

These instructions will aid you in replacing the latch roller bracket assembly on a Tommy Gate Rail BF series liftgate.

## Preparing for the Replacement

1. Verify repair kit (Figure 1 and Table 1).

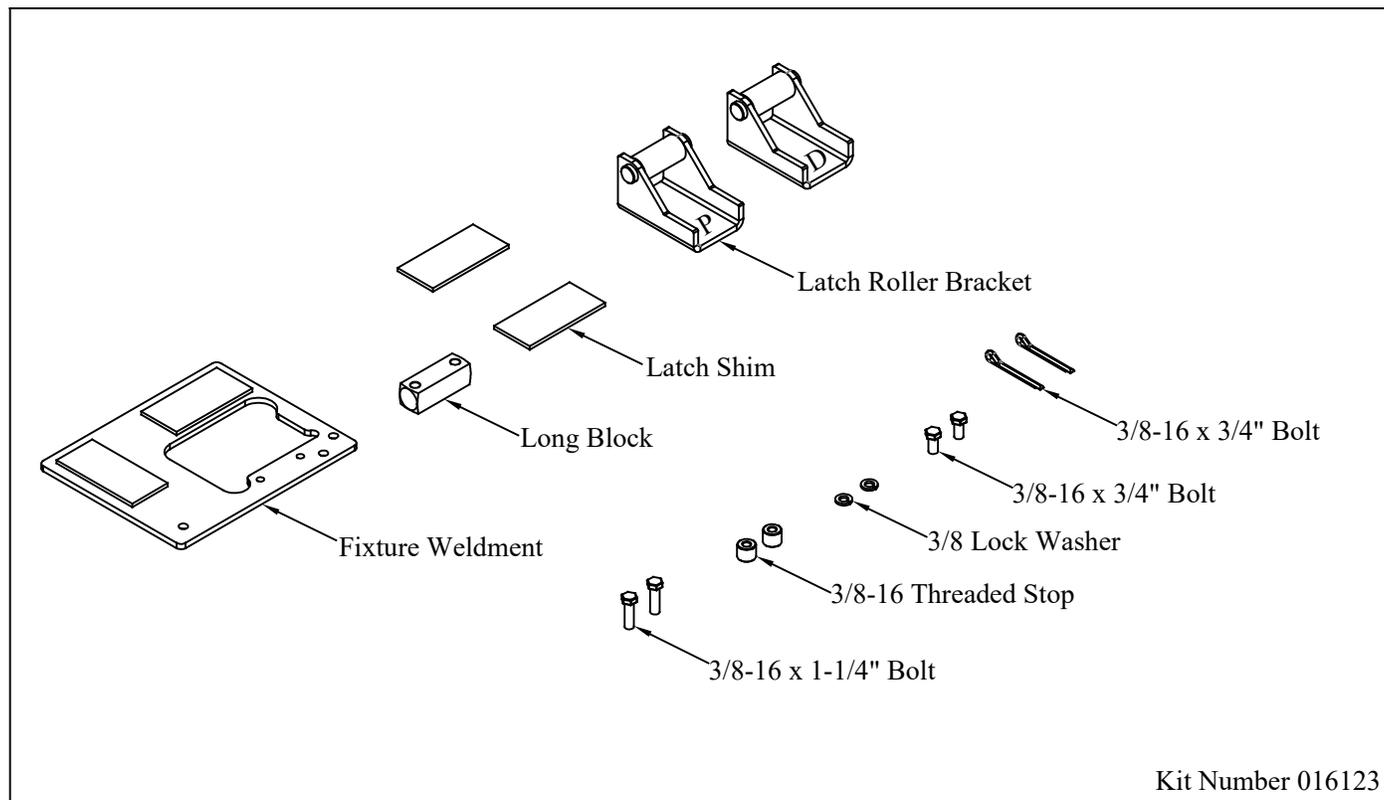


Figure 1: Replacement Parts and Weld Fixture Identification

Table 1: Part List

QTY.	PART NO.	DESCRIPTION
2	016200	PLATFORM LATCH ROLLER BRACKET
2	015199	BF LATCH SHIM
1	007263	STEEL LONG BLOCK
2	000510	3/8-16x1-1/4" HHCS GR5
2	000508	3/8-16X3/4" HHCS GR5
2	004750	1/4" x 2" COTTER PIN
2	000572	3/8" SPRING LOCK WASHER
2	007493	0.750 DIA X 0.625 THREADED STOP
1	016125	BF/GBR LATCH FIXTURE WELDMENT

# Rail Bifold Latch Roller Bracket Replacement Instructions

## Preparing Platform for Repair

1. Remove the latch padlock and **Unhook** the safety chain (Figure 2).
2. **Unlatch** the latch lever from the latch peg (Figure 2).

**CAUTION: Stand off to the side clear of the platform while operating the liftgate.**

3. Lower the liftgate until the platform is fully opened and the self close arm is disengaged (Figure 3).

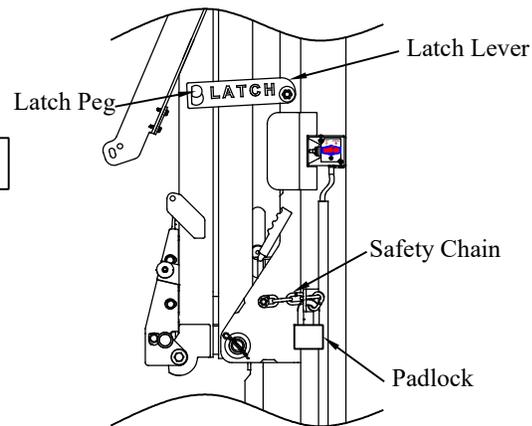


Figure 2: Platform chains removed for clarity.

4. Lower the liftgate until the platform is resting on the ground with the retention ramp/taper end slightly higher than the hinge end to allow the platform chains to hang loose (Figure 3).
5. **Disconnect** the power cable from the positive side of the battery or manually **Trip** the circuit breaker.
6. **Remove** the cotter pin from the pivot pin (Figure 3).
7. **Remove** the folding arm from the pivot pin (Figure 3).
8. **Repeat** steps 6-7 on the opposite side.

Note: Leave platform chains attached.

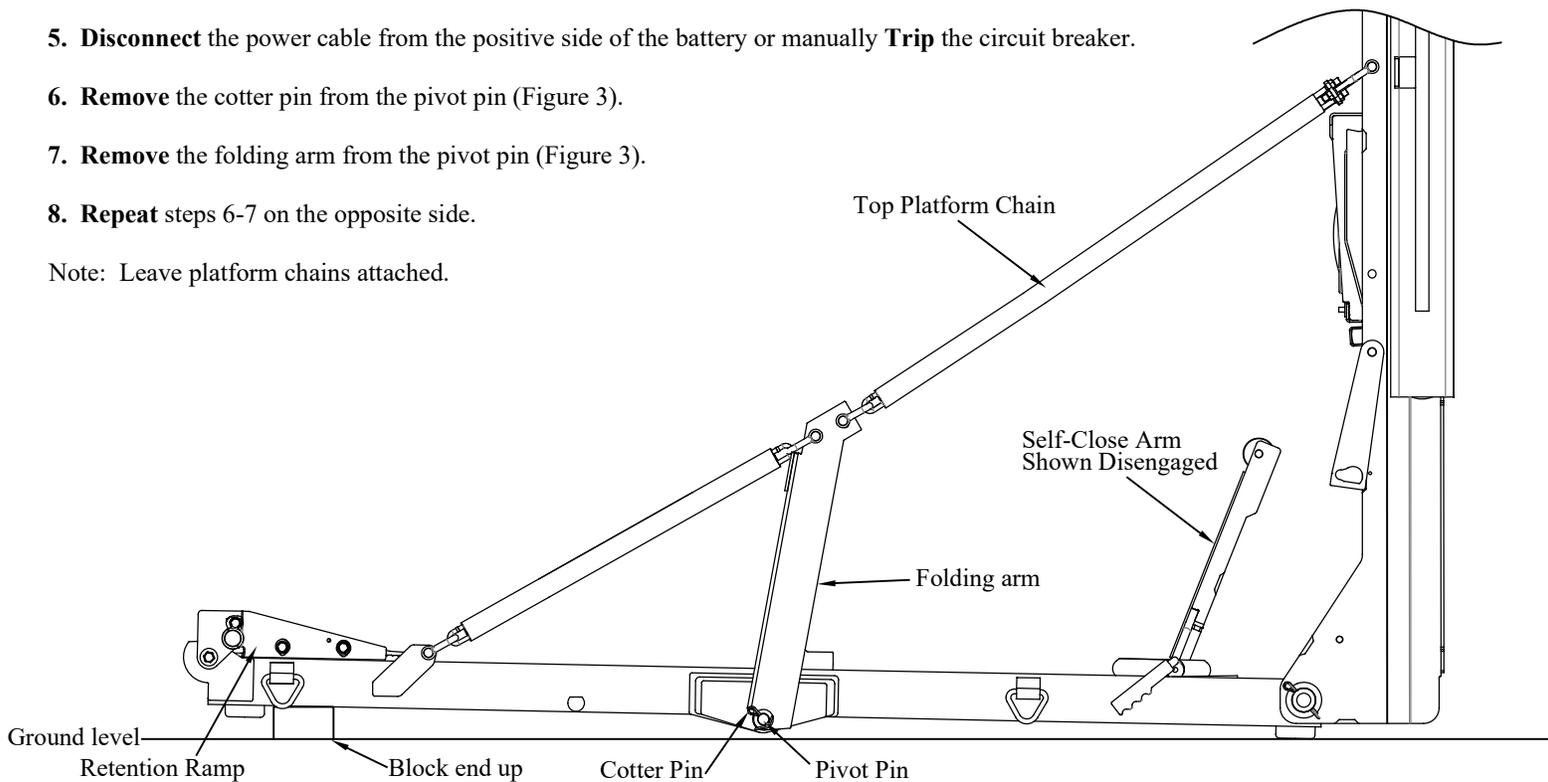


Figure 3: Bifold Platform lowered with slack in chains.

# Rail Bifold Latch Roller Bracket Replacement Instructions

## Remove the Old Latch

9. Being careful not to cut into the platform, **Cut** the welds attaching the latch roller bracket to the platform (Figures 4-6).

Note: Leave the welded latch shim if already equipped (Figure 5).

10. Repeat step 9 on the opposite side.

11. Prepare the platform surface to weld the new latch roller brackets to the platform.

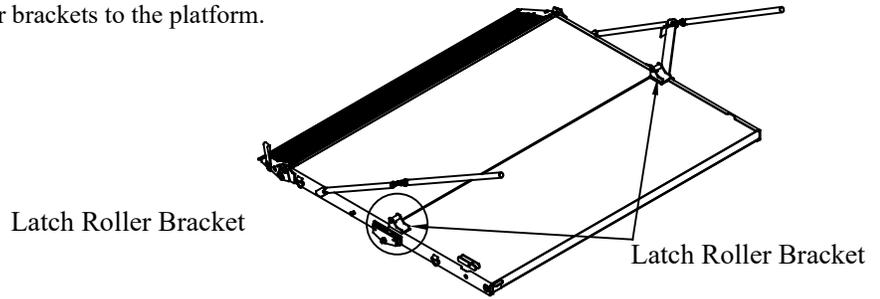


Figure 4: Platform (top, iso view)  
Folding arm removed for clarity

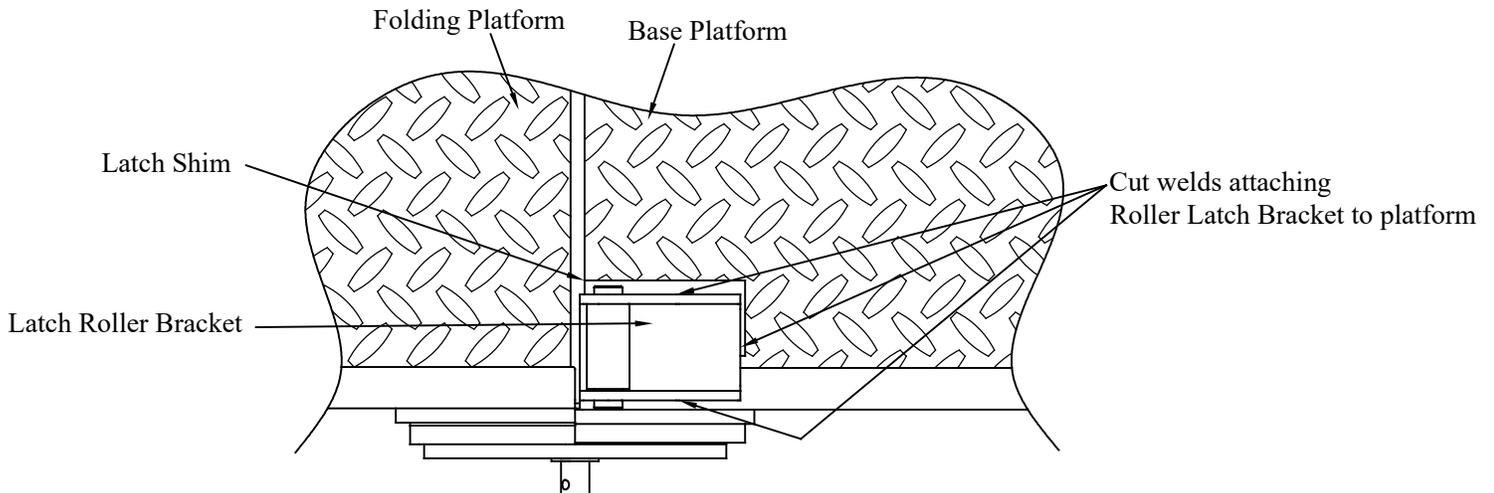


Figure 5: Latch roller on platform (top view, passenger side).

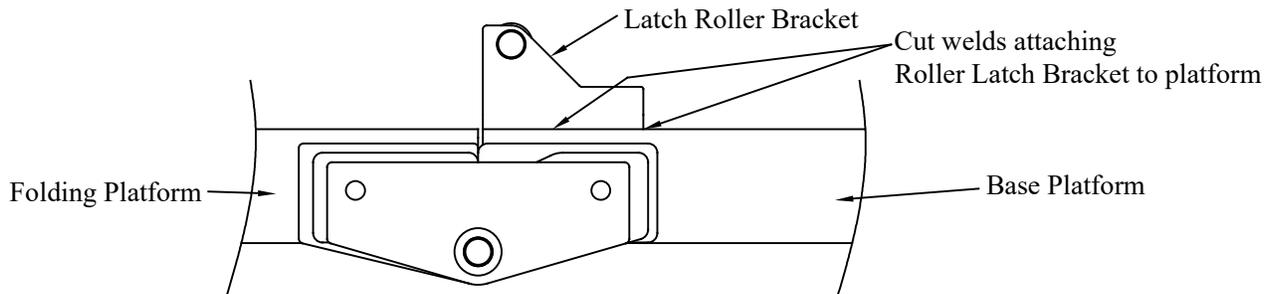


Figure 6: Latch roller on platform (side view, passenger side).

# Rail Bifold Latch Roller Bracket Replacement Instructions

## Assembling the Weld Fixture

Note: The fixture will be assembled differently for use on driver side vs passenger side.

12. **Attach** the long block to the fixture weldment using the two (2) provided 3/8-16 x 1-1/4" bolts (Figures 7-8).
13. **Insert** the 3/8-16 x 3/4" bolts through the fixture weldment (Figures 7-8).
14. **Place** the lock washers on the bolts (Figures 7-8).  
The lock washers are used as spacers in this application.
15. **Thread** the stops onto the bolts and **tighten** (Figures 7-8).

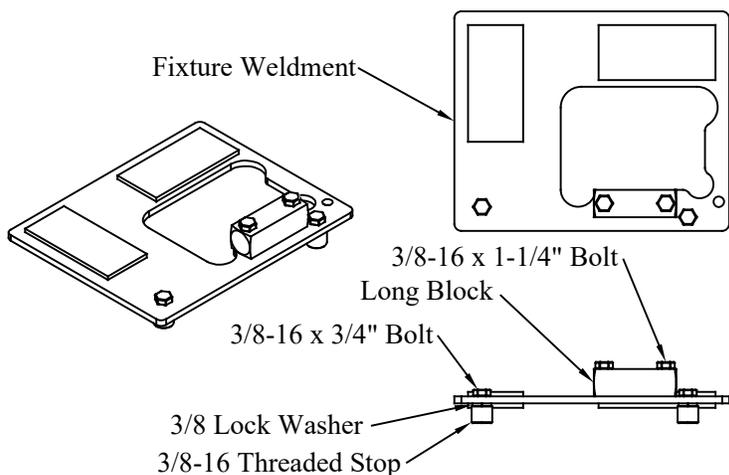


Figure 7: Weld Fixture-Driver Side

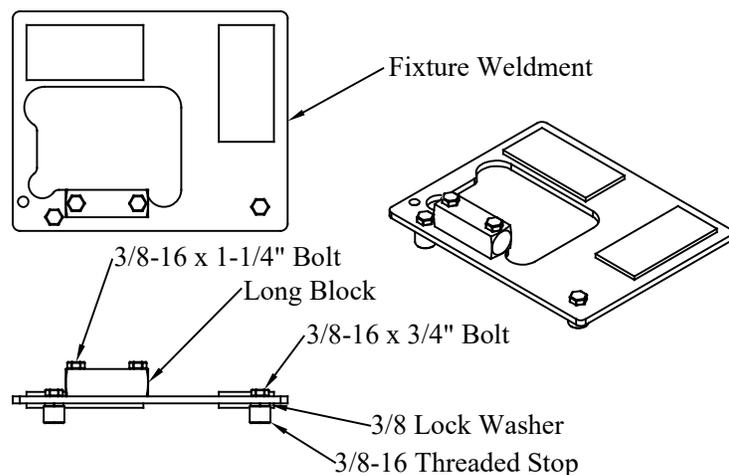


Figure 8: Weld Fixture-Passenger Side

## Position and Weld the Latch Shim to the Platform

Note: If the platform already has shims skip to step 20

16. **Position** the latch shim on the platform as shown (Figure 9).
17. **Clamp** shim in place.
18. **Tack weld** the shim to the treadplate near all four corners (Figure 9).
19. **Weld** a 3/16" weld the full length on the 3 sides shown attaching the latch shim to the platform (Figure 9).

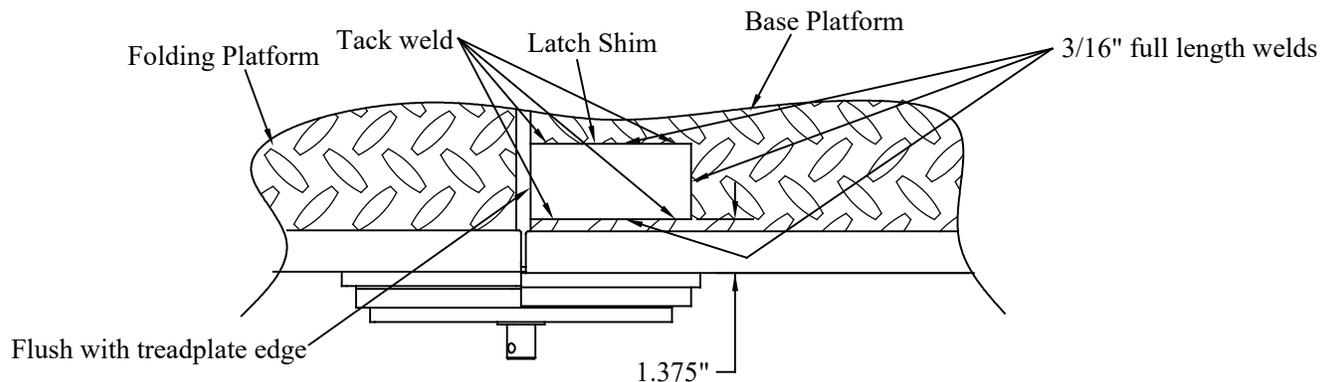


Figure 9: Latch roller shim (top view, passenger side).

# Rail Bifold Latch Roller Bracket Replacement Instructions

## Position and Weld Latch using Fixture

20. **Place** the fixture on the platform (Figure 10-12).
21. **Align** the end of the latch roller bracket flush with the lid end.
22. **Position** the fixture so that the threaded stops are contacting the lid end and plate as shown.
23. **Clamp** fixture in position.
24. **Hold** the latch roller bracket in the fixture as shown (Figures 11-12).
25. **Tack Weld** the latch roller bracket to the platform (Figures 11-12).

Note: Passenger side bracket is marked "P". Driver side bracket is marked "D".

26. **Remove** the fixture.
27. **Weld** a 1/4" weld the full length on the 3 sides shown attaching the latch roller bracket to the platform (Figure 13).
28. **Repeat** steps 12-27 on the opposite side.

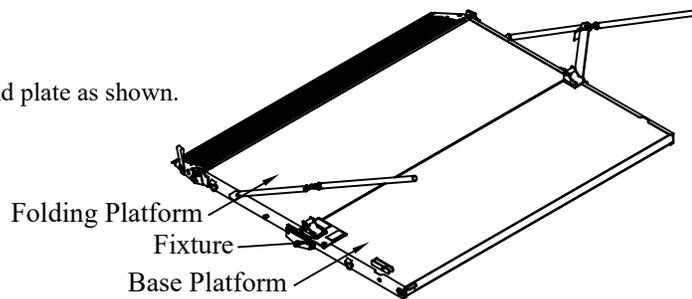


Figure 10: Platform (top, iso view)  
Folding arm removed for clarity

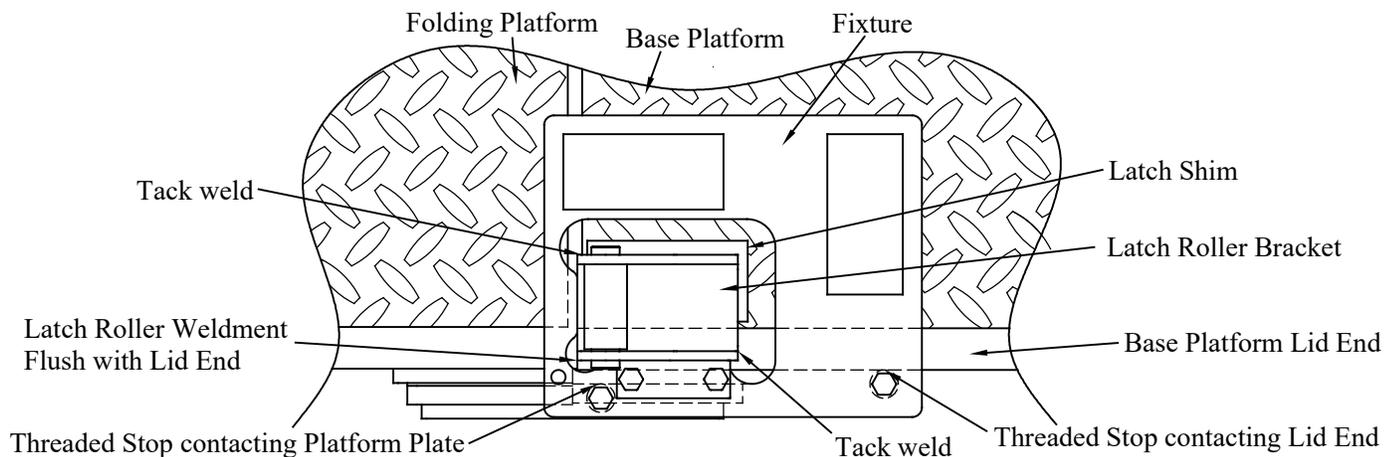


Figure 11: Latch roller on platform (top view, passenger side).

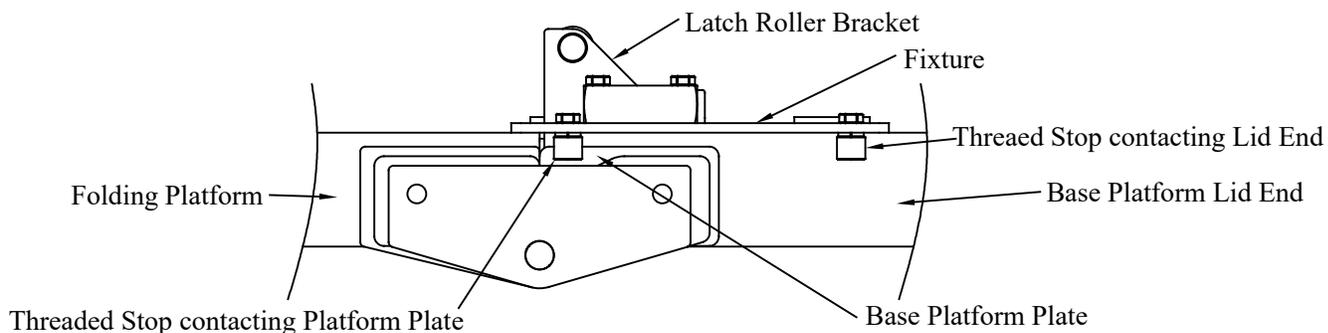


Figure 12: Latch roller on platform (side view, passenger side).

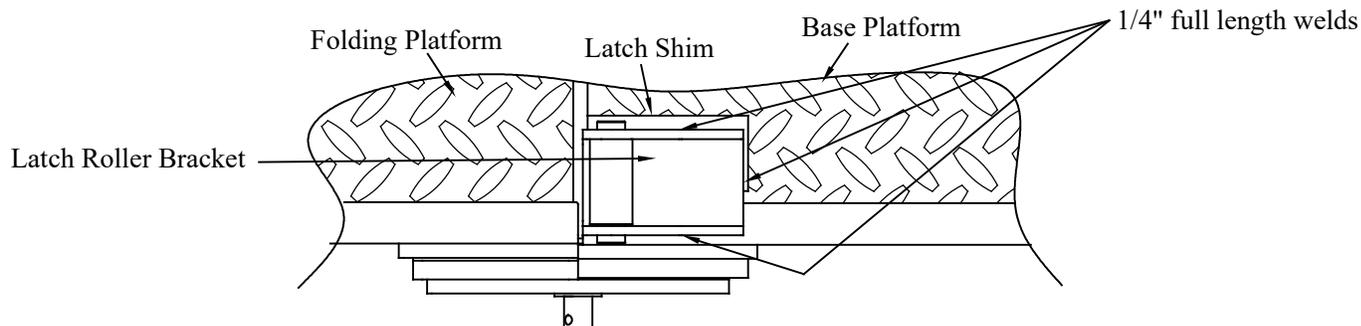


Figure 13: Latch roller on platform (top view, passenger side).

# Rail Bifold Latch Roller Bracket Replacement Instructions

## Prep and Paint the Platform

29. **Prepare** the bare steel and **Apply** touch up paint to the platform.

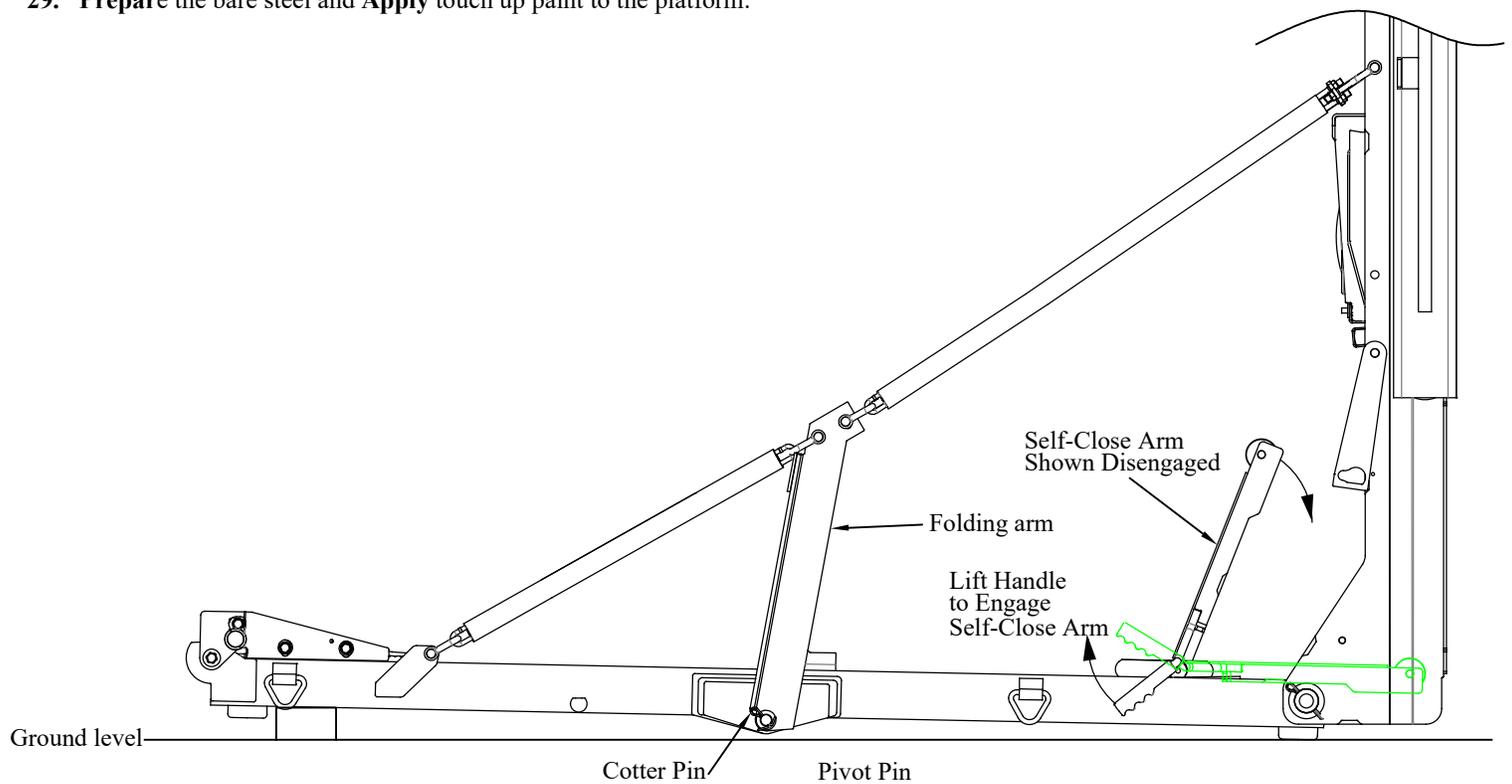


Figure 14: Bifold Platform lowered with slack in chains.

## Finishing the Replacement

30. **Attach** the folding arms.

31. **Install** the cotter pins.

32. **Connect** the power cable to the positive side of the battery or manually **Engage** the circuit breaker.

CAUTION: Stand off to the side clear of the platform while operating the liftgate.

33. **Engage** the self-close arm (Figure 14).

34. **Raise** the liftgate until the platform is folded and the latch rollers are locked in the latch plates (Figure 15).

35. **Latch** the latch lever over the latch peg (Figure 16).

36. **Hook** the safety chain and **Attach** the padlock (Figure 16).

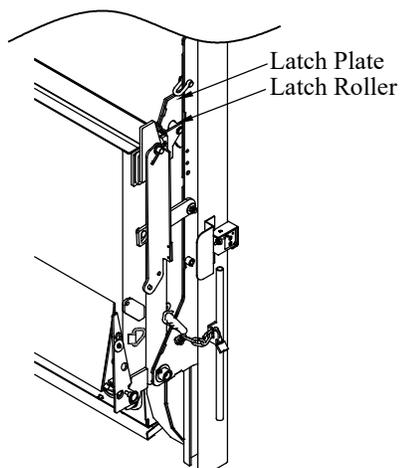


Figure 15: Platform chains removed for clarity.

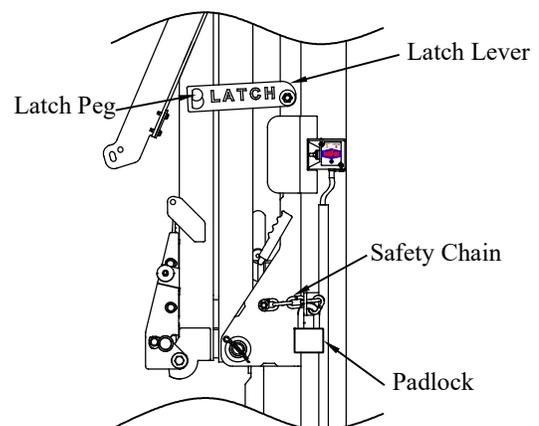


Figure 16: Platform chains removed for clarity.