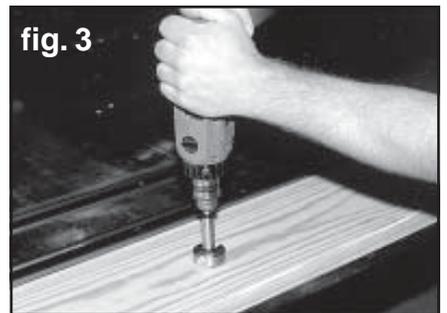
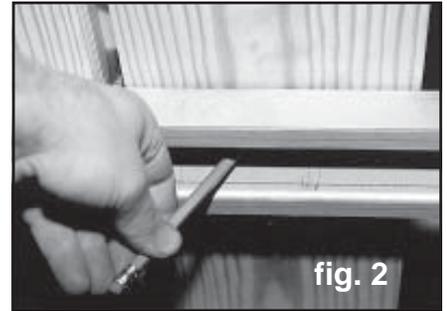
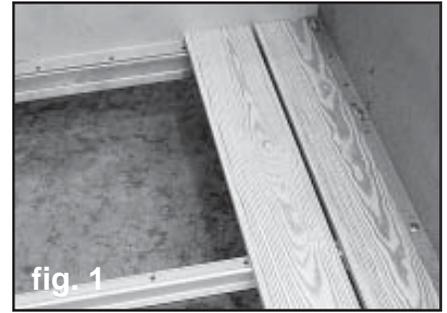


DRILLING BED TO FRAME HOLES for 1/2" Bed-to-Frame bolts with Center Hole Washers

These are suggestions on how to drill and countersink the locations for the bed-to-frame bolts and center hole 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, bed wood boards and bed strips. See figure 1.

1. The cross sills are the locations for the bed-to-frame mounting bolts. Mark the locations on the bottom of the wood boards through the 5/8" diameter holes. See figure 2. (With 53-60 Ford Flaresides the first bed-to-frame bolts are in the front of the bed strips so there is not a hole in the wood at that location. The rear sill bolts to the frame under the wood floor.)
2. 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 5/8" diameter holes marked on each of them.
3. Drill a 1/8" diameter pilot hole through the center of these marks completely through the boards.
4. On the top surface of the wood boards, countersink each location approximately 1/8" to 5/32" deep. Use a 1-7/8" diameter Forstner bit and a drill press if available. A hand drill could be used but it is not recommended. See figure 3.
5. Using the same 1/8" pilot holes as a guide, drill through the boards with a 5/8" wood bit to complete the bed-to-frame holes. See figure 4. Before drilling the 5/8" hole, place a piece of scrap wood directly under the 1/8" hole to prevent splintering as the drill breaks through. You may wish to enlarge the top of the 5/8" hole so that the bed-to-frame washer will sit in the countersink properly.
6. Re-install these boards and bed strips as before. Check that the wood holes and strip holes line up to the cross sill bed-to-frame holes on the front cross sill and center cross sills. Install the bolts with the bed-to-frame washer through the wood boards, cross sills, 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.