

# ***INSTALLATION INSTRUCTIONS***

**MODEL NO. 55091**

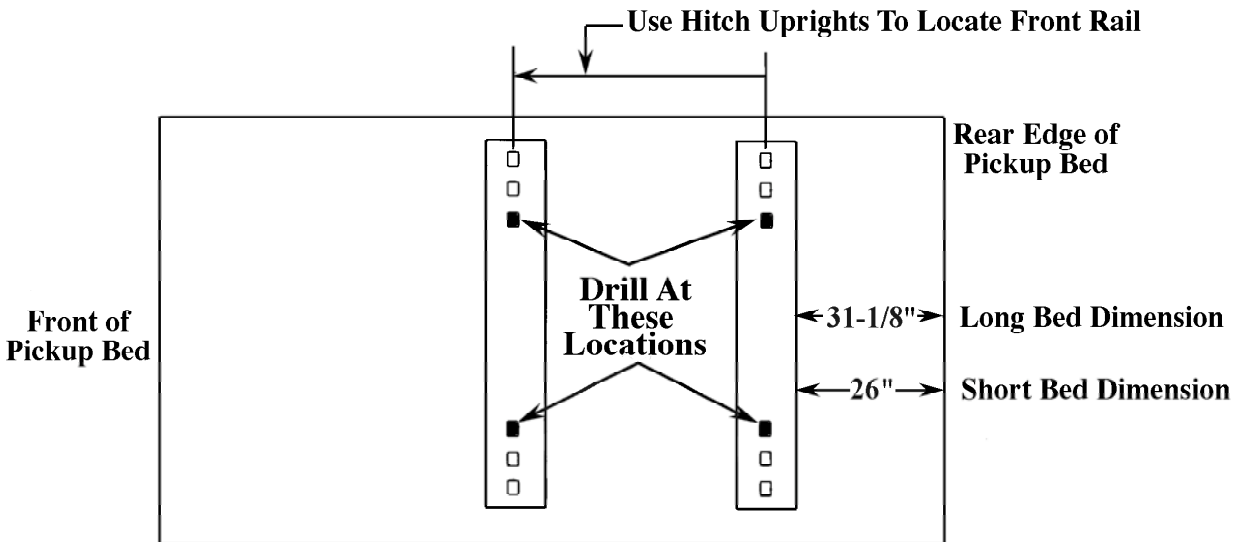
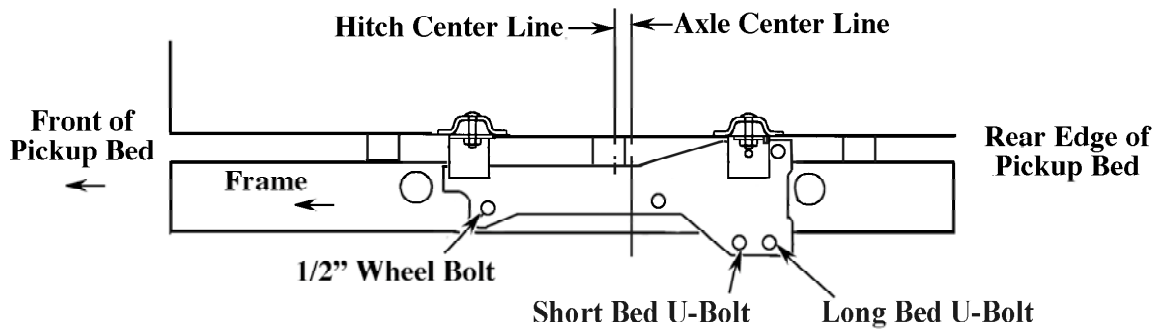
**APPLICATION:** 2007-09 Chevrolet & GMC Silverado & Sierra 1500 P/U on GMT 900 Box Frame Only

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

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

Part	Description	Quantity	Part	Description	Quantity
1.	3477-01 Left Frame Mount Bracket	(1)	8.	4034-05 1/2 - 13 Hex Nyloc Nut	(4)
2.	3478-06 Right Frame Mount Bracket	(1)	9.	1881-03 5/8 Lockwasher	(4)
3.	2605-01 Spacer Plate Bed Corrugate	(4)	10.	1732-09 5/8 Flatwasher	(4)
4.	3281-02 3/4 Spacer Plate	(4)	11.	3730-05 1/2 Conical Washer	(4)
5.	3266-05 1/2-13 x 1-1/2 Wheel Bolt	(2)	12.	2499-03 U-Bolt	(2)
6.	1828-03 1/2-13 Flange Lock Nut	(2)	13.	2831-05 5/8 Tapped Plate	(4)
7.	4434-06 5/8-11 x 3 Hex Bolt	(4)	14.	4892-07 Pull Wire	(1)

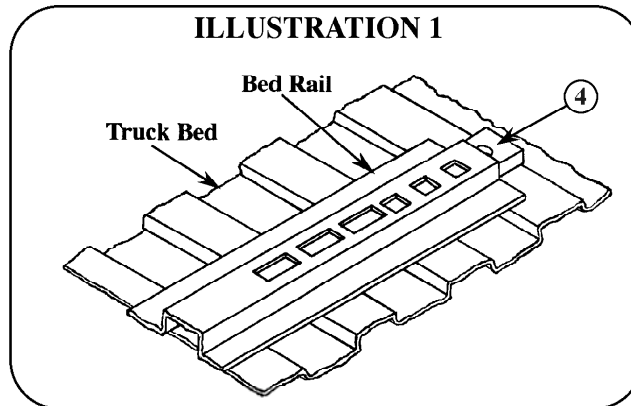
3/4" ahead of axle on short bed applications  
 3/4" ahead of axle on long bed application



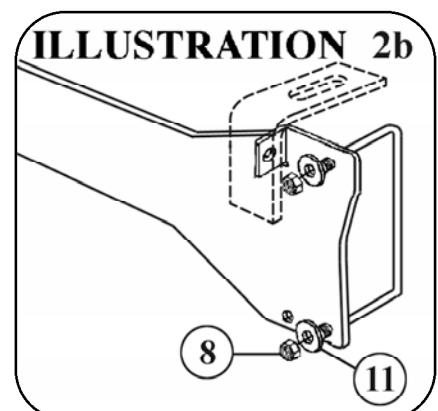
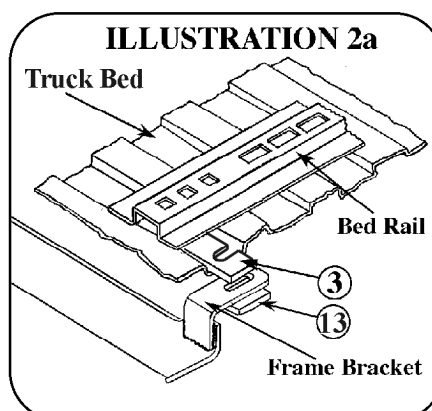
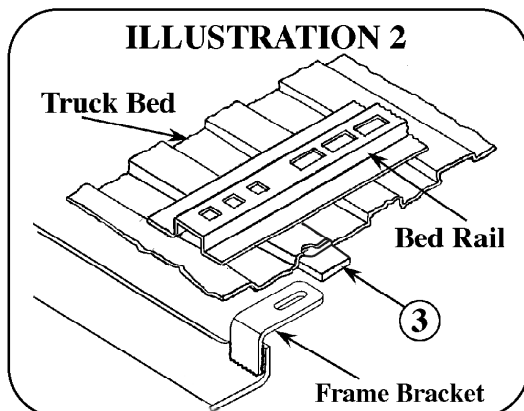
**NOTE:** Check cab clearance requirements before installing hitch.  
 The distance from the cab to the hitch center line is approximately 56" (8' bed) and 43" (6-1/2' bed).

**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.

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 on the front page 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. 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 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 3/4" thick spacer plate #4 under ends of each bed rail, in line with the drilled holes as shown on Illustration 1.

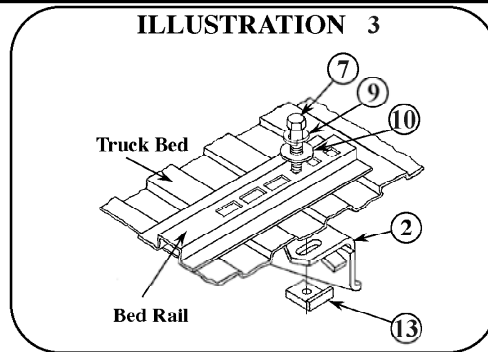


4. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a spacer plate #3 in this location as shown on Illustration 2. If the corrugation is DOWN, at this location, place a spacer plate #3 in the bed, under the base rail as shown on Illustration 2a.
5. Position the left and right frame brackets #1 and #2 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 around the truck frame at about 10" behind the rear axle. See Illustration 2b. For U-Bolt holes to be used for long bed and short bed. See front page illustration. 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.)

ILLUSTRATION 3



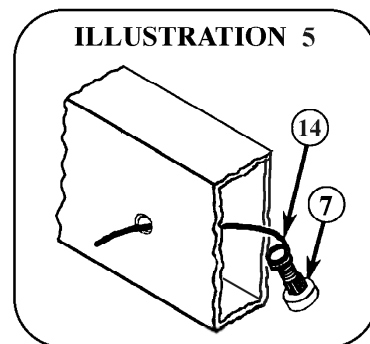
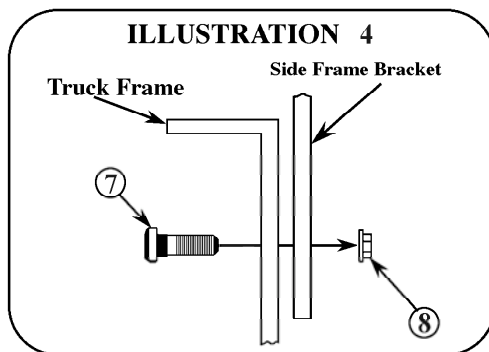
7. Move the frame brackets so that they rest tightly against the flat side of the truck frame and underneath surface of truck bed. Drop the 5/8" hex bolts with lock washer and flat washer down through bed rails and angle bracket. Thread bolts into tapped plates #13 placed under frame bracket tabs. Loosely bolt frame brackets in place. Be sure they are tight against the side of truck frame. See Illustration 3.

7a. Push U-Bolt through bracket and use Conical Washer and Hex Nyloc Nut to attach bracket to frame. See illustration 2b.

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 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 hole. Be sure hitch 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.

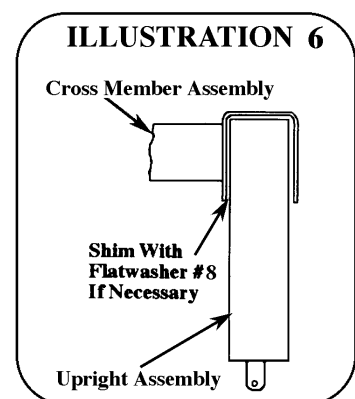
**CAUTION:** Holes MUST be drilled 17/32" diameter, so that the special wheel bolts will seat properly. If holes are too small, the bolt may break. If hole is too large it will not grip properly .



9. Place the wheel bolt into the frame first through 1" Diameter hole in bracket and then out through the drilled hole at the front of the frame brackets. See Illustration 4. Thread the pull wire coil over the end of the wheel bolt and pull through frame and frame bracket. See Illustration 5. 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.

10. Tighten all 1/2" attachment bolts to 75 ft. lbs. torque 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 a washer between the upright and the cross member to obtain free pin movement. See Illustration 6.



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