

# MAR-K

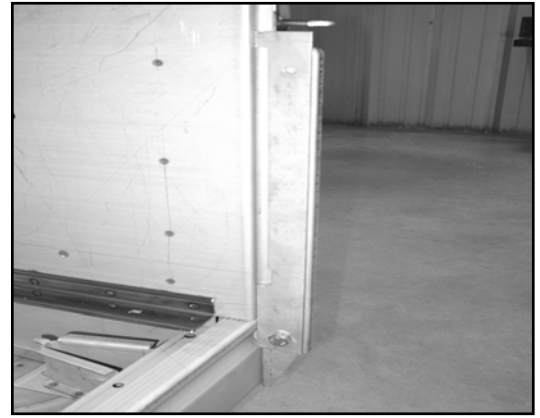
RESTORATION AND CUSTOM PICKUP PARTS

## INSTALLATION INSTRUCTIONS FOR TAILGATE CHECK LINK STRAPS FOR 54-87 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 50". 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 trunnions and tailgate and make sure it is aligned to your satisfaction. The trunnion bolt hole in the bottom of the bed sides is slotted to allow adjustment of the tailgate to the bed sides. The tailgate should be adjusted to be nearly touching the rear sill when closed but no more than 1/32" gap. Check the operation of the tailgate. Make sure it operates freely without binding.



3. Remove the tailgate and the trunnions from both bedsides. Use the template provided to locate the hole for the upper fixed pivot pin for the link straps. Bolt the template to the trunnion hole on the inside of one bedside with the hardware provided. Place the two washers between the template and the bedside. The notched side of the template should be facing the bedside. Mark the bedside through the templates upper hole. Mark the bedside through the templates upper hole.



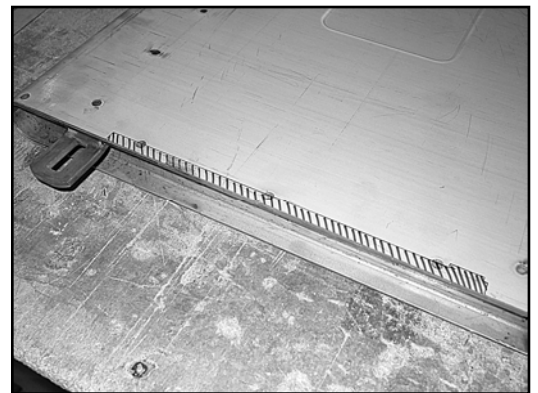
4. Remove the template and center-punch this location. Drill a 5/16" hole through the bedside at that location. Do this for both bedsides and deburr the drilled holes.



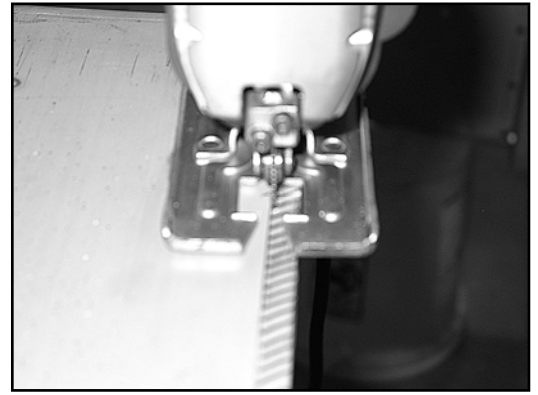
5. Install the fixed pivot pin into each of the 5/16 holes drilled in step 4. Use the 5/16" diameter button head screw to attach each pivot pin. The screw head is on the outside of the bedside and the fixed pivot pin is on the inside of the bedside. Place the stainless washer over the fixed pivot pin before bolting it to the bedside. Tighten the fixed pivot pin so that its flat edges are horizontal as shown in the photo.



6. 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 3-11/16" up from the bottom of the tailgate and goes up 14-15/16" from the bottom of the tailgate. Mark the area to be removed with a scribe or permanent marker.



7. Cut away the marked area as measured in Step 6. 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 latch ear.



8. The cuts done in step 7 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.

9. Re-install the tailgate, aligning it as in step 2.

10. 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 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.

11. 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.



12. Mount the pivot bracket against the sheet metal angled brace spot-welded inside the tailgate end. The pivot bracket should be 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.



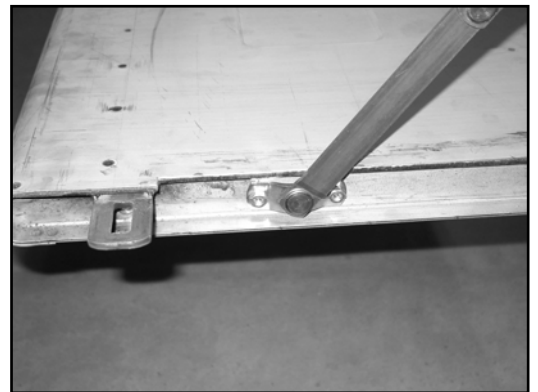
13. Using a 1/4" drill, drill through the holes of the pivot bracket into the tailgate end. Do not drill through, but drill deep enough to effectively mark the hole locations on the tailgate end. Use care to keep the drill square so that the holes in the pivot bracket are not damaged by the drill.



14. 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 13 above. These holes are exactly 2-1/16 inches apart. Deburr the holes.



15. Install the link assembly on each end of the tailgate. Use the 1/4" button head screws through the holes drilled in step 14 above to attach the pivot brackets to the tailgate ends. Tighten the screws. If you are installing Mar-K's stainless link assemblies, you must place the button head screws on the side of the tailgate end with the pivot bracket of the link assembly.



16. Remove the board used to hold the tailgate parallel to the bed floor in step 10 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.



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.



If a full tailgate cover is to be used, weld the bolts holding the link assembly to the tailgate ends in place. This will allow you to still remove the link assemblies if needed after the full tailgate cover has been installed.

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