



**FORD F100 SHORT BED (1953-1973)
VINYL TONNEAU COVER ASSEMBLY INSTRUCTIONS
#152183**

BEFORE STARTING ASSEMBLY, PLEASE READ THROUGH THE DIRECTIONS

- * We recommend a workspace large enough to accommodate entire cover such as a smooth garage floor or carpeted area.
- * Layout all pieces prior to assembly. Arranging the parts in the configuration shown in diagram #1 will aid in assembly.
- * Take care in dragging the vinyl cover over **any** surface to prevent damage.
- * The cover will be assembled with the top side facing down. The numbers on all parts should be facing up.

TOOLS REQUIRED:

- *1/2" Wrench
- *3/8" Wrench
- *Phillips Head Screw Driver
- *Flat Head Screw Driver
- *Electric Drill
 - ** 9/64" Drill Bit
 - ** 5/16" Drill Bit

FRAMEWORK PART LIST:

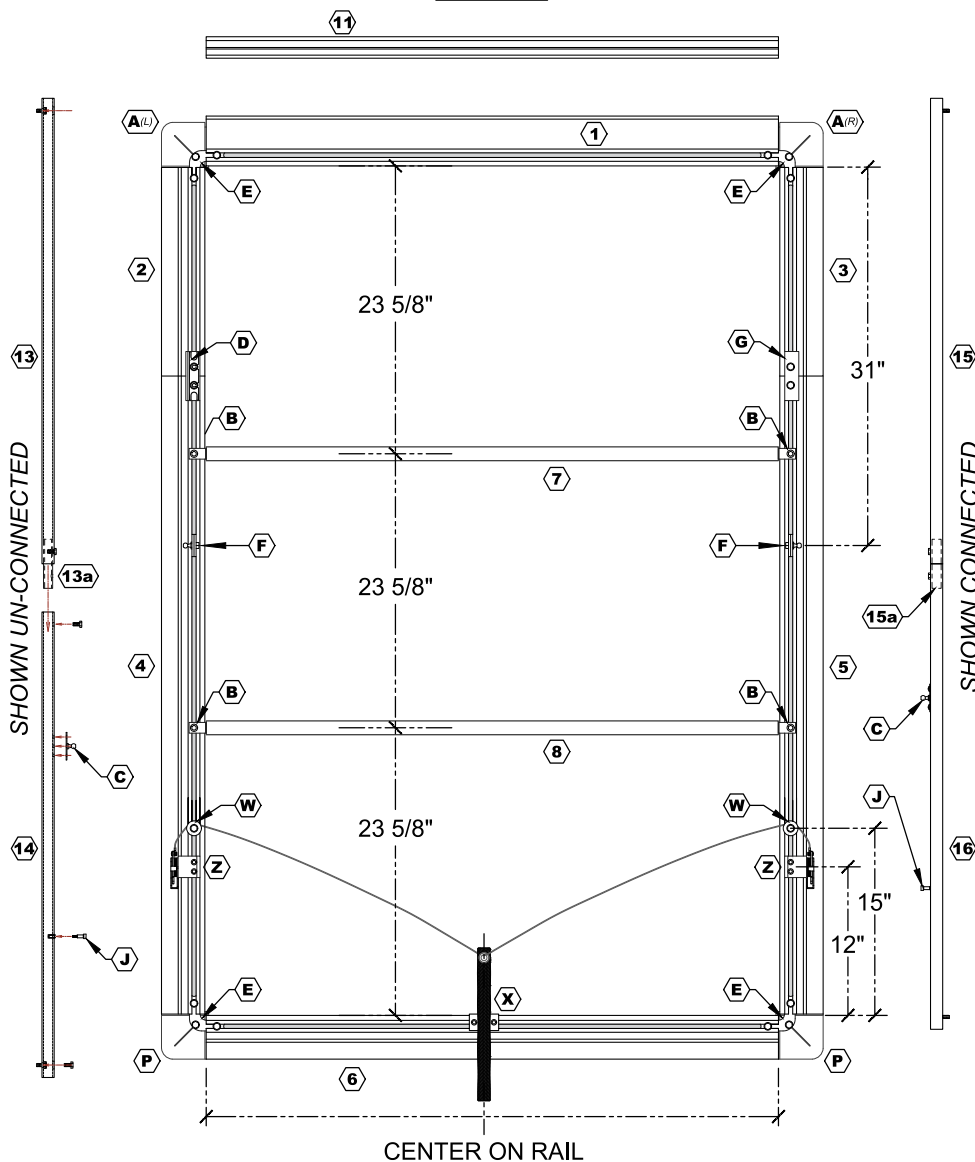
9 Main Framework Pieces

- ① Cover Hinge Rail
- ② Left Side (Cab End) Rail
- ③ Right Side (Cab End) Rail
- ④ Left Side (Tailgate End) Rail
- ⑤ Right Side (Tailgate End) Rail
- ⑥ Tailgate Rail
- ⑦⑧ Cover Bows
- ⑪ Bed Hinge Rail

4 Framework Support Pieces
(1x1 Square Tube Material)

- ⑬ Left Front Bed Side Rail
with Round Pipe Splice ⑬a
- ⑭ Left Rear Bed Side Rail
- ⑮ Right Front Bed Side Rail
with Round Pipe Splice ⑮a
- ⑯ Right Rear Bed Side Rail

DIAGRAM #1



PART IDENTIFICATION GUIDE

PART LIST:

One Set Of Assembly Instruction
One Vinyl Cover

- (T)** (2) 20 lb Shocks with Bed Rails
- (U)** (2) Bed Rail Side Supports
- (F)** (2) Cover - Shock Mounts [Pre-Assembled]
- (E)** (4) 3/4" x 3/4" x 90° Aluminum Corners
- (D)** (2) 3/4" x 3/4"x4" (2) Splices
- (G)** (2) Splice Braces
- (A)** (2) Front Plastic Corners (Notched)
- (P)** (2) Rear Plastic Corners
- (2) 6" Weather Seal
- (1) Small Flathead Screwdriver
- (1) 1/4" Aluminium Gauge Guide
- (4) Alcohol Wipes

Bow Receiver Bag

- (B)** (4) Bow Receivers
- (B2)** (4) 1/4" x 3/4" Flange Bolts
- (B3)** (4) 1/4" x 20 Weld Nuts

#17 Bolt Bag

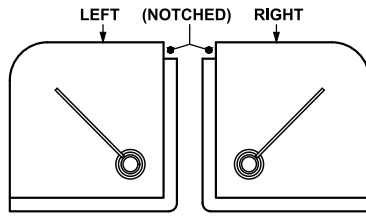
(17) 5/16" x 3/4" Thread Forming Bolts

Special Parts Kit

- (C)** (2) Triangle Bed Shock Mounts
- (12) #8 x 1/2" Screws
- (2) #10 X 2" Hinge Rail Screws

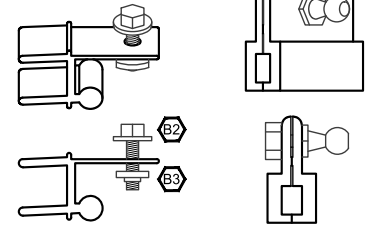
#17 Latch Handle Kit

- (Z)** (1) Rotary Latch Left
- (Z)** (1) Rotary Latch Right
- (J)** (2) Striker Pins
- (X)** (1) Pull Strap with Cable and Guide
- (W)** (2) Cable Tensioner Bolts



FRONT PLASTIC CORNERS

(A)

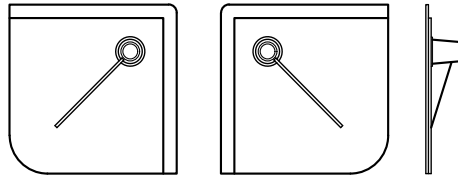


BOW RECEIVERS

(B)

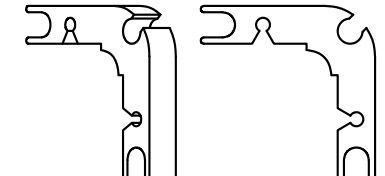
SHOCK MOUNT [COVER SIDE]

(F)



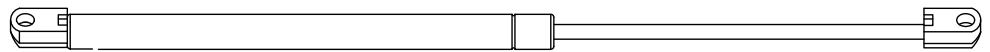
REAR PLASTIC CORNERS

(P)



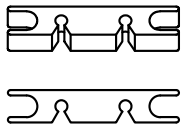
90° ALUMINUM CORNERS

(E)



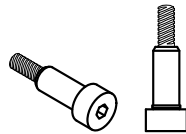
20 POUND SHOCK

(T)



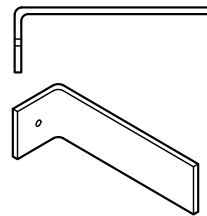
SPLICE

(D)



STRIKER PIN

(J)



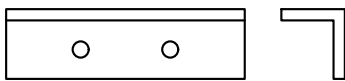
BED RAIL SIDE SUPPORT

(U)



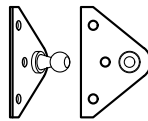
ROTARY LATCH [LEFT & RIGHT]

(Z)



SPLICE BRACE

(G)



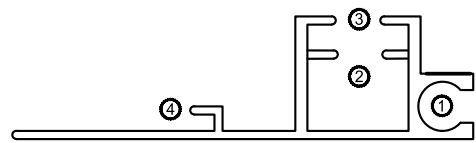
BED SHOCK MOUNT

(C)



CABLE TENSIONER BOLT

(W)



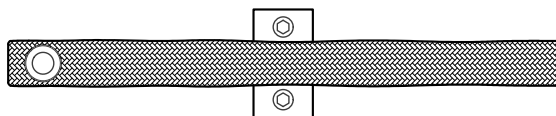
TYPICAL RAIL CONFIGURATION

① BOW SLOT

③ BOLT SLOT

② CHANNEL

④ "J" CHANNEL



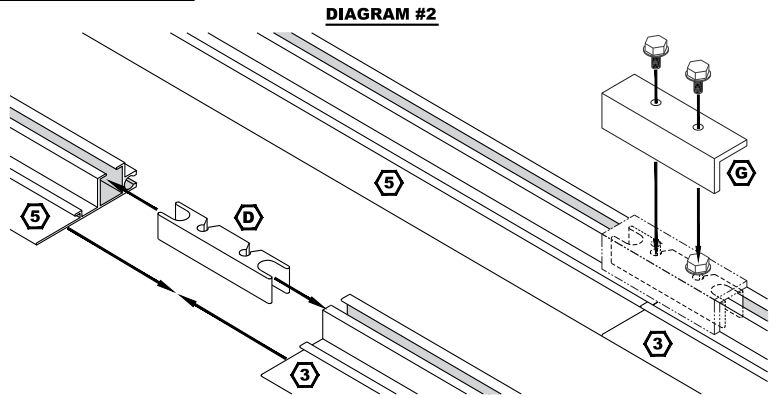
PULL CORD GUIDE PLATE

(X)

FRAMEWORK ASSEMBLY

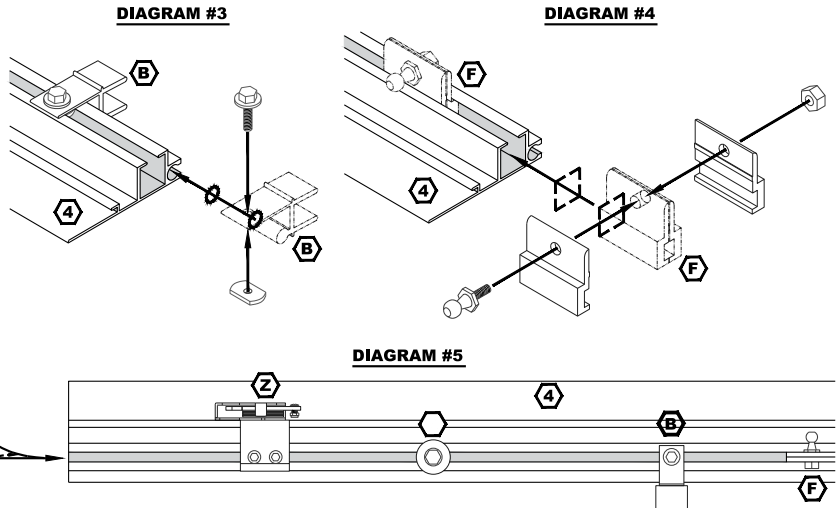
STEP 1 - SIDE RAIL ASSEMBLY:

Connect side rails ③ & ⑤, with splice ①. The "U" shaped arms should slide into the square channel of each rail. The rails should connect at the center of the splice. Bolt the splice in place with the splice brace ② using 2 thread rolling bolts. You will see no bolt grooves in part ①, this bolt will cut its own threads as it is screwed into place. Refer to *diagram #2*. Repeat this process with rails ② & ④, using the 2nd splice ① and splice brace ②.



STEP 2 - SIDE RAIL HARDWARE:

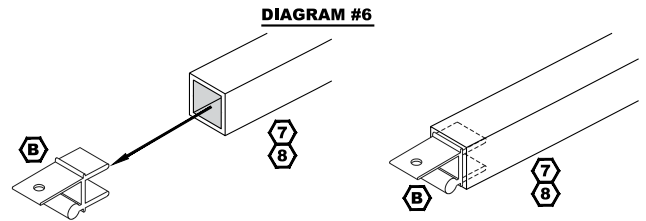
Refer to *diagram #1* for sequence and spacing of the components in rails. Measure and mark the locations of the hardware on the rails. To begin assembly, slide (1) bow receiver ③, followed by (1) shock mount ④, and then (1) additional bow receiver ③ into the end of rail ④. Refer to *diagram #3 & #4* for rail insertion. Repeat this same sequence with rail ⑤. Spread the shock mount halves ④ apart at the bolt holes as you push it through the channel to release tension for easier movement. Next, slide in a Cable Tensioner bolt ⑤ followed by Latch Assembly ⑥.



Refer to *diagram #5* for orientation of the Latch Assembly. Do NOT tighten Latch Assembly bolts to the rail at this time.

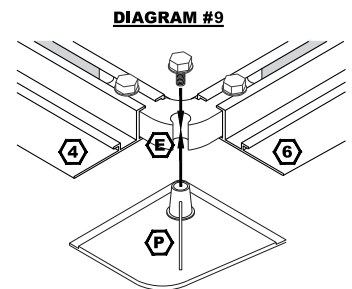
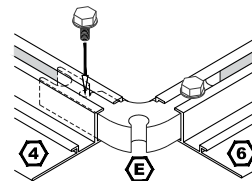
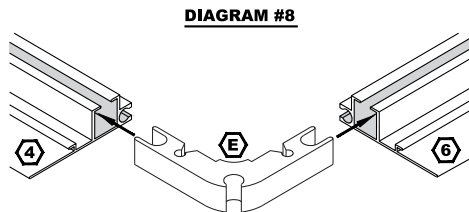
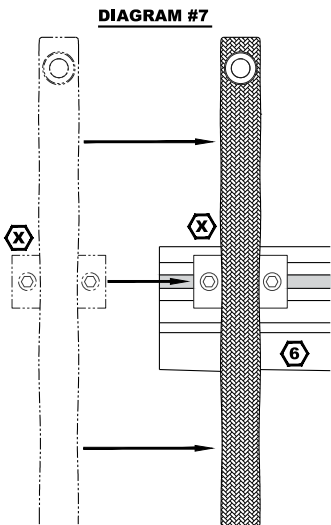
STEP 3 - ATTACH COVER BOWS:

Attach both cover bows ⑦ & ⑧ to the bow receivers ③ on each side rail. The arc of the cover bows should face down with the numbers face up. *Diagram #6*.



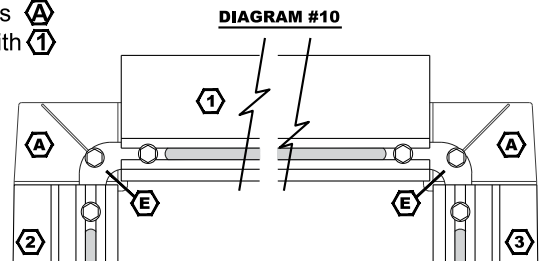
STEP 4 - TAILGATE RAIL

Slide Pull Cord Guide Plate ⑩ into an end of Tailgate Rail ⑥ *diagram #7*. Tighten bolts when centered to rail ⑥. Slide "U" shaped arms of one 90 aluminum corner ⑦ into the square channel of rail ④ & ⑥. Bolt the corner in place using two thread rolling bolts. See *diagram #8*. Attach a Rear Plastic Corner ⑧ to ⑦ by feeding the peg of ⑧ into the corner opening of ⑦ and bolt into place using thread rolling bolt. *diagram #9*. Repeat this process with rails ⑤ & ⑥.



STEP 5 - FRONT CORNERS:

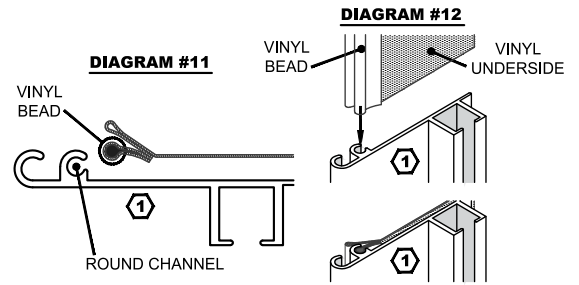
Front plastic corners ⑨ are notched to fit with ① and sides ② & ③



VINYL ATTACHMENT

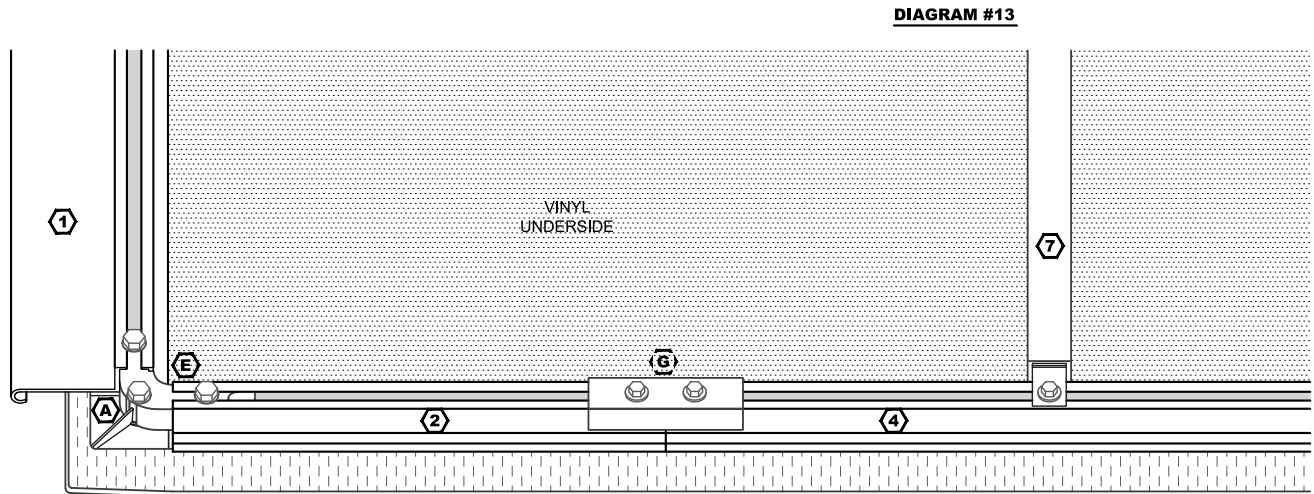
STEP 1 - HINGE END ATTACHMENT:

Flip the assembled frame over to proper vehicle orientation. Position the round channel bead of the cover which is located on the underside of the cab end of the vinyl cover close to the front rail ①, as shown in *diagram #11*. Feed the vinyl bead of the cover into the smaller round channel of rail. A little dish soap on the bead of the vinyl before feeding it into the round channel will provide lubrication to help the bead slide thru the full length of the channel. Refer to *diagram #12*. Continue feeding the vinyl until the cover is centered on the front rail.



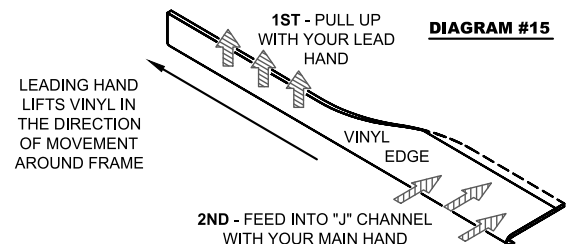
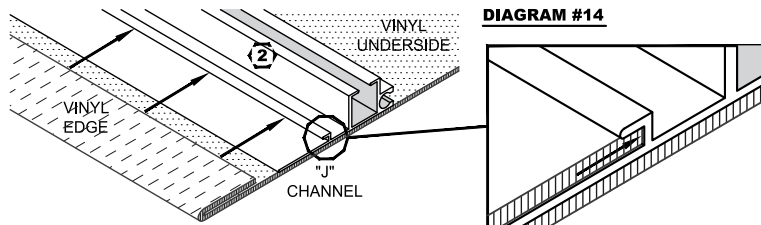
STEP 2 - ORIENTATE VINYL

Spread the vinyl cover out, evenly over the framework. Next, flip the black plastic edges of the Vinyl over the Side and Rear Frame Rails. Next, flip the entire cover assembly, back to the up-side-down orientation, taking care not to damage the finished Vinyl surface.



STEP 3 - SIDE RAIL ATTACHMENT:

Vinyl "J" channel insertion will begin with either rail ② or ③, and will be worked from the end closest to the cab (the end already attached to the frame), down to the tailgate rail and back up the opposite side rails. Choose your starting side rail by standing in front of the side rail that orientates your stronger hand (main hand) closer to the cab end of the frame. As you work your way around the frame your main hand will feed the vinyl edge into the "J" channel, while your other hand releases tension on the vinyl in the direction you are moving, down the rail. Work your way down your starting rail, towards the tailgate end. Refer to *diagram #14* and *#15*. It is not suggested to use any type of tool to force the vinyl into the channel, as it may result in damage to the edge of the vinyl. A slight snapping or popping sound might happen from the vinyl entering the channel, due to increasing tension, this is ok.



STEP 4 - ADJUST VINYL RAIL TENSION:

If needed, after the vinyl cover is installed on the frame, a flathead screwdriver or mallet can be used to adjust the tension of the cover. Very slightly loosen the bolts holding rail ⑥ in place. Place a piece of wood against the frame in this area, and tap it with the mallet, evenly on both ends. For this process to work, the bolts need to be loose enough to slide but still tight enough to maintain the tension. Re-tighten bolts when done. Repeat this same process to rail ①.

BED MOUNTING INSTRUCTIONS

STEP 1. ATTACHING HINGE RAIL #11 TO FRONT OF BED

1. Hinge rail is attached with double sided tape and (2) #10 x 2" screws. Before removing paper from tape, verify hinge rail fits. If rail is too long, trim both ends equally to keep rail centered in bed.

Keeping rail up against and under lip of front of bed (*diagram #16*), center hinge rail and mark location for installation. Apply masking tape to truck to mark on.

When you are ready to install hinge, clean surface completely with supplied alcohol wipes. Surface must be clean for tape to stick properly. Remove paper backing from tape and press firmly into position using marks on masking tape as guide. Be sure rail is in proper position, as once tape is applied it cannot be removed. After hinge rail is in place, transfer the two 9/64" holes, through hinge rail support rail, into bed lip (*diagram #17*), and secure with #10 x 2" screws provided.

DIAGRAM #16

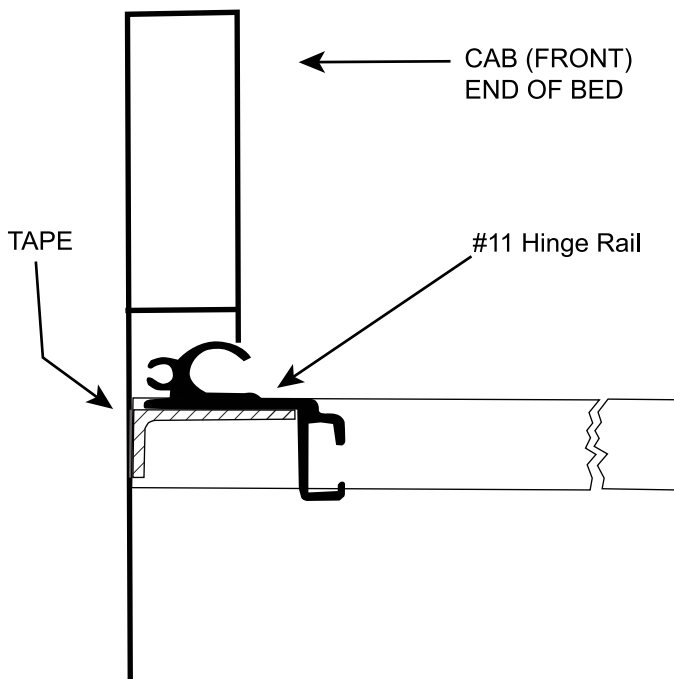
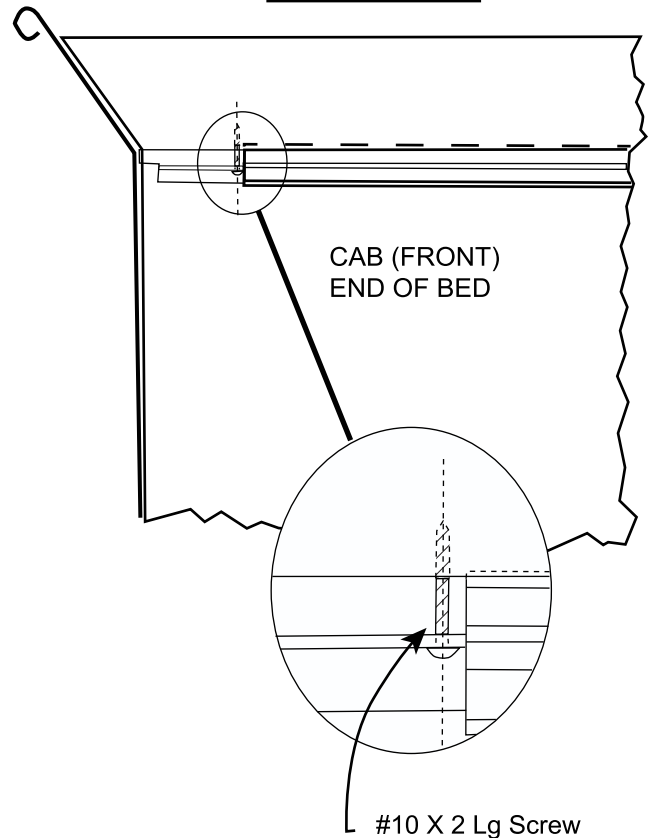


DIAGRAM #17



BED MOUNTING INSTRUCTIONS

STEP 2 - INSTALLING BED CONNECTION HARDWARE:

Locate Predrilled holes for bed shock mount **(C)** and striker pin **(D)**, and fasten into place. See *diagram #1* (on page 1).

STEP 3 - BED RAIL ASSEMBLY:

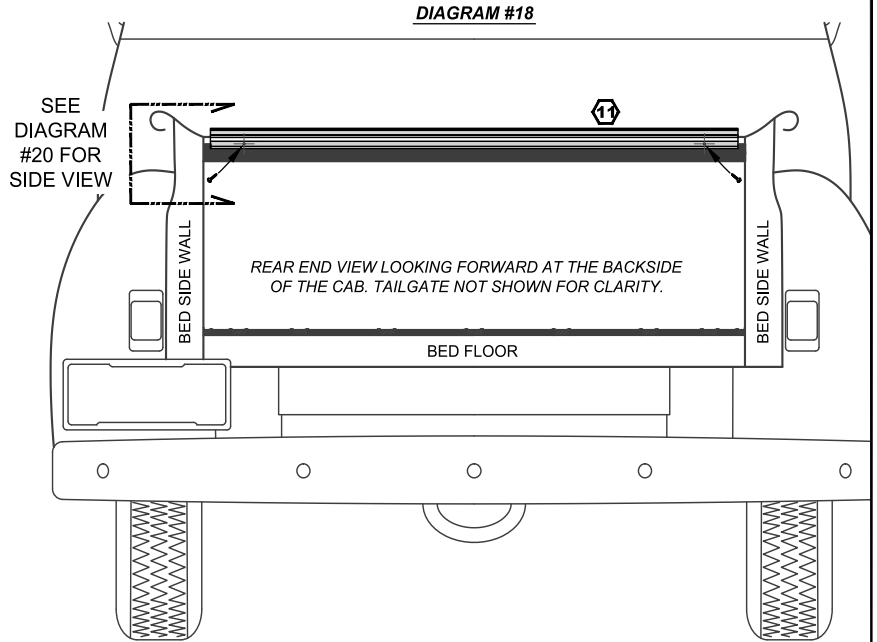
Assemble bed side rails **(13)** & **(14)** by sliding the square tube end from rail **(14)** over the round pipe splice **(13a)** protruding from rail **(13)**, matching labels 13 & 14. Secure the connection with a #8 x 1/2" screw. Refer to *diagram #1* for rail orientation. Repeat the process with bed side rails **(15)** & **(16)**.

STEP 4 - BED RAIL INSTALLATION:

Unscrew one of the fender bolts nearest to the mounted Ball Stud to install the Bed Rail Side Support **(U)**. A helpful assembly aid for proper location of side rails to tailgate is to use 1/4" aluminum gauge and a piece of wood, clamped to tailgate end of side rail assembly. (See *diagram #19*)

Picture 2, See splice & ball stud assembly in Step 2
Test fit cover before installing.

Keep cab end of rail against front of bed and the notch engaged over #11 Hinge Rail Support (See *diagram #20*). Slide rail against side, and press firmly against side of bed. At tailgate end of siderail, drill 9/64" hole at stake pocket, and secure side rail with #8 x 1/2" screw provided. Repeat steps for opposite side.



PICTURE 1

PICTURE 2

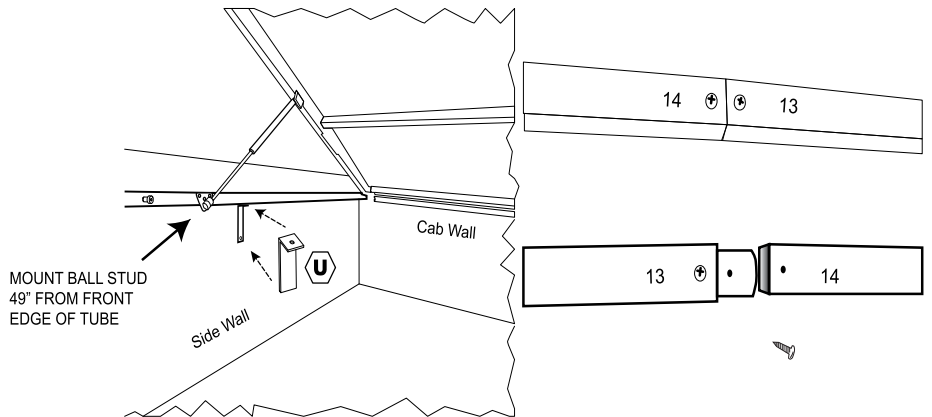
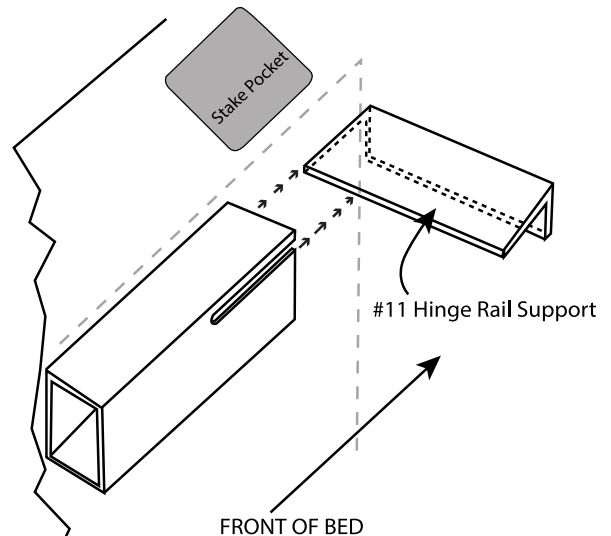
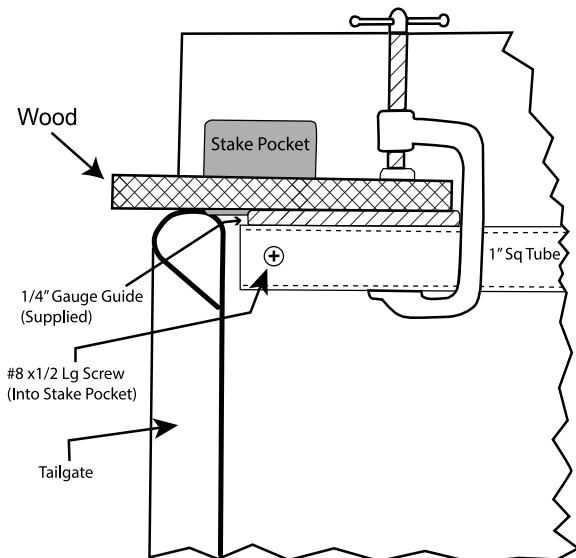


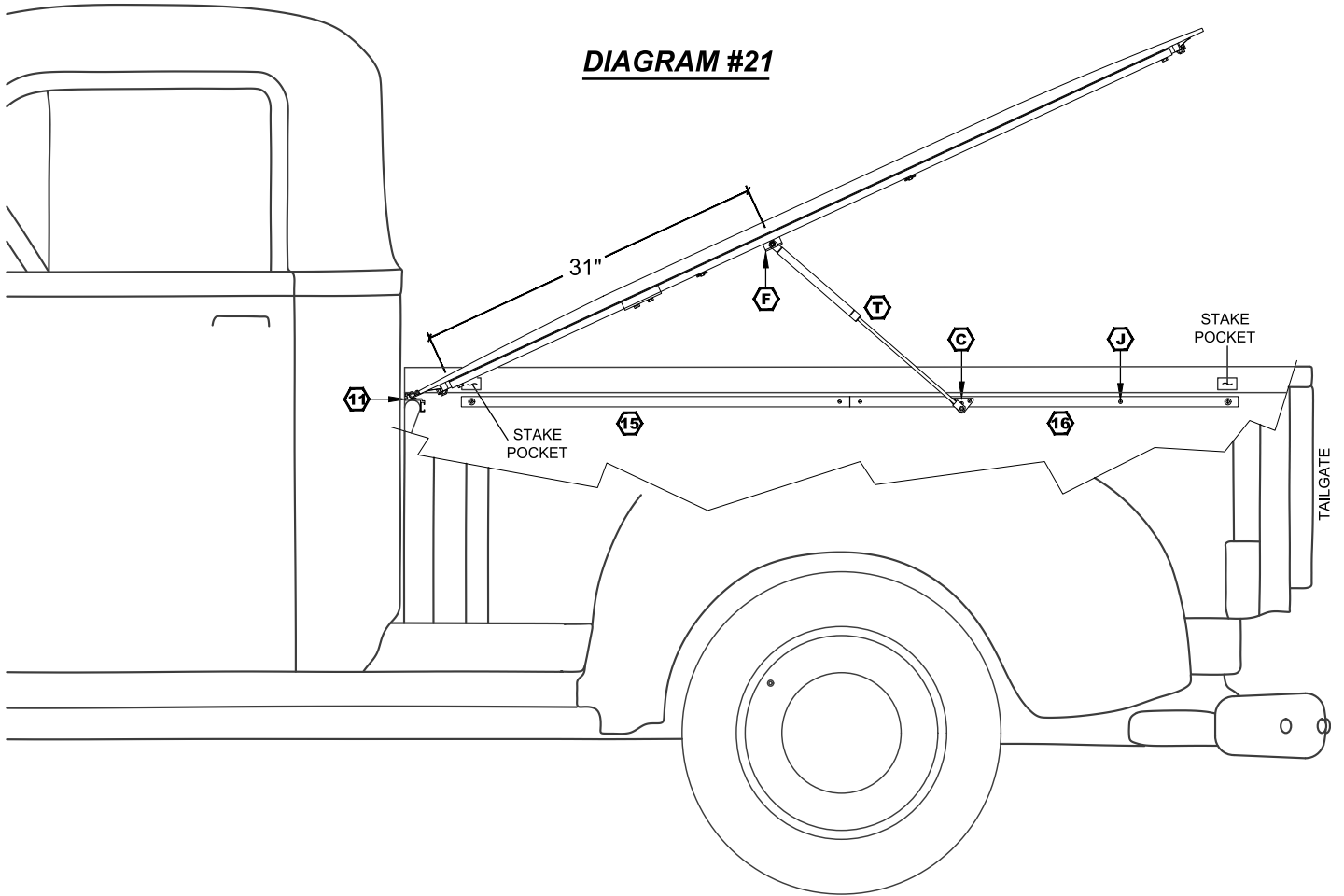
DIAGRAM #19

DIAGRAM #20



COVER INSTALLATION

DIAGRAM #21



STEP 1 - INSTALLING THE COVER:

Two people should hold the cover by the sides and walk it into position, down the length of the bed. Tilt the cover to a 90° angle (straight up and down) to engage the two hinges. Refer to *diagram #22*. Slowly lower the cover making sure the hinge stays engaged. Watch for binding of the two hinges. The bed cover should lower smoothly without any tension or flexing of cab hinge rail ①. Keeping upward pressure on the hinge point of the two rails, as the opposite end, the tailgate end, is lowered into position the first time, will help to keep binding from occurring. If binding occurs do not continue lowering the cover (damage might occur), raise the cover back up and re-engage the hinges, and try lowering again.

DIAGRAM #22

