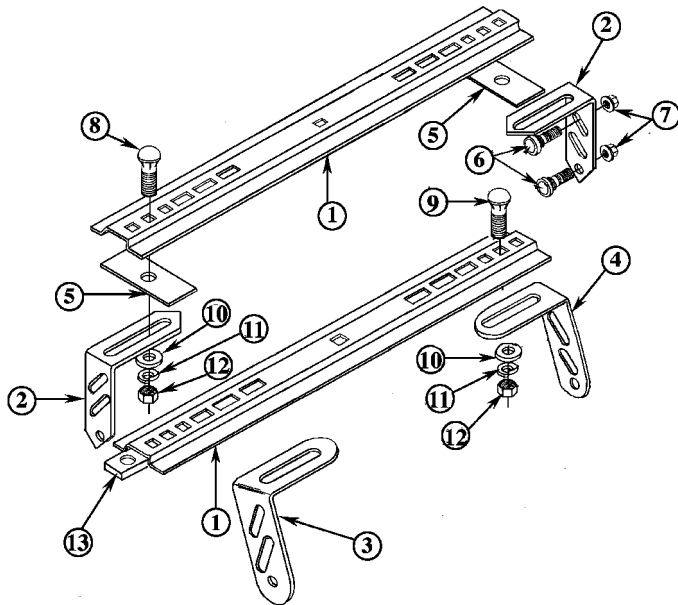


PART NO. 70550 & 70044 BED RAIL INSTALLATION KIT



PARTS INCLUDE:

1.	1425-09	Bed Rail	(2)
2.	1585-03	Straight "L" Bracket	(2)
3.	4843-02	Left Angle Bracket	(1)
4.	2001-07	Right Angle Bracket	(1)
5.	1586-02	Spacer Plate	(4)
6.	3266-05	1/2 x 1-1/2 Wheel Bolt	(8)
7.	1828-03	1/2 Flange Locknut	(8)
8.	3241-02	5/8 x 3-1/2 Carriage Bolt	(2)
9.	1587-04	5/8 x 3 Carriage Bolt	(2)
10.	1732-09	5/8 Flatwasher	(4)
11.	1881-03	5/8 Lockwasher	(4)
12.	1863-03	5/8 Hex Nut	(4)
13.	3281-02	3/4 Spacer Block	(4)
14.	4892-07	Pull Wire	(1)
15.	1001-03	3/16" Spacer Plate	(1)

Refer to the 5th WHEEL HITCH INSTRUCTIONS for assembly and installation of the head portion of hitch

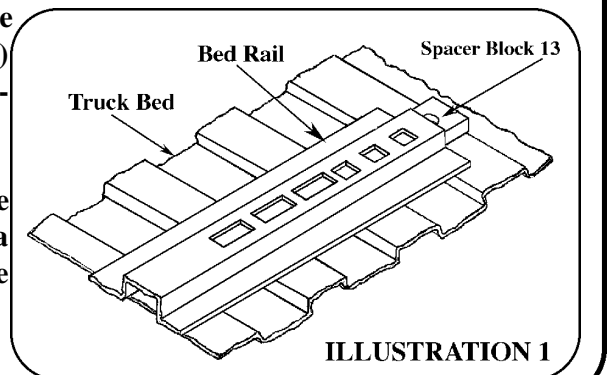
BED RAIL INSTALLATION INSTRUCTIONS

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. On most applications, the 5th wheel assembly should be positioned so that it is approximately centered over the truck axle and between the wheel wells on the bed floor. **NOTE:** To keep the trailer from hitting the cab on tight turns there must be at least 52" between the hitch and the cab. On long bed pickups the hitch center line can be up to 3" ahead of the axle. On short bed pickups this position is not possible. A 5th wheel hitch Glider #70460 is required so the hitch can be moved rearward before making a tight turn.

3. When hitch is correctly positioned in the bed and the bed rails are parallel, mark four attachment points on the truck bed using whichever one of the three (3) 5/8" square holes at the ends of each bed rail line up best with the truck frame. 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 (4) 5/8" diameter attachment holes down through the bed at the previously marked points.

4. 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 #13 under ends of each bed rail, in line with the drilled holes as shown on Illustration 1.



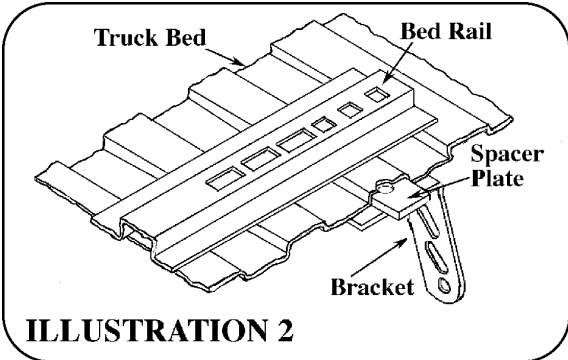


ILLUSTRATION 2

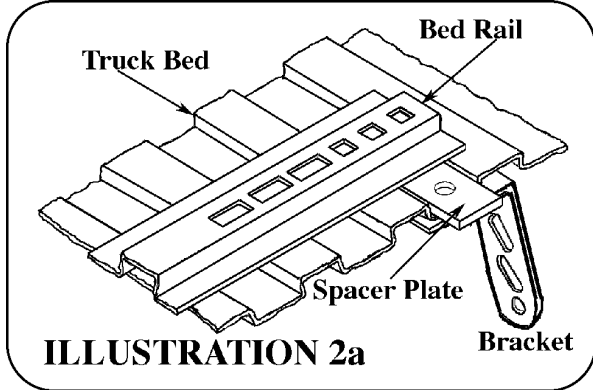


ILLUSTRATION 2a

5. If the bed corrugation above the angle bracket is *UP*, leaving a space above the angle bracket, place a spacer plate #5 in this location as shown on Illustration 2. If the corrugation is *DOWN*, at this location, place a spacer plate #5 in the bed, under the base rail as shown on Illustration 2a. Bolt parts loosely in place as illustrated.

6. Position one of the angle brackets under the bed and align with the 5/8" carriage bolts protruding down through the bed. Use the left and right angle brackets at locations where frame obstructions will not allow the straight "L" brackets to be positioned. If frame is clear of obstructions, the angle brackets may be placed at any location.

7. Move the installed straight "L" or angle brackets so that they rest tightly against the flat side of the truck frame and underneath surface of truck bed. Drop the 5/8" bolts down through bed rails and bracket.
NOTE: There are two lengths of 5/8" carriage bolts. Use the shorter bolts on applications where vehicle frame clearance may be close to attachment point. Bolts can be used in any attachment location. Securely bolt brackets in place. Be sure they are tight against the side of truck frame. Tighten the 5/8" bolts to 125-160 ft. lbs. torque

8. Before drilling any holes, 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 brackets must be attached to the side frame of the truck with two (2) special 1/2" wheel bolts. Drill two 17/32" holes through the side of the truck frame using two of the holes in each angle bracket as guides.

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 it will not grip properly. See Illustration "A"

SPECIAL NOTE: On 1999-2001 Chevrolet Silverado and GMC Sierra applications, it will be necessary to modify the bolt installation procedure on the forward driver side bracket attachment.

Drill a 5/8" diameter frame attachment hole at the lower bracket attachment point. Place one of the 1/2" wheel bolts #6 in the 3/16" spacer plate #15. Place this bolt assembly into frame so that the threaded end of bolt protrudes out through frame. Bolt bracket in place at this location. See Illustration "B". The remaining bracket bolts will install as shown on Illustration "A".

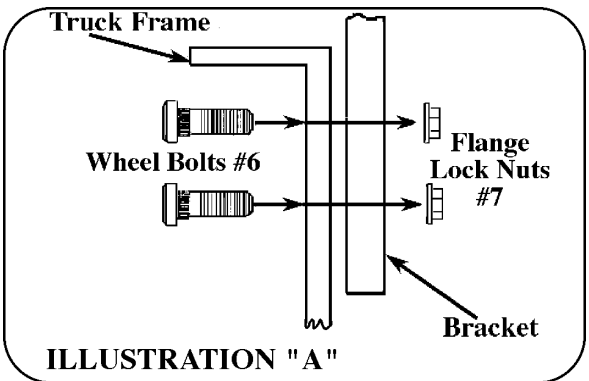


ILLUSTRATION "A"

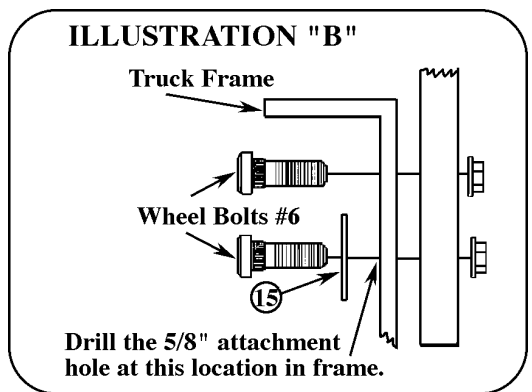
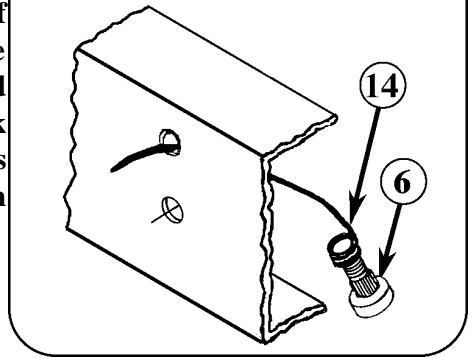


ILLUSTRATION "B"

9. Place the special bolts into the frame first and then out through the brackets. See Illustration "A". Some applications will require the use of a pull wire to align the bolts into the drilled holes in the frame. Thread the pull wire coil over the end of the wheel bolt and pull through frame and bracket. See Pull Wire Illustration. Secure each bracket to the truck frame. The knurled portion of the bolts will lock into the frame holes as the nuts are tightened. Use of an air wrench will make installation much better.

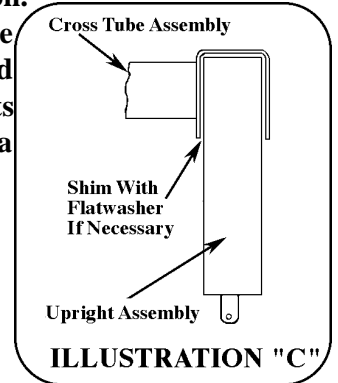
Pull Wire Illustration



10. Tighten all 1/2" attachment bolts to 75 ft. lbs. torque.

11. Check each rail hitch pin for freedom of movement in the bed rail connection. Remove the (4) pins and lift the hitch uprights up out of the bed rail slots. If tabs are tight in bed rail slots check to be sure the bed rails are parallel to one another and square. If not, loosen 5/8" bolts and adjust the bed rails. Also, check that the uprights are sitting straight vertically. It may be necessary to shim the uprights by placing a washer between it and the crossmember channel. See Illustration "C".

12. Re-tighten the 5/8" bolts to 125-160 ft. lbs. torque.



5TH WHEEL INSTALLATION TIPS BY VEHICLE

Due to variations in vehicle assembly through the years listed, the under bed cross member location on your truck may not be the same as listed below. *The following information is to be used as a suggestion for placement of the bed rail system. Slight adjustments to these positions may be required.*

SEE ILLUSTRATION ON LAST PAGE FOR BED RAIL LOCATION REFERENCE AND CUSTOM INSTALLATION BRACKET KITS

DODGE P/U Applications

1993-EARLIER DODGE P/U FULL SIZE (*ahead of axle installation*)

Position the assembled 5th wheel hitch so that its center line is approximately 2" ahead of the truck axle center line. Rear base rail should be located 32-1/2" from rear edge of bed on all trucks. The left and right angle brackets can be positioned at any location that will allow them to clear obstructions on the truck frame.

1994-2001 DODGE P/U FULL SIZE SHORT BED (*behind axle installation*)

With this installation, the #56800 adapter kit will be needed. This kit replaces the forward brackets and bolts directly down through top of truck frame. Rear base rail should be located 25-3/16" from rear edge of bed on short bed trucks.

1994-2001 DODGE P/U FULL SIZE LONG BED (*over axle installation*)

With this installation, the #56800 adapter kit will be needed. This kit replaces the forward brackets and bolts directly down through top of truck frame. Rear base rail should be located 29-3/16" from rear edge of bed on long bed trucks. The straight "L" brackets are used at the rear attachment position. NOTE: On some long bed applications, the edge of the bed cross members may not allow the formed angle brackets supplied with the bed rail kit to align with the bed rail attachment points. The use of two straight "L" brackets at this location will eliminate this problem.

FORD P/U Applications

1973-91 FORD F-SERIES P/U (*over axle installation*)

Position the assembled 5th wheel so that it is centered over the truck axle. Rear base rail should be located 28-5/8" from rear edge of bed on long bed trucks and 29-3/4" from rear edge of bed on short bed trucks. Use the left and right angle brackets to clear the shock mount brackets on the side of the truck frame, at the rear attachments.

On some Ford short bed applications or other trucks with frame obstructions, the use of four angle brackets can ease installation. Order Kit #53850, which includes the left and right angle brackets.

1992-96 FORD F-150 & F-250 P/U--1997-98 F-250 HD (*over axle installation*)

Position the assembled 5th wheel hitch so that it is centered over the truck axle. Rear base rail should be located 28-3/8" from rear edge of bed on long bed trucks and 27-3/4" from rear edge of bed on short bed trucks. This will place both of the hitch bed rail attachment points to the rear of both truck under bed cross members. Use the left and right angle brackets to clear the shock mount brackets when attaching to the side of the truck frame.

1997-98 FORD F-350 P/U (*behind axle installation*)

Due to some heavy duty suspension components on various models of this truck, the assembled 5th wheel must be positioned to the rear of the axle centerline. Rear base rail should be located 28-3/8" from rear edge of bed on long bed trucks and 27-3/4" from rear edge of bed on short bed trucks. Check the angle bracket to frame attachment points to find the best location as close to the axle centerline as possible.

1997-04 FORD F-150 & F-250 P/U (except HD F-250 & 2004 F150 new body) (*over axle installation*)

Some installations may position the base rails so that the attachment holes are drilled down through the front under bed reinforcement channel and the truck frame. On these applications, use the tube spacer kit #56810, which is purchased separately See page 6. The angles from this kit are used at the rear locations. Rear base rail should be located 26-3/4" from rear edge of bed on long and short bed trucks.

1999-2002 FORD F 250 & F 350 SUPER DUTY (*over axle installation*)

Position the assembled 5th wheel hitch so that its centerline is centered over the truck axle. Rear base rail should be located 28-1/4" from rear edge of bed on all trucks. If the truck is equipped with overload springs, the spring bracket, on the side of the frame, will have to be temporarily removed. Holes in the frame and spring brackets must be enlarged to accept 1/2" bolts. Use the straight brackets on the front base rail and the angled brackets at the rear base rail. The rear angle brackets will line up with the previously removed overload spring brackets. Reinstall the spring brackets on top of the angle brackets. The rear spring bracket attachment points will require 3/8" thick spacers and longer 1/2" bolts, not supplied, to install.

The use of a 56840 spacer kit will allow installation without the use of the angle brackets. However, the hitch centerline will be approximately 2" behind axle.

TOYOTA P/U Applications

2000-04 TOYOTA TUNDRA LONG & SHORT BED P/U (*over axle installation*)

Position the assembled 5th wheel hitch so that its centerline is over the truck axle. Rear base rail should be located 30-7/8" from rear edge of bed on all trucks. The left and right angle brackets will be placed at the rear attachment points and the straight brackets will be at the forward attachment points

CHEVROLET/GMC P/U Applications

1988-2000 CHEVROLET/GMC C/K LONG BED P/U *(over axle installation)*

Position the assembled 5th wheel hitch so that its center line is over the truck axle center line. Rear base rail should be located 29-7/8" from rear edge of bed on long bed trucks. The left and right angle brackets may be placed at whatever location will give the best attachment points on the truck side frame. Use angle brackets opposite of opposing shock absorbers.

1988-99 CHEVROLET/GMC C/K SHORT BED P/U *(over axle installation)*

Position the assembled 5th wheel hitch so that it is located directly over the truck axle. Rear base rail should be located 24-3/8" from rear edge of bed on short bed trucks. Check clearance between front of trailer and back of truck cab. If there is not enough clearance at this location, install The Glider kit #70460, which will allow rearward movement of the fifth wheel during maneuvering operations.

1999-2002 CHEVROLET/GMC SILVERADO/SIERRA LONG BED P/U *(ahead of axle installation)*

Position the assembled 5th wheel hitch so that its centerline is approximately 1" forward of truck axle centerline. Rear base rail should be located 31-1/2" from rear edge of bed on long bed trucks. The left and right angle brackets will be placed at the rear attachment points and the straight brackets will be at the forward attachment points. The front frame to bracket attachment bolts will need to be fishwired into the forward box frame section. The left and right angle brackets may be placed at whatever location will give the best attachment points on the truck side frame. Use angle brackets opposite of opposing shock absorbers. See special note on Page 2 Step 8.

1999-2002 CHEVROLET/GMC SILVERADO/SIERRA SHORT BED P/U *(behind axle installation)*

Position the assembled 5th wheel hitch so that its centerline is approximately 1" behind the truck axle centerline. Rear base rail should be located 24" from rear edge of bed on short bed trucks. The left and right angle brackets will be placed at the forward attachment points and the straight brackets will be at the rear attachment points. The front frame bracket attachment bolts will need to be fishwired into the forward box frame section. Use the 5/8" x 3" bolts at the forward base rail attachment points and the 5/8" x 3-1/2" bolts at the rear base rail attachment points. See special note on Page 2 Step 8.

For Custom base rail installation use base rail kit 70580 and one of the custom bracket kits listed below.

CUSTOM INSTALLATION KITS

55090**1999-04 Chevy/GMC Silverado/Sierra P/U
55100**1988-99 Chevy/GMC C/K P/U
55110**1994-02 Dodge P/U All (exc. 2002 1500)
55130**1999-04 Ford Super Duty P/U
55140**1997-04 Ford F150/F250 Light Duty P/U
55150**1998-older Ford F250HD & F350 P/U
55150**1996-older Ford F150/F250 P/U
55150**2000-04 Toyota Tundra P/U
55190**2002 Dodge Ram 1500 P/U
55190**2003-04 Dodge Ram P/U (all)

