



# DH1204


## 2011-12 Ford F-250/F-350/F-450 Super Duty (Long and Short Beds) Installation Instructions

Serial Number


**Please read these instructions in their entirety before attempting to install or operate this equipment.**



**The Diamond Hitch is rated to 30,000 lbs. Gross Towing Weight and 7,500 lbs. Tongue Weight.**

 **WARNING**

Refer to your vehicle's owner's manual for maximum towing capacity. DO NOT overload your vehicle - failure to follow vehicle manufacturer's recommendations could result in damage to your vehicle, personal injury or death.

 **WARNING**

Failure to read and follow these instructions could result in separation of the trailer from the truck, causing property damage, loss of towed vehicle, personal injury or death.

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1. Trailer brakes are required.
2. Insure vertical clearance for the ball when in the stored position by verifying it will not hit brake lines etc.
3. Do not use any open flame under the truck bed to cut or weld. There is extreme danger of explosion or fire.
4. Vehicle must be securely blocked and brakes set before beginning to work underneath the vehicle.
5. Do not clamp hitch over any wiring or brake lines.
6. Always make sure trailer is loaded slightly tongue heavy. Do not pull a trailer that is lighter on the tongue end.
7. The installer must instruct the operator on proper ball installation and locking procedures.
8. Be sure the user receives all instructional materials.

**If the Diamond Hitch is in an accident, it must be replaced. DO NOT use it again! An accident can cause unseen damage and using it again could result in more damage or serious injury. DO NOT use the Diamond Hitch if it is damaged or missing parts.**

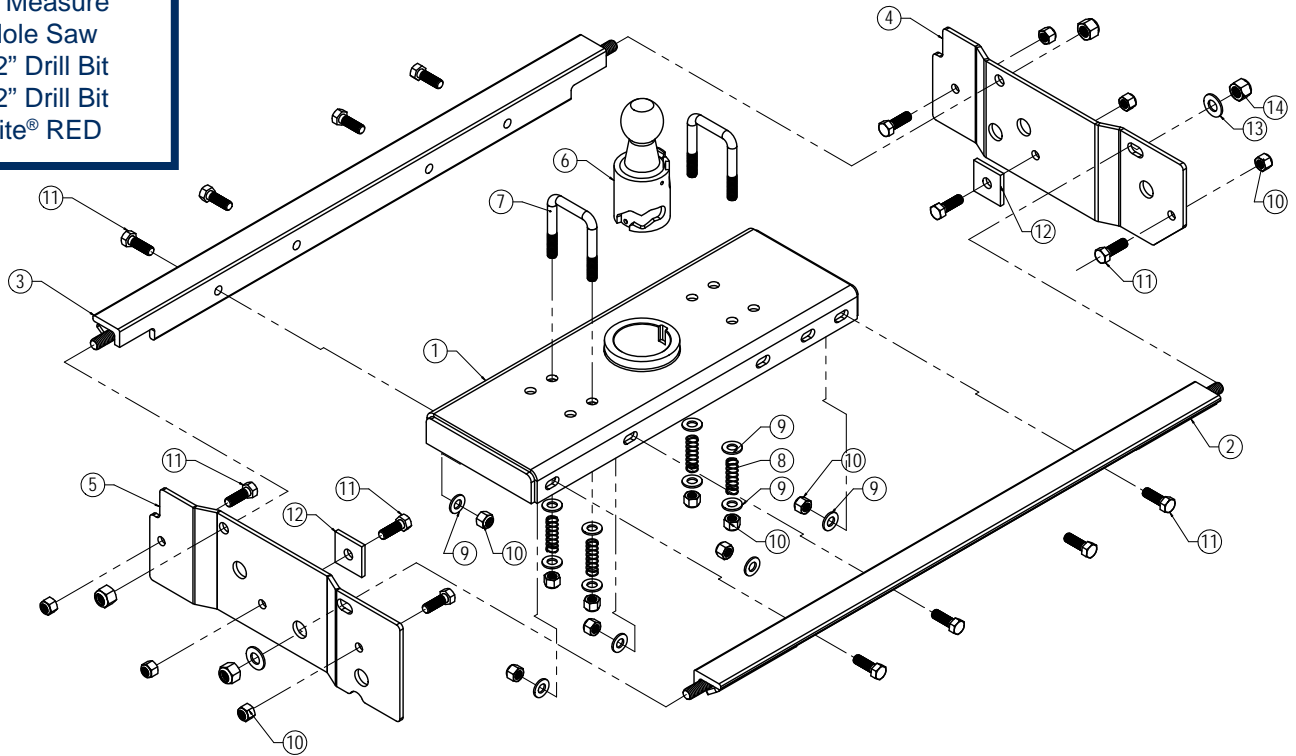
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### Installation Instructions

#### Tools Required

10MM Socket  
 3/4" Socket/Wrench  
 15/16" Socket  
 Drill  
 Tape Measure  
 4" Hole Saw  
 17/32" Drill Bit  
 19/32" Drill Bit  
 Loctite® RED



Item No.	Part No.	Description	Qty.
1.....	61-6775 .....	DH1204 Cross Member .....	1
2.....	61-6776 .....	DH1204 Front Angle .....	1
3.....	61-6777 .....	DH1204 Back Angle .....	1
4.....	101-7582 .....	DH1204 Support Plate, DS.....	1
5.....	101-7583 .....	DH1204 Support Plate, PS.....	1
6.....	62-3604 .....	Ball Assembly .....	1
7.....	201-0275 .....	U-Bolt, 1/2"-13 x 3-3/4" x 2-1/2", ZP .....	2
8.....	222-0091 .....	Compression Spring, .60 x .20 x .049 Dia. ....	4
9.....	203-0005 .....	1/2" Flat Washer, ZP.....	16
10.....	202-0094 .....	1/2"-13 Hex Nylon Lock Nut .....	18
11.....	201-0051 .....	1/2"-13 x 1-1/2" Hex Head Bolt, Grade 5, ZP .....	14
12.....	102-6772 .....	Spacer, 1/4" x 2" x 2" .....	2
13.....	203-0106 .....	5/8" SAE Flat Washer, ZP.....	2
14.....	202-0064 .....	5/8"-11 Hex Nylon Lock Nut, ZP .....	4
15.....	203-0091(not shown).....	7/16" SAE Flat Washer, ZP.....	2

#### Important:

Use only genuine factory replacement parts on your Diamond Hitch. Do **NOT** substitute homemade or non-typical parts. If a bolt is lost or in need of replacement, for your safety and the preservation of your hitch, be sure to use a replacement bolt of the same grade (In most cases it will be Grade 5, please reference the parts list above). Replacement parts may be ordered through your nearest Blue Ox® Dealer or Distributor. Failing to follow and/or altering these installation instructions in either installation or required equipment will void the manufacturer's warranty.

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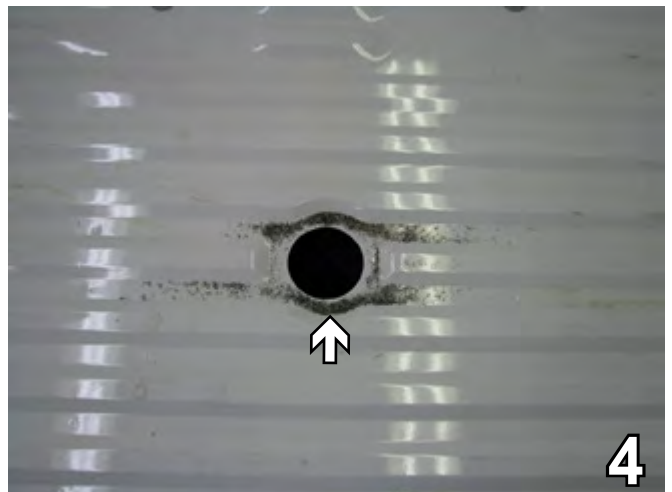
1. Using the jack handle tool which is located behind the driver's back seat, remove the spare tire as per the truck's owner's manual.



2. Between the wheel wells is a place for the ball which is center punched. Using that as a guide, drill a 4" hole.



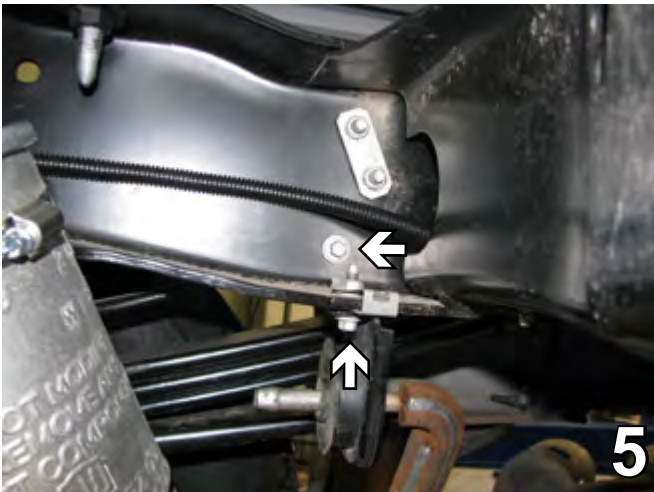
3. Using a board while drilling keeps it from wobbling.



4. The pickup bed after the hole is drilled.

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5. On the passenger side only underneath the vehicle, using a 10MM socket remove two bolts from the hanger. Set bolts and hanger aside to be reinstalled later.



6. Further back underneath the vehicle, drop the exhaust out of the way by sliding two (2) more rubber hangers off of the mount pins. Spray with silicon spray on the rubber grommet to slip off easier.

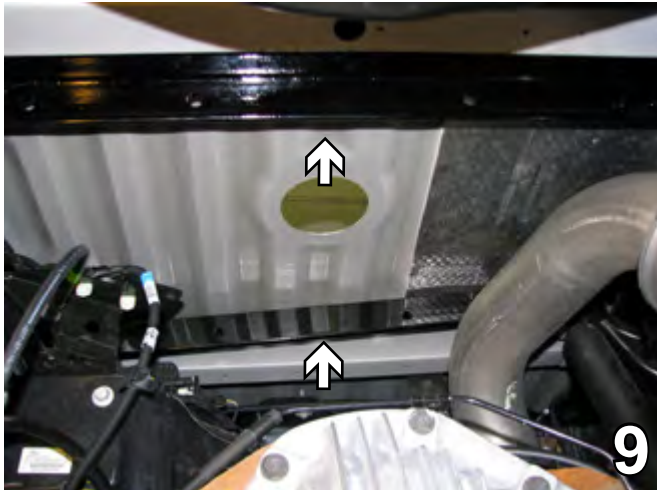


7. The back angle weldment measures 36-1/2" long.



8. The front angle weldment measures 37-1/2" long.

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9. Slide the front angle weldment in to the front of the pickup first. Slide the weldment in at an angle. Then slide the back angle weldment in.



10. Slide the cross member in, align with the drilled hole and hold in place.



11. On both sides, start four (4) 1/2"-13 x 1-1/2" hex bolts through the angle weldment first then the cross member and attach with 1/2" flat washers and 1/2"-13 lock nuts on the inside, leave them loose.



12. On the passenger side only, if the vehicle is equipped with air bags remove the 1/2" washer and nut right beside the tire. It will be replaced on the outside of the bracket.

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13. Align the bolts at the end of the angle weldment and the top two (2) holes in the plate. Attach with 5/8" flat washers on the slotted holes and 5/8"-11 lock nuts on both bolts (white arrows). Insert 1/2"-13 x 1-1/2" hex bolts into the lower three (3) holes and attach with 1/2"-13 lock nuts (gray arrows). The middle hole has a 1/4" spacer on the inside. Use Loctite Red® on all bolts. Tighten the plate bolts first then the angle weldment bolts. Do this on both sides. The driver side is shown.



14. On the passenger side, if the vehicle has air bags, replace the washer and nut which was removed. The bolt pattern is the same on both sides.

**BE SURE TO USE LOCTITE® RED ON ALL BOLTS BEFORE TIGHTENING. TIGHTEN ALL BOLTS ACCORDING TO TORQUE SPECIFICATIONS.**



15. Using the cross member as a template, drill with a 19/32" drill bit the two (2) holes closest to the ball. These are recessed into the box. Do this on both sides.



16. Attach the 1/2"-13 U-bolt on all four (4) corners with 1/2" flat washer, spring, 1/2" flat washer and 1/2"-13 lock nut. Do this on both sides.

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17. Hook the exhaust back up using the existing brackets and existing hangers.



18. Reinstall the spare tire to its original location.



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Installing the Inverta Ball



1. Align pin (see grey arrow) with slot in hitch (see white arrow). Drop into receiver cylinder and depress locking tab.



2. Twist the ball 30 degrees clockwise while lifting slightly until ball drops into position and locking tab snaps in place.

Removing the Inverta Ball



1. Push in the locking tab and then lift and rotate the ball assembly counterclockwise. Continue rotating and lifting until the ball stud clears the receiver cylinder.

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### Storing the Inverta Ball



1. Align pin with storage slot in hitch.



2. Push in the locking tab and let the ball assembly drop into the receiver cylinder.
3. Pull the ball straight up to remove it from the stored position.

### Customer Service Commitment

Blue Ox is committed to providing you with exceptional customer care throughout your lifetime with our products. Our team is here to assist you with any questions you may have regarding the performance of your product. Simply call 1-402-385-3051 and you can speak with our customer care team.

Additionally, please visit our website to see which rallies our Destination America team will be attending. For a nominal fee, our service technician will service your towing system to ensure it's in proper working condition. Also as a commitment to our customers, should you visit our factory you can stay at our full service Blue Ox campground at no charge along with enjoying a factory tour.

Again thank you for being our customer and for the confidence you have shown in the performance of our products. It is because of customers like you we enjoy the success we have today.



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