

STEP ONE: Attach template.

With tailgate fully closed and gaps properly adjusted, fold Template (last page of these instructions) on dashed line and place in corner as shown. Adjust template up or down as needed for clearance at Tailgate Backing Plate and Nut Plate inside stake pocket. Once located, mark necessary holes with center punch and remove template for use on opposite side.



STEP TWO: Drill marked holes into bedside. (Holes **MUST** fall into stake pocket area as shown.)

Drill marked holes into tailgate as shown. **Note:** All holes should be 1/4" dia. **EXCEPT** lower hole in bedside, this hole will be 5/16" dia.

Any hole can be enlarged by 1/16" if necessary for adjustment.

For bedsidess with closed stake pockets, cut 1 1/8" hole (as shown on template) and insert nut plate through 1 1/8" hole.

HARDWARE INCLUDED:

- A - 1/4" External Tooth Washer - Qty. 4
- B - 1/4" x 1/2" Button Head Bolt- Qty. 12
- C - 6mm x 18mm Button Head Bolt - Qty. 4
- D - 1/4" Serrated Flang Nut - Qty. 8
- E - 5/16" Serrated Flang Nut- Qty. 2
- F - 3/8" x 1/2" Shoulder Bolt - Qty. 2
- G - 3/8" x 3/4" Shoulder Bolt-. Qty. 2
- H - 1/4" x 1/2" Captive Stud - Qty. 4
- I - M-8 125 Latch Bolt and Nut - Qty. 2
- J - 1/4" x 1/2" Barrel Trigger - Qty. 2
- K - 6/32" x 1/2" Allen Screws - Qty. 2

WARNING: When properly assembled, the cable assembly "safe working load limit" has been set at 375 lbs.

TECHINCAL SPECIFICATIONS:

Rotary Latch - Average ultimate load: 4600N (1,100 LBF)
Material = Steel, zinc plated.

Tailgate Support Cable - 1/8" 7x19. Breaking strength average of 2,000 lbs.
Material = Steel, galvanized with vinyl jacket

Latch Kit - Material = 14 gauge HRPO, zinc plated.

PAINTING:

Degrease. Use epoxy primer. Paint by the paint manufacturer recommendations.

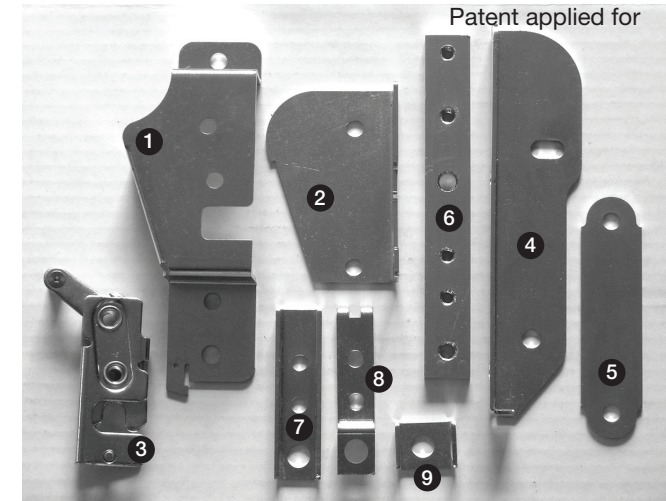
STAINLESS STEEL HARDWARE KIT AVAILABLE



On tailgates with double wall construction, "nutserts" (not supplied) can be used or an access hole can be cut in the side, nut placed in a 7/16" wrench, and installed through the access hole. Brake adjuster plug can then be used to fill access hole.



BOLT-ON TAILGATE LATCH KIT ASSEMBLY INSTRUCTIONS (with notes for Weld-On Kit in GREEN)



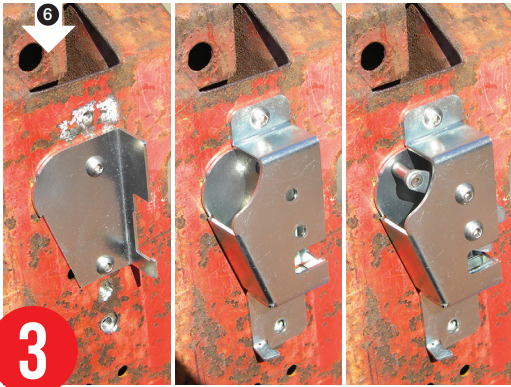
IDENTIFY ALL PARTS BEFORE BEGINNING INSTALLATION

Parts List:

- 1 - Latch Housing - Qty. 2
- 2 - Latch Housing Backing Plate - Qty. 2 (*)
- 3 - Bear Claw Latch - Qty. 2
- 4 - Tailgate Latch Bolt Bracket - Qty. 2
- 5 - Latch Bolt Bracket Backing Plate - Qty. 2 (*)
- 6 - Threaded Nut Plate - Qty. 2 (*)
- 7 - Adjustable Cable End Clamp - Qty. 2
- 8 - Clamp Backing Plate - Qty. 2
- 9 - Cable End Guard - Qty. 2

24" Tailgate Support Cable - Qty. 2

(*) - denotes part NOT INCLUDED in Weld-On Kit

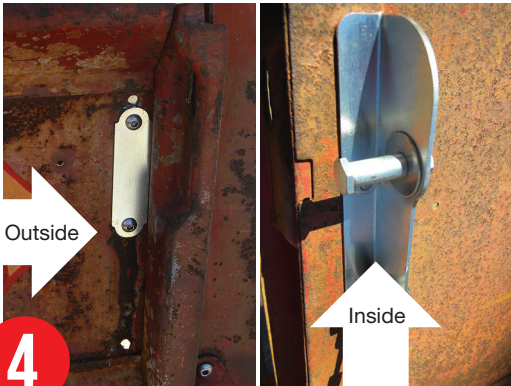


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STEP THREE: Insert Nut Plate (6) into stake pocket and align with previously drilled holes (making sure 5/16" threaded hole is at bottom).

Bolt Latch Housing Backing Plate (2) to bedside followed by Latch Body using 1/4" x 1/2" Button Head Bolt (shown left).

Using 6/32" x 1/2" Allen Screws, attach the 1/4" x 1/2" Barrel Trigger to the Bear Claw Latch (3). Bolt Bear Claw Latch to Latch Housing (1) using (2) 6mm x 18mm Button Head Bolts.



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STEP FOUR: Install Tailgate Latch Bolt Bracket (4), Latch Bolt and Latch Bolt Bracket Backing Plate (5), as shown to left, using 1/4" x 1/2" Button Head Bolt and Flang Nut.

For Weld-On applications use template to apply parts as closely as possible. Bracket should be 1 5/8" off of bedside. (See note on template)

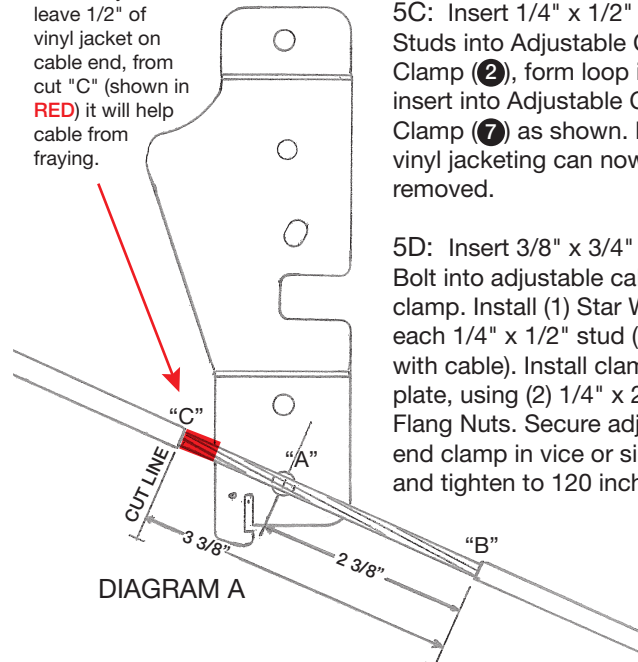
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STEP FIVE: Set cable length. Cables are shipped with formed loop on one end and an unfinished end which assembles into the Adjustable Cable End Clamp (7) allowing the user to set the finished cable length.

5A: Slip looped end into slot of Cable End Guard (9) and assemble to Tailgate Latch Bolt Bracket (4), using 3/8" x 1/2" Shoulder Bolt, 3/8" x 1" Nylon Washer and 5/16" Serrated Flang Nut.

5B: (SEE DIAGRAM A BELOW) Lower tailgate to desired position, pull open end of cable across 5/16" Dia. hole at bottom of Latch Housing and mark cable at center of 5/16" hole ("A"). Cut through cable at mark "C". Remove vinyl jacketing from cable end minus 1/2" to mark "B".

NOTE: If you leave 1/2" of vinyl jacket on cable end, from cut "C" (shown in RED) it will help cable from fraying.

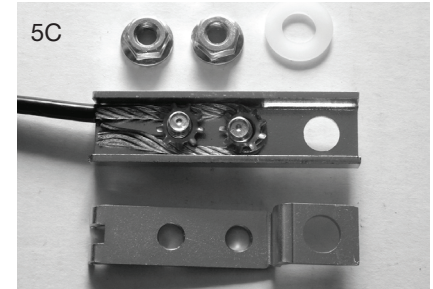


5C: Insert 1/4" x 1/2" Captive Studs into Adjustable Cable End Clamp (2), form loop in cable and insert into Adjustable Cable End Clamp (7) as shown. Extra 1/2" of vinyl jacketing can now be removed.

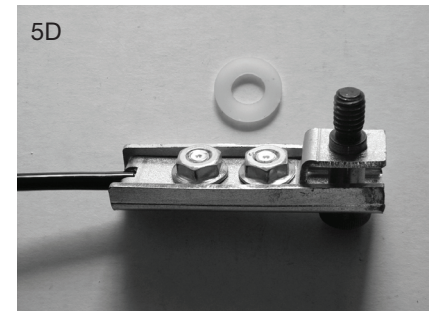
5D: Insert 3/8" x 3/4" Shoulder Bolt into adjustable cable end clamp. Install (1) Star Washer over each 1/4" x 1/2" stud (in contact with cable). Install clamp backing plate, using (2) 1/4" x 20" Serrated Flang Nuts. Secure adjustable cable end clamp in vice or similar device and tighten to 120 inch lbs.



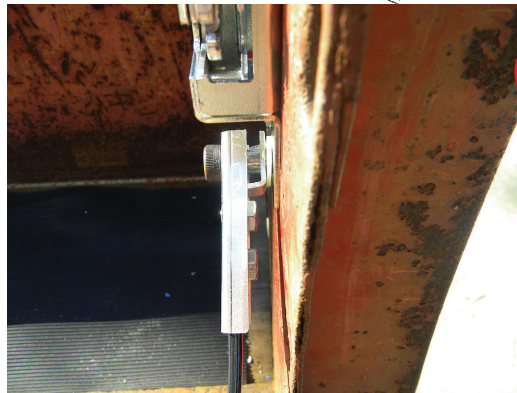
5A
Loop end attaches to outside of tailgate



5C



5D



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STEP SIX: Attach cable to truck bed, using 3/8" x 3/4" Shoulder Bolt and 3/8" x 3/4" Nylon Washer (as seen to left).

Now return to STEP TWO and repeat on other side of truck bed.