

These instructions will assist in retrofitting retention ramp latch guards on a Tommy Gate Bi-Fold Railgate.

## Preparing for the Retrofit

1. **Unfold** and **Position** the platform at a comfortable working height.
2. **Disconnect** all battery cables from the vehicle battery.

## Removing the Latch Assembly

3. **Loosen** the Latch Bolt inside the Retention Ramp, but do not remove it at this time (Figures 1 and 2).
4. **Loosen** the Latch Knob and **Remove** it from the Latch Block (Figures 1 and 2).

**CAUTION:** Latch Spring is under compression.

5. **Remove** the Latch Bolt, freeing the Latch Spring and Latch Block (Figures 1 and 2).

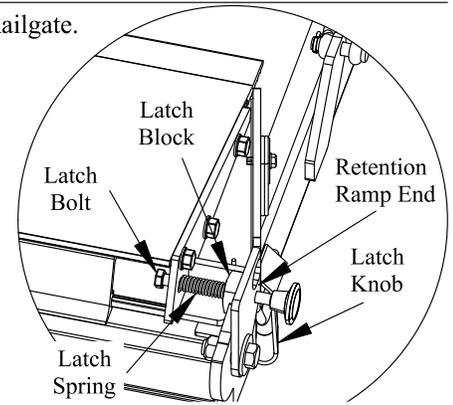


Figure 1: Latch assembly parts.

## Welding the Lid Guards

**WARNING:** Follow proper safety guidelines when welding near zinc plating.

6. **Grind** away the zinc plating or paint where the Latch Guards will be welded.
7. **Insert** the Locating Tool where the Latch Knob was removed (Figure 3).
8. **Tack** each Latch Guard using the Locating Tool as a guide (Figures 3 and 4).
9. **Weld** the Latch Guards in place (Figure 4).

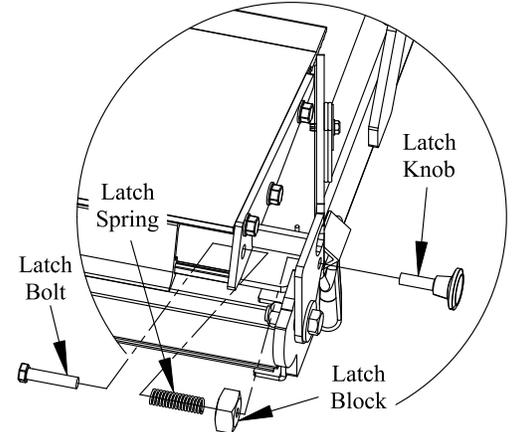


Figure 2: Remove/install latch assembly.

## Painting the Retention Ramp End

10. **Remove** any dirt, oil, grease, salt, or other contamination by washing with a mild detergent solution.
11. **Rinse** thoroughly with fresh water and allow to dry.
12. Lightly **Scuff Sand** the Tommy Gate topcoat.
13. **Sand** and **Spot Prime** any area of the Tommy Gate paint that shows signs of damage.
14. **Apply** desired finish coat per paint manufacturer's recommendations.



**WELDING NOTE!!! DISCONNECT ALL BATTERY CABLES. ALWAYS DISCONNECT THE GROUND CABLE FIRST. ATTACH THE WELDING GROUND TO THE TRUCK RATHER THAN THE LIFTGATE.**

## Reinstalling the Latch Assembly

15. **Apply** blue thread locker to the threads on the Latch Knob.
16. **Insert** the Latch Knob through the hole in the Retention Ramp End threading it into the Latch Block (Figure 2).
17. **Tighten** the Latch Knob so that no threads are showing.

**CAUTION:** Latch Spring is under compression.

18. **Position** the Latch Spring as shown in Figure 2.
19. **Insert** the bolt through the hole in the Retention Ramp End and **Thread** it into the Latch Block.
20. **Tighten** the bolt with an open-end wrench while holding the Latch Block to lock the assembly into place.

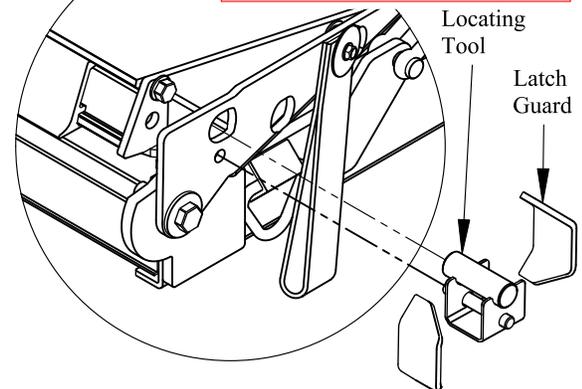


Figure 3: Locate latch guards.

## Finishing the Retrofit

21. **Reconnect** battery cables.
22. **Return** the liftgate to the stowed position.

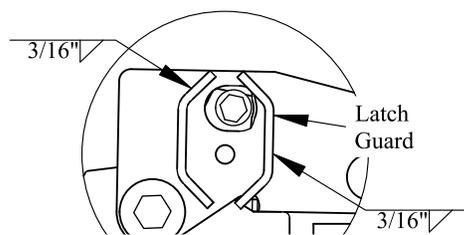


Figure 4: Weld.

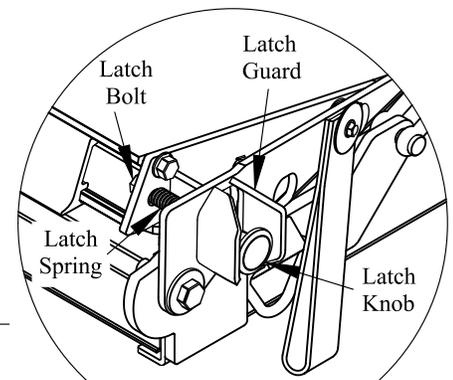


Figure 5: Completed install.