

INSTALLATION INSTRUCTIONS

MODEL NO. 55110

APPLICATION:

**1994-2001 Dodge Ram 1500
1994-2002 Dodge Ram 2500 & 3500 P/U**

COMPLETE PARTS LIST

Part	Description	Quantity	Part	Description	Quantity
1.	2882-03 Tube Spacer	(2)	7.	2883-03 5/8-11 x 5-1/2 Hex Bolt	(2)
2.	1585-03 Angle Bracket	(2)	8.	1732-09 5/8 Wide Flatwasher	(6)
3.	2605-01 Spacer Plate	(4)	9.	1881-03 5/8 Lockwasher	(4)
4.	3266-05 1/2-13 x 1-1/2 Wheel Bolt	(4)	10.	1863-03 5/8-11 Hex Nut	(4)
5.	1828-03 1/2-13 Serrated Locknut	(4)	11.	3281-02 3/4 Spacer Block	(4)
6.	3241-02 5/8-11 x 3-1/2 Carriage Bolt	(2)	12.	4892-07 Pull Wire	(1)

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.

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

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 illustrations at the end of this sheet. Bed rails may be placed at several locations as shown on Illustrations. 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 #11 under ends of each bed rail, in line with the drilled holes, As shown on Illustration 1.

4. If the bed corrugation above the angle bracket is UP, leaving a space above the angle 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. Bolt parts loosely in place as illustrated.

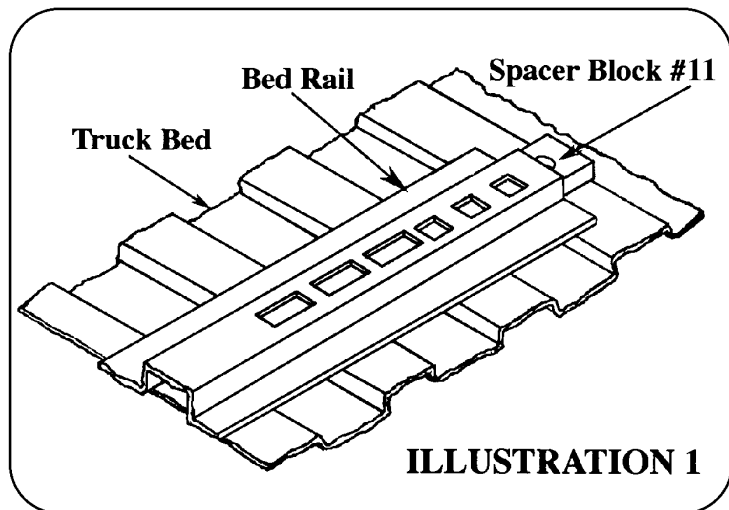


ILLUSTRATION 1

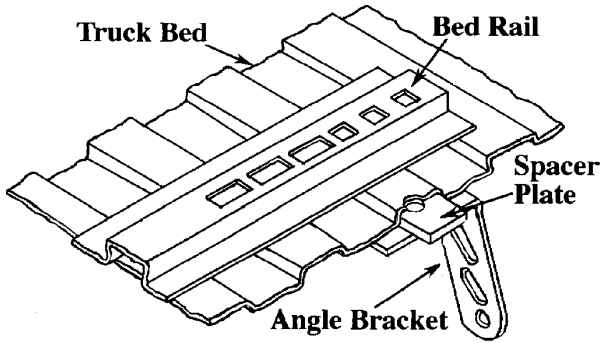


ILLUSTRATION 2

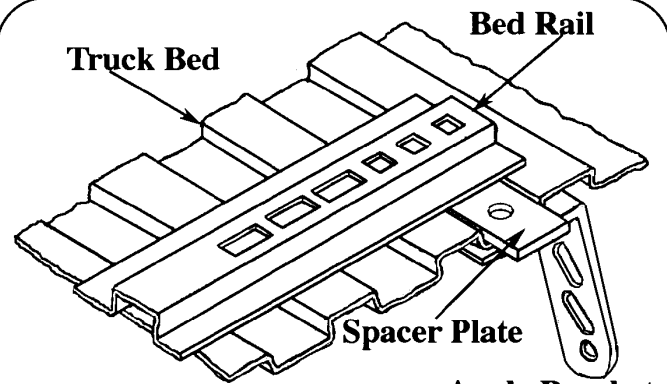


ILLUSTRATION 2a

5. Position the offset angle brackets under the bed, at the rear attachment and align with the 5/8" carriage bolts protruding down through the bed. Use straight angle brackets at the forward frame attachments. See Main Illustration for details of bracket location.
6. Move the installed 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 angle bracket.

NOTE: There are two types of 5/8" bolts. Use the hex bolts at the tube spacer locations where they will go through the top of the frame. Use the carriage bolts at the angle bracket attachments. Securely bolt the base rails in place. Be sure the angle brackets are tight against the side of truck frame. Tighten the 5/8" bolts to 125-160 ft. lbs. torque.
7. 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 angle brackets must be attached to the side frame of the truck with two 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. See Illustration "A".

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.

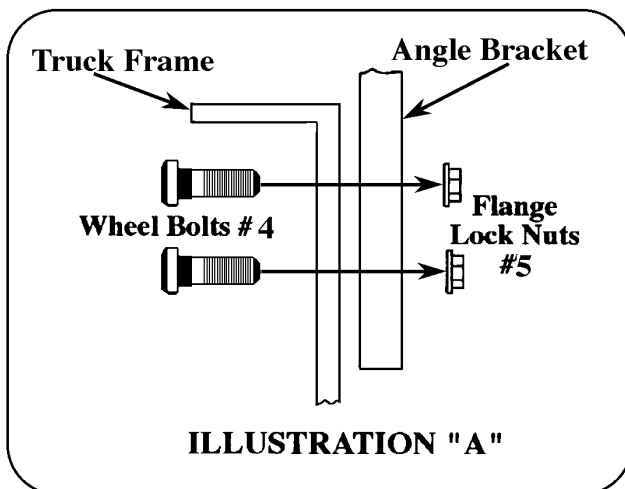
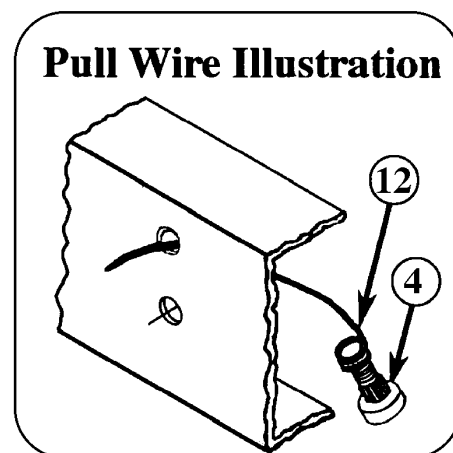


ILLUSTRATION "A"



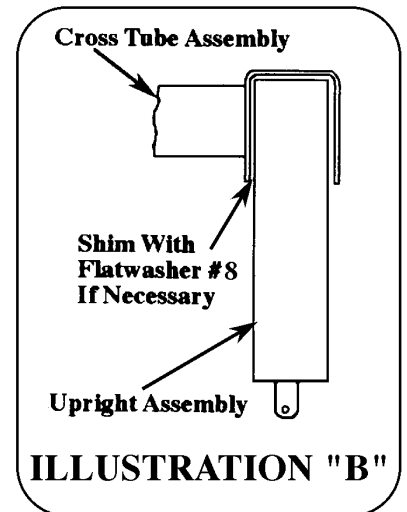
Pull Wire Illustration

8. Place the special bolts into the frame first and then out through the angle 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 angle 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.

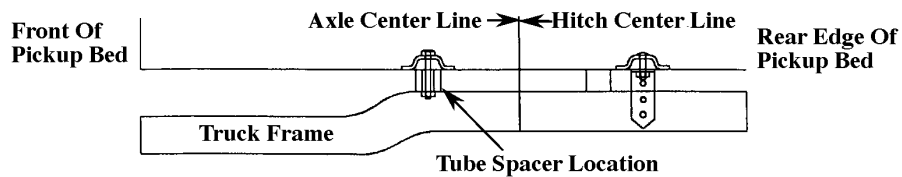
9. Tighten all 1/2" attachment bolts to 75 ft. lbs. torque.

10. Check each rail hitch pin for freedom of movement in the bed rail connection before tightening the 5/8" carriage bolts. Adjust uprights, if necessary, by placing a washer between the upright and the cross member to obtain free pin movement. See Illustration "B".

11. 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.

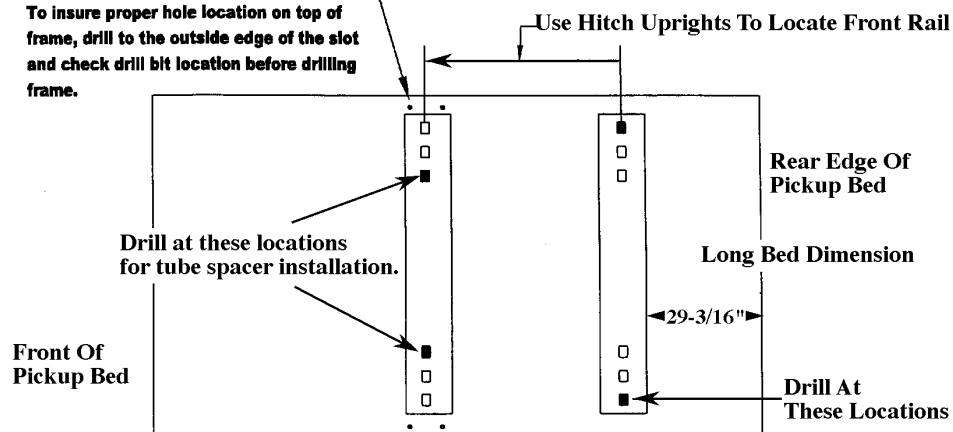


Long Bed Applications Hitch Centered Over Axle

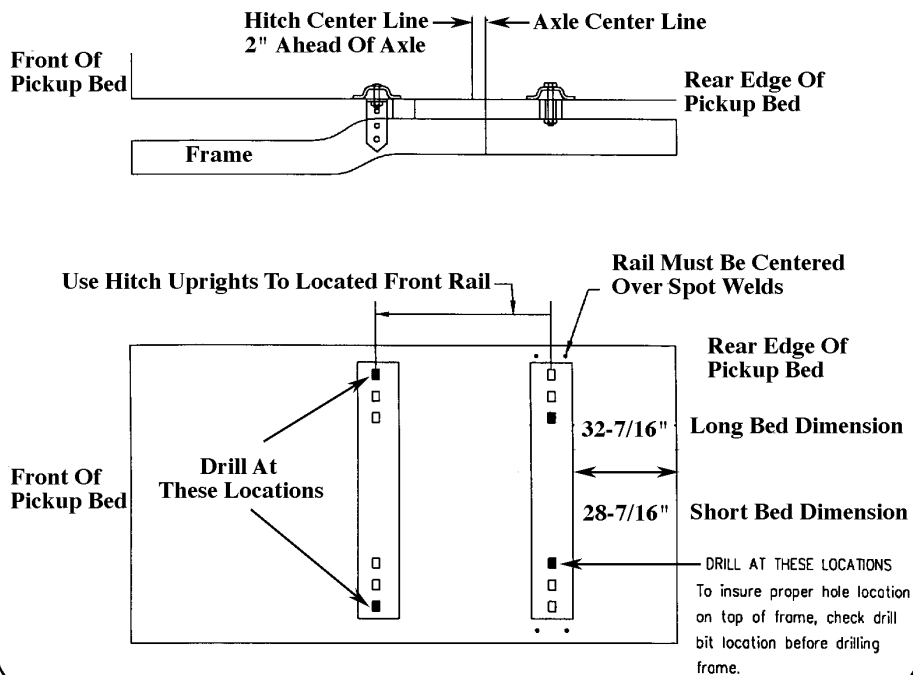


Rail must be centered over spot welds

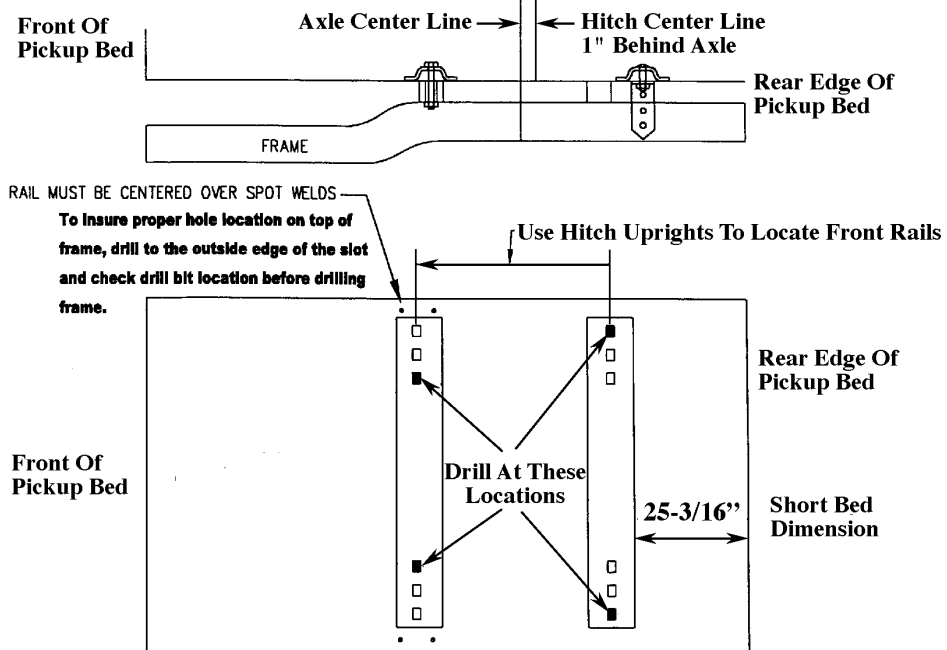
To insure proper hole location on top of frame, drill to the outside edge of the slot and check drill bit location before drilling frame.



Short Bed & Long Bed Applications Hitch Location 2" Ahead Of Axle



Short Bed Application 1" Behind Axle Location



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