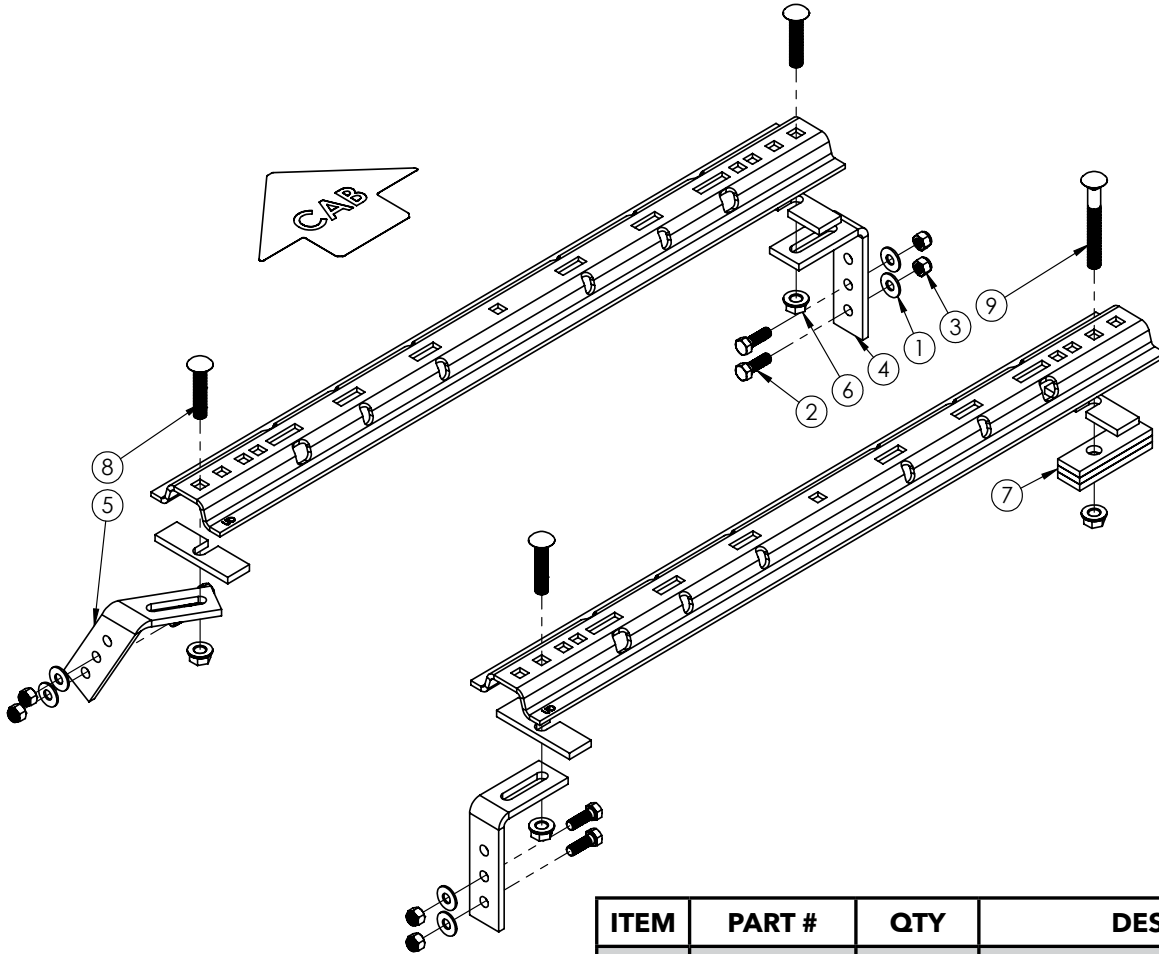


## FRAME BRACKET 8552020

Toyota Tundra (5-1/2', 6-1/2' & 8' Boxes)



ITEM	PART #	QTY	DESCRIPTION
1	<b>00085</b>	6	WASHER, .50 FLAT
2	<b>01254</b>	6	BOLT, .50 X 1-1/2" HEX GR.5
3	<b>02178</b>	6	NUT, .50 NYLON LOCK
4	<b>14189-76</b>	2	FRAME BRACKET
5	<b>14194-76</b>	1	411AL FRAME BRACKET
6	<b>14340</b>	4	NUT, .625 FLANGED WHEEL
7	<b>14374-76</b>	1	FRAME SPACER PLATE
8	<b>14377</b>	3	BOLT, .625 X 3" CARRIAGE GR.5
9	<b>14378</b>	1	BOLT, .625 X 5" CARRIAGE GR.5

Please order replacement parts by PART NO. and DESCRIPTION.

# Installation

## 8552020 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.

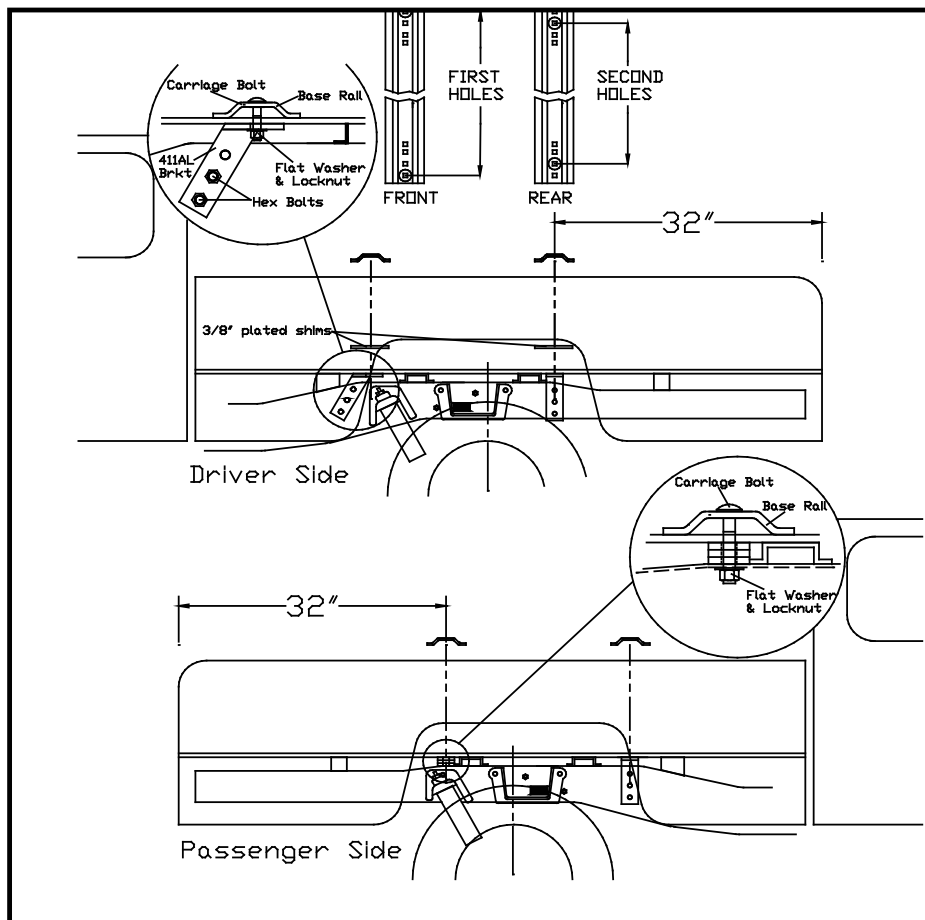
#### BOLT TORQUE SPECIFICATIONS

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

**INSTALLATION**

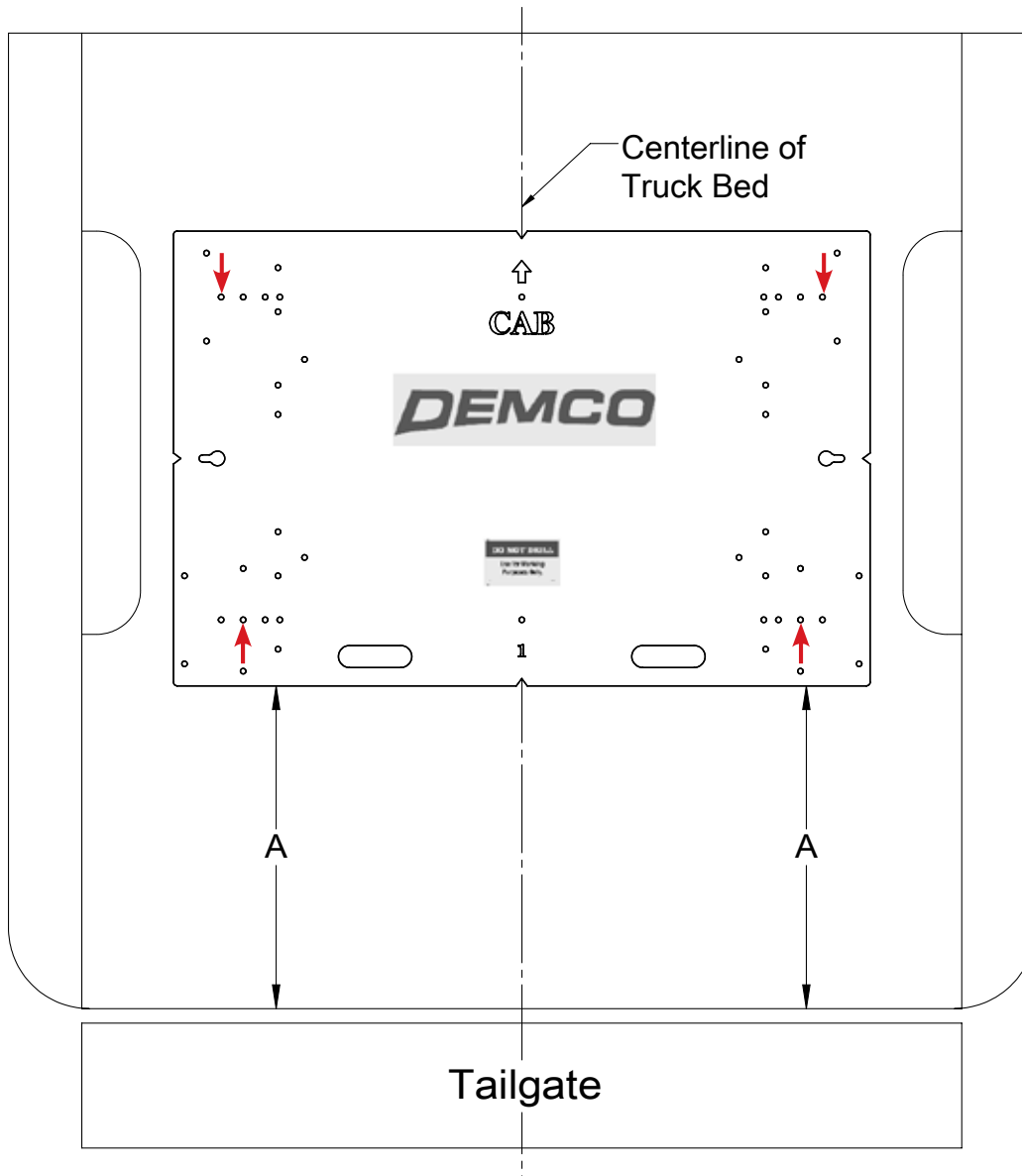
1. a. Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.  
b. Set hitch into back of truck, center it side to side.  
c. Measure 32" from back edge of truck box floor to square hole centers in rear bed rail.
2. Check underneath box at bolt hole locations for any obstructions (frame members, etc.).
3. a. Drill two 5/8" holes thru FRONT BED RAIL, OUTSIDE POSITION, as shown in **Drawing #1**.  
b. Insert two 5/8" x 3" long hex bolts.  
c. Drill two 5/8" holes thru REAR BED RAIL, 2<sup>nd</sup> HOLE POSITION (Passenger rear side drill through top of frame). Insert 5/8" x 3" carriage bolts drivers side and 5/8" x 5" carriage bolts.
4. a. Under box, loosely install frame brackets and serrated flange nuts onto carriage bolts on both drivers side and front passenger side brackets (3 places).  
b. On rear passenger side place spacer plate between top of frame and under side of box.  
c. 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. Fasten brackets with 1/2" x 1 1/2" hex bolt and 1/2" nylon lock nut.  
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 #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
TOYOTA TUNDRA		
5-1/2'	A	*27-1/2"
6-1/2'	A	*27-1/2"
8'	A	*27-1/2"
*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)

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

