

# ***INSTALLATION INSTRUCTIONS***

Rev. 2

**MODEL NO. 55080**

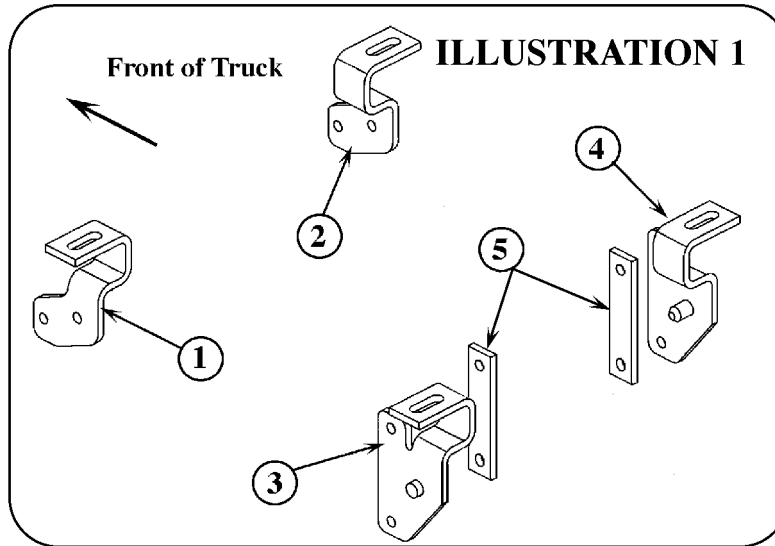
**APPLICATION:** 2004-09 Ford F150 P/U (New Body Style)

**NOTE:** This bracket kit is to be used with the 70580 Bed Rail Kit.

### ***COMPLETE PARTS LIST***

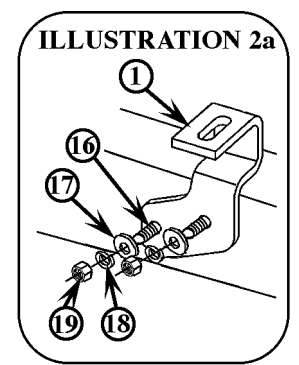
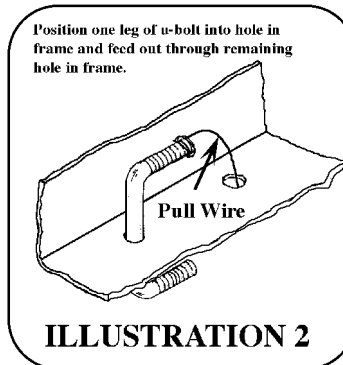
<b>Part</b>	<b>Description</b>	<b>Quantity</b>
1.	2284-08 Lt. Front Bracket	(1)
2.	2285-05 Rt. Front Bracket	(1)
3.	2288-08 Lt. Rear Bracket	(1)
4.	2289-01 Rt. Rear Bracket	(1)
5.	2283-06 Rear Mount Straps	(2)
6.	2605-01 Spacer Plate	(4)
7.	3281-02 3/4 Spacer Block	(4)
8.	4434-06 5/8-11 x 3 Hex Bolt	(4)
9.	1732-09 5/8 Wide Flatwasher	(4)
10.	1843-03 5/8 Flatwasher	(4)

<b>Part</b>	<b>Description</b>	<b>Quantity</b>
11.	1881-03 5/8 Lockwasher	(4)
12.	1863-03 5/8-11 Hex Nut	(4)
13.	2953-03 1/2-13 x 4-1/2 Hex Bolt	(4)
14.	3730-05 1/2 Conical Washer	(4)
15.	4034-05 1/2-13 Nylon Lock Nut	(4)
16.	3119-02 7/16 U-Bolts	(2)
17.	1887-03 7/16 Flatwasher	(4)
18.	1879-03 7/16 Lockwasher	(4)
19.	1861-03 7/16-14 Hex Nut	(4)
20.	4762-01 7/16 Pull Wire	(1)

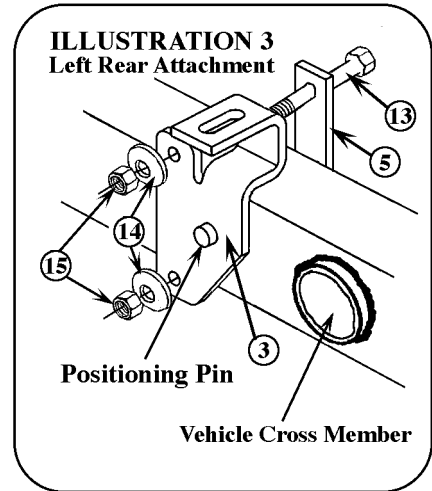


1. Locate the two holes in the outer surface of the left truck frame behind the shock mount. Place the pull wire on one leg of u-bolt #16 as shown on Illustration 2 and install u-bolt into the two holes in truck frame.

1a. Position the left front bracket #1 against the truck frame so previously installed u-bolt extends out through the two holes in bracket. Bolt bracket loosely in place as shown on Illustration 2a. Repeat installation procedure on right side of truck using the right front bracket #2.

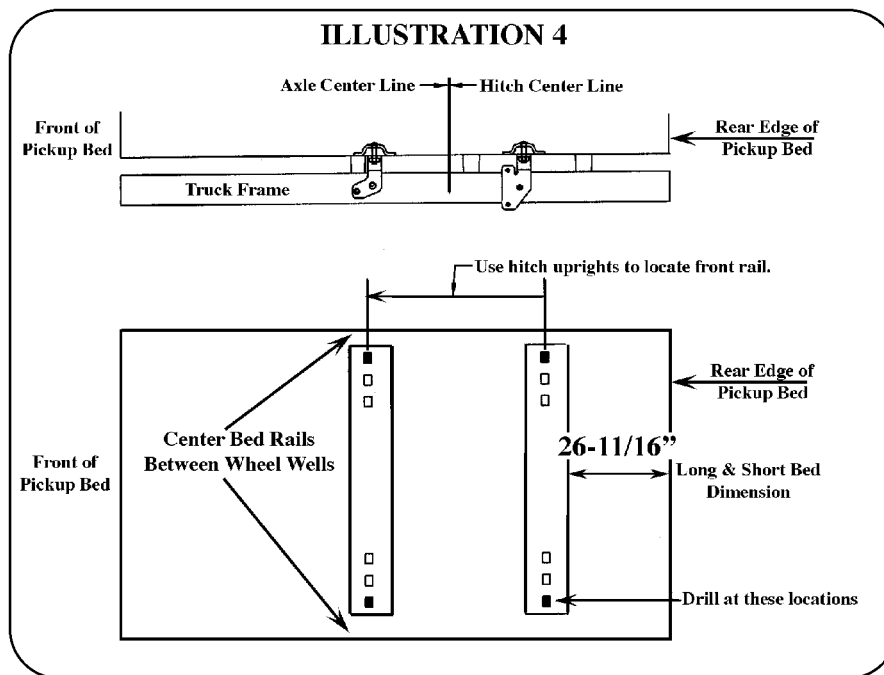


- Position the left rear bracket #3 against outer surface of truck frame, just forward of the round tube cross member welded into the frame. There will be a hole near the center of the frame where the positioning pin in bracket will be inserted. Place one of the rear mount straps #5, against the inner surface of the truck frame and bolt in place with 1/2" bolts #13. These bolts will go above and below the truck frame and connect bracket #3 and strap #5 together. See Illustration 3. Repeat installation procedure on right side of vehicle using the right rear bracket #4 and remaining rear mount strap #5.



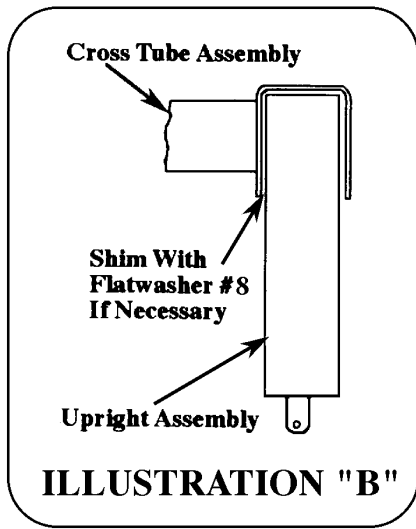
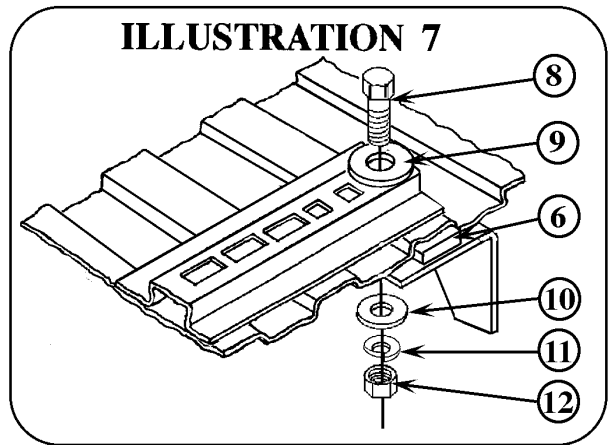
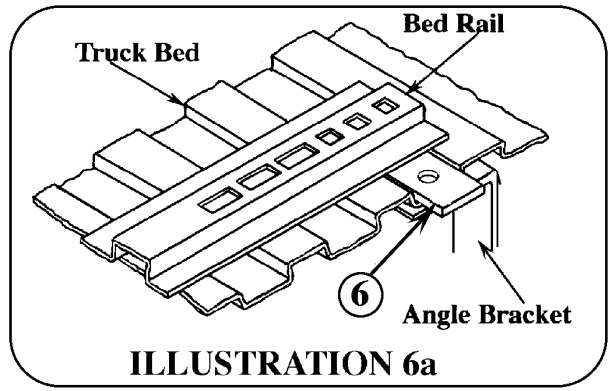
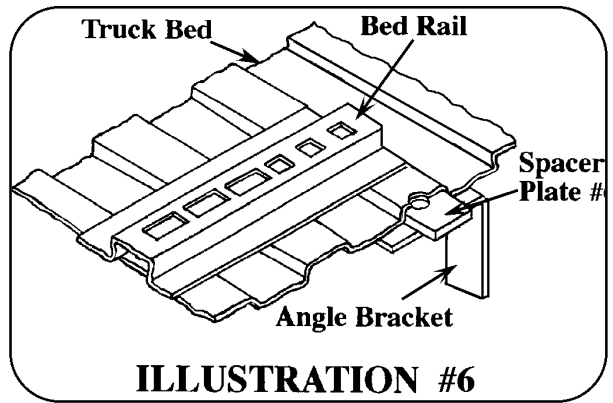
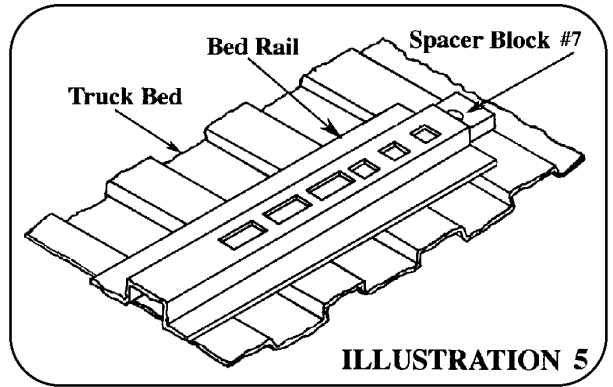
**CAUTION:** Do not install mounting rails over plastic bed liners. Plastic bed liners must be cut out of the way. Rails may be installed on spray in liners.  
**NOTE:** Consult spray liner installer for recommended curing time.

- 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 matching slots in 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.
- Position the bed rail assembly in truck bed as shown on Illustration 4. Be sure to center bed rails between wheel wells. 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 Illustration 4. 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 a 1/4" pilot hole down through the end square hole in each bed rail. Check under bed to see that holes line up with slots in top of previously installed frame brackets. Make adjustments in bed rail placement as needed. Move bed rail assembly away from hole locations and drill a 5/8" hole down through bed at pilot holes. Take care that drill bit does not contact the under bed frame brackets.

5. 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 #7 under ends of each bed rail, in line with the drilled holes as shown on Illustration 5.
6. If the bed corrugation above the angle bracket is UP, leaving a space above the angle bracket, place a spacer plate #6 in this location as shown on Illustration 6. If the corrugation is DOWN, at this location, place a spacer plate #6 in the bed, under the base rail as shown on Illustration 6a. Bolt parts loosely in place as shown on Illustration 7.
7. Tighten all 1/2" attachment bolts to 75 ft. lbs. torque. Tighten 7/16 U-Bolts to 35 ft. lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.
8. Check each bed rail hitch pin for freedom of movement before tightening the 5/8" bed rail bolts. Adjust the uprights, if necessary by placing a washer between the upright and cross member to obtain free pin movement. See Illustration "B".
9. Tighten the 5/8" bolts to 125-160 ft. lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.



For information regarding this product, or our warranty, contact your dealer or write to:  
 "CUSTOMER SERVICE MANAGER" P.O. Box 850, Lodi, CA 95241

This product complies with regulation V-5, C.S.A Standard D-264 and safety requirements for connecting devices and towing systems of the State of New York