

# MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

## MODIFICATION INSTRUCTION FOR 60-66 GM FLEETSIDE TRUCKS WITH WELDED UPPER BEDSIDE BRACKETS

This instruction covers the modifications to the bed sides that are necessary to install Mar-K's Hidden Tailgate Latches, Tailgate Link Assemblies, or the Tailgate with Handle and Latches. Some of the 60-66 GM Fleetside trucks used a welded bracket on the upper portion of the bed side to thread the original pivot bolt for the chain into. For the Link Assembly Kit and the Tailgate with Handle and Latches, this bracket must be removed and replaced with one in the kit. This new bracket bolts into place requiring threads in the upper part of the bed side.

1. Remove the tailgate from the truck by unbolting one of the lower hinges from the lower bedside inner stake pocket. Also remove the chain assemblies from the outside of the bedside. Now remove the other hinge.
2. This is the bracket in question in the picture at the right. There are three areas of weld. Drill these out with a 5/32" drill bit. Try to keep the drill in the center sunken part of each weld. Use a center-punch if needed. Then use an 11/32" bit and just drill through the bracket only. Place the pivot bolt back into the bracket. Tap on the pivot bolt with a hammer lightly. This should be enough to break the bracket free. If you don't have the original chain bracket pivot bolt, use any bolt with a 7/16"-20 thread size.



3. After the bracket is removed, clean up this area with a wire brush. There will likely be corrosion behind this bracket. Your bed side should now look like this. The two holes in the middle and the large rectangular hole will not be used. These holes will be covered by the new brackets from the other kits. They can be left open or welded shut.



4. In most cases, the lower hole and the upper hole are the ones we need to be threaded. This modification kit (Part #100291 from Mar-K) includes a template to check this location. Use the upper hinge bolt and install the template onto the bed side. If the template lines up with the existing holes, you will just have to drill them out to a larger size. If they do not line up, they will need to be welded shut and marked with the template and drilled in the proper location reference to the template.



5. We need to drill the holes out to  $17/32$ " in order to fit the nutserts supplied in the kit. Mar-K has a drill bit available for this. (See part # 50622 online).
6. Test fit the threaded insert into the  $17/32$ " diameter hole. Use a round file to enlarge the hole if the insert will not fit. Often, a drill will not make a perfectly round hole in sheet metal. Use the file to make the hole round. The insert must be installed so that its' flange is against the sheet metal surface of the bed side.

7. Special tools are available to squeeze the threaded inserts but we will tell you how to do this without these special tools. Obtain the  $5/16$ "-18 x 1-1/2" bolt and  $5/16$  hex nut supplied in the kit. Thread the hex nut about 1" onto the bolt. Place the bolt through the supplied flat washer and then through the  $5/16$ " diameter hole at the top of the marking template. Next thread the insert onto the bolt with the flange of the insert towards the template finger tight against the template.



8. Place the insert into the hole in the bed side. Make sure to hold the insert flange tight against the bed side. Allow the template to rotate downward to the hinge area of the tailgate. This template will act as a handle to keep the insert from rotating when the nut is tightened.

9. While holding the bolt head steady with a  $1/4$ " Allen wrench and continuing to hold the insert flange tight against the bed side, start turning the nut off of the bolt with a  $1/2$ " wrench. This will pull the bolt outwards and start compressing the threaded insert. The hex nut will be fairly hard to turn, so be prepared to exert some force on the nut. Turn the nut until it will not turn anymore and the insert will be fully installed. Now remove the bolt, hex nut, washer, and sheet metal handle.



Another Outstanding Part Manufactured in Oklahoma City, USA by



©Copyright 2010 MAR-K Quality Parts L.L.C. All rights reserved.