

PREPARATION:-

Dropside plank(s) should be hinged to the coaming as usual before cutting into 3 pieces as follows, A -- 197mm, B -- door opening less 5mm, C -- remainder. The top inner lip of A & C require mitring at 45° on the end which attaches to REV. A the CAP200LC & 201RC to clear the handle pivot end.
BEAR100 bush bearing plates should be cut down to 43mm long from one end and the remaining hole opened out to 6mm dia.
NOTE: If the tray has already been made, remove the BEAR100 from the relevant headboard post for re-use.

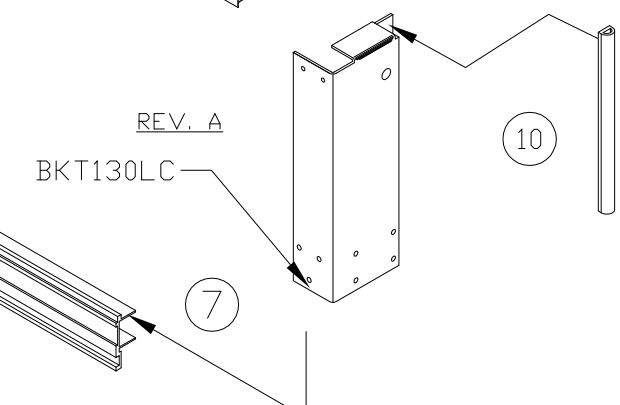
Now proceed, following the circled number sequence.
References to right & left hand apply to the illustration. Reverse them if fitting to the right hand side of the deck,
① Take PLT370C, place it with the wide (25mm) face over the outside of ANG130L. Align the top hole of the handle bush position with the top hole in the plate and secure with a RIVET200, ensure the plate is parallel with the edge of ANG130L, clamp, drill through the bottom hole and secure with a RIVET200.
② Locate part A of the side plank between the coaming top and PLT370C and against the edge of ANG130L. Mark & cut a 3mm notch, as shown in the enlargement, at the rear end of the plank piece. Drill and secure with 2 of RIVET200.
③ Locate a CAP200LC against A and in the previously cut notch. Check for square in both directions, clamp and secure using 3 of SCRHHSS620 bolts & nuts to the deck and coaming.

④ With the clamp still in place from step 3, open out the top handle bush fixing hole with a 6mm dia. drill.
Secure the shortened BEAR100 bush plate to the plank & CAP201C using 1 of SCRHHZP616 bolt & nut. Use a 4.9mm dia. drill & RIVET200 rivet to fix the bottom of the plank to CAP201C.
REV. A ⑤ Run a bead of silicone sealant along the top of the front panel and drop sides where FLASH100 will rest. Place FLASH100 into position and fix down using 5 of RIVET200 rivets along the front and one each side. Seal remaining gaps with sealant, including rivet heads.
⑥ Place part C of the side plank onto it's hinge and mark the position of the coaming lip notch at the front of the plank. Remove and cut notch.
REV. A ⑦ Replace part C and fit the BKT130LC end cap to the rear of the coaming, ensure cap is square in both directions before tightening.
⑧ & ⑨ Fit a CAP201RC and cut down BEAR100 as in steps 3 & 4.
REV. A ⑩ Stick 4 pieces of SEAL325 "D" rubber to the inboard flanges of the CAP200LC & BKT130LC brackets, so as to form a seal for the drop panel and tailgate.
Fitment of dropside end caps, handles, catches etc. are as usual.

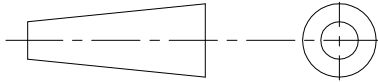
DEFINITIONS:

- RIVET200---- 73 SS 6-6 RIVET 4.8X14
- SCRHHZP616----- M6 X 16 SET SCREW
- SCRHHSS620----- M6 X 20 SET SCREW

NOTE: SELECT KITS FOR 2390 FITTING AS FOLLOWS.
SINGLE SIDE --- COMBOS07
DOUBLE SIDE --- COMBOD07



REV.	AMENDMENT	DATE	INIT
A	Insert lower front plank,		
A	revised NT072 and change		
A	NT069 to NT73. Revise text		
A	items	10/05/02	B.C.
B	UPDATE WITH NAVISION CODES	07/05/09	B.C.
B3	Change file name.	16/10/12	B.C.

PATH AND FILE			
R&D main menu\Instructions\Build Manuals\Section3-Tray Build\ Master Files\3-1F Combo tray top conversion diagram ISSB3			
FLEXIGLASS CHALLENGE INDUSTRIES Dwn.23/06/99 BY B.CONSTABLE QUALITY SYSTEM DRAWING		Title COMBO, TRAY TOP, CONVERSION WORK INSTRUCTIONS.	
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