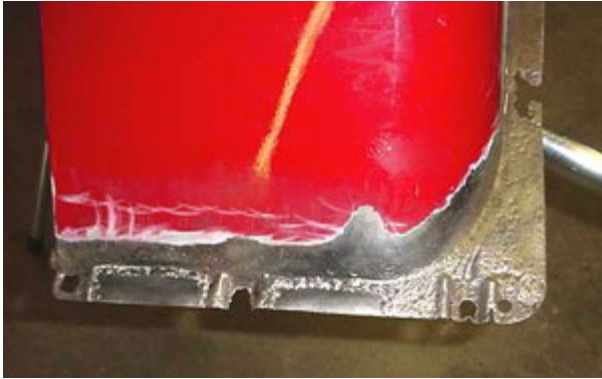


Installation Instructions for 58-66 GM Wheel Tub Repair Flange



These instructions cover the repair of the wheel tub flange where it meets the wood floor in 1958 to 1966 GM trucks with the Fleetside bed. These areas are prone to rusting because of the wood holding moisture and the steel flange resting on the wood floor. This repair flange may be used to completely replace this flange or be used in pieces to repair this area. The wheel tub pictured at the left is an extreme case of deterioration caused by rust.

1. Lay the repair flange on top of the wheel tub flange. The bed strip humps on the repair flange go in the upward direction. Line up the square holes in the repair flange with the holes in the wheel tub flange. Clamp the repair flange in place. If your wheel tub flange has the holes rusted away, use the humps to position the repair flange.
2. Using the repair flange as a guide, mark or scribe the cut line around the wheel tub. You will want to keep the cut line on the flat portion of the wheel tub. Do not mark the wheel tub on the vertical wall. The repair flange will not be enough to cover this area and you do not want to change the height of the wheel tub.



3. Remove the repair flange. Using a plasma cutter or a cut-off wheel, remove the damaged area of the wheel tub flange. Cut on the scrap side of the scribe line or marks made in the previous step. This wheel tub was rusted enough to need the complete flange replaced.



4. Fit the repair flange to the wheel tub. You may need to dress up the wheel tub where the damaged flange was removed. When the fit is good, tack weld the repair flange to the wheel tub in several places.



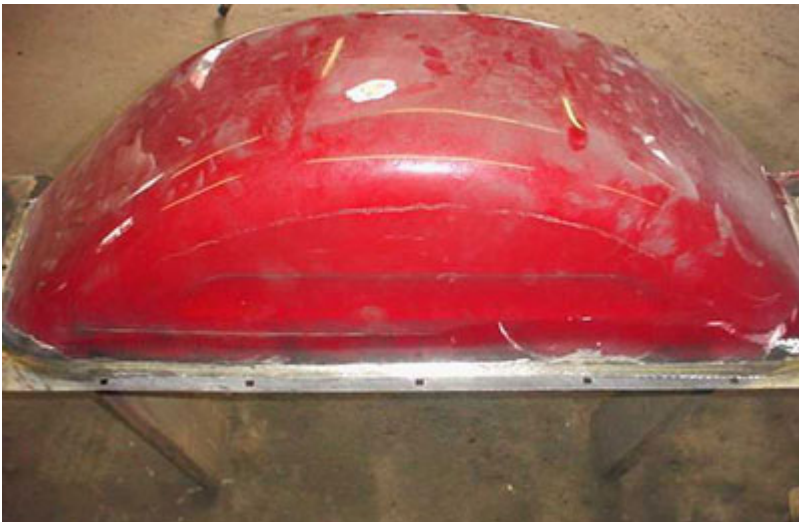
5. Continue welding the repair flange to the wheel tub. Use small welds and move around the wheel tub so that the repair flange does not warp from weld heat. If you are repairing both wheel tub flanges, alternate between them to allow the welds to cool.



6. Weld between the other welds until the entire seam is welded. Remember to allow the welds to cool so that warping does not occur. Check on the underside of the wheel tub for proper penetration of the welds.



7. Grind the welds smooth on both top and the underside of the wheel tub. Work slowly and avoid building up too much heat. Be extra careful around the hump areas where the bed strips go. A grinder could easily damage this area.



The repair flange should now be an integral part of the wheel tub. Sand these areas; primer and paint as desired.