

# STEEL BED / FLIPSEAT KIT



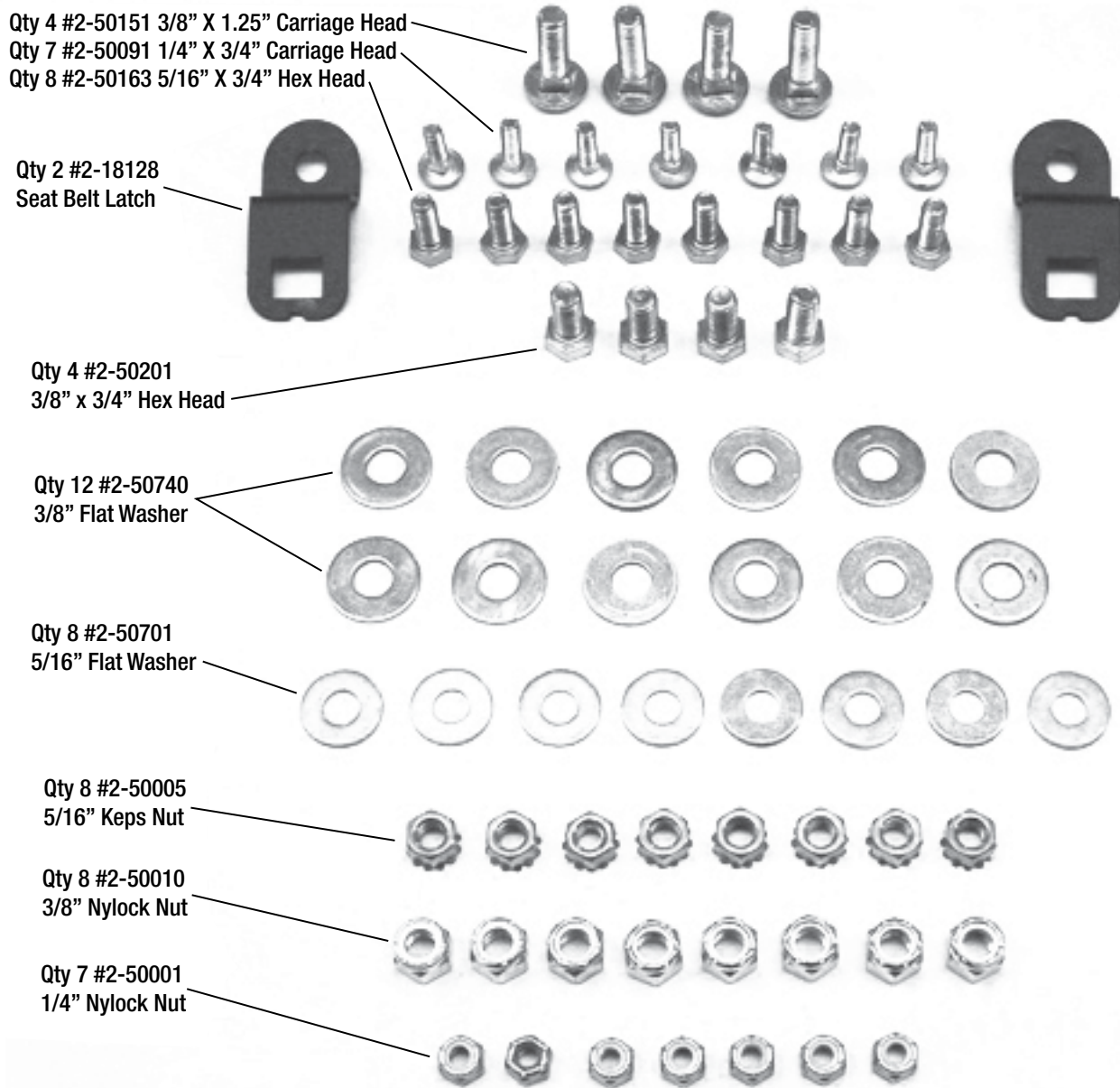
**In the package, and as  
illustrated at right,  
you will find:**

**Qty Item**

- 1 Leg Guard**
- 1 Right Side Weldment**
- 1 Left Side Weldment**
- 1 Seat Bottom Assembly**
- 1 Seat Back Assembly**
- 1 Tail Gate Weldment**
- 1 Seat Belt**
- 1 Foot Rest Weldment**
- 6 Zip Ties**



Also you will find the Fastener Kit as shown below.



**Additional fasteners used in the assemblies,  
but not included in the bolt bag are:**

**Qty Item**

- 6 Pt# 2-50627 1/4" X 1 3/4" self tapping screw
- 4 Pt# 2-50616 #10 X 3/4" screw
- 4 Pt# 2-50053 #10 Keps nut
- 4 Pt# 2-50084 1/4" X 3/4" hex head bolt
- 4 Pt# 2-50717 1/4" flat washer
- 4 Pt# 2-50716 1/4" lock washer
- 1 Pt# 2-50300 7/16" X 1" hex head bolt
- 1 Pt# 2-50025 7/16" Nylock nut
- 6 Pt# 2-50011 Zip Ties

**Tools required are as follows:**

- Ratchet
- 7/16" socket
- 1/2" socket
- 9/16" socket
- 7/16 combination wrench
- 1/2" combination wrench
- 9/16" combination wrench

## Step 1: Installation of the side weldments.

Note, if your vehicle has a standard tailgate, that tailgate must first be removed.

Using qty 4 of the 5/16" X 3/4" hex-head bolts and qty 4 of the 5/16" keps nuts, install the side weldments as shown at right. Shown is the left side, note that the lower footrest tabs are facing inward. The bolts install from the outside, with the keps nut on the inside. The right side installation is the same.

***Do not tighten these bolts yet.***



## Step 2: Installation of the footrest.

The footrest is attached to the bottom of the side weldments with qty 4 of the 5/16" X 3/4" hex head bolts, qty 4 of the 5/16" flat washers, and qty 4 of the 5/16" keps nuts. The bolts can be dropped into place from the top. Use the flat washers and then the keps nuts to secure the footrest in place.

***Do not tighten yet***





## Step 3: Installation of the leg guard.

The leg guard is installed using qty 7 of the  $\frac{1}{4}$ " X  $\frac{3}{4}$ " carriage head bolts, and qty 7 of the  $\frac{1}{4}$ " Nylock Nuts.

The 7 bolts install from the rear direction, with the nylock nuts installing from underneath the bed. These nuts are somewhat difficult to reach, a ratchet and socket are required for this installation.

Once installed, these fasteners may be tightened. There are holes on the sides of the plastic guard suitable to zip tie the guard to the tubes with the 6 provided zip ties. If your vehicle is not an LSV model, the illustrated tail lights are not included, or used.

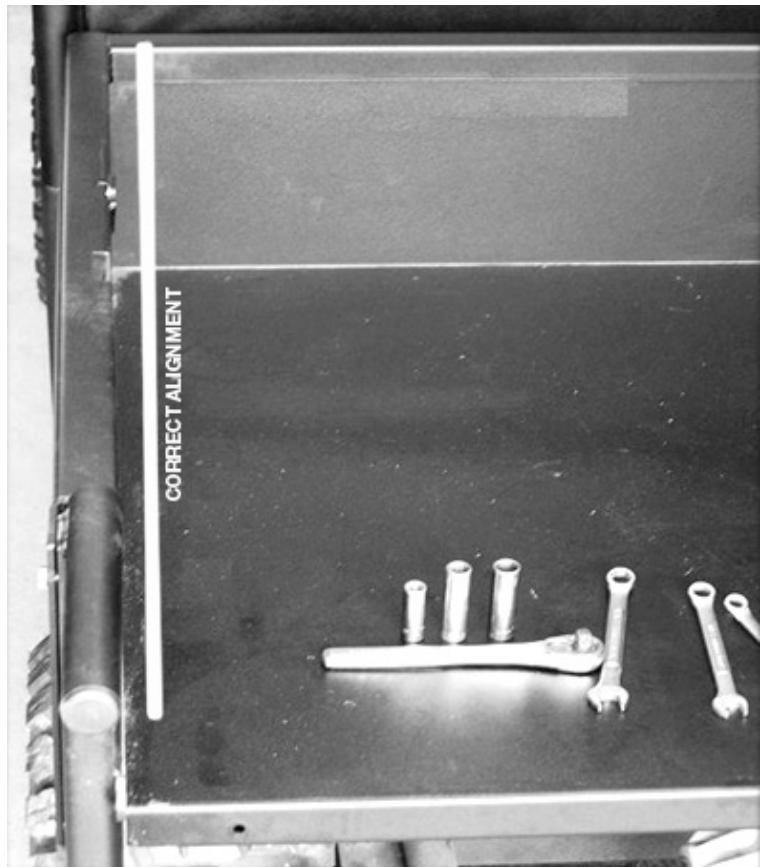


## Step 4: Aligning and tightening the side rails.

The side rails can now be aligned and tightened. Sighting down the side of the vehicle, the rear of the side weldments can be adjusted inward or outward to be straight with the side rails of the bed. Once this alignment is satisfactory, the lower bolts (in the footrest) can be tightened to maintain this alignment.

Once both sides are aligned, and the lower bolts are tightened, the side bolts may be tightened as well.

The photo at right depicts correct alignment.



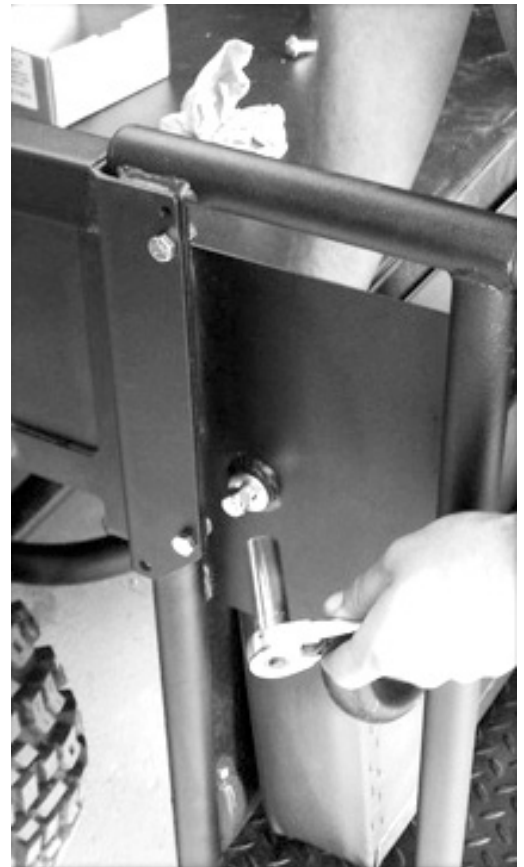
## Step 5: Installing the seat bottom.

The seat bottom is simply installed as illustrated at right, using qty 2 of the 3/8" X 1 1/4" carriage bolts, 2 of the 3/8" flat washers, and 2 of the 3/8" Nylock nuts. The placement of the flat washer between the seat bottom and the side weldment is important, as this washer allows the seat bottom to pivot easily. This carriage head bolt must not be completely tightened; it must be left loose enough to allow free movement of the seat bottom.

The photo at right shows the proper location of the hardware.



This subsequent photo shows the final installation into the side weldment, with the Nylock nut on the outside of the assembly.

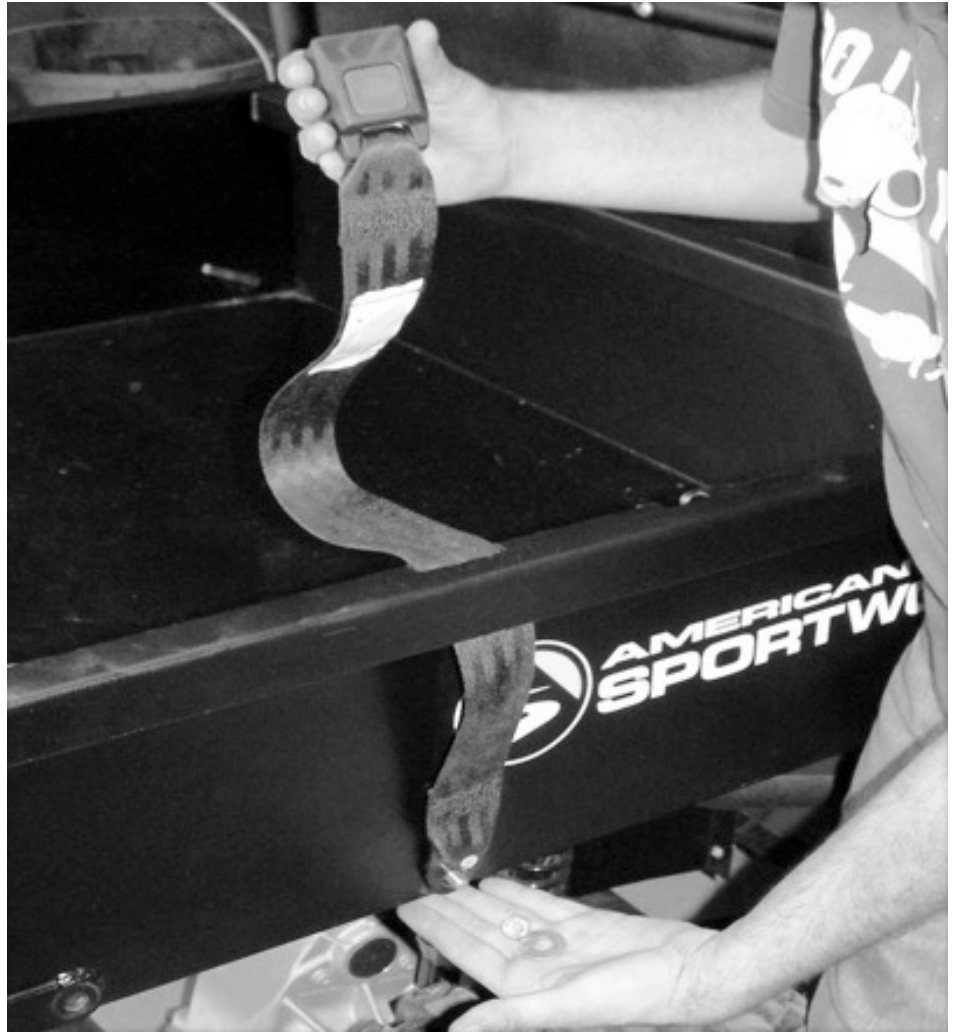


The photo below shows the final installation of the seat bottom.



## Step 6: Installation of the outside seatbelts.

The outside seatbelts are installed using qty 2 of the 3/8" X 3/4" hex head bolts, 4 of the 3/8" flat washers, and 4 of the 3/8" Nylock nuts. The seatbelt threads through the rectangular hole in the bed rail with the red latch button, **FACING OUTWARDS**, as in the first photo. The bolt and first washer inserts from the inside of the bed, the seatbelt and second washer slip onto the bolt from the outside. The seatbelt should be oriented straight up as in the photo, and tightened securely with the Nylock nuts.



## Step 7: Installation of the seat belt latch.

The seat belt latch is used to stow the seatbelts neatly away when not in use. The seat belt latches are installed using qty 2 of the 3/8" X 3/4" hex head bolt, 4 of the 5/16" flat washers, and 2 of the 3/8" Nylock nuts. (The smaller 5/16" flatwashers are correct in this application.) The latch is installed on the inside of the belt, as shown in the photo below. The latch, bolt and washer installs into the slot from the inside of the bed, with a washer and Nylock nut on the outside of the bed. The slot is designed to allow a degree of adjustment of the latch to allow for a taut seatbelt when in the stowed position.





The photo at right shows the seatbelt properly snapped onto the latch, in the proper orientation, and adjusted so that there is little “slack” in the seatbelt.

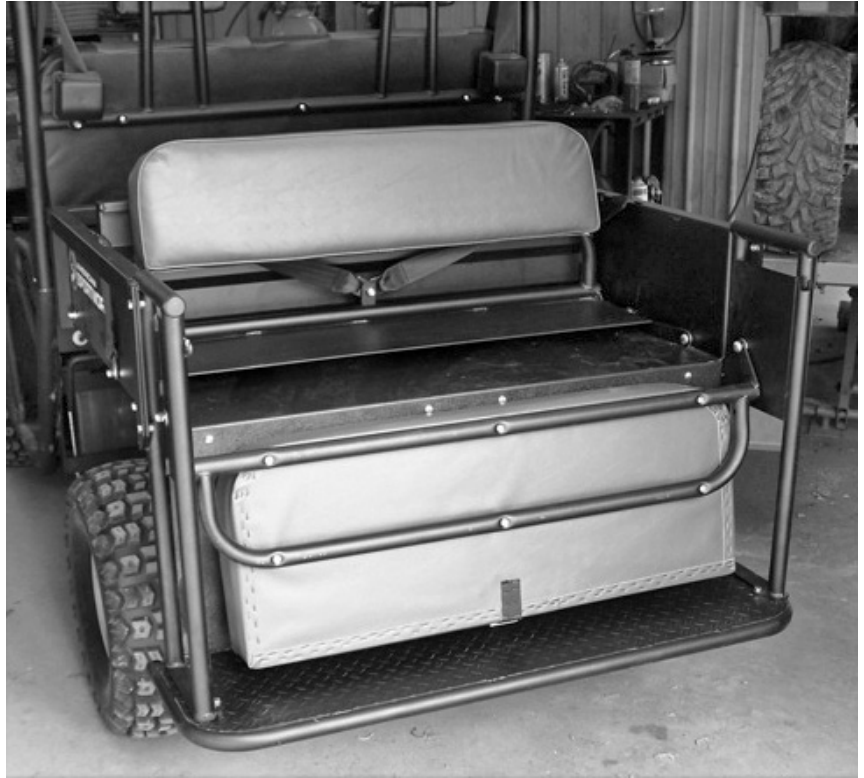


## **Step 8: Installation of the seat back / tail gate assembly.**

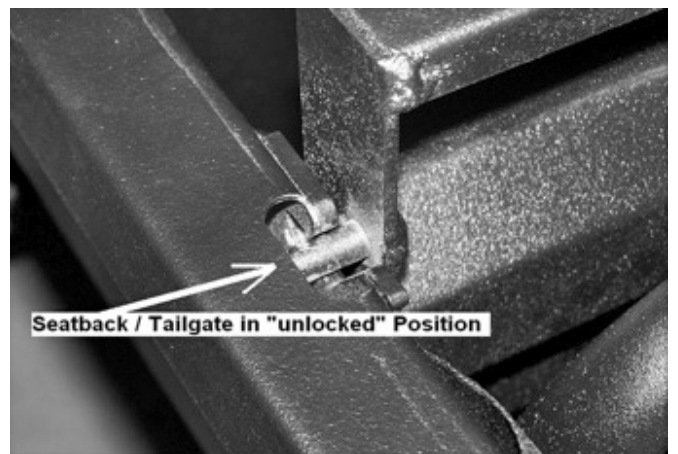
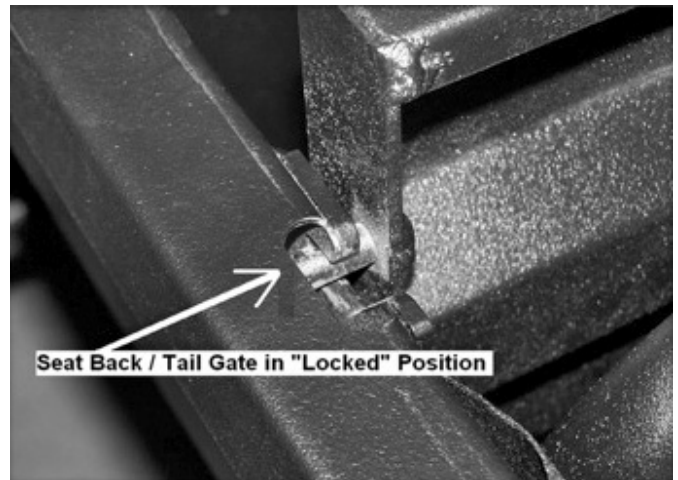
The seat bottom / tail gate assembly installs with qty 2 of the 3/8" X 1 1/4" carriage head bolts, qty 4 of the 3/8" flat washers, and qty 2 of the 3/8" Nylock Bolts. One of the washers installs in between the seat bottom and the bed rail to facilitate good movement between the two, as in the photo at right. The bolts install from the inside of the bed as shown, with the second washer and Nylock nut installed on the outside of the bed. These bolts are not tightened; they must be left loose enough to facilitate the movement of the seat back assembly.



**Pictured at right is the complete installation of the seat back / tail gate.**



To flip the seat into position for passenger seating, the tailgate must be pushed into the seat back to the “unlocked” position, and engaged into the slots in the bed rails. Once the seat back is flipped to the seated position, the tailgate is then pushed out of the seat back to “snap” into the locked position. You will note that the seat back / tailgate assembly is now locked and will not lift out of position. With the tailgate pushed into the seatback into the “unlocked” position, the seat back is ready for flipping, as in the photos at right.

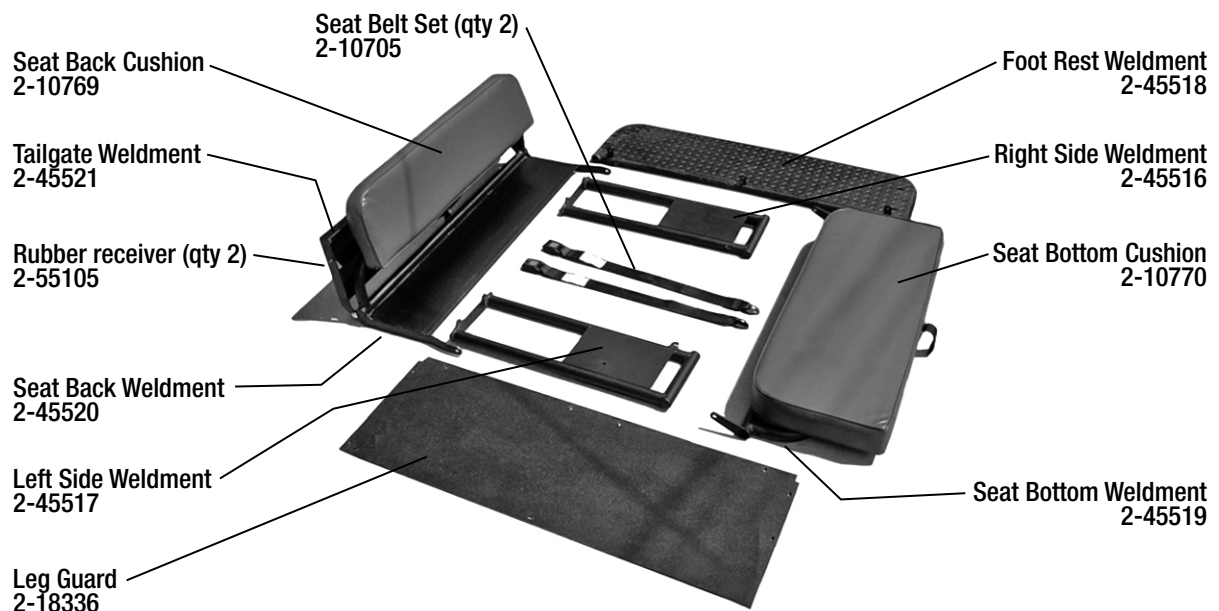




To the right are photos of the Flip Seat in the progression of positions from the "Passenger" position to the "cargo" position with tailgate up. Note how the seatbelts are threaded and hooked in the last photo to neatly stow away when in the cargo position.



## Additional Part Numbers are as follows



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