



Factory Five Racing, Inc.

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<input type="radio"/> Bill of Material	<input type="radio"/> Drawing (may be attached)	<input type="radio"/> Specification	
<input checked="" type="radio"/> <b>Assembly Instructions</b>	<input type="radio"/> Operating Procedure	<input type="radio"/> Other	

# Aluminum Bed kit

## Installation instructions



✂  $5/32$ " , 2.5mm Hex keys,  $5/16$ " nut driver, Square, tape measure, Drill, Small flat head screwdriver, #2 Philips head screwdriver, razor knife,

👉 The stainless-steel bed floor is not used with the aluminum bed kit.

👉 Do not use lock-tite on the bolts until the truck has had a few miles driven on it. It is a lot easier to access the back if the bolts are easy to remove.

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## Bed sides



👉 The truck bed will end up roughly 0.50” behind the cab with an even gap.



👉 The bed sides should be flush with the bottom of the cab.



Place the bed front on the frame behind the cab and clamp the bed sides to the frame.

With a friend, measure from side to side of the cab and put a mark over the bed front. Measure from side to side on the bed front and put a mark on the top edge of the panel. Align the marks on the Cab and bed front.



Clamp the rear panel on the inside of the side panels so that the back panel touches the back of the frame. This will also set the front to back location of the bed.



At the front of the side panel, it may be necessary to trim the upper flange and lower cut corner more so that the panel becomes tight with the bed front.



At the rear of the side panel, it may be necessary to trim the flange location shown as well as the corresponding flange on the rear panel to get the correct width.

- 👉 The side panels should be able to touch the frame mounts in the middle of the bed. This is also the same width as the mounting rails for the aluminum planks and the finished bed width.



Use a tape measure diagonally between the corners to square up the bed.

## Fuel filler

- ✂ 8mm deep socket, ratchet, 2.5mm hex key, razor knife, #2 Philips head screwdriver
- ⇒ Fuel filler assembly, Floor board with hole.

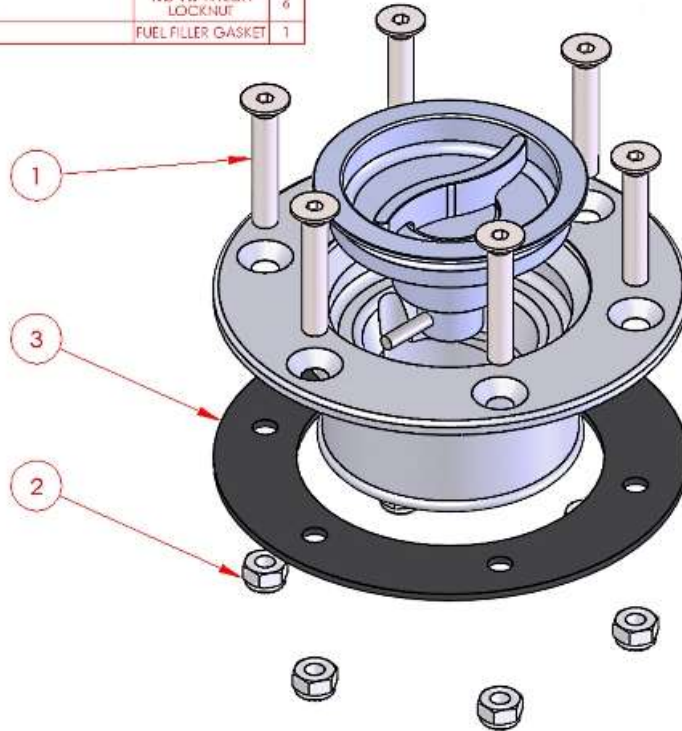


Looking through the hole in the floor board from the back side, use a razor to put a slice into each of the holes.



From the top side, use a Philips head screwdriver to open up the slices.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	B18.3.5M - 5 x 0.8 x 50 Socket FCH5 -- 30N		6
2	M5 NYLON LOCKNUT	M5-1.0 NYLON LOCKNUT	6
3	34143	FUEL FILLER GASKET	1



Put the gasket followed by the fuel filler cap onto the floorboard.

👉 The ground strap is to prevent any static electric build-up in the filler which is important when filling the tank.

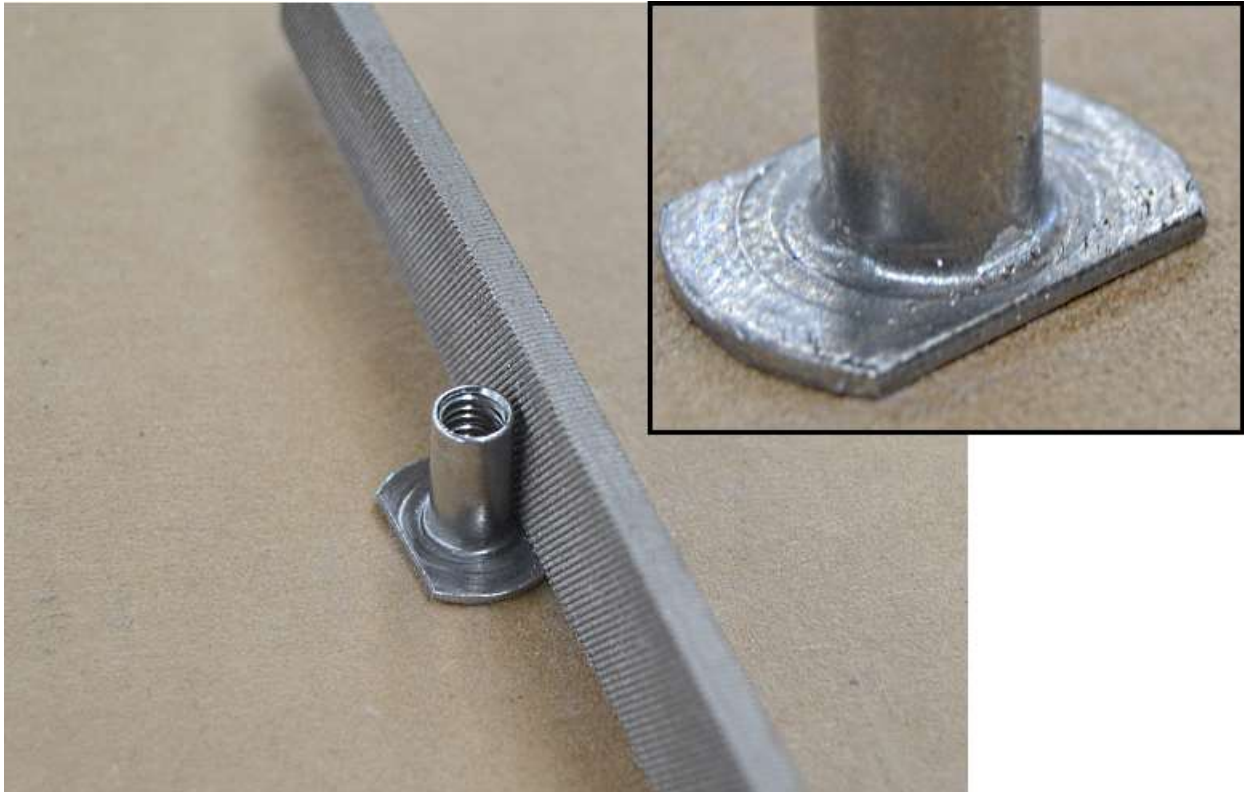
Put the ground strap on the bottom side of the floor board followed by a locknut.



The ground strap should get attached to the frame after the bed installation.  
After bed install, sand the area for the grounding strap and attach the tank to the frame using the #14 x 1/2" fastener.

## Under Floor Support prep

- ☞ Under floor supports, T-nuts
- ✂ Small flat head screwdriver, Flat file



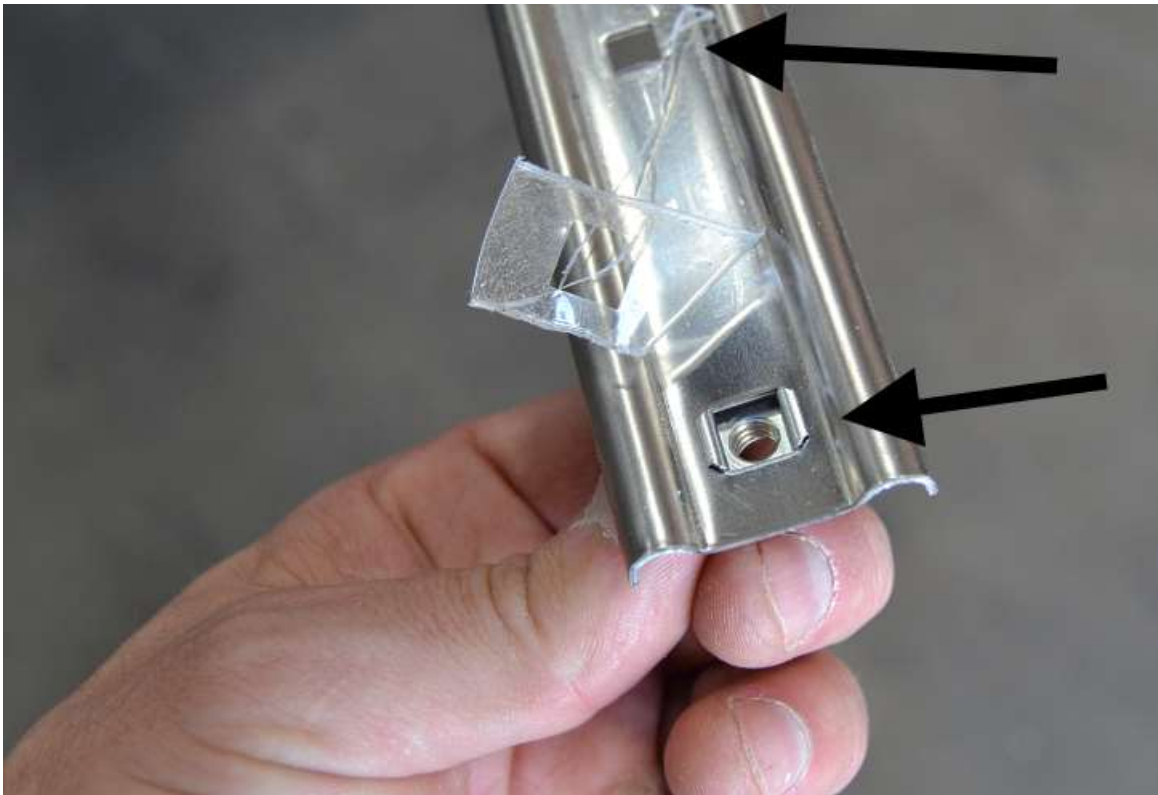
If a T-nut is hard to insert, use a flat file on the radius edge as shown to slightly flatten the radius and allow the nut to slide easily.



Slide five of the T-nuts into the double notched slot on each of the Under Floor Supports using a small flat head screwdriver against the base of the nut.

## Bed Strip prep

⇄ Bed strips, captured nuts



Locate the end of the Bed Strips with the two holes close to each other then squeeze the sides of a captured nut and insert it from the bottom up into the end hole so that the ears hold the nut in place.

👉 If it is hard to squeeze, use a pair of adjustable pliers to get the ears in enough to pop into place.

Repeat for the remaining Bed Strips.

## Under Floor Support install

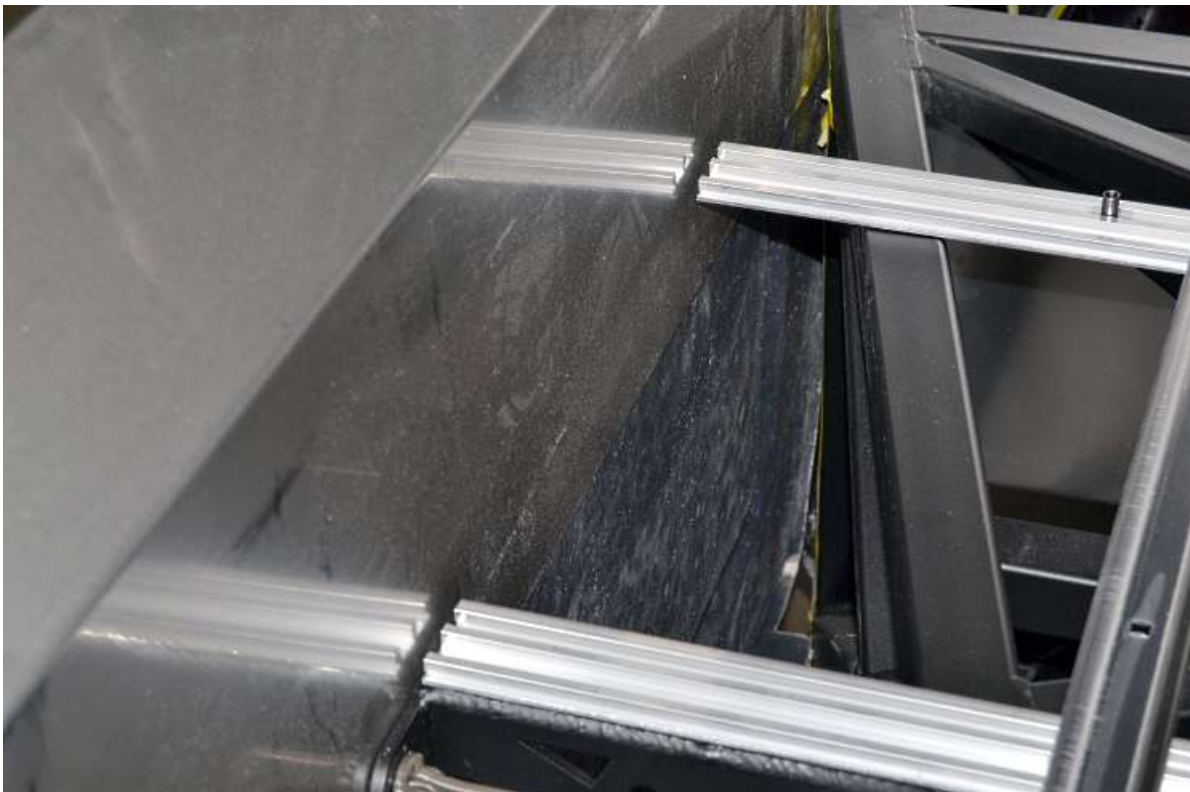
🔩 Long button head screws

🔩  $\frac{5}{32}$ " hex key, Square, small flathead screwdriver

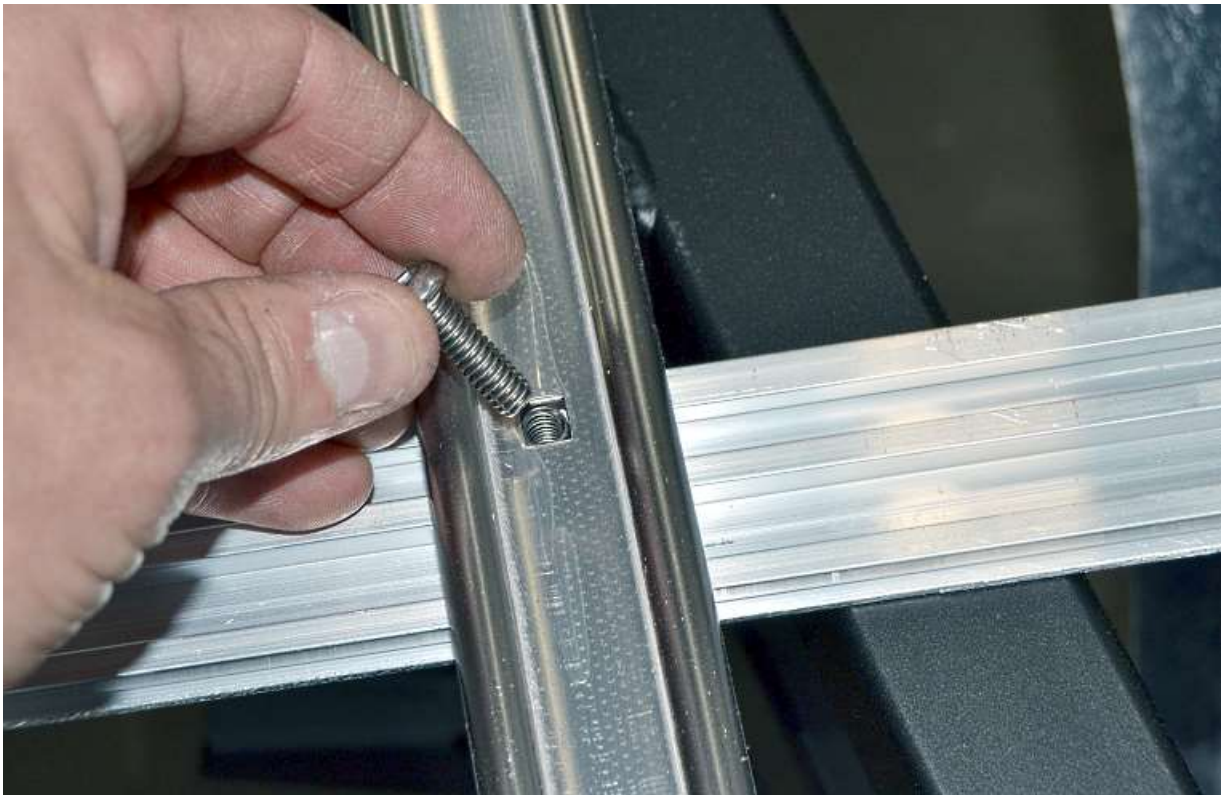


Lay the five Under Floor Supports across the frame and lay two of the Bed Strips front to back on the frame to get the location of the supports.

Use a small flathead screwdriver to spread the T-nuts out roughly a foot apart.



The Under Floor Supports should touch or be very close to the bed sides. If not these can be adjusted later after the bed dry fit. For now, butt the Supports against the left side.



Insert the longer button head screws through the square holes in the bed strips into the T-nuts. Do not tighten the screws, just screw in a few threads.



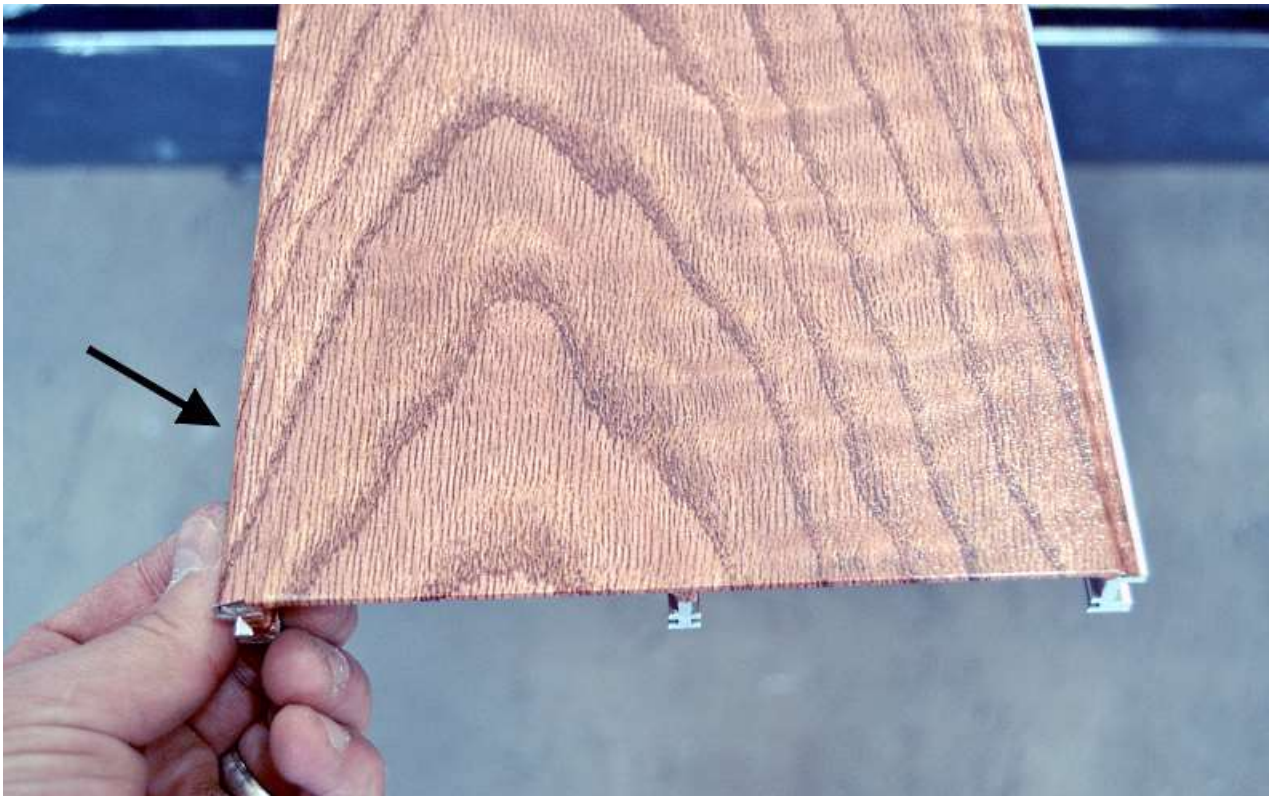
Use a square against the Bed front to roughly square the bed strip up.

Remove the two Bed Strips.

## Floor Board Dry Fit

🪵 Floor boards, Screws

🔧  $\frac{5}{32}$ " Hex key, small flathead screwdriver



There are two boards with a rounded edge as pictured above. These rounded edges will go against the bed sides, the fuel filler one on the right side.



Starting on the left side, lay the rounded edge board on the Floor supports making sure there are no T-Nuts underneath and against the bed side.



Slide the last T-nut about  $\frac{3}{4}$ " over from the edge of the board.



Lay another board down and use a Bed Strip to space it so the Bed Strip will fit into the edge grooves.

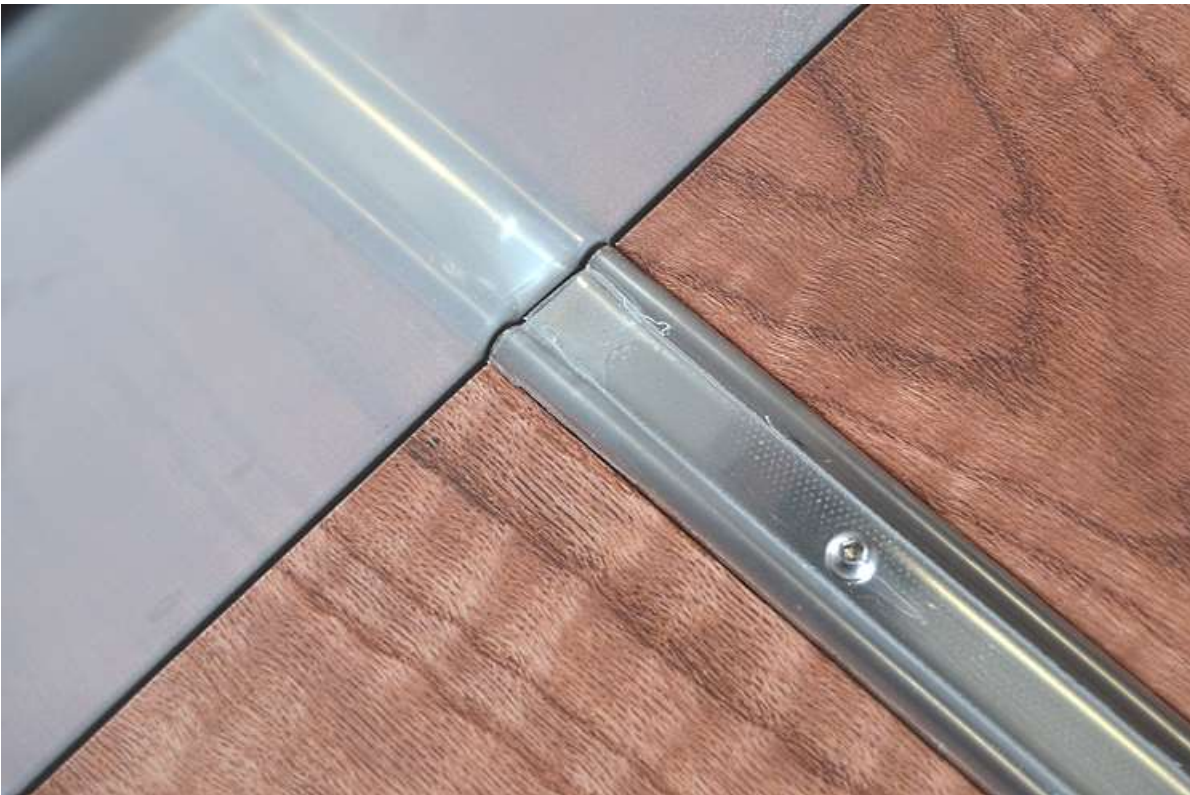


Thread the long button head screws into T-nuts a few turns.





Repeat the process for another board.

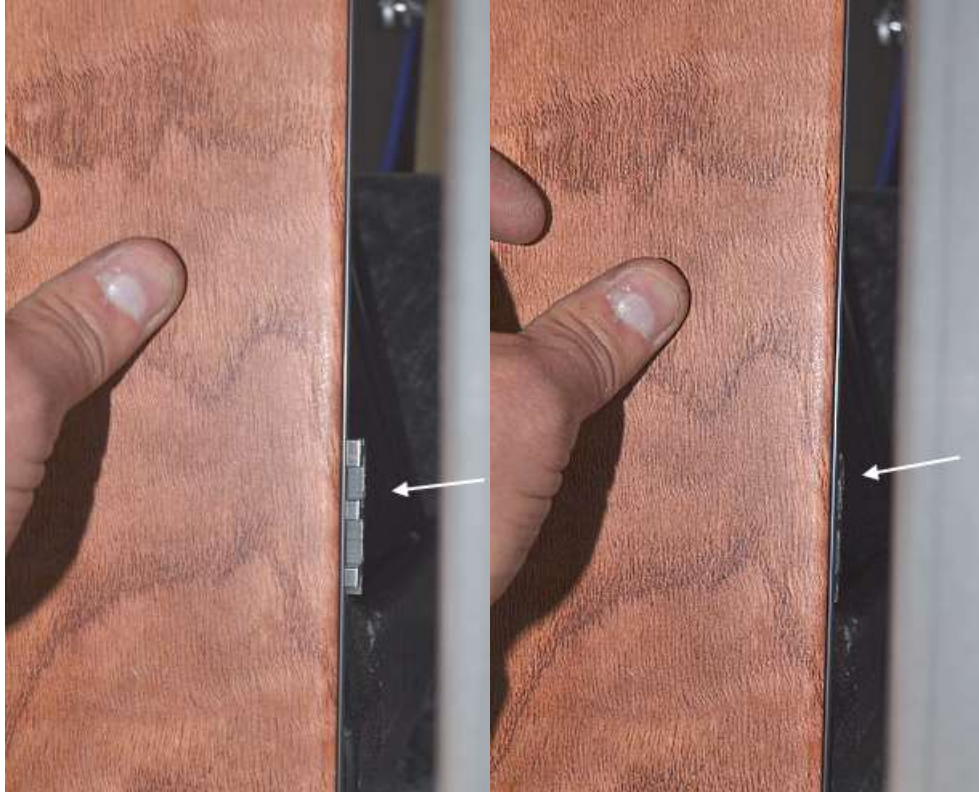


At the front of the bed make sure that the bed strips are even with the edge of the boards.

Use a square to double check that the boards are square to the bed front. This will also double check the bed sides are square.



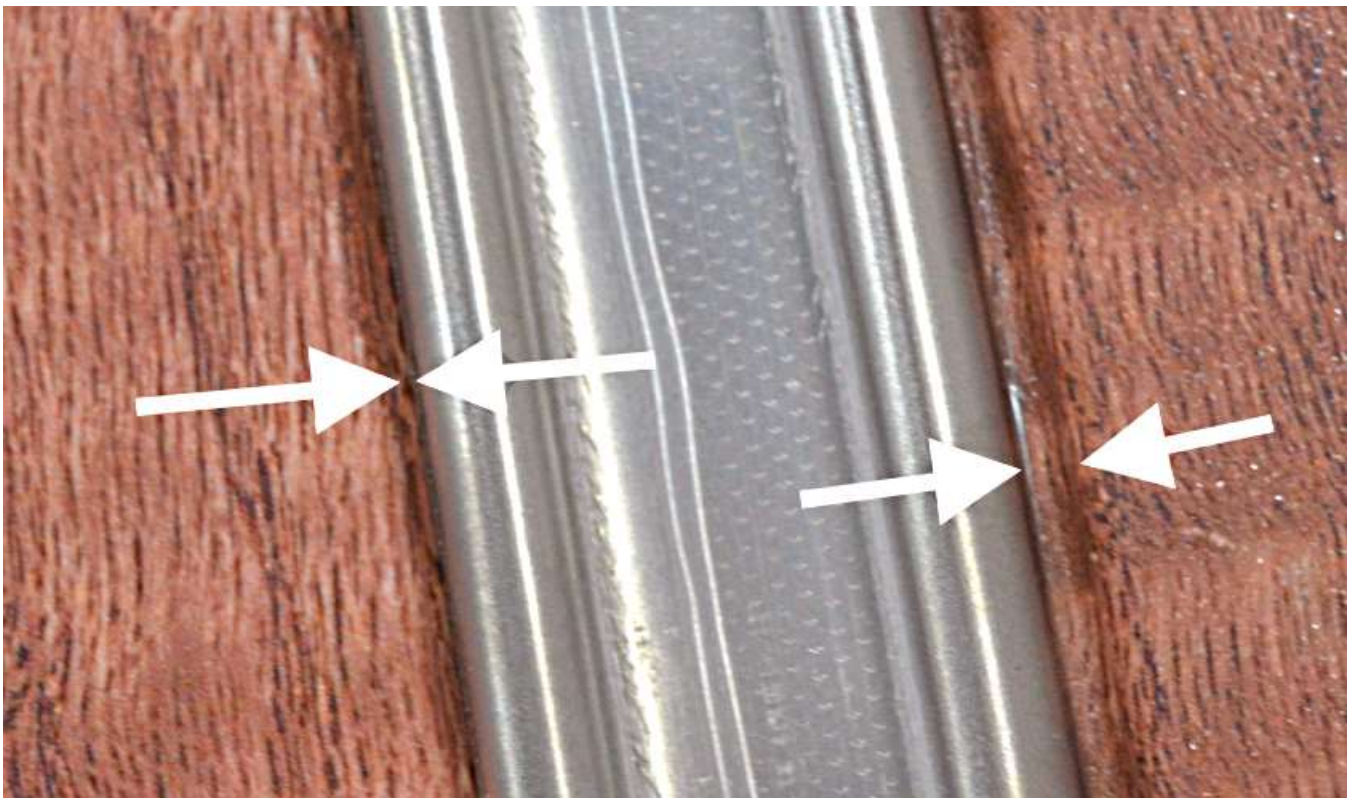
Install the remainder of the Floor Boards with the filler/rounded edge board on the right side. Do not attach the filler neck to the cap yet.



On the right side, make sure that the last board lines up with the edge of the Bed Support rails. If not you should be able to push the boards over so that they are aligned.



Place the rear board cover on top of the Bed Strip and behind the bed rear panel and attach loosely with short Button head screws.



Make sure that the bed strips have even gaps on each side. Move the boards or slightly move the T-nuts to adjust this.

Remove the rear board cover.

## Final install

☞ #10 x 1" self-drilling screws.

✂ Drill,  $\frac{5}{16}$ " nut driver,  $\frac{5}{32}$ " Hex key.



Remove the center Bed strip then use a drill with  $\frac{5}{16}$ " nut driver to screw the #10 self drilling screws through the other slot in the Support bracket into the frame tube.

Do this on each of the support brackets under the center bed strip.

Replace the bed strip and tighten the button head screw so that the Bed Strip is snug.



Repeat the process on the far left and right bed strips.

If the bed sides are not tight to the sides of the floor trim the flanges on the bed rear and side fiberglass panels or add/remove spacers as needed.

### **FUEL FILLER FINAL INSTALL**

From the underside of the bed, attach the fuel filler neck to the fuel cap using a hose clamp. Sand the area for the grounding strap and attach the tank to the frame using the #14 x ½” fastener.

Your Bed install is now complete.