

# MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

## INSTALLATION INSTRUCTIONS FOR TAILGATE CHECK LINK STRAPS FOR 41-53 GM STEPSIDE TRUCKS

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 48-1/2" for a 41-46 model and 50" for a 47-53 model. 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.

2. Install the hinges and tailgate and make sure it is aligned to your satisfaction.

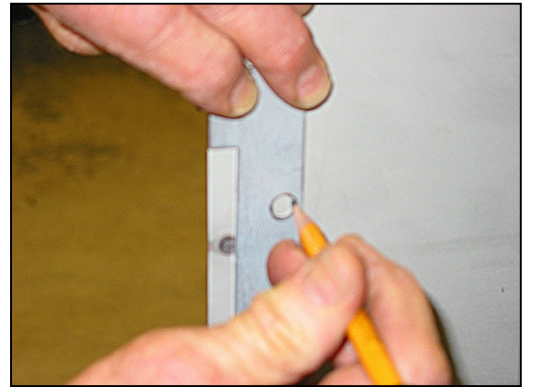
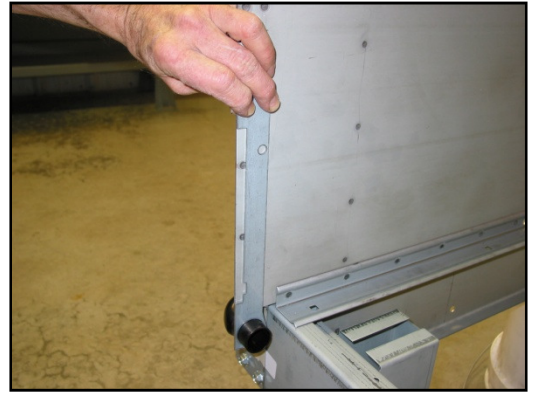


3. Mark the location of one hinge so it may be removed and reinstalled in the exact same location. This may be done by scribing around the hinge, using masking tape to outline the hinge, or placing masking tape on the mounting surface before installing the hinge and then drawing an outline on the tape with a pencil or pen.



4. Remove the hinge that was marked in step 3 above, and remove the tailgate. Install the hinge back in the same location so that both hinges are in the exact mounting position they were when the tailgate was installed and properly aligned

5. Use the template provided to locate the hole for the upper fixed pivot pin for the link straps. The large hole in the template goes over the hinge and the edge of the template is lined up with the rear edge of the bedside. Mark the hole location as shown.



6. Center punch this location and drill a 5/16" hole through the bedside at that location. Do this for both bed sides and deburr the drilled holes.



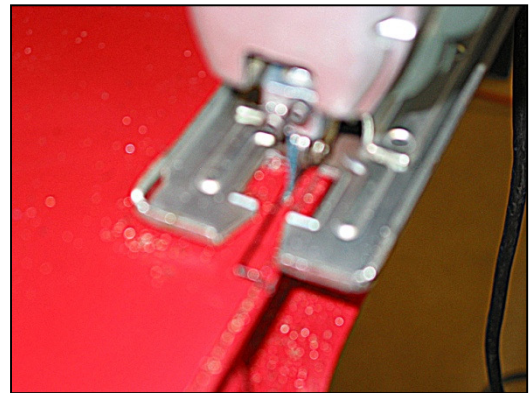
7. Install the fixed pivot pin at each of the 5/16 holes drilled in step 6 above. Use the 5/16" diameter button head screw to attach each pivot pin. The screw head is on the outside of the bedside and the fixed pivot pin is on the inside of the bedside. Place the stainless washer over the fixed pivot pin before bolting it to the bedside. Tighten the fixed pivot pin so that its flat edges are horizontal as shown in the photo.



8. This step and the next 2 steps prepare the tailgate for the linkage by cutting away part of the tailgate end so the linkage can fold into the tailgate end when the tailgate is closed. The area to be cut away is on the front edge of the tailgate end toward the cab, on each end. Mark the area to be removed as shown in the photo using the template as a guide. Align the template to the outer edge of the tailgate end and skin so the lower end of the cut out area begins 2-1/2 " up from the bottom of the tailgate and goes up 9-1/2" from the bottom of the tailgate. Mark the area to be removed with a scribe or permanent marker.



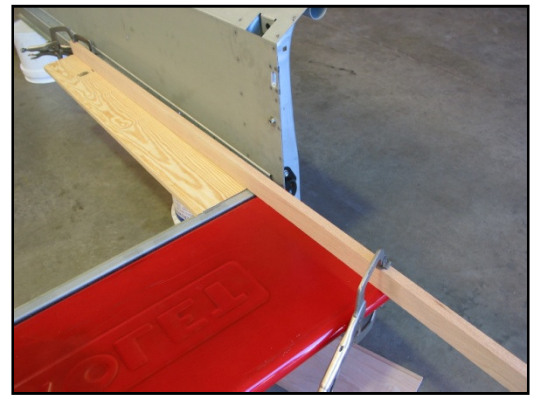
9. Cut away the marked area as measured in Step 8 above. Use a cutoff wheel or a jig saw with a short blade. Use care at the upper part of the cut to prevent damaging the tailgate end.



10. The cuts done in step 9 above may have removed some of the spot welds holding the skin to the tailgate end. If so, the skin should be re-welded to the tailgate end in those areas and the welds ground down smooth. Do not weld a continuous bead, but place good spot welds on the joint about every 2" apart. Be sure the skin is clamped to the tailgate end in the areas to be welded.
11. Remove the hinge that was marked in step 3 above and re-install the tailgate, placing the hinge back in the exact position as before



12. Open the tailgate so that it is in the horizontal position. Use a board or other straight object extended out from the bed floor to be sure the tailgate is exactly parallel to the bed floor. This is critical, as the linkage may not fold correctly into the tailgate end if the tailgate is not held parallel to the bed floor for this step.



13. With the tailgate secured in the horizontal position parallel to the bed floor, install a link on each fixed pivot pin and place the pivot bracket into the tailgate end as shown. Apply slight tension on the linkage so it is straight and clamp the pivot bracket to the tailgate end as shown. There should be exactly 1/2" between the pivot bracket and the inside edge of the tailgate end and the pivot bracket should be exactly parallel to the tailgate end. Do this on both ends of the tailgate. Both link assemblies should now be clamped in the position they will be installed on the tailgate end.



14. Using a 3/16" drill, drill through the holes of the pivot bracket into the tailgate end. Do not drill through, but drill deep enough to effectively mark the hole locations on the tailgate end. Use care to keep the drill square so that the hole in the pivot bracket is not damaged by the drill.



15. Remove the clamps securing the link to the tailgate and remove the link assembly from each end of the tailgate. Use a 1/4" drill to drill holes in the tailgate end that were marked in step 14 above. These holes are exactly 1-1/2 inches apart. Deburr the holes.



16. Install the link assembly on each end of the tailgate. Use the 1/4" button head screws and locknuts through the holes drilled in step 15 above to attach the pivot brackets to the tailgate ends. The screw head must be on the pivot bracket side. Tighten the screws.

Note: If a tailgate full cover will be used, weld 1/4"-20 nuts to the holes drilled into the tailgate ends on the opposite side from the link assembly. This will allow the link assembly to be removed and re-installed after the full cover is in place.



17. Remove the board used to hold the tailgate parallel to the bed floor in step 12 above. Carefully raise the tailgate to the closed position. The links should fold smoothly into the tailgate end as the tailgate is raised. The tailgate should move to the fully closed position without causing any binding in the link assembly.



18. This completes the installation of the check link straps. The tailgate may now be removed to detail and paint the areas cut away. When assembling the system for the final time, use thread locking compound to help prevent the screws from coming loose.

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