



INSTALLATION INSTRUCTIONS FOR THE TAILGATE WITH LATCHES AND LINK ASSEMBLY FOR FORD 53-72 SHORT FLARESIDE TAILGATE

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 **49"**. 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. Remove the chain assemblies if so equipped.



2. Place some masking tape over the hinge attaching locations on one of the bedsides. Install the hinges and the new tailgate and make sure it is aligned to your satisfaction.



3. Mark the location of the hinge onto the masking tape so that it may be removed and re-installed in the same exact location.



4. Remove the hinge marked in step # 3 above and remove the tailgate. Install the hinge back into position using the marked masking tape as a guide.



5. Slide the template provided onto the hinge far enough that the template can lay flat against the inside of the bedside. The outer edge of the template should be even with the outer edge of the bedside. Clamp the template in place. The template has been painted a dark color for the photo.



6. Mark the bedside through the two small 1/8" diameter holes in the template. These will be the location for the latch striker and the upper link mounting position.



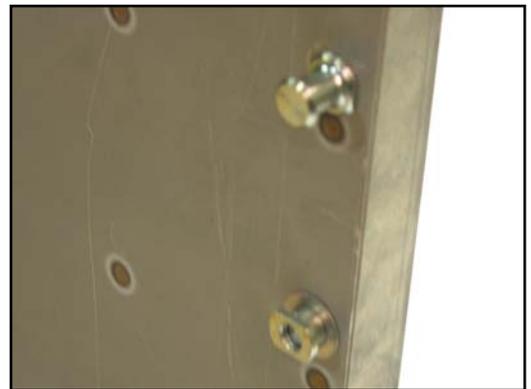
7. Remove the template and center punch these locations and drill 5/16" holes through the bedside. Remove the burr from both holes on the inside and outside. Repeat steps #5 through #7 for both bed sides.



8. Using the 5/16-18 button head screws, install the latch strikers in the upper hole on each bedside. The latch striker can be held with a 9/16" wrench while tightening the button head screw.



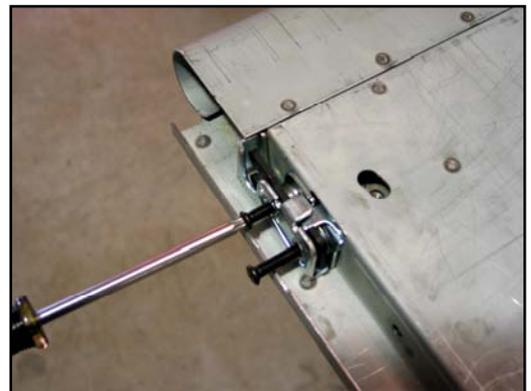
9. Next install the link assembly pivot onto both bed sides through the lower holes using the 5/16-18 button head screws. Place the provided stainless flat washer on these pivots before attaching to the bedside. This keeps the link assembly from rubbing directly on the bedside. The link assembly pivot can be held with a 7/16" wrench while tightening the button head screw. Position the flats of this pivot horizontal as shown. Both of these items should be on the inside of the bedside with the button head screws on the outside.



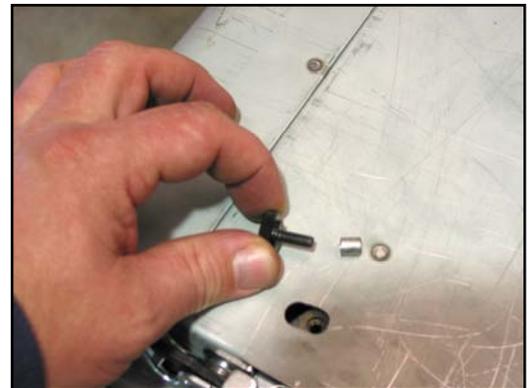
10. Re-attach the tailgate using the masking tape mark for the hinge location reference. Support the tailgate in the horizontal or open position.
11. Bolt the latches to the tailgate on each end. The latch has an actuating arm with a nut attached to it that must fit through the slot in the tailgate as shown.



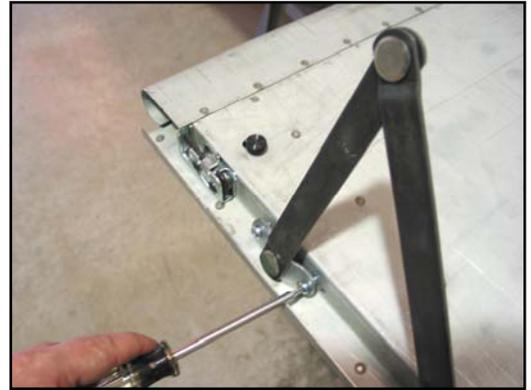
12. Each latch is held to the tailgate with (2) metric M6-1.0 x 30 mm Phillips flat head screws provided in the kit. You should be able to see the actuating arm and nut through the slotted hole in the tailgate skin.



13. The latches are released by a black knob provided in the kit. Each of these black knobs needs to have an aluminum threaded spacer fitted to it. Thread the spacer onto the knob completely and then thread the knob into the tailgate latch through the slotted hole.



14. Bolt the link assemblies to each end of the tailgate. These are held in place by (2) ¼-20 x ¾" button head torx screws provided in the kit. Use a T27 torx driver to tighten these screws.



15. Lift the tailgate while directing the link assembly arms to the pivots attached to the bedsides. The link assembly arms will need to be folded in the upward direction for this. Lift the assembly until the slot in the link will fit onto the pivot.



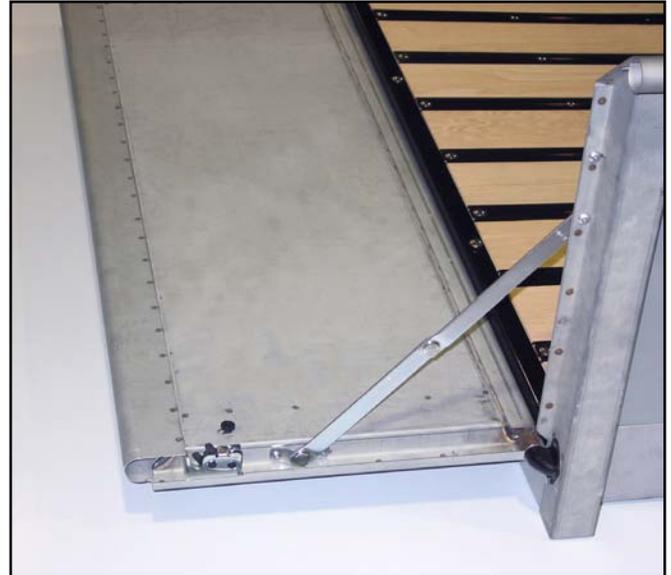
16. Lower the tailgate back to the horizontal (open) position. Release both latches by moving the black knob towards the top of the tailgate.



17. Raise the tailgate slowly making sure that the links fold downward this time. Close the tailgate slowly while checking for any interference. The latches will make a double clicking noise when latched slowly. Release the latches to check their operation. It may require slight inward pressure on the tailgate to release the latches.



18. You have successfully installed your new tailgate with the latches and links. Now disassemble the tailgate by removing the latches and links and remove the tailgate from the bed assembly. Prepare the tailgate for painting. After painting, re-install the latches and link assemblies. Use a good thread locking compound on the hardware during re-assembly. It is left to the customer to decide whether to fill in the eyebolt holes left in the stake pockets after the chains are removed.



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