

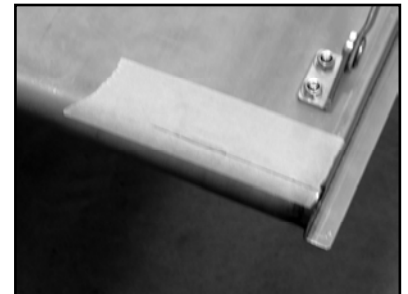
MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

INSTALLATION INSTRUCTION FOR HIDDEN TAILGATE LATCHES ON 34-40 GM STEPSIDE TRUCKS

This instruction covers the installation of the hidden tailgate latches for the 34-40 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. Remove the tailgate from the truck by unbolting one of the lower hinges from the lower stake pocket. Also remove the chain assemblies from the stake pockets. Lay the tailgate on a flat surface with the inside of the tailgate facing up. This can be done with the tailgate on the truck, but we chose to remove it.
3. Measure down from the top curl of the tailgate 11/16" on the inside and mark the tailgate near its edge. Using a square, draw a horizontal line on this mark approximately 4" long from the edge. Do this for both sides of the tailgate. Mar-K's hidden link assembly is shown already installed, but that is a topic for a different instruction.



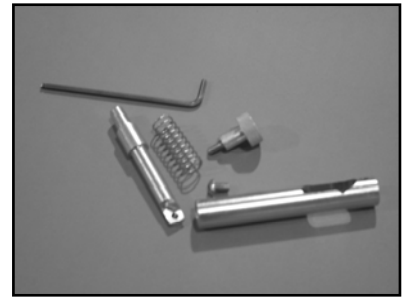
4. Measure in from the edge of the tailgate 3-5/8" and mark the tailgate on the line drawn in step #3. Center punch this mark and drill a 3/16" diameter hole. You may want to use a drill stop so that the drill point does not damage the tailgate on the outside when it breaks through. Make two other marks on this same line at 3-1/4" and 2-1/2" respectively. Center punch these two marks and drill them with a 3/8" drill. It usually works better if you start with a small drill bit and work your way up to the 3/8" diameter.



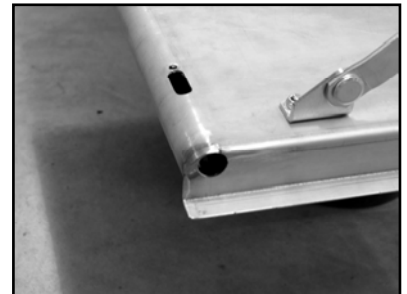
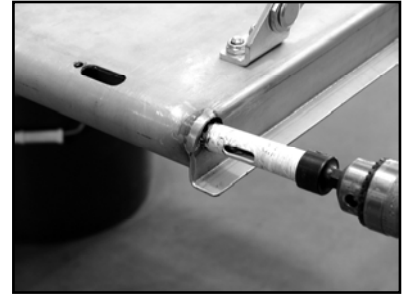
5. Using a small high speed cutting wheel, connect the two 3/8" diameter holes by cutting the metal out between them. This will create the slot that the knob on the latch will slide in.



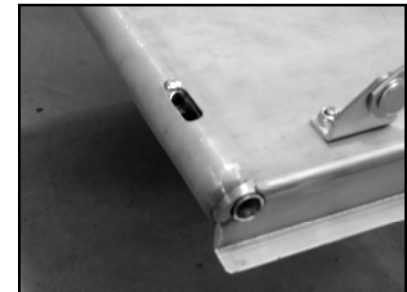
6. Disassemble the hidden latches by removing the aluminum knobs and the mounting screws. Slide the plungers and the springs out of the latch sleeves. Remove the #10-32 button-head screws from the latch sleeves.



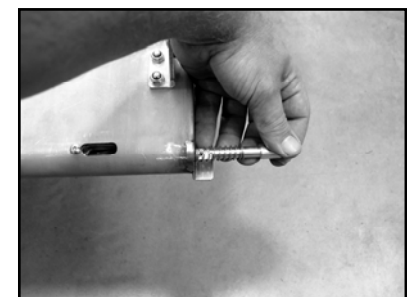
7. You need to mark and drill a 5/8" diameter hole in the tailgate ends for the hidden latch sleeve to slide into. This hole should be in line with the mark made on the tailgate skin and the latch sleeve should fit tight against the tailgate end. Mark the tailgate end 5/16" down from the surface where the latch sleeve will fit. When drilling, start with a smaller bit and work up to the 5/8" drill. You want to have a nice round hole for the latch sleeve. When finishing the hole with the 5/8" drill, it will be rubbing on the tailgate end material. This will keep the latch flat against the inside wall of the tailgate. You may find it necessary to use a round file after drilling the 5/8" hole to fit the latch sleeve. You will want to keep this a tight fit to keep the latch from moving around.



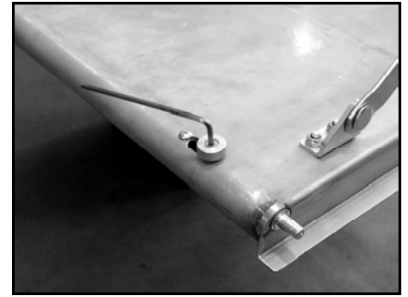
8. Slide the latch sleeve into the tailgate through the 5/8" hole until the small threaded hole lines up with the small hole in the tailgate. Thread the 10-32 button-head screw through the tailgate into the latch sleeve and tighten with the supplied 1/8" hex wrench. Check the alignment of the slot in the tailgate with the slot in the latch sleeve.



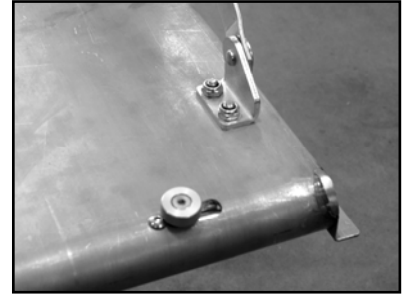
9. Install the spring on the plunger and slide it into the latch sleeve. A liberal amount of your favorite grease on the plunger is recommended before assembly.



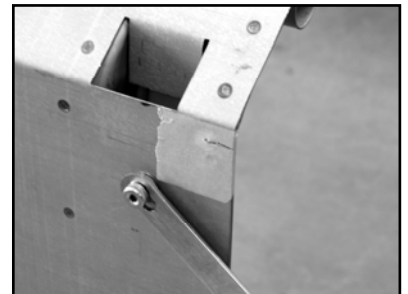
10. Push in on the plunger and position the aluminum knob with the stainless shoulder screw. Thread the screw into the plunger and tighten the screw with the 1/8" hex wrench.



11. 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.



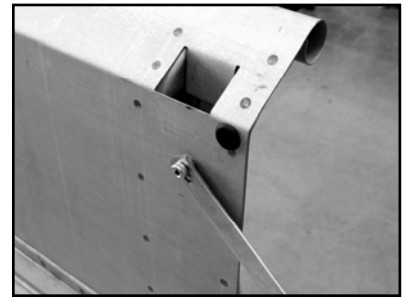
12. Place some masking tape onto the top rear corners of the bed sides as shown. Once the latches are installed on both ends of the tailgate, re-install the tailgate on the truck. Make sure both latches are retracted and shut the tailgate. Hold the tailgate tight against the bedsides and release the 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.



13. 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.



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



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