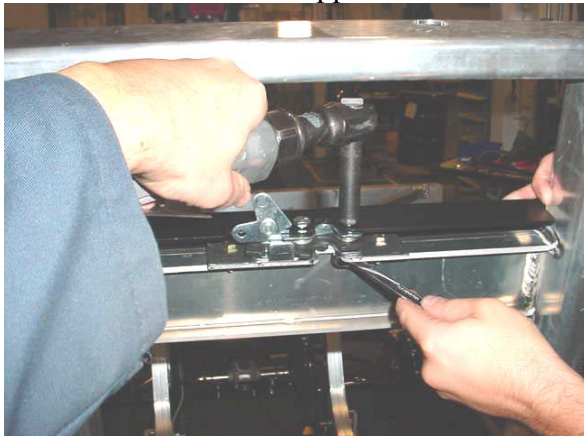
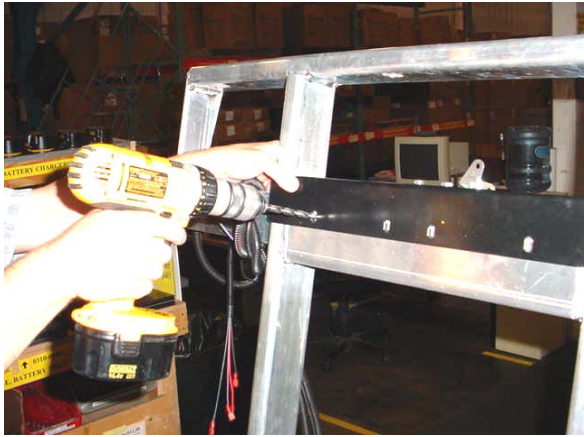
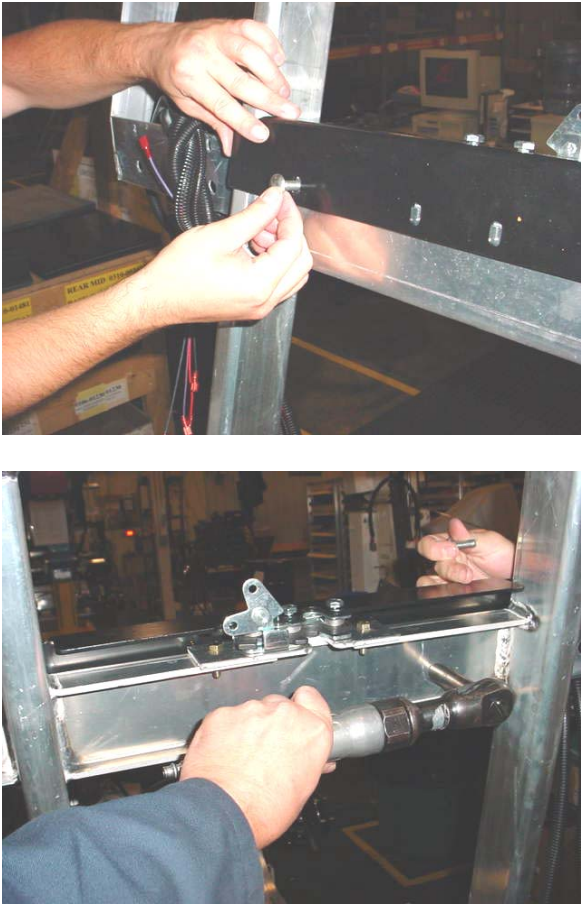


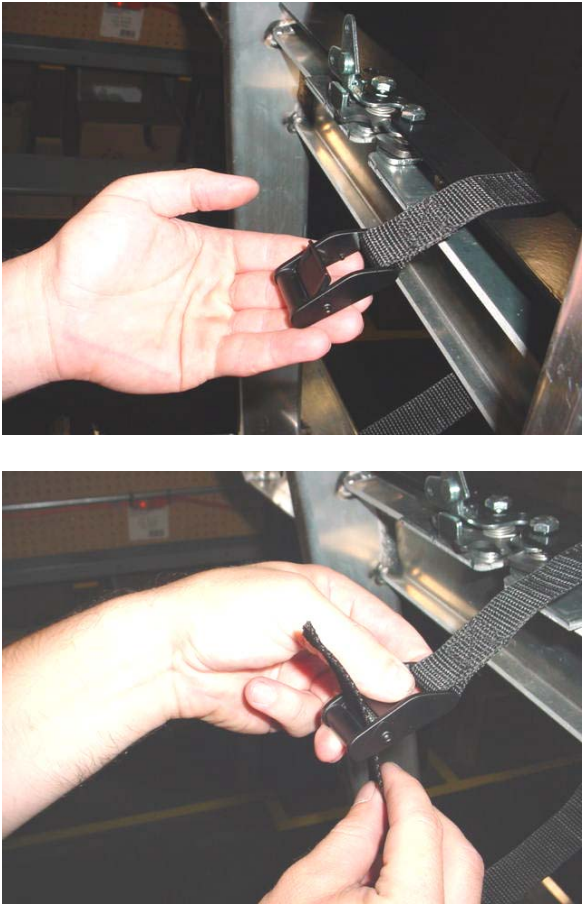
Clip In Stake Bed Installation Instructions

Step	Key Point
1. Disassemble packing materials and lay out parts on work area.	
2. In order for the clip in stake bed to work proper added support is needed. First remove the seat back.	<ul style="list-style-type: none">Refer to Service Manual – Section 7 BODY.
3. Next you will need to install the latch reinforcement support bracket. 	<ul style="list-style-type: none">Using the hardware provided in the kit, mount and secure to the cross member.This bracket adapts to ALL model GEM vehicles.Look at the latch before installation of the support bracket. The latch is currently secured with 2 bolts. A third hole is available, you may need to drill through the cross member and support bracket to secure properly.NOTE: If you find it necessary, the back panel can be removed for extra room to work as shown in the picture to the left. See Service Manual – Section 7 BODY.
4. Drill the holes for the front. 	<ul style="list-style-type: none">Use a 5/16 inch drill bit. It may be necessary to start out with a 1/8" pilot bit.Drill four holes.


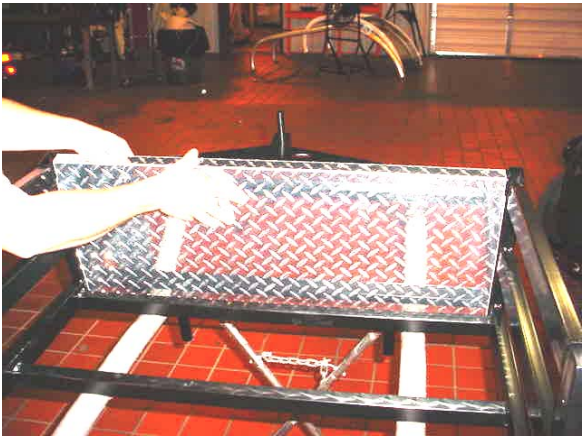

Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="219 262 730 304">5. Attach with carriage bolts provided.</p> 	<ul data-bbox="820 262 1453 525" style="list-style-type: none">▪ Tighten with a 3/8 inch pneumatic angle ratchet and 1/2" socket (hand held ratchet wrench or box wrench will work also).▪ In the case that you have not removed the back panel, you can gain access to the back side of the bracket without removing it but it may be difficult.



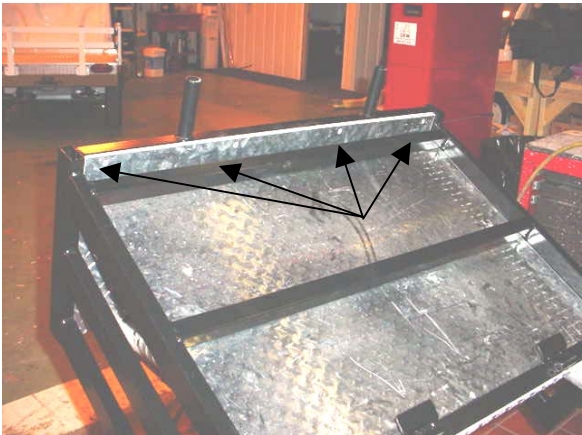
Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="215 264 509 298">6. Install safety strap.</p> 	<ul data-bbox="824 264 1430 369" style="list-style-type: none">▪ Place the strap around the entire cross member and reinforcement support bracket.▪ Insert strap into clip from the bottom.
<p data-bbox="215 1270 732 1375">7. Reinstall the seat back and any body panels you may have removed previously.</p>	<ul data-bbox="824 1270 1382 1297" style="list-style-type: none">▪ See Service Manual – Section 7 BODY.




Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="217 264 756 331">8. Begin build of stake bed frame. Place frame onto a work area or table.</p> 	<ul data-bbox="824 264 1175 296" style="list-style-type: none">▪ Any raised area will do.
<p data-bbox="217 804 781 871">9. Place front diamond plate panel to stake bed frame.</p> 	<ul data-bbox="824 804 1354 835" style="list-style-type: none">▪ Make sure that the rivet holes line up.
<p data-bbox="217 1344 532 1375">10. Place rivets and pull.</p> 	<ul data-bbox="824 1344 1422 1411" style="list-style-type: none">▪ Place all of the rivets before pulling any of them.


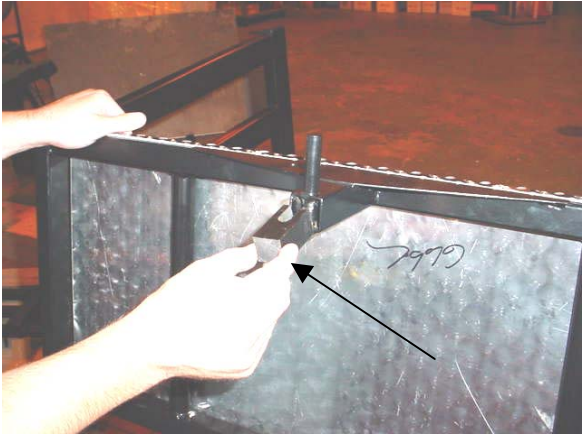

Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="219 264 764 331">11. Place the lower diamond plate panel to stake bed frame.</p> 	<ul data-bbox="824 264 1435 331" style="list-style-type: none">▪ Make sure that the holes along the back line up.
<p data-bbox="219 804 634 835">12. Place the end rivets and pull.</p> 	<ul data-bbox="824 804 1414 871" style="list-style-type: none">▪ After the end rivets are in, place the center rivets and pull.
<p data-bbox="219 1344 743 1411">13. Turn the bed over so that the forward rivet holes are visible.</p> 	<ul data-bbox="824 1344 1219 1375" style="list-style-type: none">▪ See picture to left (arrows).


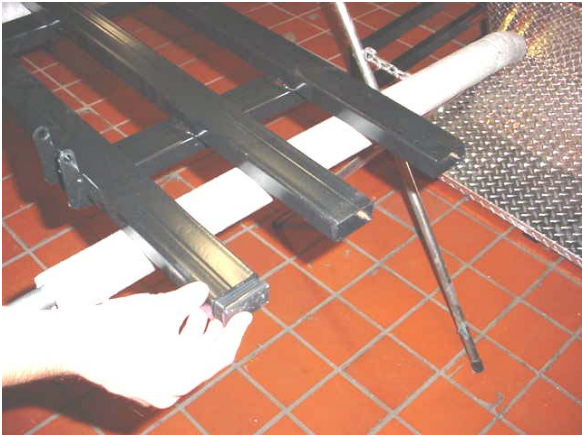
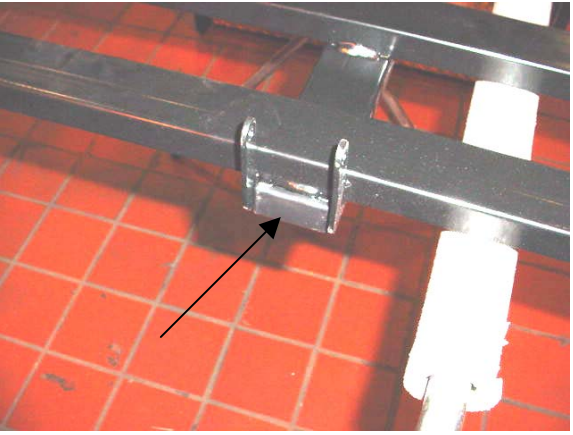

Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="219 264 581 296">14. Place the rivets and pull.</p> 	<ul data-bbox="824 264 998 296" style="list-style-type: none">▪ Set rivets.
<p data-bbox="219 804 618 835">15. Install the feet on both legs.</p> 	<ul data-bbox="824 804 1105 835" style="list-style-type: none">▪ See picture to left.
<p data-bbox="219 1344 656 1375">16. Install the bottom plastic caps.</p> 	<ul data-bbox="824 1344 1295 1375" style="list-style-type: none">▪ A rubber mallet is recommended.

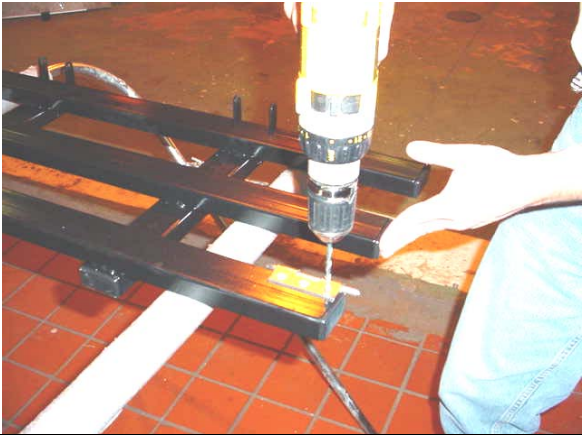


Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="219 264 787 331">17. Turn the bed over. Install the top plastic caps.</p> 	<ul data-bbox="824 264 1128 296" style="list-style-type: none">■ Use a rubber mallet.
<p data-bbox="219 804 787 909">18. Install the rubber bumper provided in the kit in to the tongue of the front square tube.</p> 	<ul data-bbox="824 804 1104 835" style="list-style-type: none">■ See picture to left.
<p data-bbox="219 1344 787 1411">19. Push the rubber bumper in until the slot is not visible.</p> 	<ul data-bbox="824 1344 1104 1375" style="list-style-type: none">■ See picture to left.


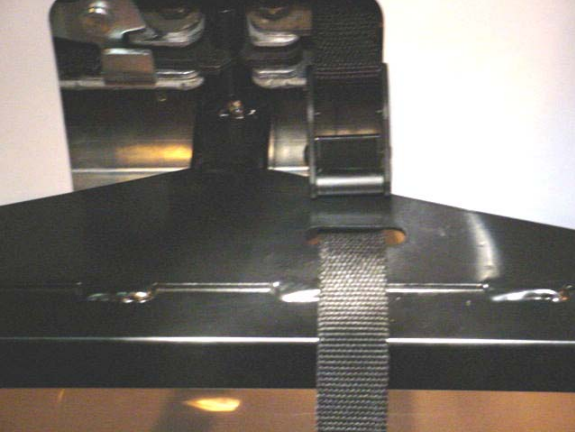
Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="215 264 711 296">20. Install the warning decal provided.</p> 	<ul data-bbox="824 264 1448 443" style="list-style-type: none">▪ NOTE: Do not exceed posted weight on the warning decal. Over loading may result in property damage and personal injury.▪ Clean area where decal is to be installed with isopropyl alcohol.
<p data-bbox="215 766 418 798">21. Install caps.</p> 	<ul data-bbox="824 766 1393 835" style="list-style-type: none">▪ Be sure that the top and bottom holes are filled as well. 
<p data-bbox="215 1308 670 1339">22. Install latches on to the tailgate.</p> 	<ul data-bbox="824 1308 1409 1339" style="list-style-type: none">▪ Pins should point outward from the frame.

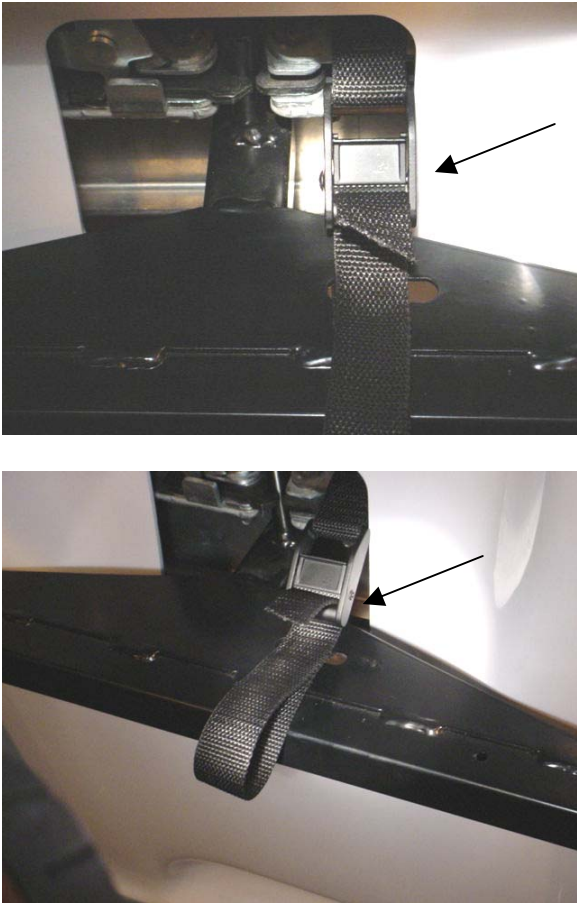
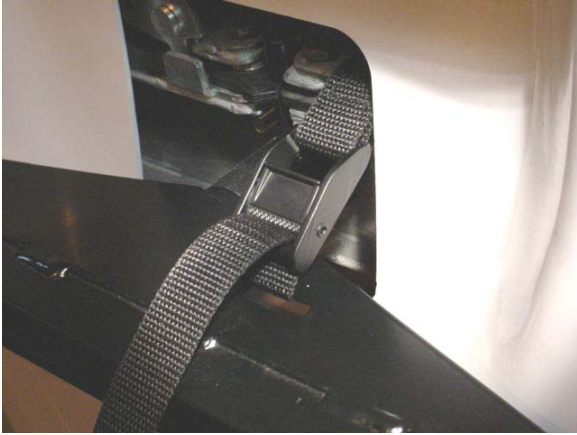
Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="217 264 634 296">23. Drill through the plastic cap.</p>  A close-up photograph showing a person's hands using a power drill to drill through a white plastic cap. The drill is positioned vertically, and a small amount of white plastic dust is visible at the point of contact. The background shows a metal frame and a red tiled floor.	<ul data-bbox="824 264 1187 373" style="list-style-type: none">▪ Drill to 3/16 inch.▪ Pull rivet and set.▪ Repeat for opposite side.
<p data-bbox="217 766 483 798">24. Place hinge pins.</p>  A photograph showing a person's hands placing hinge pins into a metal frame. The frame is black and has a silver metal plate attached to it. The person is using their fingers to push the pins into the frame. The background shows a red tiled floor.	<ul data-bbox="824 766 1105 798" style="list-style-type: none">▪ See picture to left.
<p data-bbox="217 1308 423 1339">25. Install clips.</p>  A photograph showing a person's hands installing clips into a metal frame. The frame is black and has a silver metal plate attached to it. The person is using their fingers to push the clips into the frame. The background shows a red tiled floor.	<ul data-bbox="824 1308 1224 1339" style="list-style-type: none">▪ Check operation of tailgate.

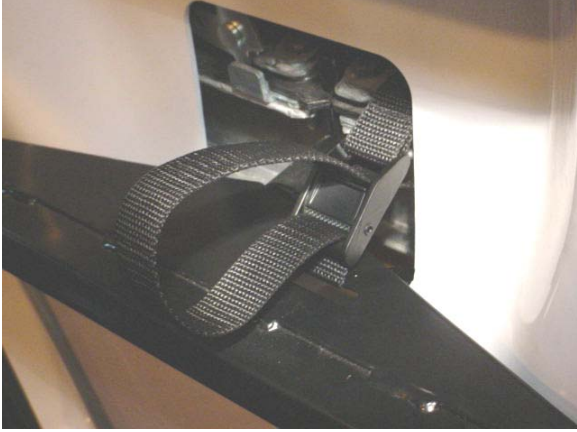

Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="217 264 786 331">26. Attach the Clip In Stake Bed to the latch of the vehicle.</p> 	<ul data-bbox="824 264 1450 407" style="list-style-type: none">▪ Use standard practices to attaching the bed to the vehicle.▪ The latch is a 2 stage clicking latch. Be sure the mechanism latches properly.
<p data-bbox="217 804 773 947">27. Secure the bed. Locate the black nylon pack strap. Feed the tail of the strap through the clip in stake bed from the bottom.</p> 	<ul data-bbox="824 804 1450 982" style="list-style-type: none">▪ See picture to left.▪ NOTE: The pack strap is an extra added safety measure to help secure the bed in to place and keep it from falling when the latch is released.

Clip In Stake Bed Installation Instructions

Step	Key Point
<p data-bbox="215 264 756 331">28. Feed the strap through the cam buckle from the bottom.</p> 	<ul data-bbox="824 264 1235 296" style="list-style-type: none">▪ See pictures to left (arrows).
<p data-bbox="215 1270 789 1302">29. Tighten the strap such that it is very taut.</p> 	<ul data-bbox="824 1270 1450 1375" style="list-style-type: none">▪ NOTE: The strap should be pulled tight and the bed should be completely latched and locked in to position.

Clip In Stake Bed Installation Instructions

Step	Key Point
<p>30. Feed the remaining tail of the strap through the opening in the cam buckle from the top.</p> 	<ul style="list-style-type: none"> ▪ This will act as a double tightener, and will not allow the strap to slip apart.
<p>31. Tuck the tail of the strap inside the back panel such that the strap lies flat on the buckle.</p> 	<ul style="list-style-type: none"> ▪ This is to hide any extra strap not being used and so it does not get wrapped in the latch.
<p>32. Installation complete.</p>	

Tools:

<ol style="list-style-type: none"> 1. Rubber Mallet 2. Drill (Electric or Cordless) 3. Angle Drill 4. Rivet Gun (Pneumatic or Hand) 5. Pliers 6. Ratchet Wrench 7. 1/2" Wrench or Socket 8. 7/16" Wrench or Socket 	<ol style="list-style-type: none"> 9. 3/8" Wrench or Socket 10. #2 Phillips Screwdriver 11. T27 Torx bit driver 12. 5/16" Drill bit 13. 3/16" Drill bit 14. 1/8" Drill bit 15. Isopropyl Alcohol
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