



INSTALLATION INSTRUCTIONS FOR THE FLUSH TAILGATE WITH HANDLE FOR FORD 51-87 FLARESIDES

1. Assemble the bed and make sure the box is square. Measure the distance between the bedsides at the floor level and the top. This width should be **49"** for the 51-72 short beds and **54"** for the 76-87 short beds and the 53-87 long beds. Also measure cross wise from one front corner to the opposite rear corner in both directions. These measurements should be within $1/16$ " of each other. Remove the chain assemblies if so equipped.



2. Assemble the tailgate hinge trunnion to the hinges as shown with the $5/16-18 \times 1/2$ " button head screws. Tighten the screws with a $3/16$ " allen wrench.



3. Place some masking tape over the hinge attaching locations on both bedsides. Install the hinges and the new tailgate and make sure it is aligned to your satisfaction.



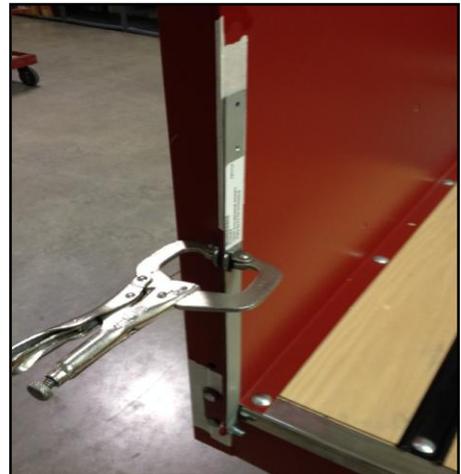
4. Mark the location of the hinges onto the masking tape so that they may be removed and re-installed in the same exact location.



5. Remove the hinges marked in step # 4 above and remove the tailgate. Install the hinges back into position using the marked masking tape as a guide. Also remove the trunnions from the hinges.



6. Bolt the template provided onto the hinge with the 5/16-18 x 1/2" button head screw and flat washer and nut provided so that the template can lay flat against the inside of the bedside. The outer edge of the template should be even with the outer edge of the bedside. Clamp the template in place.



7. Mark the bedside through the two small 1/8" diameter holes in the template. These will be the location for the latch striker and the upper link mounting position.



8. Remove the template and center punch these locations and drill 5/16" holes through the bedside. Remove the burr from both holes on the inside and outside. Repeat steps 5 through 8 for both bed sides.



9. Next install the link assembly pivot onto both bed sides through the lower holes using the 5/16-18 x 1/2" button head screws. The button head goes on the outside. Place the provided stainless flat washer on the inside before attaching the pivots to the bedside. This keeps the link assembly from rubbing directly on the bedside. The link assembly pivot can be held with a 7/16" wrench while tightening the button head screw with a 3/16" allen wrench. Make sure that the flat washer is loose when the pivot is tightened. Position the flats on these pivots horizontal as shown.



10. Re-attach the trunnions to the hinges and re-attach the tailgate using the masking tape mark for the hinge location reference. Support the tailgate in the horizontal or open position.

11. Bolt the link assemblies to each end of the tailgate. These are held in place by (2) 1/4-20 x 1/2" button head screws provided in the kit. Use a 5/32" allen wrench to tighten these screws.



12. Lift the tailgate while directing the link assembly arms to the pivots attached to the bedsides. The link assembly arms will need to be folded in the upward direction for this. Lift the assembly until the slot in the link will fit onto the pivot.



13. Attach a striker to both bedsides in the top holes as shown. Use the 5/16-18 x 1/2" button head screws on the outside of the bedsides. Tighten the strikers with a 9/16" wrench while holding the button heads with a 3/16" allen wrench.



14. Place a shim into the latch area of the tailgate. Release the latch by rotating the inner black lever.



15. Place a flat head Phillips screw, provided in the latch kit, into the top hole of the latch. Slide the latch into position with the latch tilted slightly outward until lined up with the holes. Be careful to not move the shim. Tilt the latch toward the tailgate until it seats into position. It may help to slightly raise the handle in the tailgate which rotates the actuating arm.



16. Install the other flat head screw into the latch and tighten both with a Phillips screw driver. Repeat steps #14-#16 for the other side.



17. Push down on the latches to close them. You should hear two distinct clicks as they latch shut. Pull up on the handle. Both latches should release approximately the same time.

18. With the latches open, slowly raise the tailgate. Make sure that the link assemblies fold downward this time. As you approach the top, watch for the strikers attached to the bedsides to make sure they enter the latches. Close the tailgate completely. Again, you should hear two clicks from the latches.



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