

ASSEMBLY DIRECTIONS - 1946-'64 WILLYS PICK-UP BED

The assembly of these pick-up beds is largely self-fixturing, with a few dimensions that must be adhered to for proper fit of related features on the frame. Strict attention must be paid to the quality of your plug welding process! Please take your time to assure that everything is in its proper location and orientation before you start welding. Please don't hesitate to call us if you have a problem with any area of assembly.

The following notes are to help you in understanding the attached drawing(s).

1. 226-19 "A" crossmembers (2 req'd) have an "arch" shape to the bottom flange arrangement. The "AF" (forward) crossmember is the same as the "A" members, except it doesn't have the frame mounting slots on the bottom flanges.
2. The 226-20 "B" crossmember is a straight "Z" section across its length.
3. The rearmost "A" member's side flanges face rearward - all other members' side flanges face forward (see drawing).
4. The "A" crossmembers have slots in the side flanges, which are blocked off by the bed floor sections at assembly. We don't know why they were made like that on the originals, but they are the same on these reproduction parts as well!
5. The slot/hole arrangement at the "A" crossmember locations are mounting points to the frame. Other mounting points are the inboard holes in the forwardmost "AF" crossmember, the holes in the rear crossmember, one other set of holes in the bed floor section, and of course, the front mounting legs. New rubber mounting pads are provided in this kit.
6. The plug-welding flange of 226-21 longitudinal crossmember faces to the right-hand, inboard portion of the bed, and is accurately positioned by pinning the two 1/8" diameter alignment holes to the mating holes found in the 226-20 "B" crossmember.

7. The Left-hand floor section overlaps the Right-hand floor section, so that the plug-welding holes found on the Right-hand section are on the underside of the bed.

8. The bottom flange of the Header Panel slips underneath the floor panel assembly.

9. The mounting legs are to be welded in place, despite the fact that there are a complete set of holes to bolt them in place. This is the way it is on our reference vehicle!

10. One of your first steps should be to weld and grind the few seams found in the "A" crossmembers, as well as those seams at the filler pieces found on the floor sections.

11. The front and rear crossmembers are obviously centered from side to side, and spaced according to the dimensions shown on the drawing.

12. IMPORTANT! PLEASE NOTE! On our sample vehicle (a 1963 model), the 226-19/-20/-21 stackup of crossmembers in the fuel tank area was apparently too far rearward, and caused interference and chafing to the fuel tank itself! The positioning of these members also rendered the frame attachment points in that area unusable on our vehicle! That's why we have provided an extra set of mounting holes in the bottom flanges of the bed floor sections. "CHECK IT OUT" on your vehicle! This situation on our vehicle was an apparent factory "error", and I urge you to make sure that there are no problems with interference between the bed and fuel tank on your truck!

13. Other areas of assembly on this bed are relatively self-fixturing (bed sides, tailgate/hinges, spare tire mounting stiffeners, etc.), and drawings are forthcoming showing those details.

14. The assembled width of the floor pans is regulated by the crossmembers, of course, and should pose no dimensional concerns!

15. The final quality of this assembly depends on your attention to squareness, tight fits before welding, your insistence on good plug welding techniques, and a genuine effort to put together a product that you can be very proud of showing!