

Step One – Modifying the stock rack

Cut 1" off stock rack end so seal sits flush with the end of the rack



You will need to modify your OEM rack to accept the provided seals. The passenger side uses the machined aluminum seal adapter that slip fits over the OE rack and is locked into place with a set screw. The driver side casting will need to be cut back to accept the provided seal. If you do not cut the rack back then the new clevis will contact the rack before the truck can reach full lock. You will need to cut 1" off the stock rack in order to get the seal to sit flush.

Step Two – Cutting the frame

You will need to cut the stock cross member to make room for the slide rack. Use the pictures as a guide for what need to get cut. A sawsall works best for doing this.



Step Three – Welding in the fill plates



Once you have cut the stock cross member apart fit the provided fill plates in. We recommend only tac-welding the plates in. Then you will want to install the OE rack along with the slide rack. Once you have the slide rack bolted to the OE rack install the inner clevis's. Then turn the wheel lock to lock and make sure the clevis's clear the notched out section. Once you see that everything clears you can then weld the fill plates in.

Welding these can be a little tricky and if you are struggling then you can remove the front diff for more access however we do not need to when we install them in the shop.

Step Four – Welding the cross member gussets



Once you have welded the fill plates in you need to install the cross member gussets. Take your time cleaning the paint off the frame and fit the gussets in. You may need to do some sanding on the stock frame where the factory welds are in order to get the plates to sit flush. When you have the plates fitting up nice you can then burn them in.

Step Five- Welding the Slide rack mounts



The slide rack end caps have to tabs on them. The top tabs use the factory rack bolts and the front tabs require welding the supplied mounts. Make sure you have the aluminum spacer between the end cap and the tab that gets welded on. Also DO NOT force the tabs into position, this will cause the slide rack to bind. You need to make sure the slide rack is running in parallel to the OE rack.