

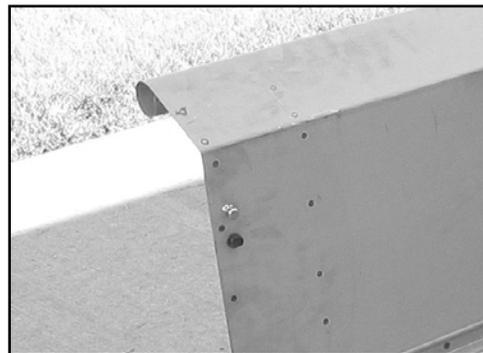
MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

ASSEMBLY INSTRUCTIONS FOR MAR-K BEDSIDES AND 41-53 GM FLUSH TAILGATE WITH HANDLE

Build the box assembly according to the MAR-K assembly instructions. When installing the tailgate and latching mechanisms refer to the steps below. Be sure to test fit all of the parts before painting.

1. Provided with the tailgate assembly are two strikers and the attaching button head bolts that are 5/16-18 x 3/8" long. Bolt the strikers to the inside of the bedsides. Leave them hand tight for now. You may need to adjust their position later.



Your new tailgate is supplied with the tailgate latch mechanisms that must be installed. However, before painting you will want to remove these items.

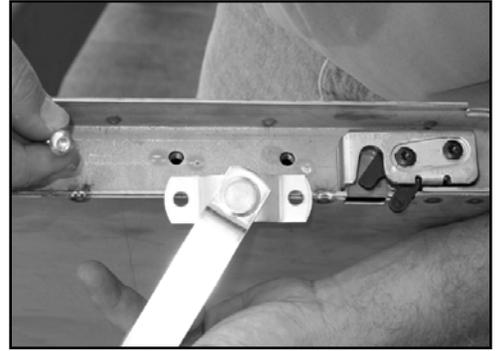
2. Each tailgate latch mechanism should be installed with the provided shim behind it. You may wish to tape them to the back side of the latches before installation.



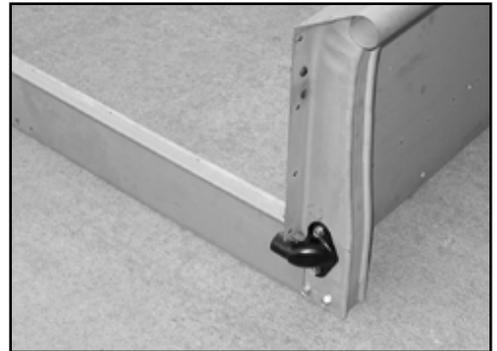
3. Attach each tailgate latch using two M6-1.0 x 30mm Phillips flat head screws. The u-shaped opening in the latch mechanism should line up closely to the notch in the tailgate end. The handle release mechanism protruding from the tailgate end should engage the latch. Use a thread locking compound on these screws.



4. Install the check straps to each end of the tailgate using two 1/4-20 x 3/4 " button head torx screws with a T-25 torx driver.



5. Attach one tailgate hinge to the right or left rear stake pocket with two 5/16-18 x 3/4" hex head bolts. Leave them loose for now. Slide the tailgate lower hinge tube onto the hinge on the stake pocket. Insert the other hinge into the opposite hinge tube of the tailgate. Attach it to the stake pocket as before.



6. Place the check straps onto the bedside pins that are welded on the inside of the bedside. In order to align the slots in the check straps fold the check straps in the opposite (upward) position while partially closing the tailgate.



7. Once both check straps are placed on the pins, lower the tailgate to its full open position. Gently close the tailgate while watching the check straps. They should fold together towards the bedsides in a downward motion. Continue closing the tailgate. If any binding occurs, you may need to adjust a hinge up or down. If everything is good then close the tailgate against the strikers. Make sure the handle has been released to open the latches before doing this.



Another Outstanding Part Manufactured in Oklahoma City, USA by



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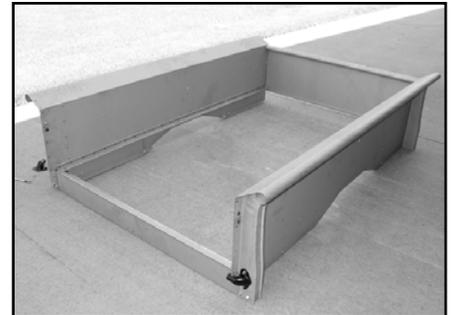
MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

ASSEMBLY INSTRUCTIONS FOR ORIGINAL BEDSIDES AND 41-53 GM FLUSH TAILGATE WITH HANDLE

This instruction sheet covers the modification to the original style bedsides and the installation of the Mar-K Quality Parts tailgate with the inside handle and custom latches. This includes removing the section of material where the chain hook goes through the bedside and filling the area with the patches provided. After modification, test fit of all the parts is required.

1. You must first build the box assembly with the new tailgate in place. Build the front bed panel, both bedsides, and the rear cross sill into an assembly. The box assembly should be 48-1/2" wide for a 41-46 model and 50" apart for a 47-53 model. Measure the bedsides at the top and bottom near the floor area. Make sure the box assembly is square in all directions.



2. Attach one tailgate hinge to the right or left rear stake pocket with two 5/16-18 x 3/4" hex head bolts. Leave them loose for now. Slide the tailgate lower hinge tube onto the hinge on the stake pocket. Insert the other hinge into the opposite hinge tube of the tailgate. Attach it to the stake pocket as before.

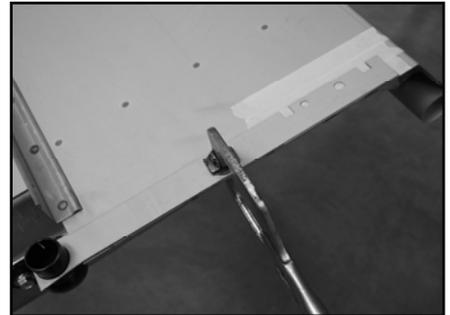


3. Close the tailgate and check for alignment with the bed sides. Adjust hinges if necessary. Once you are happy with the fit, tighten the hinge bolts. Scribe around the tailgate hinges to mark their location.

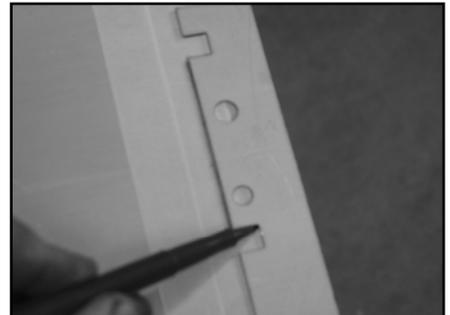


4. Remove one tailgate hinge so that you can remove the tailgate. Set the tailgate aside for now. Re-install the hinge at the scribed lines.

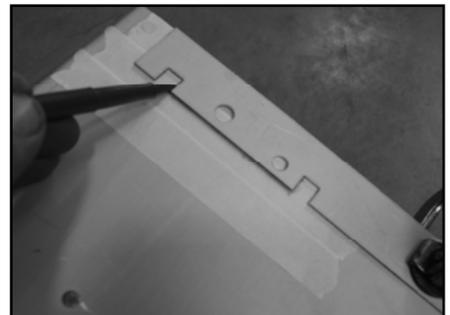
5. Install the template provided onto the hinge so that the template is on the inside of the bedside. The notches in the template should be facing forward. Align the rear most edge of the template with the rear edge of the bedside. Clamp the template to the bedside.



6. Mark the area to be removed on the bedside using the template as shown. Use the inner edges of the notches in the template and the front edge of the template is the depth of the cut.

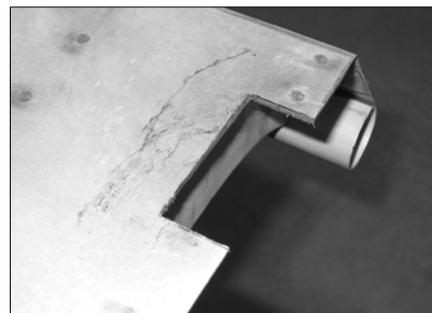


7. Remove the template. Use a straight edge to lengthen the mark from the notch out to the edge of the bedside. The marked area should be 3" tall by 1-1/4" deep. Mark the other bedside in the same manner.



Note: The cutting, welding, and grinding steps that follow may be easier if the bed sides were lying on their sides. It is suggested that the box be disassembled at this point.

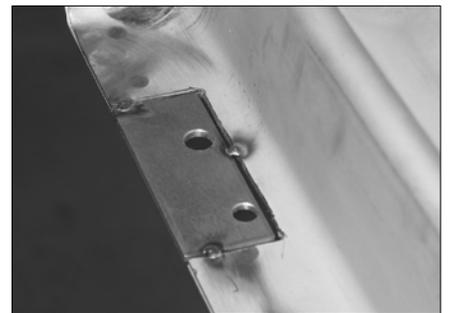
8. Cut out the area marked on the bed sides. Stay on the inside of the lines towards where the patch will fit. It is easier to make an area larger than to fill it in again. We used a jigsaw but a plasma cutter or high-speed cutoff wheel would also work.



9. Attach the template to the bedside again. Fit the patch panel to the template. The patch has a hole pattern that matches the template. Check the fit or gap around the patch to the bedside. Clamp the template and patch to the bedside. Make sure that the patch and template stay even with the back edge of the bedside. You may use the bolts and 5/16" nuts provided if you wish to bolt the patch to the template.

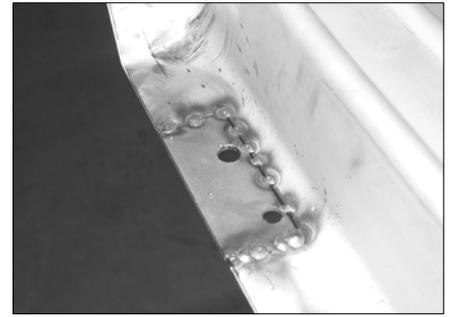


10. Tack-weld the patch into place from the outside of the bedside. Check to see that the patch has not shifted. Remove the template and tack weld from the other side. Do these steps to both bed sides.

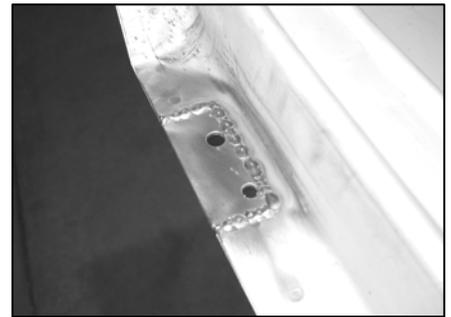


Note: You may wish to re-assemble the box at this point to verify the positions of the patches before permanently welding them in place.

11. Continue welding the gap between the patch and the bedside using short welds. Switch from inside to outside of the patch and from bedside to bedside to minimize heat distortion.



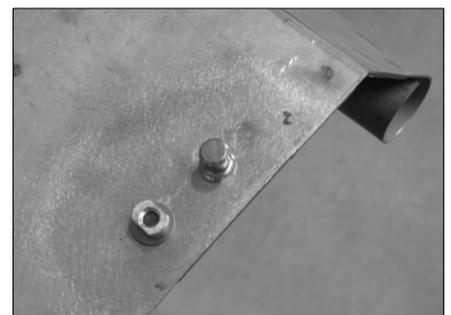
12. Grind all welds smooth. Again, be careful not to build up too much heat with the grinder.



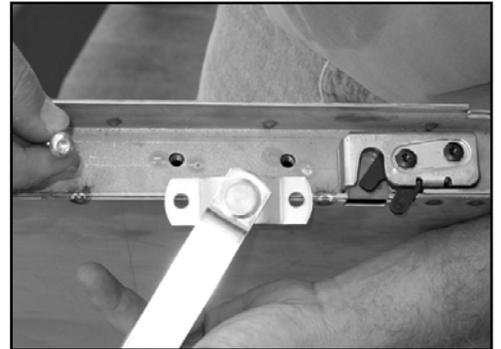
Note: The patch and the bedside should now appear to be the same metal and be smooth at the weld seam.



13. Included with the tailgate kit, you should find two link assembly pivots. These bolt to the bed sides in the lower hole on the bedside. Use a 5/16" –18 x 3/8" long button head screw with a washer under the link pivot. The washer keeps the link assembly from scratching the paint at final assembly. Make sure that the flats on the sides of the link pivots are horizontal when the bolts are tightened. After final adjustment, you will need to use a thread locking compound on all four screws and torque them to 375 in-lbs. or 33 ft-lbs. maximum.



14. Bolt the strikers to the top hole in the bedside patch with the same screws as for the link pivot.
15. Re-assemble the bed as before with the tailgate. Make sure to get the hinges in the scribed locations.
16. Install the link assemblies to each end of the tailgate using two 1/4-20 x 3/4 " button head torx screws with a T-25 torx driver.



Your new tailgate is supplied with the tailgate latch mechanisms that must be installed. However, before painting you will want to remove these items.

17. Each tailgate latch mechanism should be installed with the provided shim behind it. You may wish to tape them to the back side of the latches before installation.



18. Attach each tailgate latch using two M6-1.0 x 30mm Phillips flat head screws. The u-shaped opening in the latch mechanism should line up closely to the notch in the tailgate end. The handle release mechanism protruding from the tailgate end should engage the latch. Use a thread locking compound on these screws.



19. Place the check straps onto the bedside pins that are bolted to the inside of the bedside. In order to align the slots in the check straps fold the check straps in the opposite (upward) position while partially closing the tailgate.



20. Once both check straps are placed on the pins, lower the tailgate to its full open position. Gently close the tailgate while watching the check straps. They should fold together towards the bedsides in a downward motion. Continue closing the tailgate. If any binding occurs, you may need to adjust a hinge up or down. If everything is good then close the tailgate against the strikers. Make sure the handle has been released to open the latches before doing this.



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