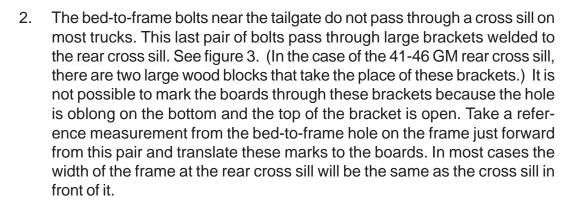
DRILLING BED TO FRAME HOLES for 3/8" Bed-to-Frame bolts with Offset Washers

These are suggestions on how to drill and countersink the locations for the bedto-frame bolts and offset washers that sit on the top of the wood surface. If wood was purchased without holes or you are making your own wood, the following steps will direct you through this process. You should have your bed put together: bed sides, front bed panel, rear cross sills and cross sills, wood boards and bed strips. See figure 1.

 The cross sills are generally the locations for the bed-to-frame mounting bolts. However, There may be instances where a cross sill does not bolt to the frame. Some cross sills may also have multiple hole patterns. Using the mounting locations on the frame as a reference, mark the bottom of the wood boards through the bed-to-frame holes in the cross sills. These marks may be on one board per side of the truck or on two boards for each side. See figure 2.

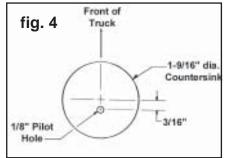


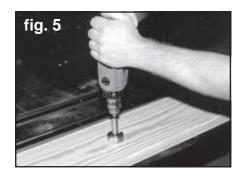
- 3. Make reference as to which end of each board is at the front of the bed. Remove the bed strips and the boards that are marked. The bottom side of these boards should now have 1/2" diameter holes marked on them. Drill a 1/8" diameter pilot hole through the center of these marks completely through the boards.
- 4. On the top surface of the boards, measure toward the front of each board 3/16" from each pilot hole and mark the boards for the countersink. See figure 4.
- 5. Using a 1-9/16" diameter Forstner bit, a drill press if available, or a hand drill, countersink each location approximately 1/8" to 5/32" deep. See figure 5.











6. From the top surface, drill through the 1/8" pilot holes with a 1/2" drill bit to complete the bed-to-frame holes. See figure 6. Before drilling the 1/2" hole, place a piece of scrap wood directly under the 1/8" hole to prevent splintering as the drill breaks through.



- 7. Re-install these boards and strips.
- 8. Align the bed holes to the frame holes. Install the carriage bolts with the offset washer through the wood boards, cross sills/brackets, wood blocks/rubber pads, and the frame. Secure with the flat washers, lockwashers, and nuts.

PLEASE NOTE: *These are **suggestions only**. Please refer to the specific instructions for each year series in the Bed Assembly Instructions for more detailed information.