

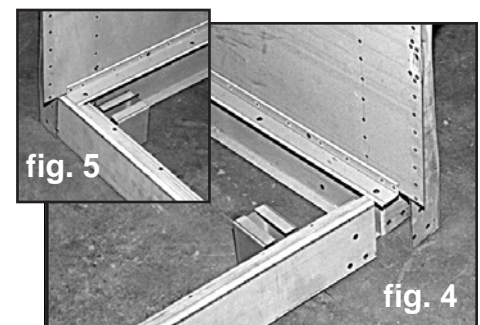
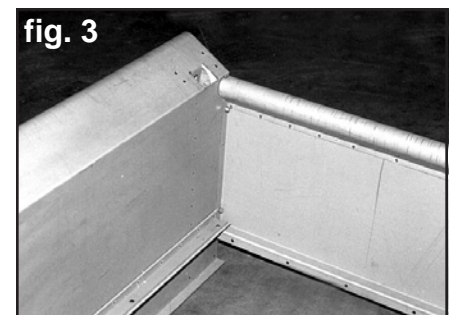
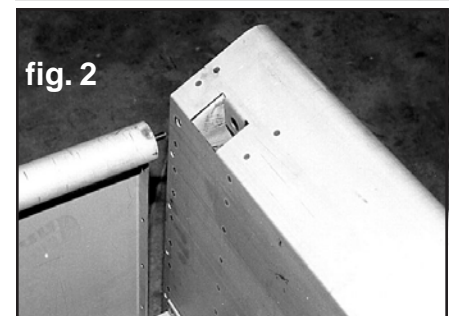
MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

BED PARTS ASSEMBLY GUIDE 47-53 GM SHORT STEPSIDE

If you have not yet disassembled your original bed, make notes or sketches and take pictures of part locations to aid in the assembly procedure. Use the following steps to assemble the entire bed to test fit all parts.

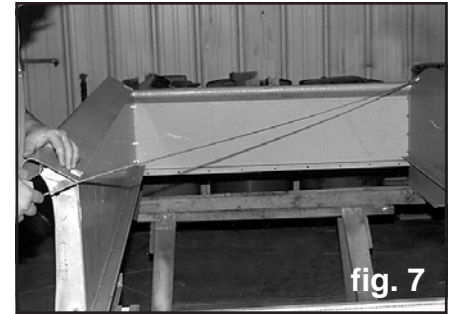
1. Begin by installing a 5/16" flat washer, lock washer, and nut onto one end of the front bed panel tie rod. Stand the front bed panel on end. Insert the tie rod end without hardware into the front bed panel top curl plug. While looking down through the curl, align the tie rod with the opposite end plug of the front panel curl. See figure 1.
2. Insert the tie rod end without hardware through the top hole in bed side. Secure with a 5/16" flat washer, lock washer, and nut. Bolt the front bed panel side flange to the inside of the bed side with (4) 1/4"-20 x 5/8" hex head bolts, lock washers, and nuts. See figure 2.
3. Remove the hardware from the other end of the front bed panel tie rod. Install this end through the other bed side and secure with a 5/16" flat washer, lock washer, and nut.
4. Bolt the front bed panel to the other bed side with (4) 1/4"-20 x 5/8" hex bolts, lock washers, and nuts. See figure 3.
5. Fit the rear cross sill inside the lower portion of the bed side rear stake pockets with the open side of the rear cross sill facing downward. See figures 4 and 5. The bracket and flanged side of the rear cross sill faces toward the front bed panel.
6. Using (10) 5/16"-18 x 3/4" indented hex head bolts, nuts, and lock washers, bolt the rear cross sill to the stake pockets. Leave the top two holes for tailgate hinges empty for now.



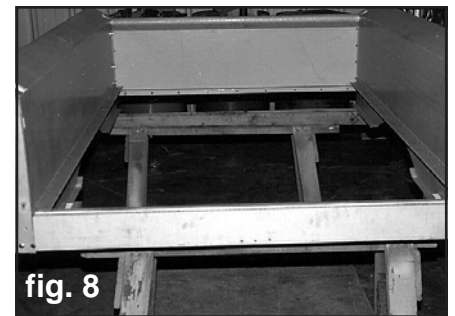
7. Once these four pieces of the bed are assembled, you will need to make sure your bed is square. Measure the bed width at the top and bottom of bed sides to ensure that the bed sides are straight up and down and are **50"** apart. See figure 6. These measurements should be within 1/16" of each other to ensure bed squareness. Tighten rear cross sill bolts.



8. Also measure crosswise from the front of the bed to opposite rear of the bed on both sides. See figure 7. Now tighten all bolts.



9. Place the assembly on supports horizontally to gain access to both the top and bottom of the bed floor area. See figure 8. This can also be achieved by standing the bed assembly vertical. Place a blanket or other suitable protection on the floor and stand the bed assembly on the front bed panel.

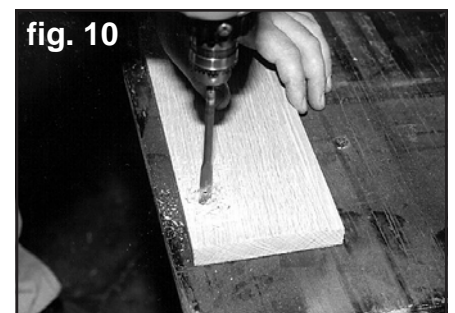


10. Place the wood boards that have only one bed strip groove (referred to as "edge boards") under the angle strips on the bed sides. See figure 9. The non-grooved edge should be toward the bed side. Leave approximately a 1/16" inch gap between the bed side and the board.



11. Mark all holes to be drilled in the two wood boards through the angle strips square holes. See figure 9.

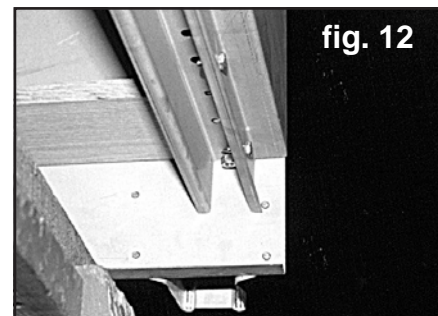
12. Remove these two boards and drill all holes marked using a 3/8" wood bit. Be careful not to splinter the other side of the board when drilling. Placing a wood block behind the board where drilling will help prevent this. See figure 10.



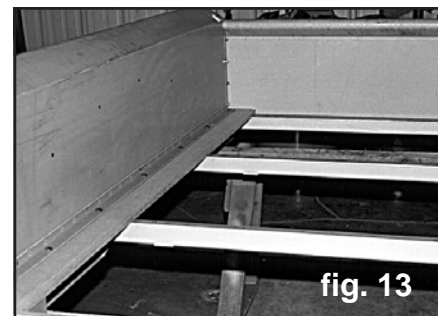
13. Install the edge boards underneath the angle strips as in step 10. Place 5/16"-18 x 1-1/2" carriage bolts through the angle strips through the boards. See figure 11. Leave off the lock washers and nuts for now.



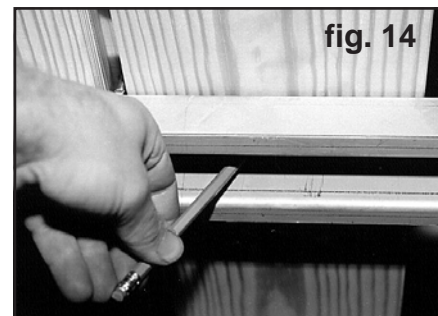
14. Slide the two center-hole cross sill brackets onto the front cross sill (identified by the hole pattern on the side leg of the cross sill), and attach the front cross sill to the first angle strip bolt from the front bed panel. This cross sill also bolts to the front bed panel with nine 1/4"-20 x 5/8" hex head bolts, lock washers, and nuts supplied with the front panel hardware. See figure 12.



15. *If the truck is a 47 or 48 and you are using the original style gas tank mounted under the bed near the front, the second cross sill will have to be trimmed to fit over the gas tank.* The second cross sill has brackets that are not necessary for installation, but were original. Slide the two offset-hole cross sill brackets onto the third cross sill from the front bed panel, with the holes offset toward the bed sides. Attach the second and third cross sill to the 5/16 angle strip bolt approximately **26-7/8"** and **53-7/16"** respectively from the front bed panel. See figure 13. Install lock washer and nut hand tight.



Note: The next step is to drill and countersink the locations for the bed-to-frame bolts and offset washers that sit on the top of the wood surface. If wood was purchased with the frame holes predrilled, skip to step 26. If wood was purchased without holes, the following steps will direct you through this process.

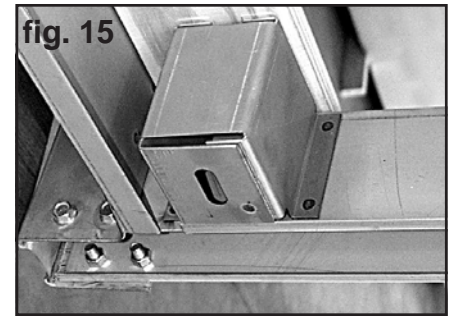


16. Install the second board on each side next to the edge board from step #13. Leave a 1/2" gap between them. Install a bed strip between these boards and secure it to the cross sills and the rear cross sill with the 1/4"-20 x 1-1/4" carriage bolts, lock washers, and nuts. *If using MAR-K's custom bed strips with hidden fasteners, follow the instructions supplied with the bed strips for correct installation.*

17. The first cross sill near the front bed panel is the first bed-to-frame hole location. Mark the bottom of the second board from each side through the 1/2" diameter cross sill holes that are **36-5/8"** apart from center of hole to center of hole. See figure 14.

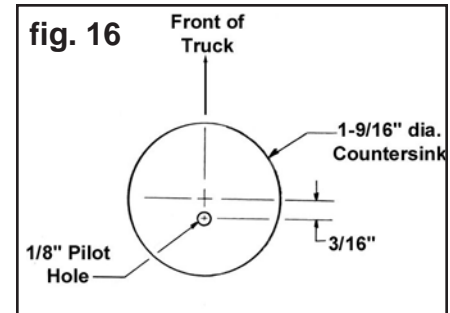
18. The second bed-to-frame bolt location is in the third cross sill counting back from the front bed panel. Mark the bottom of the outer two wood boards through the 1/2" diameter cross sill holes that are **44-1/4"** apart from center of hole to center of hole. The second cross sill does not have a bed-to-frame bolt. See figure 14.

19. The third bed-to-frame bolt location does not pass through a cross sill. There are two brackets attached to the rear cross sill. These large brackets should fit against the bottom of the outer wood boards on each side. See figure 15.



20. Mark the bottom of the outer wood boards through the big brackets. The spacing of the bracket holes in reference to each other should be **44-1/4"** apart. This mark should be **73-1/4"** back from the front of the wood boards to the center of the mark.

21. Make reference as to which end of each board is at the front of the bed. Remove the bed strips, cross sills, and the 4 boards. The bottom side of these boards should now have 1/2" diameter holes marked on them. Drill a 1/8" diameter pilot hole through the center of each mark completely through the boards.



22. On the top surface of the boards, measure 3/16" from each pilot hole toward the front of each board and mark the boards for the countersink. See figure 16.

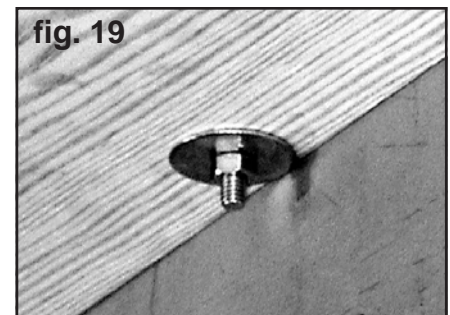


23. Using a 1-9/16" diameter Forstner bit, a drill press if available, or a hand drill, countersink each location approximately 1/8" to 5/32" deep. See figure 17.

24. From the top surface, drill through the 1/8" pilot holes with a 1/2" drill bit to complete the bed-to-frame holes. See figure 18. Before drilling the hole, place a piece of scrap wood directly under the 1/8" hole to prevent splintering as the drill breaks through.



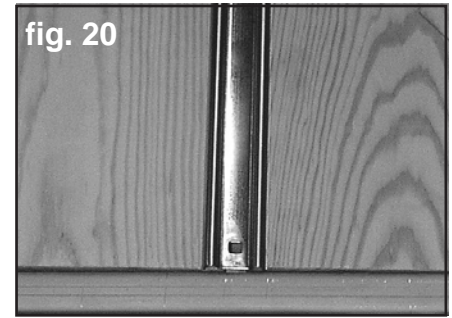
25. Reinstall the side boards. The front cross sill gets the center hole brackets. All brackets should line up with the bed-to-frame holes in the sills and wood when reassembled.



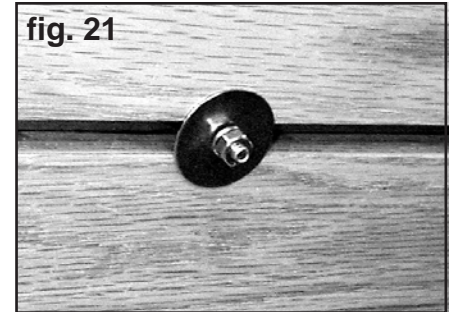
26. Tack weld the cross sill brackets in place on the sills. Make sure that the bed-to-frame spacing measurements are the same as listed in steps 17, 18, and 20.

27. Where there is not a cross sill attached to the angle strip bolts, install a 1-1/2" outside diameter flat washer with a 5/16" diameter hole on the bottom of the wood surface before installing lock washer and nut hand tight. See figure 19.

28. Place the next boards from step #17 into position on both sides leaving approximately a 1/2" space between the boards. Place a bed strip in the grooves on top of the boards. The end of the strip with the hole closest to the end is positioned on the rear cross sill. See figure 20. The cross sill holes should line up to a bed strip hole. Loosely install the 1/4" bed strip bolts, lock washers, and nuts.



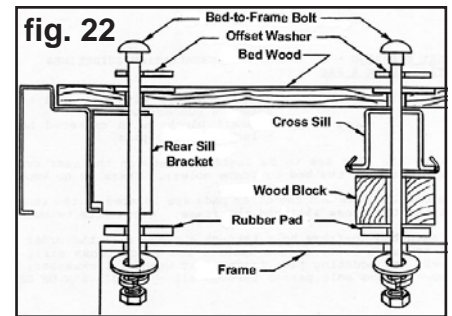
29. Where there is not a cross sill under the bed strip bolt, install a 1-1/2" outside diameter washer with a 1/4" diameter hole before installing lock washer and nut. See figure 21.



30. Continue installing boards and strips from both sides working towards the center. Remember not to tighten down any bolts completely to leave room for adjustment of boards and or strips from side to side.

31. After the spacing between the bed strips and wood boards has been adjusted, tighten all bed strip and angle strip bolts.

32. Install the completed bed assembly to the truck frame. This will enable you to check the alignment of the bed-to-frame locations. The order in which parts are installed to the frame is: rubber pad, wood blocks, and bed assembly. See figure 22. The offset wood blocks go on the third cross sill from the front bed panel with the offset brackets. The holes are offset to the outside.



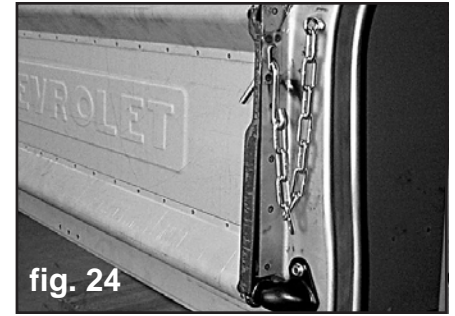
33. After checking alignment of bed assembly to cab and frame mounting holes, install the bed-to-frame bolts and offset washers through the top of the wood. The 3/8-16 X 12" long bed bolts go through the front pair of frame mounting locations. The rest are only 6" long. Install the flat washers, lock washers, and nuts.



34. Attach one hinge onto passenger bed side rear stake pocket. Secure with (2) 5/16"-18 x 3/4" indented hex head bolts. Install tailgate to this hinge. Install second hinge into other end of tailgate. Bolt second hinge to driver stake pocket. See figure 23.

35. Install tailgate chain eyebolts into stake pockets. This model has a left and right tailgate chain hook. See figure 24. Secure with 5/16" lock washers and nuts.

36. You have assembled the entire bed. Check all parts for correct fit and alignment. Be sure the bolts are in place and that all dimensions are correct. Now remove the bed from the frame and disassemble the parts to prepare for painting.



FINAL ASSEMBLY

After the parts are painted, the bed is assembled by the same procedure. By taking the time to assemble and test fit the bed before painting, you have reduced the chances for errors or problems in final assembly.