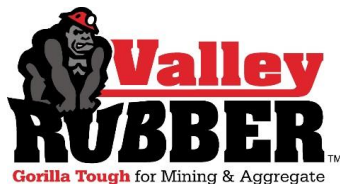


# Truck Bed Liner Install Guide

A complete guide from measuring to installing your new truck bed liners.



Gorilla Tough for Mining & Aggregate

ValleyRubber.Solutions

# Truck Bed Liner Guide

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# Introduction

Valley Rubber manufactures Haul Truck Bed Liners for all size truck bodies – historically we have lined 25-ton up to 360-ton trucks. We can effectively line heated and non-heated beds, offering extreme abrasion resistance and reducing metal fatigue and eliminates stress fractures, while increasing driver comfort and reducing noise. The easy-to-install liner system is cost effective and maintenance free compared to steel liners, increasing equipment availability. Quiet and reliable, our “Gorilla Tough” bed liners extend the life of your equipment for the long haul. Our design makes for easy installation and replacement, also known as Truck Bed Liners.

## Getting Started



To begin the process of installing your truck bed liners, you will need to provide Valley’s Rubber’s CAD department with necessary information concerning the measurement of the truck bed. The following will include application data sheets and installation instruction.

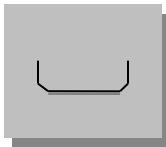
## Types of Truck Beds

Below are the three basic floor types.



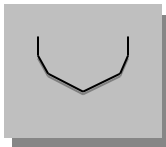
**Dual Slope:** Is a bed consisting of slopes from each side and tail end slope

**(Refer to “A” Data sheet)**



**Flat Floor:** The area of the bed to be lined is typically flat, and on some models one slope at the tail of the truck.

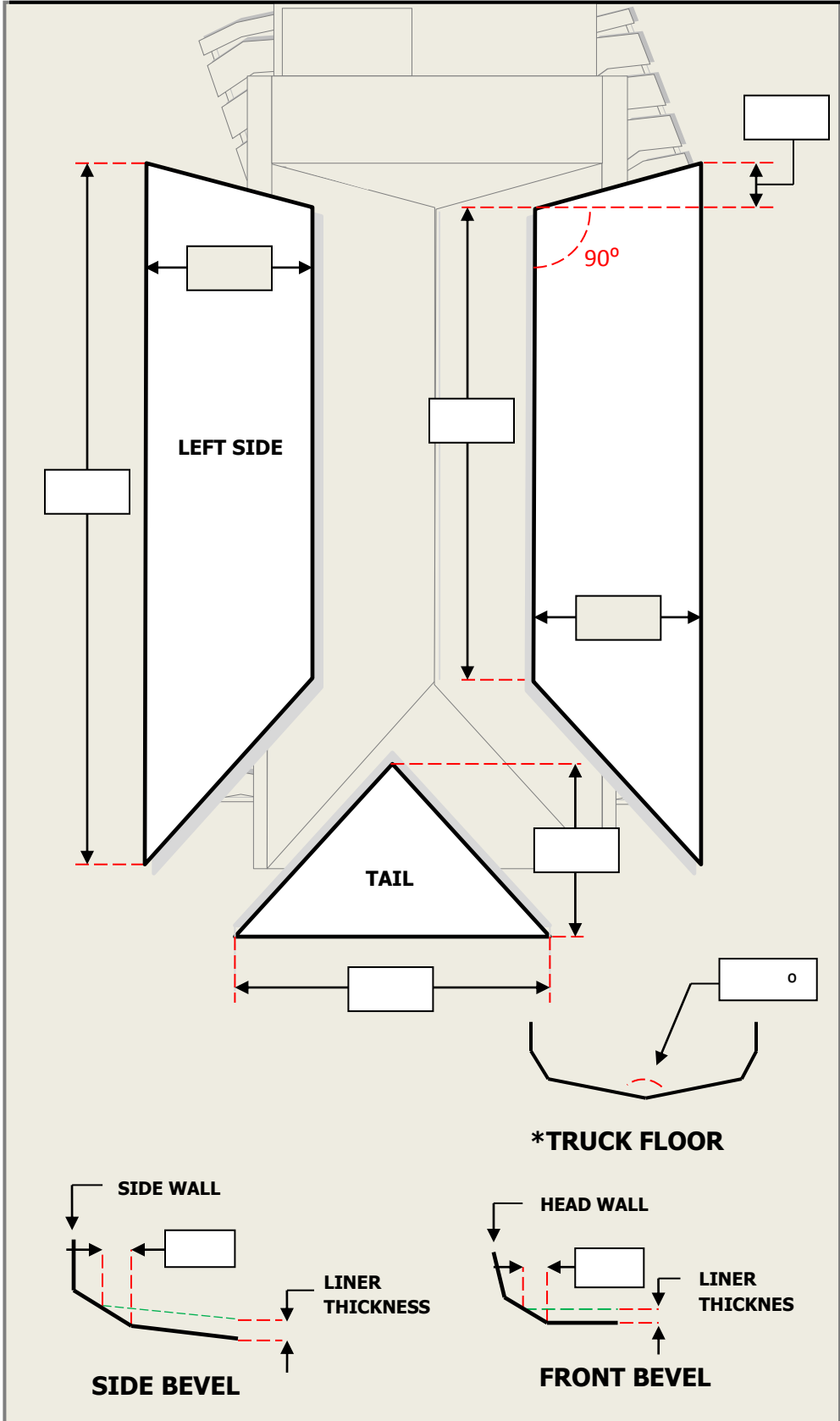
**(Refer to “B” Data sheet)**



**“V” Bottom:** Is a bed consisting of a left side slope and a right side slope forming a “V” shape looking down the tail of the bed.

**(Refer to “C” Data sheet)**

# Dual Slope Truck Bed Liner Data Sheet



## End User Information

End User: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_

State: \_\_\_\_\_ ZIP: \_\_\_\_\_

## Distributor Information

Distributor: \_\_\_\_\_

Contact: \_\_\_\_\_

Phone: \_\_\_\_\_

Fax: \_\_\_\_\_

## Technical Information

Is the Box Heated? **Yes** or **No**

Please Circle One

Indicate with an "X" on the Data Sheet where the heated exhaust enters the bed.

**Truck Make:**

\_\_\_\_\_

**Truck Model:**

\_\_\_\_\_

**Truck Series:**

\_\_\_\_\_

**Notes:** \_\_\_\_\_

\_\_\_\_\_

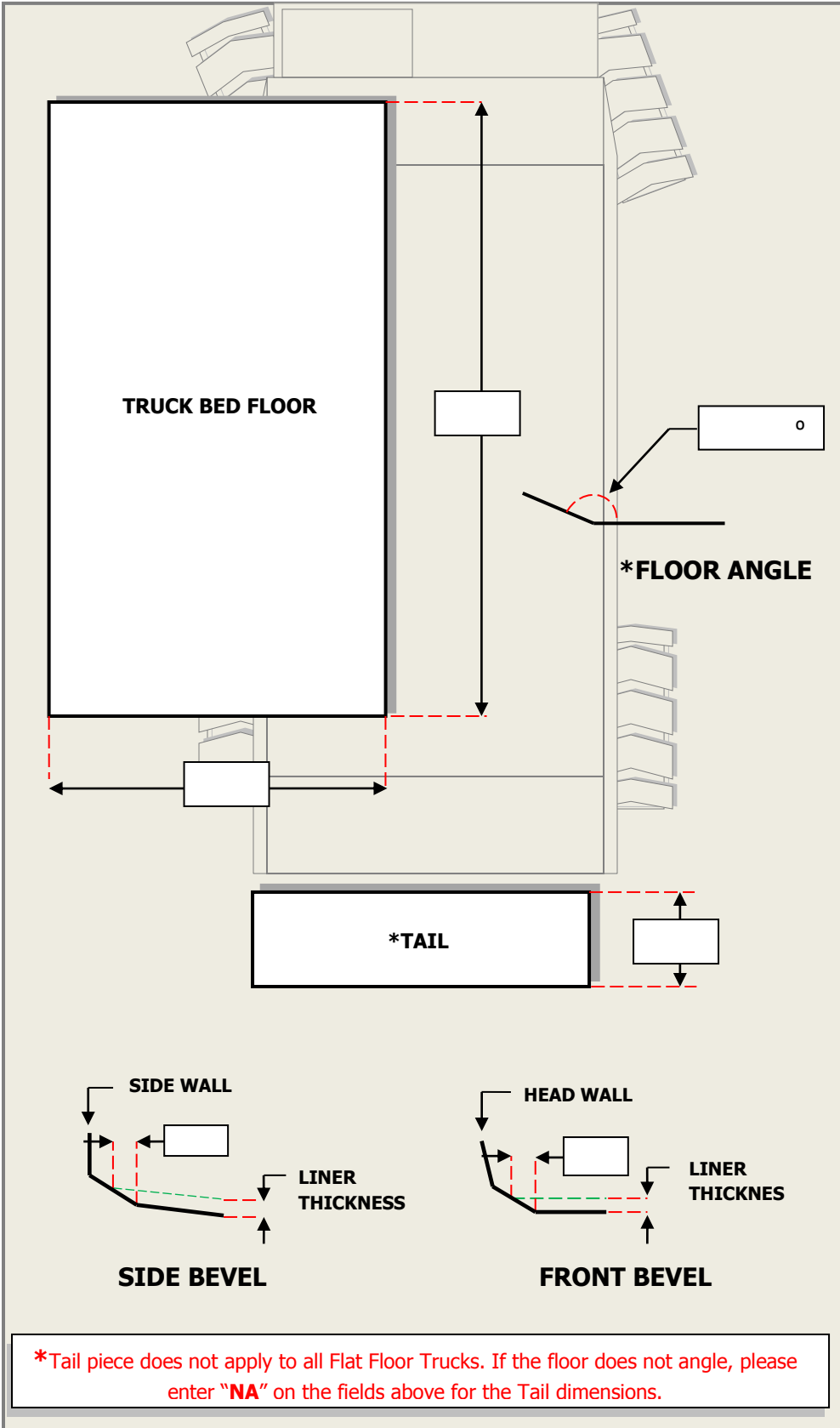
\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

For Assistance Please Call  
**1.800.622.5667**

# Flat Floor Truck Bed Liner Data Sheet



### End User Information

End User: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_

State: \_\_\_\_\_ ZIP: \_\_\_\_\_

### Distributor Information

Distributor: \_\_\_\_\_

Contact: \_\_\_\_\_

Phone: \_\_\_\_\_

Fax: \_\_\_\_\_

### Technical Information

Is the Box Heated? **Yes** or **No**

Please Circle One

Indicate with an "X" on the Data Sheet where the heated exhaust enters the bed.

Truck Make:

\_\_\_\_\_

Truck Model:

\_\_\_\_\_

Truck Series:

\_\_\_\_\_

Notes: \_\_\_\_\_

\_\_\_\_\_

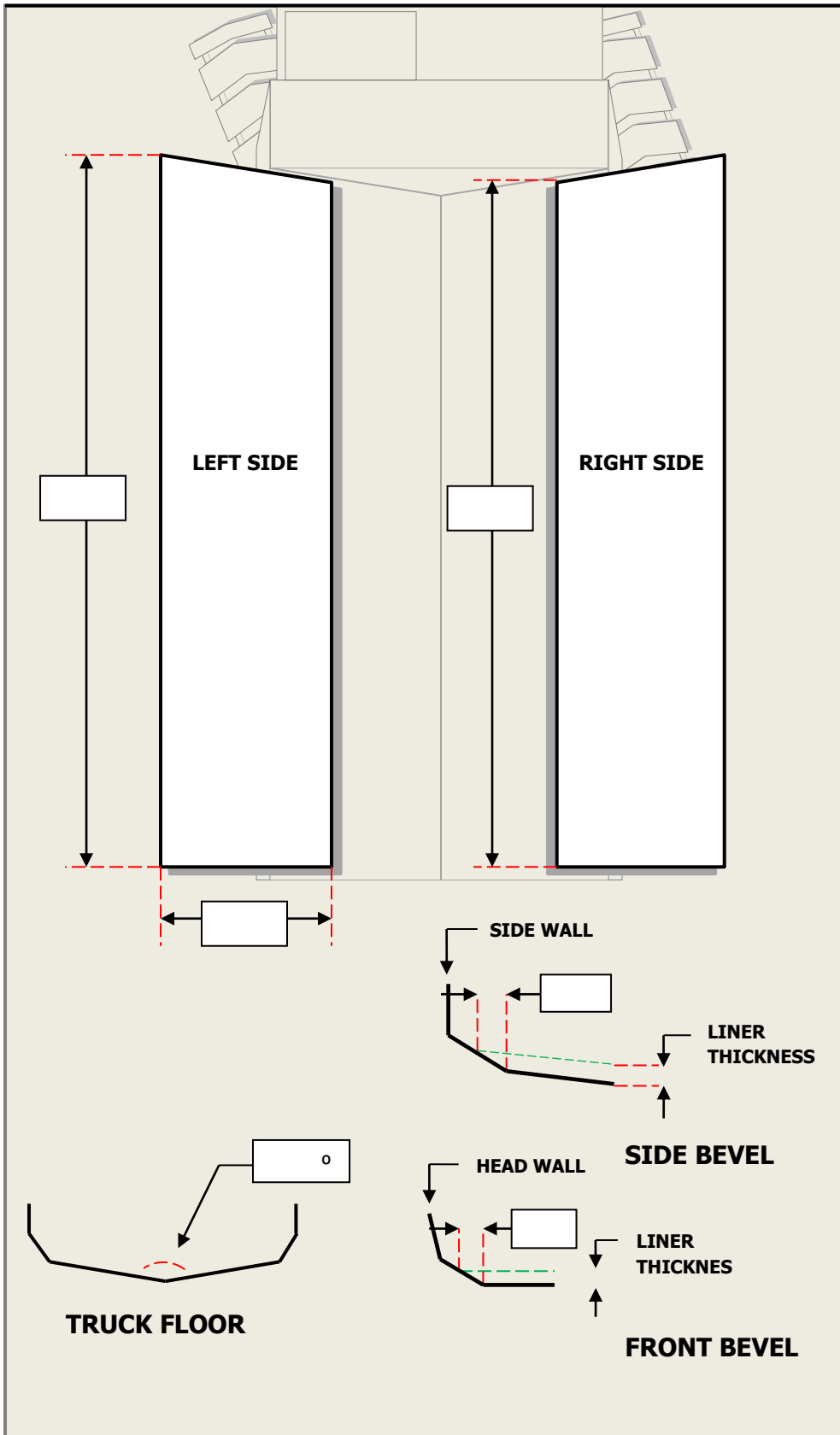
\_\_\_\_\_

\_\_\_\_\_

\*Tail piece does not apply to all Flat Floor Trucks. If the floor does not angle, please enter "NA" on the fields above for the Tail dimensions.

For Assistance Please Call  
**1.800.622.5667**

# "V" Bottom Truck Bed Liner Data Sheet



### End User Information

End User: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_

State: \_\_\_\_\_ ZIP: \_\_\_\_\_

### Distributor Information

Distributor: \_\_\_\_\_

Contact: \_\_\_\_\_

Phone: \_\_\_\_\_

Fax: \_\_\_\_\_

### Technical Information

Is the Box Heated? **Yes** or **No**

Please Circle One

Indicate with an "X" on the Data Sheet where the heated exhaust enters the bed.

**Truck Make:**

\_\_\_\_\_

**Truck Model:**

\_\_\_\_\_

**Truck Series:**

\_\_\_\_\_

**Notes:** \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_





\_\_\_\_\_

\_\_\_\_\_

For Assistance Please Call  
**1.800.622.5667**

# Measuring the Truck Bed

Before measuring your truck bed you will need to remove all debris and material build. Check the bed for areas that would jeopardize a successful stud weld. These are areas such as, cracks, voids and weld bead that would interfere with stud welding. You will need to note any locations on the data sheet, so that a stud will not be located in that particular spot. If the bed is too damaged it could void the warranty. If there are questions about the quality of the truck bed, please call Valley Rubber for assistance.

Tools Needed	
	Tape Measure
	Spool of String
	Carpenter's Square
	Angle Finder

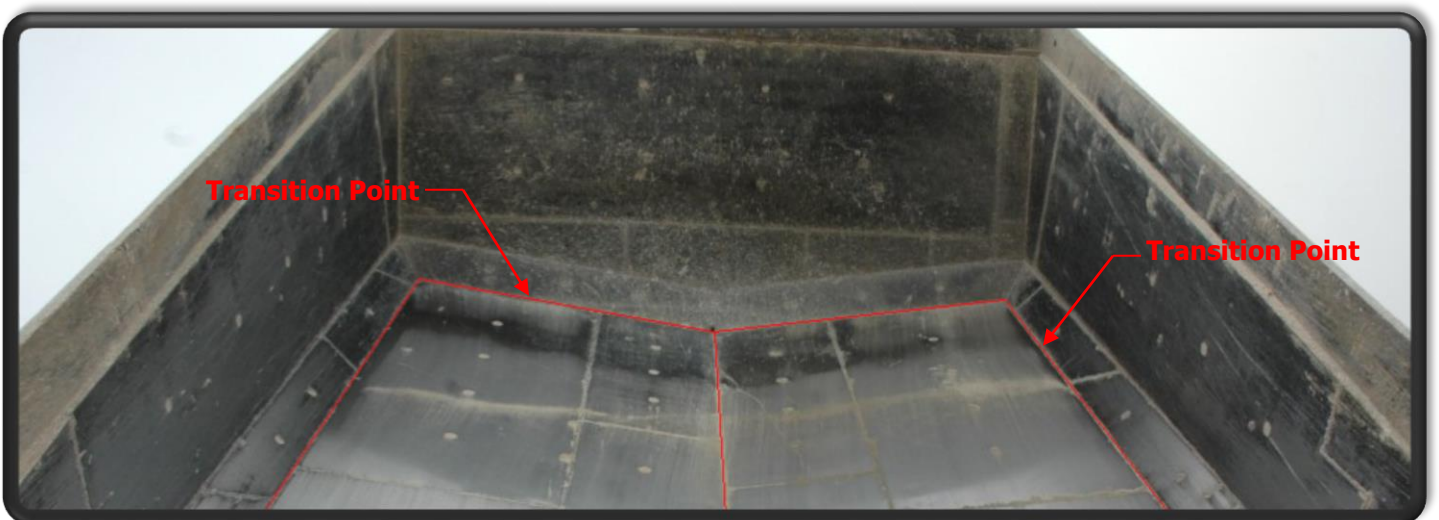


## Measuring Procedures

### Measuring the Flats

All of these measurements should be taken with the tape measure flush to the floor.

Always start your measurements at the transition point where the floor meets the cant. This is the point where the cant meets the floor.

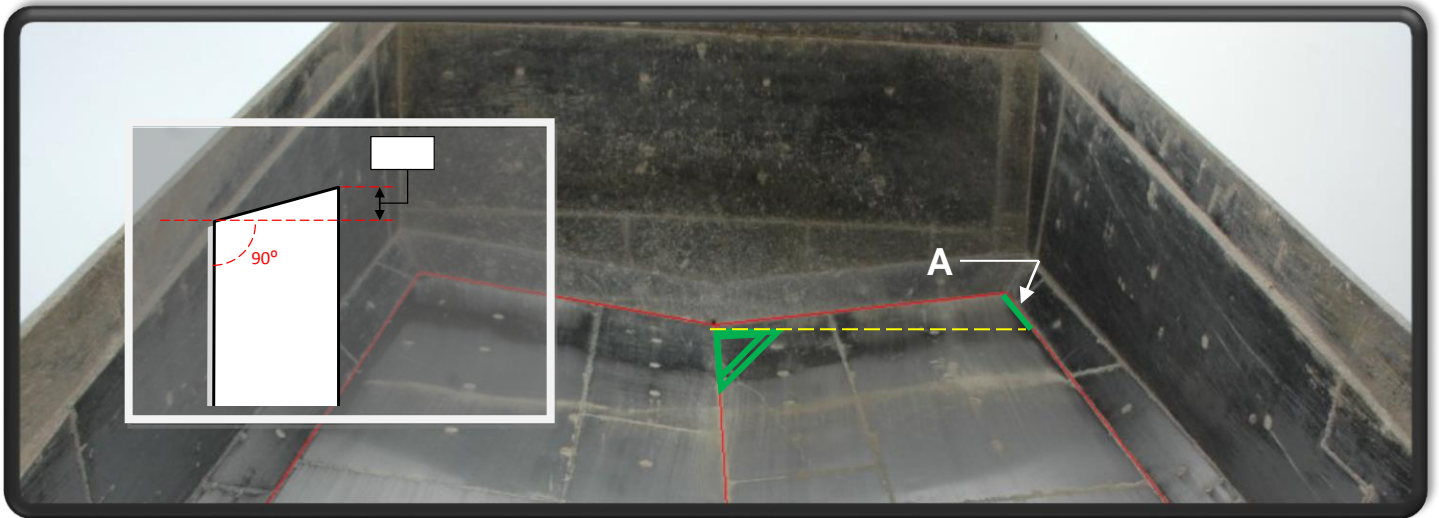
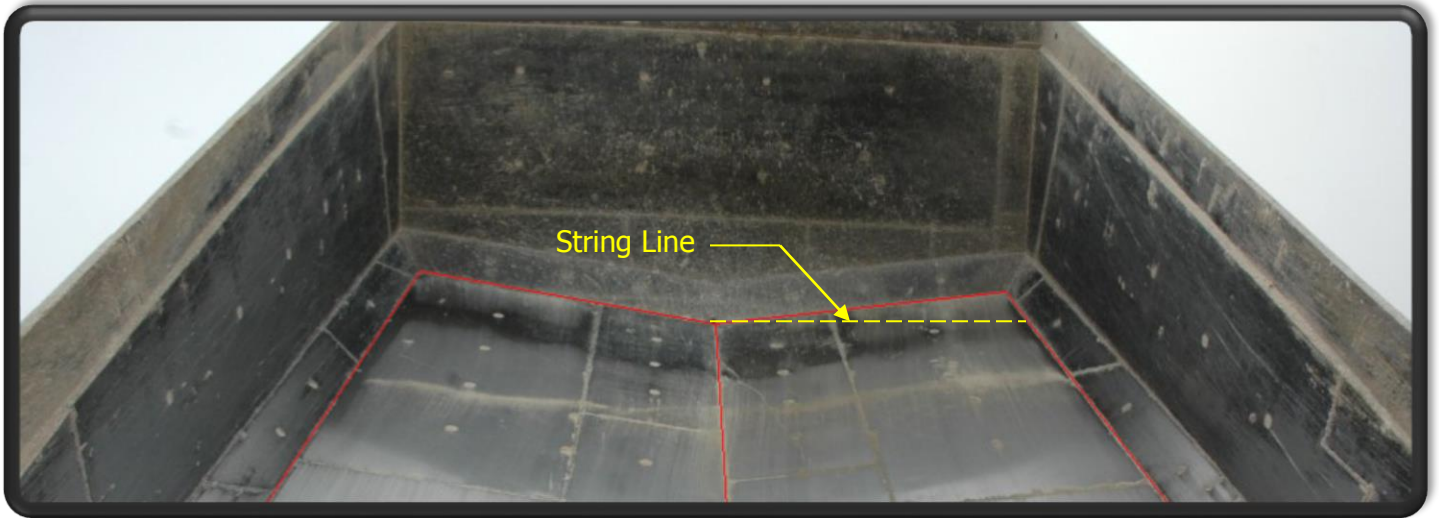




## Measuring Procedures (cont.)

### Measuring the slants

Start the string at the center of the floor and front cant of the bed and run it perpendicular using a square. (See diagrams below)

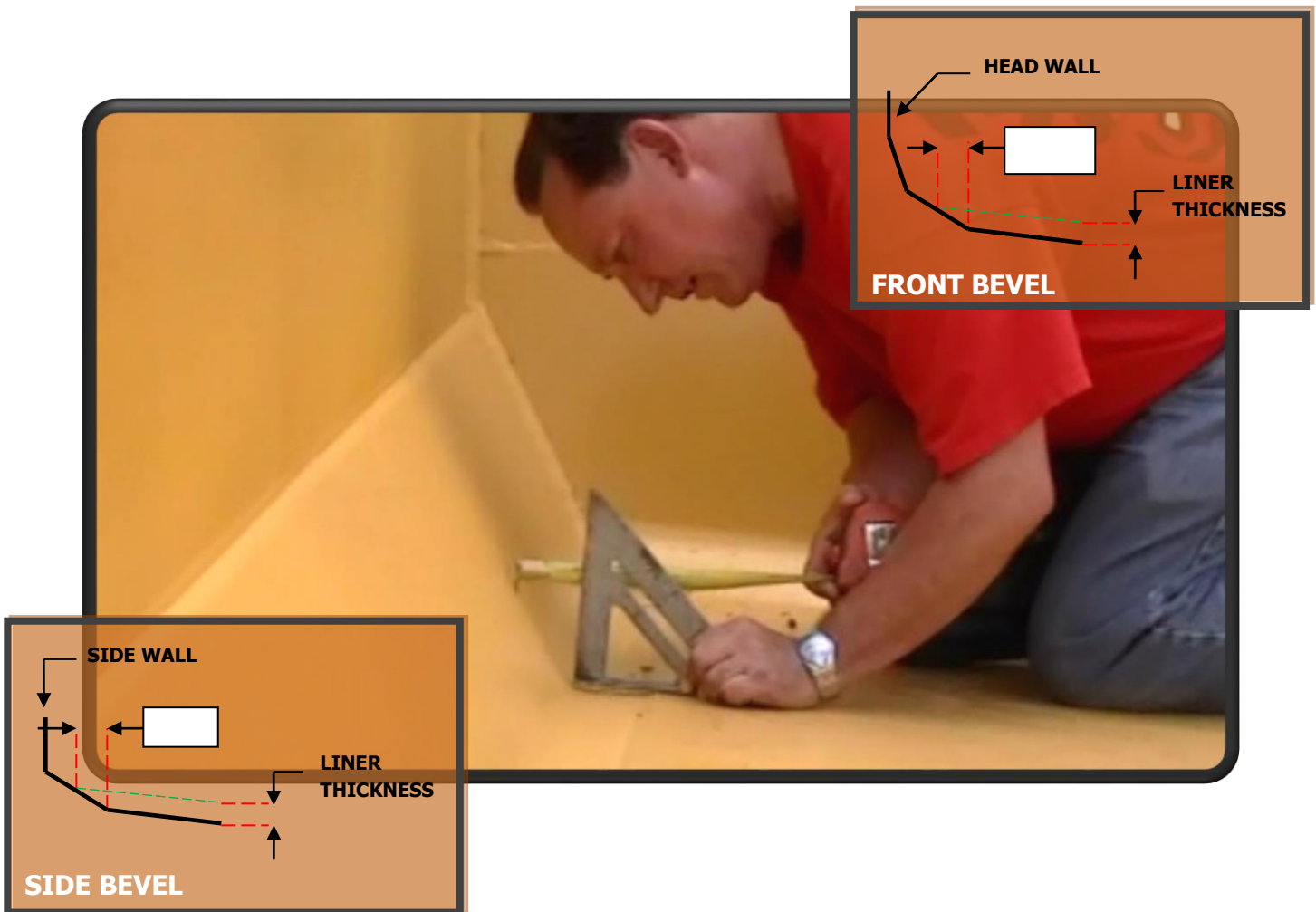


You will need to measure the end of the line to the corner of the floor and the cant, to get the dimension for "A".

## Measuring Procedures (cont.)

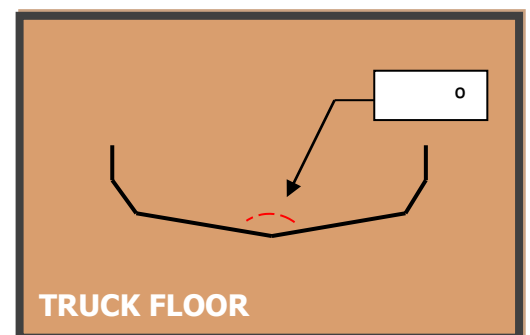
### Measuring for the liner bevels

Measuring for the rubber bevels is quite easy. First you will need to know what the overall thickness of the liner will be, this will provide a starting point. Set the square on the floor and let it pivot at the transition line with the straight edge facing toward the side of the bed where you are working. Next take your tape measure and bring it up to your overall liner thickness on the square and extend it out to the side wall, record this measurement as shown below. (See diagram)



### Measuring the angles

If you are measuring a "V" Bottom or Flat Floor with an angle, then you will need to provide the pitch or angle. To do this, simply use an angle finder and enter the degree in the space provided on the data sheet.

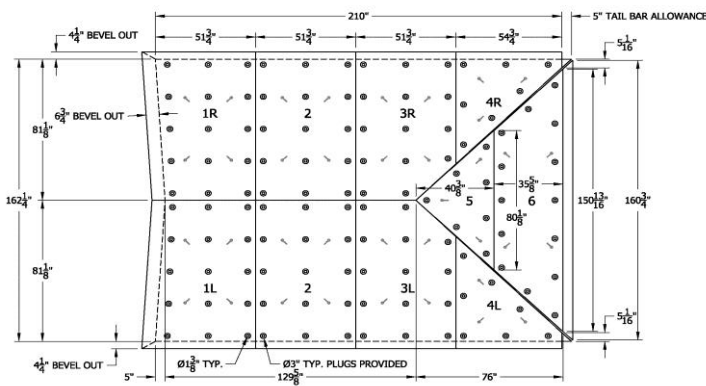


# Installing the Truck Bed

## Procedure of installation



Before the liners are shipped to your destination, they are palletized and stacked for easy installation and all of the necessary hardware is bundled in sealed containers. The first liner to be installed is right on top of the stack – the last liner to be installed is on the bottom.



Each liner has threaded lugs to attach eye bolts for ease of lifting and positioning liners. Each system comes with an easy to follow liner map that directs the placement of each piece. The first liners to be installed are nearest the cab and typically have beveled edges where they meet the walls; once these are positioned with the help of a boom, the remaining liners should be placed next to the previous liner snugly.

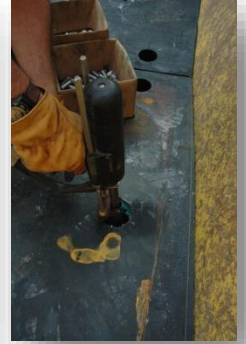


## Installing the Truck Bed (cont.)

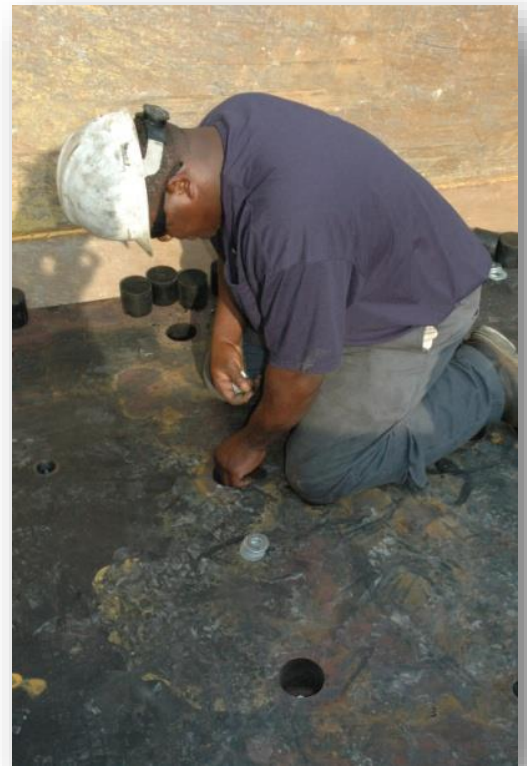
### Fastening the Truck Bed Liners

Once all the liners are in place, it's time to fasten them down. You will have a container which includes your hardware for each system, separate the hardware. If necessary prep the floor of the bed, through the mounting holes with a wire brush or needle gun to remove any rust or debris that would prevent a good stud weld.

Next you will need to apply the threaded studs to the floor through each mounting hole.



After you have finish welding the studs through each mounting hole you will need to drop a washer over each stud followed by a nut and then securely tightened using a pneumatic drill.



## Installing the Truck Bed (cont.)

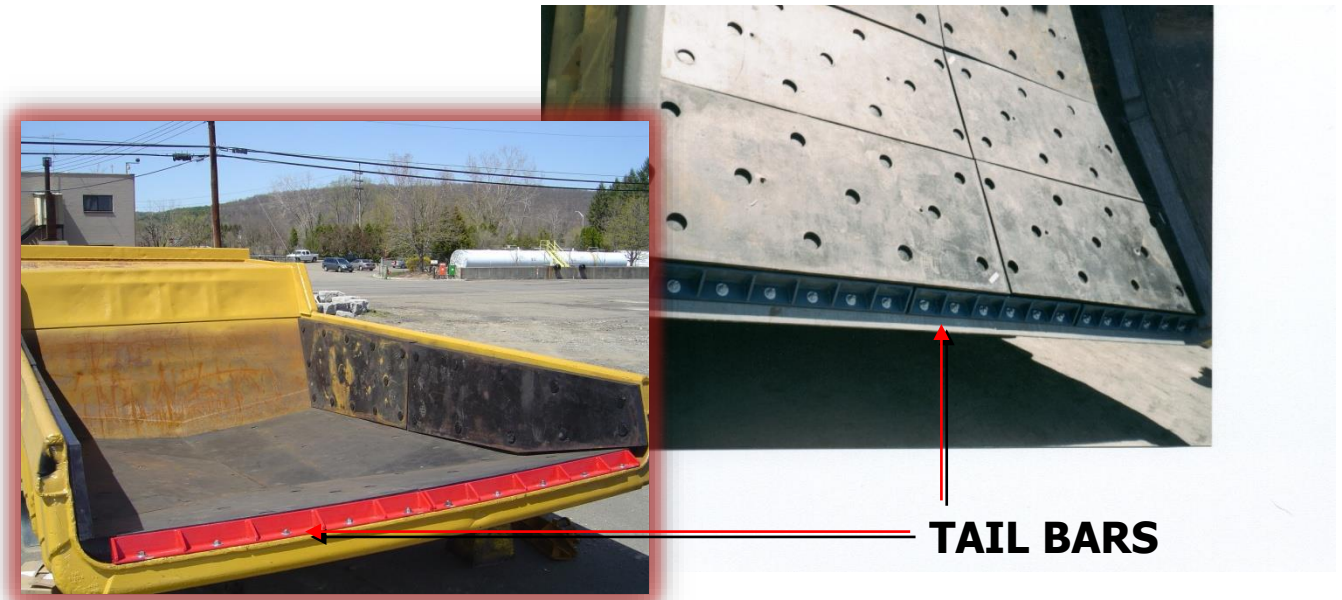
### Rubber Plugs

Now you are ready to insert the provided rubber plugs to protect the studs and hardware. To do this, hammer the plugs into the holes, if they are being stubborn spray some water on the plugs and they should slip right in.



### Tail Bar

The tail bar is installed flush against the back edge of the liners at the tail of the truck body. You will need to use the stud welder and hardware provided to secure it to the bed. When placing the tail bar for welding it will need a 1" - 2" gap between each bar. If you choose, you can use the holes in the tail bar to plug weld to the bed instead of using the studs.



### Inspection

Now that you have fastened the liners down and completed the tail bar, it would be a good idea to go back and double check your work. Make sure all holes are studded and plugged and that the tail bar is tight against the liners. You are now complete with installing the Truck Bed liner. We know that it will provide you with years of maintenance free reliability and Gorilla Tough performance.

## Warranty Information

End User: \_\_\_\_\_ Install Date: \_\_\_\_\_ / \_\_\_\_\_ / \_\_\_\_\_

Address: \_\_\_\_\_ Dealer: \_\_\_\_\_

\_\_\_\_\_ Contact: \_\_\_\_\_

---

Truck Model: \_\_\_\_\_

Is the box heated? **Yes**  or **No**  (Please Check one)

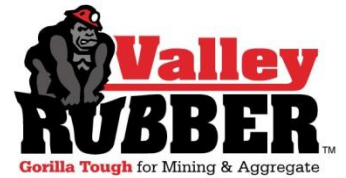
Where does the heated exhaust enter the bed? \_\_\_\_\_

Type of material: \_\_\_\_\_

Maximum material size: \_\_\_\_\_ Drop height: \_\_\_\_\_

Truck – hours of operation \_\_\_\_\_ / Week

Anticipated Life: \_\_\_\_\_ / Hrs.



### Rank Abrasiveness of Material

1	2	3	4	5	6	7	8	9	10
Light			Moderate				Severe		

#### Compared to Steel

Brinell Hardness \_\_\_\_\_ BHN

Cost \_\_\_\_\_

Thickness \_\_\_\_\_

Life \_\_\_\_\_ Hrs.

#### Compared to Rubber

Manufacturer \_\_\_\_\_

Cost \_\_\_\_\_

Thickness \_\_\_\_\_

Life \_\_\_\_\_ Hrs.

### Cost Effective Warranty

When properly installed and maintained, the cost of Valley Rubber products will be less than the competitors in the same application for the same period and usage. This is a wear life warranty and is only applicable when an Application Information Sheet is submitted and approved before placing the order. A prorated adjustment will be made if the life cost is not equal to or better than the competitor.