



**2017 Ford F350 Dually Bed
Bracket Kit
IN 627**

Product No.
94001

Hardware included shown on right.

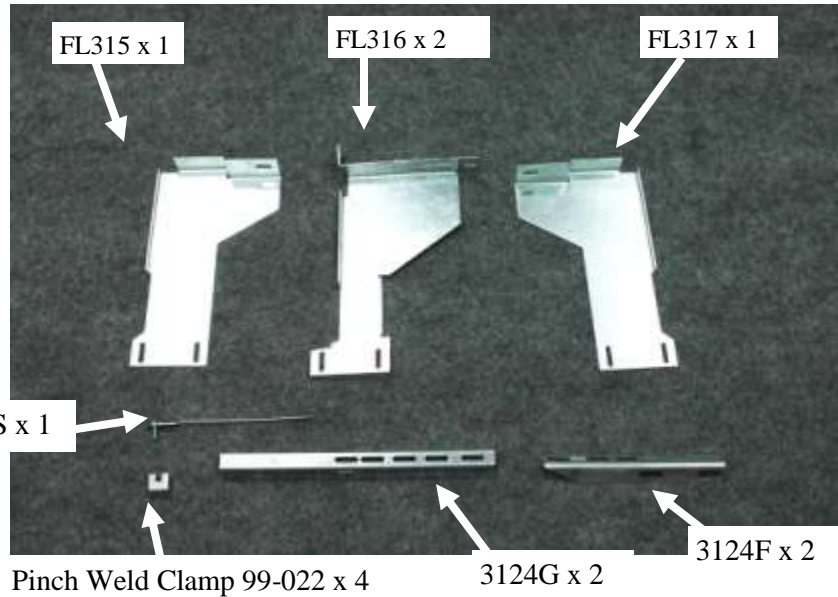
No Drilling into Vehicle is Required

Tools required:

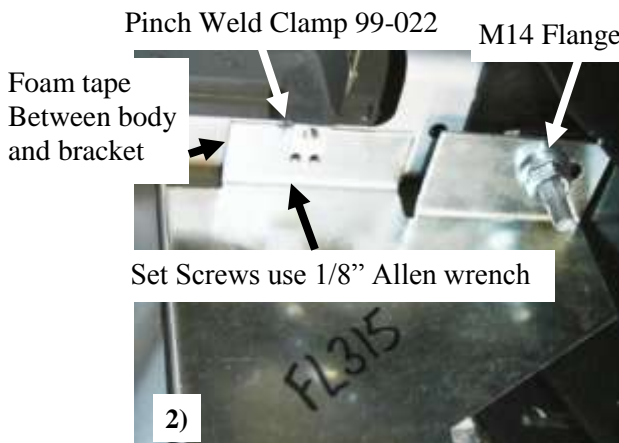
- 1/2" wrench
- Ratchet
- 1/2" Socket
- 10mm Socket
- 21mm Deep Socket / 13/16"
- Tape measure
- 1/8" Allen Wrench
- Vice Grip Pliers

Torque Specification:

- M6 Bolt - 8 Ft Lbs.
- M14 Nut - 68 Ft Lbs.
- 5/16" Bolt - 19 Ft Lbs.
- 1/4" Set Screw - 10 Ft Lbs.

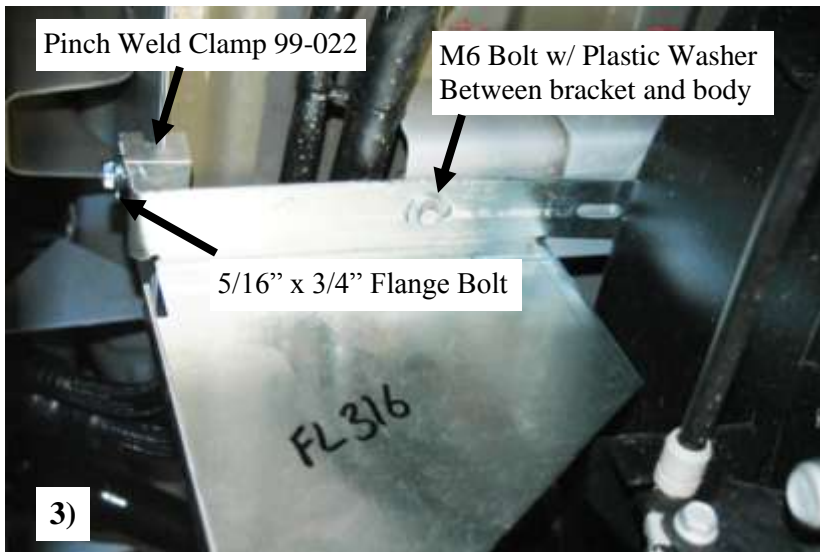


Place a strip of foam tape on the top of the FL315 and FL317 bracket as shown in photo above, this will insulate the steel bracket from the aluminum body to avoid corrosion.



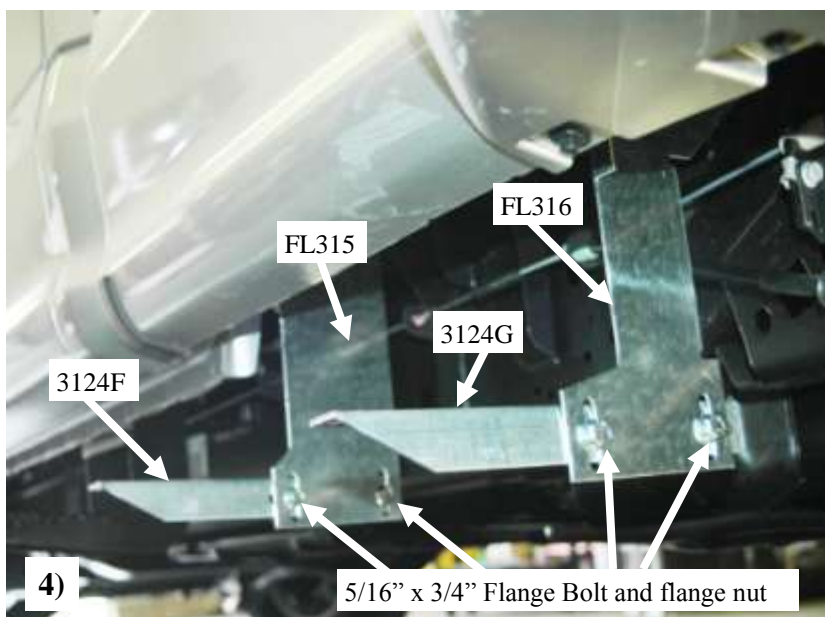
Slide the FL315 bracket slot up onto the M14 thread on the front bed cross brace, and thread the M14 Flange nut supplied in hardware pack with a 21mm deep socket or a 13/16" deep socket if you do not have a metric socket large enough. Once the nut is tight, place a 99-022 pinch weld clamp with the set screws installed with 1/8" Allen wrench over the flange of the front bed cross brace and the FL315 and tighten approximately 3/4" from the edge of the FL315 bracket as shown in **Fig 2**

Use pair of vice grip pliers to hold the 99-022 when tightening the set screws, this will give better leverage.



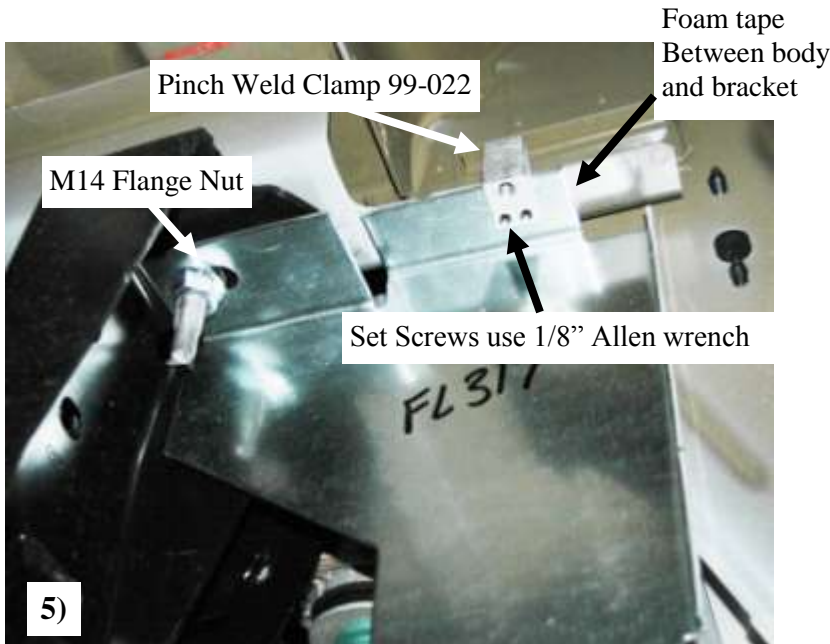
Remove the M6 bolt holding the fuel filler neck hose clamp. Then place a 99-022 pinch weld clamp up onto the pinch weld as shown above, tighten the set screws so that the 99-022 is centered with the second bed cross brace. Put the M6 bolt from the hardware pack through a flat washer and up through the center slot in the FL316 top flange making sure plastic washer is between aluminum body and FL316 then thread into the spring clip on cross brace making sure the fuel filler bracket is in between the FL316 and cross brace leave a little loose. A 5/16" x 3/4" flange bolt now needs to be places through the top flange of the FL316 and threaded into the hole in the 99-022 pinch weld clamp tighten completely. Now go back and tighten the M6 bolt with a 10mm socket completely. **Fig 3**

Use pair of vice grip pliers to hold the 99-022 when tightening the set screws, this will give better leverage.



Mount the 3124F angles to the FL315 and 3124G to the FL316 lower slots with 5/16" x 3/4" Flange bolts and flange nuts through each slot as shown in **Fig 4**

Leave loose for adjustment once board is mounted onto vehicle.



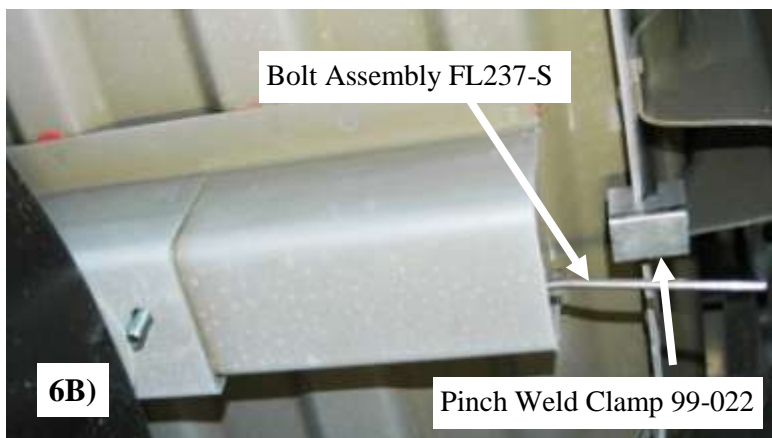
Slide the FL317 bracket slot up onto the M14 thread on the front bed cross brace, and thread the M14 Flange nut supplied in hardware pack with a 21mm deep socket or a 13/16" deep socket if you do not have a metric socket large enough. Once the nut is tight, place a 99-022 pinch weld clamp with the set screws installed with 1/8" Allen wrench over the flange of the front bed cross brace and the FL317 and tighten approximately 3/4" from the edge of the FL317 bracket as shown in **Fig 5**

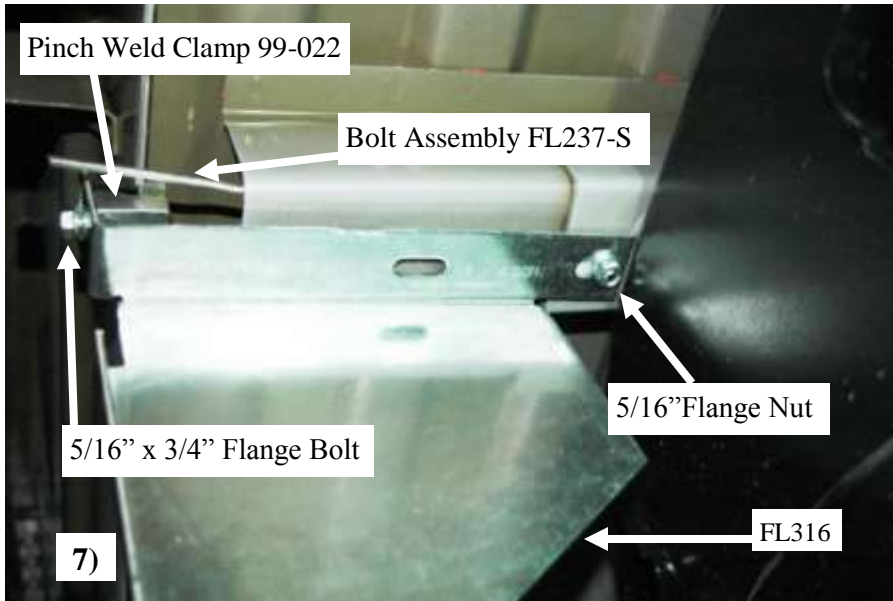
Use pair of vice grip pliers to hold the 99-022 when tightening the set screws, this will give better leverage.



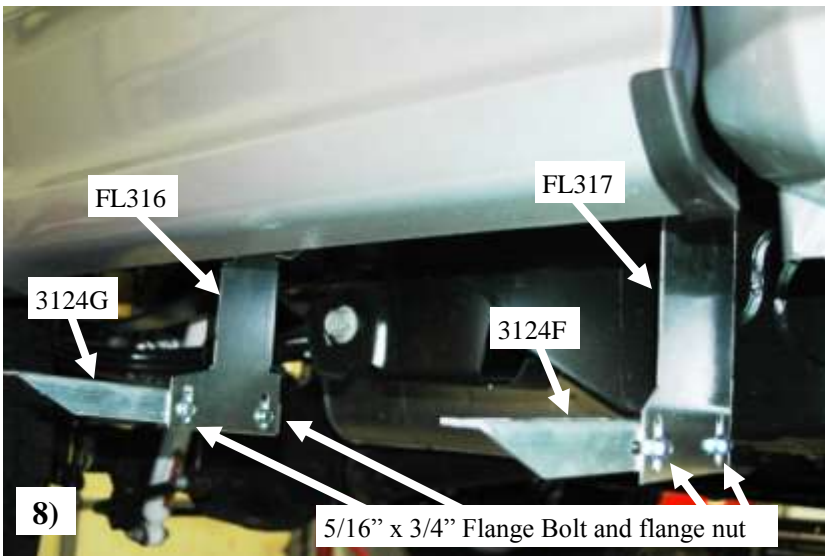
Like on the driver side on the second cross brace mount a 99-022 pinch weld clamp up onto the pinch weld, tighten the set screws so that the 99-022 is centered with the cross brace. Then slide the bolt assembly FL237-S with a plastic washer on threads to insulate the aluminum body to the steel of the FL237-S slide into the cross brace until the threads come down through the hole in cross brace. **Fig 6B**

Use pair of vice grip pliers to hold the 99-022 when tightening the set screws, this will give better leverage





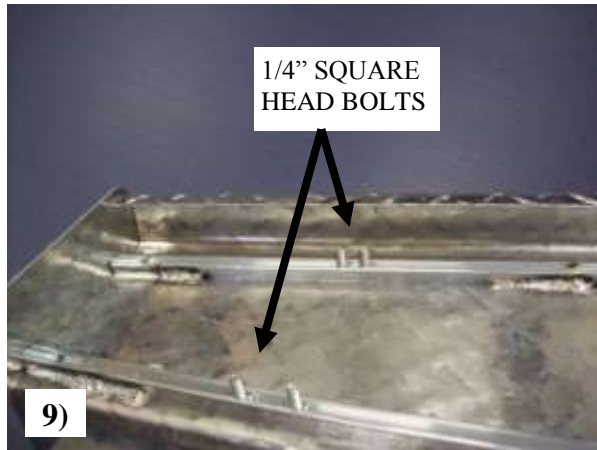
Slide the FL316 rear slot onto the threads on the FL237-S coming through the second bed rail making sure a plastic washer insulated the aluminum body to the steel bracket and thread a 5/16" flange nut onto threads, put a 5/16" x 3/4" Flange bolt through the top slot on the FL316 and thread into the 99-022 pinch weld and tighten completely. Go back and tighten the 5/16" flange nut completely.
Fig 7



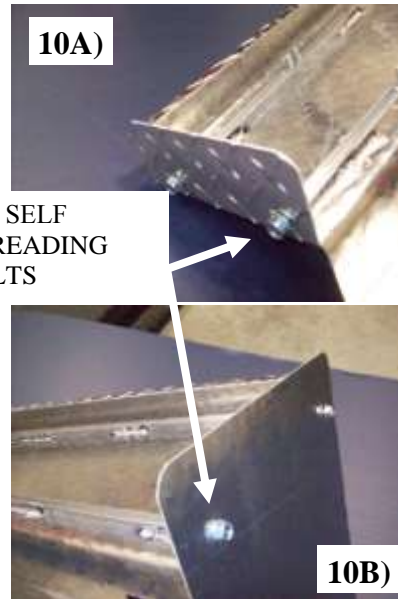
Mount the 3124F angles to the FL317 and 3124G to the FL316 lower slots with 5/16" x 3/4" Flange bolts and flange nuts through each slot as shown in **Fig 8**

Leave loose for adjustment once board is mounted onto vehicle.

Once the cab boards are mounted onto vehicle adjust the 3124F angle bracket and the 3124G channel brackets so that the boards on the bed are level with the cab boards and tighten all bolts completely.



Insert (2) square head bolts into each track. **Fig 9**



Attach stone guard and end cap to each end of running board using (2) 3/8" self threading bolts into tracks that square bolts were put into. **Fig 10**



Place 1/4" nuts onto the bolts. **Fig 11**