



**2017 Ford F250/F350 8 Ft Bed  
Bracket Kit  
IN 629**

Product No.  
**74004      31004**  
**75004      84004**  
**31005**

5/18/18

**Hardware included shown on right.**

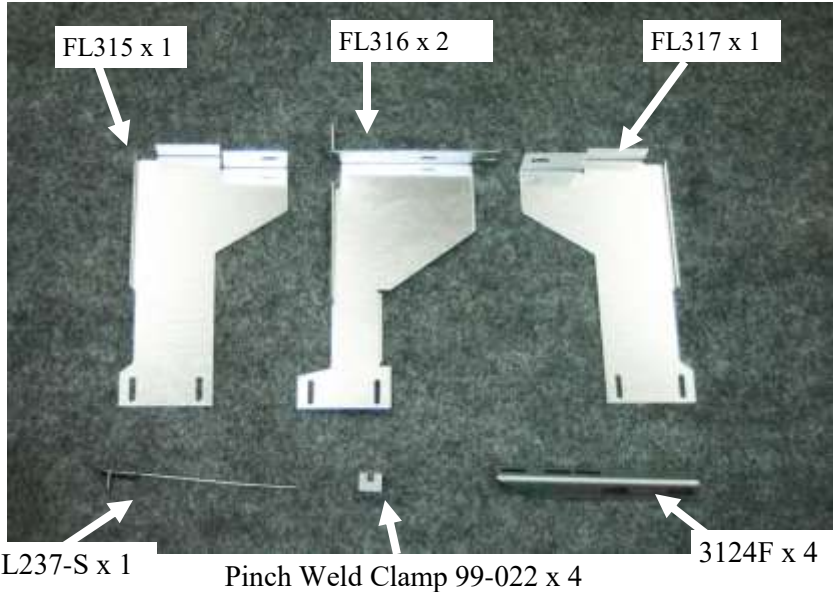
**No Drilling into Vehicle is Required**

**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.



Estimated time of  
Installation:  
35 minutes

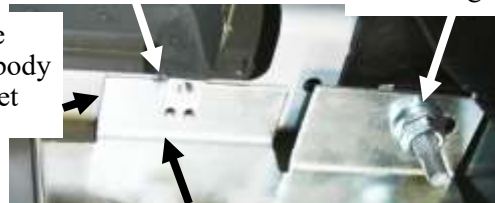


Place a strip of foam tape on the top of the FL315 and FL317 bracket as shown in photo above, this will insulate the steel bracket from the aluminum body to avoid corrosion.

Pinch Weld Clamp 99-022

M14 Flange Nut

Foam tape  
Between body  
and bracket

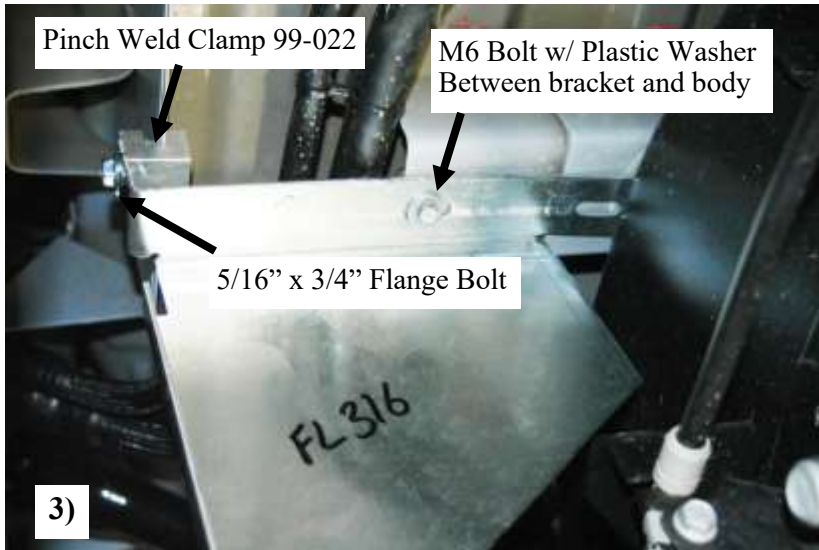


Set Screws use 1/8" Allen wrench



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.**

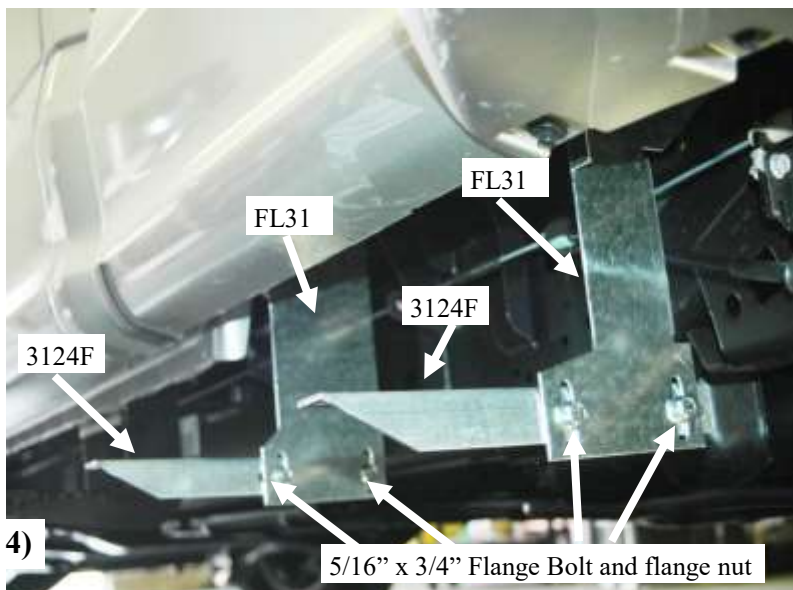


Remove the M6 bolt holding the fuel filler neck hose clamp. Then place a 99-022 pinch weld clamp up onto the pinch weld as shown above, tighten the set screws so that the 99-022 is centered with the second bed cross brace. Put the M6 bolt from the hardware pack through a flat washer and up through the 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.**

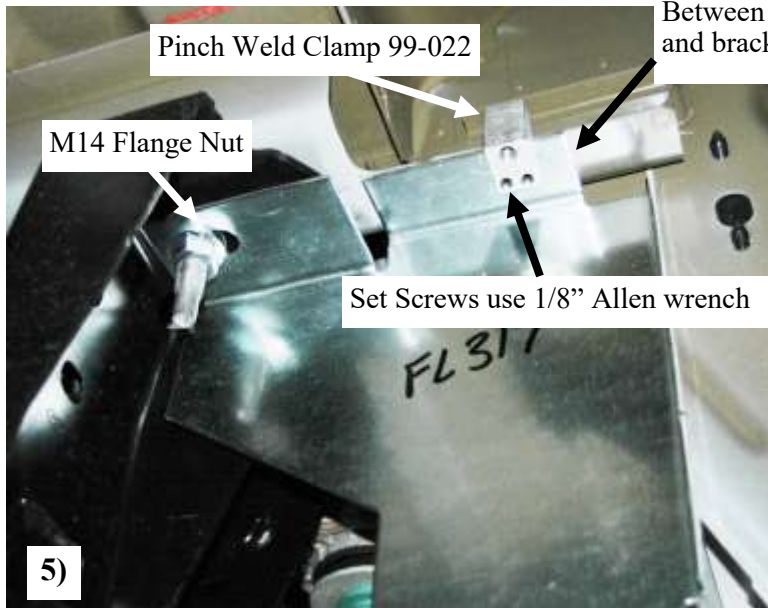
**The use of Loctite on all set screws is highly recommended to insure they do not loosen up.**

**Make sure set screws are as tight as possible.**



Mount the 3124F angles to the FL315 and 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.

**The use of Loctite on all set screws is highly recommended to insure they do not loosen up.**

**Make sure set screws are as tight as possible.**

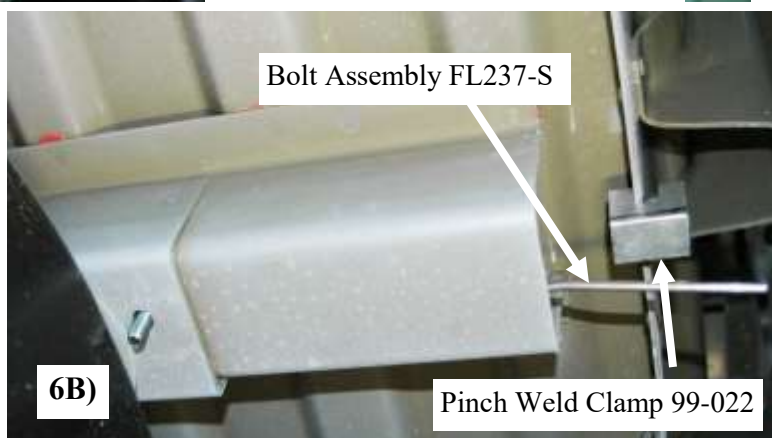


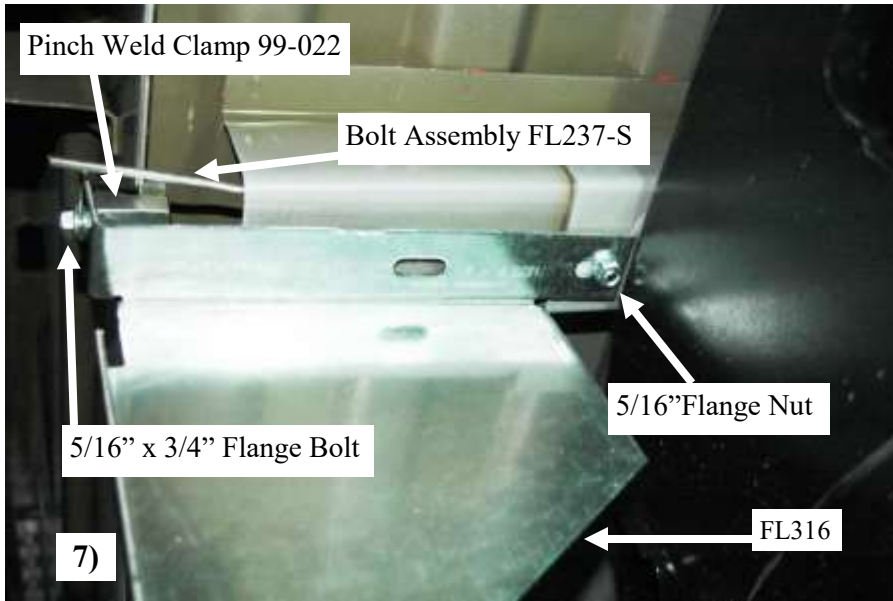
Like on the driver side on the second cross brace mount a 99-022 pinch weld clamp up onto the pinch weld, tighten the set screws so that the 99-022 is centered with the cross brace. Then slide the bolt assembly FL237-S with a plastic washer on threads to insulate the aluminum body to the steel of the 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

**The use of Loctite on all set screws is highly recommended to insure they do not loosen up.**

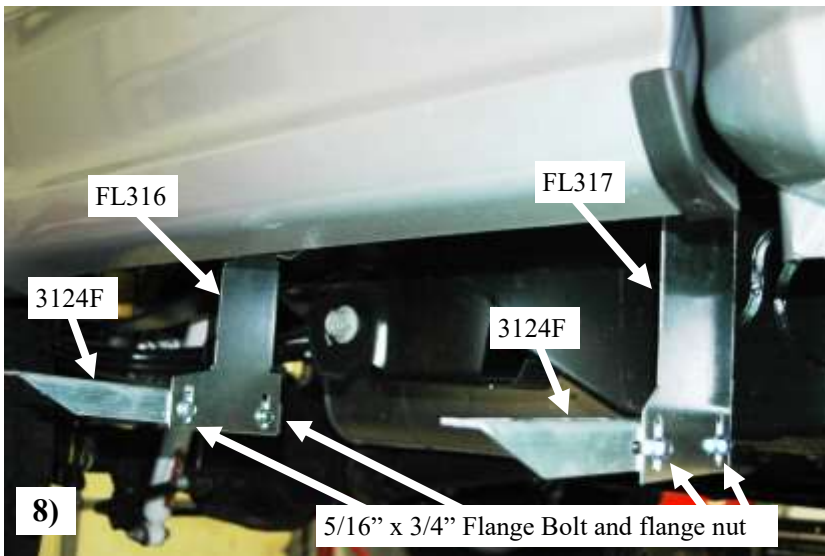
**Make sure set screws are as tight as possible.**





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.

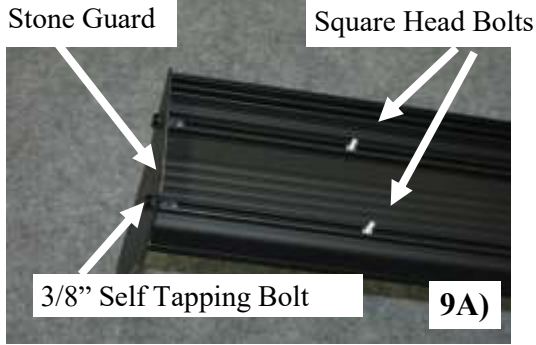
**Fig 7**



Mount the 3124F angles to the FL317 and 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 so that the boards on the bed are level with the cab boards and tighten all bolts completely.**

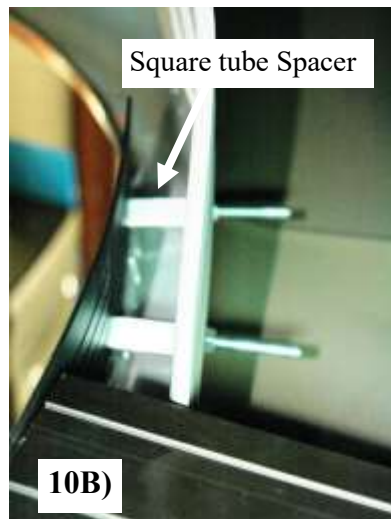
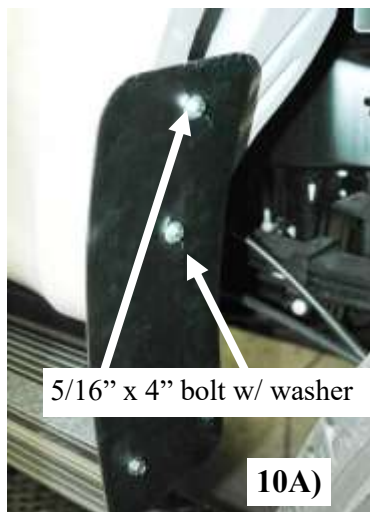


**For Aluminum Boards**

Slide square head bolt into both the front track and rear track for each bracket location. After sliding all bolts into track mount the front stone guard onto board using two 3/8" self tapping bolts into tracks that the square head bolts were inserted into. Make sure the tread tape is facing inward to match on board.



Mount the end cap onto board using two 3/8" self tapping bolts into tracks that the square head bolts were inserted into. Make sure the tread tape is facing inward to match on board.



Once the board is tight and all bolts on bracket are tight. Reach in on inside of truck wheel well in photo 10C and mark through the two lower slots onto the aluminum stone guard. Remove the stone guard from board and drill 5/16" hole stone guard for the 5/16" x 4" bolts to fit through. Reinstall stone guard to board. Place 5/16" x 4" bolt through a flat washer, 10A and as inserting bolt place the square tube in position so threads go through the center of tube and through the truck slot see photo 10B Install a plastic washer on to threads then secure with 5/16" flange nut in both locations shown in photo 10C



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### For Fiberglass

Using self drilling screws attach the board to the angle brackets making sure you are drilling into steel mounting pads. Level board and tighten any remaining loose bolts at this time.



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