Ford F-150 and Super-Duty Venture Tec Mounting

VEHICLE HARDWARE KIT CONTENTS:	
Description	**Qty.**
Stake Pocket Mounting Bracket (Driver and Passenger Side)	**1 ea**
U-Bracket	**2**
Plastic Bracket Nut	**4**
5/16’” x 3.25” button head cap screw	**4**
5/16” washer	**4**
3/8” x 1.5” hex head bolt	**2**
3/8” washer	**2**

Additional Tools Needed (5.5’ F-150 Bed Only):

- Router or Dremel
- Router or Dremel Bit
  PN: VFL3Z-99000A25-A
- Drill
- 1/2” Drill Bit
- Utility Knife

These Ford F-150 and Super Duty instructions are to be used in conjunction with the Venture Tec rack instructions. The instructions detail parts and tips specific to mounting the Venture Tec rack to the F-150 and Super Duty.

Figure 1. Front Mounting Hardware

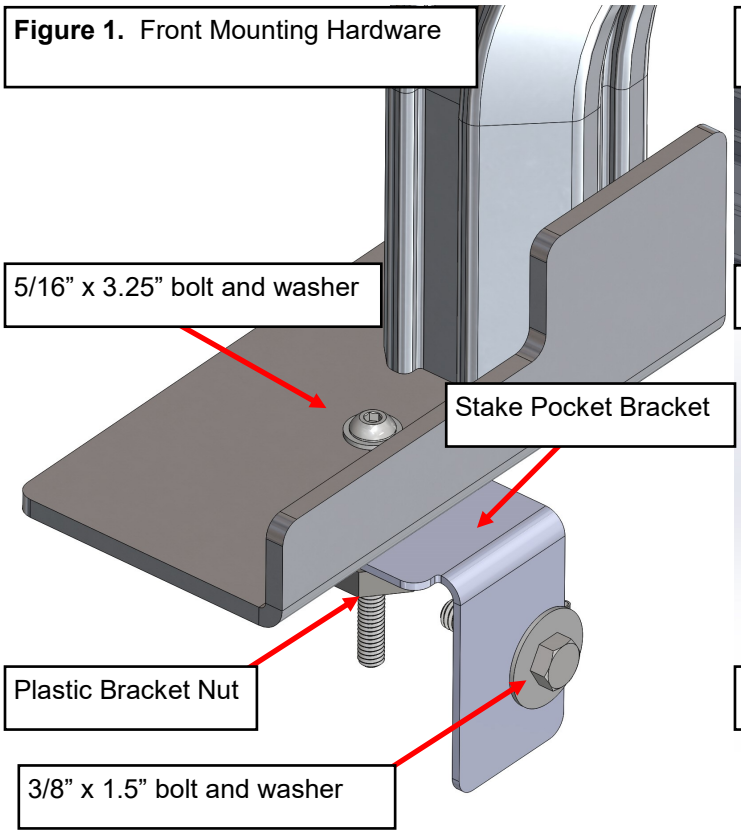
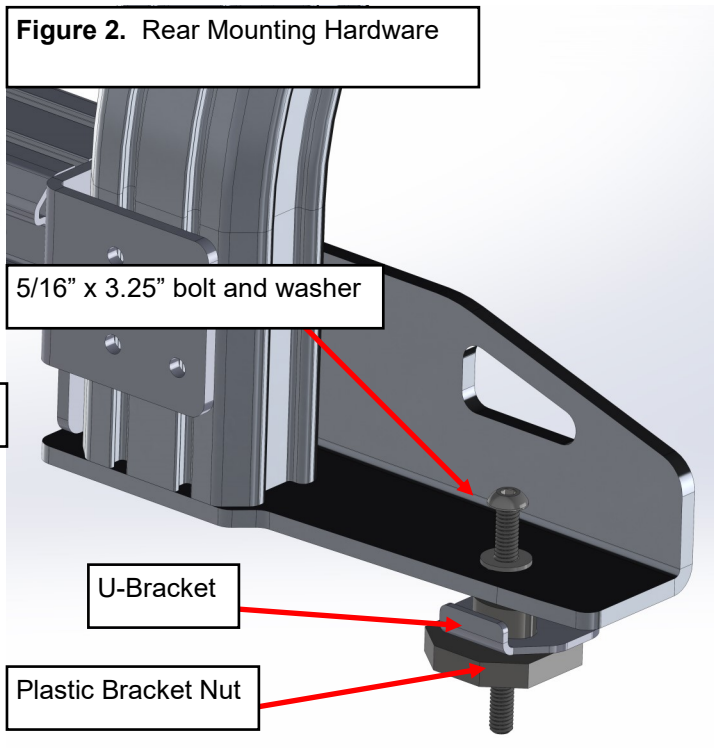


Figure 2. Rear Mounting Hardware



For 5.5' F-150 Beds, the front stake pocket is hidden by the plastic bed cap and needs to be cut out for access. Follow steps 1-6 below before proceeding with Venture Tec installation.

1. Measure, mark, and drill a ½" hole in the center of the two hidden **FRONT** stake pocket hole locations on the driver side and passenger side plastic rail caps. Location marked in **(Figure 3a and 3b)**

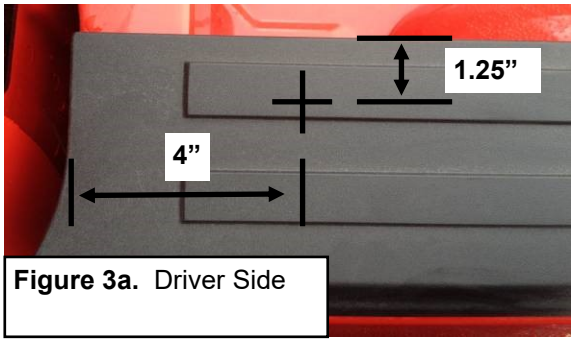


Figure 3a. Driver Side

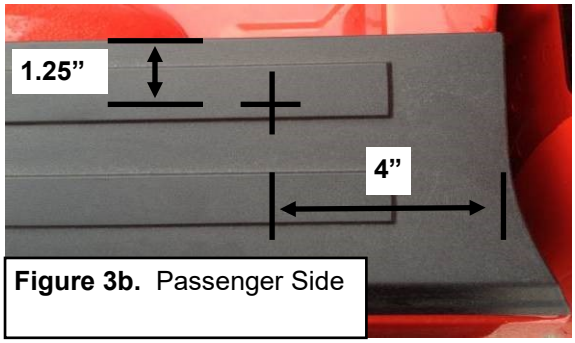


Figure 3b. Passenger Side

2. Set and tighten the router bit 3/8" from the router base to the end of the router bit cutter.
3. Turn on router and insert the router bit into the previously drilled ½" hole on the passenger side.
4. Slowly and gently guide the router until the bearings of the router bit touch an edge of the hidden pocket hole.
5. Guide the router slowly and gently in a counter-clockwise motion until the pocket is exposed **(Figure 4)**.

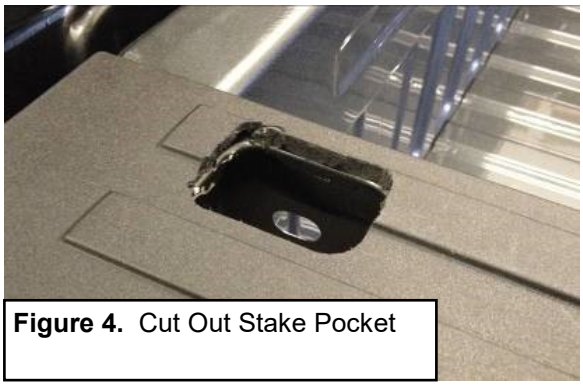


Figure 4. Cut Out Stake Pocket

Rear Hoop Installation:

The rear hoop is secured to the vehicle using a U-bracket. This process is easier with the help of a friend.

1. Assemble the U-bracket and threaded insert as shown in **Figure 5**. Note the hole is offset to the outside of the truck.



Figure 5. U-bracket hole offset orientation.

2. Run the 3.25” bolt through the rear hoop, and loosely thread on the U -bracket assembly. Leave as much bolt unthreaded as possible to allow maneuverability in the stake pocket (**Figure 6**).
3. Install the U-bracket assembly into the stake pocket by angling it into the stake pocket and then pulling up on the bolt (**Figure 7**).
4. Make sure that the U-bracket grabs the inner lip of the skate pocket sheet metal, and the bolt hole is offset towards the outside of the truck. Once the U-bracket is located properly, pull up on the hoop to hold the U-bracket in position (**Figure 8**). Keep pressure on the bracket by holding the hoop up and begin tightening the bolt with 3/16” hex driver (**Figure 9**). Do not fully tighten yet.
5. Repeat process on other side of hoop, but do not fully tighten until longitudinal support rails are installed and hoop is centered on vehicle.

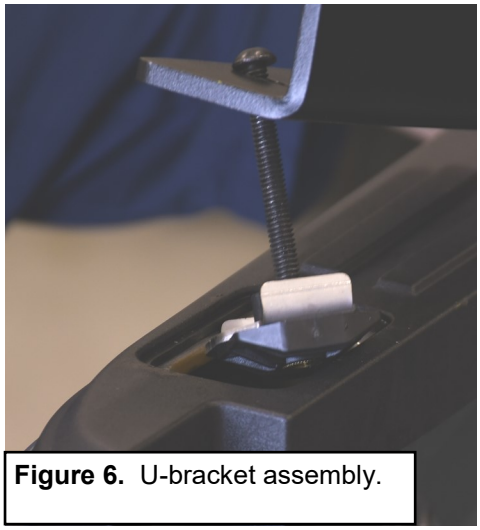


Figure 6. U-bracket assembly.

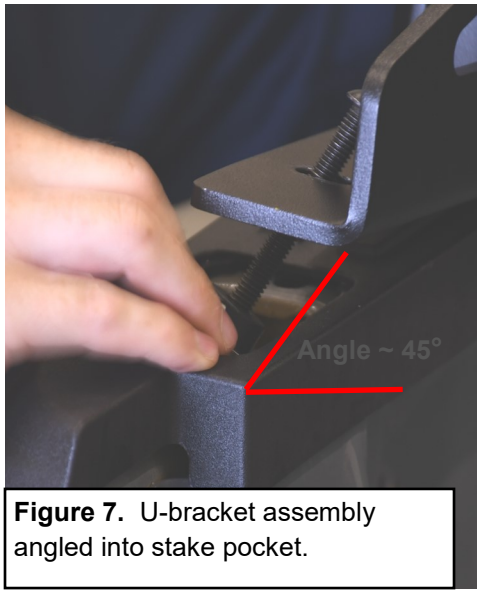


Figure 7. U-bracket assembly angled into stake pocket.

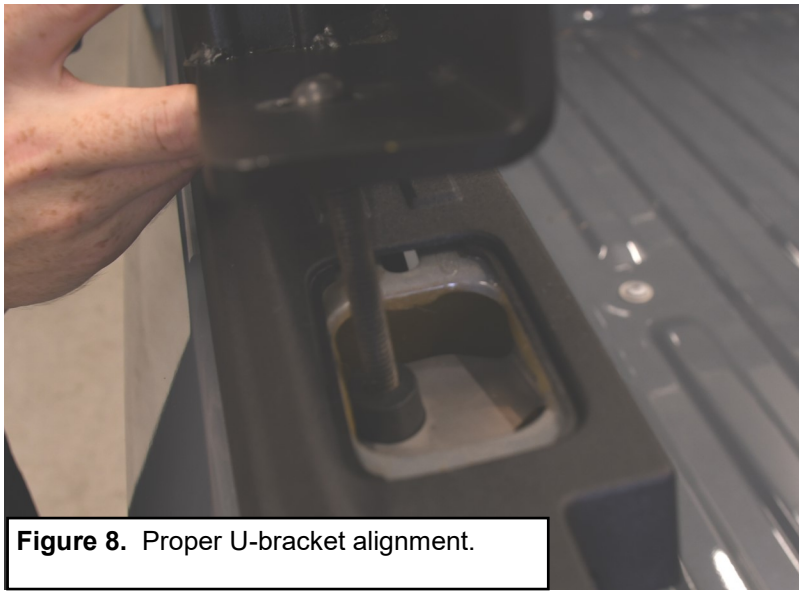


Figure 8. Proper U-bracket alignment.



Figure 9. Tightening fastener while keeping pressure on bracket.