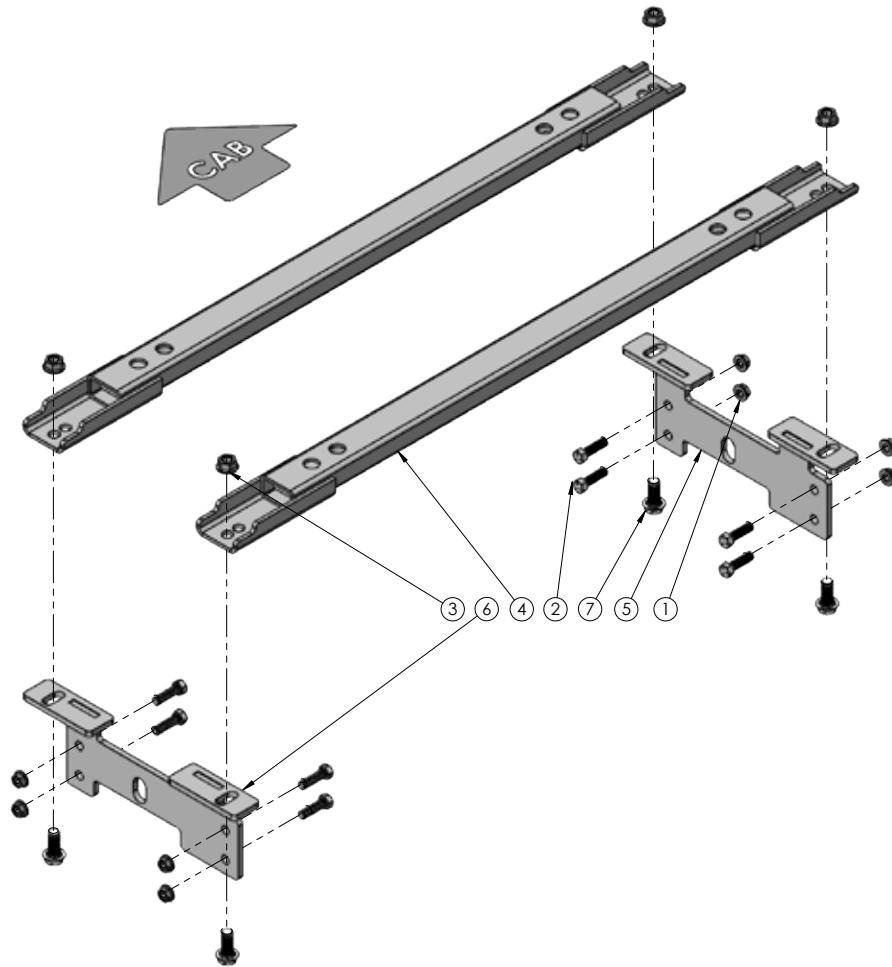


## FRAME BRACKET 8551011

Chevy Silverado 1500 & GMC Sierra 1500 5-1/2' & 6-1/2' Box



ITEM	PART #	QTY	DESCRIPTION
1	10379	8	1/2" UNC FLANGED NUT
2	14266	8	BOLT, .50 NC X 1.75 GR5 HEX W/ KNURLED NECK
3	14340	4	5/8" NC FLANGED WHEEL NUT
4	15783-76	2	UMS BASE RAIL, 2 HOLE MNT
5	16682-76	1	FRAME BRACKET, PASSENGER SIDE
6	16683-76	1	FRAME BRACKET, DRIVER SIDE
7	16690	4	BOLT, .625NC X 1.50 SERR FLG HEX HD
-	14238	1	1/2" FISH WIRE (NOT SHOWN)
-	12329	2	LOCTITE (NOT SHOWN)

Please order replacement parts by PART NO. and DESCRIPTION.

# Installation

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## 8551011 General Assembly & Install Instructions

### WARRANTY POLICY, OPERATOR MANUALS & REGISTRATION

Go online to [www.demco-products.com](http://www.demco-products.com) to review Demco warranty policies, operator manuals and register your Demco product.

### Hitch Assembly:

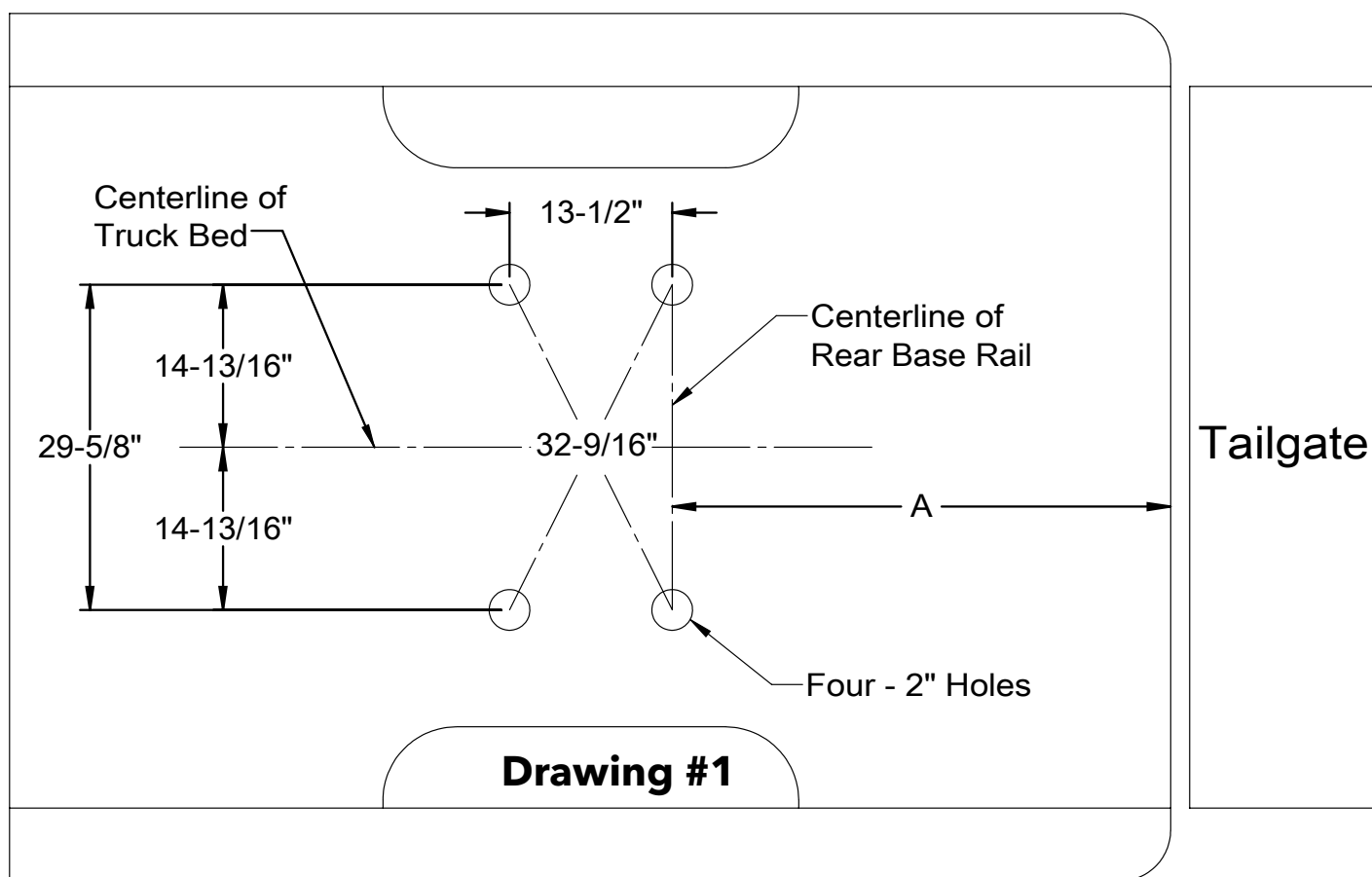
1. Place the base rails on a flat level surface. Insert and lock the side rail plates into the base rail holes as shown in the supplied hitch instructions.
2. Loosely bolt the saddle bracket and the two cross brackets to the side rails using the fasteners provided with the hitch.
3. Tighten all bolts according to the bolt torque specification chart.
4. Unlock and remove the hitch assembly from the base rails and put to the side for later.

### Truck Bed Drilling Instructions Without Template:

1. Use the measurements shown on the drill hole measurement chart to mark out the four holes that will be drilled through the truck bed.
2. Start out by measuring the distance stated for the particular **BOX LENGTH** of truck you are doing the installation on (refer to page 3) from the end of the bottom of the truck bed (tailgate end) to a point on the left side of center of the bed and mark it. Do the same on the right side of center of the bed and mark it. Draw a line across the bed using these two marks as a reference.
3. Measure out and find the center of the truck bed and draw a line from the front to the rear of the bed.
4. Measure out 14 13/16" to either side of the middle center line slightly ahead of the fender well and slightly behind the fender well.
5. Draw a line between these two points. Do the same on the other side.
6. Measure out (towards the cab) 13 1/2" from the points where the line that goes across the bed intersects with the two lines that are 14 13/16" off the center running the length of the bed. Mark these two points.
7. There should now be four spots marked out for drilling. Double check that the rear to hole marks are exactly the distance stated for the box length of truck you are doing the installation on (refer to box length on chart) from end of the bed and that the front holes marks are exactly 13 1/2" forward of those marks.
8. Check the hole marks from side to side and make sure they are exactly 29 5/8" apart from each other.
9. Finally, check for square by measuring diagonally from opposite corners Drawing #1. The measurement should be the same both ways. It should measure 32 9/16".
10. After all the hole marks have been double checked for proper placement, use a center punch and hammer to mark out the spots for drilling.
11. Drill the holes using a 2" hole saw. Deburr the holes using a small file and apply some touch up paint to match color (not supplied).

**BOLT TORQUE SPECIFICATIONS**

STANDARD BOLTS			METRIC BOLTS		
Size	Grade	Torque	Size	Grade	Torque
5/16"	5	18 ft/lbs.	8mm	8.8	23 ft/lbs.
3/8"	5	30 ft/lbs.	10mm	8.8	45 ft/lbs.
7/16"	5	50 ft/lbs.	12mm	8.8	78 ft/lbs.
1/2"	5	75 ft/lbs.	14mm	8.8	125 ft/lbs.
5/8"	5	150 ft/lbs.	16mm	8.8	160 ft/lbs.
3/4"	5	290 ft/lbs.			



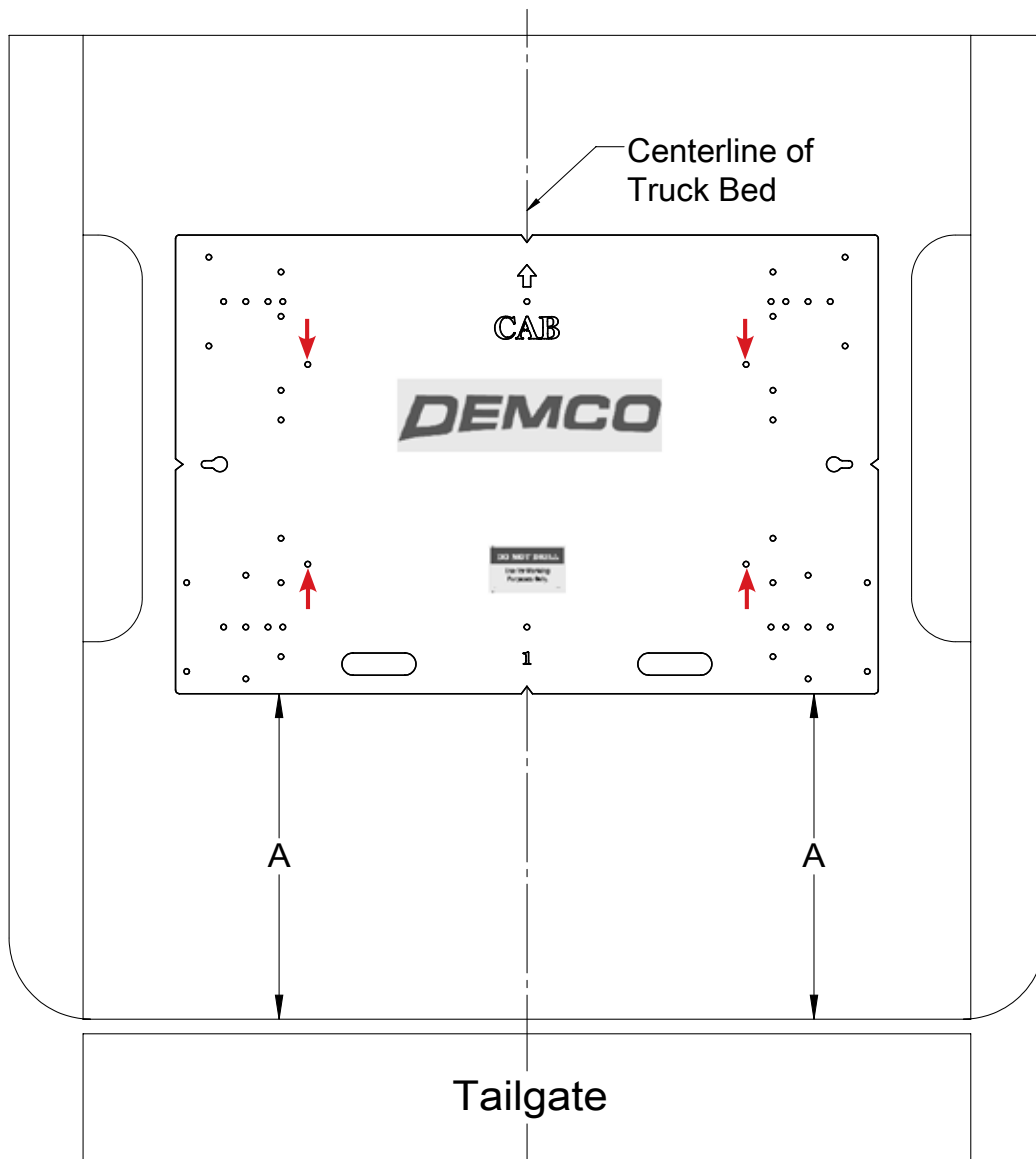
BOX LENGTH	DIMENSIONS	MEASUREMENT
5-1/2'	A	*31-3/4"
6-1/2'	A	*31-3/4"
8'	A	*N/A
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

# Installation

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## Truck Bed Drilling Instructions with Template

1. Place the template in the box and center the template between the wheel wells.
2. **IF NEEDED, TAPE THE TEMPLATE DOWN.**
3. Measure from the back of the box to the template on the passengers side and drivers side to insure that the template is square. See drawing #2 and table on page 5 for measurements.
4. Locate which holes you will be drilling, by the ones marked with a red arrow.
5. Take a 3/8" locating punch and mark the holes to be drilled.
6. **BEFORE YOU DRILL, MAKE SURE THAT THE TEMPLATE DID NOT MOVE, AND THAT THERE ARE NO OBSTRUCTIONS IN THE WAY.**
7. Remove the template and drill the four marked holes (from step 5) with a 2" hole saw.
8. Deburr each hole.
9. Touch up the bare metal with some paint that matches the box of the truck.



**Drawing #2**

BOX LENGTH	DIMENSIONS	MEASUREMENT
5-1/2'	A	*23"
6-1/2'	A	*23"
8'	A	*N/A
*ALL MEASUREMENTS ARE FROM THE BACK OF THE BOX		

# Installation

## Frame Bracket Installation

1. Remove the rear tires.
2. If equipped, remove the rear wheel well liners.
3. Slide base rails in position below the bed so that they are resting on top of the frame. Center the base rail holes under the 2" holes that were drilled in the bed of the truck.

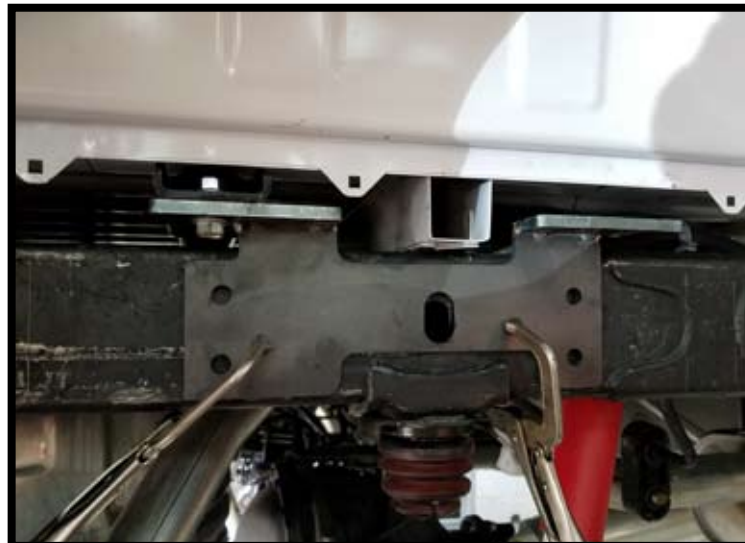
**NOTE: If there are problems sliding the base rails into position, see "Base Rail Installation" on page 8.**

4. Attach the frame brackets to the base rails and install a 5/8" x 1.50" serrated head bolt up through the bottom end of the frame bracket through the base rail and loosely tighten the 5/8" serrated nut. As shown in the picture below.



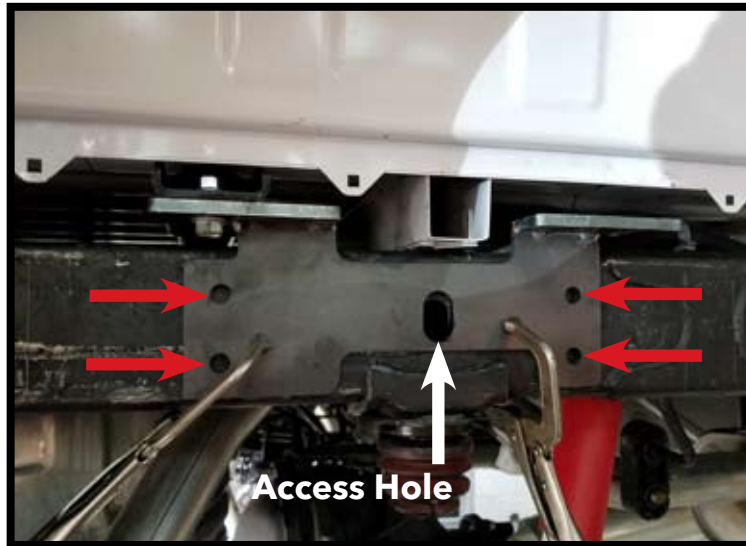
Passengers Side Shown

- 5a. Once the frame brackets are loosely tightened to the base rails, slide the whole unit up tight to the bottom of the bed.
- 5b. Re-install and lock the hitch assembly into the base rails from the topside of the box.
6. Measure and center the entire hitch assembly side to side and front to back so that it is as close to center of the holes in the bed as possible.
7. Once the base rails are locked into position and centered in the 2" holes. Clamp the frame brackets to the sides of the frame. As shown in the picture below. Tighten all 5/8" nuts and torque to the chart located on the top of page 3.



Passengers Side Shown

8. Using the holes in the frame brackets as a guide, drill the frame in the four mounting holes on each frame bracket with a 1/2" drill bit.  
**NOTE:** You may want to drill a smaller pilot hole to make drilling easier.
9. Brackets will be bolted onto frame by fishing a 1/2" x 1 3/4" knurl bolts through frame with a 1/2" fish wire and attach with a 1/2" serrated flange nut on outside of bracket. Use the access hole shown below in the picture to fish the bolts through.



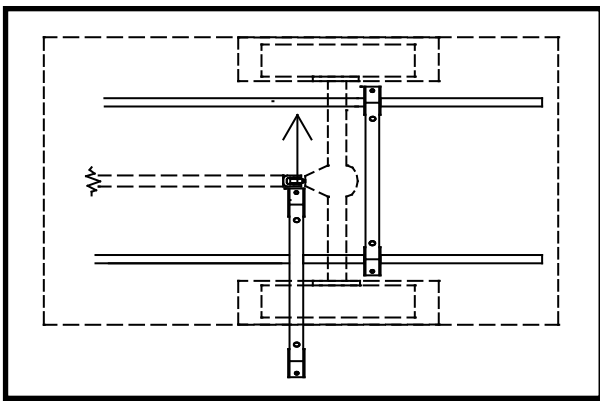
Passengers Side Shown

10. Tighten and torque all bolts to the chart on the top of page 3.
11. Re-install the rear wheels and rear wheel well liners (if removed), double check all fasteners for tightness, and lower truck (if raised).
12. Unlock and lift the hitch assembly out of the box to make sure it can be removed and inserted with relative ease. If there was any shifting during installation that caused any binding, simply loosen the four bolts that attach the base rail to the frame brackets and realign the base rail and retighten.
13. Ensure the side rail locking pins are turned and secured in the locked position with the safety pins. Install the hitch head to the saddle bracket.

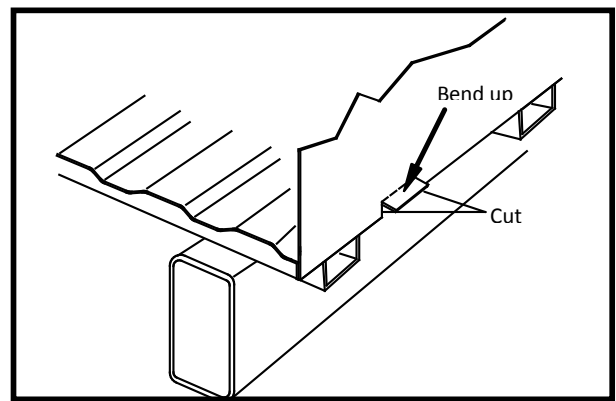
## Base Rail Installation:

**If the base rails are unable to be slid into position because of insufficient space by the lip of the box bed, then use one of the following two methods to install the base rails.**

- A. Remove the mounting bolts that attach the box to the truck frame on one side only. Raise and block the box high enough so the base rails can be inserted (with locking pin holes up) and span across and rest on top of each side of the frame (drawing #3). Lower and bolt the box back to the frame. Position base rails under holes drilled in bed.
- B. Locate a spot on both sides of the box support cross members on either side of the truck and cut and bend up a 3 1/2" wide section of the sheet metal lip where the bed and the fender well of the box join (drawing #4). Insert base rails (with locking pin holes up) and span across and rest on top of each side of the frame (drawing #3). Bend the sheet metal back down and position rails under holes drilled in bed.



**Drawing #3**



**Drawing #4**

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[www.demco-products.com](http://www.demco-products.com)

