



Assembly, Installation, Operation and Maintenance Instructions

Kit, Base Rail Bracket

Part # 31410

For updates see **PRODUCT SUPPORT** tab at www.huskytow.com

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 warning decals from the product.

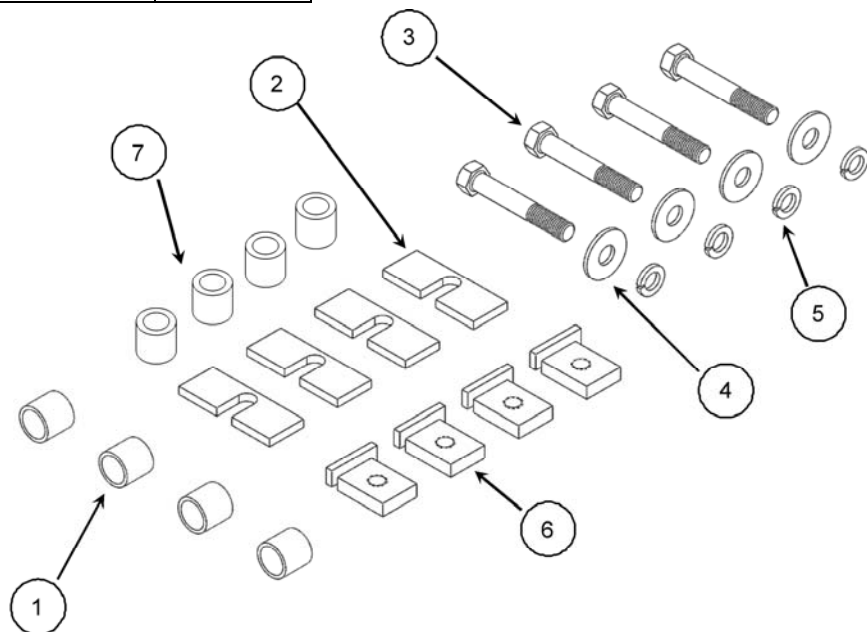
APPLICATION: 2007 – 2016 Toyota Tundra 5.5', 6.5' & 8' Beds Pick-up

Required Accessory : Husky Roller (32220) or Husky Glider (31196 or 32042) is required to use 5th wheel hitch with Crewmax 5-1/2' long bed truck.

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

Complete Parts List		
Item No.	Description	Quantity
1	Spacer, Tube 1-5/32" Long	4
2	Spacer, Plate	4
3	Bolt, Hex Head, 5/8 -11 X 4"	4
4	Flat Washer (5/8)	4
5	Lock Washer (5/8)	4
6	Plate, Tapped 5/8 -11	4
7	1" Spacer Tube	4

Tools Required
15/16" Socket & Wrench
Torque Wrench
Safety Glasses



- 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. See Figure 1.

Note: Drill to the inside of the square opening on the front bed rail. See Detail A.

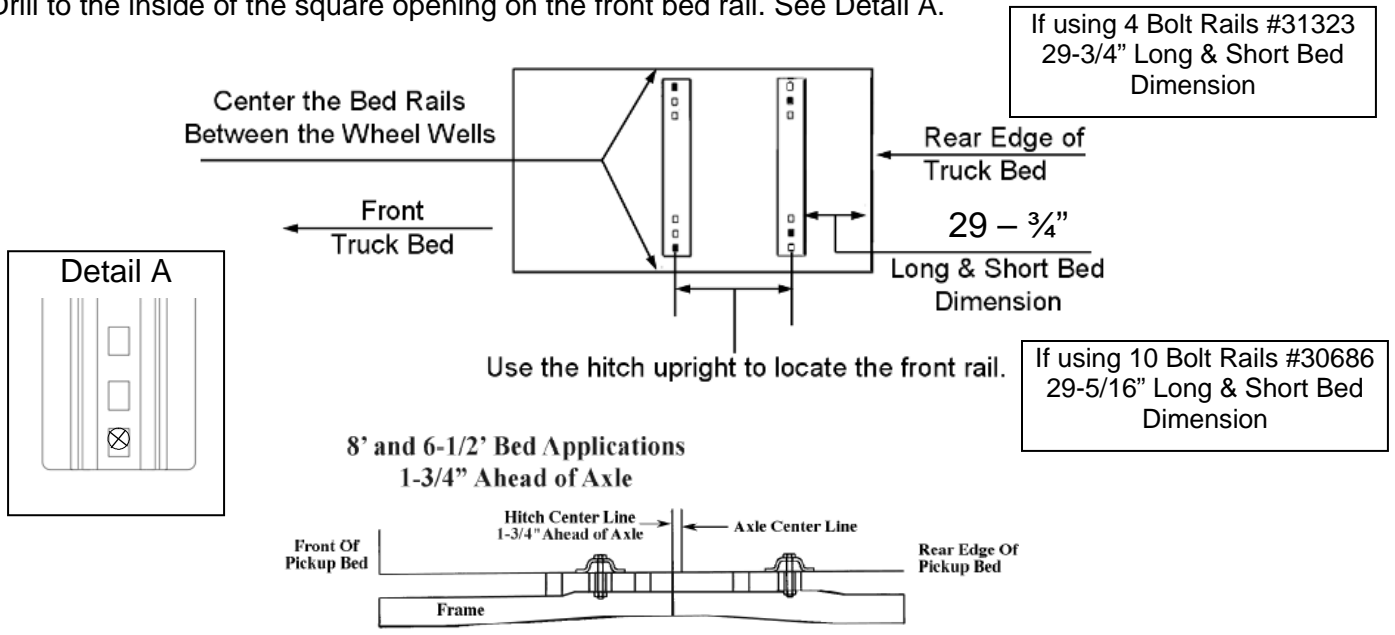


Figure 1

- At the driver's side front bolt location there is an EPA fuel canister that is attached to the frame with one nut. Remove this nut and let this canister hang down until the hitch is installed, then it will be set back in place.
- Position the bed rail assembly in truck bed as shown Figure 1 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 Figure. 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 5/8" diameter attachment holes down through the bed and truck frame at the previously marked points.
- Reposition the bed rails in the bed so that the square 5/8" holes in the rail are line up over the drilled holes. Place a 3/4" thick spacer block #7 under ends of each bed rail, in line with the drilled holes. See Figure 2.

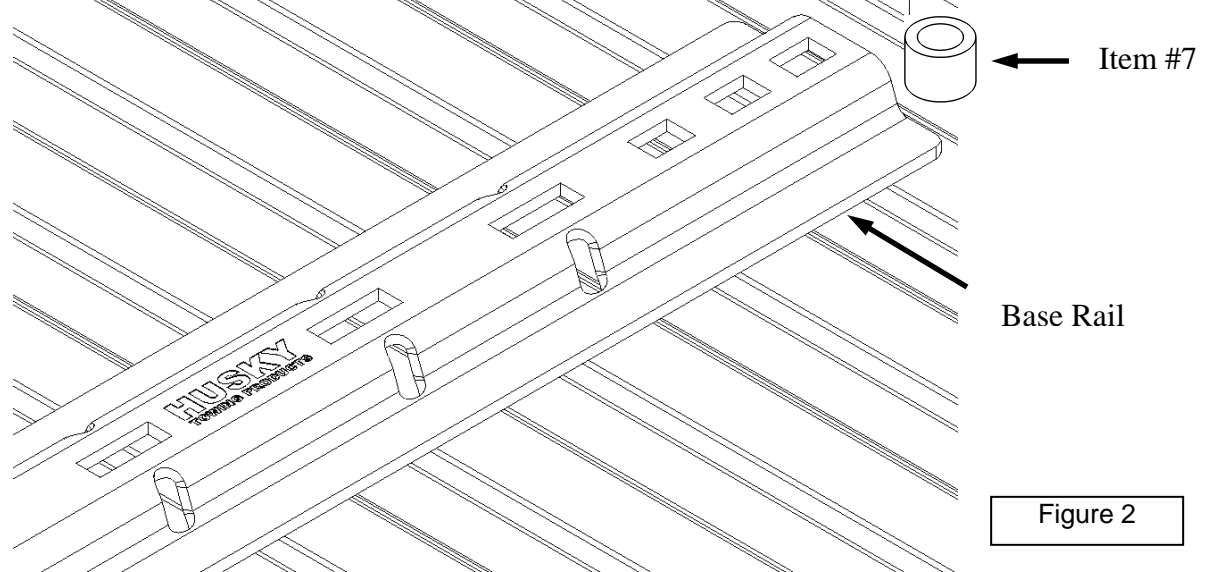
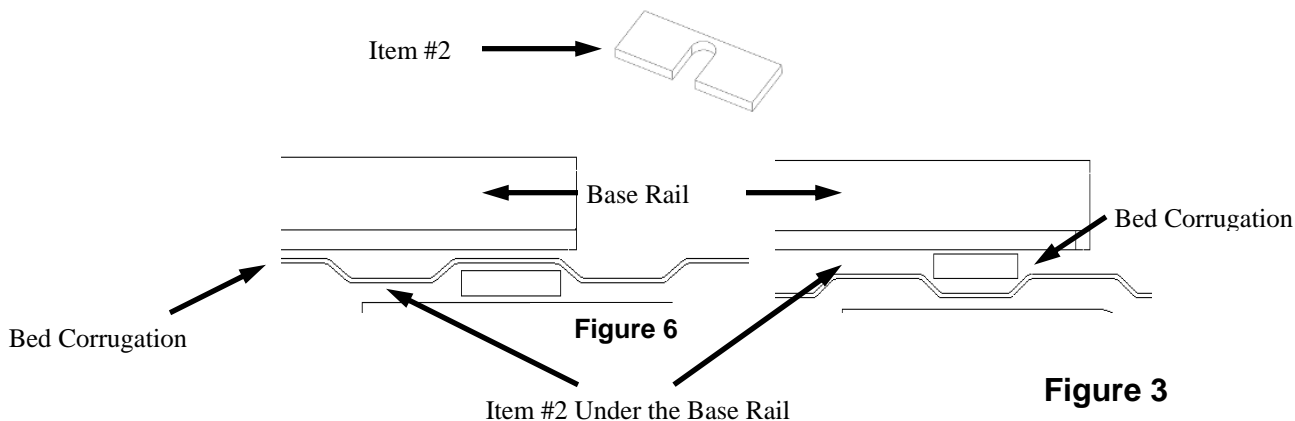


Figure 2

If the bed corrugation above the frame attachment is UP, leaving a space above the frame, place a spacer plate #2 in this location as shown on Figure 3. If the corrugation is DOWN, at this location, place a spacer plate #2 in the bed, under the base rail as shown on Figure 3.



- Position the 1-5/32" long tube spacer #1 between the frame and bed of the truck at the drilled hole locations. Then drop the 5/8" x 4" hex bolt #3 with a lock washer #5, flat washer #4, down through the bed rail and spacers, tube spacers and truck frame. Turn the tapped plate #6 onto the 5/8" hex bolt #3 with the tab bar facing down away from the truck frame. See Figure 4.

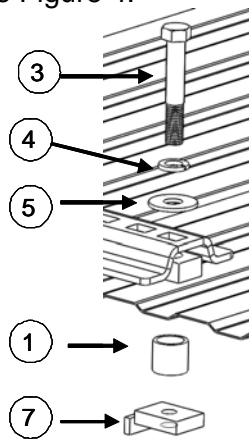
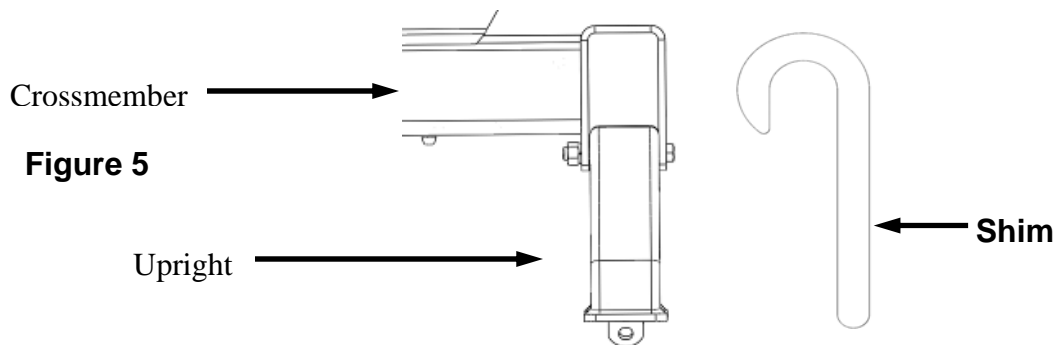


Figure 4

- Check each base rail hitch pin for freedom of movement before tightening the 5/8" base rail bolts. Adjust uprights, if necessary, by placing shim 31582 or 30243 between the upright and the cross member to obtain free pin movement. See Figure 5. Shims 31582 & 30243 sold separately.



- Tighten each 5/8" bed rail bolt to 125 – 160 ft.-lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.
- Set EPA Fuel canister back up in place and fasten with nut removed in step #2.

#31410 CUSTOM BRACKET KIT

TOYOTA TUNDRA

**ENSEMBLE DE SUPPORTS SUR
MESURE TOYOTA TUNDRA**



HUSKY
TOWING PRODUCTS

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Designed & tested in the USA & Made in China for /
Conçu et testé aux É.-U. et fabriqué en Chine DTS
Manufacturing, Wilsonville, OR 97070



P.O. #:



The date code for this product is located on the UPC label

Please retain this info for your records.

Warranty Terms:

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Husky Towing Products and Keystone Automotive Operations Inc. make no guarantees or warranties for products not manufactured by Keystone Automotive Operations Inc. Such products are covered solely under any applicable warranty of the manufacturer. It is always recommended that the operating instructions and guarantee instructions provided by the manufacturer are followed.

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