

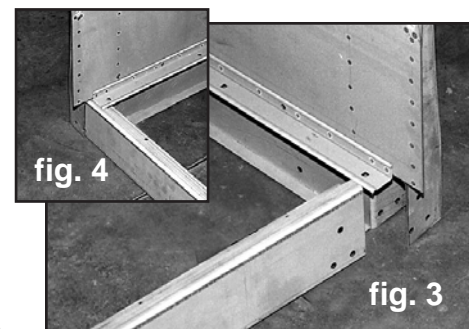
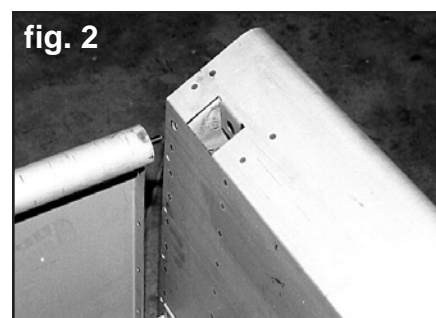
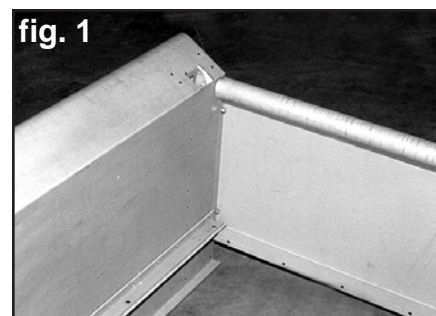
# MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

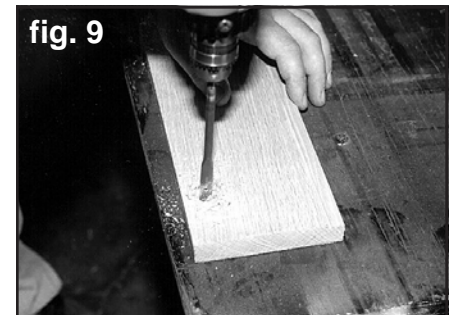
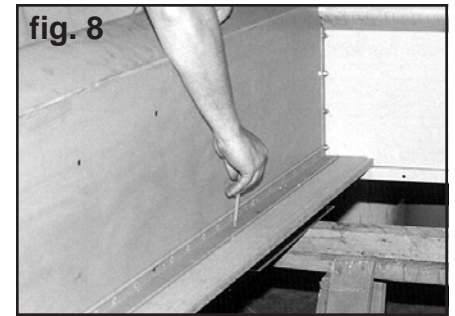
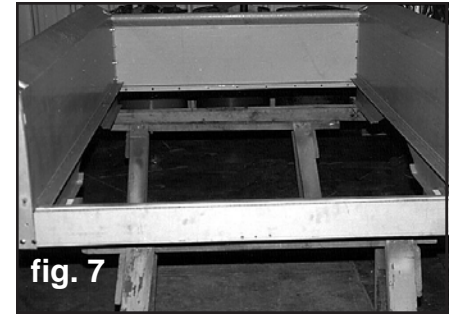
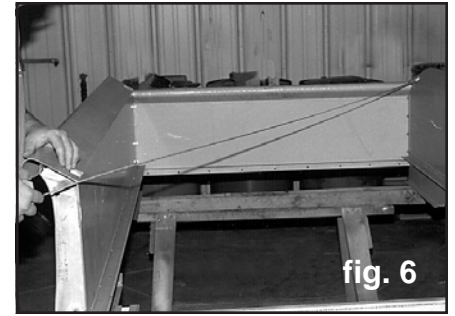
## BED PARTS ASSEMBLY GUIDE 1934-36 CHEVY SHORT STEPSIDE

If you have not yet disassembled your original bed, make notes or sketches and take pictures of part locations to aid in the assembly procedure. Use the following steps to assemble the entire bed to test fit all parts.

1. Begin with one bed side and the front bed panel. Bolt the front bed panel flange to the inside of the bed side with (3) 1/4"-20 x 5/8" hex head bolts, lock washers, and nuts from the front bed panel mounting bolt kit. See figure 1.
2. This bed also uses a long rod that attaches through the front bed panel curl to the bed sides. Install a 5/16" flat washer, lock washer, and nut on one end of the rod. Insert the rod through the top hole in bed side into the top curl of the front bed panel.
3. Align and install the loose end of the rod through the other bed side and secure with a 5/16" flat washer, lock washer, and nut. See figure 2.
4. Bolt the front bed panel to the other bed side with (3) 1/4"-20 x 5/8" hex bolts, lock washers, and nuts.
5. Fit the rear cross sill inside the lower portion of the bed side rear stake pockets with the open side of the rear cross sill facing downward. See figures 3 and 4. The flanged side of the sill faces toward the front bed panel.
6. Using (8) 5/16"-18 x 3/4" indented hex head bolts, nuts, and lock washers, bolt the rear cross sill to the stake pockets. Use the bottom (4) holes in each rear stake pocket only for now.
7. Once these four pieces of the bed are assembled, you will need to make sure your bed is square. Measure the bed width at the top and bottom of bed sides to ensure that the bed sides are straight up and down and are 45-3/4" apart. See figure 5. Now tighten the rear cross sill bolts.



8. Measure crosswise from the front of the bed to opposite rear on both sides. These measurements should be within 1/16" of each other to ensure that the bed is square. Now tighten all bolts. See figure 6.
9. Place the assembly on supports horizontally to gain access to both the top and bottom of the bed floor area. See figure 7. This can also be achieved by standing the bed assembly vertical. Place a blanket or other suitable protection on the floor and stand the bed assembly on the front bed panel.
10. Place the wood boards that have only one bed strip groove (referred to as "edge boards") under the angle strips on the bed sides. The non-grooved edge should be toward the bed side. Leave approximately a 1/16" inch gap between the bed side and the board. See figure 8.
11. Mark all holes to be drilled in the edge boards through the angle strips holes. See figure 8.
12. The front of the edge board rests on top of the front panel lower flange. This flange bolts directly to the edge boards. Mark these holes through the holes in the front panel onto the bottom of these two edge boards. These holes should fall close to the middle of each board, approximately **5-3/8"** from each bed side.
13. Remove these two edge boards and drill all holes marked using a 3/8" wood bit. Be careful not to splinter the other side of the board when drilling. Placing a wood block behind the board where drilling will help prevent this. See figure 9.
14. Install the edge boards underneath the angle strips as in step #10. Place 5/16"-18 x 1-1/2" carriage bolts through the angle strips and the boards. See figure 10. Also install these through the boards and the front bed panel lower flange. Leave off the lock washer and nut for now.

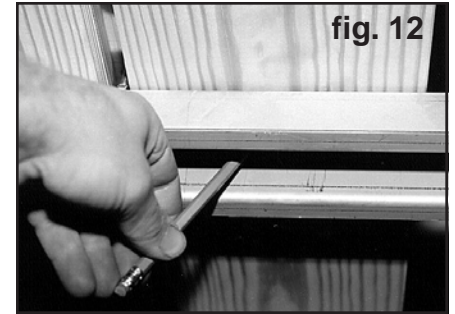


15. Attach the cross sills with brackets to the 5/16" bolts in the angle strips approximately **2-3/4"**, **20-13/16"**, and **47-1/8"** respectively from the front bed panel. Each cross sill gets two offset hole cross sill brackets. The cross sills should be installed so that when the bed is installed on the frame the cross sills should be open toward the ground. The front and second cross sills are the same. The third cross sill has special brackets that align to holes in the bedside. These brackets bolt to the bedside with 5/16-18 x 3/4" hex bolts. See figure 11.

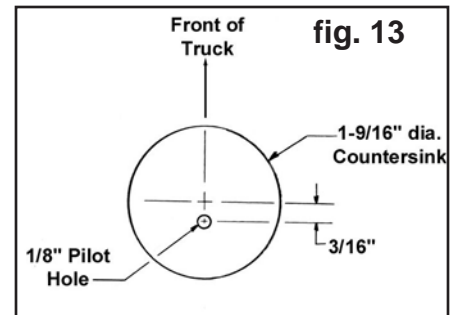


Note: The next step is to drill and countersink the locations for the bed-to-frame bolts and offset washers that sit on the top of the wood surface. If wood was purchased with the holes predrilled, skip to step #24. If wood was purchased without holes, the following steps will direct you through this process.

16. The first cross sill closest to the front bed panel is the first bed-to-frame hole location. Mark the bottom of both edge boards through the 5/8" diameter cross sill holes that are **36-1/16"** apart from center of hole to center of hole. See figure 12. The third cross sill is the second bed-to-frame hole location. Mark the bottom of the wood boards through the 1/2" diameter holes that are **41-1/8"** apart.



17. Make reference as to which end of each edge board is at the front of the bed. Remove the cross sills and boards. The bottom side of these boards should now have 1/2" and 5/8" holes marked on each of them. Drill a 1/8" diameter pilot hole through the center of these marks completely through the boards.

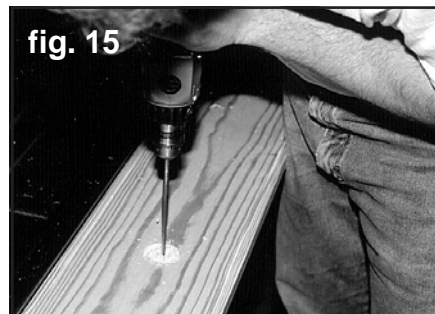


18. On the top surface of the boards, measure toward the front of each board 3/16" from the front pilot holes and mark the boards for the countersunk bed-to-frame offset washer. See figure 13.

19. Using a 1-9/16" diameter Forstner bit, a drill press if available, or a hand drill, countersink each location approximately 1/8" to 5/32" deep. See figure 14.



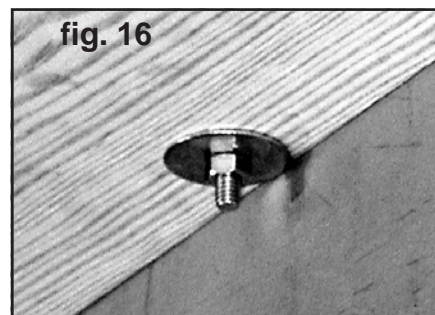
20. From the top surface, drill through the 1/8" pilot holes with a 1/2" drill bit to complete the bed-to-frame holes. See figure 15.



21. Reinstall the edge boards. All brackets should line up with the bed-to-frame holes in the cross sills and wood.

22. Tack weld the cross sill brackets in place. Make sure that the bed-to-frame hole spacing measurements are the same as listed in step 16.

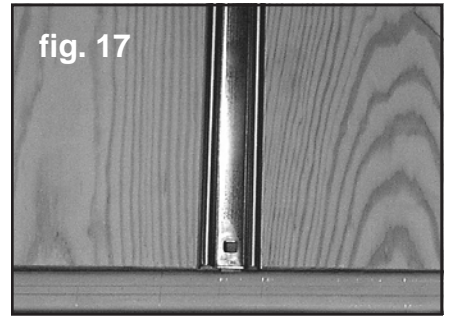
23. Where there is not a cross sill attached to the angle strip bolts, install a 1-1/2" outside diameter flat washer with a 5/16" diameter hole on the bottom of the wood surface before installing lock washer and nut hand tight. See figure 16.



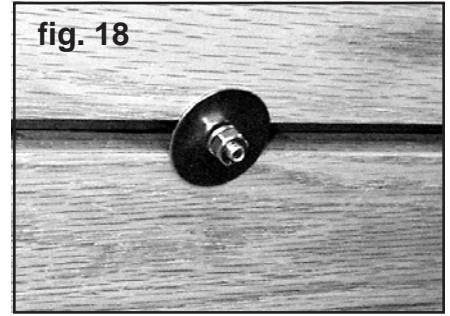
24. Install a 5/16" flat washer, lock washer, and nut to the front bed panel bolt attached to the edge board hand tight.



25. Place the next board into position on both sides leaving approximately a 1/2" space between the boards. Place a bed strip in the grooves on top of the boards. The end of the strip with the hole closest to the end is positioned on the rear cross sill. See figure 17. The bed strip holes should line up to each cross sill. Loosely install the 1/4" bed strip bolts, nuts, and lock washers. *If using MAR-K's custom bed strips with hidden fasteners, follow the instructions supplied with those bed strips for correct installation.*



26. Where there is not a cross sill under the bed strip bolt, install a 1-1/2" outside diameter washer with a 1/4" diameter hole before installing lock washer and nut. See figure 18.



27. Continue installing boards and strips from both sides working toward the center. Adjust the gaps between the bed strips and the boards before tightening the bolts. Do not over tighten or broken bolts and damaged bed strips may occur.

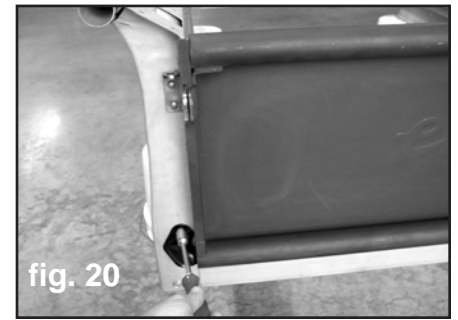
28. Mark the front of the remaining boards through the front bed panel lower flange as in steps #12 and #13 after the spacing of the strips and the wood is satisfactory. These holes will be drilled 3/8" diameter prior to wood finishing.

29. The rear cross sill has two large brackets that need to be bolted to the front. These brackets attach to the rear cross sill with two 5/16-18 x 3/4" hex bolts, lock washers, and nuts. The brackets bolt on with the open side of the brackets facing inward towards the truck center. The bracket should be against the bottom of the wood surface. These brackets have a dual pattern on them so that left or right are interchangeable. See figure 19.

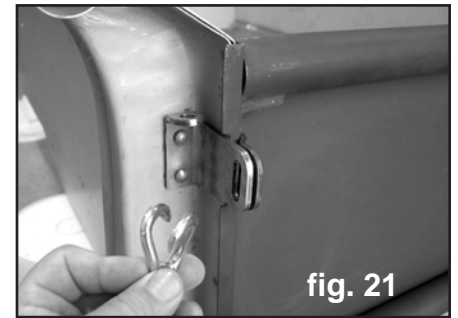


30. Install the completed bed assembly to the truck frame. This will enable you to check the alignment of the bed-to-frame bolt locations. The order in which parts are installed on the truck frame is: rubber pad, wood mounting block, cross sill bracket/cross sill, and the bed assembly.

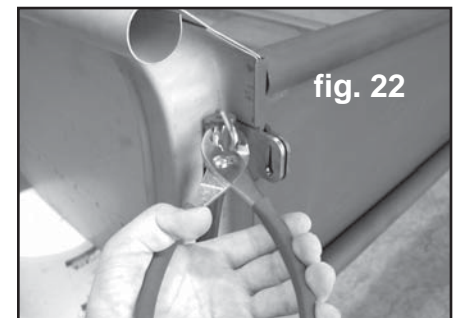
31. After checking the alignment of the bed assembly to the cab and frame mounting holes, install the (4) 3/8-16 X 6" bed-to-frame bolts and (4) offset washers on the top of the wood. Install the flat washers, lock washers, and nuts on the bottom side. Install the (2) 7/16-16 x 1-3/4" hex head bolt through the rear cross sill bracket and through the frame. These bolts only go through the bottom leg of the brackets. Secure with flat washers, lock washers, and nuts.



32. Install one hinge onto passenger side rear stake pocket with (2) 5/16"-18 x 3/4" indented hex bolts. Install the tailgate onto this hinge. Install the second hinge into the other end of the tailgate. Bolt the second hinge to the driver side stake pocket. See figure 20.



33. Install the tailgate chain closeable links onto the stake pockets brackets. See figure 21, 22 and 23. Squeeze the closeable links shut with pliers. This model has a left and right tailgate chain assembly. Check the tailgate for proper operation.



34. You have assembled the entire bed. Check all parts for correct fit and alignment. Be sure the bolts are in place and that all dimensions are correct. Now remove the bed from the frame and disassemble the parts to prepare for painting.



## FINAL ASSEMBLY

After the parts are painted, the bed is assembled by the same procedure. By taking the time to assemble and test fit the bed before painting, you have reduced the chances for errors or problems in final assembly.