



Pick-Up Bed Assembly Instructions

'32-'41 Ford, Chevy and Pro Design

Important! Please read through instructions
before you begin.

You must do all the steps in order

Note: Tools and Equipment needed
(an extra person can be helpful)

Feel free to call with any questions

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Step 1.

Begin assembly by marking 1/4" holes.

Start 1 inch from corner and mark every 4"



Step 2.

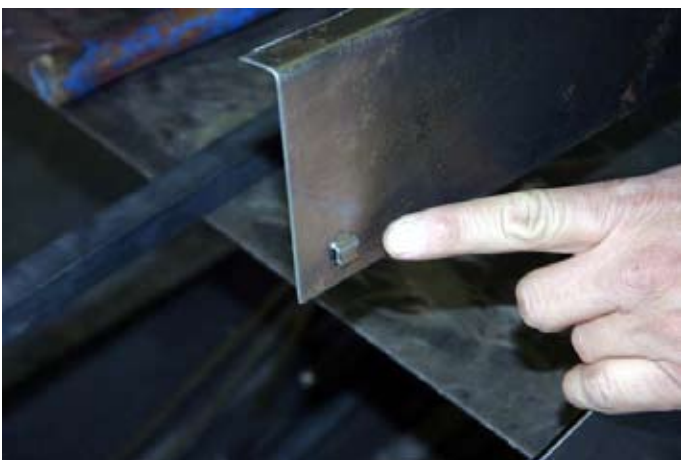
Drill pockets on both sides.



Step 3.

Don't forget the corner ears.

(Note: For '32-'36 Ford Beds, front stake pockets are larger than the rear pockets).



Step 4.

Rear channel is a two-piece assembly.

These tabs on rear channel will interlock with J pieces.
(Disregard for '38-'41 Ford)



Step 5.

These pieces form rear channel and the top flange supports wood.



Step 6.

Weld on each tab to hold securely. Assembled part is 50-3/4" long and will need to be cut down for some beds.



Step 7.

Rear channel is made for many bed sizes so trim flange back on each end and cut to length (see step 8)
Amount to cut varies: '32-'41 Ford, Pro Design, '30-'39 Chevy are the same. *'40-'46 Chevy differs!



Step 8.

All beds (EXCEPT '40 -'46 Chevy) are 46" wide on inside of bed sides. So cut to 2-3/8" on each end leaving a 46" flange in center

*('40-'46 Chevys are 48" wide, so cut to 1-3/8" on each end).



Step 9.

Double check length before cutting.

Measure twice cut once!



Step 10.

Rear channel then slips into rear stake pocket.

Square it up with a carpenter's square.



Step 11.

Drill 3 holes on each side of pocket and plug weld to channel.

Do not weld pocket to bedside before this stage!



Step 12.

Measure to other side. Gap should be width plus 1/8" for clearance, so on 46" wide beds: 46-1/8". On 48" wide beds: 48-1/8". Square it up as before.



Step 13.

Clamp front pocket to front of each bed side. Note: For '32-'36 Ford beds you have distinct right and left bedsides! (see wheel arch)



Step 14.

Weld now only the inside row of holes.



Step 15.

Drill remaining row of holes through the side panel for final plug weld to front panel.



Step 16.

For all beds, notch rear of bedside 3" by 4" to slip into rear channel.



Step 17.

Make edge flush with pocket.

Note: Flange on rear channel points in.



Step 18.

Use clamps to hold stake pockets snug.



Step 19.

Plug weld together. This is how it will look from inside.



Step 20.

Front panel goes on last. Flanges point inward.



Step 21.

Clamp with a 4 ft. pipe clamp.
Welt thru pocket and side panel to
front panel.



Step 22.

Make sure ears are snug.



Step 23.

Welds should look like this when
you are done

Congratulations!

You're finished with your bed assembly.

Last Refuge Hot Rods
thanks you for your business!