



# Assembly, Installation, Operation and Maintenance Instructions

## Kit, Base Rail Bracket Part # 31407

<b>Dealer / Installer:</b>	<b>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.</b>
<b>End User:</b>	<b>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.</b>

**APPLICATION:** 1999 - 2007 Ford F250 & F350 Super-Duty Pick-Ups

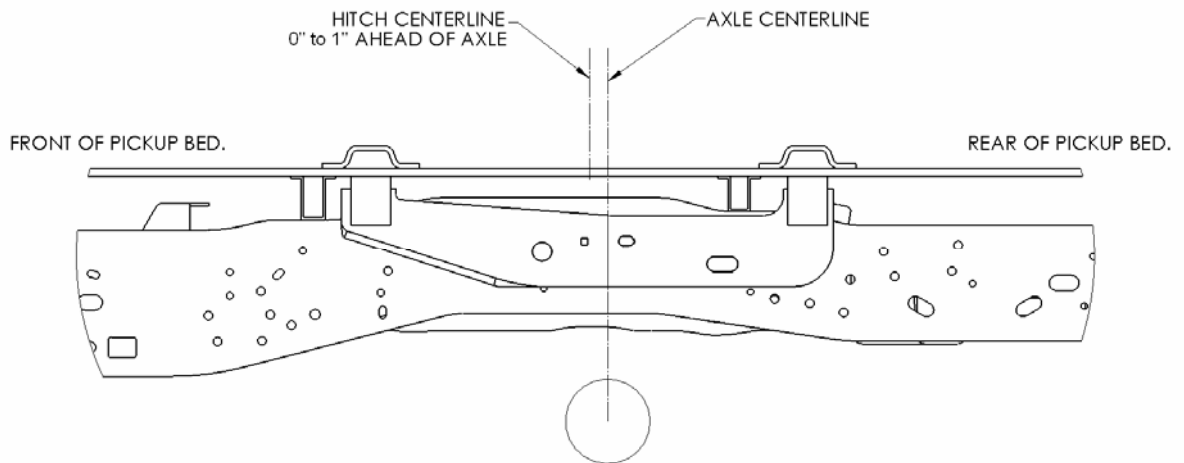
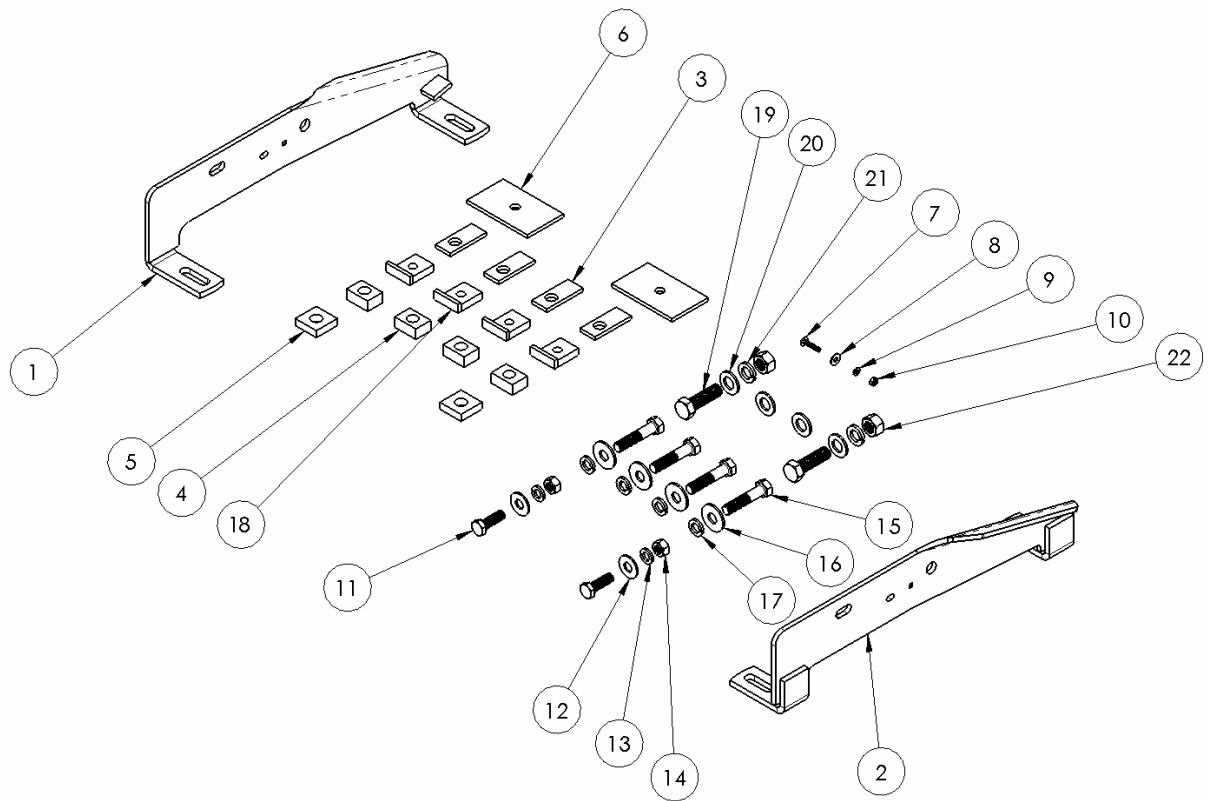
**NOTE:** This bracket kit is to be used with the 31323 Bed Rail Kit.

<b>Complete Parts List</b>			
Item No.	Part No.	Description	Quantity
1	ERD10584	Bracket, Right Frame - Weldment	1
2	ERD10585	Bracket, Left Frame - Weldment	1
3	ERD10383	Spacer Bed 1/4" Thick	4
4	ERD10031	Spacer Bed 3/4" Thick	4
5	ERD10385	Spacer Frame 1/2" Thick	2
6	ERD10577	Spacer Frame 1/4" Thick	2
7	ERD10578	Bolt, Carriage 1/4 -20 X 1-1/4	1
8	ERD10579	Flat Washer (1/4)	1
9	ERD10580	Lock Washer (1/4)	1
10	ERD10581	Hex Nut (1/4)	1
11	ERD10386	Bolt, Hex Head 9/16 -12 X 1-3/4"	2
12	ERD10392	Flat Washer (9/16)	4
13	ERD10388	Lock Washer (9/16)	2
14	ERD10389	Hex Nut (9/16 -12)	2
15	ERD10390	Bolt, Hex Head 5/8" -11 X 3"	4
16	ERD12188	Flat Washer (5/8)	4
17	ERD12187	Lock Washer (5/8)	4
18	ERD10393	Plate, Tapped (5/8 -11)	4
19	ERD10394	Bolt, Hex Head 3/4" -10 X 2-1/2"	2
20	ERD10392	Flat Washer (3/4)	4
21	ERD10396	Lock Washer (3/4)	2
22	ERD10397	Hex Nut (3/4 -10)	2

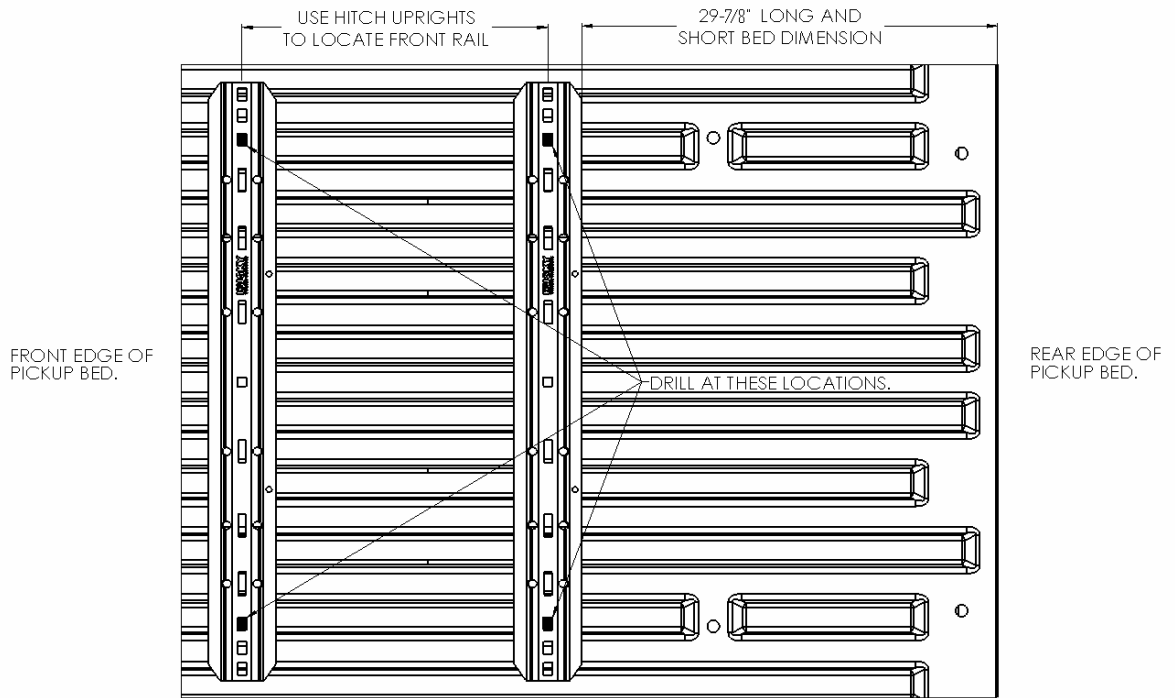
**Caution:** Do not install mounting rails over plastic bed liners. Plastic bed liners must be cut out of the way. Rails may be installed on spray in liners.

**Note:** Consult spray liner installer for recommended curing time.

<b>Tools Required</b>	
3/4" Socket/Wrench	1/4" Drill Bit
13/16" Socket/Wrench	9/16" Drill Bit
15/16" Socket/Wrench	5/8" Drill Bit
Drill	
Torque Wrench	



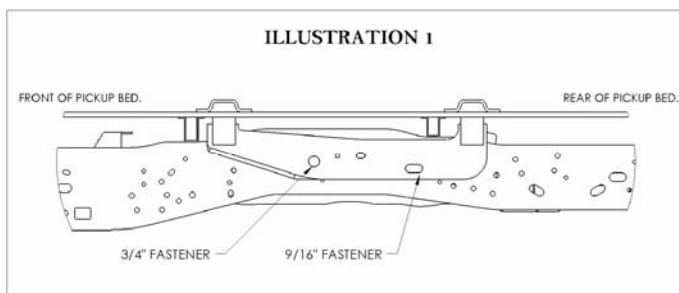
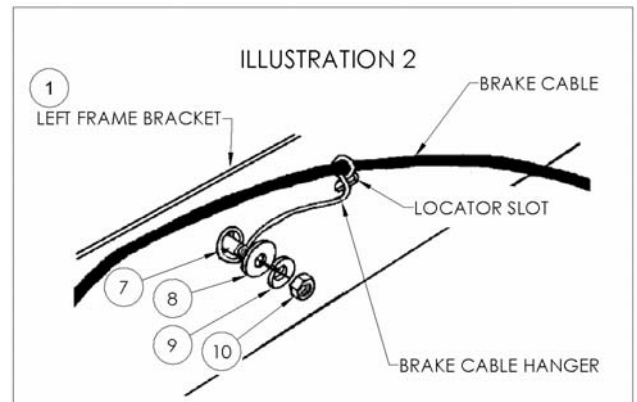
All Products limited to Vehicle Tow Rating; see Vehicle Owners Manual  
 April 2010 See [www.huskytow.com](http://www.huskytow.com) for Warranty Information / Tech Support



1. On some trucks there will be a brake cable hanger on the side of the frame where the frame bracket will be attached. Remove the brake cable hanger from outer surface of truck frame. The cable hanger will be re-installed later.

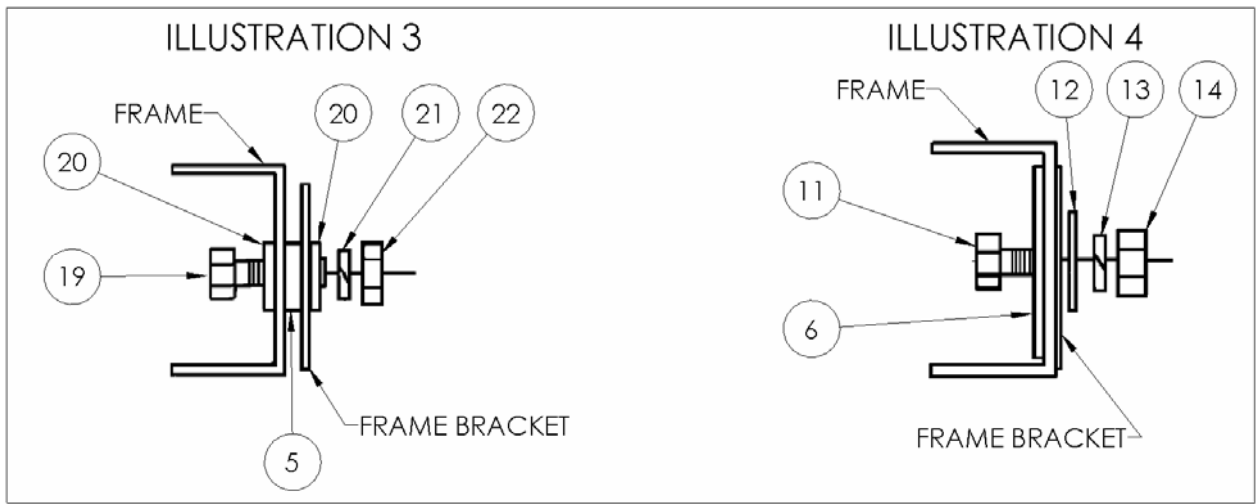
2. Position the right and left frame brackets #1 and #2 against their appropriate side of truck frame as shown on Illustration 1.

**NOTE:** On models where the cable hanger has been removed from frame, place the 1/4" carriage bolt (#7) through the left frame bracket before placing the bracket against the frame. See Illustration 2. The threaded end of the bolt should be extending out from the frame bracket. Place the brake cable hanger over the carriage bolt and secure as shown on Illustration 2. Be sure that the free end of the hanger is positioned into the locator slot in frame mount bracket, before tightening nut.

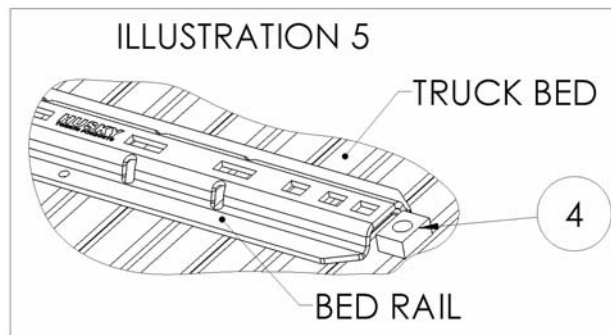


3. Place a 3/4" Hex bolt (#19) and 3/4" washer (#20) through the truck frame slot at the center attachment point in frame bracket. Place a 1/2" thick spacer plate (#5) on bolt between the truck frame and the frame bracket, as shown on Illustration 3. Bolt in place with a 3/4" flat washer (#15), 3/4" Lock washer (#16), and 3/4" hex nut (#17).

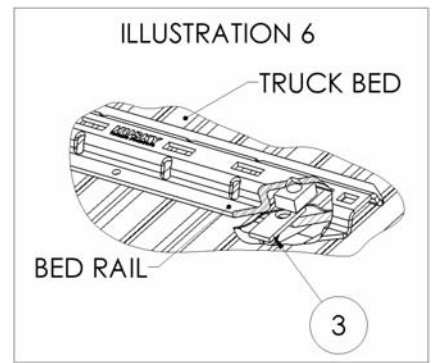
4. Place the 1/4" thick spacer plate (#6) inside each truck frame in line with the rear attachment hole. Position this plate with 5" dimension up and down in frame. Bolt reinforcement plates (#6) and frame brackets to frame with 9/16" fasteners as shown on Illustration 4. Do not tighten fasteners at this time.



5. Place the two bed rails across the truck bed between the wheel wells. Position the 5<sup>th</sup> 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 5<sup>th</sup> wheel installment kit. Securely attach 5<sup>th</sup> wheel cross member to uprights.
6. Position the bed rail assembly in truck bed as shown on the layout illustration on page 2 of this instruction sheet. When hitch is correctly positioned in the bed and the bed rails are parallel, mark four attachment points on the truck bed using the 5/8" square holes indicated on the layout Illustration on Page 3 of this document.
7. 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. Drill 1/4" pilot hole through bed floor at each previously marked location. Check to see that these holes line up with installed frame bracket mounting tabs. Adjust hole location as needed. Move the hitch assembly out of the way and drill four 5/8" diameter attachment holes down through the bed at the previously marked points.
8. 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 3/4" thick spacer block (#4) under ends of each bed rail, in line with the drilled holes. See Illustration 5.

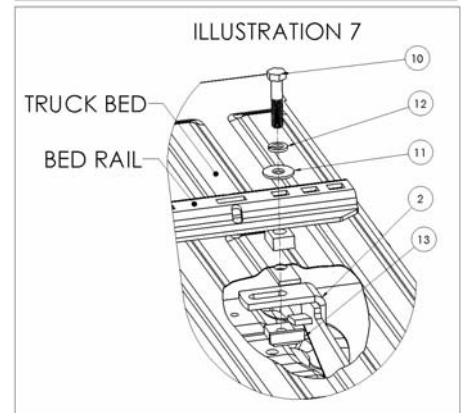
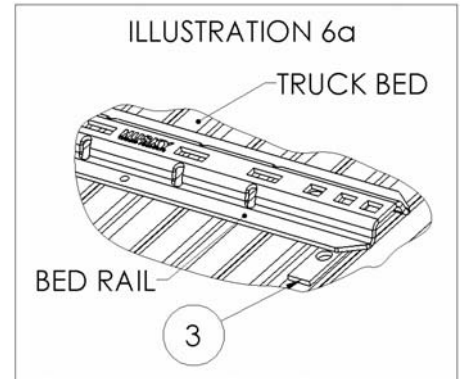


9. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a spacer plate (#3) in this location as shown on Illustration 6. If the corrugation is DOWN, at this location, place a spacer plate (#3) in the bed, under the base rail as shown on Illustration 6a. Bolt parts loosely in place as shown on Illustration 7.



10. Tighten all 1/4" attachment bolts to 8 ft.-lbs. torque, all 1/2" attachment bolts to 75 ft.-lbs. torque, all 9/16" attachment bolts to 110 ft.-lbs. torque, and all 3/4" bolts to 260 ft.-lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.

11. Tighten each 5/8" bed rail attachment bolt to 150 ft.-lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.



12. Check each rail hitch pin for freedom of movement in the bed rail connection. Adjust uprights, if necessary, by placing a shim between the upright and the cross member to obtain free pin movement. See Illustration 8.

