



**BED INSTRUCTIONS DOWN'S SPECIAL 1937**

(Revised 2002)

Thank you and congratulations on your purchase of the finest Street Rod Pickup Bed on the market today. The following instructions should help you assemble your bed in the most efficient manner.

**READ THE INSTRUCTIONS SEVERAL TIMES BEFORE STARTING ASSEMBLY**

- REQUIRED TOOLS**
- Flat work surface, floor or bench
  - Electric or battery drill
  - Drill bits - 1/8 - 5/16 - 11/32 - 25/64 - 17/32
  - Mig welder (optional)
  - Body grinder (optional)
  - Wrenches - 9/16" - 1/2" - 7/16"
  - 3/16 Allen wrench
  - Nutsert installation tool - available at a hardware or NAPA store
  - Tape measure & Felt tip marker

**STEP 1 UNPACKING**

Check the contents to make sure that it's all here!

<b>Description</b>	<b>Qty</b>	
Front panel	1	
Left bedside	1	
Right bedside	1	
Cross members	4	may be various sizes
Rear cross member	1	
Rear cross member hardware kit		

**STEP 2 INSTALL REAR Cross member**

The rear cross member bolts to the bed sides with two 3/8 x 1" bolts one each side. The rear cross member will sit on the bottom bedside lip and be flush with the rear of the lower bedside panel. **If your application includes our smoothie tailgate kit refer to step 10 on page 5 before commencing step 2.**

### STEP 3      **INSTALL THE FRONT PANEL**

The front panel has ½" returns on each end. These returns fit **inside** the bed side panels. The rear cross member has a bed wood support lip that supports the bed wood so that the bed wood is flush with the top of the rear cross member.

Clamp the front panel in place, smooth surface facing forward, ensuring that the top roll of the front panel is the same height as the top of the bedsides. Square the bed by measuring diagonally from corner to corner. To be square, the corner to corner measurements should be the same. Adjust as necessary. Once satisfied that the bed is square and clamped, **either** drill the bedsides through the holes in the front panel & bolt together, **or** weld the front panel to the bedsides through the aforementioned holes. If welding the front panel in place, it is advisable to also weld the bottom lip of the front panel to the bedside in each corner.

### STEP 4      **WELD & FINISH GRIND FRONT PANEL**

If you welded the front panel in place, grind off excess weld so as to leave a smooth finish.

### STEP 5      **INSTALL EDGE BOARDS AND SIDE ANGLE STRIPS**

In order to complete the installation you will require the bed wood, skid strips, side angle strips and appropriate skid strip bolt kit. These instructions apply only to Pro's Pick wood kits but the procedure for other kits are similar.

**A note about bed wood:**      Pro's Pick bed wood is kiln dried to a very low moisture content. The boards will take on moisture very quickly if they are not protected. As soon as your wood arrives apply two or three coats of the chosen finish, coating all six surfaces of the boards. If the finish is marked during assembly it can be remedied when the final 2 or 3 coats are applied.

There are eight boards in the wood kit. Six center boards and two edge boards. Place the two edge boards in place. The outside of the edge boards are the side that has the widest machined groove. Place the side angles onto the edge boards with the widest side of the angle sitting on the floor. In some applications the bolt holes are previously punched and in others you will have to drill the necessary holes.

The bed side angles must be bolted to the bedside. Assure that the bed side angles are sitting on the edge board and are fitting nicely to the bedside. With a felt marker, mark the side angle strip for attachment holes half way up the vertical leg of the side angle in

the location of the stake pocket .The object is to hide the required fastener inside of the stake pocket. Having marked the side angle strip, remove, center punch the hole location, and drill 1/8" holes. Reinstall the strip, using the 1/8" holes as a guide, drill 1/8" holes in the bedside.

Remove the side angle once more, enlarge the holes in the bedside to 17/32" and install the supplied 5/16 NC nutserts. Enlarge the holes in the side angle to 11/32". Bolt the side angle to the bedside.

At this point, make sure that the edge boards are perfectly straight. If there is any sagging down, or bowing up in the center, correct it by clamping a block, or blocks to the bedside. **THIS IS CRITICAL TO GET THE BEST RESULTS.**

## **STEP 6      LOCATE Cross member POSITIONS**

Locate the bed mounting holes in your truck frame. Measure the hole spacing from front to rear and write it down.

### **PRE PUNCHED BED STRIPS**

If you are using bed strips with pre-punched holes you will have to compare the spacing of the punched holes to the frame mounting holes to determine which end of the strips face the front of the bed. The bed strips have extra holes between some cross members so don't be concerned about it yet.

Having determined which end of the strips face forward, lay the rest of the wood into the bed. You will notice that the wood fits rather loosely to the bolt holes, this is as it should be to allow the wood to expand and contract. Lay in the bed strips, make sure they are all facing in the right direction.

Consult the packing list that came with the bed. You will notice that the cross members on the packing slip are designated A, B, C, or D and then the corresponding eight digit part number. A is the front cross member B the second and so on. There should be a paper tag on each cross member on which you will see the part number.

Having found the front cross member, place a carriage bolt in the front hole, through the bottom of the front panel in two of the strips. Fit the cross member up from the bottom and install a washer and nut loosely. Proceed in this fashion until all the cross members are hanging in place. Install the rest of the strip bolts into the cross members. You can now fill in the holes that do not have a cross member, use a large fender washer on these.

Before tightening the skid strip bolts, check to see that the bed is still square. Over-tightening the skid strip bolts will deform the strips. As you tighten the skid strip bolts have a helper watch to see that you are not over-tightening.

### **NON PUNCHED BED STRIPS**

If you are using bed strips that do not have pre-set hole positions the following procedure will be necessary. As described earlier in step 6 sort out the cross members and bolt them to the truck frame in the appropriate positions. Lift the bed onto the truck aligning the front bed panel with the front cross member. Check to ensure that the bed is square, adjust as necessary. **Cross member location is critical**, take your time. There are several ways of doing this, you could mark the location of each cross member on the side boards, however I would prefer to cut two temporary pieces of 1 x 6 to the correct bed wood length, lay them in as far as possible to the outside of the bed, drill the wood and bolt **all** the cross members to the 1 x 6 boards. Unbolt the cross members from the frame, remove the whole unit from the truck and place on saw horses. Verify that bed is still square. From underneath drill 5/16" holes through the cross members, edge boards and side angles. Bolt the cross members to the edge boards and angles. The cross members are now secure and the temporary 1 x 6 boards can be removed.

If your bed strips need to be drilled this is the time to mark out the hole locations and do it. Lay the center boards in place . Install the strips using the precautions mentioned earlier in step 6.

### **STEP 7      INSTALL BED ON TRUCK**

You are now ready to install the bed. Simply bolt the cross members to the frame.

### **STEP 8      FENDER INSTALLATION**

If you are using steel fenders, temporarily install the fender by clamping or holding in place. When satisfied with the fit, using a can of spray paint, paint through the fender mounting holes from under the fender. This will mark the fender hole locations. You may now remove the fender and drill the fender holes in the bed side

If you are using fiberglass fenders, starting in the middle of each fender, lay out a uniform bolt pattern. **Bear in mind that two of the fender mounting holes, one front and one rear, run through the bed side angles, before drilling these holes make sure that the edge board is perfectly flat, once these holes are drilled you are stuck with the result.** When satisfied with the bolt pattern, drill one fender for mounting holes. Clamp the left and right fenders together by their mounting flanges. Using a can of spray paint, paint through the drilled holes to mark the undrilled fender.

When installing the fenders use nylock nuts. Avoid over-tightening the fender bolts as it can distort the bed side.

## **STEP 9      SIDE ANGLE BOLTS**

As mentioned in step 8, two of the fender mounting bolts on each fender pass through the side angle strip. On the side angle find the center point between these two bolts. Center punch and drill first a 1/8" hole and finally an 11/32" hole. Install 5/19 button head bolt and nylock nut.

## **STEP 10     TAILGATE INSTALLATION**

Install hinges to rear cross member before installing the cross member to the bed sides. There are right and left hinges. The proper installation is with the flanged head of the bronze hinge pin bushing facing the center of the vehicle. Tap the hinge pin in until the head of the pin is flush to the pin sleeve. The hinge pin may now be protruding from the side mounting surface of the cross member, if so cut the pin off flush with a hacksaw. The cross member may now be installed as per step 2.

Point the hinges toward the rear of the vehicle in a horizontal position. With a helper, slide the tailgate over the hinges until the gate is about 3/16" from touching the rear cross member. We like to use a 3/16" spacer (like wood or cardboard) between the gate and the cross member. Have the other person install the four 3/8 x 1 button head bolts in the side of the gate. Close the gate to check adjustment, the top of the tailgate should be even with the bend on the bedside. Adjust as necessary. With the tailgate held in the closed position slide one of the stainless striker plates down behind the nylon latch bolt. You are now determining the position of the striker plate. Later, after the bed is painted, you will be installing a foam strip between the tailgate and the end of the bedside.

I like to temporarily attach the foam tape in place as it will affect the operation of the latch. Tension the striker plate towards the front of the vehicle in order to remove any slack in the latch assembly. Mark the striker attachment hole locations on the bedside, be sure that you are happy with the fit of the latch with the striker plate and that the striker is centered vertically on the latch bolt as once you drill the holes it is too late. With the striker plates installed the tailgate should only require a light push to close and should have very little movement when latched. Drill 1/8" holes for the striker plate attachment screws. Use a hex head sheet metal screw provided to thread the holes (the heads of the Philips screws will strip if you use them) install the Philips screws.

You will now install the check straps. The strap buckles are bent so that the strap material does not drag on the paint. Apply blue Loctite to the threads and fasten the check strap to the gate with a 1/4" button head bolt. Leave the bolt loose enough so that the strap will rotate freely on the bolt. Install opposite side. Support the tailgate about 3/16" above the horizontal position (the straps will stretch slightly with the weight of the tailgate).

Mark the hole location for the other end of the straps using the buckle as a locator, be sure

that this hole is centered on the stake pocket as the pocket will be used to hide the fastener. Drill a 1/8" hole then a 25/64" hole, install the 1/4NC nutserts provided. Apply blue Loctite to threads and install strap ends leaving bolts loose enough so that the buckle rotates freely on the bolt.

**We hope this has been a pleasurable experience** for you and once again thank you for purchasing our product. If you have any comments as to how we may improve our product line or ideas for new product you think would be valuable please drop us a line. Address correspondence to Paul Maurer at any of the following,

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