

MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

INSTALLATION INSTRUCTIONS FOR TAILGATE CHECK LINK STRAPS FOR 58-66 GM FLEETSIDE TRUCKS

1. Install the trunnions and tailgate and make sure it is aligned to your satisfaction. The trunnion holes are slotted to allow adjustment of the tailgate to the bed sides. 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.
2. Remove the chain and pivot bolt from the bedside. The pivot bolt threads into the bedside and has a jam nut on the outside. Break the jam nut loose and thread the pivot bolt out. Also remove the latch eye bracket from the tailgate. It is held in place by two bolts through the tailgate end. The latch eye bracket must be removed from the outside of the tailgate skin. Pull it out, pivot it down and twist and it should come out.
3. Remove the threaded bracket bolted to the upper bedside as shown. This bracket contains the threads for the pivot bolt. If these upper brackets are welded to the bed sides, see additional instructions for the bed side modification kit Part number 100291 from Mar-K



4. Locate the new upper link pivot brackets from the kit. There is a left and right hand side because of the angled cut and the hole pattern. These will only fit on one way.



5. Bolt the new upper link pivot bracket to the two holes where the threaded bracket was just removed. You must re-use the old hardware. Do this on both sides.



6. In order for the link assemblies to fold up inside the tailgate ends when closed, some material will need to be removed from each end of the tailgate. A template has been provided to mark the tailgate for these cuts. Align the template to the edge of the tailgate and the bottom of the curl of the tailgate as shown.



7. The template will rest above the surface due to the embossment in the skin. Clamp the template in place so that it remains flat. Scribe the shape onto the tailgate keeping the scribe vertical. The width of the material to be cut out should be $\frac{3}{8}$ inch except for the bottom area where the rivet of the link assembly passes when folded. That depth is $\frac{1}{2}$ inch. Use this template to mark both ends of the tailgate.



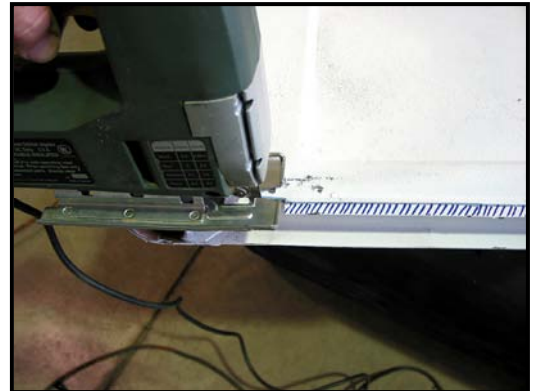
8. Cut out the area indicated by the template (shown by the cross-hatch pattern) with a jig saw, high speed cutting wheel, or plasma cutter. We chose the jig saw method.



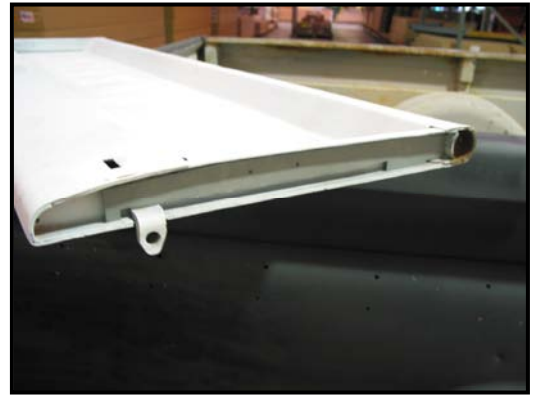
9. We decided to remove the tailgate for this step. Starting at the bottom, cut straight in to the 1/2-inch depth. Do this at both edges of the deeper part of the notch. Then cut at angles until the deep notch is completely cleared out.



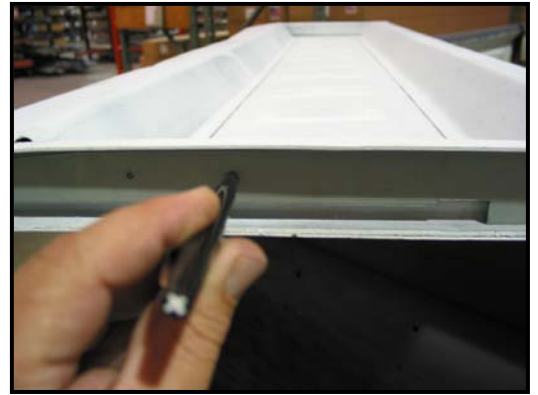
10. Cut up the straight line towards the upper ear of the tailgate until you make contact with the ear. We used a rotary tool with a reinforced cutting wheel to finish out the top cut. While cutting on the tailgate, the jigsaw will rest on the embossed area of the tailgate. Make sure to keep the jig saw flat and not tilted. Make this cut on both ends of the tailgate.



11. When cutting these areas out, you may have cut through a few spot welds that hold the tailgate skin to the tailgate ends. If needed, place a couple of small tack welds on the tailgate skin and ends and grind them down smooth. We cut through the center of some welds, but the tailgate skin was still welded and not detached.



12. Using the same template as in step 6 & 7, we now need to mark the holes where the pivot bracket of the link assembly will attach to the tailgate. Turn the tailgate outside up and place the template in the tailgate end as shown. Make sure that the bottom of the template is against the trunnion bracket in the bottom of the tailgate end and that it is touching the inside surface of the tailgate end as shown.



13. Mark the tailgate end through the holes in the template. Mark both ends of the tailgate with this template.



14. Center punch these four marks and then drill them to 1/4" diameter.



15. Re-install the tailgate back on the bed as before. Support the tailgate in the horizontal position. Attach the pivot bracket on the link assembly to the tailgate using the 1/4-20 button head screws and lock nuts supplied in the kit. The head of the bolt should be on the visible side of the tailgate end when closed and the nut should be on the pivot bracket side.



16. While lifting the tailgate, fold the link assembly in the upward direction. Align the oblong hole in the link assembly with the pin on the upper bracket bolted to the bedside. Slide the link assembly on the pin. Lower the tailgate to the open position.



17. Raise the tailgate again. This time make sure that the link assembly folds downward. Check that the tailgate will close completely without binding.

18. Removal of the chains has left a few holes to be welded closed. The kit provides two 7/8" diameter pieces of metal for the holes in the bed sides. Grind the paint from around these areas. Fit the patches into the depressions and hold in place with a magnet. Tack weld these pieces in place. Continue welding until the area is completely filled with weld. Do this slowly and move from bedside to bedside to avoid too much heat build up.



19. If a full tailgate cover is to be used, weld the bolts holding the link assembly to the tailgate ends in place. This will allow you to still remove the link assemblies if needed after the full tailgate cover has been installed.

©Copyright 2007 MAR-K Quality Parts L.L.C. All rights reserved.

Another Outstanding Part Manufactured in Oklahoma City, USA by

