

# Installation Instructions



# Hitch Receiver, Class 4 1801005

**CHEVY/GMC**

- 1988-2000 Classic
- 1999-2006 Silverado / Sierra 1500, 2500
- 1996-2006 Silverado / Sierra 2500HD

**DODGE**

- 1971-1993 Full size pickup
- 1994-2001 Ram 1500 (*drilling required on short bed*)
- 1994-2002 Ram 2500 (*drilling required on short bed*)
- 1994-2002 Ram 3500 (*drilling required on short bed*)

**FORD**

- 1973-1996 Full Size Pickups
- 1997-2004 F-150 Old Body Style
- 1997-2006 F-250 / F-350 Super Duty

**TOYOTA**

- 2000-2006 Tundra

• *Indicates no drilling required*

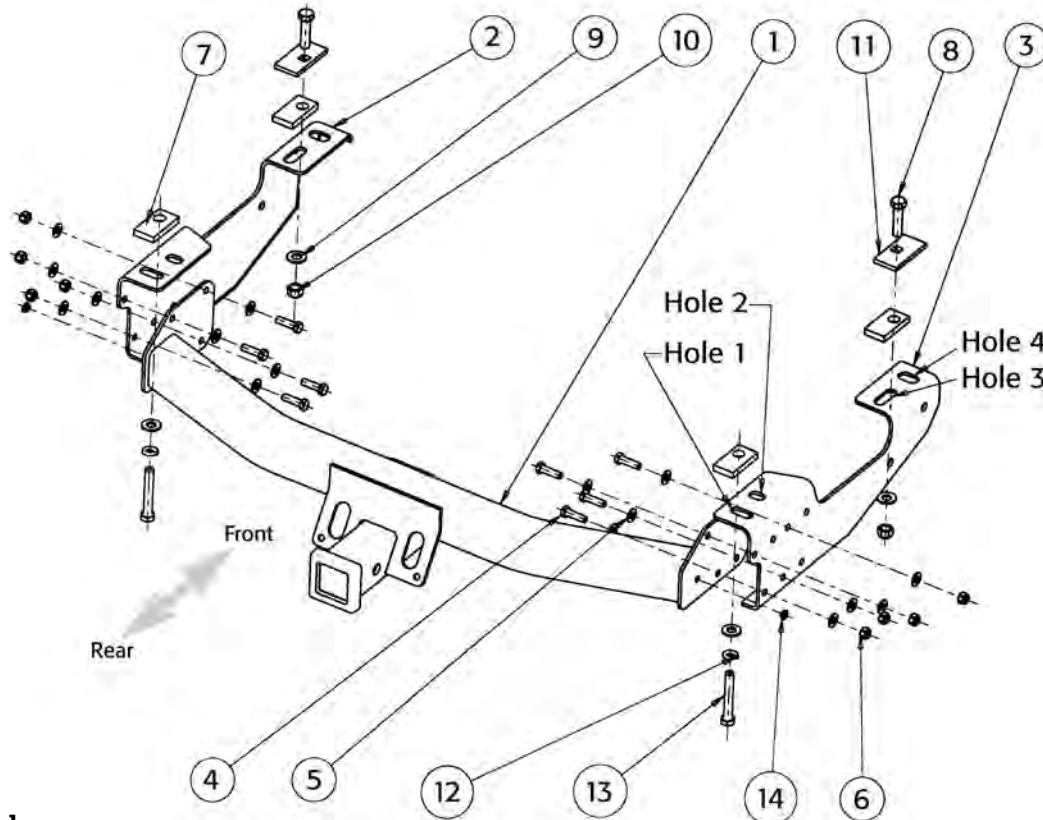
**WARNING:**

- Do not lubricate threads; hardware failure may occur due to overtightening.
- Do not drill or weld to this product.
- Use only Buyers supplied or approved hardware to install this product.

**CAUTION:**

- To keep debris out of your eyes always wear protective eyewear.
- Tighten screws and nuts only when it is recommended by these instructions.
- Check contents of box against part list to make sure all components are included.

## Chevy & GMC (Classic), 1988-2000



### Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004906	4	3/8" Spacer

ITEM	PART NO.	QTY.	DESCRIPTION
8	3001384	2	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
9	FWF050106010	4	Washer, Flat 1/2" SAE Zn
10	FNE050013053	2	Nut, Nylock 1/2-13 Zn
11	3004907	2	Bolt Plate, 1/4"
12	FWL050	2	Lockwasher, 1/2"
13	3005063	2	Screw M12-1.75 x 80 mm HH Class 10.9 Zn
14	3005078	2	Plug, 7/16" Dia. Poly

### Tools Required

- 1/2" drill bit
- 9/16" socket
- 19 mm socket
- 15 mm socket
- 3/4" socket
- 9/16" wrench
- 15 mm wrench
- Torque wrench
- 3/4" wrench
- 19 mm wrench

- 1.** Remove and discard the 12 mm diameter bolts at end of frame. Some vehicles have 8 mm diameter bolt on passenger's side. Remove that bolt and reinstall it with the head on bottom of frame.
- 2.** If your vehicle has rivets on bottom of frame, you will need to install one 3/8" thick spacer between frame and bracket at each bolting location. **Do not bolt brackets directly against rivets.**
- 3.** Using supplied 12 mm screws, 1/2" flat washers and lock washers, fasten brackets to frame where the 12 mm factory bolts were removed. See diagram. For short beds use hole 2. For long beds use hole 1. **NOTE: Some dual pipe exhaust systems will hit the bracket. Exhaust will need to be modified.**

**4. Short beds.** Insert 1/2" screws with 1/4" plates down through 1" diameter holes in frame and into holes (4) in bracket. Install 1/2" washers and lock nuts on each screw. Leave nuts loose at this time.

**5. Long beds.** Insert 1/2" screws with 1/4" plates down through 1" diameter holes in frame and into holes (3) in bracket. (On some models the forward holes may be 1/2".) Install 1/2" washers and lock nuts on each screw. Leave nuts loose at this time.

**6.** Place middle section between brackets as shown. Spare tire may need to be loosened. Attach middle section using 3/8" screws, washers and lock nuts. **NOTE: Be sure to use four holes to bolt side brackets to middle section.**

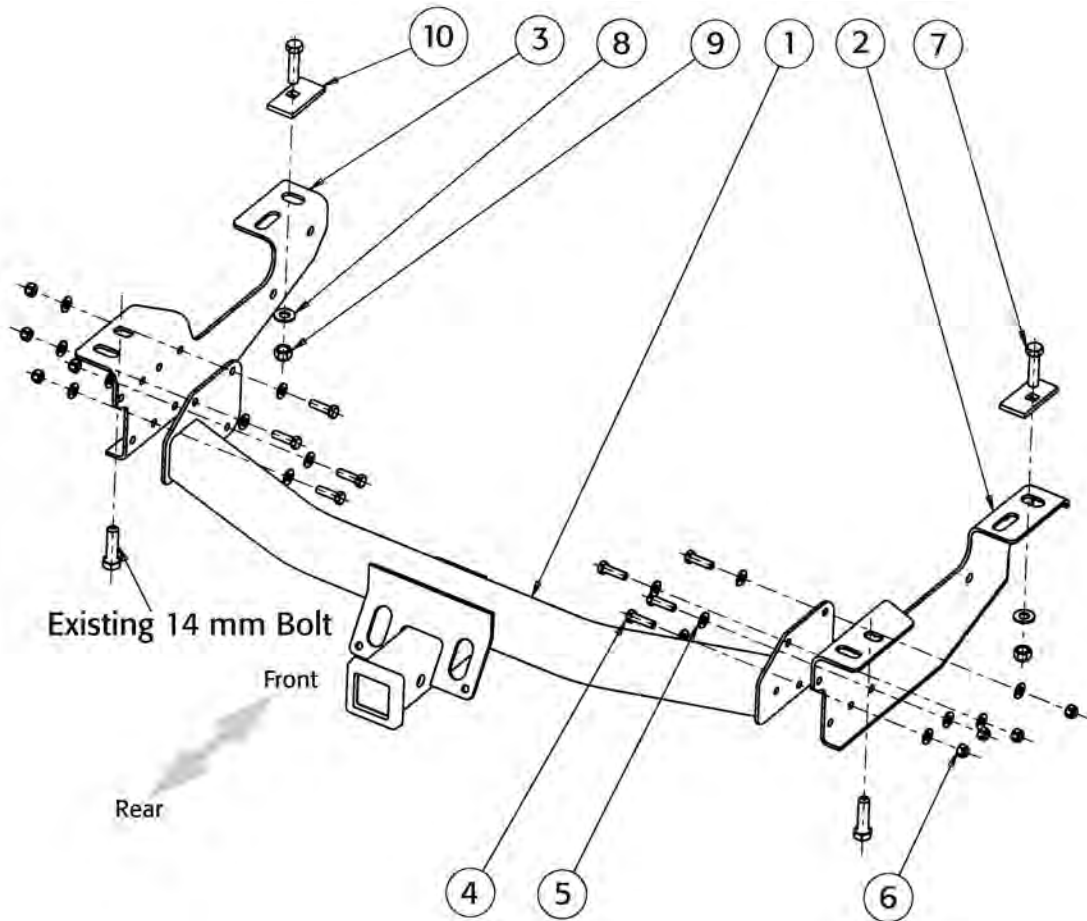
**7.** Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

**8.** Retighten spare tire if it was loosened.

**9.** Be sure that spare tire is not rubbing against brake hose. If needed, bend the brake hose bracket so that you have clearance between tire and brake hose.

**10.** Install plastic plugs into 3/8" holes in middle section.

## Chevy Silverado & GMC Sierra 1500, 2500, 1999-2006



### Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3001384	2	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
8	FWF050106010	2	Washer, Flat 1/2" SAE Zn
9	FNE050013053	2	Nut, Nylock 1/2-13 Zn
10	3004907	2	Bolt Plate, 1/4"

### Tools Required

- 3/4" socket
- 3/4" wrench
- 9/16" socket
- 9/16" wrench
- 21 mm socket
- Torque wrench

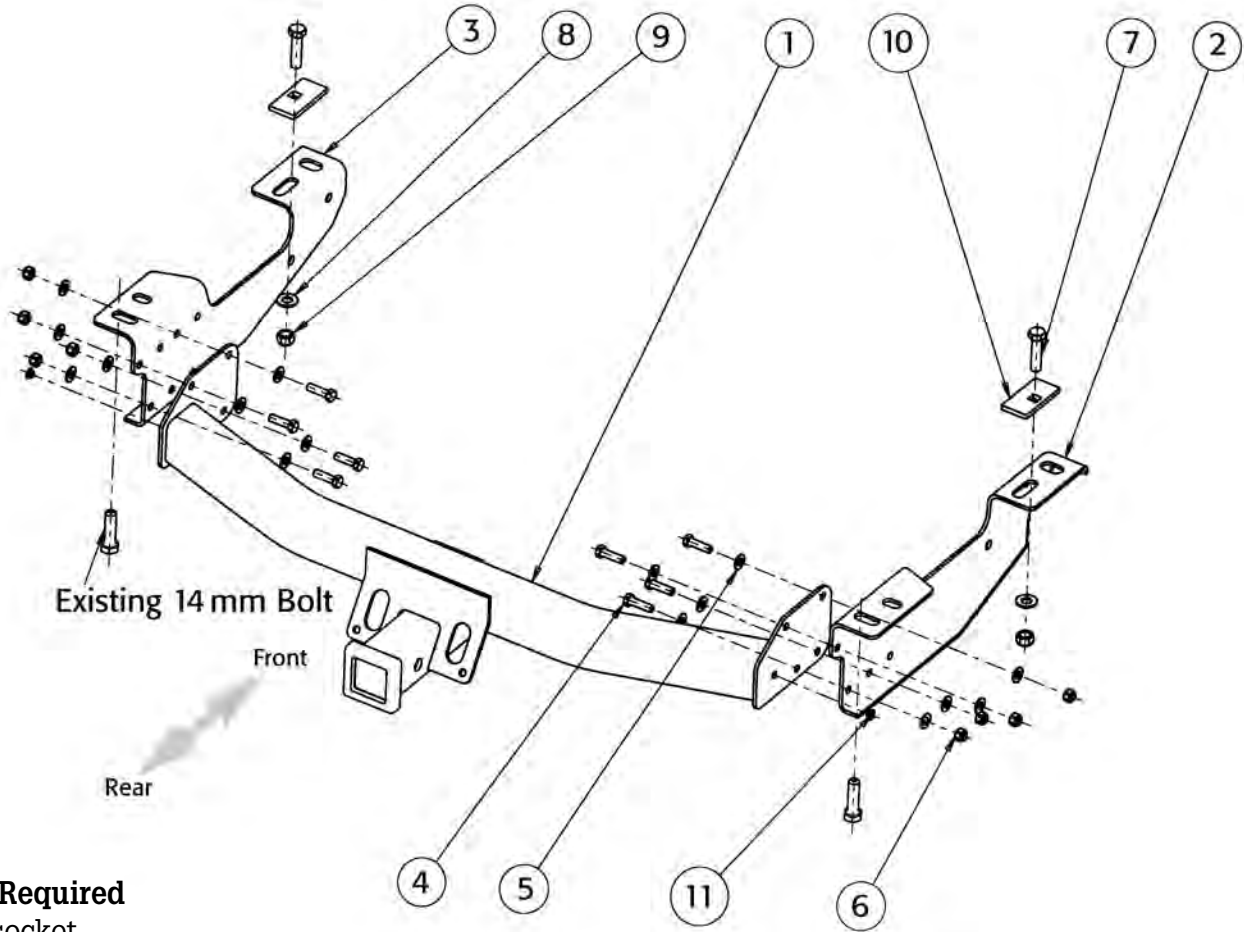
**1.** Remove 14 mm bolts from bottom of frame with a 21 mm socket.

**2.** Bolt brackets on with 14 mm bolts that were just removed into the holes as shown. Insert 1/2" screw with 1/4" plate through large hole in frame and into brackets as shown. Install 1/2" washers and lock nuts on the bolts. Leave nuts loose at this time.

**3.** Install middle section between the brackets as shown. Use bolting locations indicated. Attach middle section using 3/8" screws, washers and lock nuts. **NOTE: Be sure to use four holes to bolt side brackets to middle section.**

**4.** Tighten nuts in the following order: First torque the 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb. and 14 mm bolts to 85 ft-lb.

## Chevy Silverado & GMC Sierra 2500HD, 1999-2006



### Tools Required

- 3/4" socket
- 3/4" wrench
- 9/16" socket
- 9/16" wrench
- 21 mm socket
- Torque wrench

**1.** Remove 14 mm bolts from bottom of frame with a 21 mm socket.

**2.** Bolt brackets on with 14 mm bolts that were just removed into holes as shown. Insert 1/2" screw with 1/4" plate through large hole in frame and into brackets as shown. Install 1/2" washers and lock nuts on bolts. Leave nuts loose at this time.

**3.** Install middle section between brackets as shown. Use bolting locations indicated. Attach middle section using 3/8" screws, washers and lock nuts. **NOTE: Be sure to use four holes to bolt side brackets to middle section.**

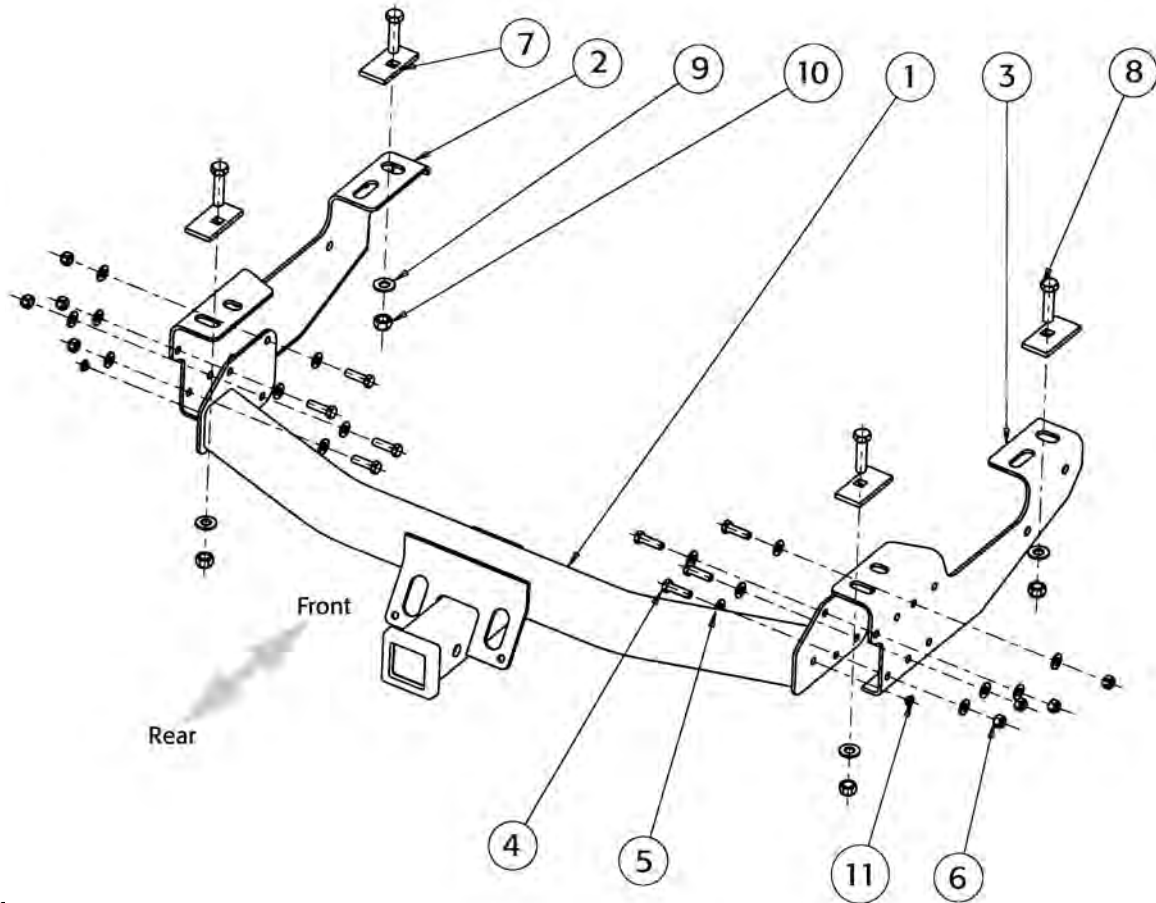
### Bill of Materials

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1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3001384	2	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
8	FWF050106010	2	Washer, Flat 1/2" SAE Zn
9	FNE050013053	2	Nut, Nylock 1/2-13 Zn
10	3004907	2	Bolt Plate, 1/4"
11	3005078	2	Plug, 7/16" dia. Poly

**4.** Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb. and 14 mm bolts to 85 ft-lb.

**5.** Install plastic plugs into 3/8" holes in middle section.

## Dodge Full Size Pickups, 1971-1993



### Tools Req

- 1/2" drill bit
- 3/4" socket
- 3/4" wrench
- 9/16" socket
- 9/16" wrench
- Torque wrench

**1.** Insert 1/2" screws with 1/4" plate down through 1" holes at end of frame. Fasten brackets to frame as shown with 1/2" washers and lock nuts. Leave nuts loose at this time.

**2.** Install middle section as shown. Use bolting locations indicated. Attach middle section using 3/8" screws, washers and lock nuts. **NOTE: Be sure to use four holes to bolt side brackets to middle section.** Leave nuts finger tight at this time. Some spare tire carriers may need to be modified if the receiver hits tire.

**3.** Using the most farthest holes in brackets as a guide, drill 1/2" holes in frame.

### Bill of Materials

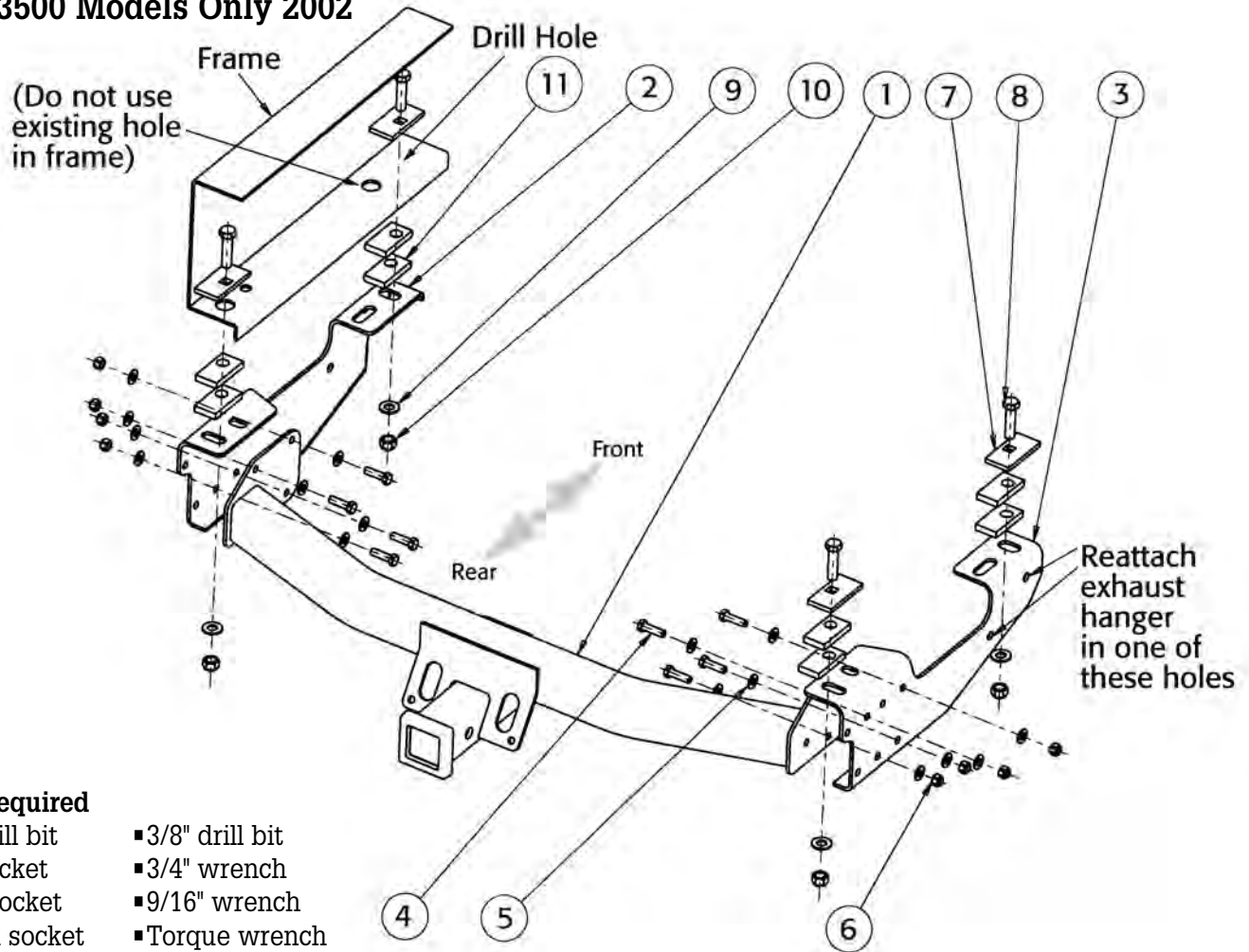
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1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004907	2	Bolt Plate, 1/4"
8	3001384	2	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
9	FWF050106010	2	Washer, Flat 1/2" SAE Zn
10	FNE050013053	2	Nut, Nylock 1/2-13 Zn
11	3005078	2	Plug, 7/16" dia. Poly

**4.** Insert 1/2" screws with 1/4" plates down through frame and brackets. Install 1/2" washers and lock nuts.

**5.** Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

**6.** Install plastic plugs into 3/8" holes in middle section.

## Dodge Pickup (short bed), 1994-2001 2500, 3500 Models Only 2002



### Tools Required

- 1/2" drill bit
- 3/4" socket
- 9/16" socket
- 13 mm socket
- 3/8" drill bit
- 3/4" wrench
- 9/16" wrench
- Torque wrench

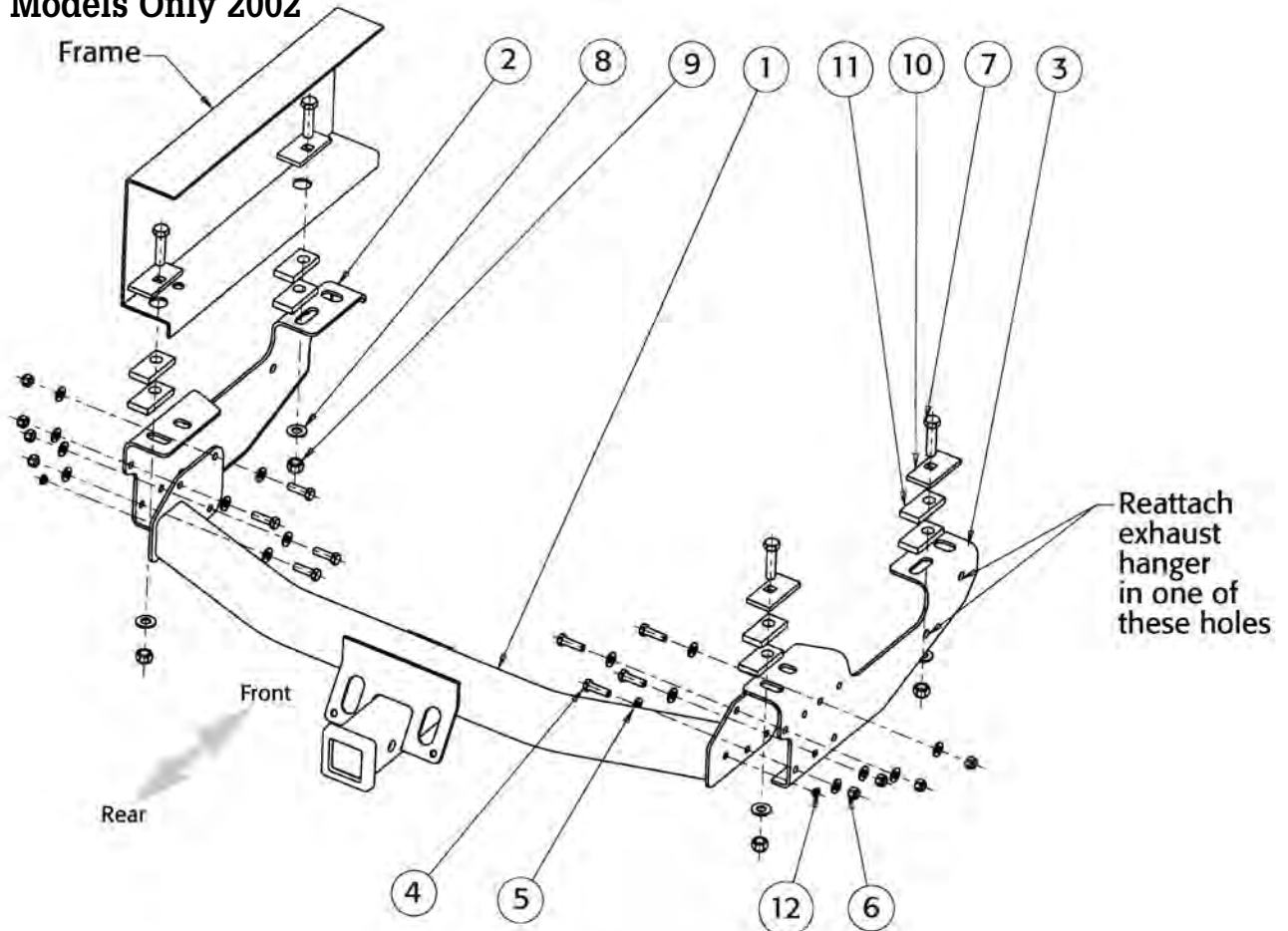
1. Spare tire may need to be loosened for installation.
2. Bolt brackets to frame with 1/2" screws and 1/4" plates inserted through 1" holes in end of frame. Install two 3/8" thick spacers between frame and brackets at rear bolting locations. Install 1/2" washers and lock nuts. **NOTE: For some models, exhaust hanger will need to be unbolted from frame.**
3. Install middle section between brackets as shown. Use hole pattern that works best for your truck. Insert 3/8" bolts through middle section and brackets. Install 3/8" washers and nuts on screws; finger-tight nuts at this time. **NOTE: Be sure to use four holes to bolt side brackets to middle section.**
4. Using holes in brackets as a guide, drill 1/2" hole through frame as shown in diagram. Install 1/2" screws with 1/4" plates into holes. Be sure to insert two 3/8" thick spacers between frame and brackets. Install 1/2" washers and lock nuts.

### Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8" SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004907	4	Bolt Plate, 1/4"
8	3001384	4	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
9	FWF050106010	4	Washer, Flat 1/2" SAE Zn
10	FNE050013053	4	Nut, Nylock 1/2-13 Zn
11	3004906	8	Spacer, 3/8"

5. If exhaust hanger was removed, drill 3/8" hole through hanger and attach it to side bracket in one of the holes provided in bracket. Use 3/8" hardware provided to reattach exhaust hanger.
6. Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.
7. If spare tire was loosened, retighten it now.

## Dodge Pickup (long bed), 1994-2001 2500, 3500 Models Only 2002



### Tools Required

- 3/8" drill bit
- 3/4" wrench
- 9/16" wrench
- Torque wrench
- 3/4" socket
- 9/16" socket
- 13 mm socket

1. Spare tire may need to be loosened for installation.

2. Bolt brackets to frame with 1/2" screws and 1/4" plates inserted through 1" holes in the end of the frame. Install two 3/8" thick spacers between frame and brackets at rear bolting locations. Install 1/2" washers and lock nuts.

**NOTE: For some models, the exhaust hanger will need to be unbolted from the frame.**

3. Install middle section between brackets as shown. Use hole pattern that works best for your truck. Insert 3/8" bolts through middle section and brackets. Install 3/8" washers and nuts on screws; finger-tight nuts at this time.

**NOTE: Be sure to use four holes to bolt side brackets to middle section.**

4. Insert 1/2" screws with 1/4" plates through 1" holes in frame and into brackets as shown. Install two 3/8" thick spacers between frame and brackets. Install 1/2" washers and lock nuts.

### Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8" SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3001384	4	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
8	FWF050106010	4	Washer, Flat 1/2" SAE Zn
9	FNE050013053	4	Nut, Nylock 1/2-13 Zn
10	3004907	4	Bolt Plate, 1/4"
11	3004906	8	Spacer, 3/8"
12	3005078	2	Plug, 7/16" dia. Poly

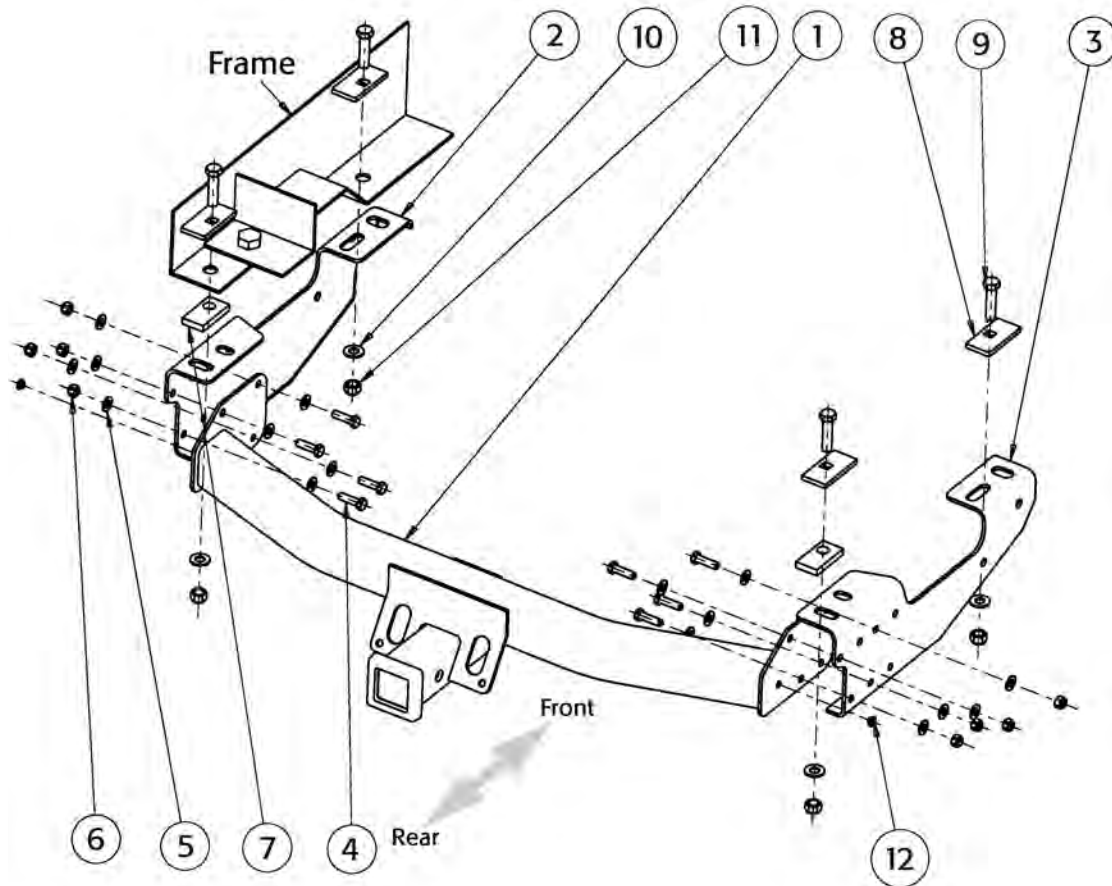
5. If exhaust hanger was removed, drill 3/8" hole through hanger and attach it to side bracket in one of the holes provided in bracket. Use 3/8" hardware provided to reattach exhaust hanger.

6. Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

7. If spare tire was loosened, retighten it now.

8. Install plastic plugs into 3/8" holes in middle section.

## Ford Full Size Pickup, 1973-1996 & 1997 F-250/F-350 Super-Duty



### Tools Required

- 1/2" drill bit
- 3/4" socket
- 3/4" wrench
- 9/16" socket
- 9/16" wrench
- Two clamps
- Torque wrench

**1.** Assemble middle section with side brackets as shown in picture. Leave screws finger-tight.

**NOTE:** Be sure to use four holes to bolt side brackets to middle section.

**2.** Clamp hitch receiver with 3/8" thick spacer between the receiver and the frame at the rear. Align ends of brackets with end of frame as shown. Align holes in 3/8" spacers with slots in brackets.

**3.** Using holes in brackets as a guide, drill 1/2" diameter holes into frame at locations shown.

### Bill of Materials

ITEM	PART NO.	QTY.	DESCRIPTION
1	3004980	1	Middle Section
2	3004908	1	Side Bracket
3	3004909	1	Side Bracket
4	FCS038016125	8	Screw, HHC-3/8-16 x 1.25 Gr 5 Zn
5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004906	2	3/8" Spacer
8	3004907	4	Bolt Plate, 1/4"
9	3001384	4	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
10	FWF050106010	4	Washer, Flat 1/2" SAE Zn
11	FNE050013053	4	Nut, Nylock 1/2-13 Zn
12	3005078	2	Plug, 7/16" Dia. Poly

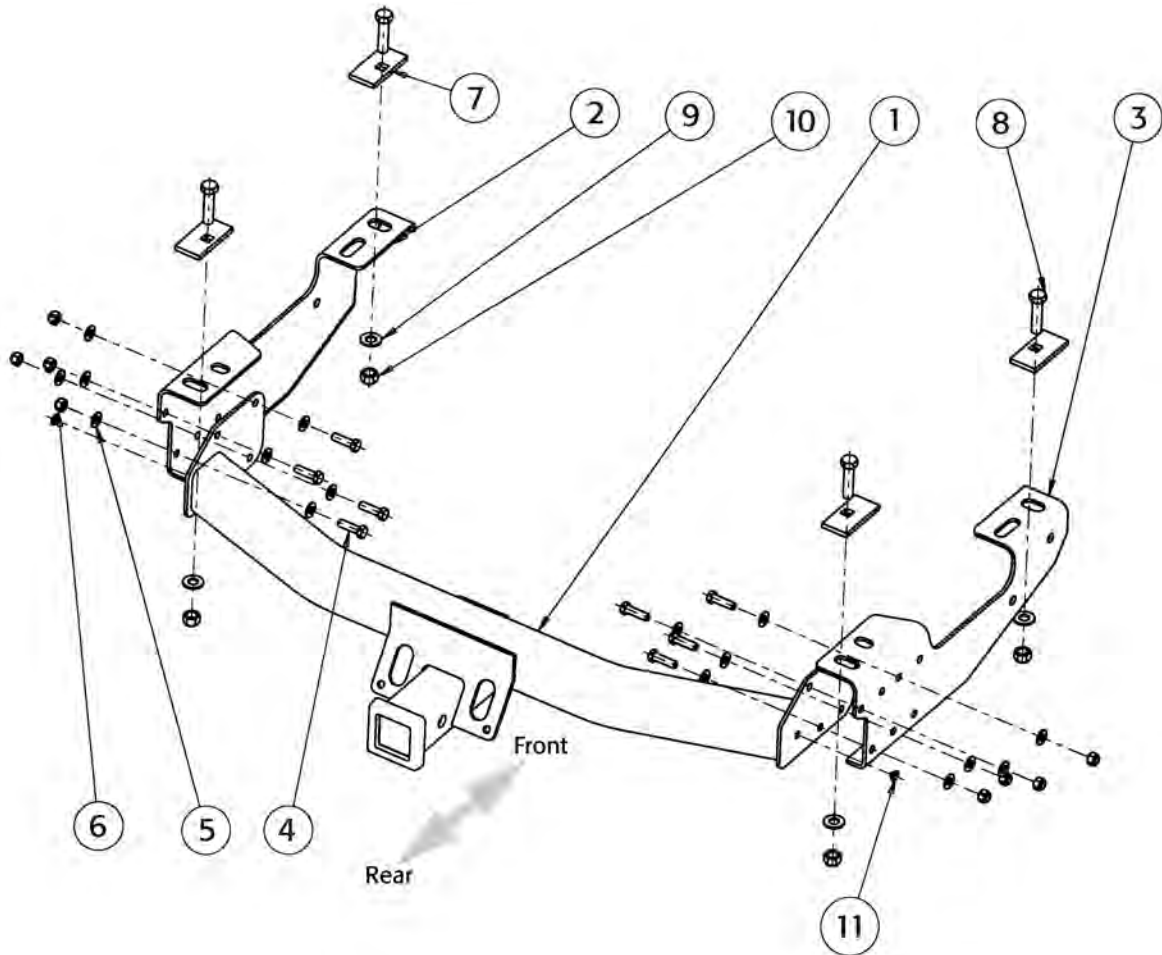
**4.** Insert 1/2" screws with 1/4" plates through frame and into brackets. Install flat washers and lock nuts on 1/2" screws.

**5.** Tighten nuts in the following order: First torque the 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

**6.** Install plastic plugs into 3/8" holes in middle section.



## Ford F-250/350 Super-Duty, 1997-2006



### Tools Required

- 1/2" drill bit
- 3/4" socket
- 3/4" wrench
- 9/16" socket
- 9/16" wrench
- Torque wrench

**1.** Align side brackets with rear edge of frame. Attach brackets to frame as shown with 1/2" screws and 1/4" plates down through rear holes in frame. Install flat washers and lock nuts on these screws. Leave nuts loose at this time.

**2.** Install middle section as shown with side brackets on the outside of it. Bolt through holes shown using 3/8" screws, washers and lock nuts.  
**NOTE: Be sure to use four holes to bolt side brackets to middle section.** Tighten enough for brackets to make full contact with middle section.

### Bill of Materials

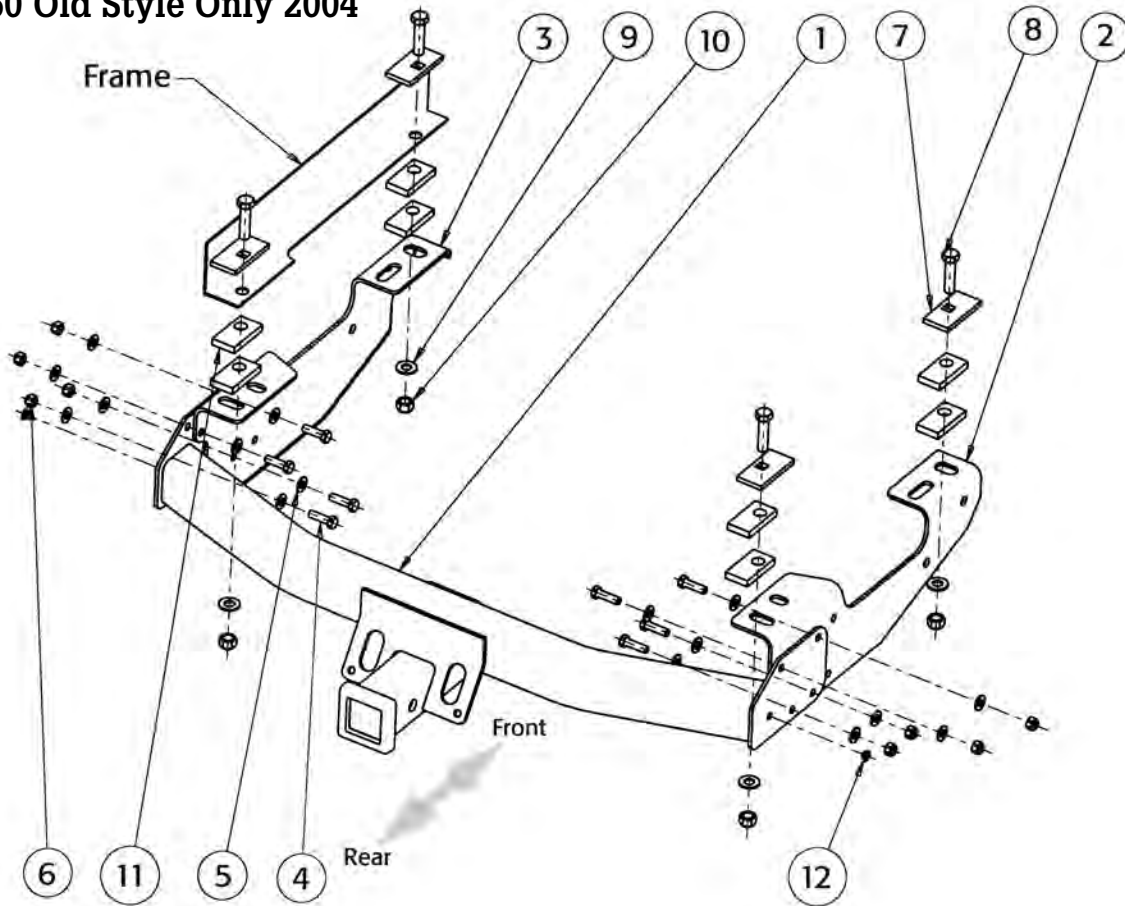
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5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004907	4	Bolt Plate, 1/4"
8	3001384	4	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
9	FWF050106010	4	Washer, Flat 1/2" SAE Zn
10	FNE050013053	4	Nut, Nylock 1/2-13 Zn
11	3005078	2	Plug, 7/16" dia. Poly

**3.** With 1/2" drill, drill two front holes. Install 1/2" screws, 1/4" plates, washers and lock nuts. Leave nuts loose at this time.

**4.** Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

**5.** Install plastic plugs into 3/8" holes in middle section.

**Ford F-150 & Light-Duty F-250, 1997-2003**  
**Ford F-150 Old Style Only 2004**



**Tools Required**

- 3/4" socket
- 3/4" wrench
- 9/16" socket
- 9/16" wrench
- Torque wrench

**1.** Align side brackets with rear edge of frame. Place 3/8" thick spacers between brackets and frame as shown. Attach brackets to frame as shown with 1/2" screws and 1/4" plates down through frame, spacers and brackets. Use first and last holes in the brackets. Install flat washers and lock nuts on screws. Leave nuts loose at this time.

**2.** Install middle section with side brackets on the inside of it. Attach middle section using 3/8" screws, washers and lock nuts. **NOTE: Be sure to use four holes to bolt side brackets to middle section.**

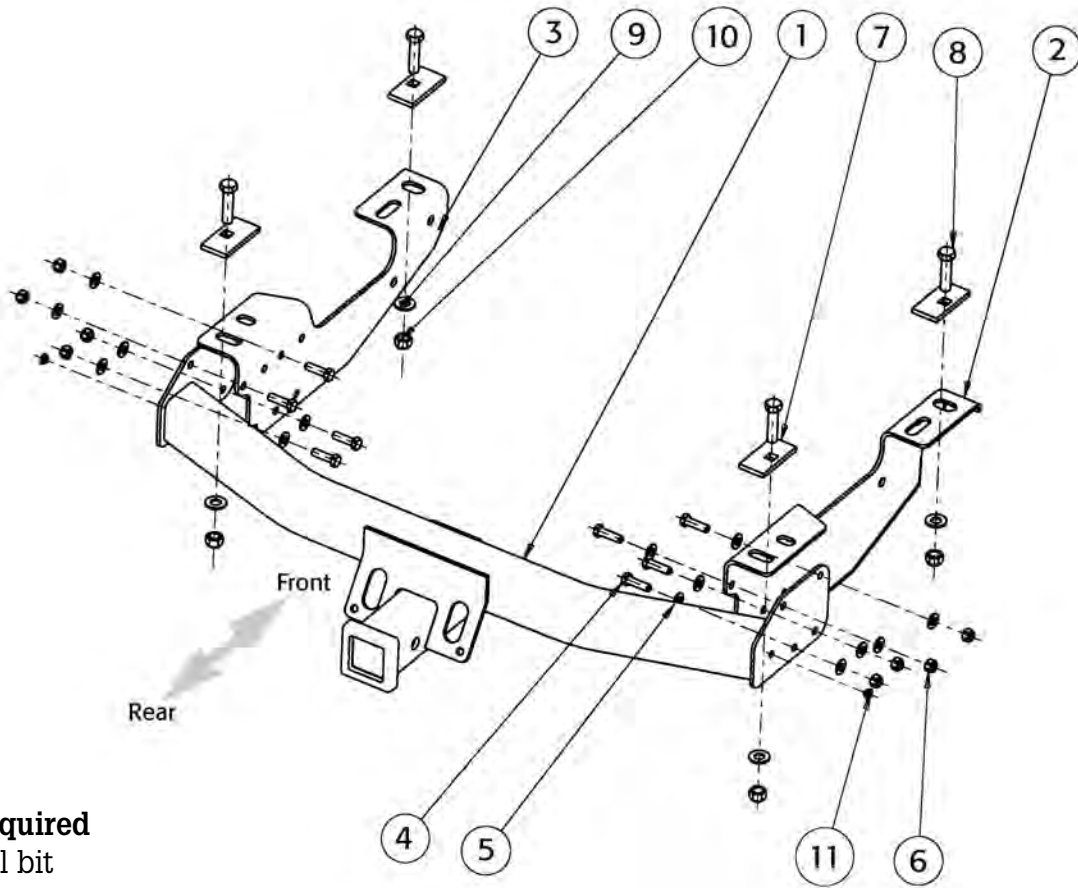
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5	FWF038081006	16	Washer, Flat 3/8 SAE Zn
6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004907	4	Bolt Plate, 1/4"
8	3001384	4	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
9	FWF050106010	4	Washer, Flat 1/2" SAE Zn
10	FNE050013053	4	Nut, Nylock 1/2-13 Zn
11	3004906	8	Spacer, 3/8"
12	3005078	2	Plug, 7/16" dia. Poly

**3.** Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

**4.** Install plastic plugs into 3/8" holes in middle section.

## Toyota Tundra, 2000-2006



### Tools Required

- 1/2" drill bit
- 3/4" socket
- 3/4" wrench
- 15/16" socket
- 15/16" wrench
- 21 mm socket
- Torque wrench

**1.** Use existing holes at rear of frame and install 1/2" screws through 1/4" plates and into frame. With 1/2" screws, washers and lock nuts attach brackets to frame. Do not install fasteners in the forward holes in brackets at this time.

**2.** Install middle section as shown. Use bolting locations indicated. Attach middle section using 3/8" screws, washers and lock nuts. **NOTE: Be sure to use four holes to bolt side brackets to middle section.**

**3.** Using forward most holes in brackets as a guide, drill 1/2" holes and install 1/2" screws with 1/4" plates through frame and brackets. Then install 1/2" washers and lock nuts.

### Bill of Materials

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1	3004980	1	Middle Section
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3	3004909	1	Side Bracket
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6	FNE038016044	8	Nut, Nylock 3/8-16 x 7/16 Zn
7	3004907	4	Bolt Plate, 1/4"
8	3001384	4	Screw, Hex Cap 1/2-13 x 2" Gr 5 Zn
9	FWF050106010	4	Washer, Flat 1/2" SAE Zn
10	FNE050013053	4	Nut, Nylock 1/2-13 Zn
11	3005078	2	Plug, 7/16" dia. Poly

**4.** Tighten nuts in the following order: First torque 3/8" nuts to 40 ft-lb. Then torque 1/2" nuts to 70 ft-lb.

**5.** Install plastic plugs into 3/8" holes in middle section.



Quality since 1946

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### **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.