

REAR PANS FOR 81-92 GM SUBURBAN

The rear pan fits between the side panels below the tailgate. It is formed to match the curve of the side panels so that when installed it fills the open area under the tailgate by carrying the original body lines across the rear of the body.

Suggested Installation Instructions

1. Remove the bumper and brackets.
2. The frame will need to be trimmed back towards the body. To aid in marking the frame, hold a tight string or other straight edge against the outer side panel edge from one side of the opening to the other. Move the string down until it contacts the top of the frame rails. Mark the frame rails approximately 1/4" forward from this contact point.
3. Repeat this marking procedure for the bottom of the frame.
4. Cut the frame at an angle by joining the marks made in step #2 and #3.
5. It may also be necessary to make clearance cuts into the body or frame for the recessed tag box of the rear pan.
6. Hold the pan into position. If necessary, grind the ends slightly so that the pan fits between the side panels.
7. Make sure that the tailgate will operate freely without binding against the pan. While holding the pan in position, mark through the top mounting flange holes in the pan onto the rear body structure.
8. Remove the pan. Center punch and drill the holes as marked through the top mounting surface of the pan. Use a 5/32" drill.
9. Again mount the rear pan into position and verify that all holes are aligned and that the tailgate operates freely.
10. Two styles of mounting clips are provided to attach the bottom of the rear pan to the lower edge of the side panels. These clips can be mounted to the back side of the rear pan and the side panels by screws provided.
11. Again temporarily mount the pan after attaching the lower clips and verify that the pan is not interfering with the operation of the tailgate.
12. Remove the pan from the vehicle and paint to match. The back side should be painted to prevent corrosion.
13. **If the rear pan is to be welded to the side panels**, The clips will not be used. In this case, remove the paint from the side panel edges. With the pan still bolted at the top, fit the edges of the pan to the lower body.

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14. Tack weld the pan edges to the side panels. Be careful not to build up too much heat that would warp the sheet metal. Alternate welding areas to let the welded areas cool naturally.
15. Continue welding with small beads until the pan is fully welded to the side panels.
16. Use body filler or lead and smooth the seam where the rear pan meets the side panels. You may also wish to spray the back side of the rear pan with undercoating to prevent corrosion especially around the weld seams. This may also prevent dents from flying rocks from the rear tires.
17. Prepare the pan and match to the color of the truck.

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