

NORTHERN CLASSIC TRUCKS, INC

42786 MOUND RD

STERLING HEIGHTS, MI 48314

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1942-1950 INSTRUCTION BOOKLET

## **1942-50 TRUCK BOX COMPONENTS**

First we, at Northern Classic Trucks would like to thank you for your purchase of our truck boxes and or body panels.

Below you will find a check list of the components you should have when you open the crate:

**Bed Front**

**2 Bedside Panels**

**1 Tailgate**

**1 Pair Tailgate Hinges**

**1 Wood Adaptor Kit**

**1 Set Oak Bed Wood**

**1 Pair Tailgate Chains**

**1 Set Steel Bed Strips**

**1 Pair Bed Extension Panels (1942-47 Only)**

**1 Pair Stake Pocket Braces**

**1 Box of Hardware and Instructions**

**1 Sub Frame Assembly**

**1 Cap Strip for Wood at Back of Bed**

**If anything in the crate is missing or damaged please notify us right away**

**HARDWARE KIT INCLUDES:**

- 10 3/16 X 3/8 ROUND HEAD RIVETS
- 28 3/16 X 3/8 TRUSS HEAD RIVETS
- 2 TAILGATE HINGES
- 4 1/4 INCH BOLTS
- 4 1/4 LOC WASHERS
- 10 10-24 NUTS
- 10 10-24 MACHINE SCREWS
- 22 5/16 FENDER BOLTS
- 2 7/16 BOLTS, NUTS, LOCK WASHERS
- 8 5/16 LOCK WASHERS, NUTS,
- 8 5/16 X 3/4 HEX BOLTS

**SKID STRIP HARDWARE**

- 14 5/16 X 3/12 CARRIAGE BOLTS
- 15 5/16 X 2 1/2 CARRIAGE BOLTS
- 21 5/16 X 1 1/2 CARRIAGE BOLTS
- 50 5/16 LOC WASHERS
- 50 5/16 NUTS
- 21 FENDER WASHERS
- 8 #6 X 1/2 CAP STRIP SCREWS

**HOLD DOWN BOLT KIT**

- 6 4 1/2 X 3/8 FLAT HEAD BOLTS
- 6 RECESSED WASHERS
- 6 LOCK WASHERS AND NUTS

## WOOD ADAPTOR KIT INSTRUCTIONS

After all the metal working is done, it is time to fit the wood. This is the basic adaptor kit that was designed to convert the original sheet metal floor to the newer board and strip concept used later by Ford.

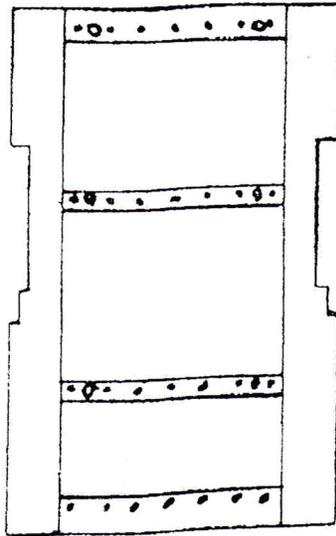
The first thing that needs to be done is layout all six pieces on the steel sub frame starting with the long runners with the notches cut out as shown on the next page. Make sure you have them against the front panel and that they are sitting flat on the structure. You will have a gap at the back so don't get nervous yet. The gap gets covered up at the end of the whole floor installation procedure.

Next, you must install the cross slats that run horizontally to the length of the box. Work from front to back. The wide boards are for the front and the back. The narrow ones in between. The holes should be about 2 ½ inches from the front.

As for the back, line up the holes with the ones drilled in the rear sill. The edge should line up with the end of the long runners at the back. Once those two are in place, the middle slats should rest nicely on the middle cross sills.

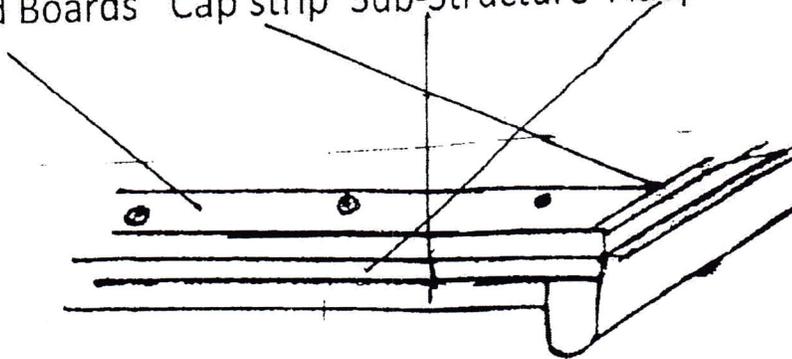
THIS IS THE TOP VIEW

FRONT



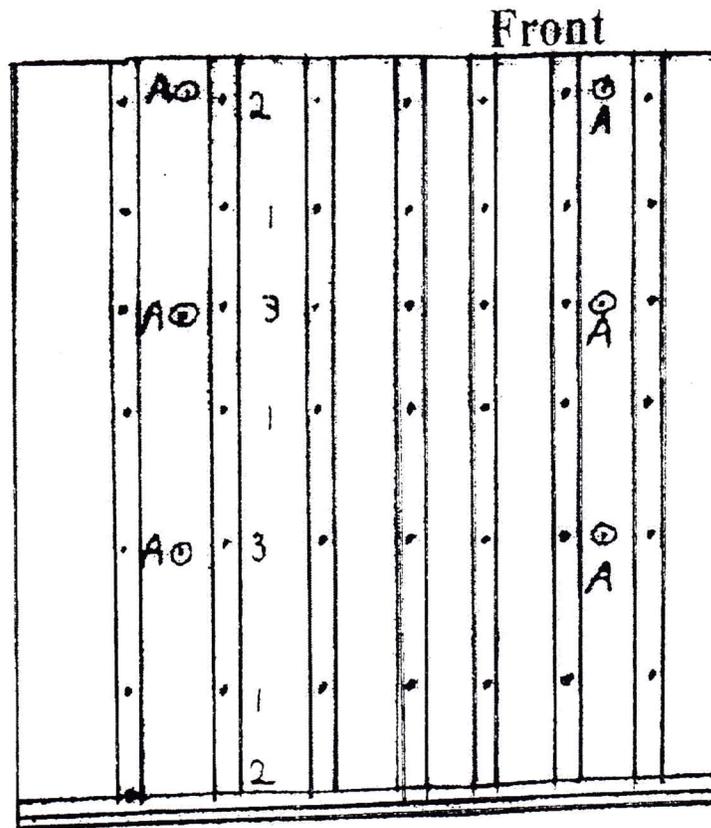
This kit sets down on the Sub-Structure and then the deck boards rest on top. Next the steel strips are installed and everything is bolted down to the bed.

Wood Boards   Cap strip   Sub-Structure   Adaptor kit



# 1942-50 DECK BOARDS AND STRIP LAYOUT

THIS IS THE TOP VIEW



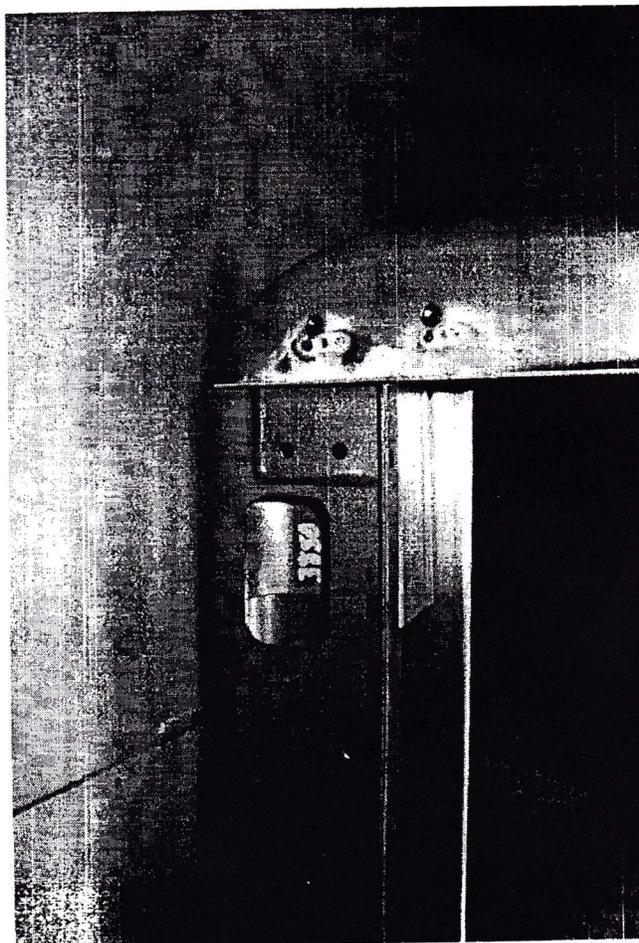
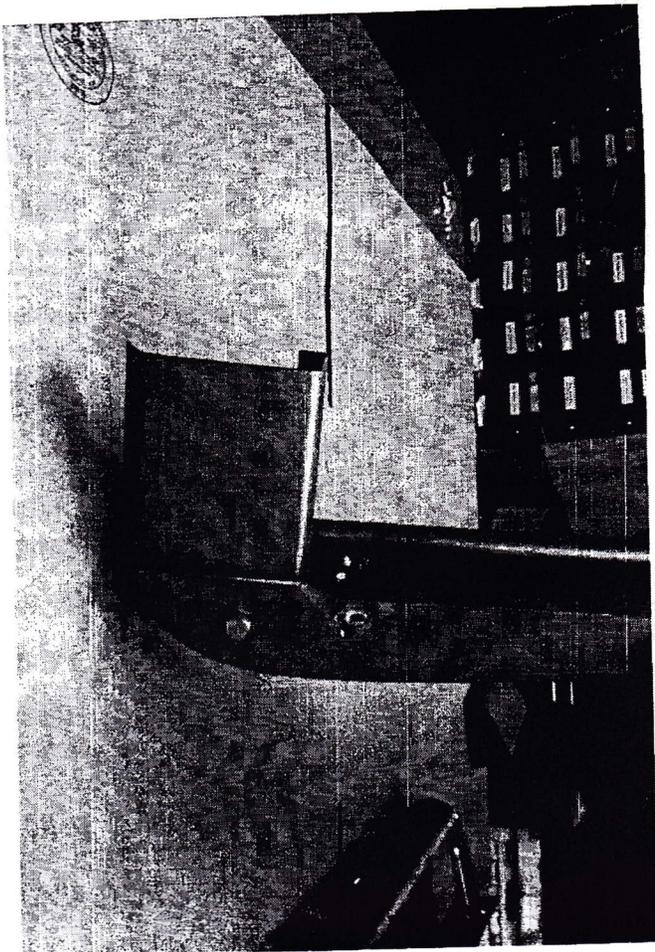
A = 4 ½ FLAT HEAD BOLTS, WASHERS AND NUTS

1 = 1 ½ CARRIAGE BOLTS, WASHERS AND NUTS

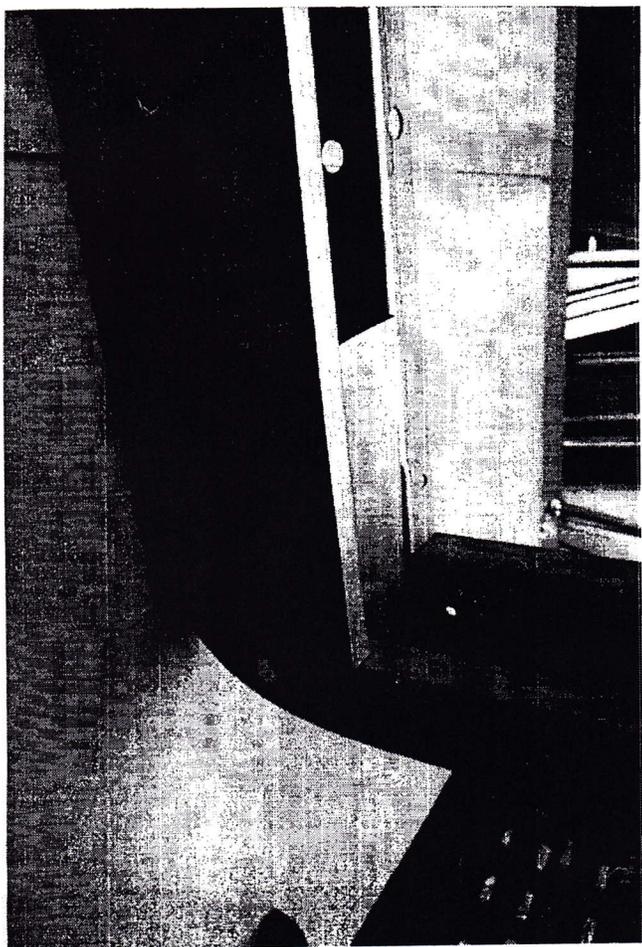
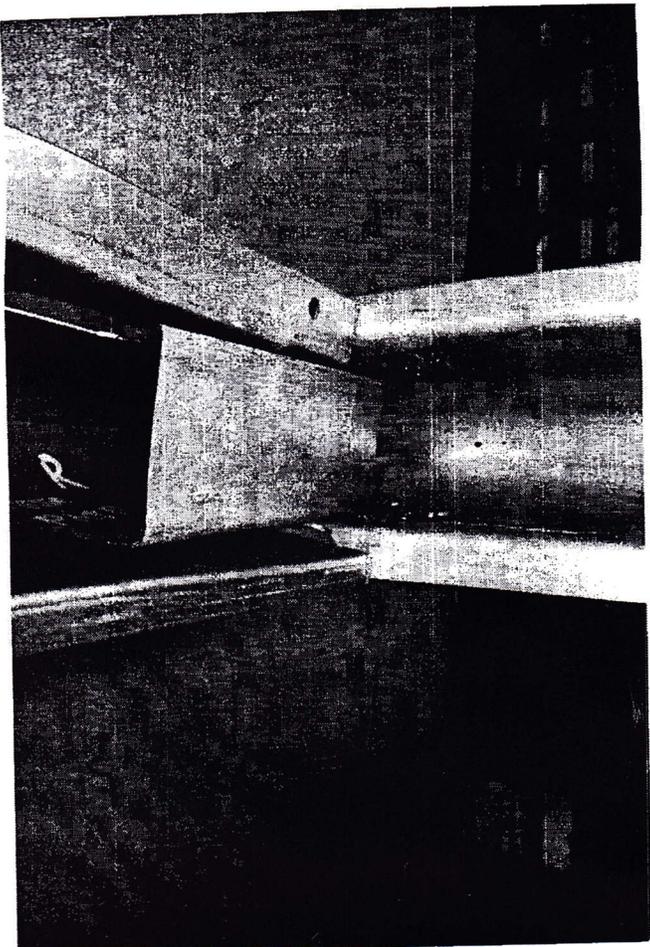
2 = 2 ½ CARRIAGE BOLTS, WASHERS AND NUTS

3 = 3 ½ CARRIAGE BOLTS, WASHERS AND NUTS

PLACEMENT OF STAKE POCKET BRACES



2



Before any of the following procedures are attempted, make sure all surfaces after assembly will be prepped and primed to eliminate the bare steel from rusting.

You may want to use a table to start the assembly as it can be quite helpful. Place the large sub-structure upside down. The round part of the rear cross member should be facing up. put the rear stake pocket braces on with the 1/4 inch bolts in to the bedside first.

Place one bedside at a time up against the side of the sub-structure aligning the pre-drilled holes on the bedside up with the holes on the structure. You will need to use the 10-24 alignment screws and nuts to attach the bedside to the structure. These alignment screws will later be replaced by the truss head rivets. The rear stake pocket should line up with the rear cross member. There are pre-drilled holes on eah side panel. Repeat on opposite side.

Once the bed sides are held by the starter screws and tightened, use a 3/16 drill bit and chase all the other holes that are in the structure. Make sure you de-bur the holes before setting the rivets. The rivets for the bed sides are 3/16 and have a low profile head on them. When you are ready to rivet, the head belongs on the outside panel. To eliminate any gaps or warping, you will need a steel backup block and a hammer. No need to heat the rivets because they are a soft mild steel.

After all the rivets are installed you may want to place the assembly on the floor still upside down. This makes it easier to install the front panel. Make sure the flange on the bottom of the bed front faces on the inside of the bed. the bedwood sits on that flange. Use the 10-24 starter screws to set the front panel in place before riveting the panel in.

It is also helpful to use a wood block under the roll of the front panel to ensure a flush fit in the angle of the bedside and front panel. Once you

have a tight seam you can use the screws to hold the panel. Next, place and set one rivet at a time working from the bottom up to keep the front panel flush to the front bedside edge.

Now that the rivets are in place, the front panel should be straight and lined up with the front bedside edges. Next thing to do is flip the bed right side up so you can continue working on the bed. You will need to do two things: 1. Weld the rolled part of the front panel to the bedside where the roll meets the side panel. This gives extra support to the joining and helps keep the bedside angle from getting bent. 2. Make sure the seam is tight before welding. Repeat on the other side. Where the angle is at the top of the bedfront on each side you will see a tab that sticks up a little. You need to tap that down flush against the bedside and tack weld it.

It is time to work on the backside of the bed. You will need a large carpenter's square and a couple of welding clamps. Next you need to tap the outer lip of the rear cross member so that it is flush with the back edge of the bedside and then clamp it there so you can tack weld it. Same on the other side. Now that it is held square, you can weld in the gap between the bedside and rear cross member leaving a little gap at the bottom for water drainage. Make sure inside width of bed is 49 inches. Clean up any extra weld with a grinder and you can smooth up the area with a good sander.

The bed should now be squared up and coming along nicely. The next big thing to do is start fitting the wood adaptor kit and deck boards. ( Do this before any varnishing to make sure the fit is correct.) Use the diagrams that are included in the instructions. This will help you make sure you won't need to trim something or refinish in case of any digging or scratching caused by fitting everything. Once you have fitted the wood you can finish sanding and staining or painting. Now you can install the tailgate using the hinges provided and the necessary 1/4 inch hardware.

Do not paint the bed yet until everything is fitted correctly.

Installing the tailgate chains can be a bit difficult but not impossible. You want to start with the large oval link on the end of the chain. A bench vice is great for this job. Hold the link in the vice with the notch facing up. You can use either a pair of ice grips or a crescent wrench to twist the leg of the link open enough so that it will slip onto the triangle bracket that is riveted to the rear stake pocket. Next comes the hard part. You will need two pair of vice grips or channel locks and something to heat up the link to help bend it back easier. Hold each end of the link with a pair of channel locks and start heating it up without getting it too hot and warping the bed. When it is bent back to its original position, you can weld the gap shut on the link and do the other side. That takes care of the chains.

Now you can take the tailgate off. remove the wood and steel strips. It is now time to prep, prime and paint the bed. Also, you can now sand and varnish or paint the wood. Ford originally painted everything body color along with the wood. Once you painting is done, re-install the wood and lay your bedstrips in.

You can now bolt the strips down using the indicated bolt dimensions from the diagram. When you install the strips, only use a bolt, nut and lock washer where the cross members are located. Where there isn't a cross member present, use a bolt, nut , lock washer and a flat washer supplied in the kit. The flat washer helps to keep the bottom of the two boards flat by overlapping the edge on each side. Don't over tighten the bolts or else the strip will warp where the bolts are positioned.

Now lay your cap strip down so that it covers the end grain of the wood at the back of the bed. It should line up with the end of the skid strips. Once you have that alignment you can use the small wood screws to hold it in place. The back of the cap strip should overlap the back edge of the rear cross member. Now you can put your tailgate back on and slide the

fabric sleeves back over the chains. Lift up the tailgate and latch it closed.

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