

# MAR-K

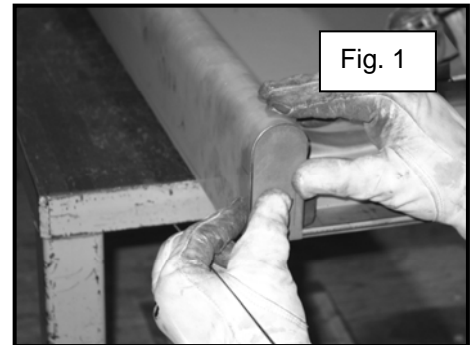
RESTORATION AND CUSTOM PICKUP PARTS

## TEARDROP INSTALLATION INSTRUCTIONS 54-87 GM STEPSIDE BED SIDES

Teardrops are panels that are designed to fill in the area at the end of the bed side curl to provide a smooth custom look. This part can be applied to the bed side at the rear end near the tailgate. Suggested installation is as follows:

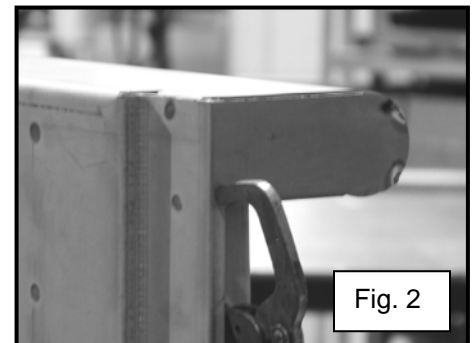
1. Make sure that the bed side panels are in good shape at the curl area and the top portion near the ends of the bed side. Straighten any bent areas on the top of the bed side and make sure that the curl is round.

2. Check the fit of the teardrop panel to the end of the bed side. The teardrop panel is designed to fit to the end of the bed side curl and not inside the curl or under the top surface of the bed side. See figure 1. The small flange on one side of the teardrop should be towards the bottom of the bed side.



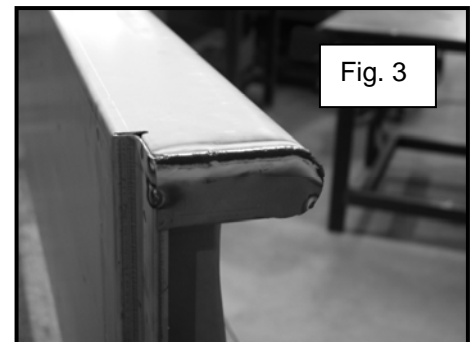
3. Grind the teardrop panel as required to obtain a good fit to the end of the bed side and sand off the electro-galvanized coating next to the weld area.

4. Grind or remove the paint from the bed side around the end of the curl and top area to aid in welding the teardrop panel in place. If you are installing on a new bed side with electro-galvanized coating, sand off the coating in the area that will be welded.

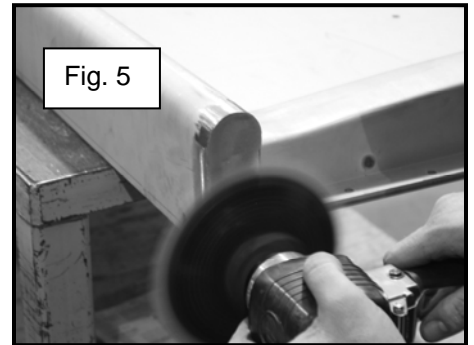
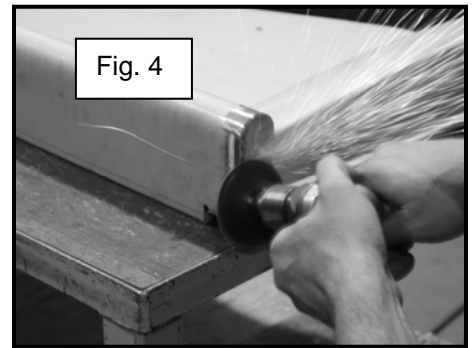


5. Hold the panel in position and tack weld in place. See figure 2. Two tack welds at the curl area and two along the top surface should be enough to hold the panel in place. Make sure that the teardrop panel has not shifted during this procedure.

6. Weld in the spaces between the tack welds until the entire seam is welded. See figure 3. Weld about 1/4" at a time and allow plenty of time to avoid heat build-up which could cause distortion of the teardrop or the bed side. You will be welding more than one bed side so alternate from one corner to the other to allow the welds to cool naturally before continuing.



7. Grind the welds as needed to smooth the surface and blend to the surrounding sheet metal. See figures 4 and 5. Fill uneven areas with plastic filler if needed and sand to desired contour.



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