

# MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

## INSTALLATION INSTRUCTIONS FOR BEDSIDE INNER REPAIR PANELS 67-72 GM FLEETSIDES

This instruction illustrates the removal and replacement of the often rusted and damaged lower inner flanges on the 1967-1972 GM Fleetside bedsides where the bedsides meet the wood floor or steel floor assembly. Experienced installers may choose not to use the entire replacement panel if it is not needed, but the instructions show the entire panel being used. We strongly advise you to read the instructions thoroughly and understand that cutting and welding are involved before proceeding. It will be necessary to disassemble the box and remove the wheelhouse from each bedside. The following text and photos show the replacement panel being installed on a 1971 GM long Fleetside passenger bedside.

1. Measure from the inside of the top of the bedside down to the bottom flange. This one measured 19-3/8" to the bottom of the flange. Write your number down for later use. Measure up from the bottom of the flange 3-1/16" and make a mark. Do this at the front and at the rear near the wheel house area. Draw a line through these marks from the front bed panel flange through the wheel house embossed area.



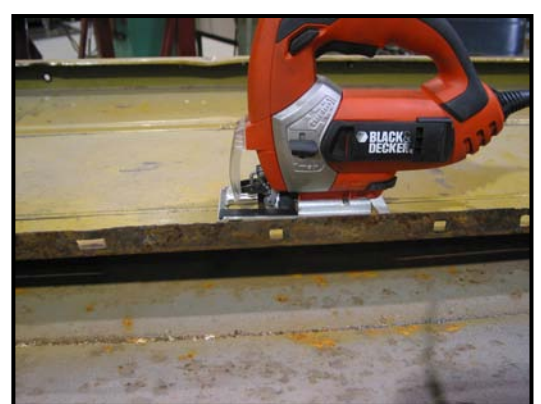
2. Mark and drill a hole where your line from the previous step crosses the curved area of the wheel house indentation. This will allow you to insert the jigsaw blade into this corner. Remember to drill the hole into the part being replaced below the line you marked. This hole will allow you to cut in either direction. You will make a cut following the shape of the wheel house opening through the bottom of the flange. Leave the curved section there so that there is something strong to weld to.



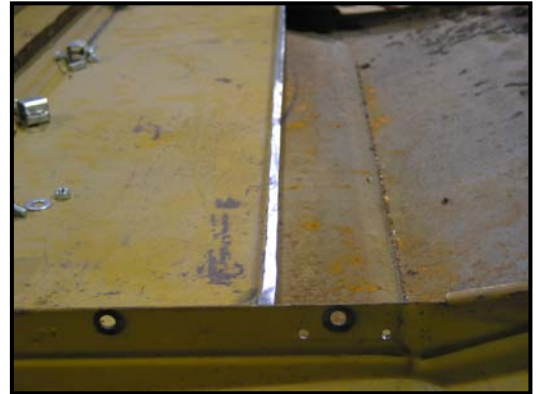
3. Using a jigsaw or other suitable cutting device saw along this radius out to the bottom as shown. You will be cutting close to the nut on the panel, but not through it. The replacement panel has this nut welded to it.



4. Place the jig saw blade back into the corner hole and cut below the line towards the front of the bedside. Try to stay on the scrap side of the line towards the bottom flange. The jigsaw can't reach all the way to the front of the bedside. You will be left with some metal left to cut plus a small vertical portion. Using a 3" high-speed cutting wheel, finish the horizontal cut all the way to the 90-degree bend in the panel. Then cut vertically in the bend towards the top until the panel is separated from the top portion.



5. Center punch the spot weld areas where this panel welds to the front bedside inner brace. There should be (2) welds here. Drill through both panels at the spot welds with increasing drill sizes until the panel breaks free. It should not require much bigger than a 1/4" drill. At this point, the panel can be removed completely. Grind the spot welds smooth on the front brace so that the new panel will fit tight against the brace. Also remove the paint around the areas where the replacement panel will be welded as shown.



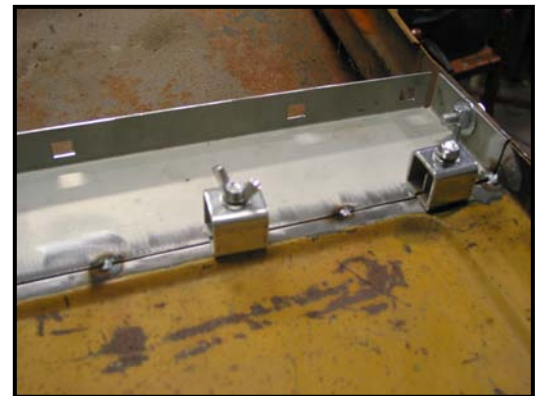
6. Trial fit the replacement panel to the bedside. Line up the hole provided in the front of the replacement panel with the 3/8" hole in the bedside front brace. Using a 3/8" bolt and some flat washers and nut, fix the panel in place. If there is interference with the area that was cut with the jigsaw, grind the bedside above the line drawn in step1 and test fit until the bolt hole lines up. We chose to use a butt-weld panel clamps along the seams to ensure a flat weld seam and a proper gap for welding. You will also need to remove the electro-galvanized coating from the repair panel before welding.



7. It is also a good idea to mount the wheel house back on the bedside. This places the rear of the replacement panel in the correct location. Measure the height of the bedside and replacement panel as shown. The overall height should be the same as measured before you removed the damaged panel. These numbers are critical as they control how high the bed sides sit off the floor. Make sure the wheel house flange is on top of the replacement panel as shown. Place a 5/16-18 x 1-1/2" carriage bolt through the flanges to hold them together.



8. If the height measurements are good, tack weld the panel into place. Make small tack welds and space them apart far enough not to heat things up. We want to attach the two pieces together but not warp the panel with excessive heat.



9. When you reach the wheel house with tack welds, you must remove the wheel house to tack weld behind it.



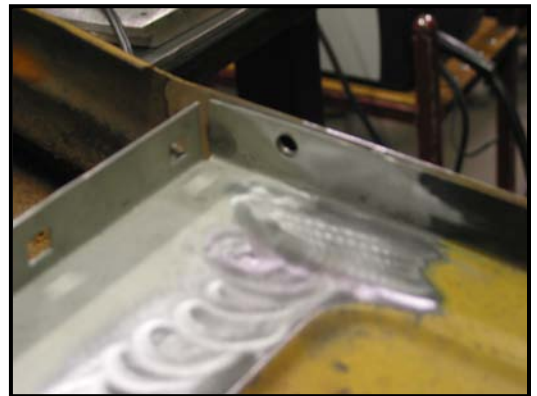
10. Continue tack welding until the entire seam has been filled. Don't forget the short vertical section at the front bedside flange. Move around while tack welding. If the panels are warm to the touch after a few welds, stop and take a break and let the panels cool.



11. We need to re-create the two spot welds at the front panel flange that were drilled out. You will need to remove the paint around these holes also as shown. Clamp these panels together and weld through the holes that were drilled to remove the original panel. You may use an aluminum block or copper to back up the panel so that you do not burn through the repair panel with the plug weld.



12. At this time, grind down the welds and check your progress.



13. The rear section is installed in the same way except it does not have a bent flange at the rear where it meets the bedside rear stake pocket. This panel rests on top of the rear stake pocket and is spot welded a couple of times. Use the same measurement method to locate the panel and also check the fit with the wheel house as before.

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