



INSTALLATION INSTRUCTIONS FOR MAR-K'S 54-87 GM STEPSIDE TAILGATE WITH HIDDEN TAILGATE LATCHES & LINK ASSEMBLY

1. Assemble the bed and make sure the box is square. Measure the distance between the bedsides at the floor level and the top. This width should be 50". Also measure cross wise from one front corner to the opposite rear corner in both directions. These measurements should be within 1/16" of each other.



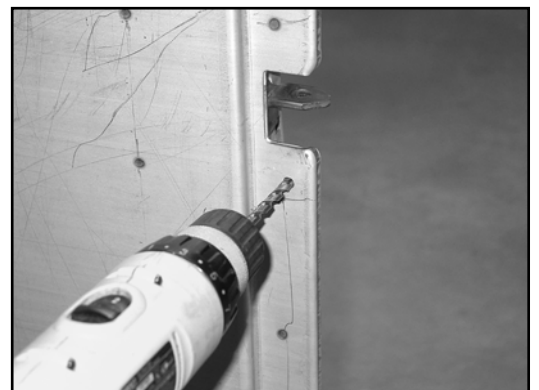
2. Install the trunnions and tailgate and make sure it is aligned to your satisfaction. The trunnion bolt hole in the bottom of the bedsides is slotted to allow adjustment of the tailgate to the bedsides. The tailgate should be adjusted to be nearly touching the rear sill when closed but no more than 1/32" gap. Check the operation of the tailgate. Make sure it operates freely without binding.



3. Remove the tailgate and the trunnions from both bed sides. Use the template provided to locate the hole for the upper fixed pivot pin for the link straps. Bolt the template to the trunnion hole on the inside of one bedside with the hardware provided. Place the two washers between the template and the bedside. The notched side of the template should be facing the bedside. Mark the bedside through the templates upper hole.



4. Remove the template and center-punch this location. Drill a 5/16" hole through the bedside at that location. Do this for both bed sides and debur the drilled holes.



5. Install the fixed pivot pin into each of the 5/16 holes drilled in step 4. Use the 5/16" diameter button head screw to attach each pivot pin. Place the stainless washer over the fixed pivot pin before bolting it to the bedside. The screw head is on the outside of the bedside and the fixed pivot pin is on the inside of the bedside. Tighten the fixed pivot pin so that its flat edges are horizontal as shown in the photo.



6. Re-install the tailgate and align it as before. Open the tailgate and support it so that it is in the horizontal position.



7. Bolt the link assemblies to the tailgate ends using the supplied 1/4-20 x 1/2" button head screws and 1/4" lock nuts. Place the nuts on the same side of the tailgate ends with the links. This will make only the button heads visible when the tailgate is shut.



8. Raise the tailgate assembly while folding the link assemblies upward. Align the slot in the link assembly to the flat sides of the pivot pin and slide the link onto the pivot pin. Lower the tailgate back to the open position while letting the link assemblies support the tailgate.



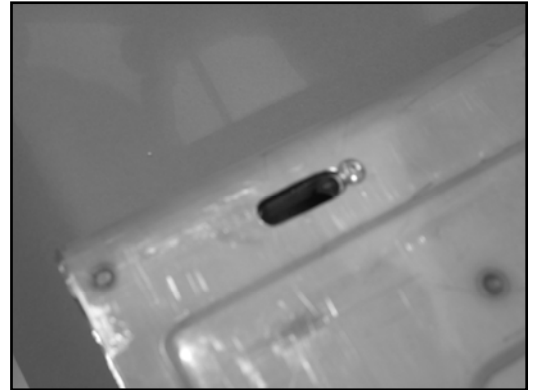
9. Carefully raise the tailgate to the closed position. The links should fold smoothly downward and then into the tailgate end as the tailgate is raised. The tailgate should move to the fully closed position without causing any binding in the link assembly.



10. Lower the tailgate down to the open position again. Next you need to install the hidden latch barrels into the tailgate ends. It does not matter which one goes into which end of the tailgate at this time. Slide the latch sleeve into the tailgate through the 5/8" hole until the small threaded hole lines up with the small hole in the tailgate.



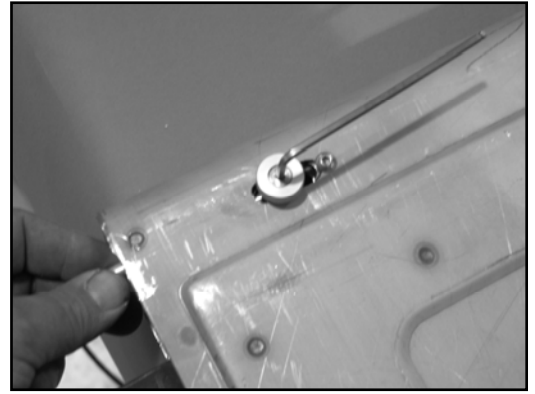
11. Thread the 10-32 button-head screw through the tailgate into the latch sleeve and tighten with the supplied 1/8" hex wrench. Check the alignment of the slot in the tailgate with the slot in the latch sleeve.



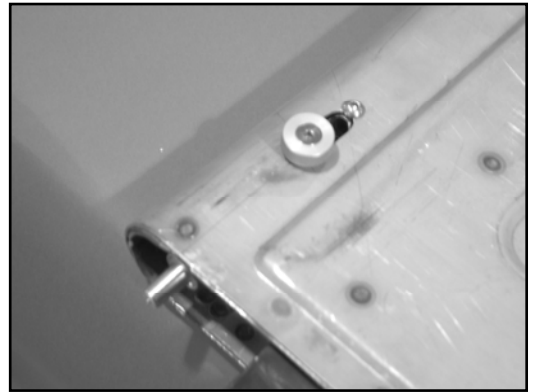
12. Install the spring on the plunger and slide it into the latch sleeve. The plunger has an angle cut on it that has to match the machining on the barrel. A liberal amount of your favorite grease on the plunger is recommended before final assembly.



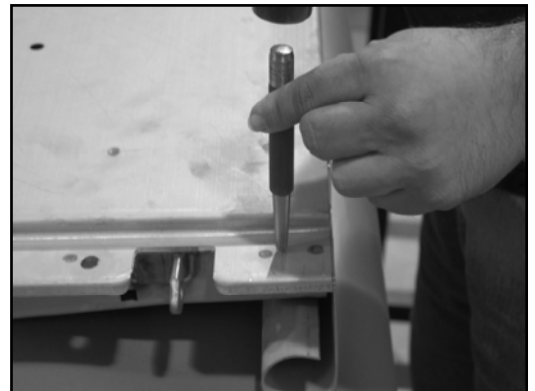
13. Push in on the plunger and position the aluminum knob with the stainless shoulder screw. Thread the screw into the plunger and tighten the screw with the 1/8" hex wrench.



14. Test the movement of the plunger by sliding it back and fourth. Pull the plunger all the way back and twist the knob to lock it in the retracted position. Make sure both latches are retracted and shut the tailgate. Hold the tailgate tight against the bedsides and release the latches by twisting the knobs. The latches have a pointed tip that will mark the bedsides for the rubber grommet to be installed. You may want to place masking tape on the bedsides where the plunger will make its mark. This will aid in seeing the marked position.



15. Lower the tailgate and support it in the open position. At each marked location on the bedsides, you need to drill a 5/8" diameter hole. It is better to start with a small drill and work up to the 5/8" diameter to ensure a more uniform round hole.



16. Insert the supplied rubber grommets into the bedside holes.
Close the tailgate and release the latches into the grommet.



Another Outstanding Part Manufactured in Oklahoma City, USA by



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