

CA00059 - BED, CONVERTIBLE STEEL BOX

CP00160 – Bed Installation and Assembly Guide

SPECIAL REQUIREMENTS: Used on steel beds made starting 2/2023.

BED INSTALLATION TOOLS REQUIRED		ESTIMATED INSTALL TIME	RECOMMENDED SKILL LEVEL
Hammer/Mallet		5 MINUTES	Intermediate

STEEL BED CONVERSION TOOLS REQUIRED		ESTIMATED INSTALL TIME	RECOMMENDED SKILL LEVEL
7/16" Socket & Ratchet	7/16" Wrench	20 MINUTES	Intermediate
9/16" Socket & Ratchet			

Before you begin, check the contents of the kit against the parts list below. Immediately contact American Landmaster with any questions or discrepancies. American Landmaster cannot assume responsibility for any damage or injury resulting from incorrect installation of parts. American Landmaster suggests that accessory kits be installed by an authorized American Landmaster dealer or service center.

!! WARNING !!

Serious injury or death could occur!

- Use proper personal protective equipment during installation of this kit. Use safety glasses.

PARTS LIST FOR AMERICAN LANDMASTER ACCESSORY KIT

Convertible Steel Bed / Flat Bed:

- (1) Convertible Steel Bed Assembly

Team lifting (2 or more people) is required for bed installation.

Bed Installation:

- 1- Place the bed on the rear of the vehicle so that the latch is engaged and the bed hinge brackets line up with the bed stub tubes on both sides.

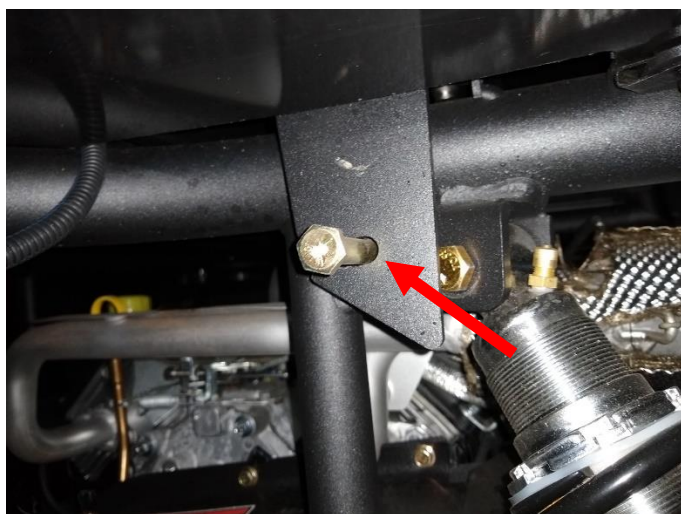


Figure 1: Bed latch fully engaged on the retaining bolt.



Figure 2: Bed hinge bracket lined up with the bed stub tube.

- 2- Insert the bed hinge pins from the outside of the bracket toward the center of the vehicle so that the pin passes through the bracket and bed stub tube. It may require a couple of taps with a hammer/mallet to fully insert the pin.



Figure 3: Bed hinge pin fully inserted through the bed hinge bracket and bed stub tube.

- 3- Insert the hair pin through the bed hinge pin to lock in place.



Figure 4: Hair pin inserted into the bed hinge pin.

CONVERTIBLE STEEL BED ASSEMBLY INSTRUCTIONS:

Assembly / dis-assembly can be conducted with the bed on or off the vehicle.

Converting from flatbed to box bed:

- 1- Follow steps 1-3 in the “Bed Installation” section above.
- 2- Verify the bed hinge pins are properly captured with the hairpin and the handle latch is fully engaged if the bed is on the vehicle.
- 3- Obtain the two side panels of the bed as shown in Figure 5.

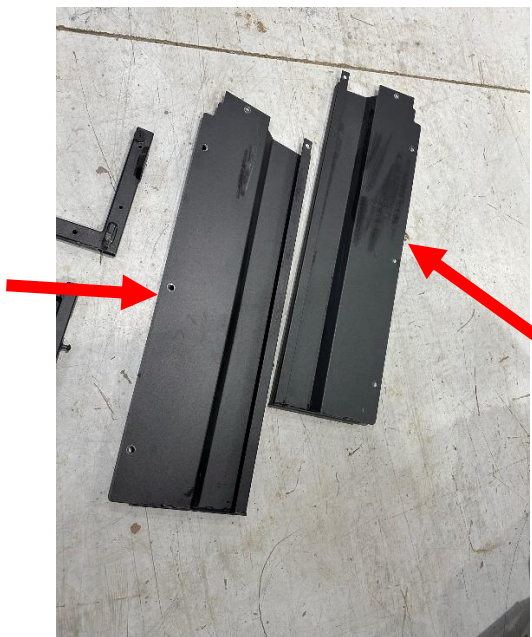


Figure 5: Side panels of the bed.

- 4- Install the side panels to the side of the bed by lining up the holes in the side panel to the holes in the flat bed and install using the 9/16” socket and 3/8” flange head bolts as shown in Figure 6 and Figure 7. It is best to leave the sides a little loose for right now.



Figure 6: This shows the side panel properly aligned with the header of the bed.



Figure 7: Four of the five side bolts shown completely installed.

- 5- Install the rear support weldment on the back of the bed using the four 3/8" washers and standard hex head bolts using the 9/16" socket as shown in Figure 8. It is best to leave the weldment loose.



Figure 8: The left and the right side of the rear support weldment lined with the side panels.

- 6- Install the 1/4" bolts through the rear support weldment tubes into the side panel using the 7/16" socket as shown in Figure 9.



Figure 9: 1/4" bolts installed through the rear support into the side panels.

- 7- Tighten rear support weldment and the side panels.

Installation Tip: If the side panel holes do not line up well with the holes on the side of the bed, install the upper bolt on the header and the rear most bolt on the side panel. Attach the rear support weldment to the side panels and then tighten down the rear support weldment. Then install the rest of the side panel bolts.

- 8- Install the tailgate by positioning the tailgate near vertical and pushing the pin down onto the pivot hook.



Figure 10: Tailgate installed.

- 9- Install the tailgate cables by installing the 1/4" bolt through the latch catch brackets with the cable loop placed between the bracket. Clip the other end of the tailgate onto the pin on the tailgate.

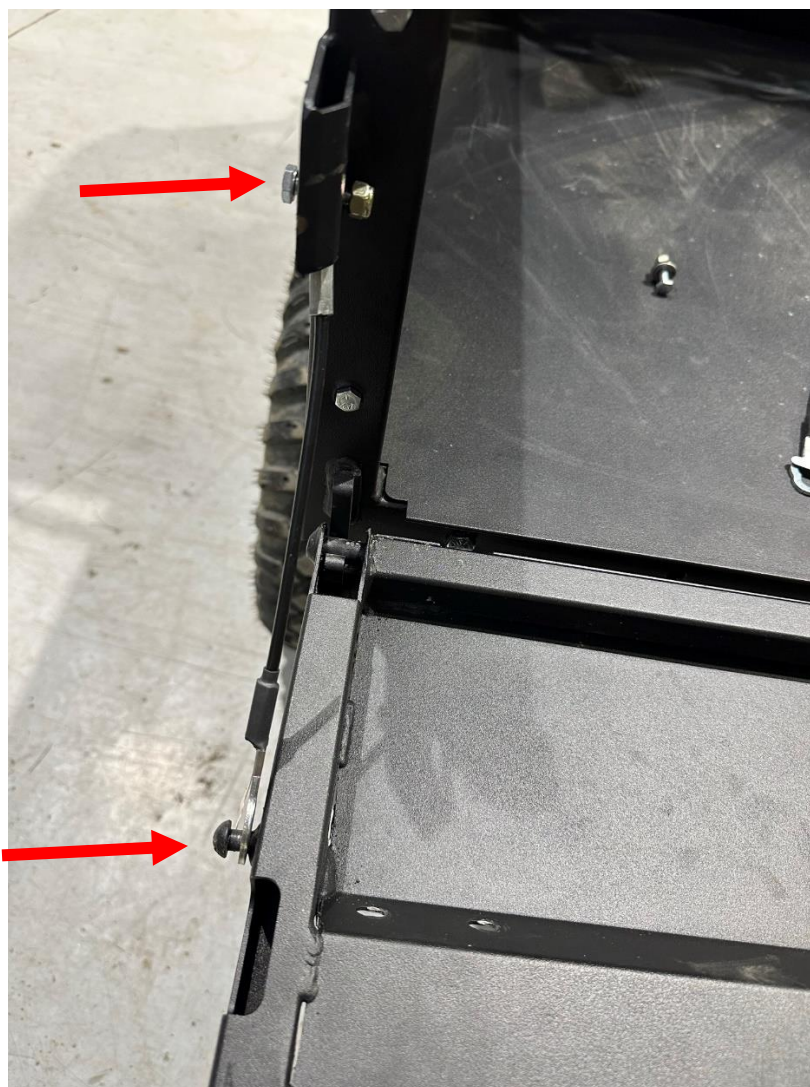


Figure 11: Tailgate cable installed.

10- Install the tailgate latches on the tailgate.



Figure 12: Tailgate latch installed.

11- Verify the tailgate latches when closed.

Converting the box bed to a flatbed:

- 1- Verify the bed is latched completely.
- 2- Remove the tailgate.
- 3- Remove the rear support weldment.
- 4- Remove the side weldments.
- 5- Place all parts in a safe and secure location.