



Assembly, Installation, Operation and Maintenance Instructions Base Rail Bracket Kit

P/N: 31413



90-120 minutes

| | |
|----------------------------|--|
| Dealer / Installer: | 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. |
| End User: | 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. |

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

DO NOT EXCEED Recommended towing limits. SEE VEHICLE'S OWNER'S MANUAL.

Complete Parts List

| Item No. | Description | Qty. |
|----------|---------------------------------|------|
| 1 | Bracket, Front Left - Weldment | 1 |
| 2 | Bracket, Front Left Clamp | 1 |
| 3 | Bracket, Front Right - Weldment | 1 |
| 4 | Bracket, Front Right Clamp | 1 |
| 5 | Bracket, Left Rear Mount | 1 |
| 6 | Bracket, Right Rear Mount | 1 |
| 7 | Spacer, U-Bracket | 1 |
| 8 | Spacer, Tube 1" | 4 |
| 9 | Spacer, Tube - Weldment | 2 |
| 10 | Plate, Spacer | 4 |
| 11 | U-Bolt, 1/2 -13 X 5-1/2" | 1 |
| 12 | U-Bolt, 1/2 -13 X 6-1/2" | 2 |
| 13 | Washer, Flat (1/2) | 8 |
| 14 | Nut, Nylon Lock (1/2 -13) | 8 |
| 15 | Bolt, Carriage 1/2 -13 X 5" | 4 |
| 16 | Bolt, Hex 5/8 -11 X 3" | 2 |
| 17 | Bolt, Hex 5/8 -11 X 5-1/2" | 2 |
| 18 | Washer, Flat (5/8) | 4 |
| 19 | Washer, Flat Standard (5/8) | 2 |
| 20 | Washer, Lock (5/8) | 4 |
| 21 | Nut, Hex (5/8 -11) | 2 |

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.

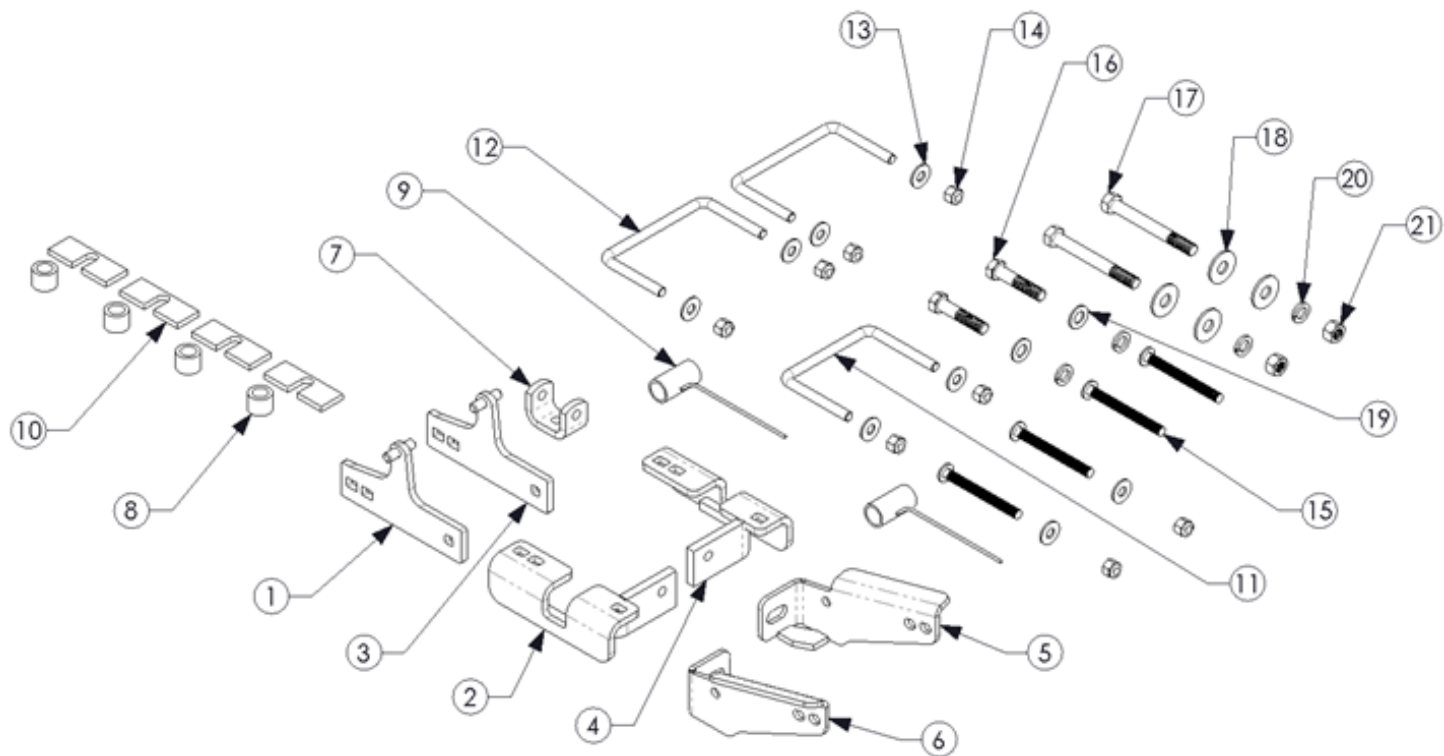
NOTE: Consult spray liner installer for recommended curing time.

Tools Required

| | |
|------------------------|-----------------|
| 3/4" Socket & Wrench | 1/4" Drill Bit |
| 15/16" Socket & Wrench | 9/16" Drill Bit |
| Drill | 5/8" Drill Bit |
| Torque Wrench | 3/4" Drill Bit |
| Safety Glasses | 13MM Socket |
| Ratchet Extension | Pry Bar |

Torque Value Chart

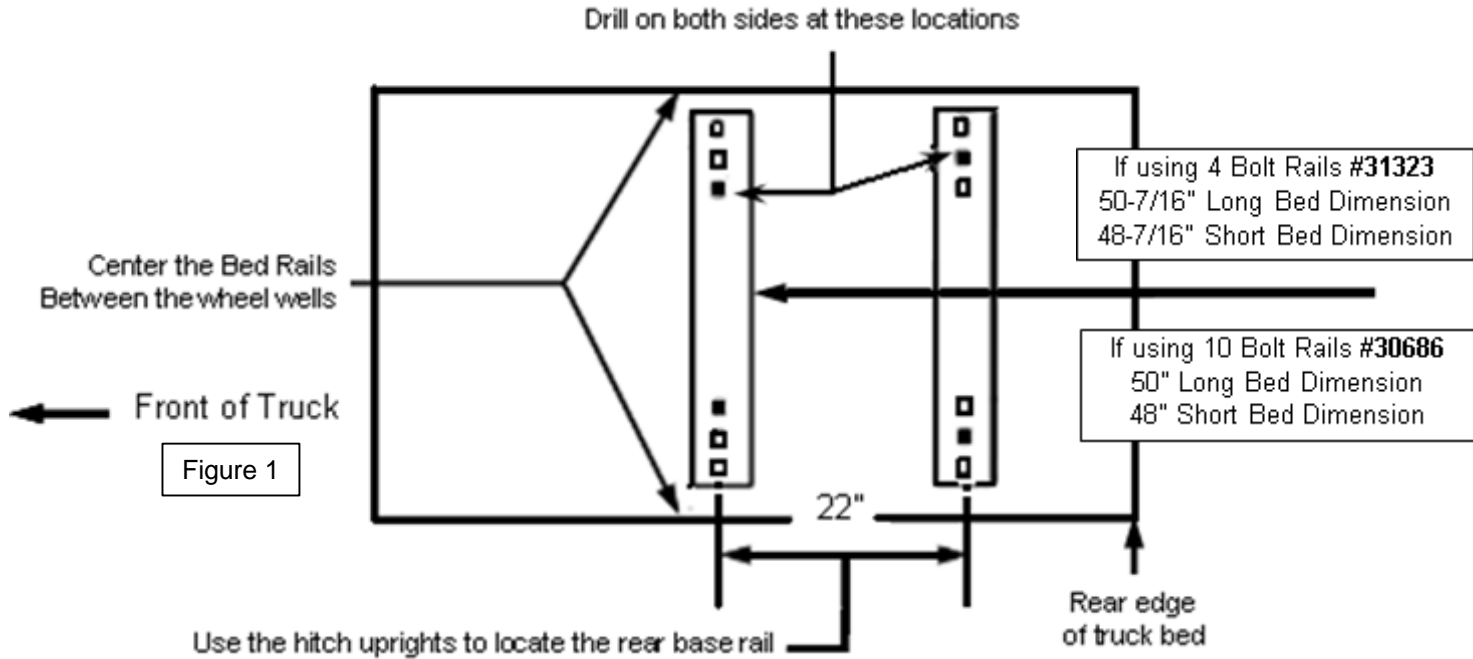
| Bolt size | Torque Range (ft. - lbs) |
|-----------|-----------------------------|
| 1/2 | 75 |
| 9/16 | 110 |
| 5/8 | 150 |
| 3/4 | 260 |



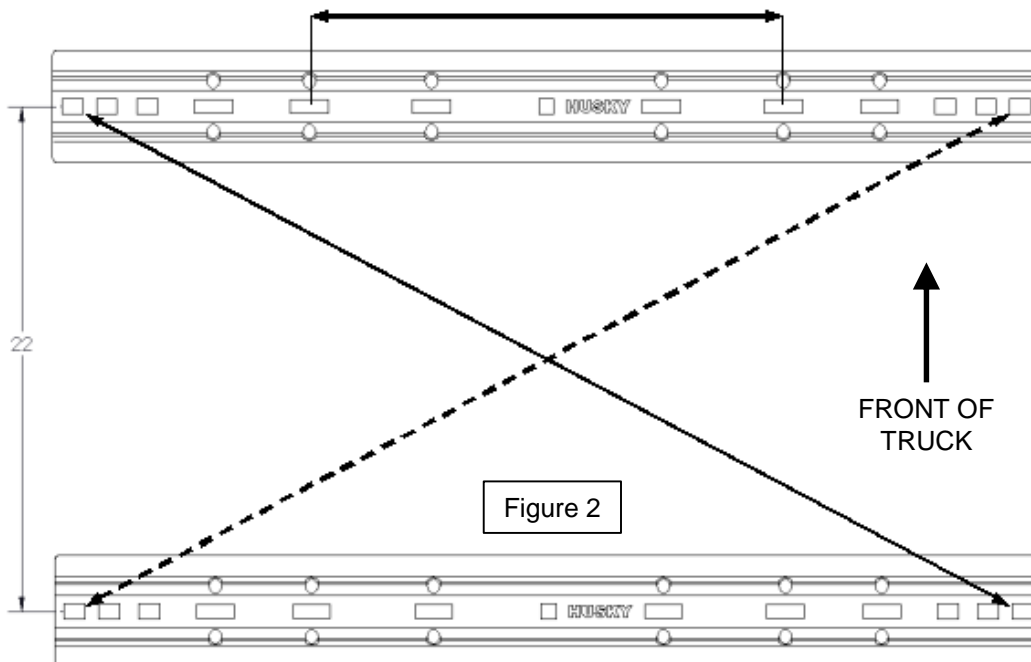
Warning:

On the inside of the driver's side vehicle frame is a wiring harness that is held in place with plastic clips. This section of wiring harness must be moved aside by removing plastic clips from frame. This will allow the hitch parts to be positioned correctly on frame.

1. Place the two bed rails across the truck bed between the wheel wells. See Figure 1. Position the 5th wheel uprights on to 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 5th wheel installation kit. Securely attach 5th wheel cross member to uprights.



2. Position the bed rail assembly in truck bed as shown on Figure 1. Be sure bed rails are parallel by measuring diagonally as shown in Figure 2. Measurements should be less than 1/4" different.

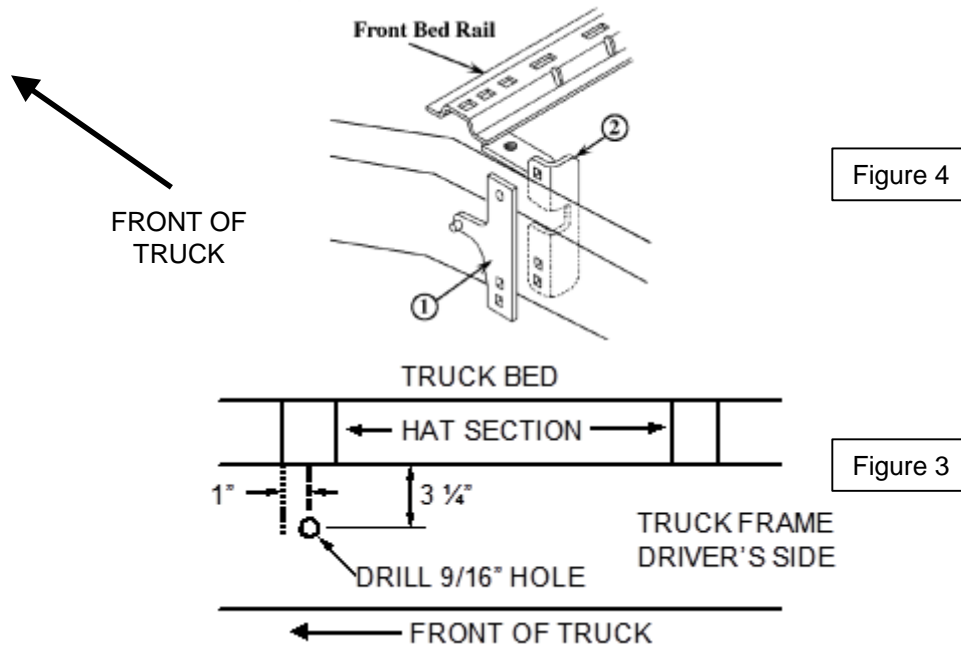


3. Mark two attachment points on the truck using the slots in the front base rail as indicated on Figure 2.

NOTE: Mark to the inner edge of the forward slots.

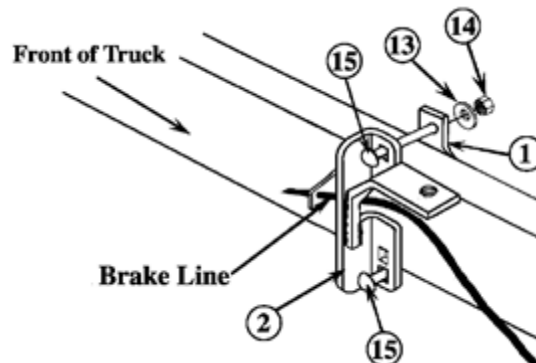
DO NOT mark rear bed rail points at this time. Check below the bed **before** drilling holes to see that all wiring, brake lines or other obstructions are moved out of the way and will not be contacted by drill. Drill 1/4" diameter pilot holes down through the bed and hat section at the previously marked points. Be certain that the holes are drilled in correct location. They must also be drilled through the under-bed hat section. See Figure 3.

4. Position the left and right front outer brackets #1 and #3 against their respective truck frames so that the pin in each bracket aligns with the existing hole in the side of the vehicle frame. See Figure 4.



NOTE: On 2500HD and 3500HD series trucks there may be a wire hanger bracket bolted to the frame at a location which will not allow the front frame bracket to be installed. This wire bracket will have to be removed from the frame so that the frame bracket can be installed.

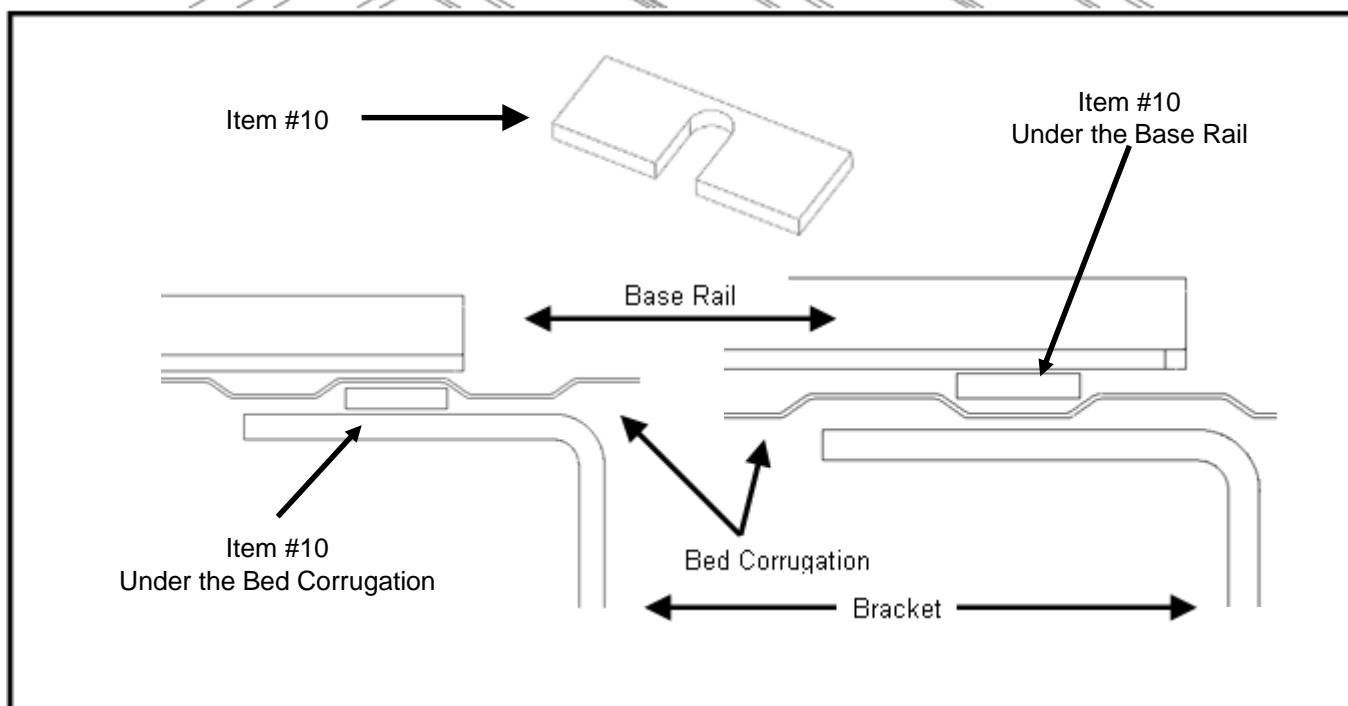
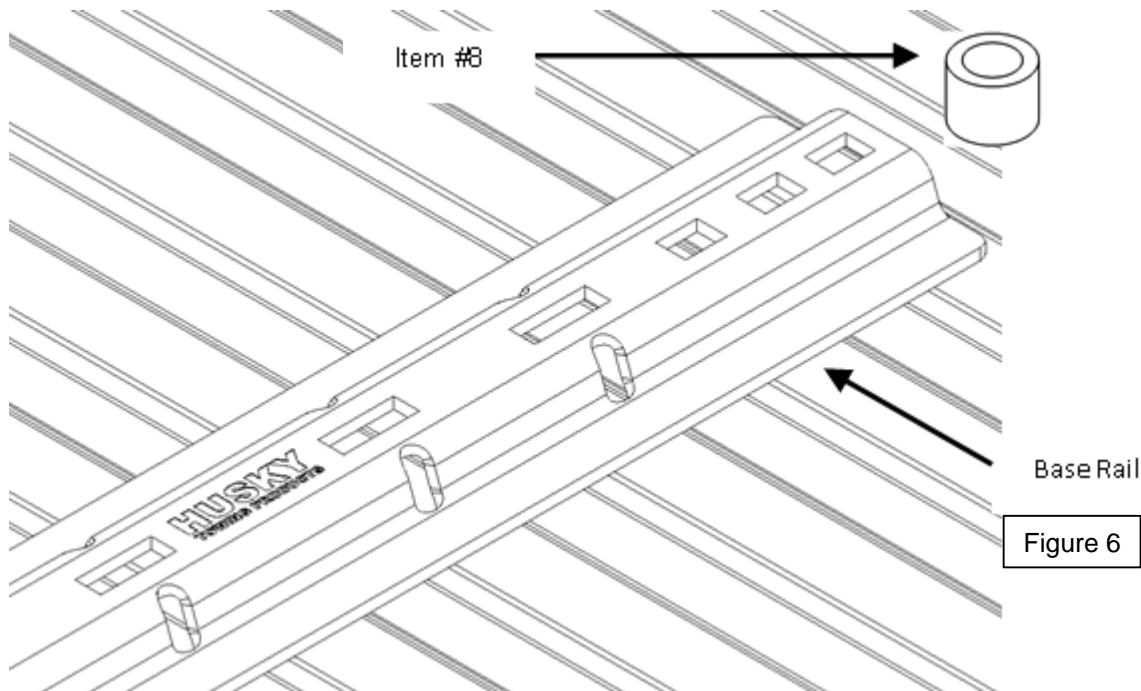
5. Bolt the left and right front outer brackets #1 and #3 to frame the inner brackets #2 and #4. Take care when positioning the left inner bracket #2 so that the slot in bracket fits over the steel brake line. See Figure 5. Use the carriage bolts (#15) at both bracket attachments. Slide bracket #2 rearward away from the gas tank so long bolt can be installed. Then slide bracket forward into position. Use the lower hole in each bracket for the 2500HD and 3500HD trucks and the upper hole in each bracket for the 1500 trucks. Bolts must be as close to bottom of truck frame as possible. The tab on the inner bracket should be against the bottom of the bed support hat section. The hole in the tab should be aligned with the previously drilled 1/4" pilot hole



6. Position the bed rails in the bed so that the inner square 5/8" hole in the front rail is lined up over the previously drilled pilot holes. Double check that the pilot holes line up with holes in bed rail and tab on frame bracket under the bed. Move bed rails away from pilot holes and drill a 3/4" hole down through truck bed at each of the previously drill pilot holes. The 3/4" hole will give some tolerance to get bolt down into the bracket hole. **Use caution when drilling so that drill does not make contact with the installed brackets or fuel tank under bed.**

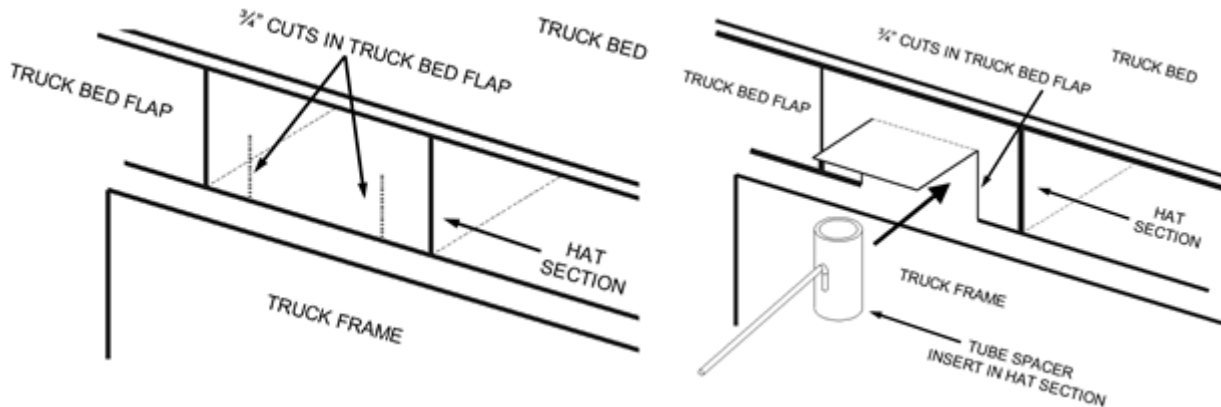
NOTE: For alternative installation procedures refer to the last page of this document.

7. Place a 1" thick spacer plate (#8) under ends of each bed rail, in line with the drilled holes, as shown in Figure 6. If the bed corrugation above the mounting bracket at the drilled hole is UP, leaving a space above the bracket, place a spacer plate (#10) in this location as shown in Figure 7. If the corrugation is DOWN, at this location, place a spacer plate (#10) in the bed, under the base rail as shown in Figure 7.



8. Slide tube spacers (#9) into the forward bed support hat section from the open end in each wheel well.

NOTE: On some applications, a small sheet metal flange may appear to obstruct placement of the spacer tube. This flange can be modified to gain access to the hat section. Make (2) $\frac{3}{4}$ " cuts in the truck bed flange near the hat section. Bend the cut section outward. Then insert the tube spacer. See Figure 8.



9. On driver's side of the truck align the tube spacer with drilled hole and drop the 5/8" bolts (#17) with the flat washers (#18) and lock washer (#20) down through all parts and mounting brackets. Thread bolt into tapped plate on left front inner bracket, #2. Repeat procedure on the passenger side of the front bed rail using the same fasteners. See Figure 9. Tighten 5/8" bolts to 150 ft. – lbs. torque. Bend the cut section back to its original position and the installation will be complete. Paint or undercoat the cut areas to help prevent corrosion.

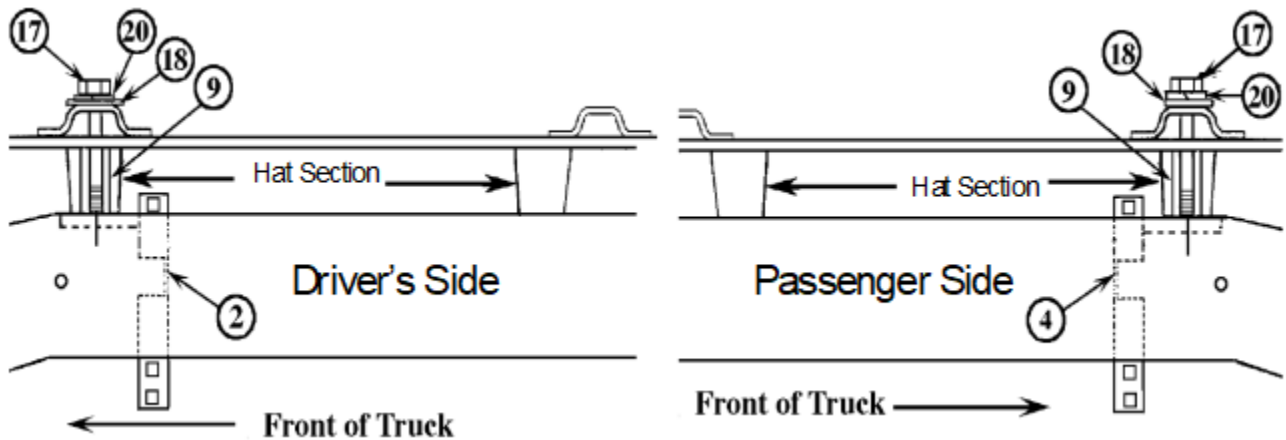
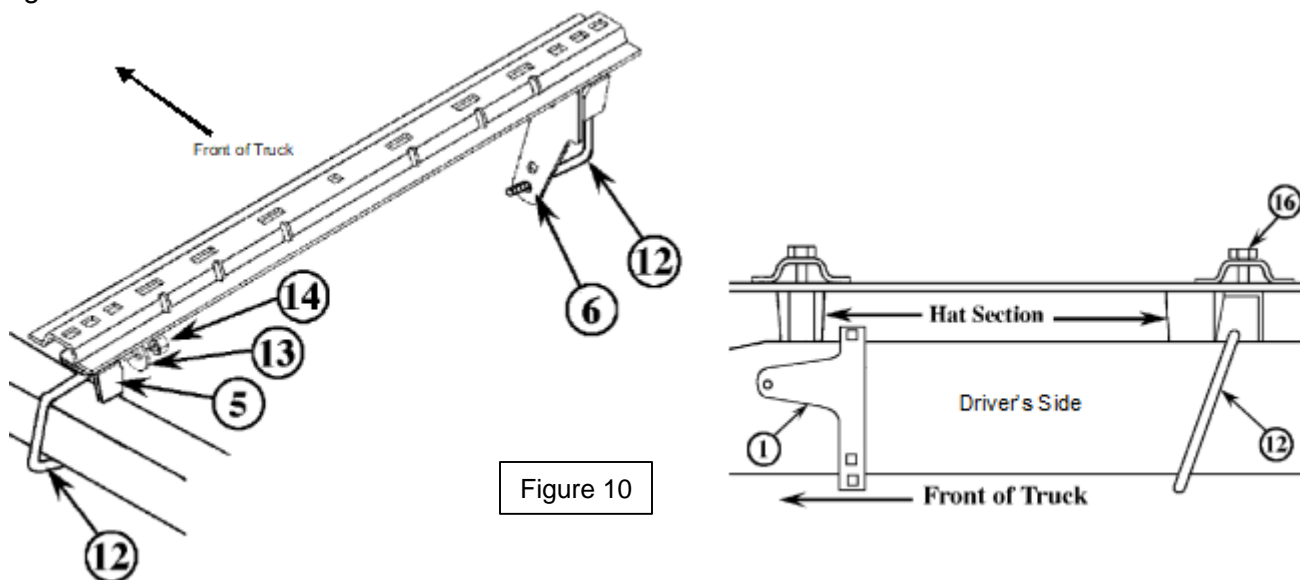


Figure 9

10. Mark the rear hole locations using the rear bed rails as shown on Figure 1. Drill a 5/8" hole down through bed using the center 5/8" hole in each end of rear bed rail as a guide as shown in Figure 1.
11. Place spacer plates under bed rails as described in Step 6. Place the short 5/8" bolts (#16) with wide flat washers (#18) down through bed rail, spacer plates and truck bed at drilled holes

2500HD & 3500HD Applications:

12. Place the left and right rear inner mounting brackets (#5 & #6) up in place against the inside surface of the vehicle frame, just behind the under-bed hat section reinforcement. See Figure 10. The previously installed 5/8" bolts should go through the upper tab in each bracket. NOTE: The rubber tailpipe hanger may need to be moved away from the frame slightly so that the right bracket can be positioned correctly. Bolt the brackets loosely in place at these bolts with flat washers (#19), lock washers (#20), and hex nuts (#21).
13. Secure the left and right inner mounting brackets in place with the longer U-bolts (#12) placed around truck frame as shown in Figure 10. Use the lower hole in each bracket for the 2500HD and 3500HD trucks. Bolt must be as close to bottom of truck frame as possible.
14. Tighten all 1/2" bolts to 75 ft.-lbs. and all 5/8" bolts to 150 ft.-lbs.



NOTE: After the U-bolts are installed and torqued to specification, the lower leg of the U-bolts may need to be trimmed off to clear leaf springs or suspension parts.

15. Check each base rail hitch pin for freedom of movement before tightening the 5/8" base rail bolts. Adjust uprights, if necessary, by placing shim 31582 or 30243 between the upright and the cross member to obtain free pin movement. See Figure 11. Shims 31582 & 30243 sold separately

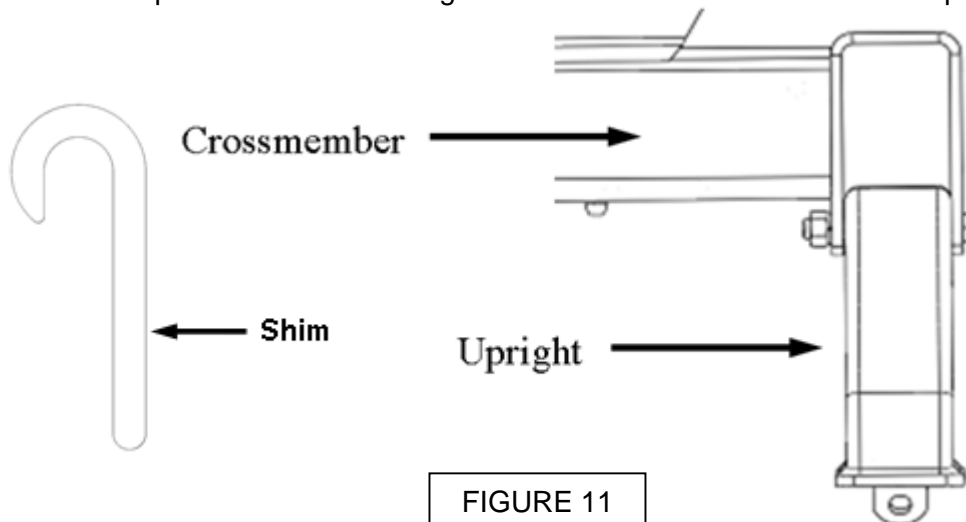


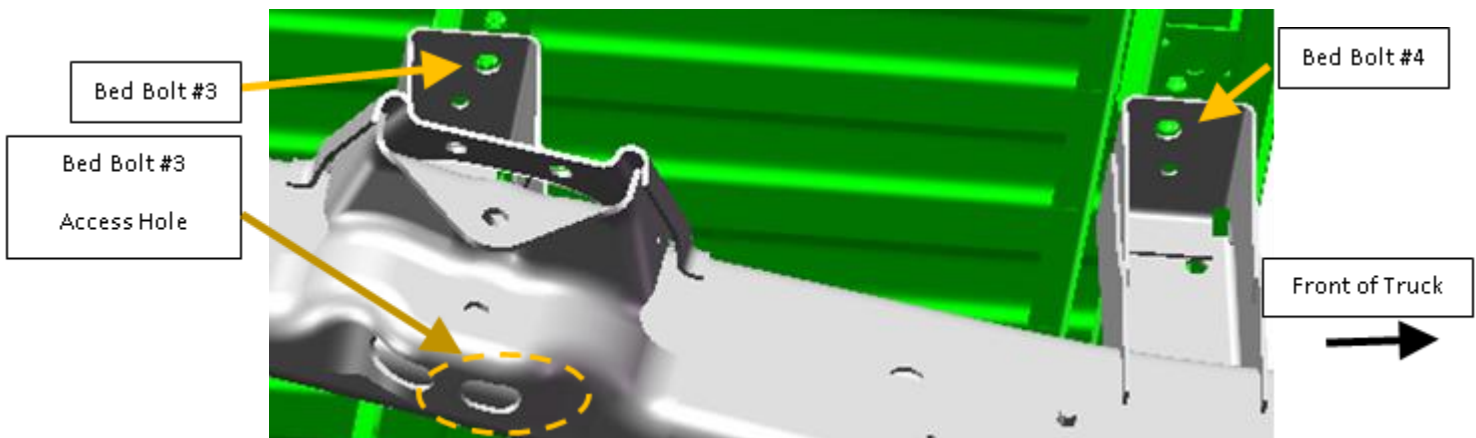
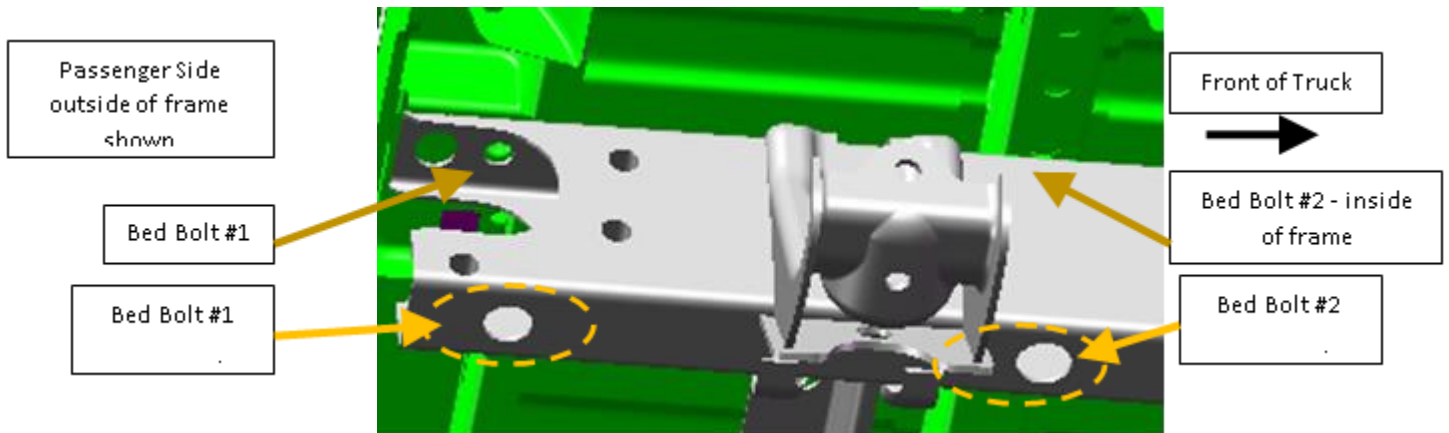
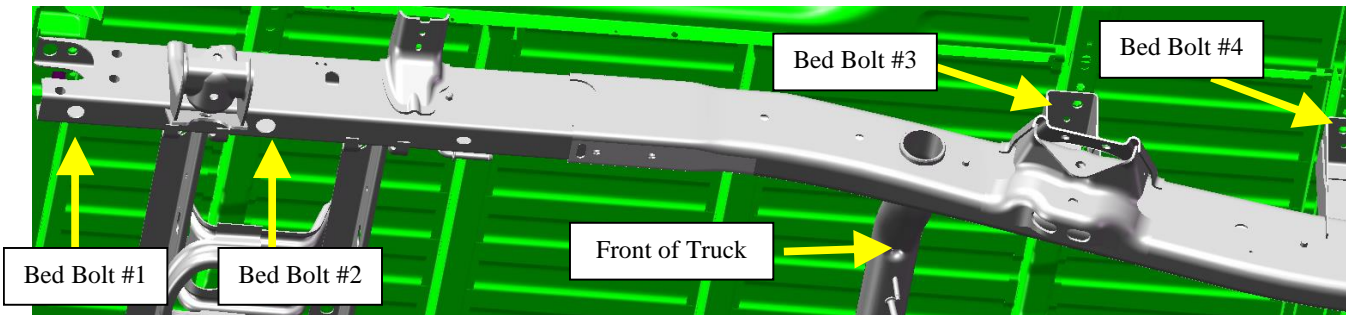
FIGURE 11

Alternative Installation Procedure for 2500HD & 3500HD Applications:

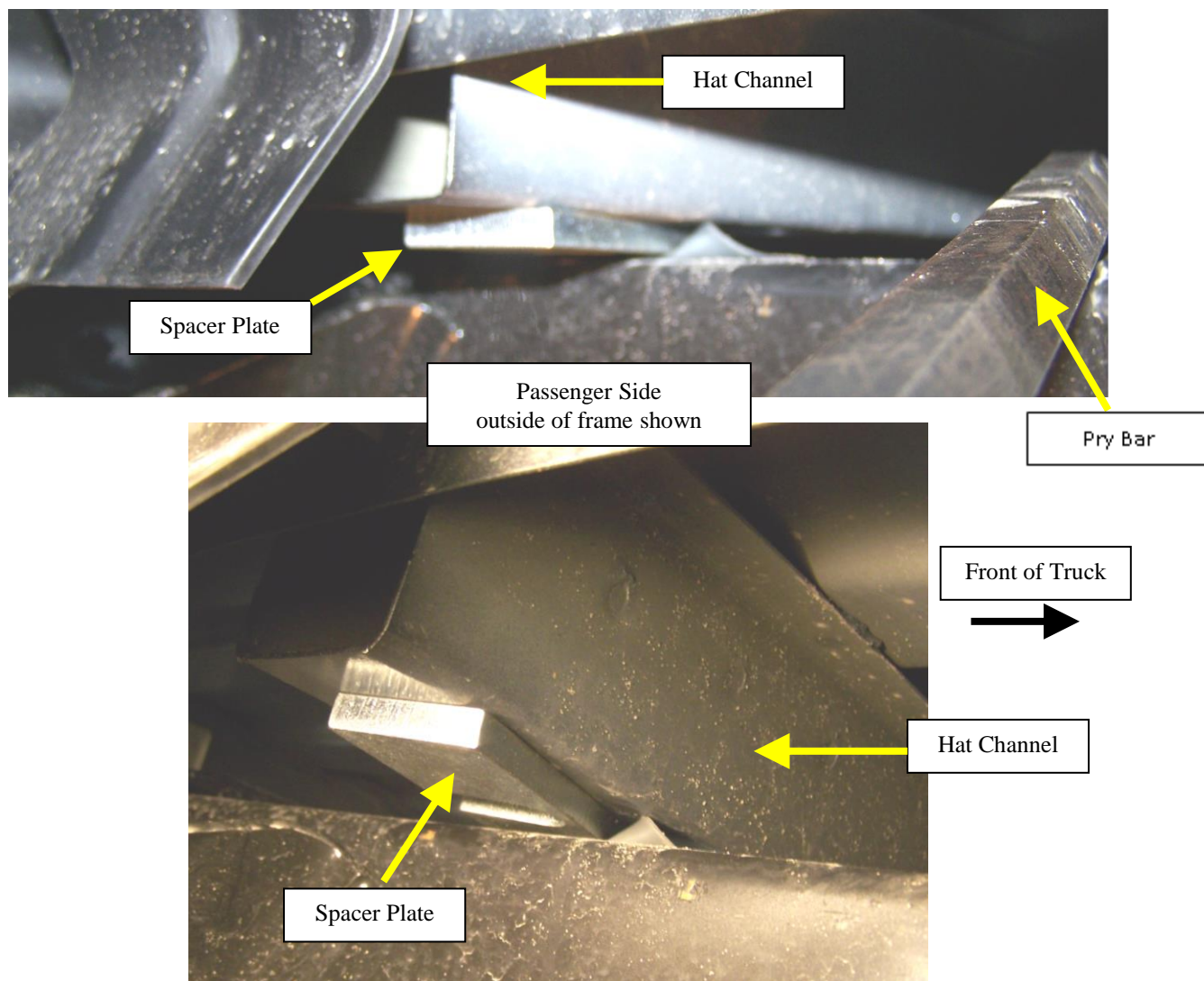
Some models may have difficulty installing the passenger side rear bracket (#5) due to the exhaust & muffler hanger & spare tire heat shield. An alternative method of installing this bracket is to loosen the passenger side bed bolts and temporarily raise the bed 1/4". This will allow the passenger side rear bracket (#5) to be installed without removing the exhaust from the muffler hanger or removing the spare tire heat shield.



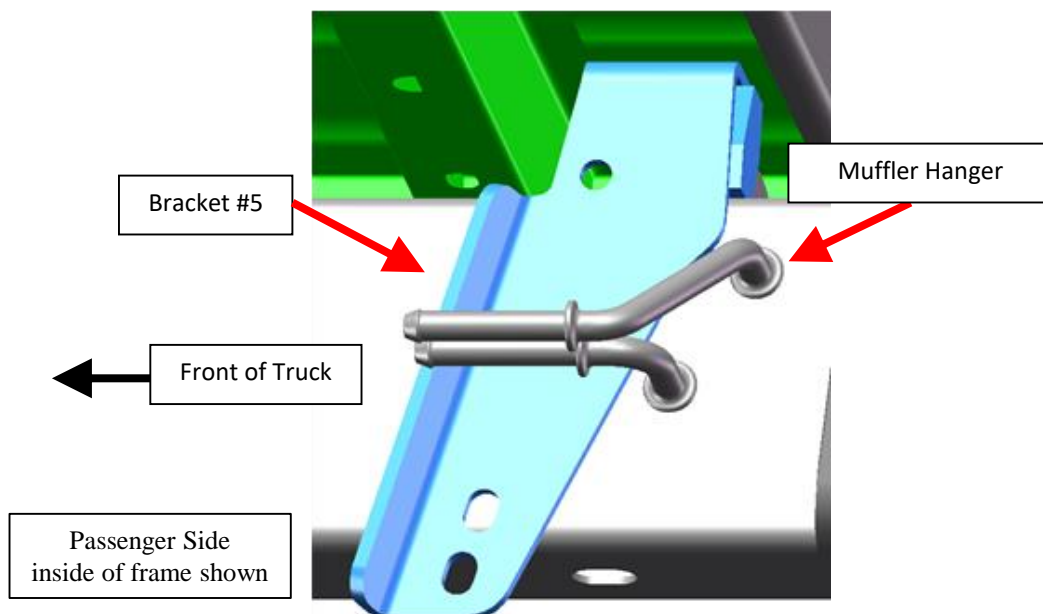
12A) Loosen (DON'T REMOVE) the 4 passenger side bed bolts using a 13mm thin wall socket and 12" extension.



12B) Use pry bar to raise truck bed enough to temporarily insert spacer plate (#10) in between the truck frame and hat channel just above passenger side rear bracket (#5) location.

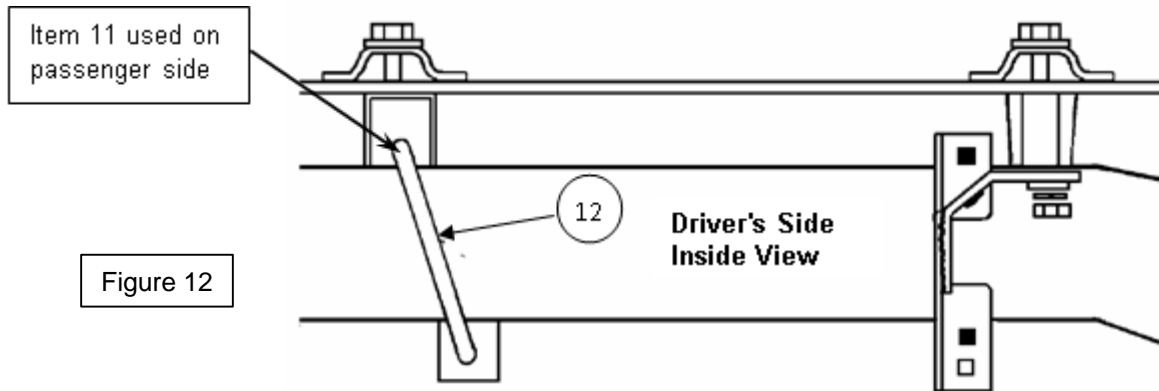
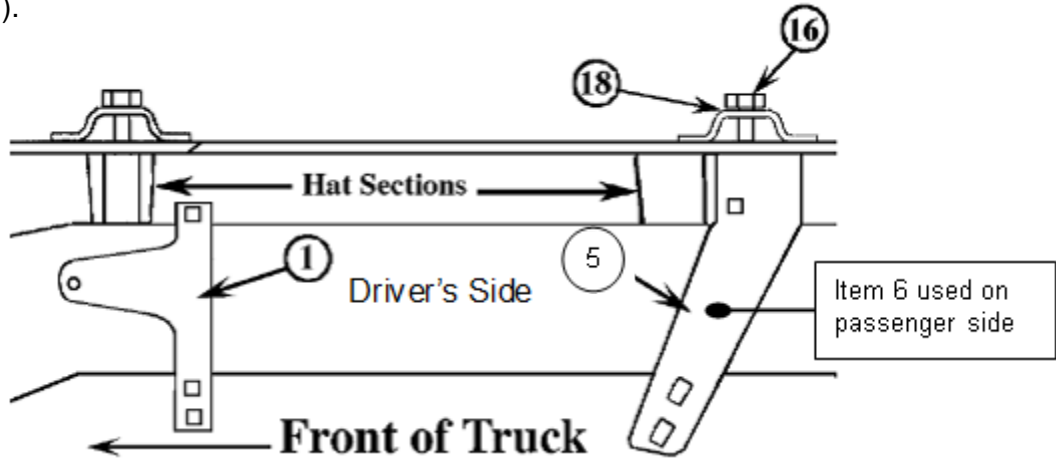


12C) Install passenger side rear bracket (#5) as shown in Figure 10. Remove the spacer plate. Retighten the passenger side bed bolts. Continue with Step 13 on page 6.

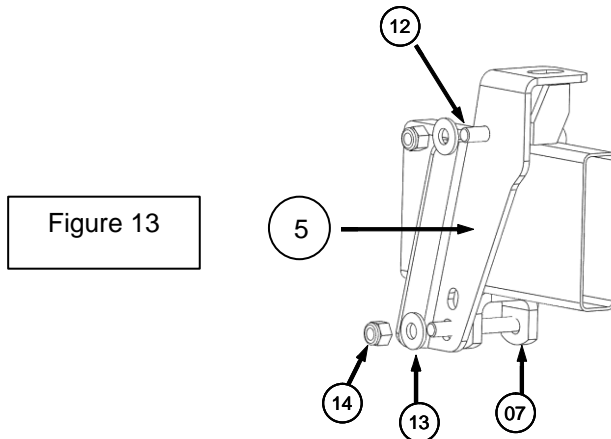


1500 Applications:

12. Place the left rear mounting bracket (#5) against the outside surface of the right frame and the right rear mounting bracket (#6) against the outside surface of the left frame with the mounting tabs positioned over the truck frame rails in line with the previously installed 5/8" bolts. See Figure 12 which shows the left frame. Bolt the brackets loosely in place at these bolts with flat washers (#19), lock washers (#20), and hex nuts (#21).



13. Secure the rear mounting bracket (#6) to the driver's side of the truck frame with one of the long U-Bolts (#12) and spacer bracket (#7) as shown in Figure 13.

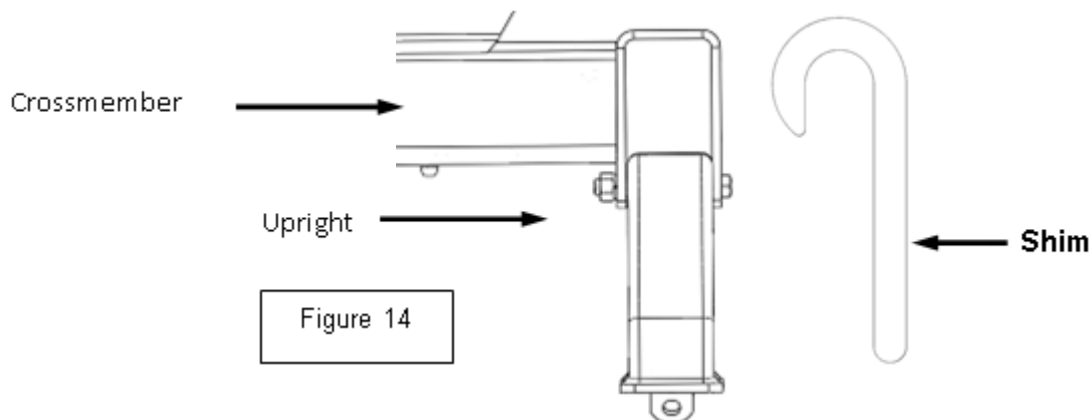


14. Secure the rear mounting bracket (#5) to the right truck frame with the short U-bolt (#11) as shown in Figure 13.

Warning: After the U-bolts are installed and torqued to specification, the lower leg of the U-bolts may need to be trimmed off to clear leaf springs or suspension parts.

15. Tighten all 1/2" bolts to 75 ft.-lbs. torque and all 5/8" bolts to 150 ft.-lbs.

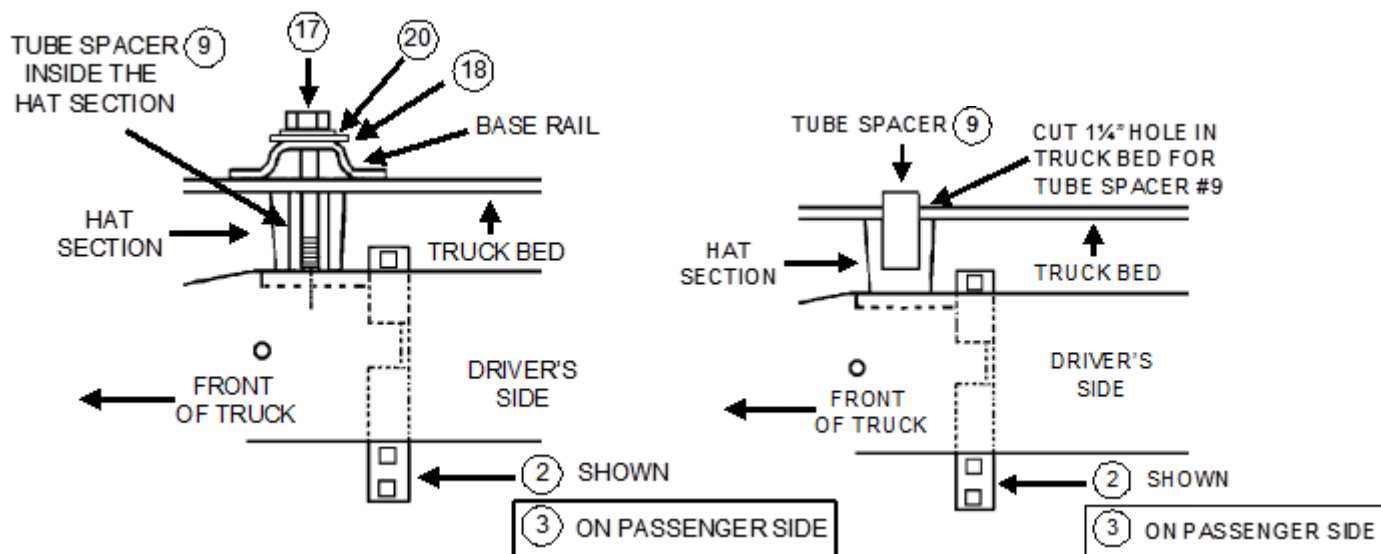
16. Check each base rail hitch pin for freedom of movement before tightening the 5/8" base rail bolts. Adjust uprights, if necessary, by placing shim 31582 or 30243 between the upright and the cross member to obtain free pin movement. See Figure 14. Shims 31582 & 30243 sold separately



Alternative Installation Procedure for 1500 Applications:

BE SURE TO ADVISE CUSTOMER ABOUT THE LARGE HOLES THAT WILL BE CUT INTO BED BEFORE BEGINNING THIS INSTALLATION.

1. Cut a 1-1/4" hole down through the bed at pilot hole location. This hole must only be cut through bed of truck, not through bottom of hat section under the bed.
2. Drill a 5/8" hole through bottom of the hat section under the bed at the previously drilled pilot hole.
3. Remove the wire handle from spacer tube #9. Drop the spacer tube down through the hole in bed so that it will rest on the under bed hat section in line with the previously drilled 5/8" diameter hole.
4. With the front base rail in place; drop one of the 5/8 X 5-1/2" hex bolts (#17) down through the base rail, tube spacer, and frame bracket tab. Bolt securely in place at this location.
5. Repeat procedure on the other end of front base rail.
6. Tighten 5/8 bolts to 150 ft - lbs.
7. Continue with Step 10 in the main Instructions.



Warranty Terms:

5 Year Limited Warranty:

This warranty applies solely to Husky 5th Wheel Installation Kits manufactured by Keystone Automotive Operations Inc. for Husky Towing Products.

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

Keystone Automotive Operations Inc. 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 Keystone Automotive Operations Inc. 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 Keystone Automotive Operations Inc.

The Warranty applies to Keystone Automotive Operations Inc. products used for individual and recreational purposes. Commercial usage of the Keystone Automotive Operations Inc. products limits the warranty to 90-days from date of purchase.

The Warranty applies only to Keystone Automotive Operations Inc. products which are found to be defective in manufacturing or material. This warranty does not apply to normal wear and tear of the finish placed on Keystone Automotive Operations Inc. products.

Husky Towing Products and Keystone Automotive Operations Inc. are not responsible for any labor costs incurred for removal or replacement of the defective product.

Husky Towing Products and Keystone Automotive Operations Inc. 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.

Without limiting the generality of the foregoing, Husky Towing Products and Keystone Automotive Operations Inc. shall under no circumstances be liable for any incidental or consequential loss or damage whatsoever arising out of, or in any way relating to any such breach of warranty or claimed defect in, or non-performance of the products. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above exclusion or limitation may not apply to you.

This limited warranty gives you specific legal rights, and you may also have other rights that vary from state to state.