

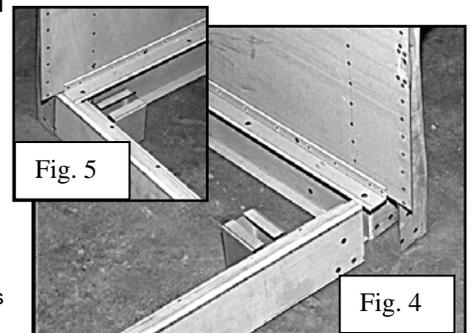
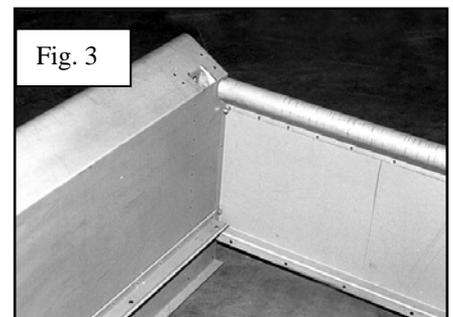
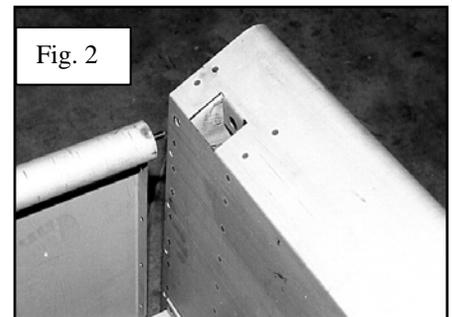
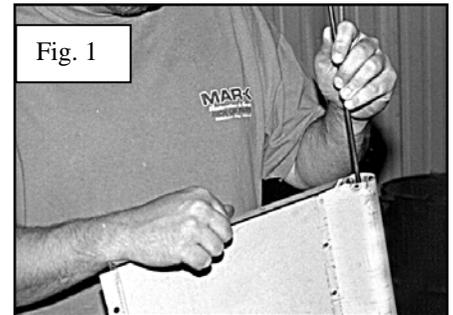
MAR—K

RESTORATION AND CUSTOM PICKUP PARTS

BED PARTS ASSEMBLY GUIDE 47-53 GM 1-TON LONG STEPSIDE

If you have not yet disassembled your original bed, make notes and sketches and take pictures of part locations to aid in the assembly procedure. Use the following steps to assemble the entire bed to test fit all parts.

1. Begin by installing a 5/16" flat washer, lock washer, and nut onto one end of the front panel tie rod. Stand the front bed panel on end and insert the tie rod end without hardware into the front bed panel curl plug. While looking down through the curl, align the tie rod with the opposite end curl plug of the front panel. See figure 1.
2. Insert the tie rod end without hardware through the top hole in the bedside. Secure with a 5/16" flat washer, lock washer, and nut. Bolt the front bed panel side flange to the inside of the bed side with (4) 1/4"-20 x 5/8" hex head bolts, lock washers, and nuts. See figure 2.
3. Remove the 5/16" hardware from the other end of the front panel tie rod. Install this end through the other bedside. Replace the 5/16" hardware.
4. Bolt the front bed panel to the other bed side with (4) 1/4"-20 x 5/8" hex head bolts, lock washers, and nuts. See figure 3.
5. Fit the rear cross sill into the lower portion of the rear stake pockets. The open side of the rear cross sill should be facing downward. See figure 4 and figure 5*. The bracket and flanged side of the rear sill faces toward the front bed panel.
6. Using (10) 5/16"-18 x 3/4" hex head bolts, lock washers, and nuts, bolt the rear cross sill to the rear stake pockets. Leave the top two holes for tailgate hinges empty for now.

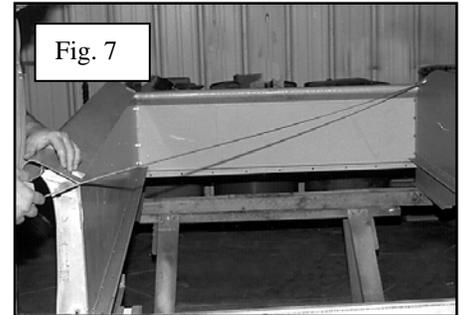


*1/2 Ton picture shown. On the 1 Ton, the brackets will be slightly more towards the inside.

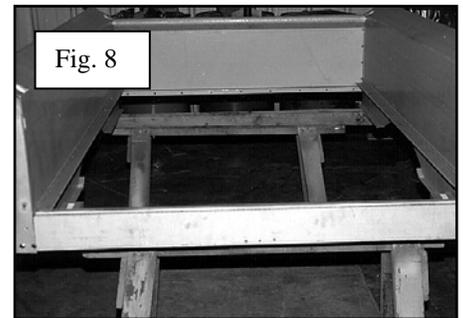
7. Once these four pieces of the bed are assembled, you will need to make sure your bed is square. Measure the bed width at the top and bottom of bed sides to ensure that the bed sides are straight up and down and are **50"** apart. See figure 6. Tighten rear cross sill bolts.



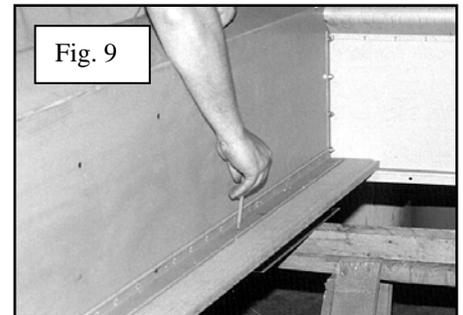
8. Also measure crosswise from the front of the bed to opposite rear of the bed on both sides. See figure 7. These measurements should be within 1/16" of each other to ensure bed squareness. Now tighten all bolts.



9. Place the assembly on supports horizontally to gain access to the top and bottom of the bed floor area. See figure 8.

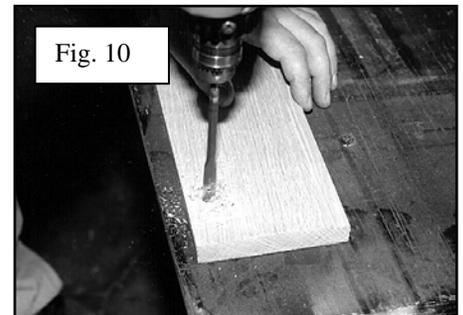


10. Place the wood board that has only one bed strip groove (referred to as "edge boards") under the angle strip on the bedside. See figure 9. The non-grooved edge should be toward the bed side. Leave a 1/16" gap between the bedside and the board.

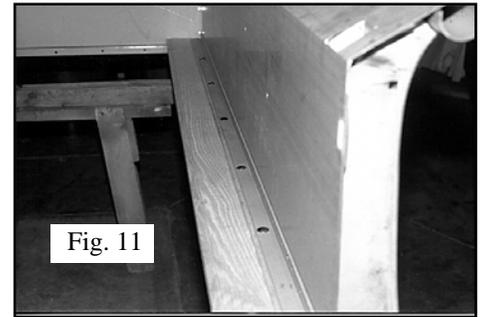


11. Mark all holes to be drilled into the wood boards through the angle strips square holes. See figure 9.

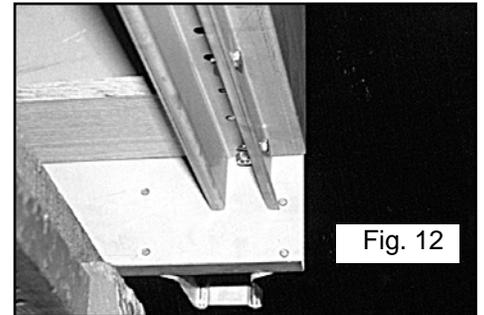
12. Remove these two boards and drill all holes marked using a 3/8" wood bit. Be careful not to splinter the other side of the board when drilling. Placing a scrap wood block behind the board where drilling will help prevent this. See figure 10.



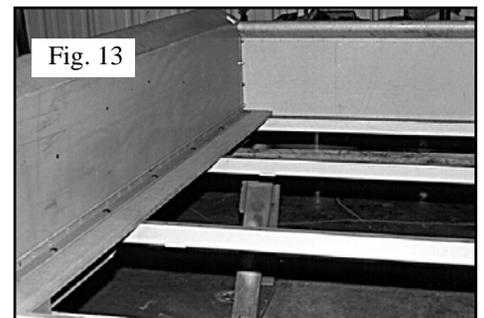
13. Install the edge boards underneath the angle strips as in step #10. Place 5/16"-18 x 1-1/2" carriage bolts through the angle strips and through the boards. See figure 11. Leave off the lock washer and nut for now.



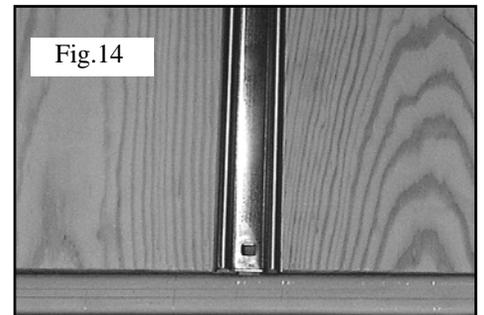
14. Attach the front cross sill and the center hole cross sill brackets, at 4 3/4" back from the front panel.



15. Attach the second and third cross sills with cross sill brackets installed to the angle strip bolts approximately 30-1/4" and 56-1/8" from the front bed panel respectively. The fourth cross sill bolts to the angle strip at 81-3/8" from the front panel. See figure 13. Install lock washers and nuts hand tight.

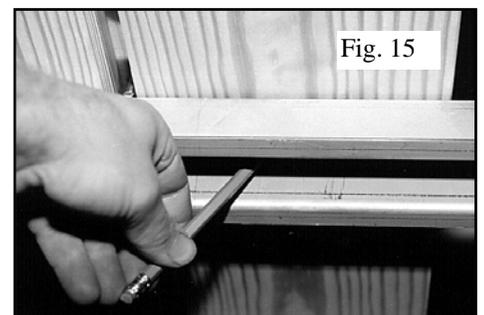


16. Install the second board on each side next to the edge board from step #13. Leave approximately a 1/2" gap between them. Place a bed strip between these boards on both sides. The end of the bed strip with the hole closest to the end should be at the rear cross sill. See figure 14. Bolt the bed strips down to the cross sills using the 1/4"-20 x 1-1/4" carriage bolts. *If using MAR-K's custom bed strips with hidden fasteners, follow the instructions supplied with the bed strips for correct installation.*



Note: The next step is to locate, drill, and countersink the locations for the bed-to-frame bolts and offset washers that sit on top of the wood surface. If wood is purchased with these holes predrilled, skip to step #24. If wood is purchased without these holes, the following steps will direct you through this process.

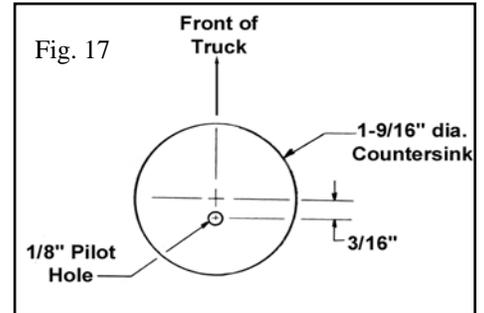
17. The cross sills are the locations for the bed-to-frame bolts. Mark the bottom of the second board from each side through the 1/2" diameter holes that are 33-3/4" apart in all four cross sills. See figure 15.



18. Brackets welded to the rear cross sill serve as the rear bed-to-frame mounting locations. Mark the bottom of the boards through the brackets on the rear sill that are **33-3/4"** apart (see figure 16). The center of these marks should be **103-3/8"** from the front of the wood boards.

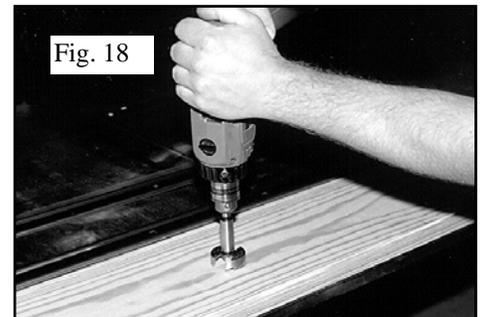


19. Make reference as to which end of each board is at the front of the bed. Remove the bed strips and the two inner boards. The bottom side of these boards should now have 1/2" diameter round marks on them. Drill a 1/8" diameter pilot hole through the center of these marks completely through the boards.



20. On the top surface of the boards, measure toward the front from each hole 3/16" and mark the boards for the countersink. See figure 17.

21. Using a 1-9/16" diameter Forstner bit, a drill press if available, or a hand drill, countersink each location approximately 1/8" to 5/32". See figure 18.



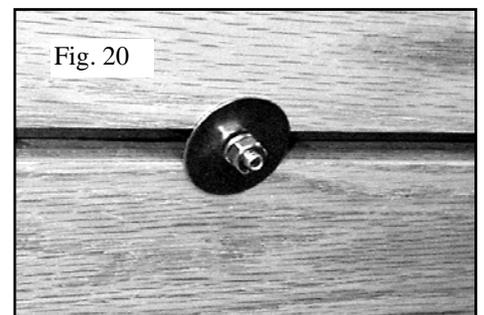
22. From the top surface of the boards, drill through the 1/8" pilot holes with a 1/2" wood bit to complete the bed-to-frame holes.



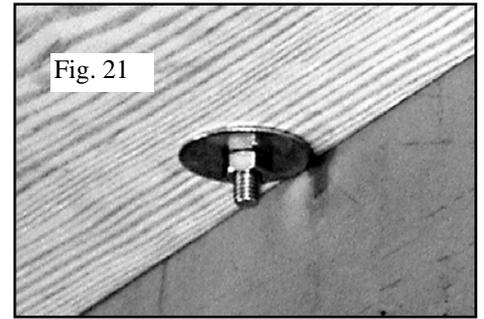
See figure 19.

23. Replace the second board and bed strip on both sides.

24. Where there is not a cross sill under the bed strip bolts, use a 1-1/2" outside diameter flat washer with a 1/4" diameter hole before the lock washer and nut. See figure 20. Tighten hand tight.

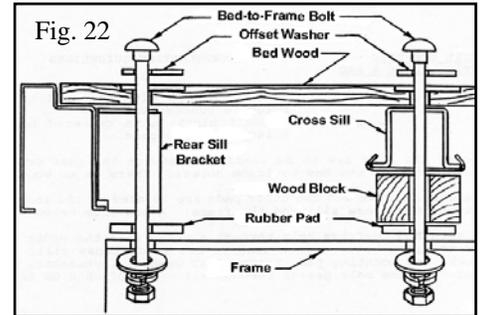


25. Where there is not a cross sill attached to the angle strip bolts, install a 1-1/2" outside diameter flat washer with a 5/16" diameter hole on the bottom of the bolt before lock washer and nut. Tighten nut hand tight. See figure 21.



26. Continue installing boards and bed strips working from the bedsides toward the center. The cross sill hole pattern controls which board width goes in next. After adjusting spaces between boards and strips, tighten the bed strip bolts. Be careful not to tighten bolts too much. Broken bolts or damaged bed strips may be the result.

27. Install the bed assembly to the frame of the truck. This will enable you to double check the bed-to-frame mounting locations. The bed rests on rubber pads and wooden blocks. The sequence is as follows: truck frame, rubber pads, wood blocks, cross sill bracket/cross sill, and bed floor/assembly. See figure 22.



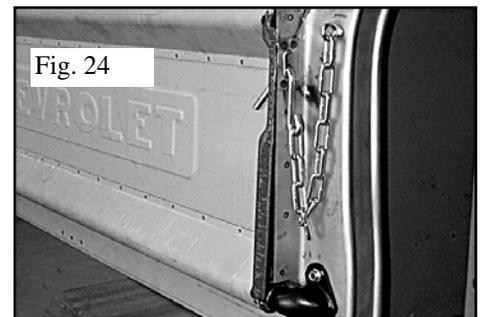
28. Insert the bed-to-frame bolts. These install through the offset washers, through the top of the wood surface, through the cross sills, blocks, rubber pads, and then through the frame.

29. After checking alignment of the bed-to-frame holes, install flat washers, lock washers, and nuts.

30. Bolt one hinge to the passenger bedside rear stake pocket with (2) 5/16"-18 x 3/4" hex head bolts. Place the tailgate end pivot area onto this hinge. Place the other hinge into the opposite end of the tailgate and bolt it to the driver stake pocket. See figure 23.



31. Install the tailgate chain eyebolts through the square hole near the top of the rear stake pockets. Secure with the 5/16" lock washers and nuts. This model has a left and right tailgate chain assembly. See figure 24.



32. You have assembled the entire bed. Check all parts for correct fit and alignment. Be sure the bolts are in place and that all dimensions are correct. Now remove the bed from the frame and disassemble the parts to prepare for painting.

After the parts are painted, the bed is assembled by the same procedure. By taking the time to assemble and test fit the bed before painting, you have reduced the chances for errors or problems in final assembly.

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