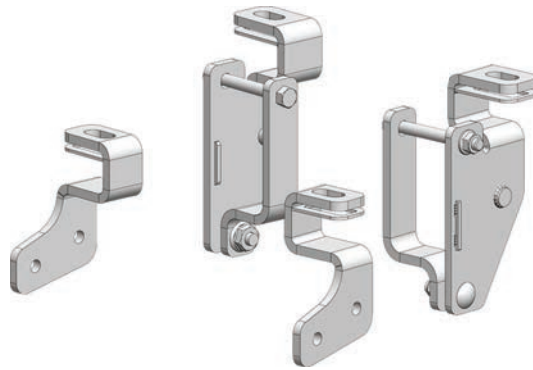




# FORD

## 16K Industry Standard Rail Custom Mounting Kit

# #2732



Gross Trailer Weight (Maximum)..... 16,000 lbs.  
Vertical Load Weight (Max. Pin Weight)..... 4,000 lbs.

### SYSTEM TOW CAPACITY

Please note, in order to determine the **total tow capacity** of a system, you must consider the weight ratings of each component in that system. This includes, but may not be limited to, the capacity/rating of the **tow vehicle**, the **fifth wheel hitch**, and the hitch's **mounting system**. Actual tow capacity of the system will be equal to the lowest rated component.

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# Installation Instructions

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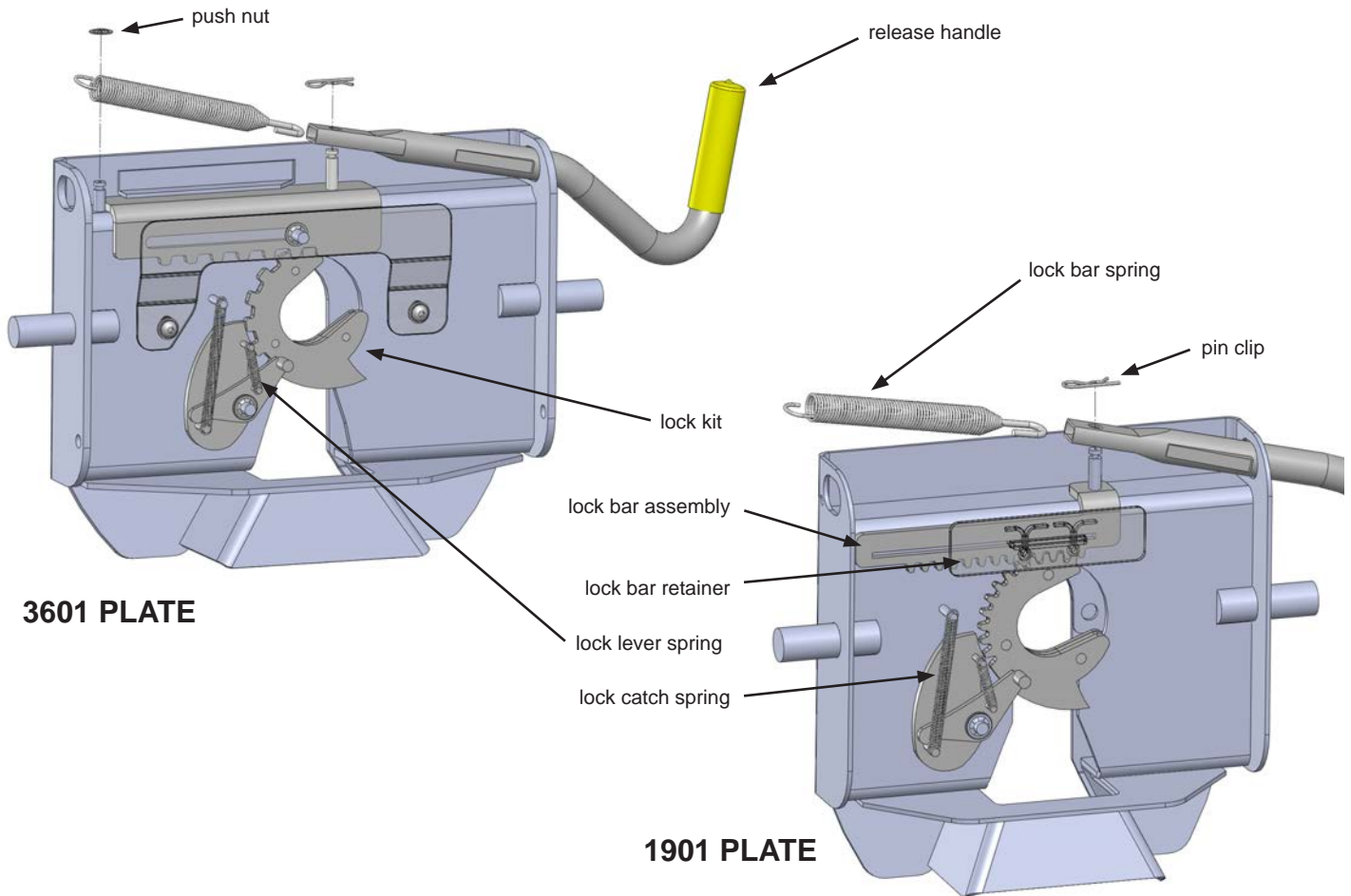
## SPECIFICATIONS

- Fits 2004-2014 Ford F150
- Hitch is located center of the axle
- Custom Mounting Bracket Kit (*Bracket & Hardware*) #2733

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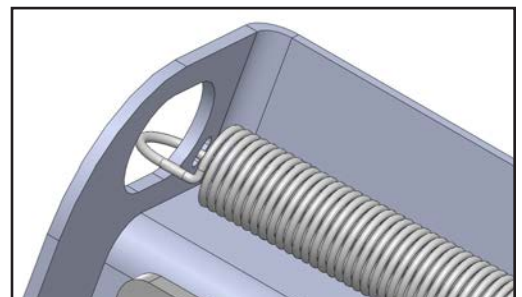
## PLATE ASSEMBLY



1. Remove the Fifth Wheel Plate from the Rocker Arm and place it upside down on a smooth, clean surface.
2. Insert the Release Handle into the obround hole of the plate as seen above.
3. The Lock Bar Spring must be placed inside the handle prior to placing the handle down over the pin of the Lock Bar Assembly, "catching" the hook inside the handle around the pin.
4. Push the handle and spring assembly down past the groove in the pin of the Lock Bar Assembly, and place one of the Pin Clips in the groove of the pin to fasten.
5. Grip the body of the spring and stretch it far enough over the opposite pin (welded to the plate) and push it down past the groove.
6. Install the Push Nut to secure the Lock Bar Spring onto the welded pin.

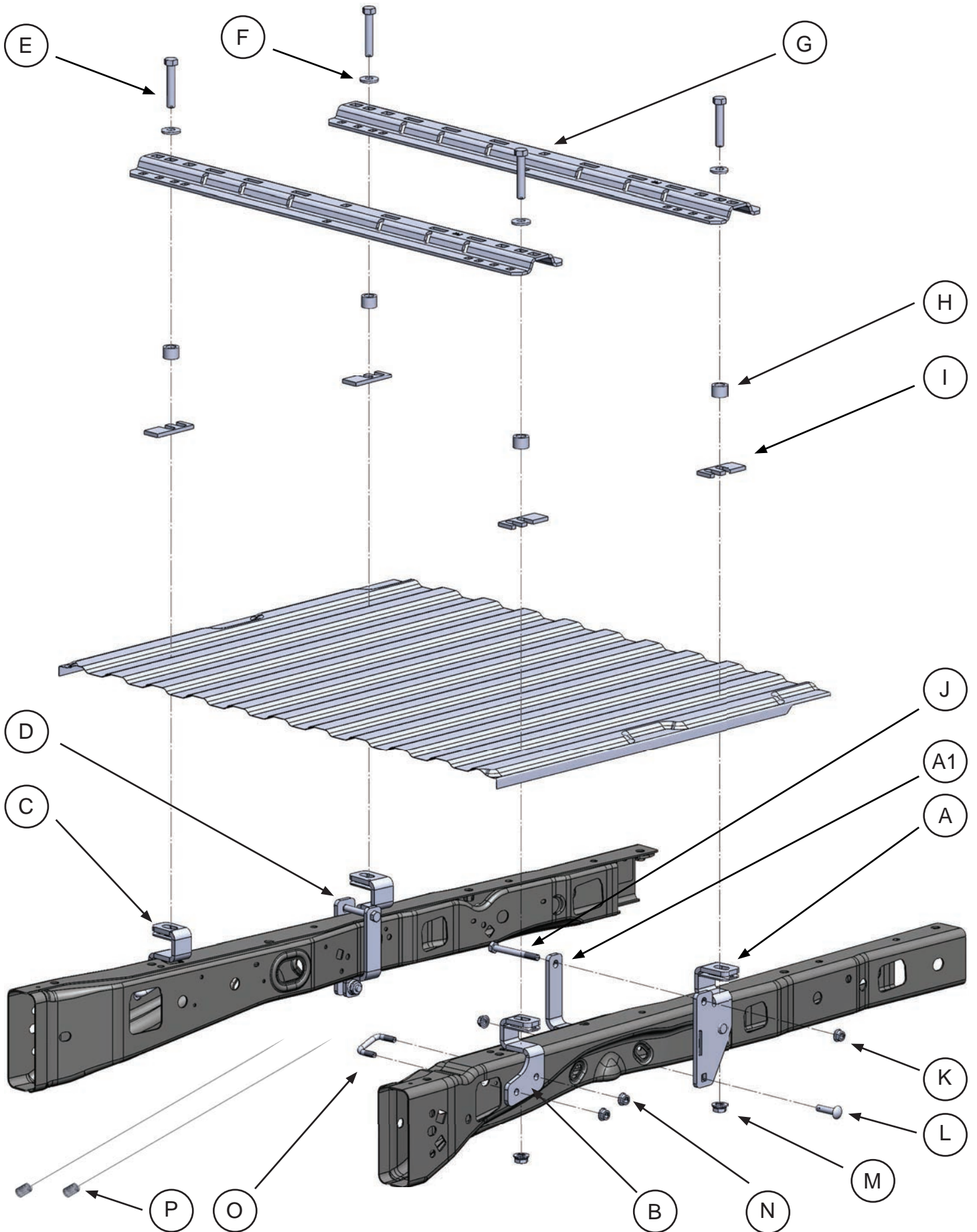
**NOTE:** The 1901 plate for the #1900 Super 5<sup>th</sup> does not use a push nut to attach the end of the spring, but rather a slot in the side of the fifth wheel plate located above the obround hole. See illustration to the right.

As a PullRite fifth wheel hitch owner, it is important for you to study and manually operate the Fifth Wheel Plate and Release Handle to better understand the locking action. A better working knowledge of the plate will help prevent accidental dropping of your trailer due to incorrect hitching.



Also, it is imperative that you study and adhere to the Maintenance procedures provided in the Owners Manual. If you did not receive one upon purchase, please contact PullRite or visit us on the web at [www.pullrite.com](http://www.pullrite.com).

# MOUNTING KIT EXPLODED VIEW



# MOUNTING KIT PARTS LIST

## #2732 FORD CUSTOM ISR BRACKET KIT

description	part no.	qty	material
MOUNTING BRACKET KIT	2733	1	(See kit contents listed below)
BASE RAIL KIT	2719	1	(See kit contents listed below)

### #2733 — MOUNTING BRACKET KIT

item	description	part no.	qty.	material
A	DRIVER SIDE REAR MOUNTING BRACKET	273303	1	
A1	REAR MOUNTING CLAMP BRACKET	27330305	2	
B	DRIVER SIDE FRONT MOUNTING BRACKET	273301	1	
C	PASSENGER SIDE FRONT MOUNTING BRACKET	273302	1	
D	PASSENGER SIDE REAR MOUNTING BRACKET	273304	1	
	MOUNTING BRACKET HARDWARE KIT	273305	1	(See kit contents listed below)

### #273305 — MOUNTING BRACKET HARDWARE KIT

item	description	part no.	qty.	material
E	5/8" BASE RAIL BOLT	98010216	7	5/8"-11 X 3-1/2" HHCS GRD 5
F	CONICAL WASHER	98200171	4	5/8" EXT. TOOTH CONICAL WASHER
H	BED SPACER TUBE	27210204	4	
I	DOUBLE SLOTTED BED SHIM	27210202	4	
J	REAR BRACKET BOLT	98010195	2	1/2"-13 X 4-1/2" HHCS GRD 5
K	1/2" FLANGE NUT	98150201	4	1/2"-13 SERRATED FLANGE NUT
L	CARRIAGE BOLT	98050110	2	1/2-13 X 2" CARRIAGE BOLT GRD 5
M	5/8" FLANGE NUT	98150200	4	5/8"-11 SERRATED FLANGE NUT
N	7/16" FLANGE NUT	98150167	4	7/16"-14 SERRATED FLANGE NUT
O	U-BOLT	98050180	2	7/16"-14 U-BOLT
P	7/16" BOLT LEADER	98340199	2	7/16"-14 BOLT LEADER

### #2719 — BASE RAIL KIT

item	description	part no.	qty.	material
G	BASE RAILS	271901	2	

### LAYOUT TEMPLATE

description	part no.	qty.	material
LAYOUT BED TEMPLATE	27200000	1	ITEM SOLD SEPARATELY

# TRUCK PREPARATION

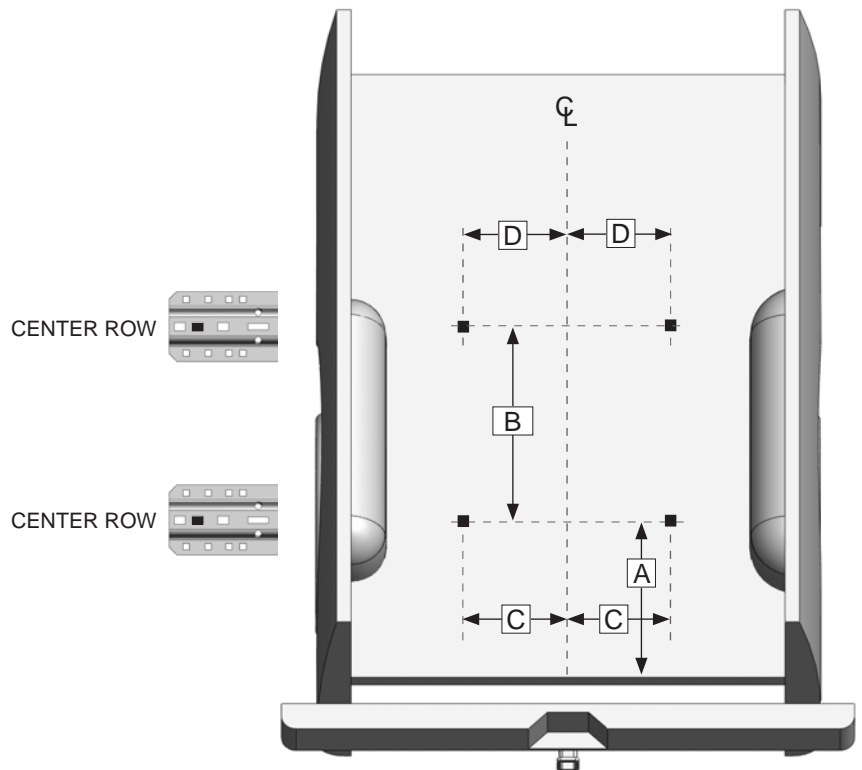
1. Block vehicle wheels. Some vehicles may require you to raise the rear of the truck to install the mounting brackets on the truck frame.
2. Remove the inner fender insert from both rear fender wells (not applicable to every model).
3. If necessary, the wheels may be removed to gain additional clearance while working, as well as the spare tire.

## MARKING THE TRUCK BED FOR DRILLING

### LAYOUT METHOD

If you purchased an installation template, please proceed to "TEMPLATE METHOD".  
*Templates are sold separately.*

1. Referencing "Truck Bed Dimension Table" below, measure and mark from the back of the bed forward, the values for "A." Do this at any point on both sides of the bed and draw a line across the bed from mark to mark.
2. Find the centerline of the bed.
3. Draw a line down the middle of the bed from front-to-rear.
4. Starting at "A," measure from the end of the bed back to the center row of bolt holes on the base rail and mark the bed (see right).
5. Measure the distance of "C" from the centerline of the bed in both directions. The center of the bolt location will be at the intersection of A & C
6. Continue working toward the cab, marking the center holes of each remaining bolt locations.

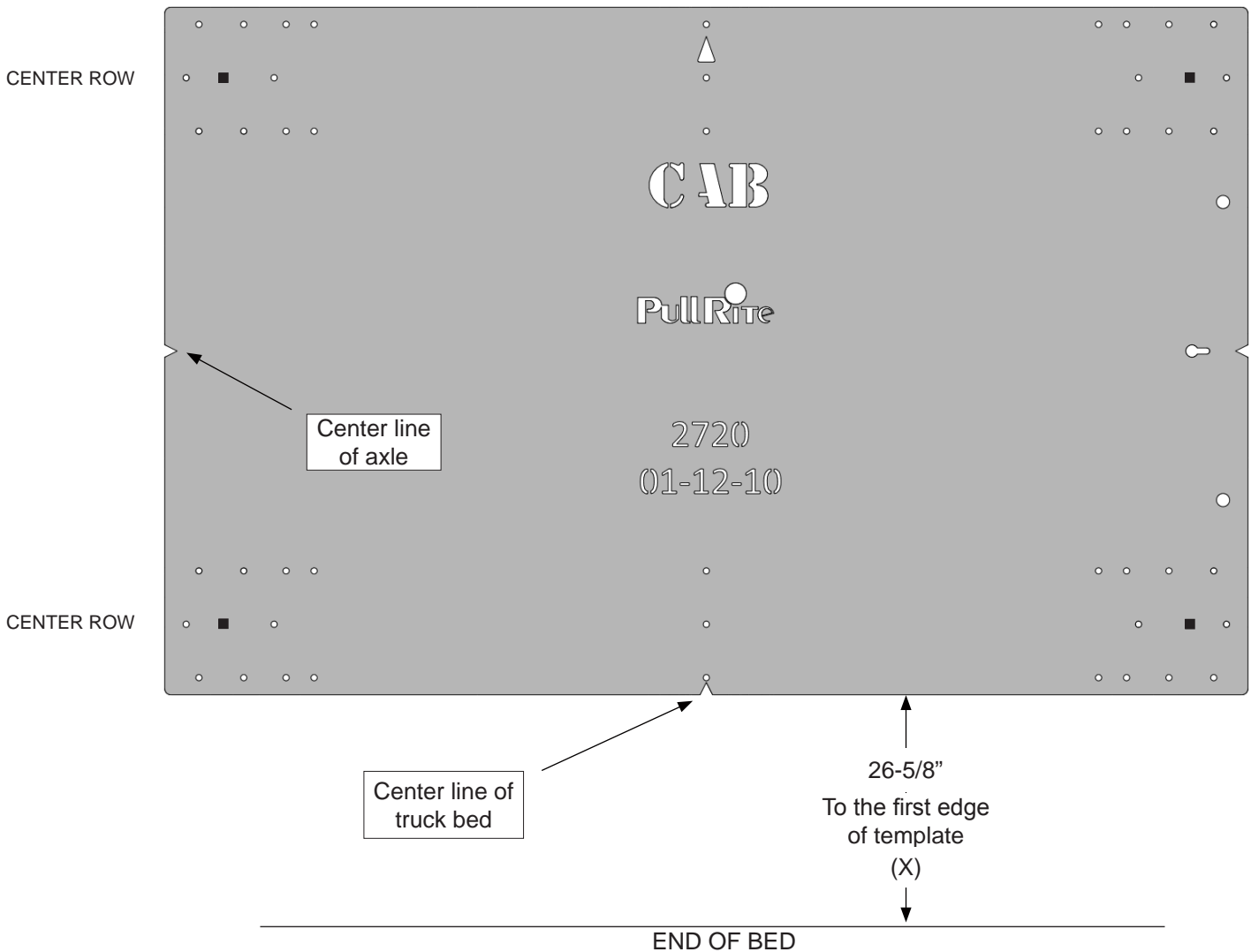


TRUCK BED DIMENSION TABLE					
LAYOUT METHOD				TEMPLATE METHOD	
"A"	"B"	"C"	"D"	"X"	Template part#
29-1/2"	22"	19-7/16"	19-7/16"	26-5/8"	27200000

## TEMPLATE METHOD

1. Lay the template in the truck bed, centering it from side-to-side, and parallel to the end of the truck bed using the dimension "X" listed in "Truck Bed Dimension Table."
2. Mark the 4 holes, while making sure the template does not move.

**INSTALLATION TIPS:** The *TEMPLATE* should be orientated as shown in the drawing below. To avoid drilling holes in error from out of tolerance bed-to-frame dimensions, mark the hole locations as lightly as possible if a center or transfer punch is used. Then use a very small diameter drill bit to drill one location on either side of bed. Place the *Mounting Brackets* against the frame to determine the correctness of the bed hole locations relative to the pre-punched holes in the *Mounting Bracket* and existing frame holes. Adjust the template pattern relative to the end of the bed, as necessary, to move the bed holes nearer the center of the mounting bracket holes. Note also, the information etched into the template — the direction of the cab, the template number and the revision date. As one last measure, the template has a tendency to move when placed on the slick paint of new truck beds, and it may be helpful to place a small piece of *NON-SKID* matting, such as "SCOOT-GARD"™ or simply use duct tape on each corner to help keep the template from moving.





# INSTALLATION

## PART 1 — BRACKET PLACEMENT & BED HOLE LOCATIONS

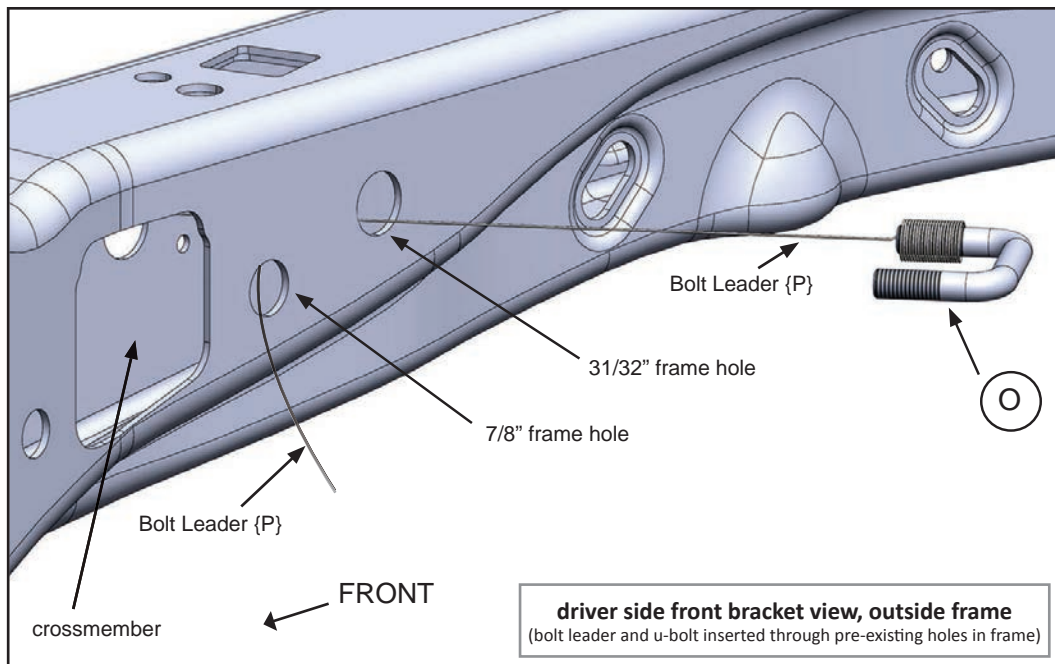
Since most truck beds are not installed square to the frame or are the same distance from the back of the cab, the installer will need to make sure the bed holes line up properly with the obround hole in the top of the mounting bracket.

The basic steps in this section are as follows:

- Layout the bed holes
- Drill the first pilot hole in the bed
- Check centering
- Adjust the bed hole layout if necessary
- Drill the second pilot hole and check centering to ensure bed hole locations are square to the frame; adjust as needed
- Drill remaining pilot holes in the bed; check centering

### FRONT MOUNTING BRACKET INSTALLATION

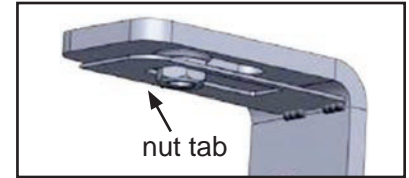
1. This is a no-drill installation, the brackets are fastened around the truck's frame, with the exception of two U-bolts that are fished through the enclosed section on each side of the truck's frame. We suggest you read completely through these installation procedures, paying close attention to the fastening methods and illustrations provided before proceeding.
2. Thread a U-bolt {O} onto the supplied Bolt Leader {P}. Prior to installing the U-bolt through the frame, thread the required Flange Nut {N} on and off the bolt to ensure the nut will install easily once the bolt is in place.
3. Create a slight "U" shape in the Bolt Leader as you will be pulling one end of the U-bolt through two holes in the outside of the frame that are located close to each other (below).
4. With the U-bolt threaded in place, pass the Bolt Leader through the 31/32" hole located on the outside of the frame and out the 7/8" hole until both ends of the U-bolt are exposed on the outside of the frame.





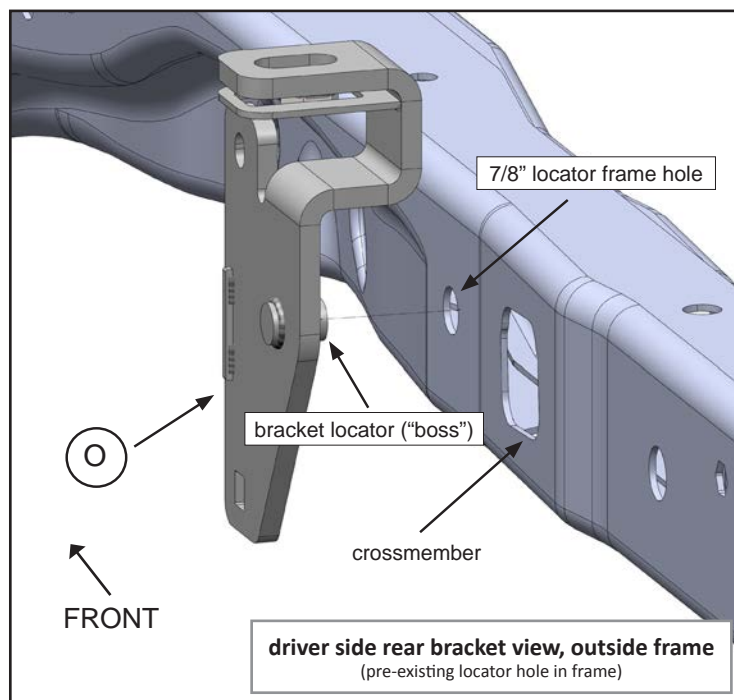
# INSTALLATION

5. Examine the Mounting Brackets and note that there is a 1/8" thick tab located just below the slotted bolt hole in the top plate of the Mounting Bracket. The purpose of this tab is to assist you in holding the Flange Nut {M} in place. To install, pry the "tab" down far enough so that a Flange Nut can be inserted, then push the "tab" back up into position. The Flange Nut should be able to slide in and out while the "tab" holds the nut in place. When fastening the Base Rails to the Mounting Brackets, the Flange Nut can easily be positioned under the square hole in the Base Rail using a pen or other small tool. When tightening the Base Rail Bolts with an impact gun, start slowly as the "tab" may otherwise "strip out." Do this for all four Mounting Brackets before proceeding.
6. While holding the threaded U-bolt in place on one end, thread the Front Mounting Bracket {B} through the Bolt Leader and onto the frame, seated properly over both ends of the U-bolt.
7. Secure the exposed end of the U-bolt with the required Flange Nut {N}. Hand tighten only.
8. Remove the Bolt Leader from the other end of the U-bolt and repeat the step above, securing the Mounting Bracket in place.
9. Repeat Steps 2-8 for the Front Passenger Side Mounting Bracket {C}.



## REAR MOUNTING BRACKET INSTALLATION

1. Locate the pre-existing rear 7/8" diameter hole in the truck's outside frame (cab forward of the rear crossmember), resting the top flange of the bracket flush on top of the frame. Lightly clamp in place.
2. Slide the Rear Mounting Clamp Bracket {A1} against the inside of the frame near the brake bracket and lines until the holes align with the holes in the Rear Mounting Bracket {A}.
3. Install the Rear Bracket Bolt bolt {J} in the top hole of the Rear Mounting Clamp Bracket and Rear Mounting Bracket and secure with a Flange Nut {K}. Hand tighten only.
4. Install the Carriage Bolt {L} into the bottom rectangle on the Rear Mounting Bracket and the bottom slot of the Clamp Bracket and secure with a Flange Nut {K}. Hand tighten only.
5. Repeat the above steps for the Rear Passenger Side Mounting Bracket {D}.



# INSTALLATION

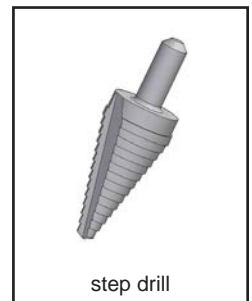
## PART 2 — BASE RAIL INSTALLATION

**WARNING:** Prior to drilling any holes, be sure to check the inside of the frame to guard against drilling into the fuel tank, wiring, brake lines or fuel module.

1. Drill the first 1/16" pilot hole through the truck bed over the obround hole in the top of the rear mounting bracket. The bit should come down center to the walls of the obround hole (fore-to-aft).

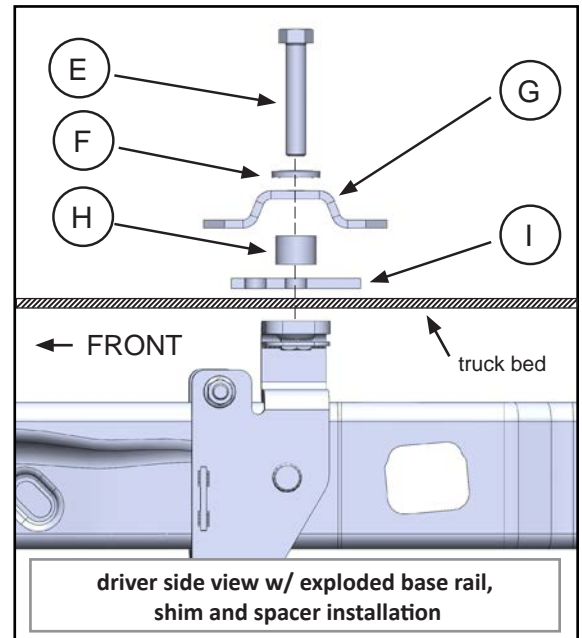
**NOTE:** Some truck beds are not installed square on their frame by the manufacturer. To ensure your pilot holes are aligned properly, it is important that you use the measurements provided only as a starting point and make adjustments as needed.

2. Once proper centering is achieved, using a step drill, increase all four truck bed pilot holes to a minimum of 3/4" diameter.
3. To prevent "crushing" of the corrugated truck bed, we provide Shims {I} and Spacers {H} to be installed above and/or below the truck bed where necessary. Not all truck beds are installed exactly the same when manufactured, so it is necessary for you to determine where to place your shims, relative to the bolt locations (see Layout Method).
4. Install the base rails and hardware as seen on the "Mounting Kit Exploded View" drawing.



## PART 3 — FINAL INSTALLATION PROCEDURES

1. Set the Industry Standard hitch on the base rails and align the hitch assembly with the mounting holes.
2. Install the hitch pins and clips, to secure the hitch assembly to the base rails.
3. Make certain the hitch comes on and off without binding prior to completing final torques.
4. Tighten all bolts, including the base rail bolts, according to the Torque Table or until the Brackets begin to bend.



### TORQUE TABLE

3/8" bolt	—	31 ft. lbs.
7/16" bolt	—	60 ft. lbs.
1/2" bolt	—	75 ft. lbs.
5/8" bolt	—	151 ft. lbs.
3/4" bolt	—	266 ft. lbs.





*MANUFACTURED BY:*  
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