

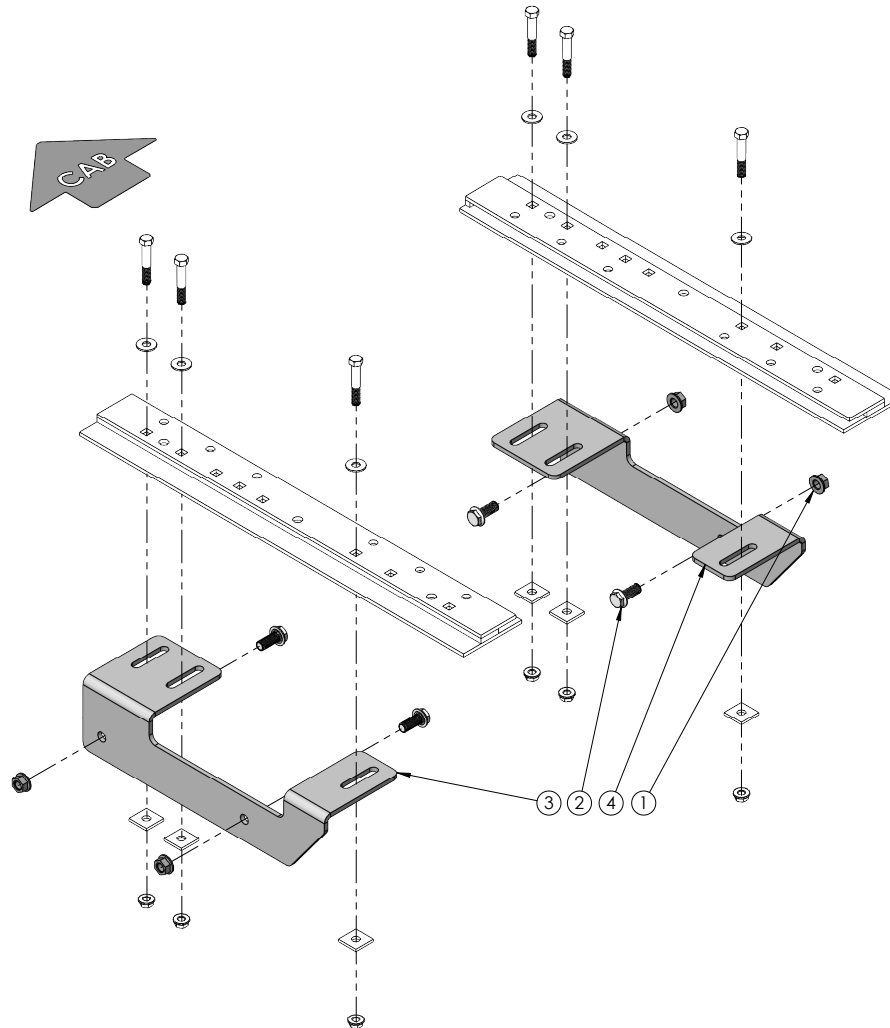


Doing Our Best to Provide You the Best

HJ33020, Rev 1
02/20

FRAME BRACKET 8553020

Chevy/GMC 2500 HD & 3500 HD 6-1/2' & 8' Box



ITEM	PART #	QTY	DESCRIPTION
1	14340	4	NUT .625 NC SERRATED FLG. HEX
2	16690	4	BOLT, .625NC X 1.50 SERR FLG HEX HD
3	16858-76	1	DRIVER SIDE FRAME BRACKET
4	16859-76	1	PASS. SIDE FRAME BRACKET
-	14210	1	5/8" FISH WIRE (NOT SHOWN)
-	12329	2	LOCTITE (NOT SHOWN)
-	15919-76	2	.50 SHIM (NOT SHOWN)
Please order replacement parts by PART NO. and DESCRIPTION.			

OPERATOR MANUAL

INTRODUCTION

8553020 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.

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.

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.

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

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

Truck Bed Drilling Instructions Without Template:

1. Completely assemble hitch. See GENERAL INSTRUCTIONS and SAFETY supplied.
2. Place and lock the hitch into the SL base rail in the back of truck, center the hitch and the rails from side to side.
3. Measure "A" from back edge of truck box to back edge of bed rails, as shown in Drawing #1.

NOTE: Dimensions are in Table #1.

4. **CHECK UNDERNEATH BOX AT BOLT HOLE LOCATIONS FOR ANY OBSTRUCTIONS.**
5. Drill one 17/32" holes through hole #1 on each SL bed rail.

NOTE: Touch up the bare metal with some paint that matches the box of the truck.

6. Insert two 1/2" x 3" long hex bolts and two 1/2" washers through the drilled holes.
7. Slide hitch to rear position, to parallel bed rails.
8. Drill holes #2 and #6 on each SL bed rail. Insert four 1/2" x 3" hex bolts.

NOTE: Touch up the bare metal with some paint that matches the box of the truck.

9. Insert four 1/2" x 3" hex bolts and four 1/2" washers through the drilled holes.

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.			

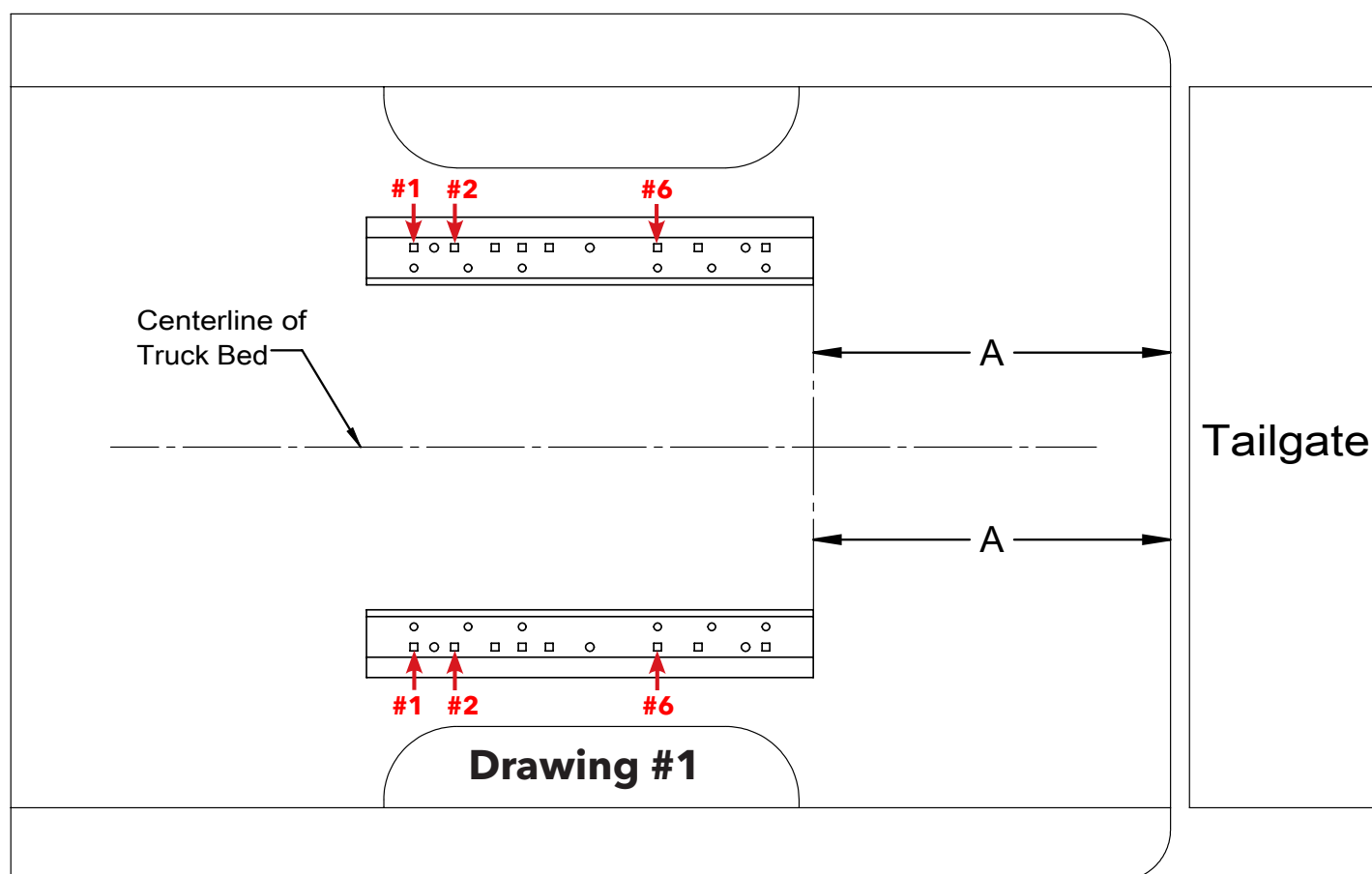


Table #1

BOX LENGTH	DIMENSIONS	MEASUREMENT
6-1/2'	A	*19-7/8"
8'	A	*23"
*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 #2 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.

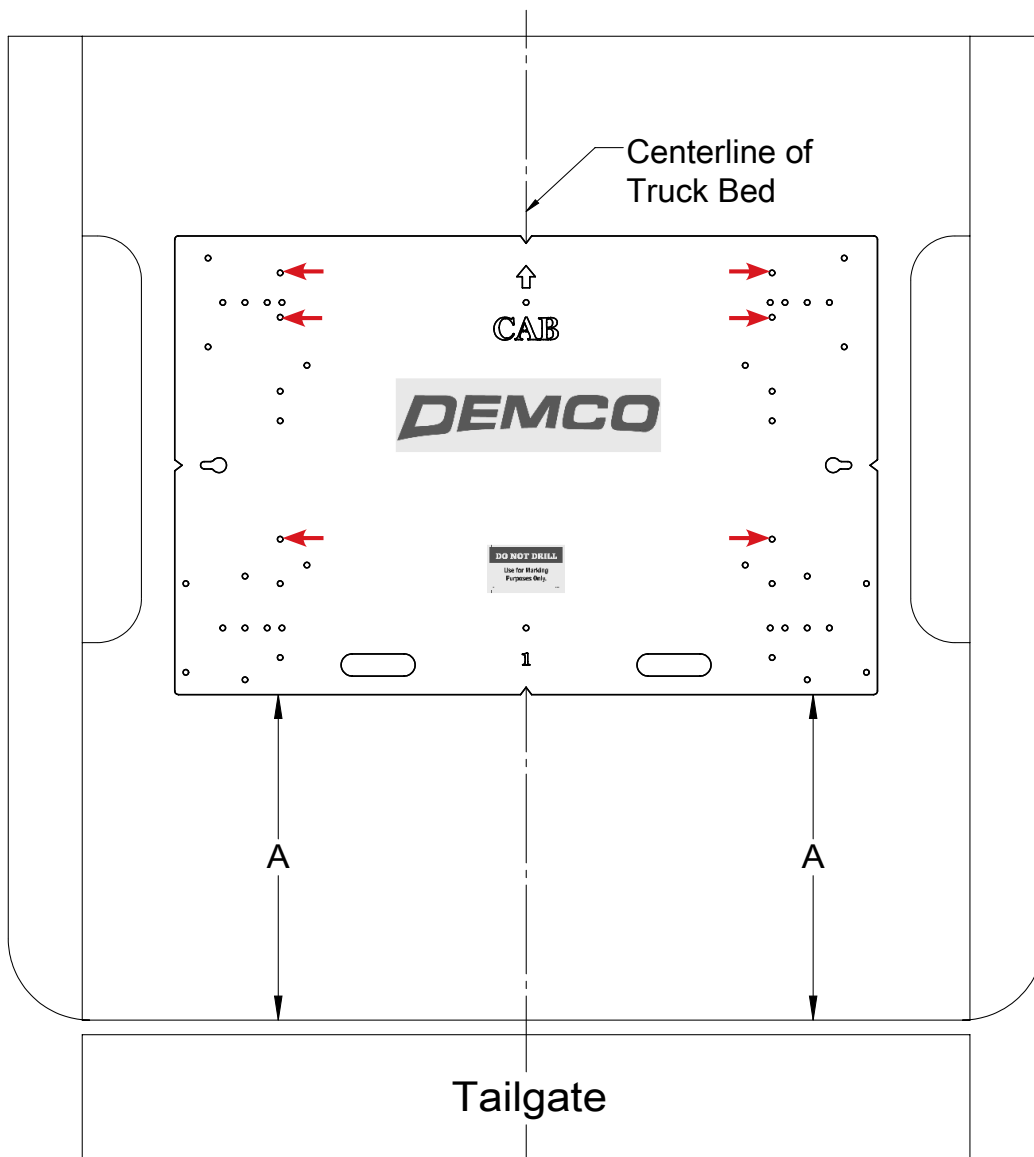
NOTE: DO NOT DRILL THE HOLES WITH THE TEMPLATE STILL IN THE BOX, THIS WILL RUIN THE TEMPLATE

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 (from step 5) 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.
10. Once drilling instructions are completed, return to step #1 on page 5 for frame bracket installation.

TRUCK BED DRILLING INSTRUCTIONS WITH TEMPLATE



Drawing #2

Table #2

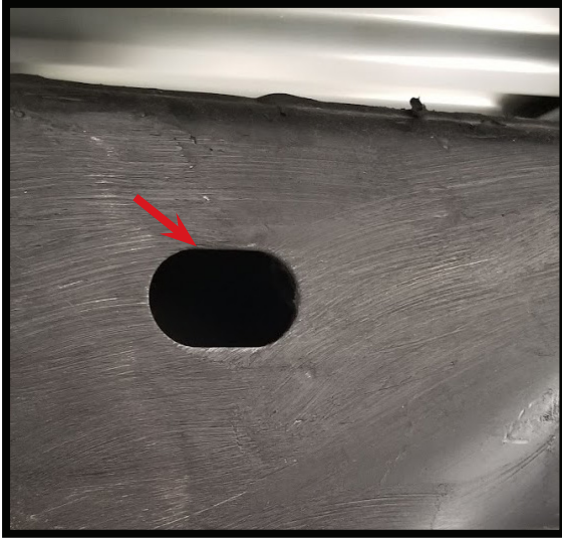
BOX LENGTH	DIMENSIONS	MEASUREMENT
6-1/2'	A	*17-3/8"
8'	A	*20-1/2"
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

INSTALLATION

FRAME BRACKET INSTALLATION

1. Remove the rear tires.
2. If equipped, remove the rear wheel well liners.
3. Center the bolts, that are coming down from the bed, in the slots in the frame brackets as best as possible and slide the frame brackets up tight to the bottom of the bed and tight to the frame. Clamp the brackets to the frame.
4. Install the six spacer plates and loosely tighten the 1/2" serrated nuts onto the bolts.
5. Using the holes in the frame brackets as a guide, drill the holes in the frame with a 11/16" drill bit.

NOTE: A pilot hole maybe needed.



Outside of frame: One of the access holes is on the outside of frame. This access hole might have to be trimmed larger to fit the head of the bolt through.



Inside of frame: The other access holes are on the inside of frame. These holes are located right behind the bracket. No trimming is need, but you may have to move some steel lines out of the way to fish the bolts through.

6. Using the 5/8" fish wire, fish the 5/8" serrated head bolts through one of the access holes in the frame. See pictures above.
7. Install the SL shims that are provided to you with the frame bracket kit. **DO NOT** use the SL shims that come with the 6012 Rail Kit.
8. Tighten all 5/8" and 1/2" serrated nuts. LOCTITE and torque all the nuts to the chart located on the top of page 3.
9. Re-install the rear wheels and rear wheel well liners (if removed), double check all fasteners for tightness..
10. Unpin and slide the hitch assembly forward and back to make sure it can slide freely with ease. If there was any shifting during installation that caused any binding, simply loosen the six bolts that attach the base rail to the frame brackets and realign the base rail and retighten.



4010 320th St., Boyden, IA. 51234

Phone: (712) 725-2311

Fax: (712) 725-2380

Toll Free: 1-800-54DEMCO (1-800-543-3626)

**Demco warranty policies, operator manuals, and product registration
can be found online:**

www.demco-products.com

