



## **3100 Bed Corner Installation Manual**

**Thank you for your purchase of the *Apicella Designs* 3100 Bed Corner Kit. Please read and review ALL instructions contained in this kit. *Apicella Designs* is NOT responsible for any personal or property damage deriving from the modification and/or installation of this product. ALL modification and/or installation should be performed by a professional.**

**Inquiries? Email us at**

**[Apicelladesigns@gmail.com](mailto:Apicelladesigns@gmail.com)**

# Chevy 3100 Bed Corner Kit

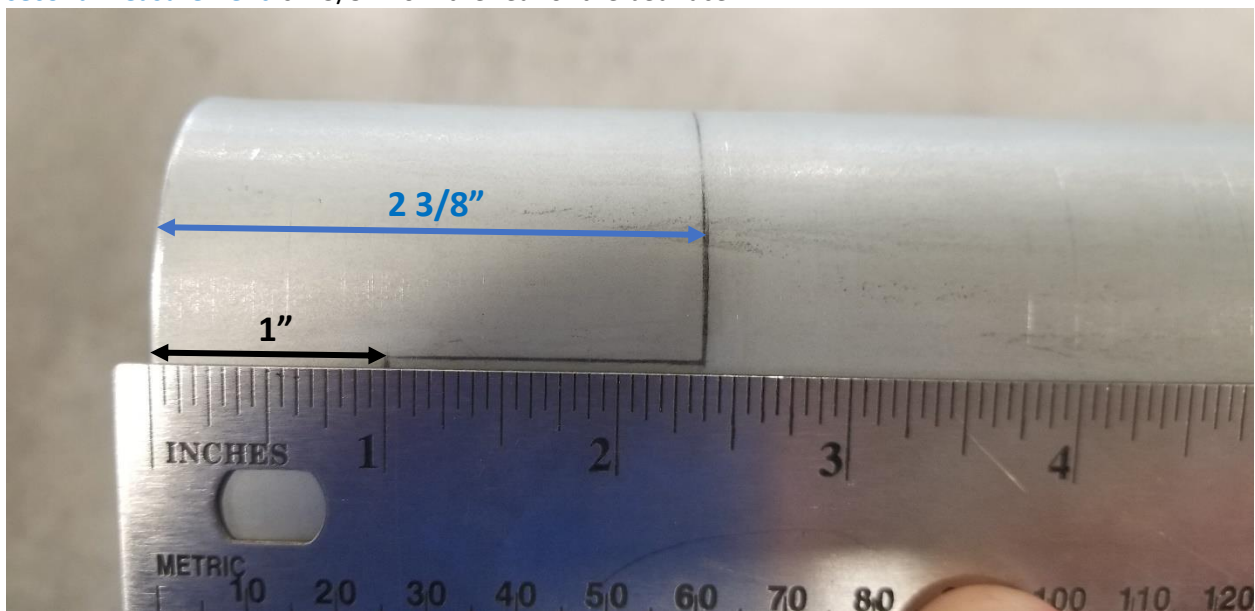
## Step 1:

Start by making your cut lines on your factory bed. Figure 1 shows the completed marking ready for cutting.



**Fig 1**

Figure 2 shows two measurements. The **first measurement** is 1" from the rear of the bed face. The **second measurement** is 2 3/8" from the rear of the bed face.

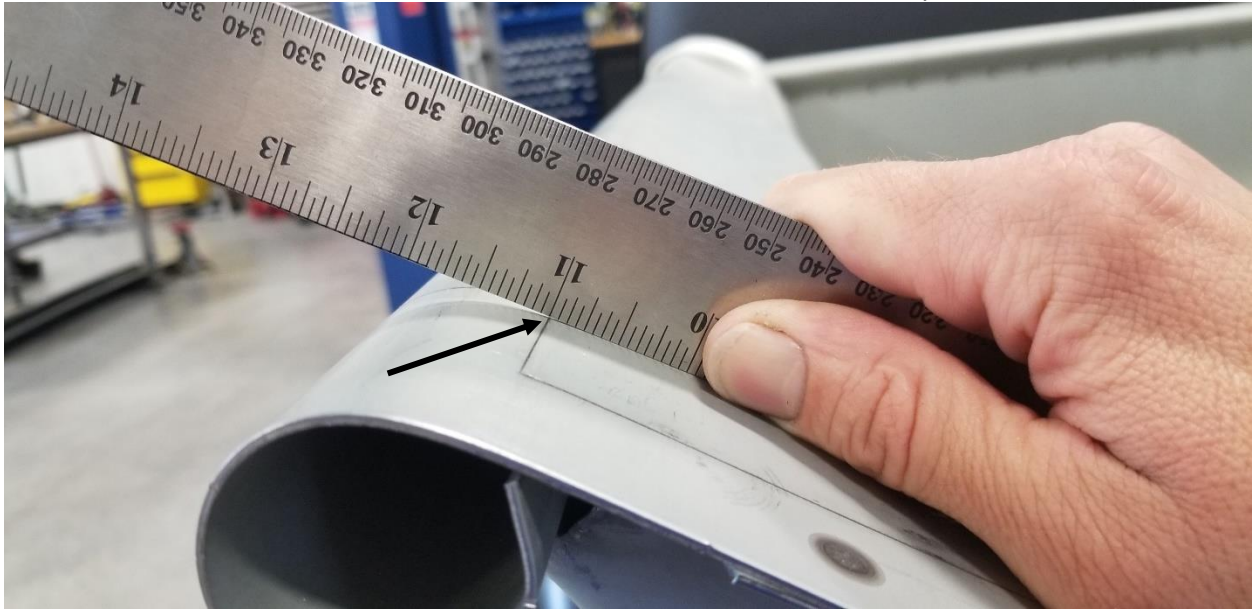


**Fig 2**

The following instructions will describe how to locate the parallel cut lines on your bed side.

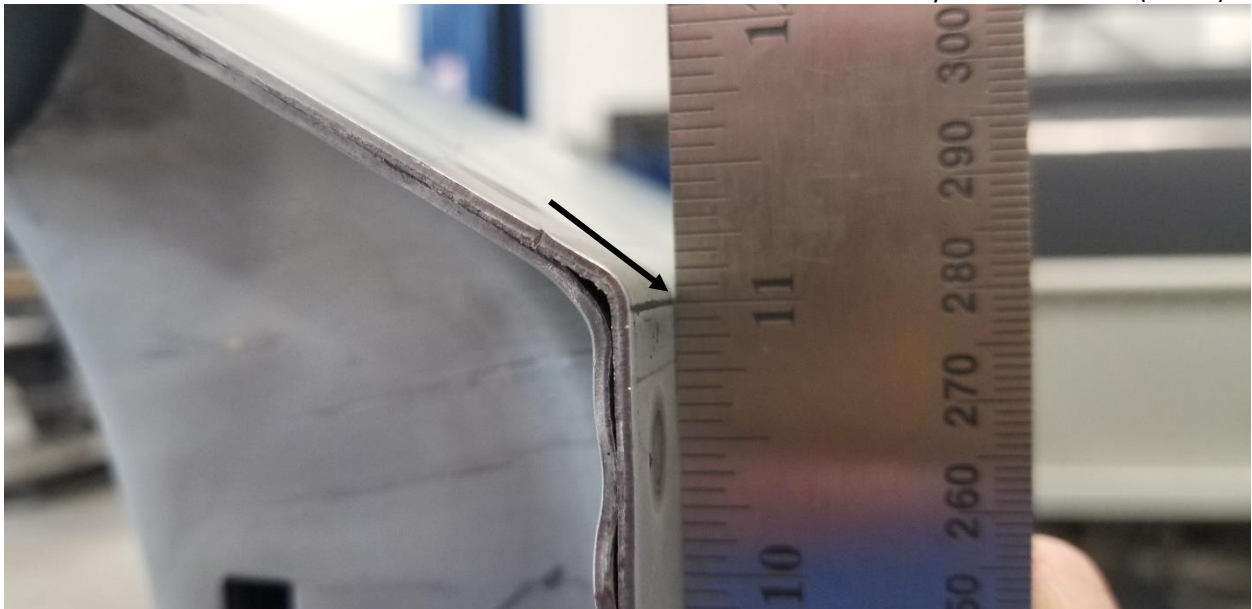
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Figure 3 shows using a straight edge ruler to see where the radius starts on your bed rail. Your parallel line should be drawn across the bed rail where the radius starts to “fade away” from the ruler (arrow).



**Fig 3**

Figure 4 shows using a straight edge ruler to see where the radius starts on your bed side. Your parallel line should be drawn across the bed side where the radius starts to “fade away” from the ruler (arrow).



**Fig 4**

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Figure 5 shows your parallel line locations (black arrows), and the 1" and 2 3/8" lines completed and ready to cut.

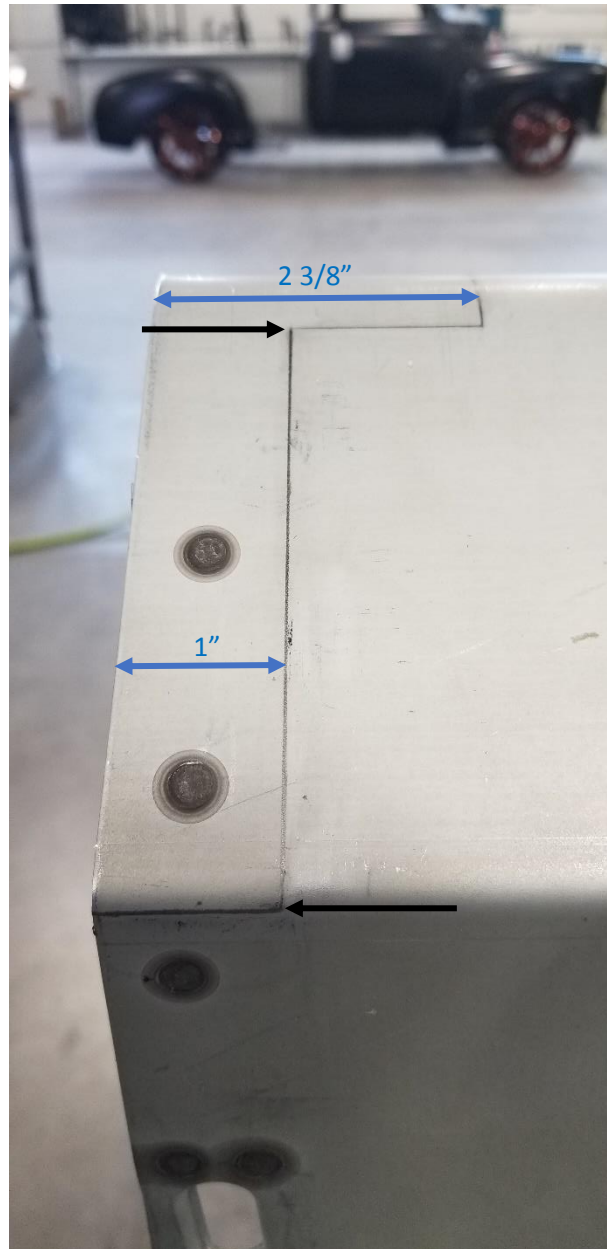


Fig 5

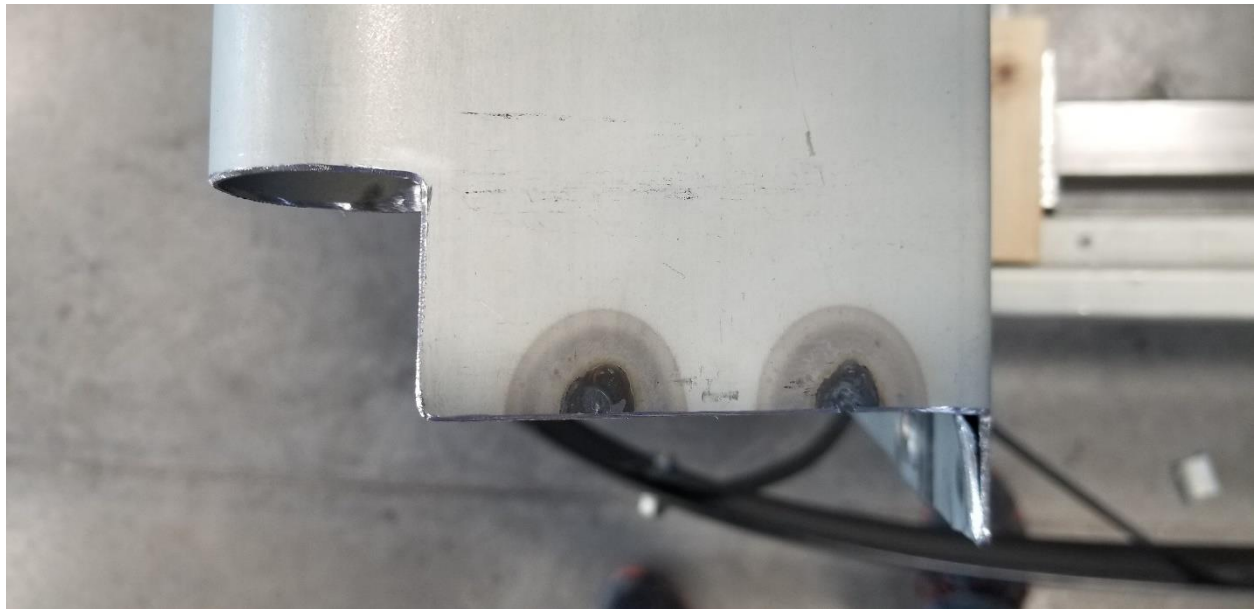
# STOP!

**DOUBLE CHECK ALL MEASUREMENTS BEFORE MOVING TO THE NEXT STEP!  
DOUBLE CHECKING ALL MEASUREMENTS ASSURES THE FIT AND FINISH OF YOUR  
APICELLA DESIGNS PRODUCT! THE CUSTOMER ASSUMES ALL LIABILITY FOR ANY  
MODIFICATION TO THIS PRODUCT AND/OR THE VEHICLE BEING MODIFIED.**

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## Step 2:

Now that you've double checked and are certain that your markings are correct, it is time to cut your bed sides. **CAUTION: Be sure to TAKE YOUR TIME and wear the PROPER SAFETY PROTECTION!** Our bed sides were cut using an aluminum oxide cut off wheel. This will make for a nice clean cut as seen in figure 6.



**Fig 6**

## Step 3:

In figure 7, we see the two spot welds (**circled**). At this time, using a spot weld cutter or Rotabroach, cut the spot welds from the **bottom** (stake pocket) side. **Make sure not to cut completely through both layers! You need to leave the top intact.**

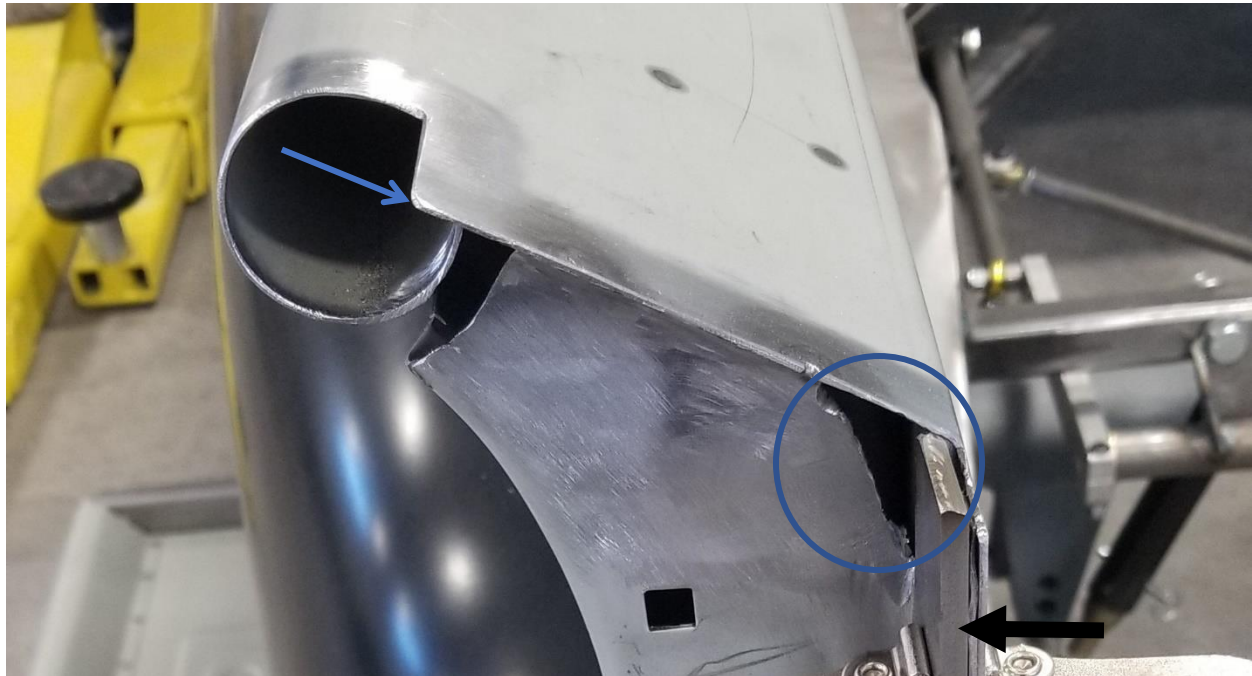


**Fig 7**

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## Step 4:

Now that you have the stake pocket free of the top skin of the bed, you can trim away some excess metal from underneath so that your new Apicella Designs bed corners can have adequate clearance. You will want to trim the bottom skin (stake pocket) back from your **new edge** (indicated by blue arrow) about  $\frac{1}{2}$ " into the stake pocket in figure 8. When done properly, you'll have a nice clean single layer to butt your new bed corner underneath. Take this time to remove additional stake pocket material (blue circle) with a carbide burr bit as well. Clean and deburr all edges.



**Fig 8**

**Note:** We've added a reinforcement on our bed sides (**BLACK** arrow). If you are **NOT** adding this feature to your bed sides, please disregard it in these illustrations. These instructions are written without taking into account the installation of these parts.

## Step 5:

It's now time to start fitting your new Apicella Designs bed corners. Taking your time could mean the difference between an ill-fitting or perfect fit. The short side of the bed corner is pre-cut to length at  $2\frac{3}{8}$ ", so any trimming can be done on the bed side. The long side, however, is left long so it can be trimmed for that perfect, custom fit. Be careful to measure and cut accordingly, a little at a time, so this fit can be achieved.

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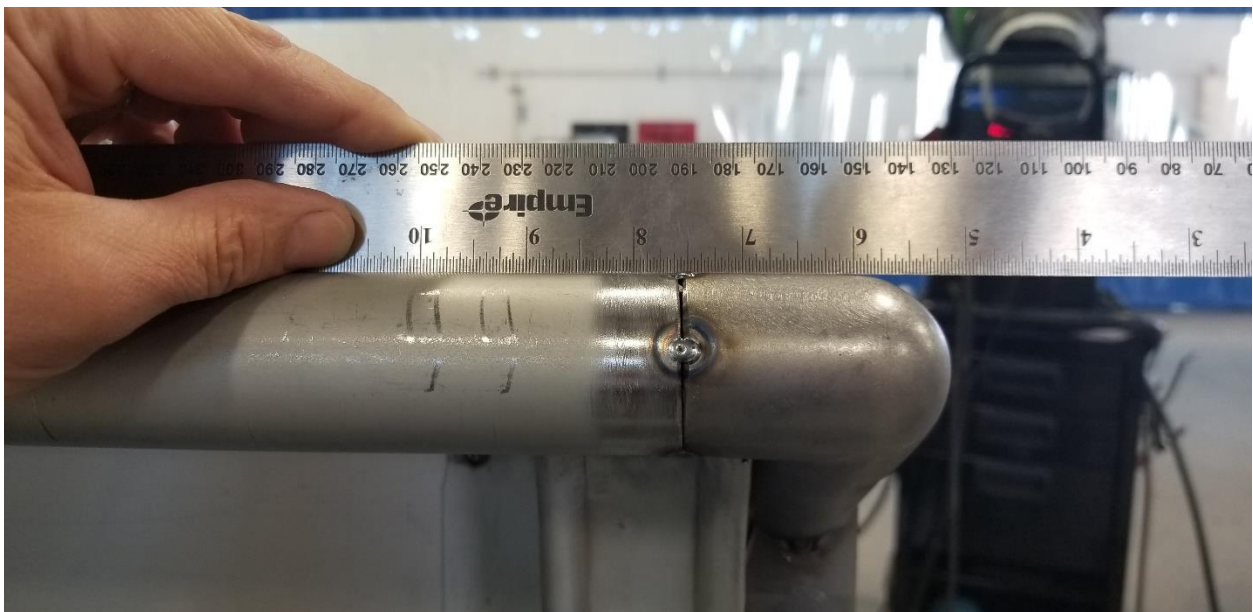
In figure 9, the bed corner is fit and ready to tack weld in place. The cut side (circled) is achieved by using an angle finder to find the proper cut angle. Reminder: Cut away a little at a time until the proper length is achieved! It's easier to take away than it is to add!



**Fig 9**

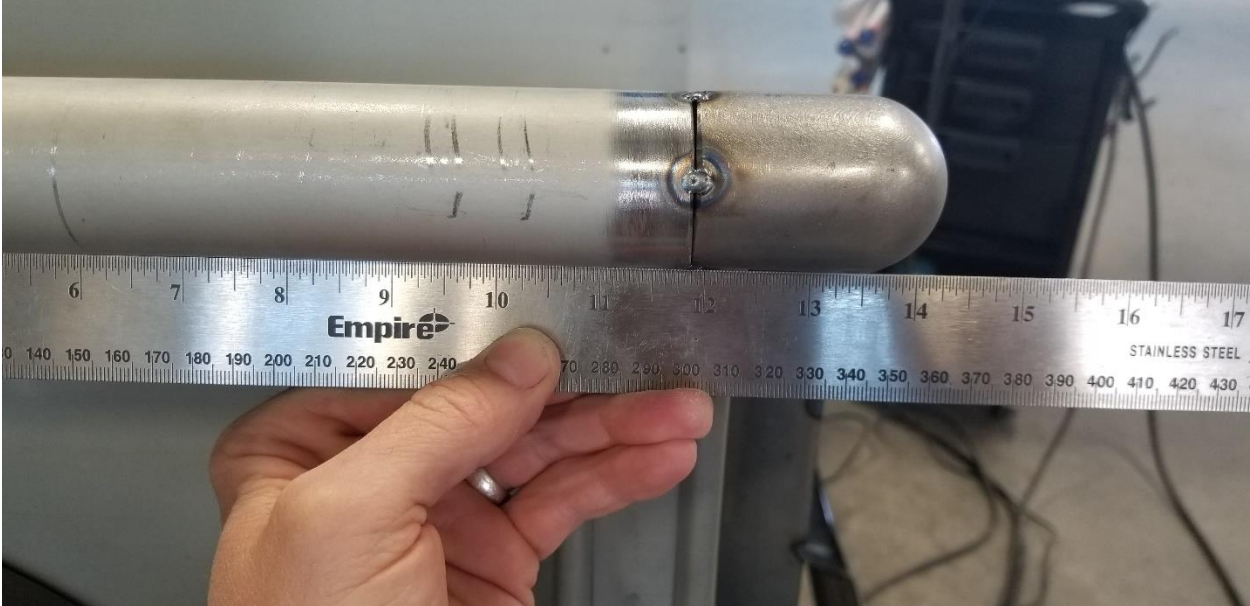
### **Step 6:**

Tack weld bed corner in place. Double check that the corner is straight with the bed rail. This can be achieved by using a straight edge to across the bed rail and corner together. (Figures 10 & 11)



**Fig 10**

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**Fig 11**

Once bed corner is in its location, tack weld firmly in place. (Figure 12)



**Fig 12**



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### Step 7:

You are now ready to fully weld your corners in place. **NOTE:** Make sure to stitch weld small areas at a time and let completely cool to prevent warping as much as possible. (Figures 13 & 14) **NOTE:** Do **NOT** weld underneath the bed corners. There is too much of a gap between the corner and the stake pocket to adequately weld. A seam sealer would be a better choice for filling in this area.



**Fig 13**



**Fig 14**

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### Step 8:

Now that the bed corners are in place, it's time to grind down the welds. Figures 15 and 16 are the before and after. Keep in mind that there will have to be some body work done, so don't worry if they don't look perfect at this point. Figure 16 is a perfect example of how they should look. Figure 17 shows a straight edge ruler on the rail. Make sure when taking down the welds not to gouge the material. You want the blend to be as smooth as possible to make the body work as minimal as possible. Figure 18 is just pretty!



**Fig 15**



**Fig 16**

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**Fig 17**



**Fig 18**

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## Step 9:

Time for some body work. If you don't feel comfortable doing this, take it to a professional. It WILL be worth it. Figures 19-22 show basic body work being done on a set of freshly installed Apicella Designs bed corners.



**Fig 19**



**Fig 20**

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**Fig 21**



**Fig 22**

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## Step 10:

Crack a beer, sit back, and admire a job well done! You now have a custom bed that adds the perfect finishing touch to your 3100.

Don't forget to take pictures and share them on [www.facebook.com/apicelladesigns](http://www.facebook.com/apicelladesigns). We'd love to share your work!

