



# Assembly, Installation, Operation and Maintenance Instructions

## Kit, Base Rail Bracket

## Part # 31405

*APPLICATION: 1999 – 2004 Ford F250 & F350 Super Duty Pick-Ups*

<b>Dealer / Installer:</b>	Provide a copy of these Instructions to the end user of this product. These Instructions provide important operating and safety information for proper usage of this product. Demonstrate the proper use of the product with the end user. Have the end user demonstrate that they understand the proper use of the product.
<b>End User:</b>	Read and follow all instructions included in this manual. Ask your Dealer / Installer for assistance if you do not understand the proper use of the product. Never remove any decals from the product.

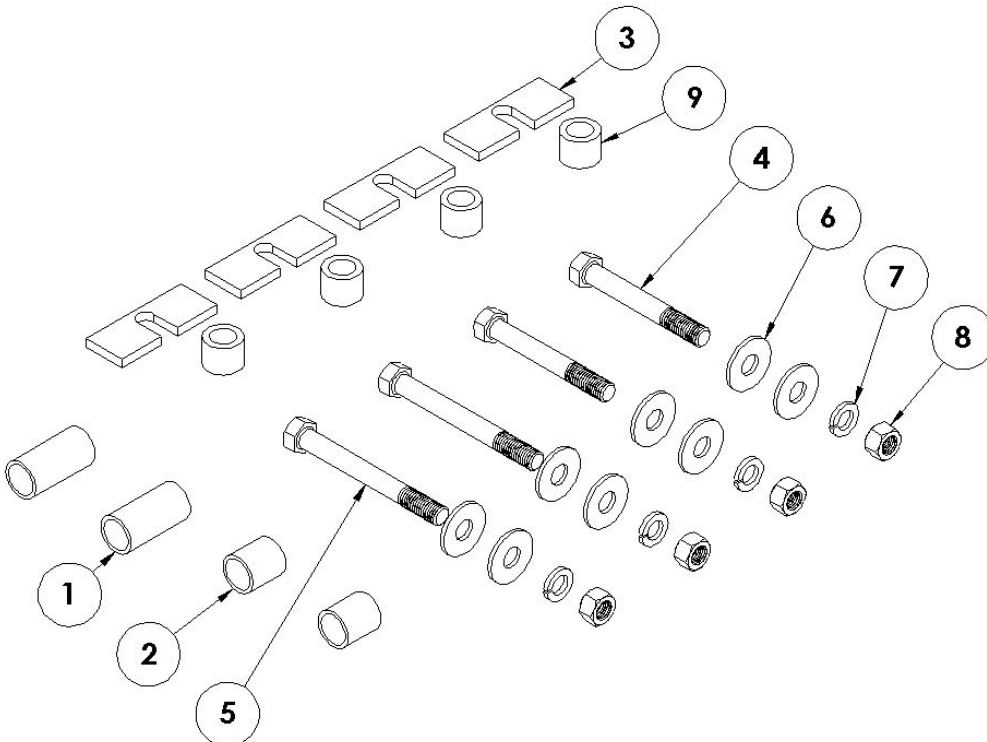
**NOTE:** This bracket kit is to be used with the 31323 4 Bolt Bed Rail Kit or 30686 10 Bolt Bed Rail Kit.

Complete Parts List			
Item No.	Part No.	Description	Qty.
1	ERD10715	Spacer, Tube 2-1/2" Long	2
2	ERD10716	Spacer, Tube 1-3/8" Long	2
3	ERD10020	Plate, Spacer	4
4	ERD10773	Bolt, Hex 5/8 -11 x 4-3/4"	2
5	ERD10677	Bolt, Hex 5/8 -11 x 5-3/4"	2
6	ERD12188	Flat Washer (5/8)	8
7	ERD12187	Lock Washer (5/8)	4
8	ERD12184	Nut, Hex (5/8)	4
9	ERD10031	Spacer Tube 1"	4

**WARNING!** Never exceed the towing capacity of the tow vehicle.

**Center Bolt Kit 32059 (sold separately) must be used when towing with a 26K hitch, Goose Neck, or Maneuvering System.**

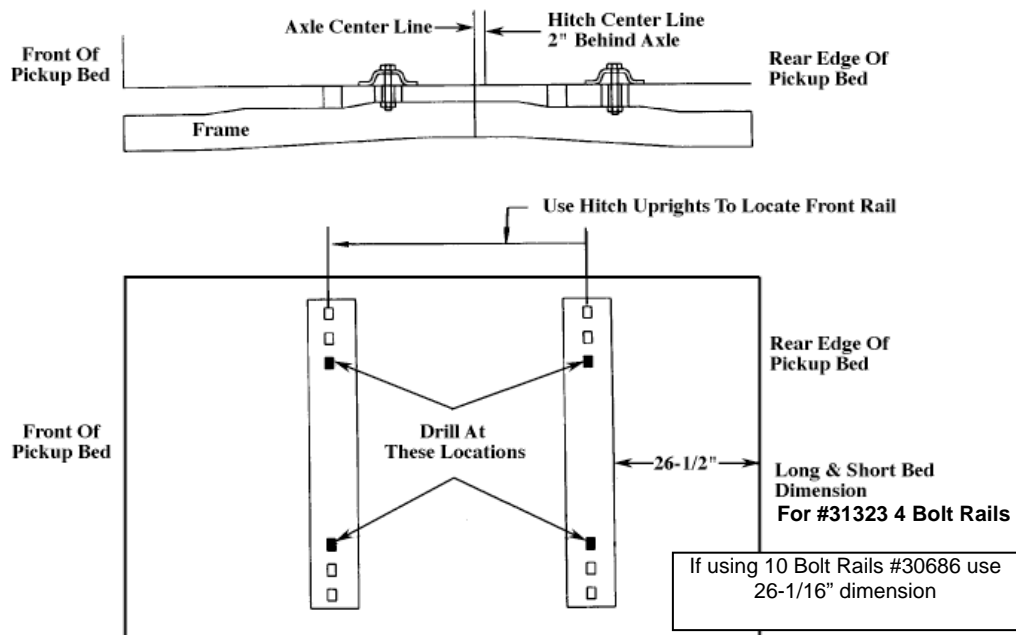
Base Rails Not Included



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.

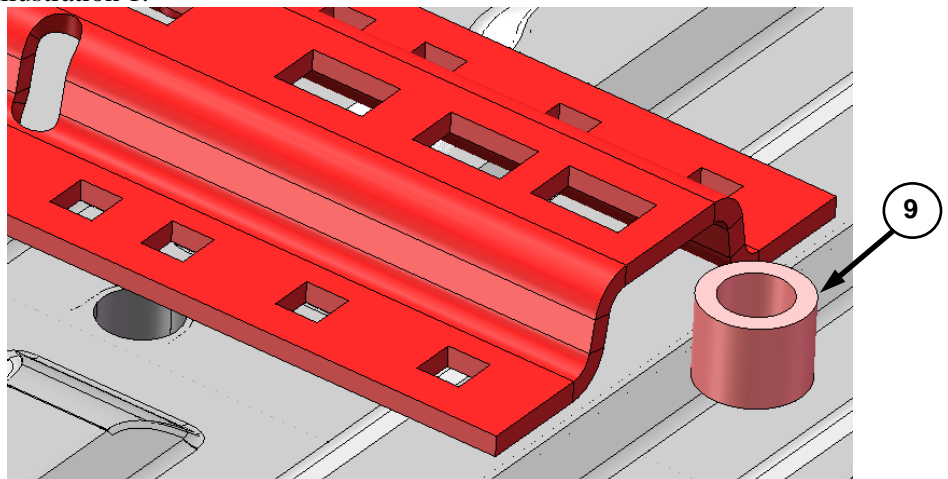
**NOTE:** Consult spray liner installer for recommended curing time.

## Long & Short Bed Applications 2" Behind Axle

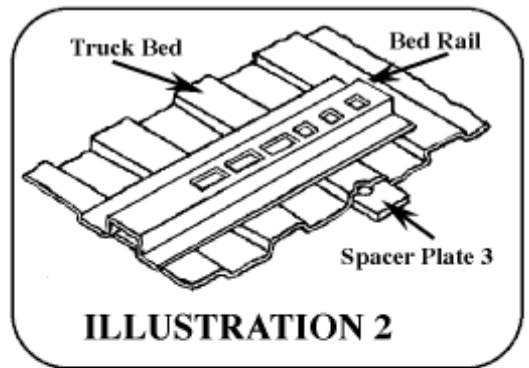


**Note:** Check cab clearance requirements before installing hitch. The distance from the cab to the hitch center line is approximately 59" (8' bed) 43" (6½' bed)

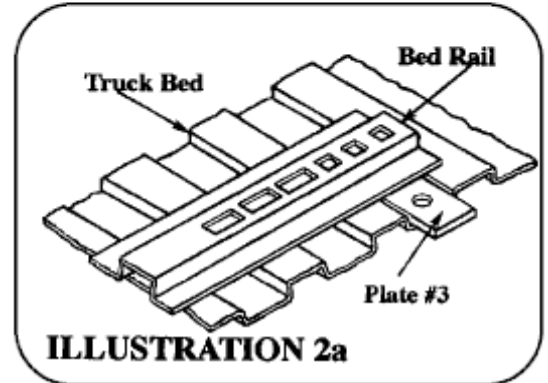
1. Place the two bed rails across the truck bed between the wheel wells. Position the 5<sup>th</sup> wheel uprights between the bed rails so that the tabs in the base of each upright will fit into the slots in the ends of the bed rails. Secure the uprights in place with the rail hitch pins and hair pins supplied with the 5<sup>th</sup> wheel installation kit. Securely attach 5<sup>th</sup> wheel cross member to uprights.
2. Position the bed rail assembly in truck bed as shown on the Illustration above. When hitch is correctly positioned in the bed and the bed rails are parallel, mark four attachment points on the truck bed using 5/8" square holes indicated on the layout Illustration above. 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 1" thick spacer tube (#9) under ends of each bed rail, in line with the drilled holes. See Illustration 1.



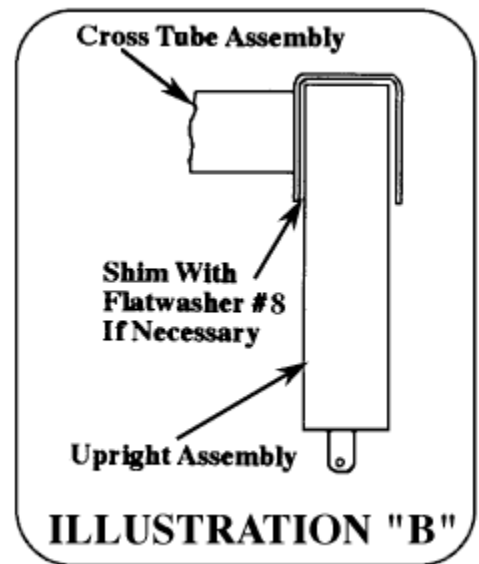
4. If the bed corrugation above the frame attachment is UP, leaving a space above the frame, place a spacer plate (#3) in this location as shown on Illustration 2. If the corrugation is DOWN, at this location, place a spacer plate (#3) in the bed, under the base rail as shown on Illustration 2a. Bolt parts loosely in place as illustrated.



5. Position the 2-1/2 long tube spacers (#1) between the bed and the frame, at the rear attachment points and drop the 5/8 -11 x 5-3/4" bolts (#5) down through the bed. Place the 1-3/8" long tube spacers (#2) between the bed and vehicle frame at forward attachment point. Drop the 5/8 -11 x 4-3/4" bolts (#4) down through the bed rail, tube spacer and frame at this location. Place one of the 5/8" flat washers (#6) under the head of each bolt and under the nut inside frame. Bolt securely in place.



6. Check each rail hitch pin for freedom of movement in the bed rail connection before tightening the 5/8" attachment bolts. Adjusts uprights, if necessary, by placing a washer between the upright and the cross member to obtain free pin movement. See Illustration "B".
7. Tighten each 5/8" bed rail attachment bolt to 150 ft.-lbs. torque. Failure to tighten bolts as described may result in fastener loss or failure.



# #31405 CUSTOM BRACKET KIT, FORD SUPER DUTY



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Designed & tested in the USA & Made in China for /  
Conçu et testé aux É.-U. et fabriqué en Chine DTS  
Manufacturing, Wilsonville, OR 97070

P.O. #:



The date code for this product is located on the UPC label

Please retain this info for your records.

# Warranty Terms:

## 5 Year Limited Warranty:

This warranty applies solely to Husky 5<sup>th</sup> Wheel Installation Kit manufactured by DTS Mfg. for Husky Towing Products.

Husky Towing Products and DTS Mfg. make no guarantees or warranties for products not manufactured by DTS Mfg. Such products are covered solely under any applicable warranty of the manufacturer. It is always recommended that the operating instructions and guarantee instructions provided by the manufacturer are followed.

DTS Mfg. warrants its products to be free from manufacturing and material defects to the original purchaser for the length of warranty stated above from the date of retail purchase. If any products are found to have a manufacturing or material defect, the product will be replaced or repaired at the option of Husky Towing Products and DTS Mfg. with proof of purchase by the original purchaser. The original purchaser shall pay all transportation and shipping costs associated with the return of the defective product and the defective product shall become the property of DTS Mfg.

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The Warranty applies only to DTS Mfg. products which are found to be defective in manufacturing or material. This warranty does not apply to normal wear and tear of the finished placed on DTS Mfg. products.

Husky Towing Products and DTS Mfg. are not responsible for any labor costs incurred for removal or replacement of the defective product.

Husky Towing Products and DTS Mfg. are not responsible for repair or replacement of any product under the limited warranty where the product was improperly installed, misapplied, altered, abused, neglected, overloaded, misused or damaged as a result of an accident, including any use of the product not in accordance with all product operating and safety instructions.

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