



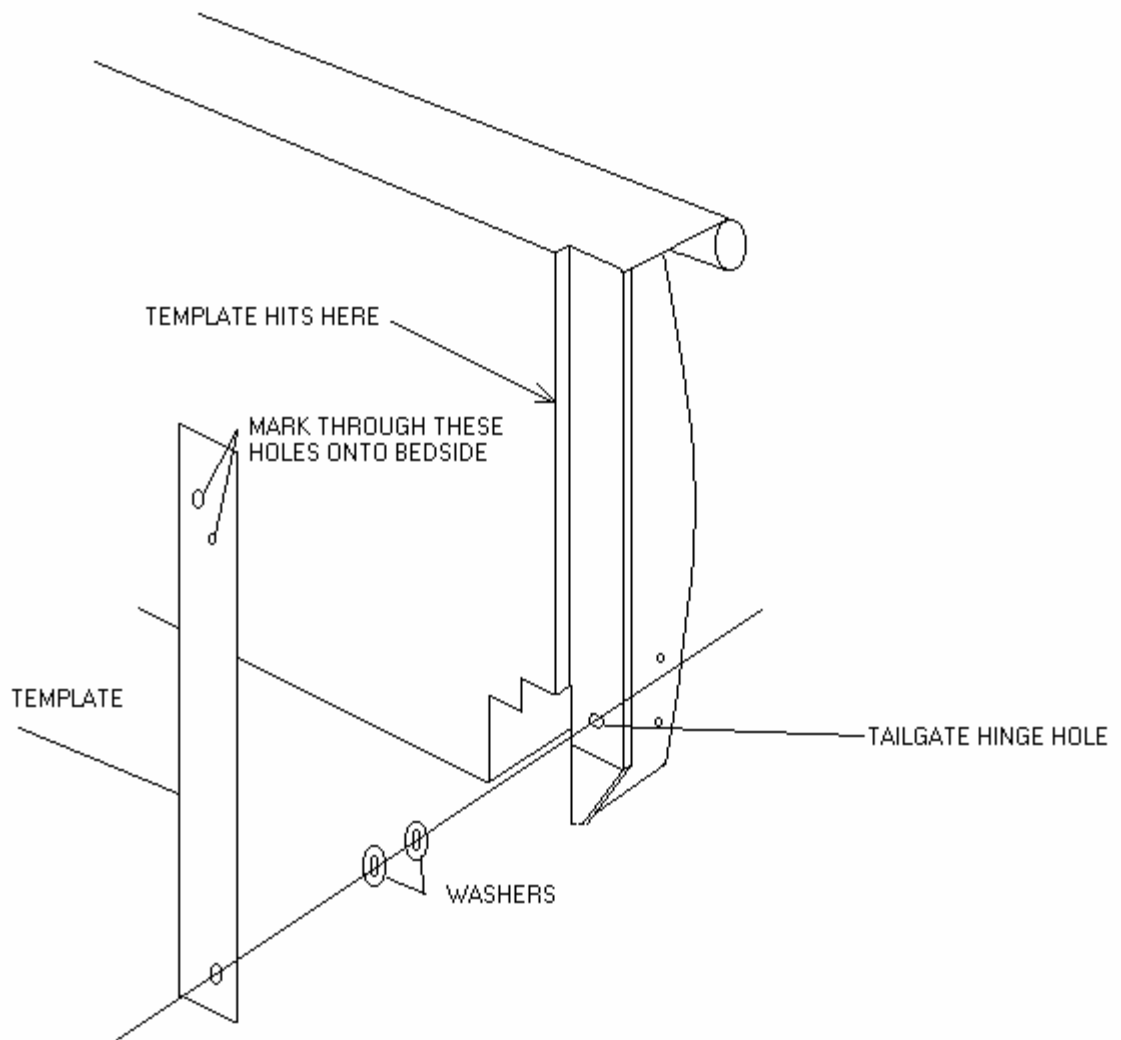
**ASSEMBLY INSTRUCTIONS FOR BEDSIDES WITHOUT LATCH
54-87 GM FLUSH TAILGATE WITH HANDLE**

To install the flush tailgate with handle onto bedsides that do not have the tailgate latch cutout, a few modifications must be performed on the bedsides. This includes locating and drilling several holes for the tailgate latch strikers that bolt to the bedside and the tailgate check strap pins that bolt to the bedside. The following steps will guide you through these procedures.

1. Locate the sheet metal template provided. Using 7/16" diameter hardware (provided), bolt the template to the bedside through the lower hinge hole. Place the (2) 7/16" flat washers between the template and the bedside.
2. Make sure that the wider portion of sheet metal of the template from the hinge hole is facing the bedside forward where the tailgate shuts. This is important to get the upper holes positioned correctly so the tailgate will shut tightly.
3. Rotate the template on the lower hinge hole until the template comes in contact with the upper part of the bedside.
4. Mark the hole locations on the bedside through the template. This can be accomplished with the use of transfer punches or a scribe. Make sure that the template contacts the bedside from top to bottom.
5. Drill the bedside holes where marked. Drill the top hole at 3/8" diameter. This is the latch striker position. Drill the lower hole at 5/16" diameter. This is the tailgate check strap pin location.
6. Continue to install the tailgate following the tailgate installation instructions provided with the tailgate.

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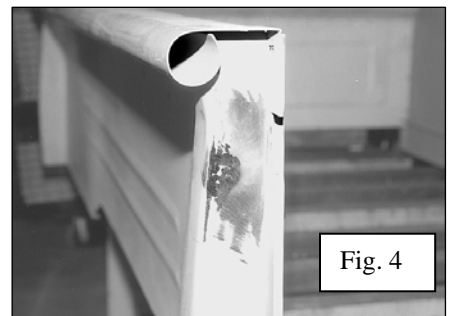
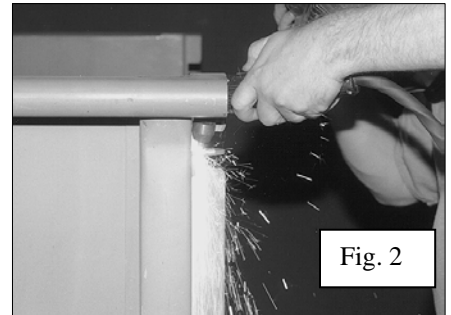
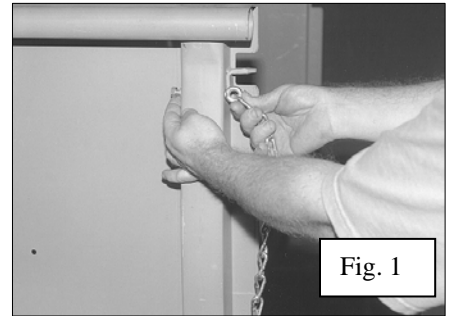
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RESTORATION AND CUSTOM PICKUP PARTS

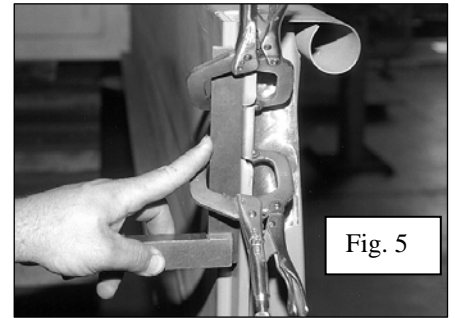
ASSEMBLY GUIDE: 54-87 GM FLUSH TAILGATE WITH HANDLE FOR ORIGINAL STYLE BEDSIDES

This assembly guide covers the modification to the bedsides and the installation of the tailgate with the centrally located handle. The tailgate that you have purchased includes all necessary hardware and filler pieces to install the new tailgate to work like a GM fleetside truck. After modification, test fit of all the parts is required.

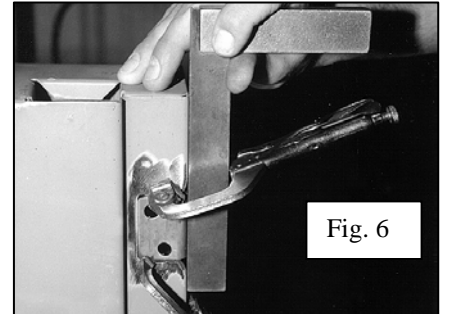
1. Remove one trunnion bolt from one side at the pivot area of the tailgate. Remove the tailgate chain hooks from the bedside latch brackets on the stake pockets. Remove the tailgate from the truck.
2. Remove the tailgate chain eyebolts from the stake pockets and discard the chain assemblies. See Fig. 1.
3. The latch brackets on the stake pockets need to be removed. Cut these off of each stake pocket being careful not to cut the stake pocket itself. A plasma cutter is being used here to remove the flat upper portion. See Fig. 2.
4. Remove the lower portion of the latch eye bracket with a 4-1/2" angle grinder. Grind only on the latch eye bracket and not on the stake pocket. Remove enough material until the bracket can be pried loose from the stake pocket. See Fig. 3.
5. Clean all paint from surfaces to be welded. Weld the holes for the eyebolt of the chain assembly closed in the rear stake pockets. See Fig. 4. For bedsides with the stake pocket hole in the top of the skin, slide an aluminum block down inside the stake pocket from the top. Use the aluminum block to back up the hole while welding. Weld both holes closed on the front and back side. Grind all areas smooth.



6. A filler panel is provided to fill the area on the bed sides where the tailgate latch ear used to shut. These filler panels are different for left and right sides of the truck with relation to the holes in them. The smaller of the two holes should be on the bottom. See Fig. 7.

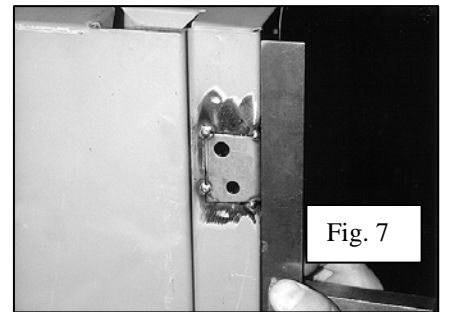


7. Test fit these pieces into the bedside flanges. Grinding of the filler pieces on the non-bent edge may be necessary to make them match the bedside shape.

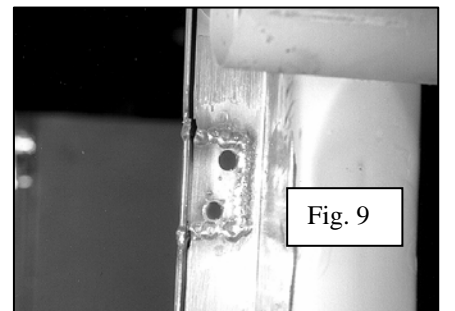
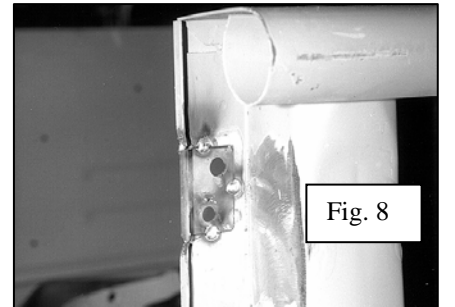


8. Remove all paint from areas to be welded. Clamp the filler panels in place and use a straight edge on the outside edge of the bedside and the inner surface where the tailgate shuts. Leave about the same amount of gap around the filler panel on all three sides. See Figs. 5 & 6.

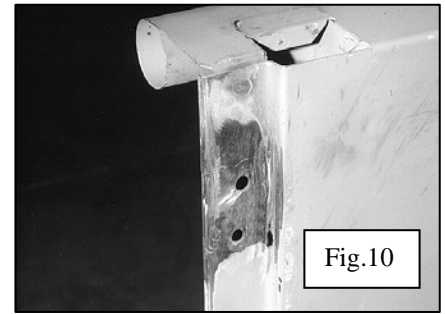
9. Tack weld the filler panels in place. Check the location of the filler panels with a straight edge again to make sure they have not moved. See Fig. 7



10. Continue welding the filler panels in place with small welds. Do not lay one continuous bead to fill the gap. This will build up too much heat and could warp the bed side. See Figs. 8 & 9.



11. Grind all surfaces smooth after welding both sides of the patch panels. Check all welds for good penetration. See Fig 10.

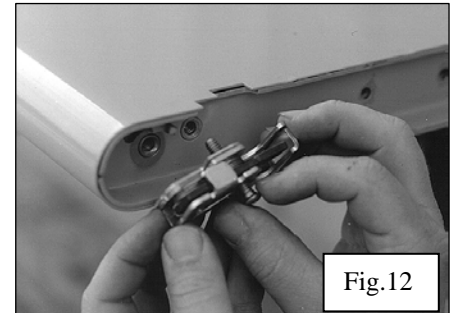


Your new tailgate is supplied with the tailgate latch mechanisms that must be installed. However, before painting you will want to remove these items.

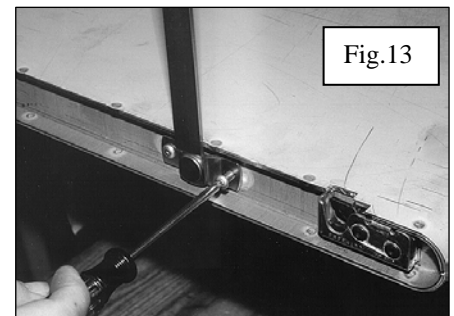
12. Each tailgate latch mechanism should be installed with the provided shim behind it. You may wish to tape them to the back side of the latches before installation. See Fig. 11.



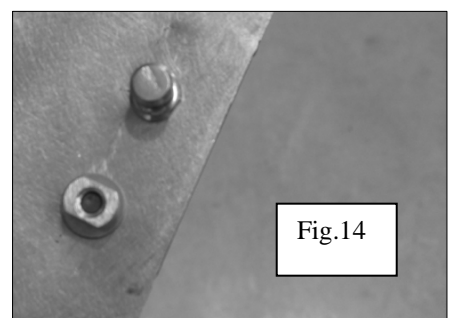
13. Attach each tailgate latch using two M6-1.0 x 30mm Phillips flat head screws. The u-shaped opening in the latch mechanism should line up closely to the notch in the tailgate end. The handle release mechanism protruding from the tailgate end should engage the latch. Use a thread locking compound on these screws. See Fig. 12.



14. Bolt the tailgate check links to the tailgate on both ends using two 1/4"-20 x 3/4" button-head screws. See Fig. 13

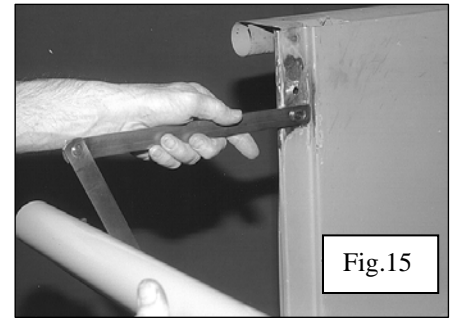


15. Provided in the tailgate kit are two check strap pivot pins. Bolt these pivot pins to the lower smaller hole in the patch area using two 5/16"-18 x 3/8" long button-head socket screws. The pivot pin should be on the inside and only the bolt showing on the outside. The pivot pin has flats on two sides and should be installed with these flats horizontal. This picture also has the latch striker installed above the pivot pin. (See Fig. 14)

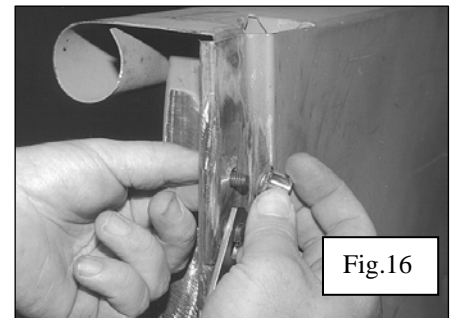


16. Install the new tailgate onto the hinge trunnion from step #1. Place the other trunnion removed in step #1 into the opposite end of the tailgate. Align this trunnion to the hole in the bed side and attach with bolt.

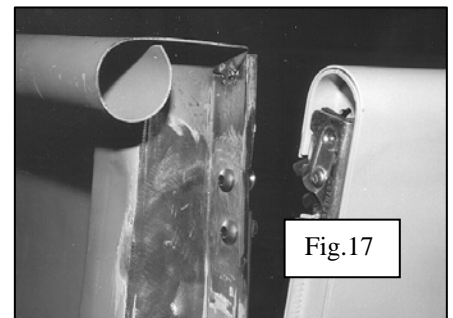
17. Lift the tailgate slightly and align the oblong hole in the end of the tailgate check links with the oblong shape on the bed side pivot pins. This will require that you pivot the check links in the upward direction opposite from the normal folding direction. Repeat this for both ends of the tailgate. (See Fig. 15.) Let the tailgate rest in the open position.



18. Bolt the two latch strikers to the bed sides through the remaining holes in the patch panels. The latch striker will be on the inside towards the tailgate with only the striker bolt showing on the outside. Use the 5/16"-18 x 3/8" long button-head socket screws to attach the strikers. (See Fig. 16) 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.



19. Lift the handle of the tailgate to release the latch mechanisms. Shut the tailgate slowly while watching the check links. Make sure they fold downward properly without binding. Check that the strikers hit the latches properly. (See Fig 17) If they do not, it may be necessary to adjust the tailgate trunnions on the bedsides. Push the tailgate shut until you hear the latches click shut. Check to see if the tailgate is even with the outer edges of the bedsides and the top of them as well. Adjust the trunnions or the strikers as necessary.



20. You have successfully installed your new tailgate. Now remove the tailgate by reversing the procedure and prepare the tailgate and the bedsides for painting. Be careful not to add any plastic filler in the area that the striker bolts to avoid chipping when re-installing the strikers. If you have removed the latch assemblies from the tailgate, re-install them using steps #12 & 13. Use a thread-locking compound on all fasteners during final installation and follow torque specifications.

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