

INSTALLATION INSTRUCTIONS

MODEL NO. 55093

APPLICATION: 1999-07 Classic Chevrolet & GMC Silverado & Sierra 1500 & 2500 LD P/U
 2001-07 Classic Chevrolet & GMC Silverado & Sierra 2500 & 3500 HD P/U
 2007-09 New Body Style Chevrolet & GMC Silverado & Sierra 2500 & 3500 HD P/U
 with or without Integrated Electric Brake Control - No change to IBC Position

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

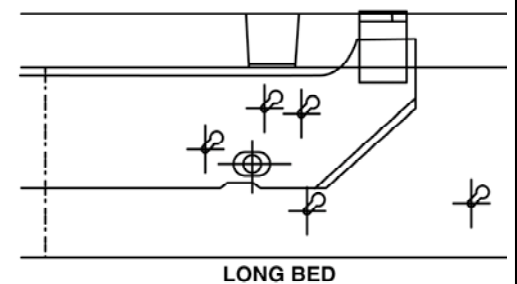
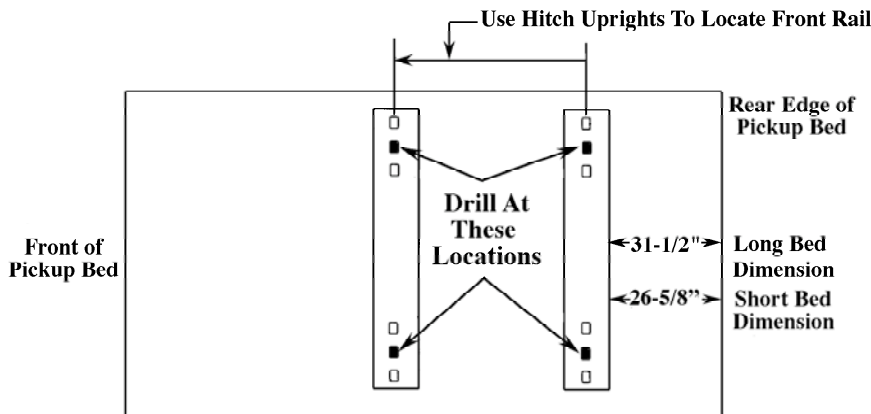
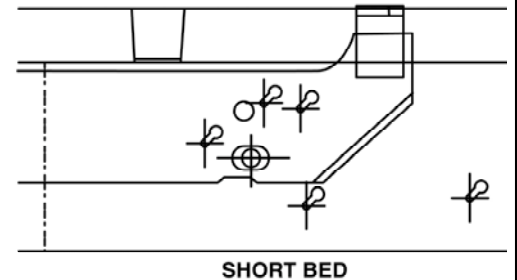
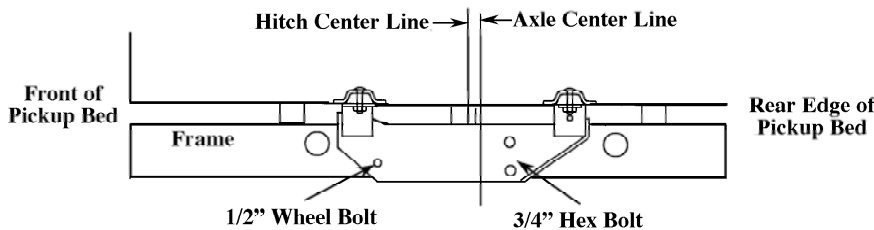
COMPLETE PARTS LIST

Part	Description	Quantity
1.	3583-06 Left frame Bracket Weld Assembly	(1)
2.	2765-04 Right Frame Bracket Weld Assembly	(1)
3.	2605-01 Spacer Plate	(4)
4.	2057-05 Centered Alignment Spacer	(2)
5.	2058-01 Offset Alignment Spacer	(2)
6.	3281-02 3/4 Spacer Plate	(4)
7.	3266-05 1/2-13 x 1-1/2 Wheel Bolt	(2)
8.	1828-03 1/2-13 Flange Lock Nut	(2)
9.	4434-06 5/8-11 x 3 Hex Bolt	(4)
10.	1881-03 5/8 Lockwasher	(4)
11.	1732-09 5/8 Flatwasher	(4)

Part	Description	Quantity
12.	2831-05 5/8 Tapped Plate	(4)
13.	2968-03 3/4-10 x 2 Hex Bolt	(2)
14.	1882-03 3/4 Lockwasher	(2)
15.	1850-03 3/4 Flatwasher	(2)
16.	1864-03 3/4-10 Hex Nut	(2)
17.	4892-07 Pull Wire	(1)
18.	1001-03 3/16 Spacer Plate	(2)
19.	3581-08* Tube Space 7/8 x .750 Dia	(2)
20.	3545-04* 6mm Hex Screw 55mm Full Thread	(2)
21.	4721-03* Flat Washer	(2)

* not used on vehicles that do not come equipped with the integrated brake control

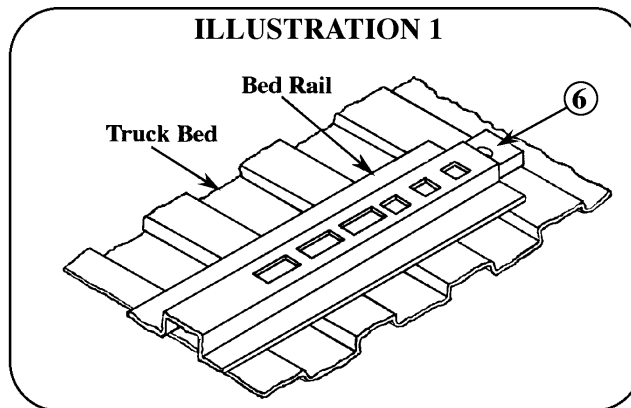
1-3/8" ahead of axle on short bed applications
 1-5/8" ahead of axle on long bed application



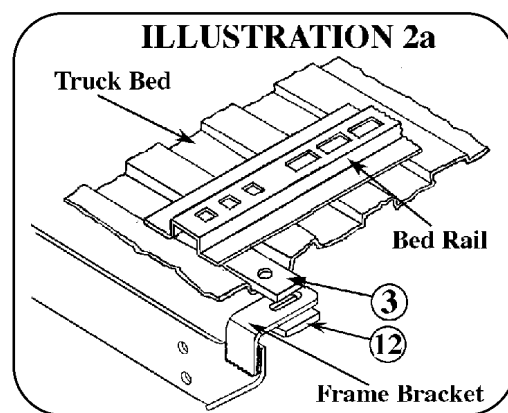
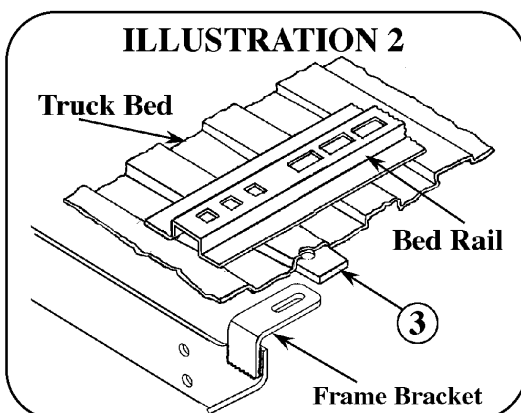
NOTE: Check cab clearance requirements before installing hitch.
 The distance from the cab to the hitch center line is approximately 56" (8' bed) and 43" (6-1/2' bed).

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.

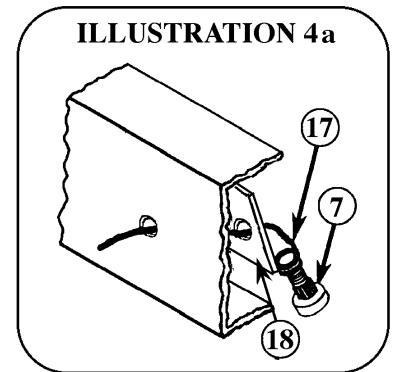
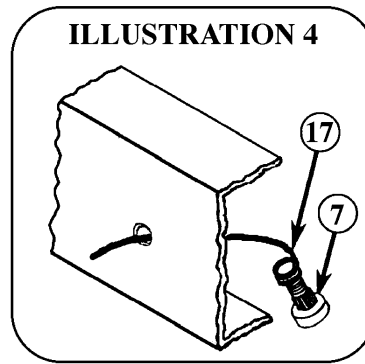
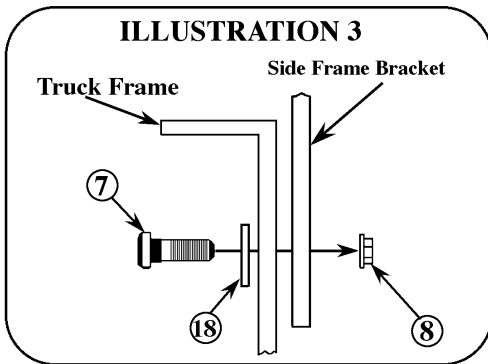
1. Place the two bed rails across the truck bed between the wheel wells. Position the 5th wheel uprights between the bed rails so that the tabs in the base of each upright will fit into the slots in the ends of the bed rails. Secure the uprights in place with the rail hitch pins and hair pins supplied 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 block #6 under ends of each bed rail, in line with the drilled holes as shown on Illustration 1.



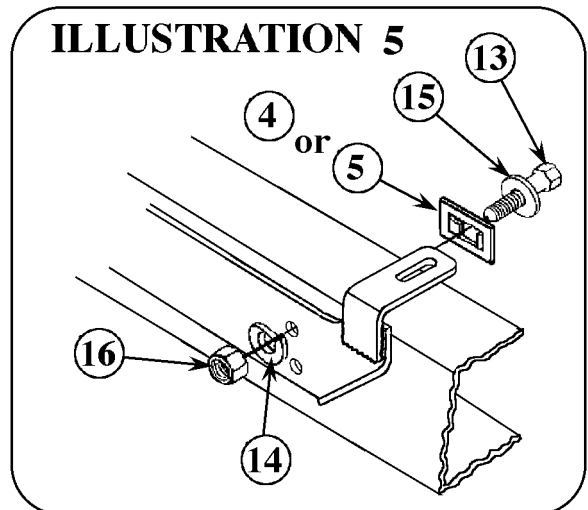
4. If the bed corrugation above the frame bracket is UP, leaving a space above the frame bracket, place a spacer plate #3 in this location as shown on Illustration 2. If the corrugation is DOWN, at this location, place a spacer plate #3 in the bed, under the base rail as shown on Illustration 2a.
5. Remove the two existing screws holding the forward IBC Unit onto the frame at the large 3/4" Dia. bolt hole. Complete the installation then re-install the forward IBC Unit using Longer 6mm bolts, flatwashers and tube spacers.
6. 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.



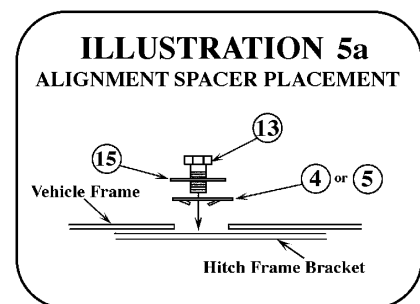
7. Move the frame brackets so that they rest tightly against the flat side of the truck frame and underneath surface of truck bed. Drop the 5/8" hex bolts down through bed rails and angle bracket. Thread bolts into tapped plates #12 placed under frame bracket tabs. Securely bolt frame brackets in place. 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. Also, check the forward frame bracket attachment hole to see if there is a hole in the truck frame that is aligned with hole in the frame bracket. 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 3/4" bolt at the rear hole.
- 8a. If there is no hole in the truck frame 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 and then out through the frame brackets. See Illustration 3. On applications with existing slots in frame, insert a 3/16" spacer on the pull wire before the bolt. Thread the pull wire coil over the end of the wheel bolt and pull through frame and frame bracket. See Illustration 4 and 4a. 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.

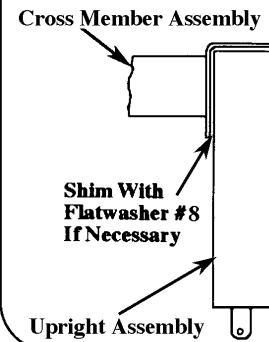


10. At the rear of each frame bracket there are two large attachment holes. Choose the one hole which lines up with the existing hole in the truck frame. Bolt frame bracket to truck frame with 3/4" fasteners as shown on Illustration 5 and 5a. Be sure to use one of the alignment spacers #4 or #5 that will best line up with the bolt and large slot in the truck frame. Alignment spacer must rest fully into the large frame slot. See Illustration 5a.



11. Tighten all 1/2" attachment bolts to 75 ft. lbs. torque and the 3/4" bolts to 260 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 washer between the upright and the cross member to obtain free pin movement. See Illustration 5.
13. Tighten each 5/8" bed rail attachment bolt to 125-160 ft. lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.

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

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