

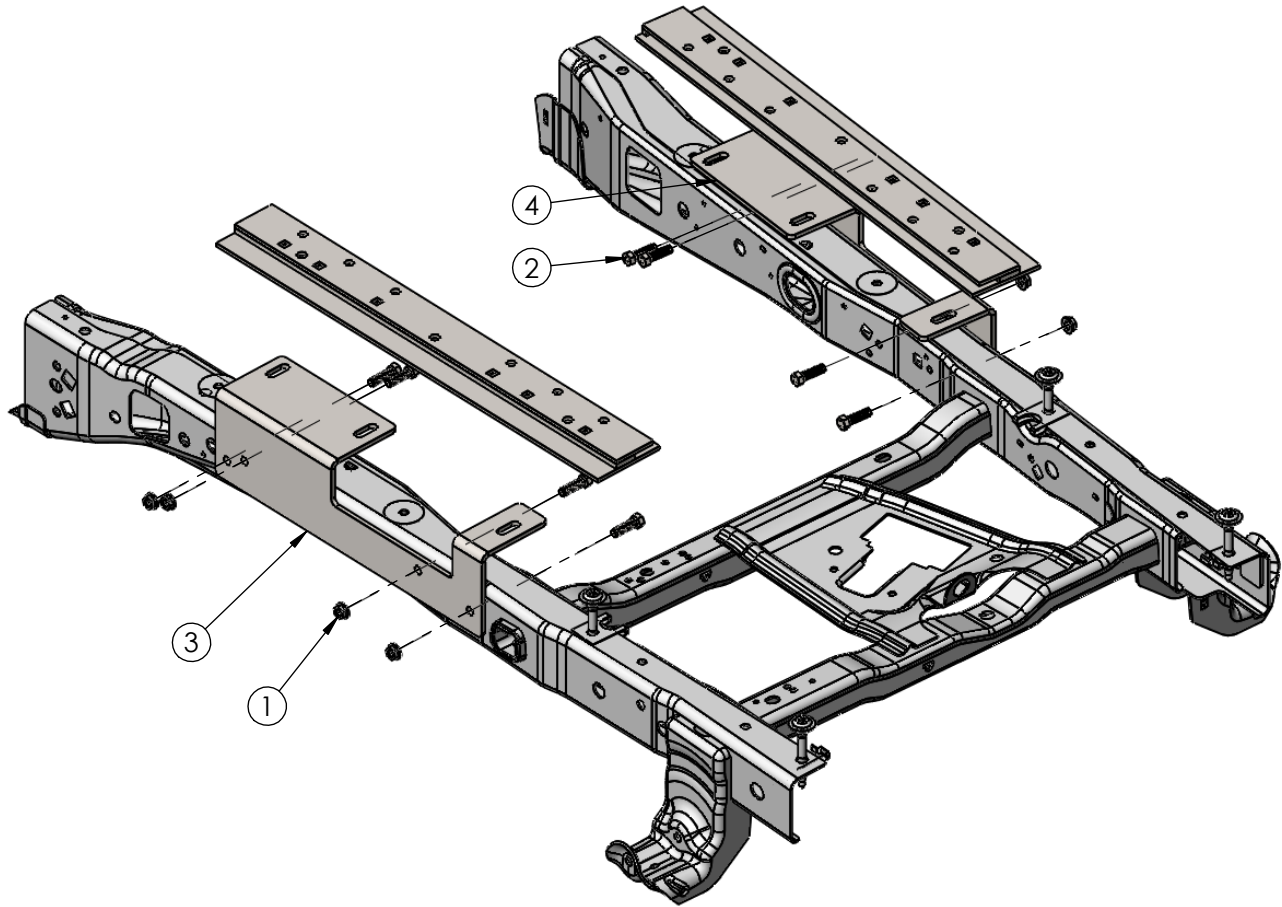


Doing Our Best to Provide You the Best

HJ33002, Rev 5
12/20

FRAME BRACKET 8553002

Ford F-150 5-1/2', 6-1/2' & 8' Box



8553002 PARTS LIST

ITEM	PART #	DESCRIPTION	QTY.
1.	10379	1/2" Serrated Flange Nut	8
2.	14266	1/2" NC x 1 3/4" Hex Bolt Gr.5 Serrated Neck	8
3.	14370-72	Frame Bracket Driver Side	1
4.	14371-72	Frame Bracket Passenger Side	1
5.	14238	1/2" Fish Wire (not shown)	1
Please order replacement parts by PART NO. and DESCRIPTION.			

OPERATOR MANUAL

GENERAL ASSEMBLY & INSTALLATION 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.

READ THROUGH THE ENTIRE MANUAL BEFORE BEGINNING INSTALLATION!

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.

Consult spray liner installer for recommended curing time.

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

1. Fully assemble the 5th wheel hitch on a flat, level surface and pin the hitch into the base rails.

NOTE: Assembly instructions come with hitch components.

2. Place assembled hitch in the bed of the truck, centered between the wheel wells.
3. Position the base rails in the truck bed as shown in Drawing #1.
4. If you **DO NOT** have a Demco Frame Bracket Installation Template use Drawing #1 and Table #1 to find your pick-ups box length and measurements. If you **DO** have a Template use Drawing #2 and Table #2.

IF EQUIPPED WITH A HEAT SHEILD, FIND HEAT SHEILD INSTRUCTIONS IN MANUAL BEFORE DRILLING ANY HOLES. IF THERE ARE NO INSTRUCTIONS ON THE HEAT SHEILD, PROCEED WITH THE INSTALLATION.

HIGH IMPORTANCE! BEFORE ANY DRILLING IS DONE. MAKE SURE, THERE ARE NO OBSTRUCTIONS UNDER THE BOX!

5. Start by drilling one of the marked holes in the base rail closes to the tailgate, with a 1/2" drill bit.

NOTE: Touch up the bare metal, as you drill the holes, with some paint that matches the box of the truck.

6. Place a 1/2" standard bolt and a 1/2" washer or place a 1/2" carriage bolt down through the hole before drilling the next holes.

NOTE: This will help to stop base rails from shifting.

7. Drill the same hole, with a 1/2" drill bit, on the opposite base rail.
8. Place another 1/2" standard bolt and a 1/2" washer or place a 1/2" carriage bolt down through the hole before drilling the next holes.
9. Slide the hitch to the rear position, this will parrallel the base rails.
10. Drill the remaining four holes with a 1/2" drill bit.
11. Place the four remaining 1/2" standard bolts and 1/2" washers or the 1/2" carriage bolts down through the holes.
12. Under the box, place the frame brackets up onto the bolts.
13. Loosely install the frame brackets with the 3/16" flat washers and 1/2" nylon lock nuts. Press each frame bracket tight against the frame and the bed. Tighten the nuts snug against the box.

HIGH IMPORTANCE! BEFORE ANY DRILLING IS DONE. MAKE SURE, THERE ARE NO OBSTRUCTIONS ON THE OPPOSITE SIDE OF THE FRAME!

14. Using the frame bracket as a template, Drill 17/32" holes into truck frame.

NOTE: A pilot hole may need to be drilled. To pilot drill: use a 17/32" drill bit or transfer punch to mark the center of the hole. Drill through the frame with a 1/4" drill bit.

15. Through the holes drilled, fish the knurled bolts through the frame by using the fish wire provided.
16. Install the nuts on the outside of the frame brackets.
17. Loctite and torque all bolts according to the **BOLT TORQUE SPECIFICATION** chart located on the next page.

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.			

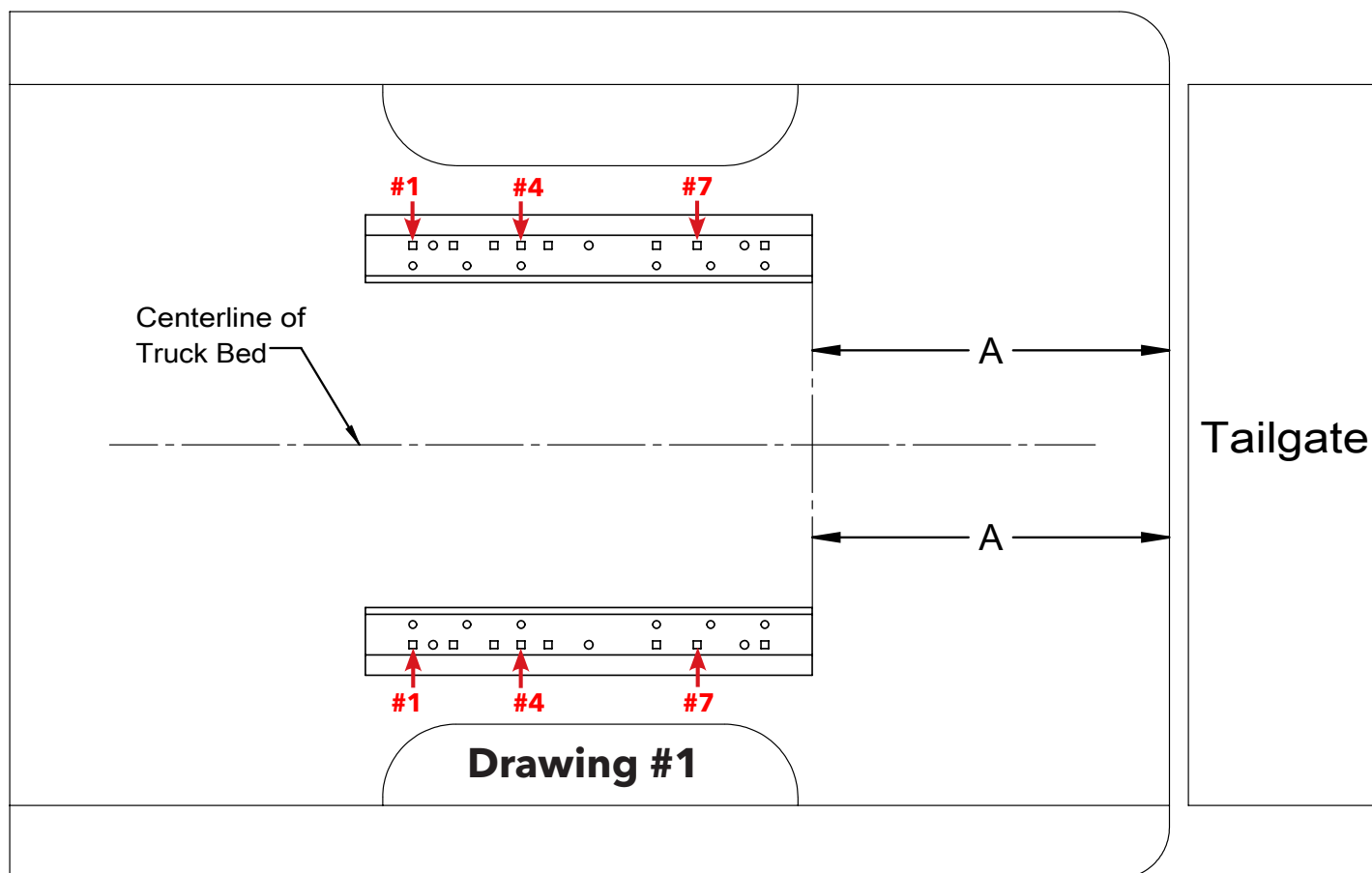


Table #1

BOX LENGTH	DIMENSIONS	MEASUREMENT
5-1/2'	A	*20-1/2"
6-1/2'	A	*20-1/2"
8'	A	*20-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

INSTALLATION

TRUCK BED DRILLING INSTRUCTIONS WITH TEMPLATE

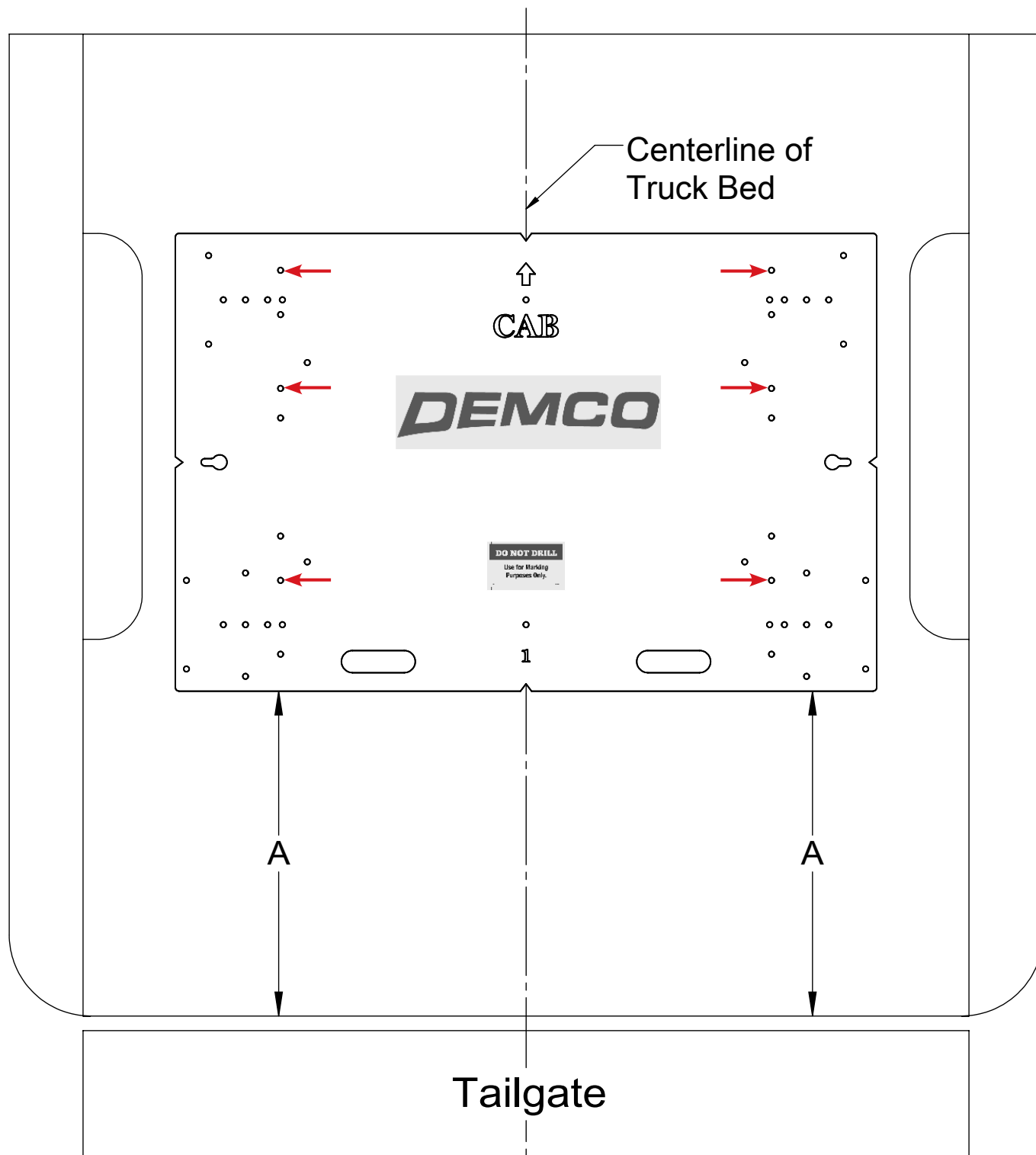
1. Place the template in the box and center the template between the wheel wells.
2. **IF NEEDED, TAPE THE TEMPLATE DOWN.**
3. Measure from the back of the box to the template on the passengers side and drivers side to insure that the template is square. See drawing #2 and table on page 6 for measurements.
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.

NOTE: DO NOT DRILL THE HOLES WITH THE TEMPLATE STILL IN THE BOX, THIS WILL RUIN THE TEMPLATE

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 six marked holes with a 1/2" 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

Table #2

BOX LENGTH	DIMENSIONS	MEASUREMENT
5'-12"	A	*21-1/2"
6'-1/2"	A	*21-1/2"
8'	A	*21-1/2"
*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