

**INSTALLATION INSTRUCTIONS FOR MOUNTING  
STAKE POCKET BED RAILS – MODEL #'s 510020, 510030, 510040,510100**

**TRUCK MODELS:**

- 510020** 99-07 GM CLASSIC 6.5' BOX
- 510020** 2002 DODGE 1500 SHORT BOX
- 510030** 1997 FORD F-150 SHORT BOX
- 510030** 1999 FORD F-250, F-350 SHORT BOX
- 510040** 04-07 GM CLASSIC 5.8' BOX
- 510100** 2009+ DODGE 1500 5.7' BOX
- 510100** 2009+ FORD F-150 5.5' BOX

1. READ THE INSTRUCTIONS COMPLETELY AND CHECK TO MAKE SURE THAT ALL OF THE REQUIRED PARTS ARE ON HAND BEFORE STARTING THE INSTALLATION.
2. IF THE TRUCK HAS PLASTIC BED CAPS IT WILL BE NECESSARY TO CUT THESE OUT SO THAT THE STAKE POCKETS ARE ACCESSIBLE. BE CAREFUL NO TO CUT THE OPENING ANY LARGER THAN THE BLACK PLASTIC PLATE WILL COVER.
3. PREASSEMBLE MULTI THREAD U-NUT (ITEM #4) TO THE SMALL GALV. PLATE (ITEM #3) AS SHOWN IN FIGURE #1. REPEAT FOR ALL 4 PLATES.
4. ASSEMBLE THE BED RAIL ASSEMBLY:
  - A. INSERT THE 5/16-18 X 2-1/2" SST BUTTON HEAD SCREW (ITEM #5) THROUGH ACCESS HOLE AND ATTACH TO THE BED RAIL (ITEM #1) THROUGH THE WELD PLATE.
  - B. SLIDE THE PLASTIC PLATE (ITEM #2) OVER THE 5/16" SCREW (ITEM #5), AND ATTACH THE NUT PLATE ASSEMBLY (ITEM #3,4) TO THE BOLT SO THAT THE THREADS ARE JUST TO THE BOTTOM END OF THE U-NUT.
5. PLACE THE BED RAIL ASSEMBLY OVER THE STAKE POCKETS AND CAREFULLY WORK THE NUT PLATE ASSEMBLY INTO THE STAKE POCKETS.
6. USING A 3/16" ALLEN HEAD WRENCH, TIGHTEN DOWN THE BED RAIL TO THE TOP OF THE BED. MAKE SURE THAT THE PLASTIC SPACER COVERS BOTH STAKE POCKETS.
7. INSERT THE 9/16" DIA HOLE PLUG (ITEM #6) INTO BED RAIL ASSEMBLY.
8. REPEAT FOR OPPOSITE SIDE.

ITEM	PART #	QTY	DESCRIPTION
1	510022	2	TUBE WLDMT 72.19" #510020
1	510032	2	TUBE WLDMT 75.69" #510030
1	510042	2	TUBE WLDMT 62.69" #510040
1	510102	2	TUBE WLDMT 61.50" #510100
2	104845	4	SPACER-PLASTIC 2.25 X 3.50
3	510075	4	PLATE-MTG, GALV. SMALL, BED RAIL
4	105541	4	MULTI THREAD U-NUT 5/16-18
5	104837	4	5/16-18 X 2-1/2" SST BTN HD SCREW
6	104844	6	PLUG, BPF 9/16, BLACK LDPE

MODEL NO.
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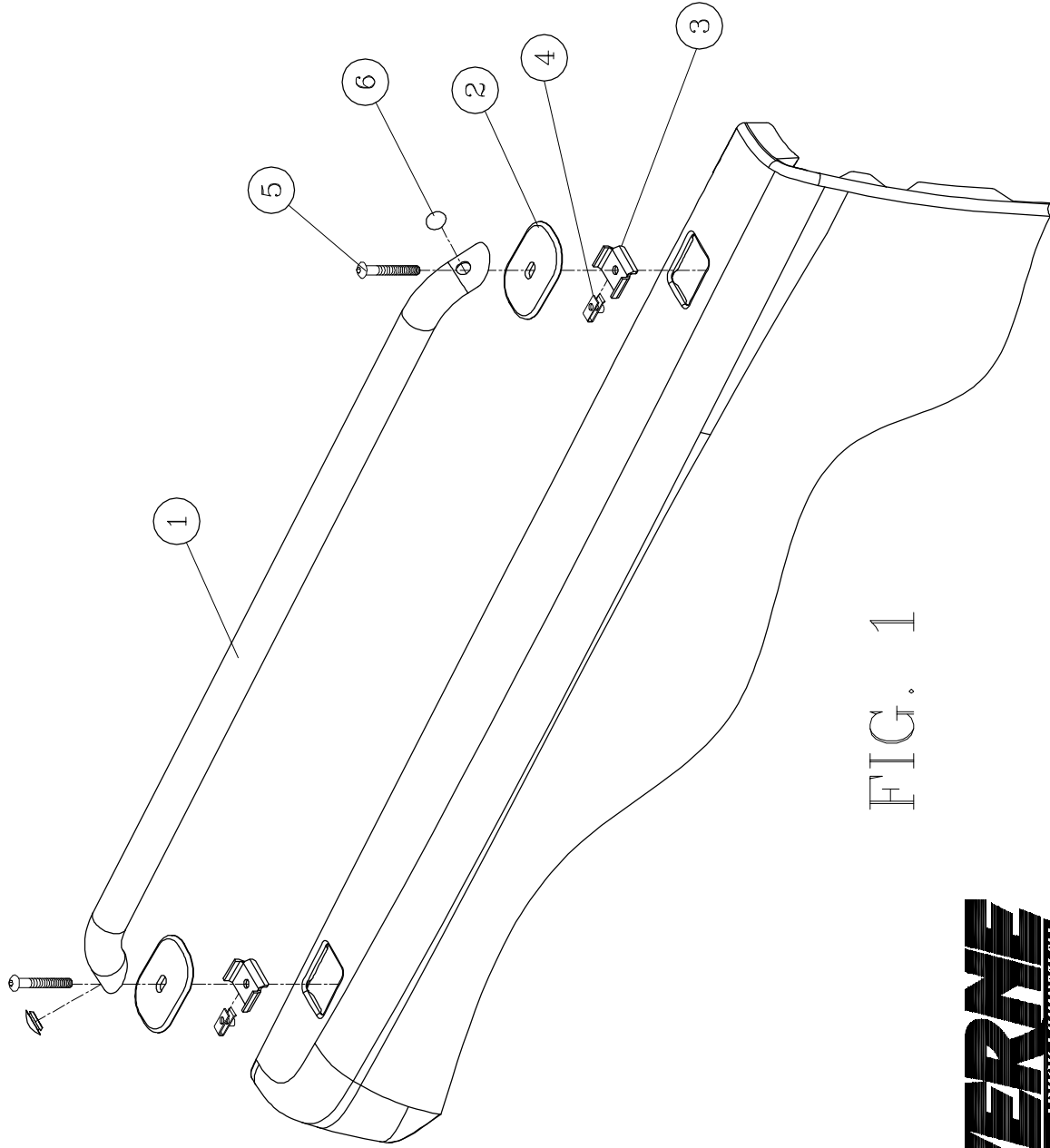


FIG. 1

**LAVERNE**  
 TRUCK EQUIPMENT  
 (A LUYERNE Company)

1200 E. Birch St.  
 Brandon, SD 57005

REV. D 09JAN13  
 REV. C 27OCT06  
 REV. B 26FEB04  
 REV. A 14JUN02  
 510029 SHEET 2 OF 2 21JAN02