



Installation Instructions

Kit, Base Rail Bracket Part # 31396

Dealer / Installer: Provide a copy of these Instructions to the end user of this product. These Instructions provide important operating and safety information for proper usage of this product. Demonstrate the proper use of the product with the end user. Have the end user demonstrate that they understand the proper use of the product.

End User: Read and follow all instructions included in this manual. Ask your Dealer / Installer for assistance if you do not understand the proper use of the product. Never remove any decals from the product.

APPLICATION:

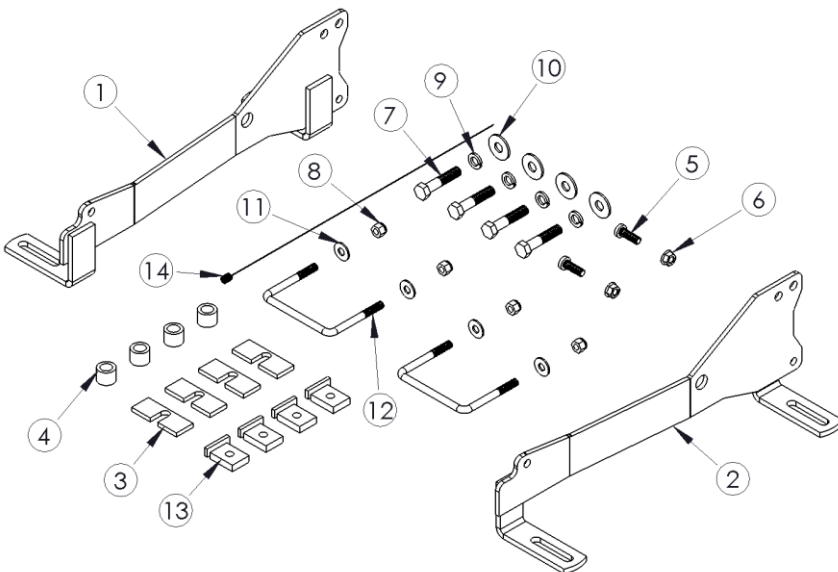
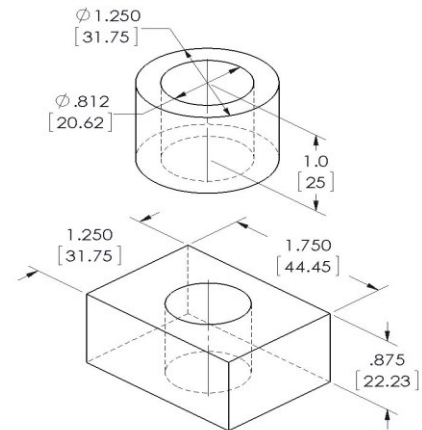
2007 to 2013 Chevrolet & GMC Silverado & Sierra 1500 Pick-up on GMT 900 Box Frame Only
 2014 Chevrolet & GMC Silverado & Sierra 1500 Long Bed ONLY. Does **NOT** fit Double or Crew Cab pickups.

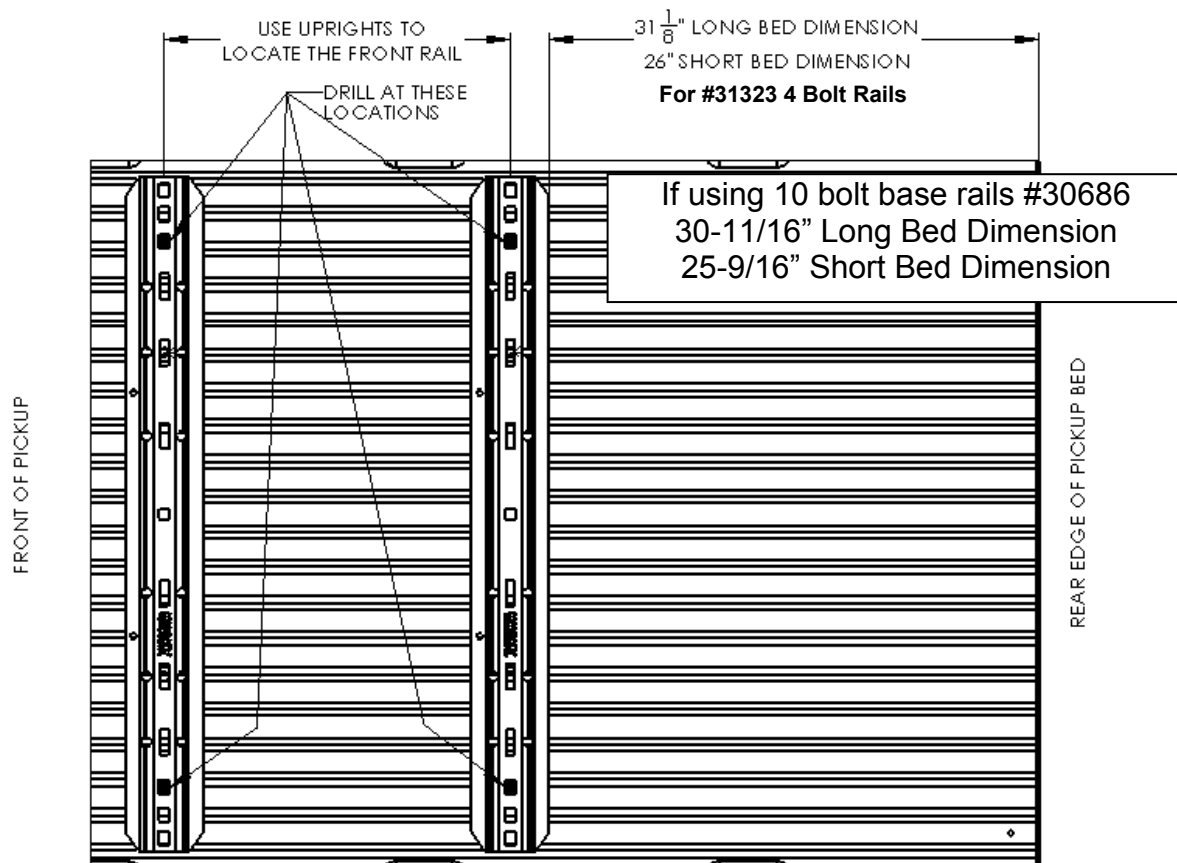
NOTE: This bracket kit can be used with the 31323 4 Bolt or 30686 10 Bolt Bed Rail Kit.

Caution: Do not install mounting 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.

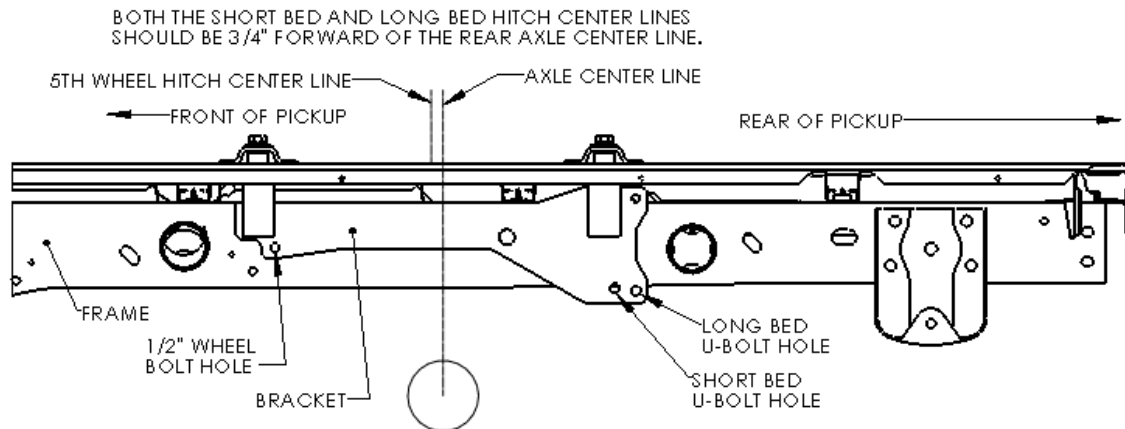
Complete Parts List		
Item No.	Description	Quantity
1	Driver Side Mounting Bracket	1
2	Passenger Side Mounting Bracket	1
3	1/4" Thick Spacer Plate	4
4	1" Spacer Tube	4
5	1/2" -13 X 1-1/2" Wheel Bolt	2
6	1/2" -13 Serrated Lock Nut	2
7	5/8" -11 X 3" Grade 5 Hex Head Bolt, Black	4
8	1/2" -13 Nylock Nut	4
9	5/8" Lock Washer, Black	4
10	5/8" Flat Washer, Black	4
11	1/2" Flat Washer	4
12	1/2" U-Bolt	2
13	5/8" -11 Tapped Plate	4
14	Pull Wire for 1/2"-13 Threaded Bolt	1

This kit may contain either one of the spacers (item 4) shown below.



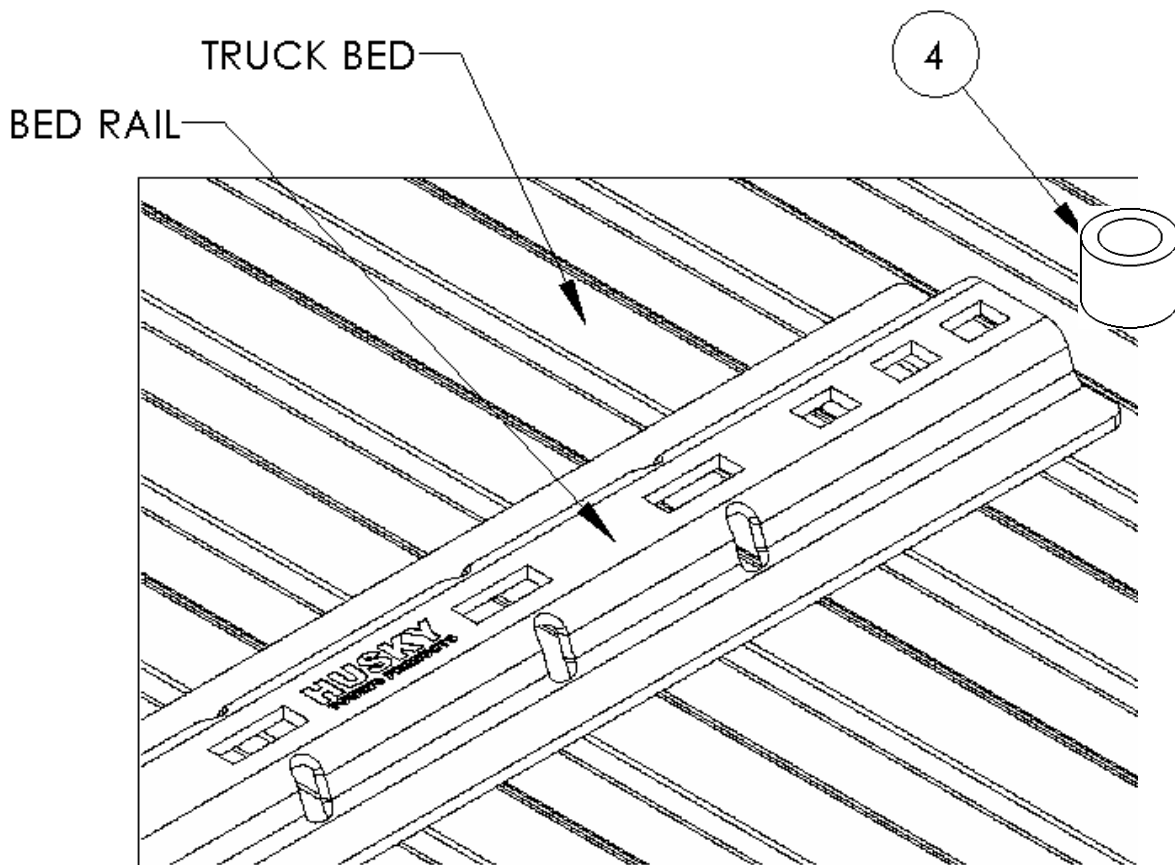


NOTE: CHECK CAB CLEARANCE REQUIREMENTS BEFORE INSTALLING HITCH. THE DISTANCE FROM THE CAB TO THE HITCH CENTER LINE IS APPROXIMATELY 56" (8' BED) AND 43" (6-1/2' BED)

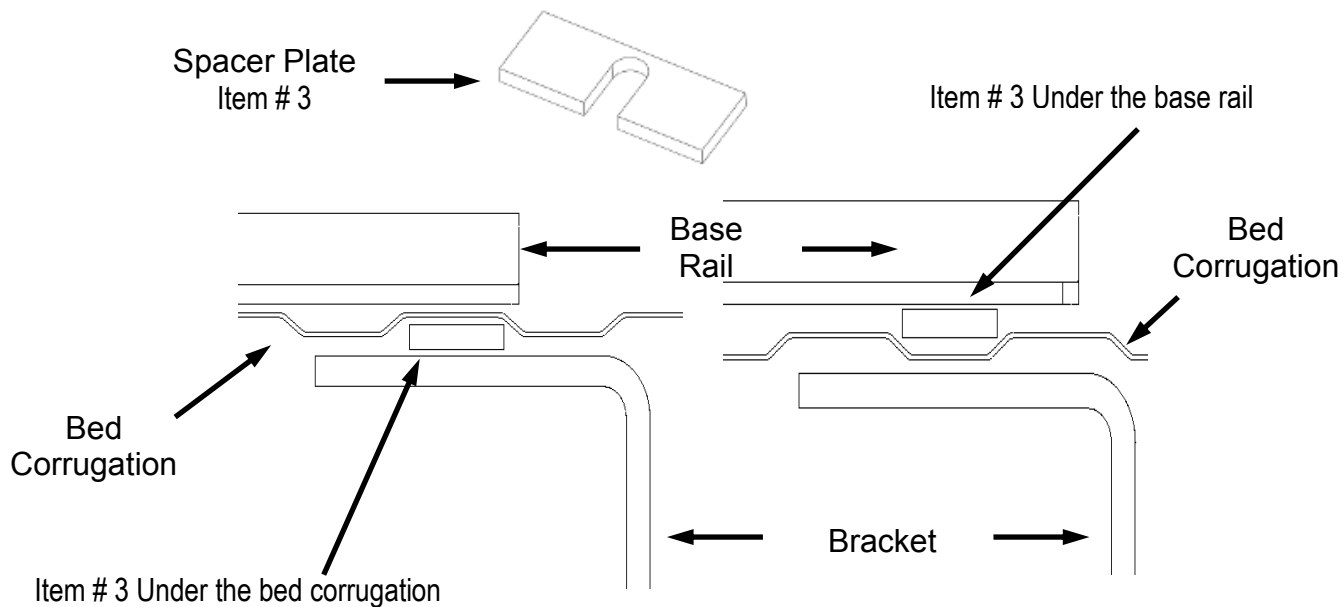


1. Place the two bed rails across the truck bed between the wheel wells. Position the 5th wheel uprights between the bed rails so that the tabs in the base of each upright will fit into the slots in the ends of the bed rails. Secure the uprights in place with the rail hitch pins and hair pins supplied with the 5th wheel installation kit. Securely attach 5th wheel cross member to uprights.
2. Position the bed rail assembly in truck bed as shown on the Illustration above. When hitch is correctly positioned in the bed and the bed rails are parallel, mark four attachment points on the truck bed using the $\frac{5}{8}$ " square holes indicated on the layout Illustration above. Check below the bed before drilling holes to see that all wiring, brake lines or other obstructions are moved out of the way and will not be contacted by the drill. Move the hitch assembly out of the way and drill four $\frac{5}{8}$ " diameter attachment holes down through the bed at the previously marked points.

3. Reposition the bed rails in the bed so that the square 5/8" hole in the end of each rail is lined up over the drilled holes. Place a 1" spacer tube (#4) under ends of each bed rail, in line with the drilled holes as shown in Illustration below.

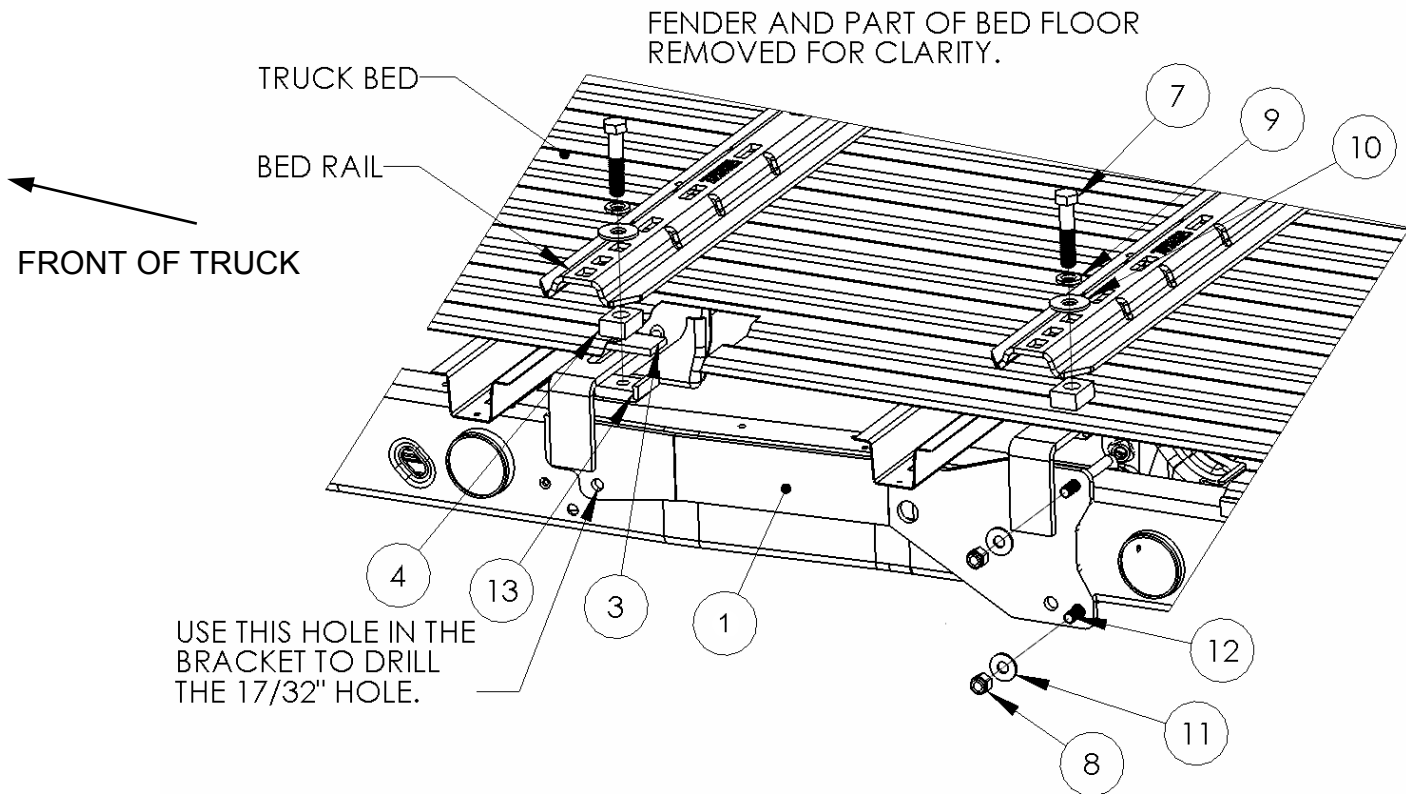


4. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a spacer plate (#3) in this location as shown on Illustration 2. If the corrugation is DOWN, at this location, place a spacer plate (#3) in the bed, under the base rail as shown in the Illustration below.

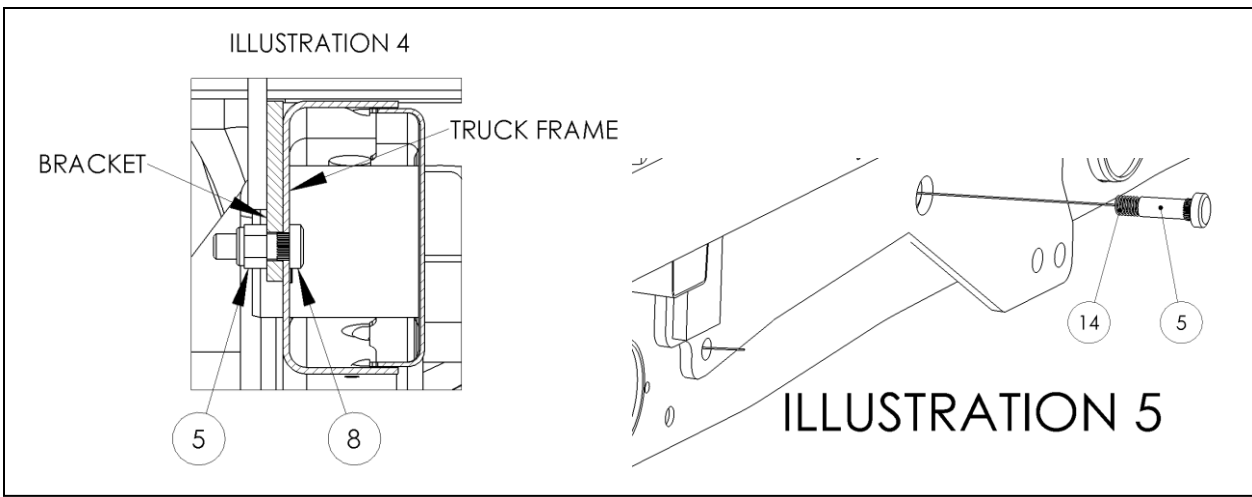


5. Position the left frame brackets (#1) up against the outer surface of the truck frame with the mounting tabs positioned over the frame and under the bed in line with previously drilled holes in bed.

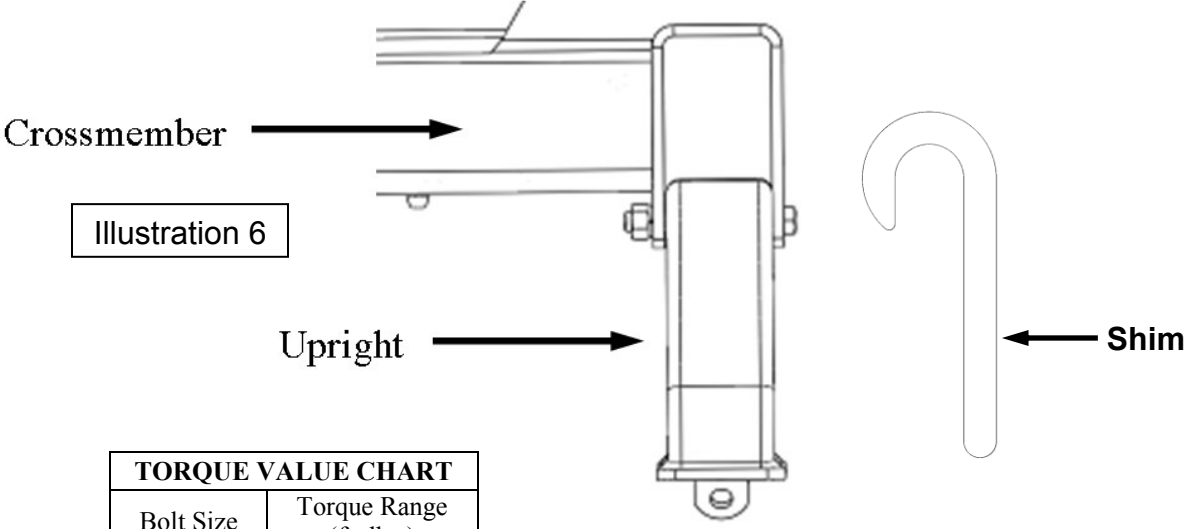
6. Place U-Bolt (#12) around the truck frame at about 12" behind rear axle shown in Illustration below. For U-Bolt holes to be used for long bed or short bed, see Illustration on page 2. Be careful to get drivers side U-Bolt under the wiring loom and up against the truck frame. (Do not pinch wires under the U-Bolt).
7. Move the frame bracket so that it rests tightly against the flat side of the truck frame and underneath of truck bed. Drop the 5/8" hex bolts with lock washer and flat washer down through bed rails and angle bracket. Thread bolts into tapped plates (#13) placed under frame bracket tabs. Loosely bolt frame brackets in place. Be sure they are tight against the side of truck frame shown in Illustration below.



- 7a. Push U-Bolt through bracket and use flat washer and hex nyloc nut to attach bracket to frame. See Illustration above.
8. Before drilling hole in front of bracket, check inside the frame to be sure that there are no wires, brake lines or other obstructions in the frame which may be contacted by the drill. Each of the frame brackets must be attached to the side frame of the truck with a special 1/2" wheel bolt at the forward hole and a U-Bolt at the rear holes. Be sure the bracket's 1" Diameter hole is over large slot in truck frame.
- 8a. At the front attachment point, drill a 17/32" hole through the side of the truck frame using the hole in each frame bracket as a guide as shown in Illustration above.
CAUTION: Holes MUST be drilled 17/32" diameter, so that the special wheel bolts will seat properly. If holes are too small, the bolt may break. If hole is too large, the bolt will not grip properly.



9. Insert the coiled end of the pull wire (#14) through 17/32" hole, angle the wire to guide the coiled end along the inside of the truck frame rearward. Continue feeding pull wire and look through the 1" dia. bracket hole for the coiled end of the pull wire. Use a pair of needle nose pliers to guide the coiled end of the pull wire out through the 1" dia. hole, ensure the other end of the pull wire remains protruding through the 17/32" hole. Thread the end of the wheel bolt into the coiled end of the pull wire completely. Carefully pull the other end of the pull wire and guide the wheel bolt into the 1" dia. bracket hole. Continue pulling wire so the threaded end of the wheel bolt can be pulled through the 17/32" dia. hole from the inside. Hold onto the wheel bolt with one hand and carefully remove the pull wire from the threads, then install the nylon loc nut onto the wheel bolt. Use of a air wrench will make seating the serrations of the wheel bolt into the hole much easier. Otherwise you can use a standard 1/2" nut to start pulling the wheel bolt through the hole and then replace it with the nylon loc nut.
10. Tighten all 1/2" attachment bolts to 75 ft.-lbs. and the 5/8" bolts to 125 – 160 ft.-lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.
11. Check each rail hitch pin for freedom of movement in the bed rail connection. Adjust uprights, if necessary, by placing shim 31582 or 30243 between the upright and the cross member to obtain free pin movement. See Illustration 6. Shims 31582 & 30243 sold separately.



TORQUE VALUE CHART	
Bolt Size	Torque Range (ft.-lbs.)
1/2"	65-85
9/16"	100-120
5/8"	125-160
3/4"	240-280