

MAR-K

RESTORATION AND CUSTOM PICKUP PARTS

INSTALLATION INSTRUCTIONS FOR TAILGATES WITH HIDDEN LATCH & LINK ASSEMBLIES FOR 40-53 GM STEPSIDE TRUCKS

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 48-1/2" for a 40-46 model and 50" for a 47-53 model. 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. If installing this on a 1940 Chevy, you must remove the tailgate chain latches from each stake pocket before continuing. Weld all holes shut after removal of brackets. You must also use a pair of 1941-1953 hinges.

2. Apply masking tape to each hinge area on the rear stake pockets. Install the hinges and tailgate and make sure it is aligned to your satisfaction.

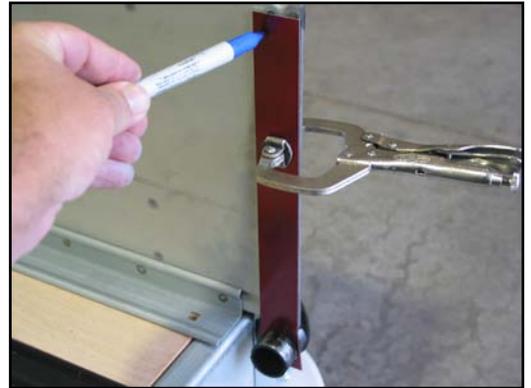


3. Mark the location of both hinges so they may be removed and re-installed in the same location.



4. Remove one hinge and remove the tailgate. Install the hinge back in the same location so that both hinges are in the exact mounting position they were when the tailgate was installed and properly aligned.

5. Use the template provided to locate the hole for the upper fixed pivot pin for the link straps. The large hole in the template goes over the hinge and the edge of the template is lined up with the rear edge of the bedside. The small hole in the template goes toward the front of the bed. Mark the hole location as shown. Do this for both bed sides.



6. Center punch these locations and drill a 5/16" hole through the bedside. Do this for both bed sides and deburr the drilled holes.



7. Install the fixed pivot pin at each of the 5/16 holes drilled in step 6 above. Use the 5/16" diameter button head screw to attach each pivot pin. The screw head is on the outside of the bedside and the fixed pivot pin is on the inside of the bedside. Place the stainless washer over the fixed pivot pin before bolting it to the bedside. Tighten the fixed pivot pin so that its flat edges are horizontal as shown in the photo.



8. Remove one hinge and re-install the tailgate, placing the hinge back in the same position as before.
9. Support the tailgate in the horizontal-open position. Install the link assemblies on each end of the tailgate. Use the 1/4" button head screws through the holes in the tailgate ends to attach the pivot brackets. The button head of the screws should be on the outside towards the tailgate script and the nuts on the side with the pivot bracket. Tighten the screws.



10. Carefully raise the tailgate while folding the links in the upward direction. This will allow the slot in the link assembly to fit onto the fixed pivot that you bolted to the bed side.



11. Lower the tailgate to the open position. Close the tailgate slowly making sure that the links fold downward this time. The links should fold smoothly into the tailgate end as the tailgate is raised. The tailgate should move to the fully closed position without causing any binding in the link assemblies.
12. This completes the installation of the check link straps. Now we need to proceed with the hidden latches.

13. Insert the hidden latch barrel into the tailgate end through the 5/8" diameter hole. At this time it does not matter which latch barrel you choose. Slide it in until the threaded hole lines up with the small hole in the tailgate skin. Bolt the latch barrel to the tailgate skin with the #10-32 button head screw. Tighten the screw with the supplied hex wrench.



14. The latch plunger and the latch barrel need to match. The latch plunger and the barrel have an angled cut on them that controls the direction of the locking knob. The angle on these needs to be pointing the same direction as shown. Slide a spring onto the latch plunger and slide the assembly into the latch barrel.



15. Place the shoulder bolt through the knurled side of the aluminum knob. Push in on the plunger until the threaded area of the latch plunger is visible in the slot. Thread the shoulder bolt into the latch plunger. Tighten the bolt with the supplied hex wrench.



16. Pull the knob towards the center of the tailgate and twist to lock it into position. You may need to twist up or down depending on which latch barrel and plunger you put in. You may also switch these from end to end on the tailgate to reverse this direction.



17. We need to drill a hole in the bed side for the latch to fit through. Raise the tailgate and observe where the latch plungers will contact the bed sides. Place masking tape on the inside area of the bed side where the latch plunger will hit. Release the plungers by turning the aluminum knobs. The plungers have a point on them that will mark the tape.

18. Lower the tailgate to the open position. Center-punch the marks in the masking tape. Drill a 5/8" diameter hole at each bed side location. We used a 5/8" diameter hole saw for this.



19. Remove the burr from the holes and install the supplied rubber grommets.



20. Close the tailgate and release both latches. Make sure that they enter the grommets.



You have now successfully installed your new tailgate, hidden latch system, and the link assemblies. During final assembly, use a quality lubricant on all the moving parts and a thread locking compound on the assembly hardware.



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