



Installation Instructions

G9003/G9005 Gooseneck Ball Mount Frame Mounting Kit No. 09001023

For use with FORD F-250, F-350, Super Duty, Long & Short Bed Pickup Trucks; models 1999-2005

WARNING!

Most trucks have fuel lines, brake lines, and/or electrical wires located along the frame rails where the bolt-on frame mounting kit is installed. Carefully examine the location of the fuel lines, brake lines and electrical wires before installation. **Be certain that you will not damage fuel lines, brake lines or electrical wiring** when positioning the mounting frame or coupling device, drilling holes, tightening fasteners and raising/lowering the truck bed.

Read this entire instruction booklet **prior** to proceeding with installation. Read the G9003/G9005 gooseneck ball mount hitch instruction booklet **prior** to proceeding with installation of this kit.

This mounting kit is rated for a **Maximum Gross Trailer Weight (M.G.T.W.) of 15,000 lbs.** and a **Maximum Vertical Load Capacity of 5,000 lbs.** However, note that the G9003/G9005 Gooseneck Ball Mount Hitch is rated for a Maximum Trailer Rating of 25,000 lbs. M.G.T.W. Therefore, the rating of this Frame Mount Kit supersedes the Maximum Load Rating of the G9003/G9005 folding ball hitch. **Do not overload this mounting kit.**

Verify the Truck Gross Vehicle Weight Rating (G.V.W.R.)

before installation of this mounting kit. **Do not overload your tow vehicle.**

The gooseneck ball must be positioned to allow **adequate clearance** between the gooseneck trailer and the rear corners of the truck bumper. Adequate clearance between the gooseneck trailer and the rear of the truck cab must be provided. The preceding clearances should be checked with the trailer center axis 90° to the truck center axis. After installation of this kit, the centerline of the installed gooseneck ball should lie approximately 4-1/2" forward of the centerline of the truck rear axle.

The installed gooseneck ball must be located in the center of the truck body. The center of the ball must be located forward of the centerline of the rear axle at a distance not to exceed 6".

Follow all tow vehicle and gooseneck trailer manufacturer installation procedures, recommendations and warning before proceeding with installation of this Frame Mount Kit or the G9003/G9005 Folding Ball Hitch.

Periodically **retorque all hitch fasteners.** Check ball, safety chains and other connections **every time you tow a trailer.**

READ ALL STEPS THOROUGHLY BEFORE BEGINNING WORK

1. Remove the heat shield located above the rear axle under the truck bed. The heat shield is attached with four hex head sheet metal screws. Replace die front screws after removing the heat shield.

2. Select the rear cross member (item 2). The rear cross member has only two predrilled mounting holes cut into the 2" leg of the angle and has the deepest notches. With the centerline of the two mounting holes oriented vertically and installed *as shown in Fig. 1*, position it across the top of the frame rails between the bed and the frame of the truck. This can be accomplished by pushing it through the opening in the wheel well on the driver's side of the vehicle. After the cross member is across the frame rails, move it towards the

rear of the truck and up onto the top of the truck frame rails. If required, loosen the truck bed mounting bolts to slide the cross member towards the rear of the truck. Carefully select a safe method of holding the truck bed in an elevated position while installing this kit.

3. Position the front cross member (item 1) in the same manner with the six predrilled holes flush against the bottom of the truck bed and oriented *as shown in Fig. 1*.

4. Insert one 5/16" carriage bolt into the square hole in the driver's side mounting plate with the thread end facing away from the truck. Insert one 3/4"-10 x 2-1/2" Gr. 5 cap screw and one USS flat washer with the head and the washer on the inside of the truck frame. Insert this bolt through the 3/4" x 1-1/4" horizontally-oriented slotted hole in the truck frame

member. With this cap screw already installed, slide one 2" square washer plate (item 11) onto the threaded portion of the screw. Install the driver's side mounting plate onto the cap screw through the center .81" OD hole. Place one USS flat washer, one 3/4" split lock washer, and one 3/4"-10 hex nut Gr 5 onto the threads and hand tighten.

5. Position the front and rear angle iron cross members and align with the outside of the formed ears of the side mounting plates. Insert one 1/2"-13 x 1-1/2" cap screw Gr 8 and one 1/2" USS flat washer through each slot in the side mounting plate and the corresponding slot in the angle iron cross members. A total of two 1/2"-13 x 1-1/2" cap screws Gr 8 are required for mounting both the front and rear cross members to the driver's side mounting plate. Install one 1/2" USS flat washer, one 1/2" split lock washer and one 1/2"-13 hex nut Gr 8 onto each of the threaded ends of the cap screws and hand tighten.

6. Insert one 3/4"-10 x 2-1/2" Gr. 5 cap screw and 3/4" USS flat washer through the 3" x 5" frame spacer plate (item 12), and install from the inside of the truck frame member through the 1-1/4" x 2" vertically oriented slotted hole and the corresponding rear slot in the side mounting plate. Orient the frame spacer plate vertically in the truck frame member. Install one 3/4" USS flat washer, one 3/4" split lock washer and one 3/4"-10 hex nut Gr 5 onto the threaded end of the cap screw and hand tighten.

7. Place the emergency brake cable bracket over the threaded portion of the 5/16" carriage bolt. Secure the bracket with a 5/16" USS flat washer, 5/16" lock washer and nut. Tighten to a torque of 20 ft-lbs.

8. Install passenger side mounting plate and hardware in the same manner as detailed in Step #4-#6.

9. Verify that the mid-point between both front and rear cross members is located no more than 4-1/2" forward of the centerline of the rear truck axle. Then hand tighten the fasteners.

10. If it was necessary to raise the truck bed, it is now time to lower it back into its original position. Be sure not to move the position of the cross members. **Make sure to replace all of the truck bed mounting hardware and torque to recommended settings.**

11. From the underside of the truck, locate the four G9003/G9005 folding ball hitch mounting holes on the horizontal side of the cross members (two holes per cross member). These four holes correspond to the holes marked "A" on the cutting template included with this kit. Using a 1/8" bit, drill one hole through the truck bed at the centerline of each of the four cross member mounting holes. Be sure to drill each

1/8" hole at center of each predrilled holes in the cross member.

12. From inside the truck bed, locate the 1/8" pilot holes drilled in Step 11. Place the cutting template so that the pilot holes drilled are at the centerline of the corresponding template holes (marked "A" on template). Temporarily attach the template to the truck bed, using adhesive tape. Verify that the template is properly positioned to allow the centerline of the gooseneck ball to be located at the center of the truck bed. **Be sure that the template is lined up with the appropriate holes! Template must be parallel with the truck cab!**

13. From under the vehicle, verify that the area between the front and rear cross members does not contact any fuel lines, brake lines, electrical wiring, or objects that will get damaged when this area of the truck bed is removed to allow for the G9003/G9005 Folding Ball Hitch to set into the truck bed.

14. From inside the truck bed and using the template, drill four 1/8" pilot holes at the centerline of the holes marked "B" on the cutting template. Remove the template once this is complete. In the next step the area within the four pilot holes (marked "B" on the cutting template) will be removed to allow installation of the folding ball hitch.

15. Using a saber saw, cut a hole in the truck bed by connecting the 1/8" pilot holes (marked "B" on the cutting template). **Be sure that there are no obstructions under the bed of the truck that can be damaged by cutting.**

16. Using a 1-3/4" hole saw, enlarge the mounting holes (marked "A") already drilled in the truck bed. Be sure to only cut through the truck bed. Do not cut into or through the front or rear cross members.

17. From inside of the bed, place the G9003/G9005 Gooseneck Ball Mount into the large hole (marked "C" on template). **(Be sure the front of the G9003/G9005 is towards the truck cab).** The enclosed 7/8" SAE and 5/8" USS flat washers are used as spacers between the cross members and the bottom surface of the G9003/G9005. These spacers allow the G9003/G9005 to be mounted flush with the truck bed. Place one (or two, if required) 5/8" USS flat washer on top of both cross members over each of the four G9003/G9005 mounting holes. Place one 7/8" SAE flat washer on top of each 5/8" USS flat washer. Place the G9003/G9005 through the large cut-out hole in the truck bed and set on top of the washers. Note the 7/8" SAE flat washer has a larger hole inside diameter to allow for the flush mount of the carriage bolt. Using four 5/8" x 2-1/2" G5 carriage bolts (supplied with the G9003/G9005), secure the G9003/G9005 through the truck bed and the front and rear cross members. From the underside of the truck, install four 5/8" heavy-duty lock washers (supplied with this Frame Mounting Kit), four 5/8"

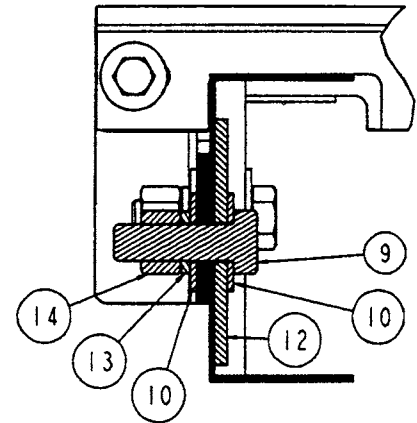
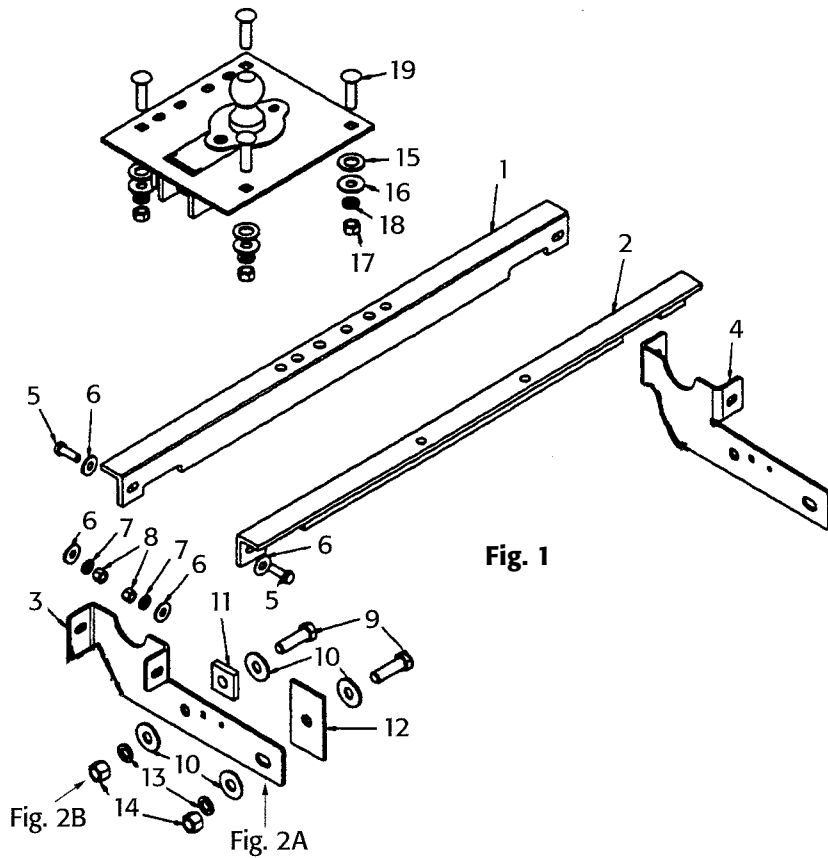


Fig. 2A

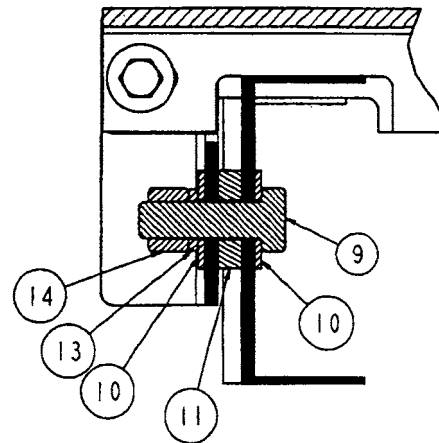


Fig. 2B

Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3007219	1	Front Cross Member
2	3000095	1	Rear Cross Member
3	3007289	1	Driver's Side Mounting Plate
4	3007288	1	Passenger's Side Mounting Plate
5	-	4	1/2"-13 x 1-1/2" Cap Screw G8
6	-	8	1/2" USS Flat Washer
7	-	4	1/2" Split Lock Washer
8	-	4	1/2"-13 Hex Nut G8
9	-	4	3/4"-10 x 2-1/2" Cap Screw G5
10	-	8	3/4" USS Flat Washer
11	3000096	2	2" x 2" Washer Plate
12	3000097	2	3" x 5" Frame Spacer Plate
13	-	4	3/4" Split Lock Washer
14	-	4	3/4"-10 Hex Nut G5
15	-	4	7/8" SAE Flat Washer
16	-	8	5/8" USS Flat Washer
17	-	n/i	5/8" Hex Nut G5
18	-	n/i	5/8" Heavy-Duty Split Lock Washer
19	-	n/i	5/8" x 2-1/2" Carriage Bolt

* n/i = not included in Mount Kit. Parts included in G9003/G9005 Kit.

G5 hex nuts to the 5/8" bolts; one of each per bolt. **Hand tighten the hardware only.** Reference Figs 2A & 2B for clarification.

18. After the G9003/G9005 cross members and mounting plates are installed, tighten the fasteners in the following sequence: First, tighten the four 5/8" carriage bolts that mount the G9003/G9005 to the cross members to a torque of 110 ft-lbs. Second, tighten the cross members to the side mounting plates to a torque of 60 ft-lbs. Third, tighten the mounting plates to the frame rails as follows: 1/2" hardware, 150 ft-lbs.; 3/4" hardware, 290 ft-lbs.

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19. To install the Safety Chain Mounting Kit (part no. BRB03 not included), it is necessary to drill four 3/4" holes through the truck bed floor. Review and follow the Installation Instructions for part no. BRB03 prior to installation of the Safety Chain Mounting Kit. Locate the four safety chain kit holes (marked "D" on the cutting template) in the front cross member. From inside the truck bed drill one hole in truck bed, in the center of each of the four mounting holes ("D"). From inside the truck bed, install the two U-Bolts, as shown in Fig. 3. From the underside of the truck, install four 5/8" SAE flat washers, four compression springs and two 5/8" center locking jam nut. Tighten all four 5/8" jam nuts until two full bolt threads protrude below the jam nut. **Make certain the U-bolts pass through the G9003/G9005, truck bed and the front cross member.**

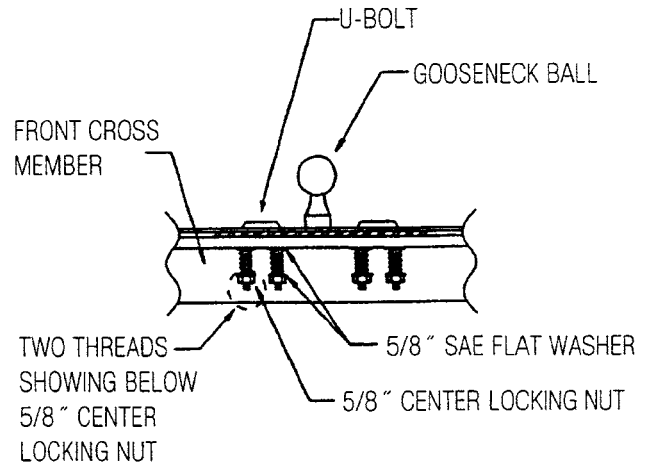


Fig. 3
 Installation of Safety Chain U-Bolts

WARRANTY

Buyers Products Co. warrants all truck/trailer hardware manufactured or distributed by it, to be free from defects in material and workmanship for a period of one year from date of shipment. Parts must be properly installed and used under normal conditions. Any product which has been altered, including modification, misuse, accident or lack of maintenance will not be considered under warranty. Normal wear is excluded. The sole responsibility of Buyers Products Co. under this warranty is limited to repairing or replacing any part or parts which are returned, prepaid, and are found to be defective by Buyers Products Co. Authorization from Buyers Products Co. must be obtained before returning any part. No charges for transportation or labor performed on Buyers' products will be allowed under this warranty.