM 1500/2500/3500 (8' BOX)

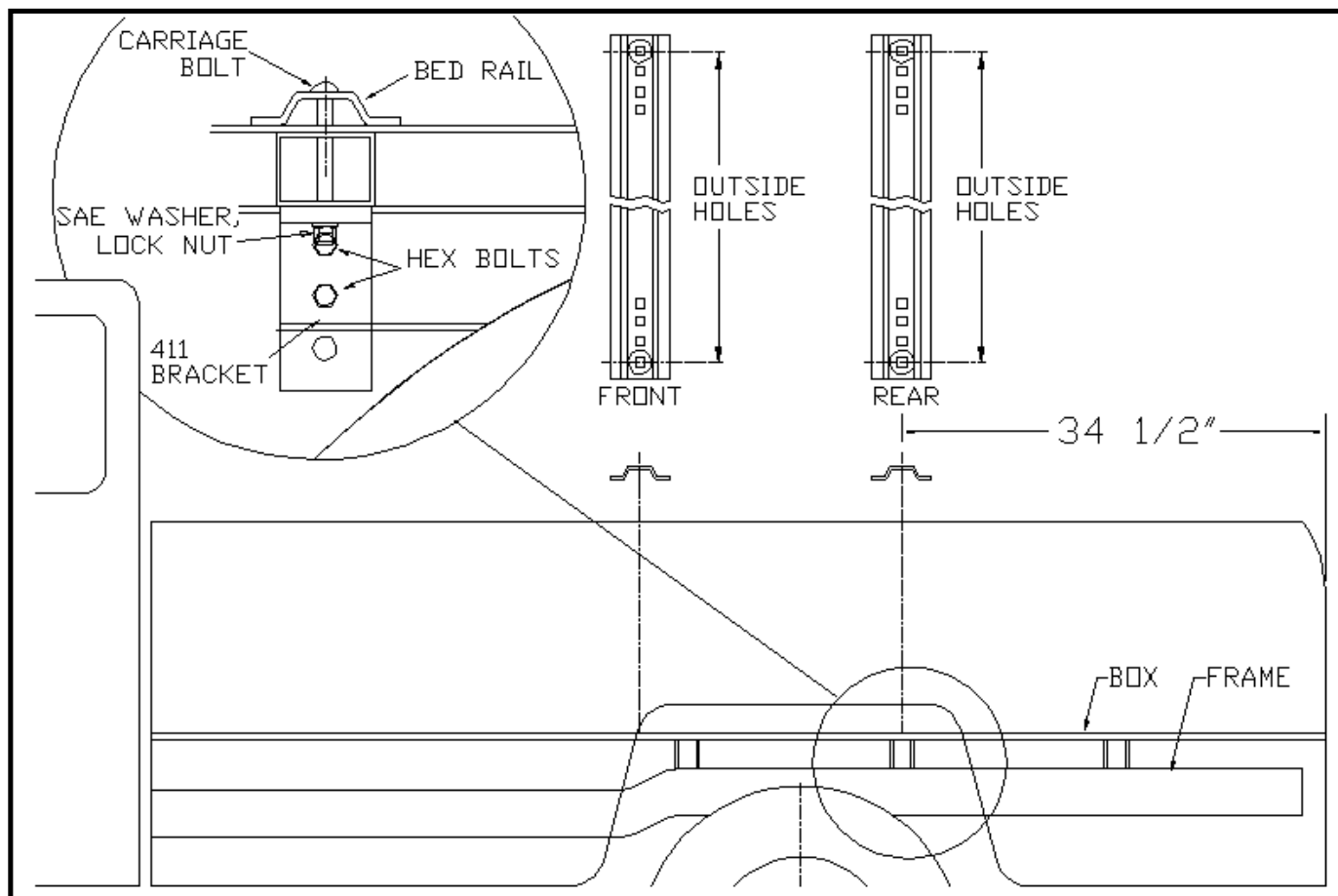
Truck Bed Drilling Instructions with Template



Drawing #15

BOX LENGTH	DIMENSIONS	MEASUREMENT
DODGE: 1994-1997 RAM 1500/2500/3500		
8'	A	*31"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

**DODGE: 1998-2001 RAM 1500 (8' BOX)
1998-2002 RAM 2500/3500 (8' BOX)**



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 34 1/2" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3.
 - a. Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown. Use OUTSIDE hole locations, front and rear. Drop in two bolts.
 - b. Drill two holes in REAR BED RAIL, OUTSIDE POSITION. Drop in two bolts. You will have to use two 5/8" x 5" long bolts to go through cross member.
4.
 - a. Under box, place washers (2" wid flat bar), 411 frame brackets, flat washer 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" holes 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.**

Installation

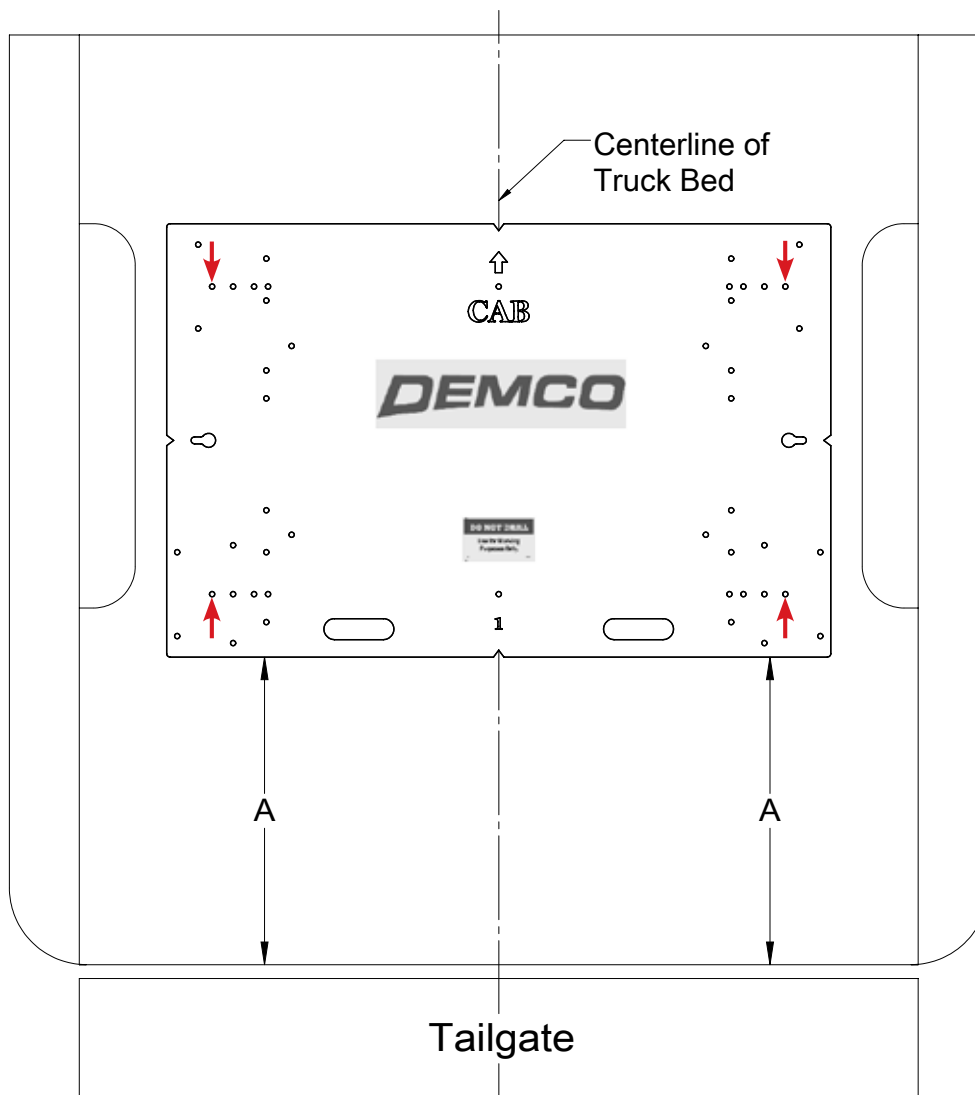
DODGE: **1998-2001 RAM 1500 (8' BOX)**
 1998-2002 RAM 2500/3500 (8' BOX)

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 #16** 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.

**DODGE: 1998-2001 RAM 1500 (8' BOX)
1998-2002 RAM 2500/3500 (8' BOX)**

Truck Bed Drilling Instructions with Template



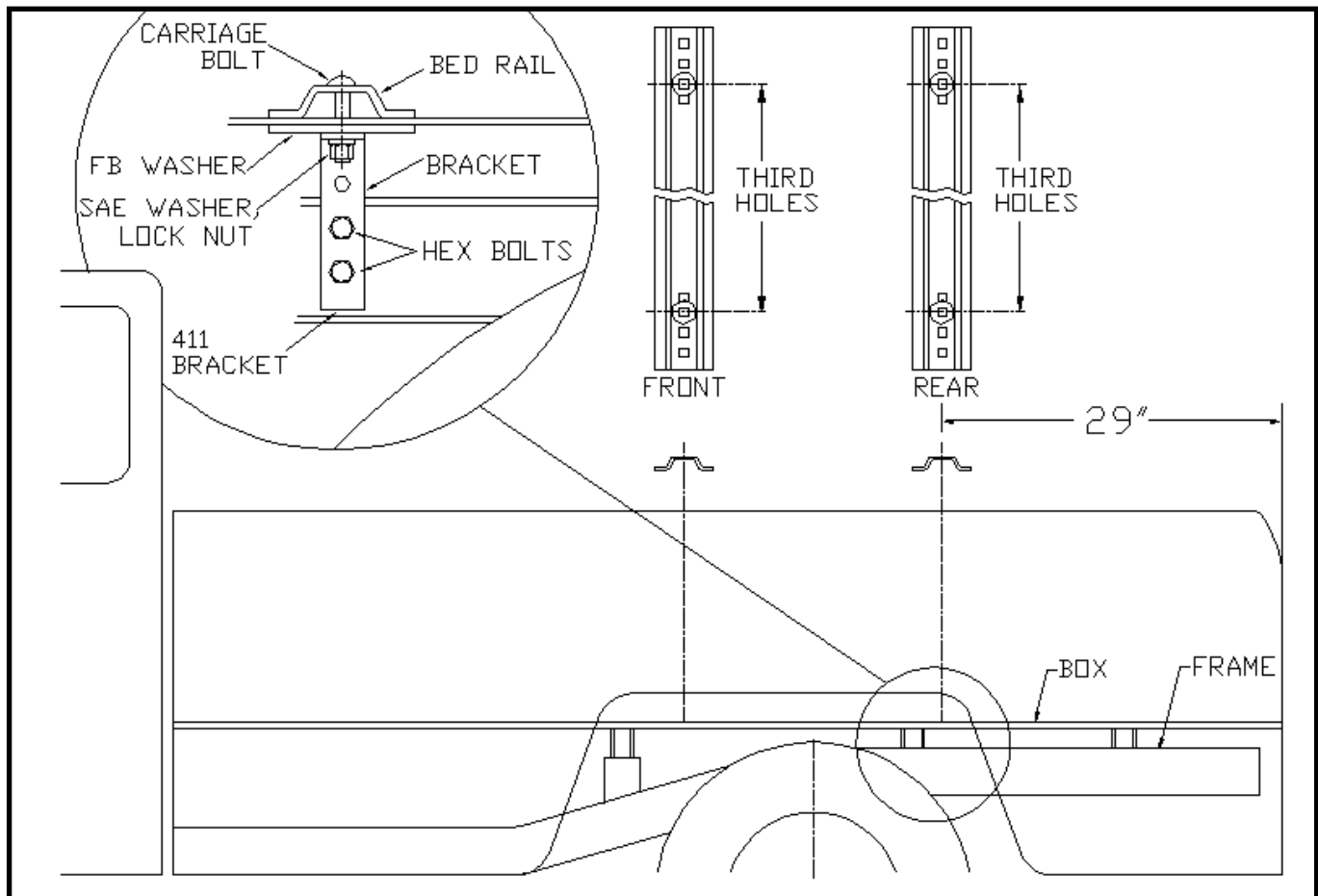
Drawing #16

BOX LENGTH	DIMENSIONS	MEASUREMENT
DODGE: 1998-2001 RAM 1500		
8'	A	*30"
DODGE: 1998-2002 RAM 2500/3500		
8'	A	*30"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

DODGE:

2001 & EARLIER DAKOTA



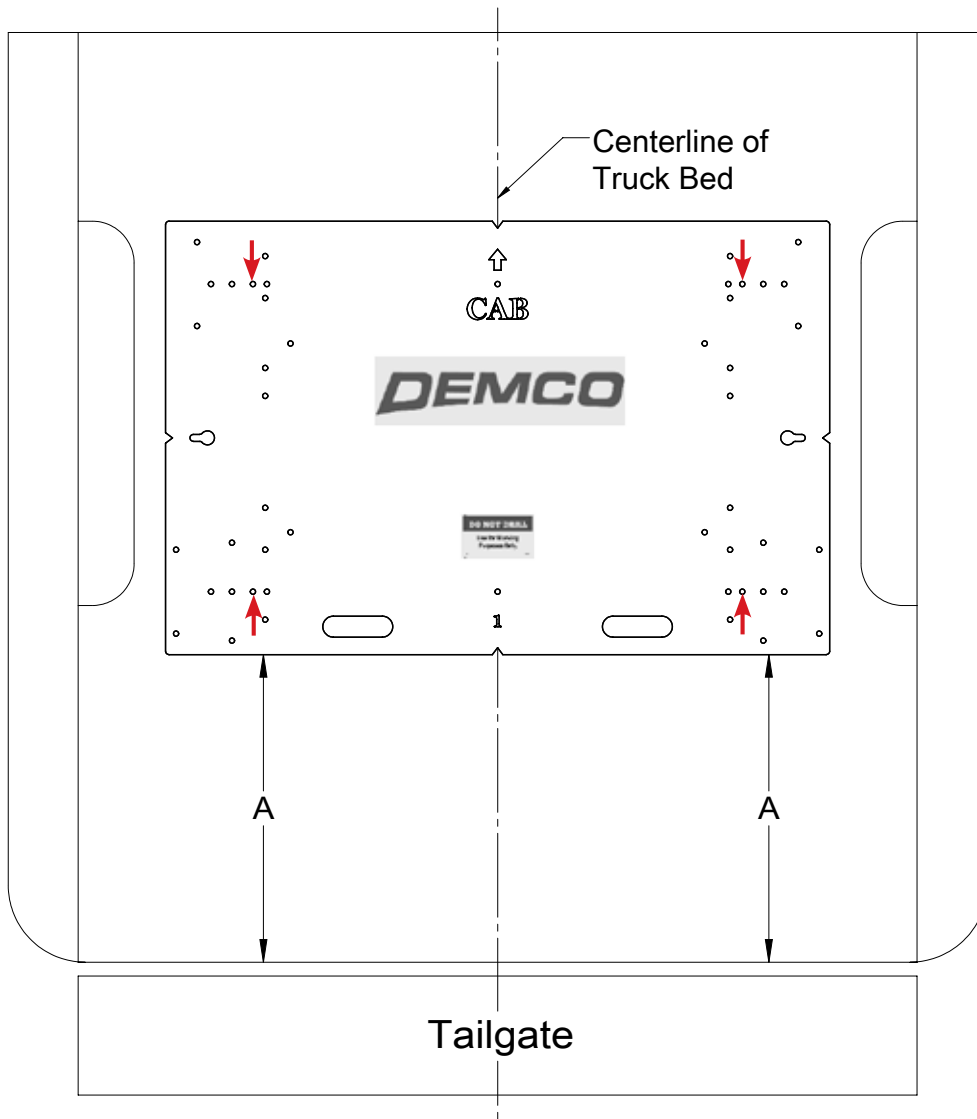
INSTALLATION

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 29" from back edge of truck box to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, THIRD HOLE POSITION, as shown. NOTE: use OUTSIDE hole locations, front and rear, if desired.
b. Drill two holes in REAR BED RAIL, THIRD HOLE POSITION. Drop in two bolts.
4. a. Under box, place washers (2" wide flat bar), 411 frame brackets, flat washer 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" holes 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.**

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 #17** 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.

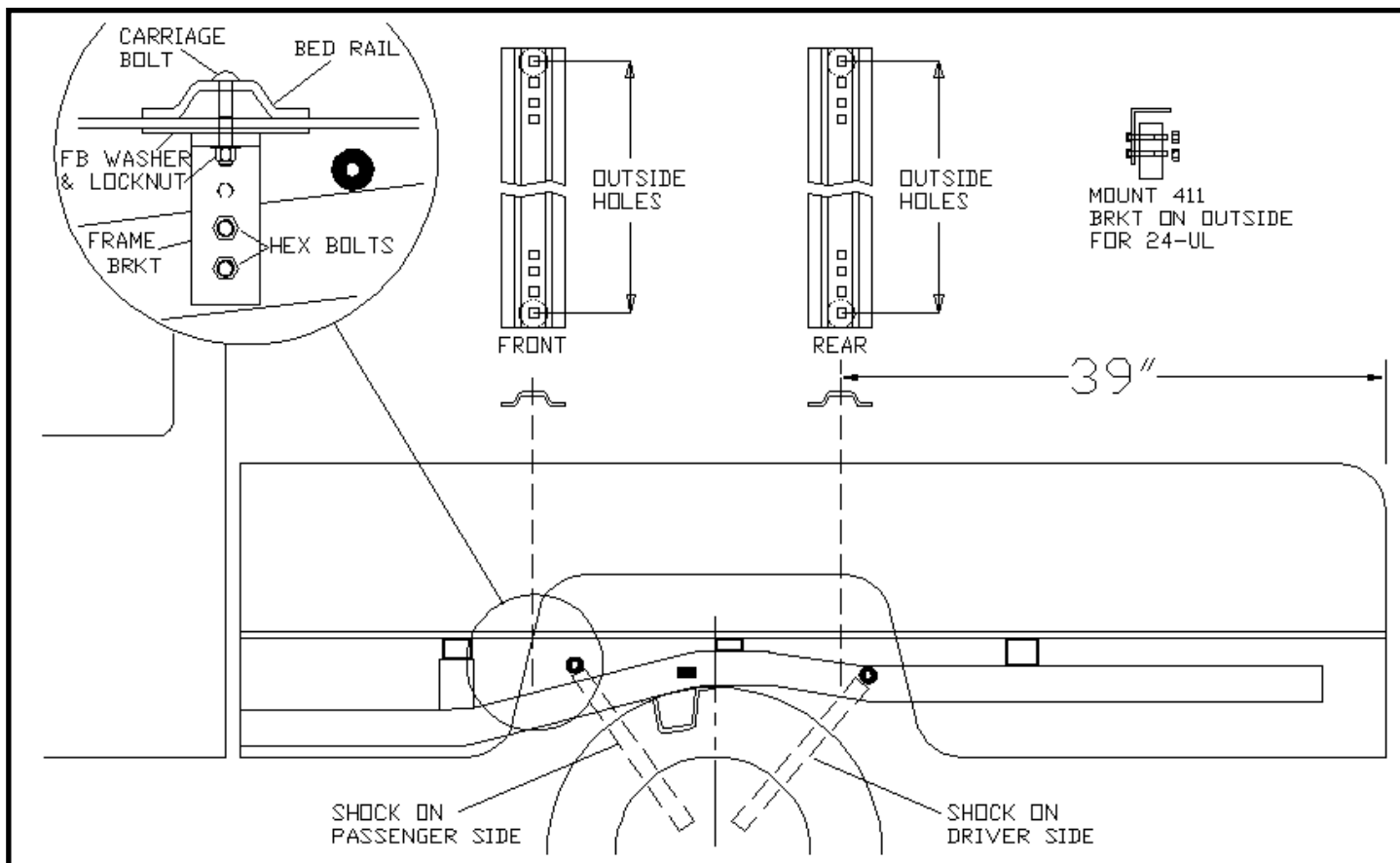
Truck Bed Drilling Instructions with Template



Drawing #17

BOX LENGTH	DIMENSIONS	MEASUREMENT
2001 Dakota & Earlier		
-	A	*24-1/2
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

TOYOTA: 2000 & EARLIER T100 REGULAR & EXTENDS CAB (INCLUDES 4 x 4)



INSTALLATION

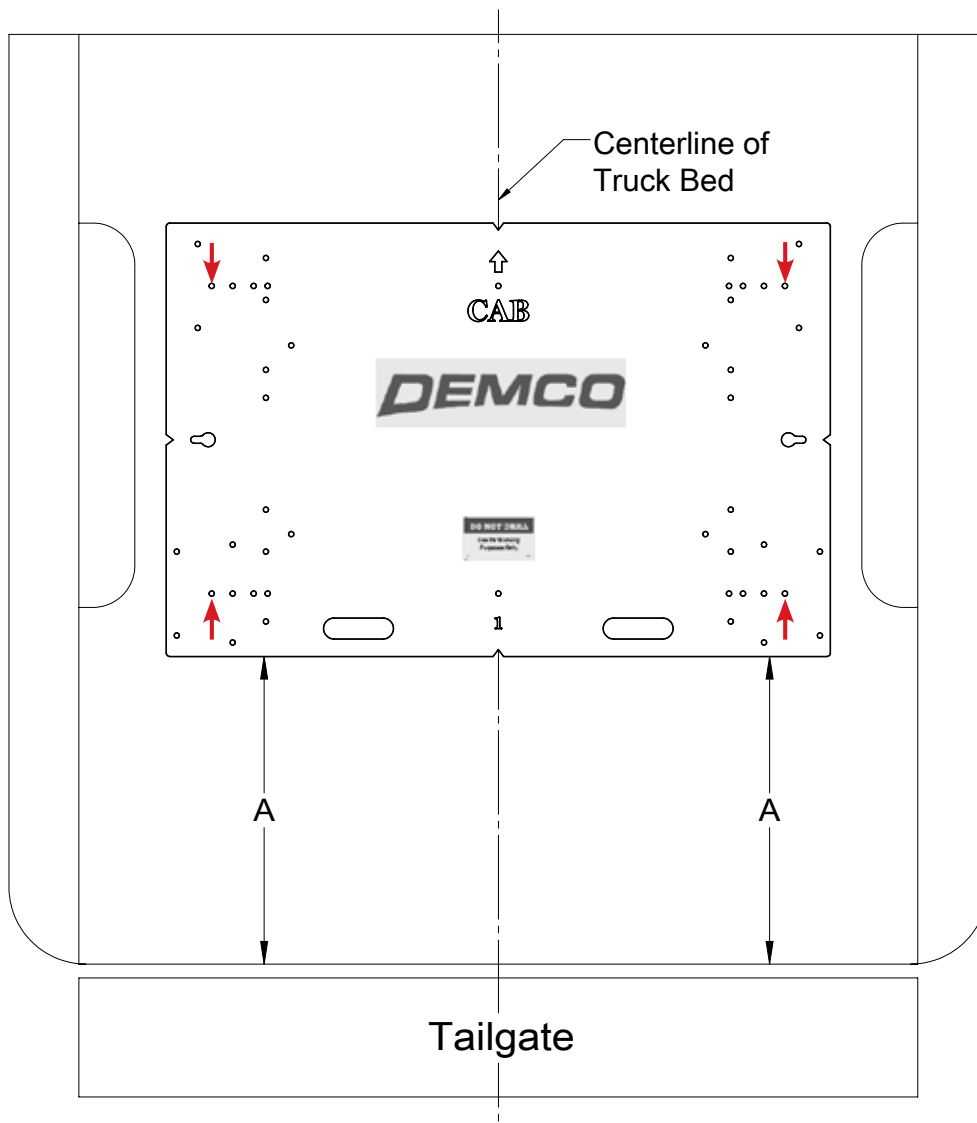
1. a. Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 b. Set hitch into back of truck, center it side to side.
 c. Measure 39" from back edge of truck box to square hole centers in rear bed rail. This places hitch 2" ahead of the axle.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown.
 b. Drop in two 5/8" x 3 1/2" long bolts.
 c. Drill two holes in REAR BED RAIL, OUTSIDE POSITION. Drop in two bolts.
4. a. Under box, place washers (2" wid flat bar), 411 frame brackets, flat washer 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" holes 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.**

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 #18** 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.

TOYOTA: 2000 & EARLIER T100 REGULAR & EXTENDS CAB (INCLUDES 4 x 4)

Truck Bed Drilling Instructions with Template



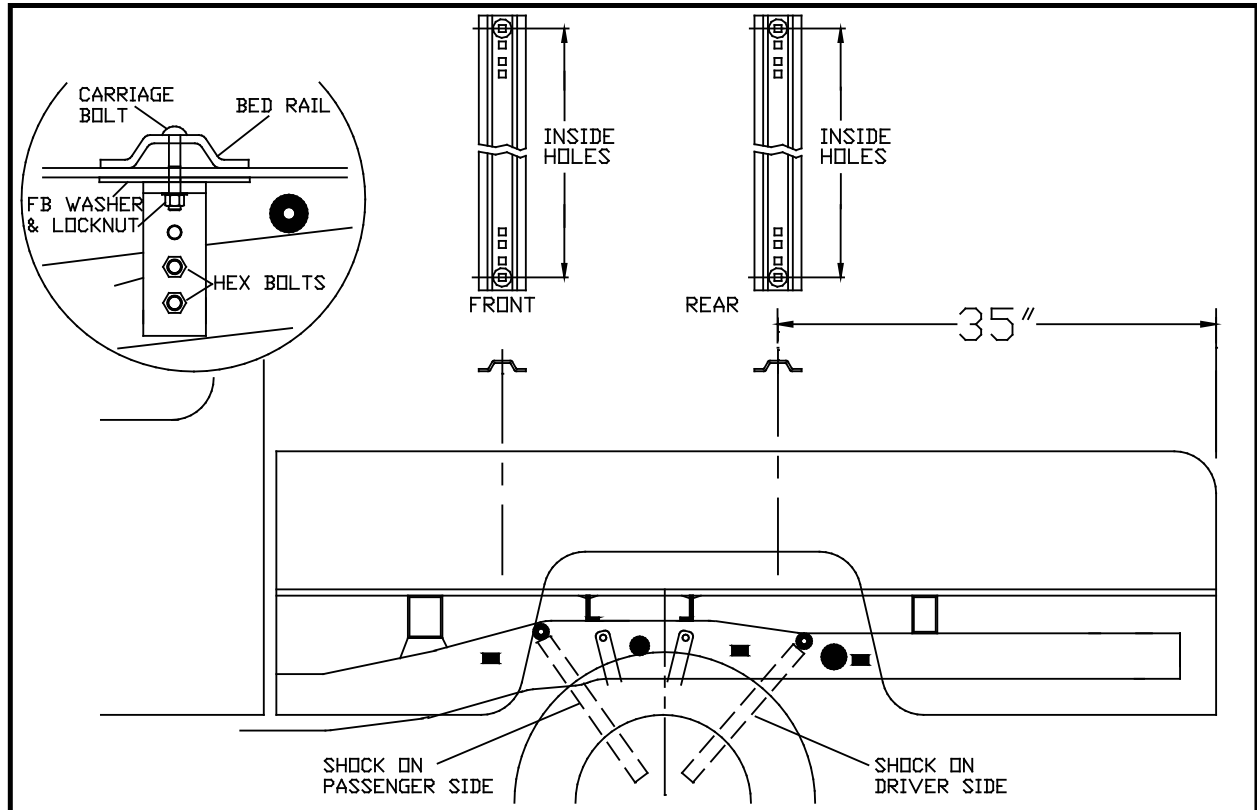
Drawing #18

BOX LENGTH	DIMENSIONS	MEASUREMENT
TOYOTA: 2000 & EARLIER T100 REGULAR & EXTENDS CAB (INCLUDES 4 x 4)		
	A	*34-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

Installation

TOYOTA:

2000-2006 TUNDRA REGULAR & EXTENDS CAB (INCLUDES 4 x 4)



INSTALLATION

- Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
 - Set hitch into back of truck, center it side to side.
 - Measure 35" from back edge of truck box to square hole centers in rear bed rail. This places hitch 2" ahead of the axle.
- Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
- Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown. Use OUTSIDE hole locations, front and rear. Drop in two 5/8" x 3 1/2" bolts.
 - Drill two holes in REAR BED RAIL, OUTSIDE POSITION. Drop in two 5/8" x 3 1/2" bolts.
- Under box, place washers (2" wid flat bar), 411 frame brackets, flat washer 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" holes 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**.

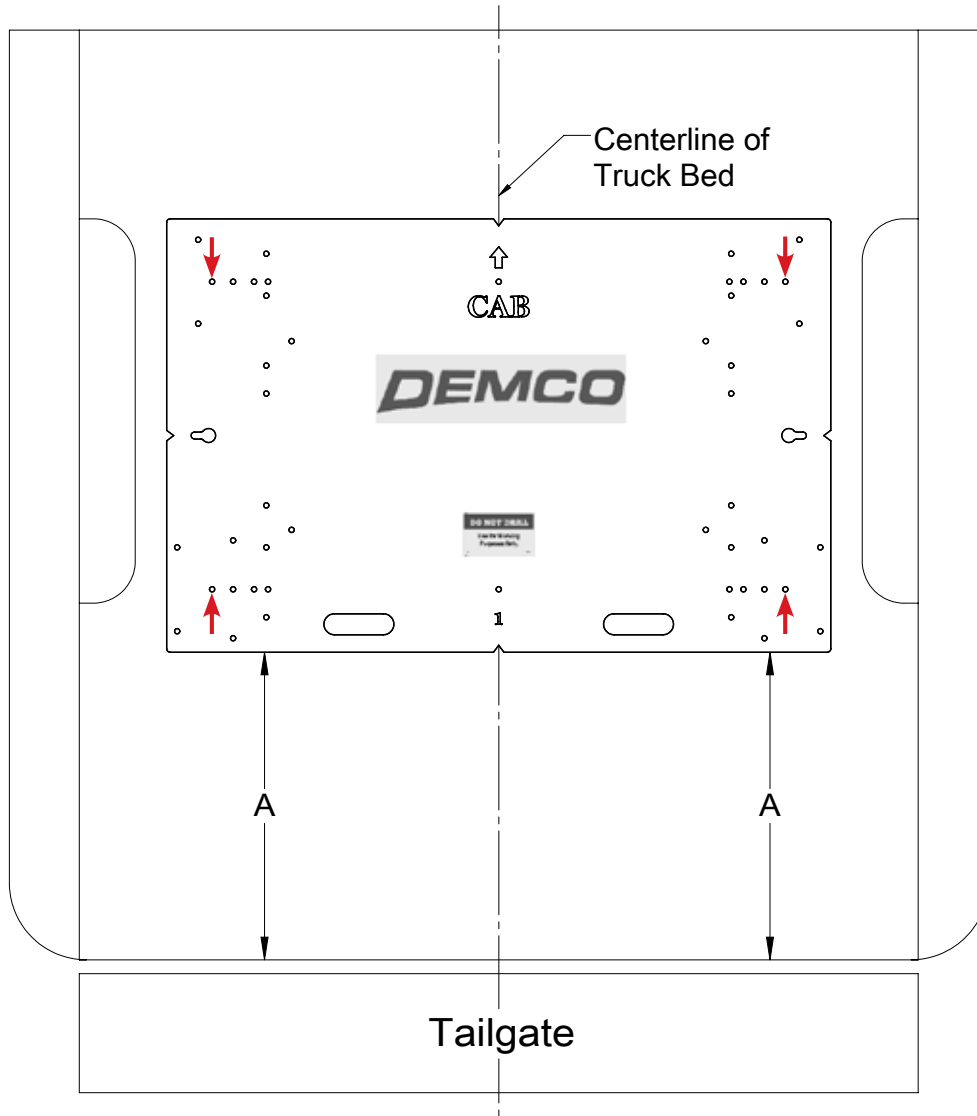
Truck Bed Drilling Instructions with Template

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 #19** 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

TOYOTA:

2000-2006 TUNDRA REGULAR & EXTENDS CAB (INCLUDES 4 x 4)



Drawing #19

BOX LENGTH	DIMENSIONS	MEASUREMENT
TOYOTA 2000-2006 TUNDRA REGULAR & EXTENDED CAB INCLUDES 4X4		
-	A	*30-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

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