

# MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

## INSTALLATION INSTRUCTIONS FOR TAILGATES WITH HANDLE, LINK ASSEMBLIES, & HIDDEN LATCHES FOR 58-66 GM FLEETSIDE TRUCKS

1. Assemble the bed and make sure the box is square. Measure the distance between the bedsides where the tailgate fits at the floor level and the top. This width should be 66-1/4". Also measure cross wise from one front corner to the opposite rear corner on the bed assembly in both directions. These measurements should be within 1/16" of each other. This is to ensure the bed assembly is not out of square.
2. If your bedsides are painted, place masking tape on all of the exposed surfaces of the bed sides around the tailgate opening.
3. It is advised to have a helper for this step. Place a standard trunnion into the passenger side of the tailgate. Insert this trunnion into the lower part of the bedside below the area that it bolts to. Let this trunnion and end of the tailgate drop as far as it will go.



4. Slide the trunnion into the bedside. Gently slide the trunnion and tailgate downward until a bolt will thread into the trunnion hole. Gently raise the other end and trunnion until it aligns with the trunnion bolt holes and bolt it in place. Leave the trunnion bolts slightly loose for now. They may need adjustment later in the process. The trunnions and bolts are not provided in this kit. Support the tailgate in the open or horizontal position.



5. We need to assemble the upper link and latch brackets. The strikers are bolted to these brackets with a 5/16-18 x 5/8" socket head cap screw provided in the kit. The back side of the bracket is counter-sunk for the bolt head and the striker mounts to the front. The passenger's side right hand is shown.



6. Hold the striker with a 9/16 open-end wrench and tighten the screw with a 1/4" Allen wrench. This is the driver's side left hand bracket shown.



7. The original bracket attached to the bed sides that the pivot bolt threads into must be removed. On most trucks this bracket is bolted in place from the factory. The new bracket utilizes these factory threaded holes. On some trucks however, the original bracket may have been welded in place. If this is the case, see the instructions for the bed side modification kit part # 100291 from MAR-K. The bolts used to attach the brackets are 5/16-18 x 3/4" indented hex washer head and are included in the kit. Tighten these bolts for now but they may need adjustment later.



8. Install the link assemblies to the tailgate. These are held in place by (2) 1/4-20 x 1/2" button head cap screws and 1/4-20 lock nuts. Install the bolts through the tailgate end so that the nuts will be on the same side as the link arm inside the tailgate end. Tighten the bolts and nuts using a 5/32" Allen wrench for the bolts and a 7/16" socket for the nuts. All of this hardware is provided in the kit. If you plan on installing a tailgate cover on the outside of the tailgate, you will need to weld the bolt heads to the tailgate end. This will allow the link assembly to be removed later. You may choose to reverse the hardware and weld the nuts to the tailgate end but do not use the nuts supplied in the kit. Use standard hex nuts instead. This will place the bolt head on the same side as the link assembly.



9. With both link assemblies installed, lift the tailgate while folding the link assemblies upward. Align the slots in the link arms to the oblong mount on the latch brackets on the bed sides. When both link assemblies are mounted on the latch brackets, allow the tailgate to drop back to the open position.



10. Next, we need to install the latches into the ends of the tailgate. Working on the right side of the tailgate as shown, install a latch shim and latch into the top area of the tailgate. The latch is held in place with two M6-1.0 x 30mm Phillips flat head screws. When installing the latch be careful to get the release arm into the latch without hitting the internal spring of the latch. When tightening the screws, make sure the shim stays behind the latch. You can lift up on the shim with a screw driver while tightening the screws.



11. Release the handle in the tailgate by pulling upward. Make sure both latches release and open. Slowly close the tailgate. The strikers on the bed side latch brackets should enter the latches on the tailgate and be centered in the latches. If not, an adjustment may be necessary in the trunnions or latch brackets on the bed sides. Close the tailgate and listen for the latches to lock. These are double locking latches so two clicking noises will be heard. Release the latches and open the tailgate.





12. You have successfully installed your new tailgate with hidden handle, latches, and links. Now all that's left to do is weld up the pivot bolt hole and enjoy using the new tailgate.



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