



**INSTALLATION INSTRUCTIONS FOR TAILGATES WITH HIDDEN LATCH & LINK
FOR 34-39 GM STEPSIDE TRUCKS**

**TOOL LIST FOR TAILGATE CHECK LINK STRAPS
FOR 34-39 GM STEPSIDE TRUCKS**

Vise Grip Clamps – C-clamps

Sharpie Marker

Ball Peen Hammer

Center Punch

3/8" or 1/2" Drill

3/8" and 1/4" Drill Bits

Masking Tape

5/32", 1/4" and 3/16" Allen Wrenches

Tape Measure

17/32" Drill Bit **(this part is available from MAR-K separately, if needed).**

Round File

Small Flat File

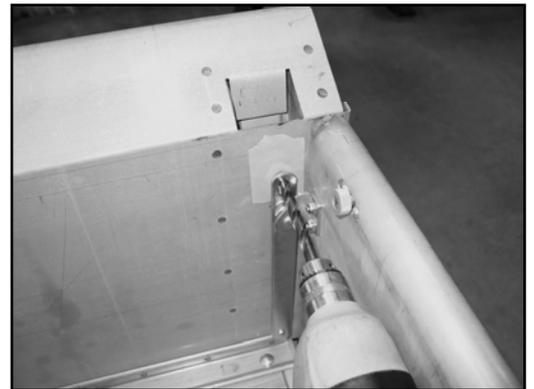
1/2" Open-end Wrench

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 45-3/4". 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 hinges and tailgate and make sure it is aligned to your satisfaction.
3. Support the tailgate in the horizontal (open) position.
4. Attach the link assembly to the tailgate with two 1/4-20 x 1/2" button head screws. Tighten the screws with a 5/32" Allen wrench. It is important to notice that there is a left and right link assembly due to the pivot bracket of the link assembly. The offset part of the bracket where the rivet is should be at the bottom. This is the passenger side link shown installed. The tailgate is shown with the hidden latch already installed but we will get to that later.

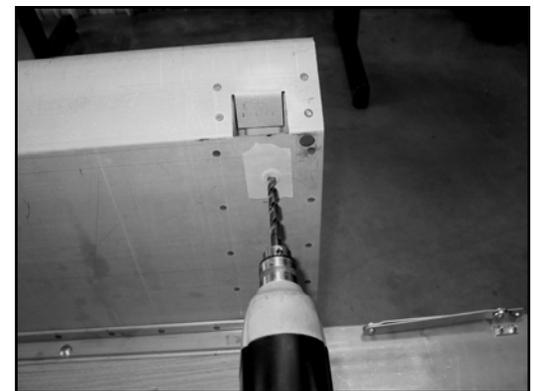


Note: If you have purchased Mar-K bedsides with the bedside upgrade for hidden latch & link, you may proceed to step # 7.

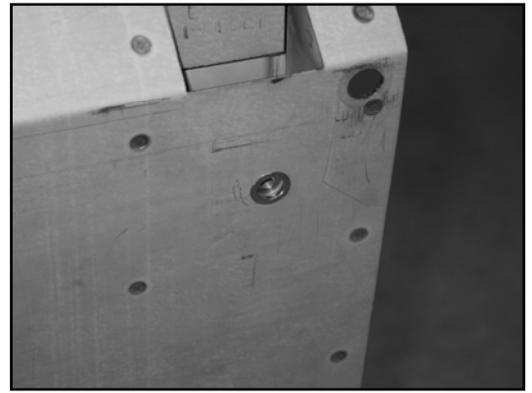
5. Now you need to position the upper pivot for the link assembly. Fold the link assembly as it would be when the tailgate is shut and lift the tailgate to the closed position. The link should be hanging vertical. Using a 3/8" diameter bit in a drill, place the drill bit through the slotted end of the link assembly as shown. Lift the drill bit to the top of the slot. Lightly drill the bedside with the drill bit just to leave a mark. Do this for both bedsides.



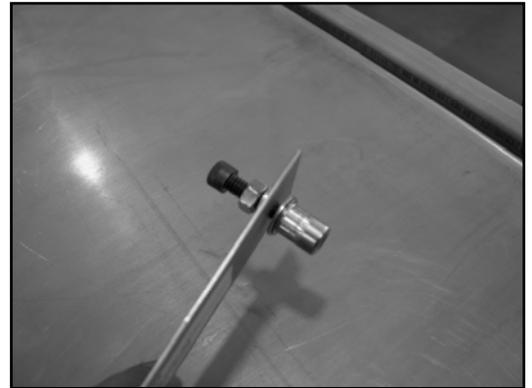
6. Lower and support the tailgate once again. Measure in from the back edge of the bed side 2-1/8" at the same vertical position as the drill mark and make a mark. Center-punch this position. Drill this position on each bedside with a 1/4" drill bit. Now drill this hole to a final size of 17/32".



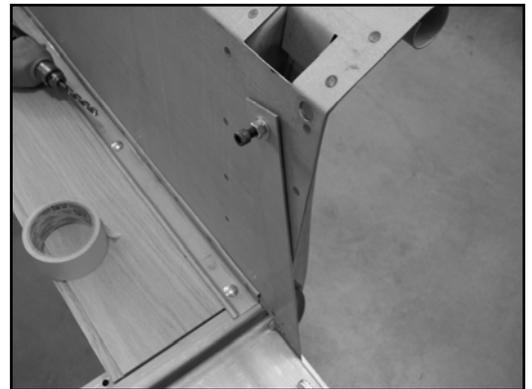
7. Test fit the threaded insert into the 17/32" diameter hole. Use a round file to enlarge the hole if the insert will not fit. Often, a drill will not make a perfectly round hole in sheet metal. Use the file to make the hole round. The insert must be installed so that its' flange is against the sheet metal surface of the bed side.



8. Special tools are available to squeeze the threaded inserts but we will show you how to do this without these special tools. Obtain the 5/16"-18 x 1-1/2" bolt and 5/16 hex nut supplied in the kit. Thread the hex nut about 1" onto the bolt. Place the bolt through the supplied flat washer and then through the 5/16" diameter hole at the bottom of the marking template. Next thread the insert onto the bolt with the flange of the insert towards the template finger tight against the template.



9. Place the insert into the hole in the bed side. Make sure to hold the insert flange tight against the bed side. Allow the template to rotate downward to the hinge area of the tailgate. This template will act as a handle to keep the insert from rotating when the nut is tightened.



10. While holding the bolt head steady with a 1/4" Allen wrench and continuing to hold the insert flange tight against the bed side, start turning the nut off of the bolt with a 1/2" wrench. This will pull the bolt outwards and start compressing the threaded insert. The hex nut will be fairly hard to turn, so be prepared to exert some force on the nut. Turn the nut until it will not turn any more and the insert will be fully installed. Now remove the bolt, hex nut, washer, and sheet metal handle.



When repeating this procedure on the driver's side, the template will be positioned against the base of the bed side. Protect this area with a scrap piece of cardboard or wood. If you need further explanation of this procedure, go to www.mar-k.com and click on the Installation information on the home page. Scroll down to "Other helpful information" and click on "Threaded insert Information".

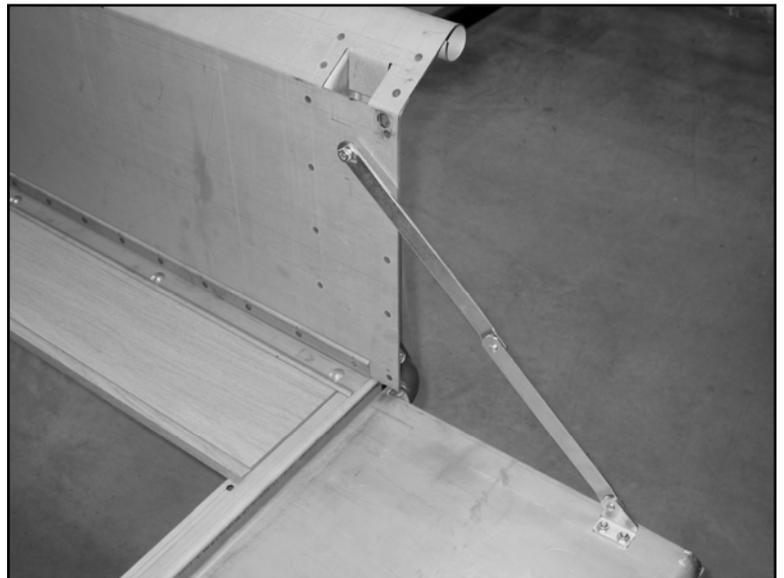
11. Supplied in the kit are 5/16"-18 shoulder screws and washers to act as upper pivots for the link assemblies. Place the bolts through the slotted end of the links. Then place the washer on the bolt. Thread these bolts into the threaded inserts. The washer keeps the link from scraping the bed side. Tighten these bolts with the 3/16" Allen wrench.



12. Raise the tailgate slowly to the closed position. The links should fold smoothly downward while closing. Supplied in the kit are two self-adhesive bumpers. Attach these bumpers where the link assembly will contact the tailgate when closed.



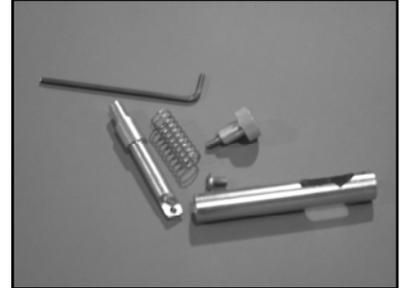
You have successfully installed the link assemblies. At final assembly, use a thread locking compound on all threaded areas to prevent them from coming loose. This kit is greatly complimented with our hidden tailgate latch which is Part # 100265 shown already installed.



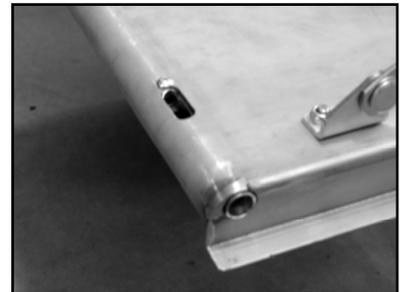
INSTALLATION INSTRUCTION FOR HIDDEN TAILGATE LATCHES ON 34-39 GM STEPSIDE TRUCKS

This instruction covers the installation of the hidden tailgate latches for the 34-39 GM Stepside trucks. Follow along as we say "Good-Bye" to those tailgate chains.

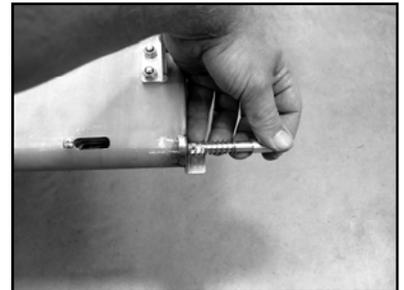
1. Check the alignment of the tailgate to the bedsides. If necessary adjust the position of the tailgate hinges.
2. Disassemble the hidden latches by removing the aluminum knobs and the mounting screws. Slide the plungers and the springs out of the latch sleeves. Remove the #10-32 button-head screws from the latch sleeves.



3. 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. 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.



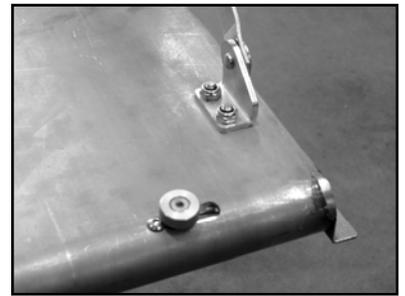
4. Install the spring on the plunger and slide it into the latch sleeve. A liberal amount of your favorite grease on the plunger is recommended before assembly.



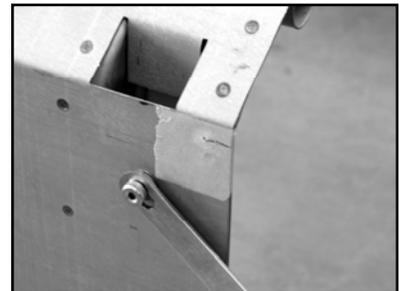
5. Push in on the plunger and position the aluminum knob with the stainless shoulder screw. Thread the screw into the plunger and tighten the screw with the 1/8" hex wrench.



6. Test the movement of the plunger by sliding it back and fourth. Also pull the plunger all the way back and twist the knob to lock it in the retracted position. If the knob rubs on the tailgate or will not retract far enough to lock, you will need to enlarge the slotted hole in the tailgate with a file until full movement is obtained.



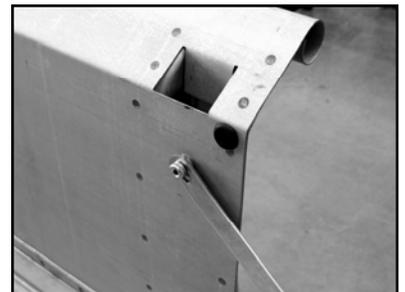
7. Place some masking tape onto the top rear corners of the bed sides as shown. Make sure both latches are retracted and shut the tailgate. Hold the tailgate tight against the bedsides and release the latches by twisting the knobs. The latches have a pointed tip that will mark the tape on the bedsides for the rubber grommet to be installed. If you have purchased Mar-K bedsides with the bedside upgrade for hidden latch & link proceed to step #9.



8. 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. Again, it is better to start with a small drill and work up to the 5/8" diameter to ensure a more uniform round hole. If you have access to a step drill, these tend to make perfectly round holes in sheet metal.



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



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