



TOLL FREE 1-800-890-8544

BOX 2049 HUMBOLDT, SK. CANADA S0K 2A0 PH: (306) 682-4410 FAX: (306) 682-4410
HIGHWAY # 5 EAST & BRUCE STREET (MORRIS BUILDING)

www.alumi-tech.com

11/04

ALUMI-TECH® COVER
ASSEMBLY INSTRUCTIONS

U.S. PATENT NO. 5,096,250
CANADIAN PATENT NO 1,314,302

IMPORTANT

PLEASE READ ALL INSTRUCTIONS BEFORE ASSEMBLING
FAILURE TO FOLLOW THE ENCLOSED ASSEMBLY AND MAINTENANCE
INSTRUCTIONS, AND RETURN THE WARRANTY CARD WILL VOID ALL
WARRANTY.

*The model and serial numbers are located on the front drivers
side of the cover storage hood.*

MODEL NO. _____
SERIAL NO. _____

SEND WARRANTY CARD TO: **TREK INDUSTRIES INC.**

Box 2049
Humboldt, Saskatchewan, Canada
S0K 2A0

www.alumi-tech.com



PLEASE RETURN WARRANTY CARD WITHIN 10 DAYS OF PURCHASE DATE.

Purchase Date: _____
Purchased From: _____
Model No.: _____
Serial No.: _____

Customer Installed Dealer Installed

Customer Name: _____
Address: _____

Phone No.: _____
Signature: _____

ASSEMBLY

TOOLS REQUIRED

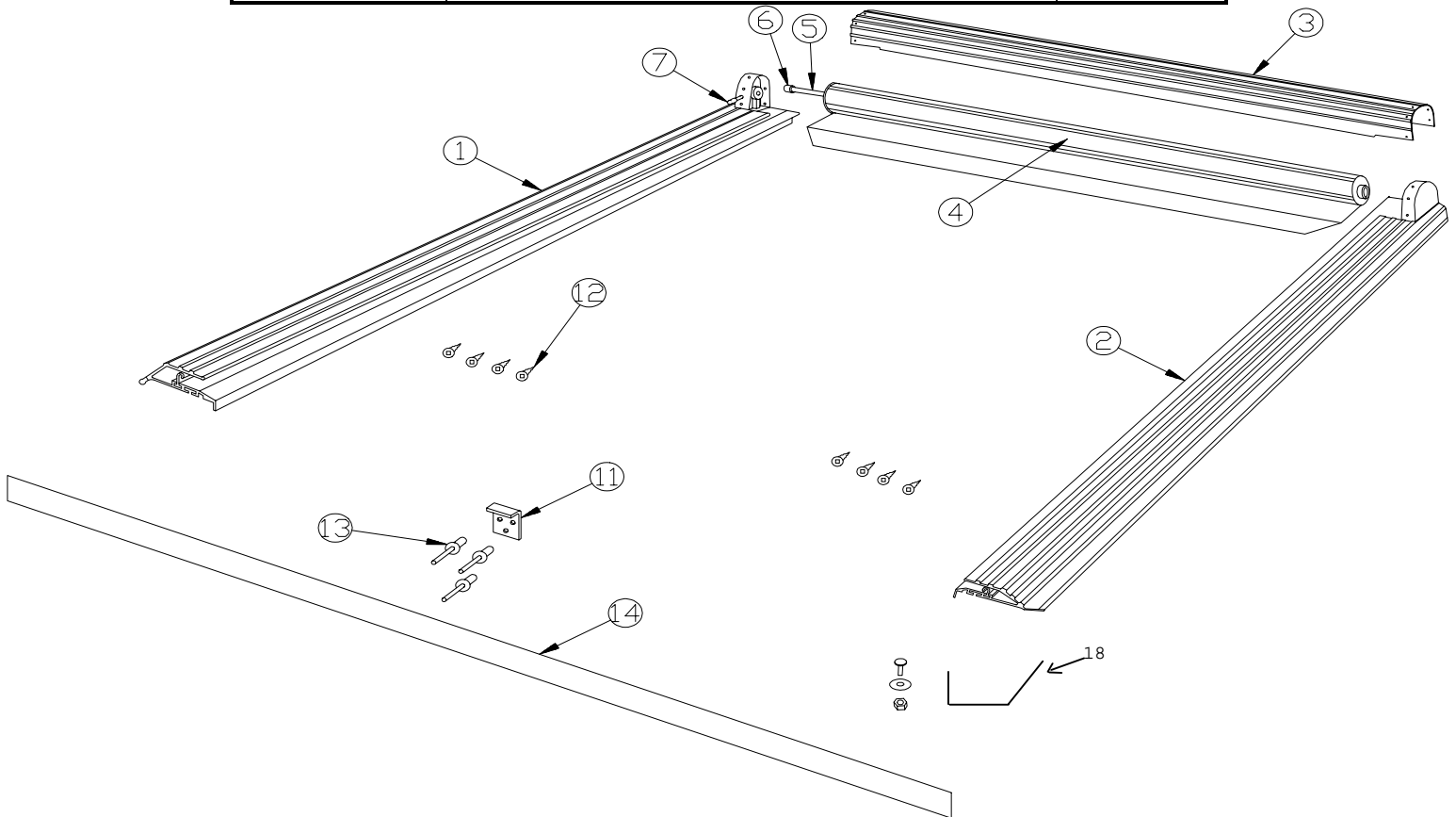
- TAPE MEASURE
- POWER DRILL
- 3/16" DRILL BIT

1/2" SOCKET AND SOCKET WRENCH
 #8 ROBERTSON SCREWDRIVER
 POP RIVETER
 VISE GRIP
 SILICONE SPRAY

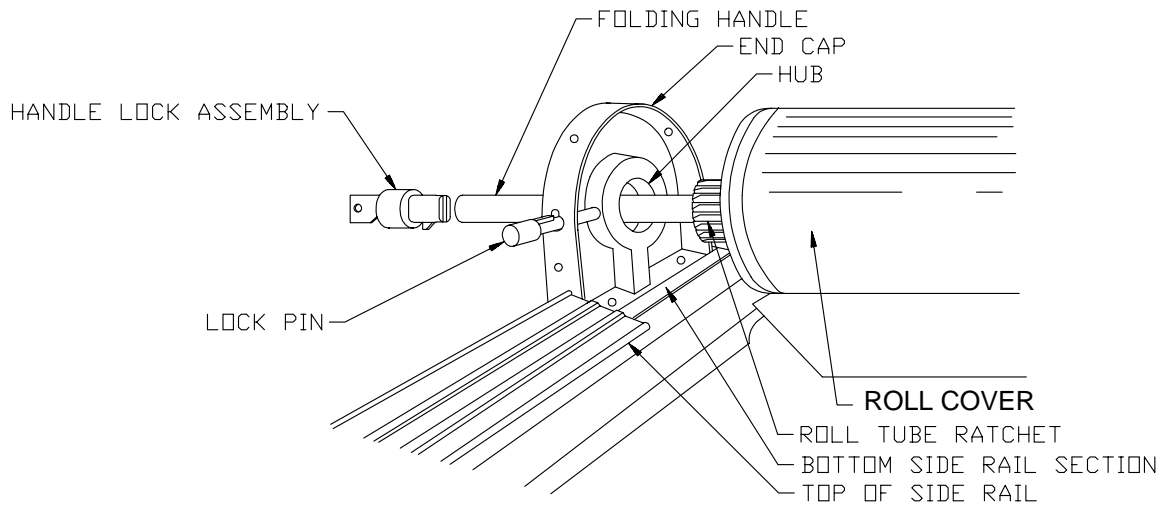
NOTE: A LEVEL SURFACE (EG. TWO WORKBENCHES PUSHED TOGETHER) IS REQUIRED TO FACILITATE EASY ASSEMBLY.

PARTS LIST

ITEM NUMBER	DESCRIPTION	# REQUIRED
1	DRIVER'S SIDE RAIL ASSEMBLY	1
2	PASSENGER'S SIDE RAIL ASSEMBLY	1
3	COVER HOOD	1
4	ROLL COVER	1
5	FOLDING HANDLE ASSEMBLY	1
6	HANDLE LOCK ASSEMBLY	1
7	LOCK PIN	1
11	TAIL GATE SECURITY CLIP (not incl. with Ford)	1
12	#8 SCREW	8
13	3/16 INCH POP RIVET (not incl. with Ford)	3
15	2- S Hooks And Pull Cord(not shown)	1
16	3/8" X 2" Foam Tape (for front of box)not shown	66"
18	Clamps with bolts to anchor cover	4 or 6

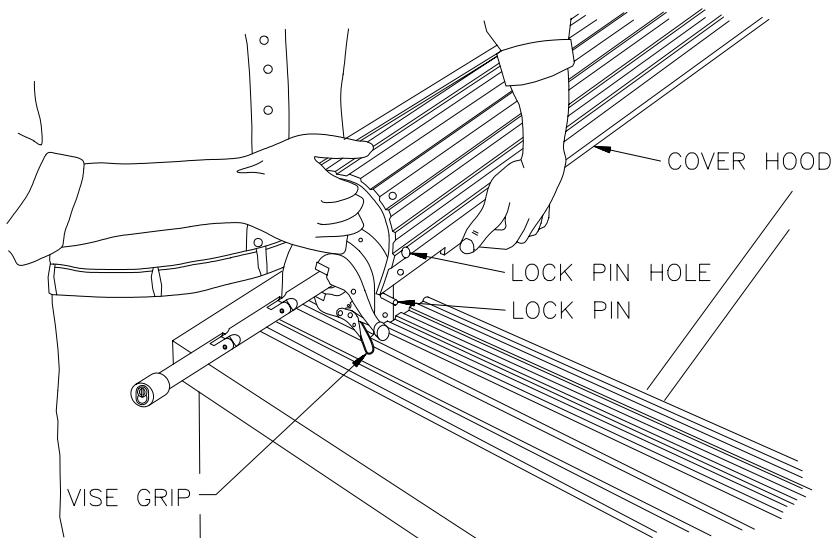


STEP 1 INSTALLATION OF ROLL COVER INTO RAIL SECTIONS

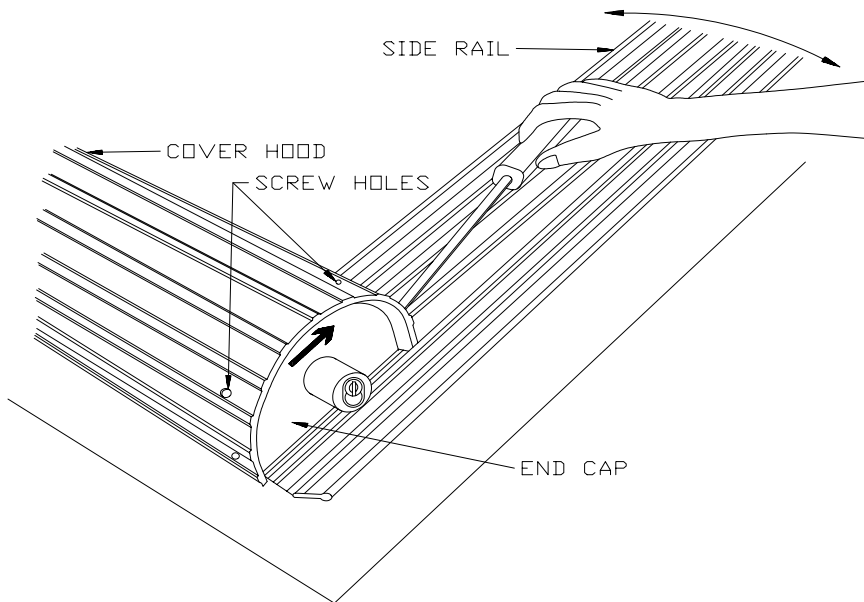


- REMOVE THE FOLDING HANDLE LOCK. MAKE SURE THAT THE HANDLE DOES NOT SLIDE INTO THE ROLL TUBE PAST THE ROLL TUBE RATCHET.
- DISENGAGE THE LOCK PIN BY PULLING IT OUT AND TURNING IT ONE QUARTER TURN.
- SPRAY THE INSIDE OF BOTH SIDE RAILS AND HUBS WITH SILICONE SPRAY.
- INSERT THE ROLL TUBE, DRIVER'S SIDE FIRST, INTO THE END CAP SO THAT THE ROLL TUBE COLLAR IS FIRMLY SEATED IN THE END CAP. PULL HANDLE OUT ALL THE WAY AND CLAMP A VISE GRIP ON THE HANDLE TO PREVENT ROLL TUBE FROM SLIPPING OUT OF HUB.
- INSERT THE ROLL TUBE INTO THE PASSENGER'S SIDE END CAP.
- INSTALL THE HANDLE LOCK.
- GUIDE THE FREE END OF THE ROLL COVER BETWEEN THE TOP AND BOTTOM OF THE SIDE RAILS SO THAT THE **TONNEAU MATERIAL IS ON TOP OF THE RAIL INSERT** (fig. B above). PULL APPROXIMATELY 1 FOOT OF TONNEAU FROM THE ROLL. **ENSURE TONNEAU MATERIAL IS NOT FOLDED OVER. THIS WILL PREVENT BINDING.**

STEP 2 INSTALLATION OF THE ROLL COVER HOOD



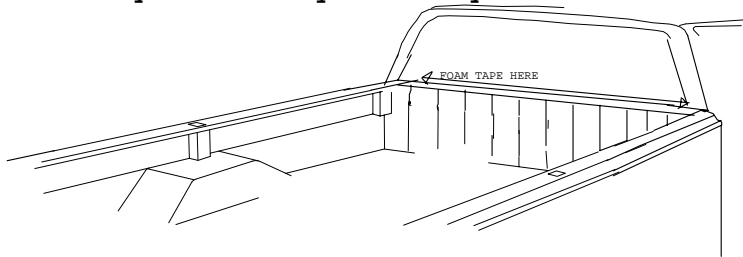
- FIT THE COVER HOOD SUCH THAT THE LOCK PIN IS GUIDED THROUGH THE LOCK PIN HOLE.



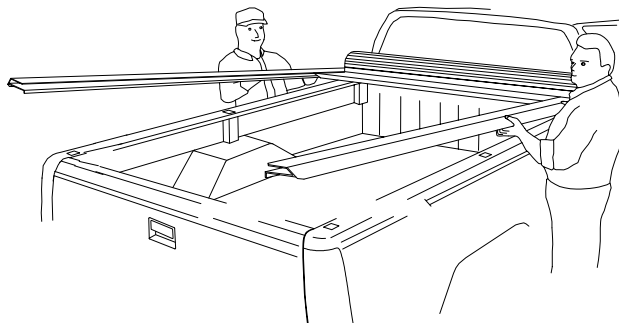
- INSTALL THE BOTTOM FRONT SCREWS (#8 ROBERTSON) THROUGH THE COVER HOOD INTO THE RESPECTIVE END CAPS. (DO NOT TIGHTEN SCREWS UNTIL ALL HAVE BEEN LOOSELY FITTED)
- INSTALL THE REMAINDER OF THE COVER HOOD SCREWS. HOLES ARE EASILY ALIGNED BY MOVING THE SIDE RAIL AS SHOWN.

STEP 3 APPLYING FOAM TAPE TO TRUCK

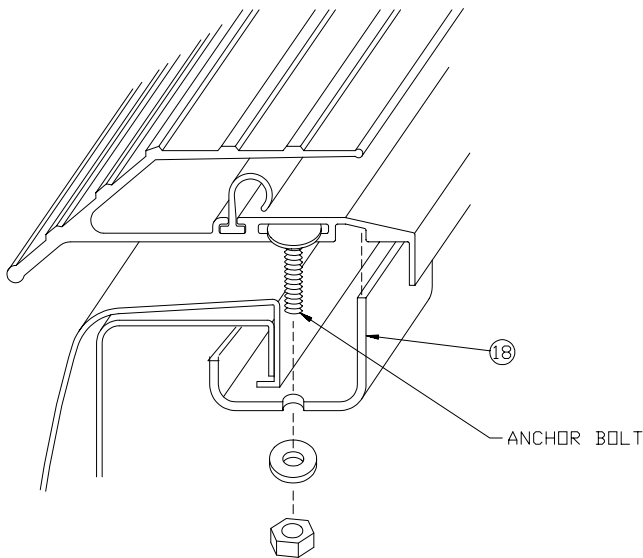
THE 3/8" x 2" STRIP OF FOAM TAPE IS APPLIED TO THE TOP FRONT OF THE TRUCK BOX. TAPE IS APPLIED ONLY IN AREA INDICATED BELOW. (Additional strip (1/4" X 1 1/2") is required for Fords only. This is applied on top of the 3/8" X 2" . It may not be required if you have a box liner.)



STEP 4 MOUNTING THE ALUMI-TECH COVER TO THE TRUCK BOX



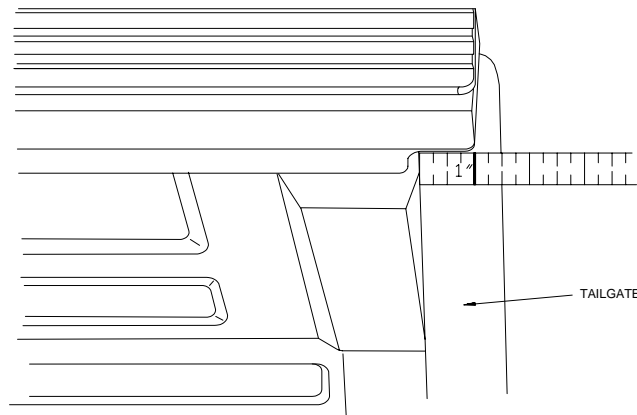
- PLACE THE SIDE RAILS ON TOP OF THE TRUCK.
- INSTALL THE ANCHOR BOLT GUIDING THE BOLT INTO THE CLAMP AND LOOSELY ASSEMBLE A WASHER AND NUT TO BOLT. ENSURE THAT CLAMP IS SEATED PROPERLY IN GROOVE UNDER RAIL AS SHOWN IN DRAWING BELOW.



IMPORTANT!

- CENTRE RAILS ON TOP OF THE TRUCK BED, MEASURING BOTH SIDES FOR EQUAL DISTANCES. AT THE SAME TIME POSITION THE END OF THE RAIL (**SEE CHART ON PAGE 6 FOR THIS MEASUREMENT***) FROM THE INSIDE OF THE TAILGATE (**SEE DRAWING BELOW**).

***This measurement assures that the ends of the rails line up with your security clip.**



**Note Drawing:
(SEE CHART ON PG. 6 FOR CORRECT MEASUREMENTS)**

- DUE TO MOST MODELS BEING TAPERED AND ALSO TO FOLLOW THE EXTERIOR CONTOUR OF THE TRUCK, THE WIDTH BETWEEN RAILS ON SOME MODELS WILL DIFFER FROM FRONT TO REAR. ONCE THE COVER IS ATTACHED TO THE TOP OF THE TRUCK BED WITH THE CLAMPS, MEASURE THE DISTANCE (WIDTH) BETWEEN THE FRONT AND REAR, THE DIFFERENCE IS LISTED IN THE CHART ON PAGE 6.

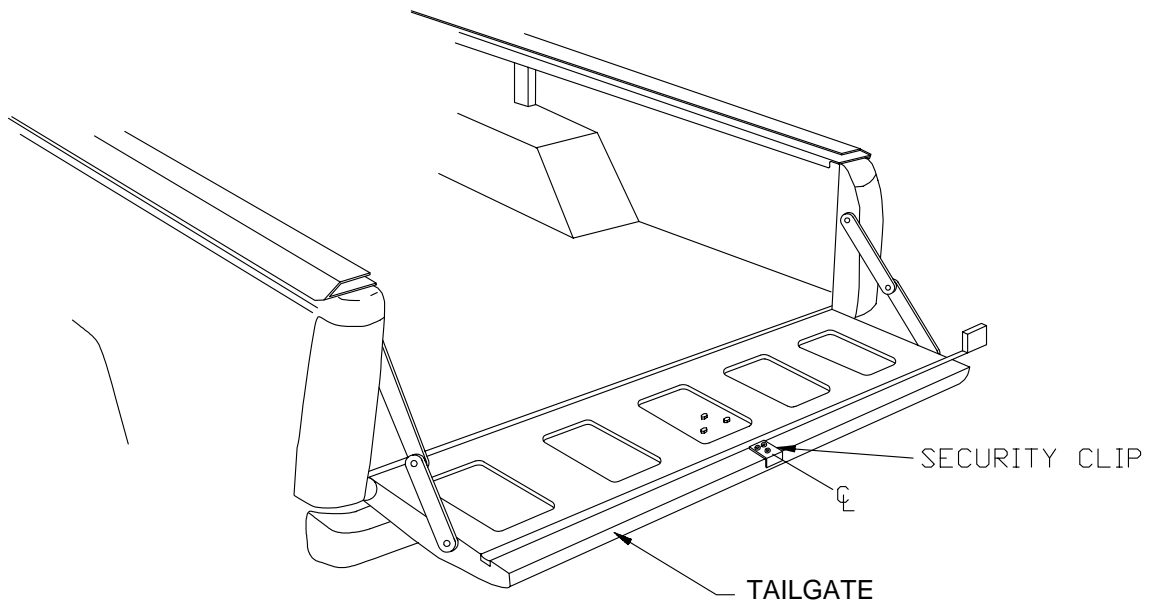
**MEASUREMENTS LISTED BELOW IN THE DIFFERENCE COLUMN ARE APPROXIMATE,
AND MAY BE A LITTLE MORE OR LESS THAN STATED.**

Truck Make	Year	Description	Model #	Difference between rails from front to rear (width)	Rail past inside of tailgate measurement (SEE PG. 5)
	1988-2005	Full - Size Long Bed	66 - 78 - 99	2 inches	1 ½ inches
C	1988-2005	Full Size Short Bed	66 - 78 - 80	2 inches	1 ½ inches
H	2004-2005	1500 Crew Cab Extra Short Bed	66-18-70-12	2 inches	1 ½ inches
E	2004-2005	Canyon/Colorado Ext. Cab Short Bed	58-00-75	equal distance	2 inches
V	2004-2005	Canyon/Colorado Crew Cab Short Bed	58-00-63	equal distance	2 inches
/	1994-2005	S10/S15 Long Bed	59 - 34 - 90 - 12	1 3/4 inches	1 ½ inches
GMC	1994-2005	S10/S15 Short Bed	59 - 34 - 75	1 3/4 inches	1 ½ inches
	1982-1993	S10/S15 Long Bed	57 - 34 - 90 - 12	equal distance	1 ½ inches
	1982-1993	S10/S15 Short Bed	57 - 34 - 75	equal distance	1 ½ inches
	2002 - 2005	Ram 1500/2500 (2003) Quad Cab Long Bed	66-18-99	2 1/2 inches	2 inches
	2002 - 2005	Ram 1500/2500 (2003) Quad Cab Short Bed	66-18-78	2 1/2 inches	2 inches
D	1994-2001	Full-Size Long Bed (incl.2002,2500 series)	68 - 38 - 99	2 inches	1 inch
O	1994-2001	Full-Size Short Bed (incl.2002,2500 series)	68 - 38 - 79 - 14	2 inches	1 inch
D	2000 -2005	Dakota Quad Cab Short Bed	60 - 38 - 66 - 12	equal distance	2 inches
G	1997-2005	Dakota Long Bed	60 - 38 - 99	equal distance	2 inches
E	1997-2005	Dakota Short Bed	60 - 38 - 80	equal distance	2 inches
	1987-1996	Dakota Long Bed*spec. light(L)	60 - 38 - 98 (L)	equal distance	1 ½ inches
	1987-1996	Dakota Short Bed*spec. light(L)	60 - 38 - 79 - 14(L)	equal distance	1 ½ inches
	2004-2005	F150 Styleside Long Bed	65 - 38 - 98 (SQ)	equal distance	1 ½ inches
	2004-2005	F150 Styleside Short Bed	65 - 38 - 80	equal distance	1 ½ inches
	2004-2005	F150 Styleside Crew Cab Short Bed	65 - 38 - 68	equal distance	1 ½ inches
	1997-2003	Full-Size Long Bed (New Body)	65 - 38 - 98 (TP)	1 inch	1 ½ inches
F	1997-2003	Full-Size Short Bed (New Body)	65 - 38 - 79 - 14	1 inch	1 ½ inches
O	2001 -2003	F150 Super Crew Cab Short Bed	60 - 78 - 67 - 12	2 ½ inches	1 ½ inches
R	1999 - 2005	Super Duty 250/350 Long Bed	67 - 78 - 99	1 3/4 inch	1 ½ inches
D	1999 - 2005	Super Duty 250/350 Short Bed	67 - 78 - 83	1 3/4 inch	1 ½ inches
	1980-1996	Full-Size Long Bed (Old Body)	67 - 38 - 99	equal distance	1 ½ inches
	1980-1996	Full-Size Short Bed (Old Body)	67 - 38 - 83	equal distance	1 ½ inches
	1993-2005	Ranger Long Bed	56 - 78 - 85 - 12	equal distance	1 ½ inches
	1993-2005	Ranger Short Bed	56 - 78 - 74	equal distance	1 ½ inches
	1999 - 2003	Ranger Step Side	48 - 38 - 74	equal distance	1 ½ inches
	1999 -2003	Ranger Splash	48 - 12 - 73 - 12	equal distance	1 ½ inches
MAZDA	1999 - 2003	Mazda Short Bed	56 - 78 - 74	equal distance	1 ½ inches
TOYOTA	2000 - 2003	Toyota Tundra Short Bed	64 - 38 - 77	equal distance	1 ½ inches
	2000 - 2003	Toyota Tundra Long Bed	64 - 38 - 99	equal distance	1 ½ inches
	2004-2005	Toyota Tundra Double Cab (4 Door) Short Bed	63 - 78 - 77	equal distance	1½ inches
	2004-2005	Toyota Tacoma 4 Door Short Bed	*57 - 38 - 62	equal distance	1 inch
	2004-2005	Toyota Tacoma Xtra Cab (2 door) Long Bed	*57 - 38 - 75-12	equal distance	1 inch
NISSAN	2000-2003	Nissan Frontier (4 Door) Long Bed	57-38-75-12	equal distance	1 ½ inches
	2000-2003	Nissan Frontier (4 door) Short Bed	57-38-56-34	equal distance	1 ½ inches
	2004 -2005	Nissan Titan Crew Cab Short Bed	62-78-68	equal distance	1 ½ inches
OTHERS					

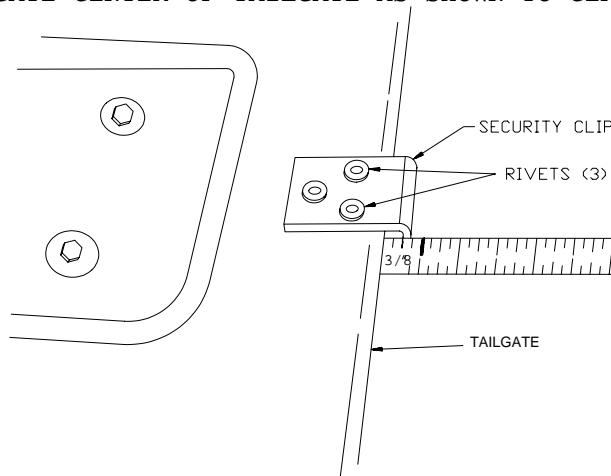
* These models are mounted with angles that are attached to the inside of the box. See additional instructions.

- TIGHTEN ALL REMAINING NUTS. **NOTE: DO NOT OVER TIGHTEN !**

STEP 5 INSTALLATION OF TAILGATE SECURITY CLIP (if no lock in your tailgate)



- LOCATE CENTER OF TAILGATE AS SHOWN TO CENTER SECURITY CLIP ON TAILGATE.



- ENSURE WHEN INSTALLING THE SECURITY CLIP THAT A GAP OF 3/8 INCH IS MAINTAINED BETWEEN THE INSIDE OF THE SECURITY CLIP AND THE TOP OF THE TAILGATE.
- LOCATE AND CENTER PUNCH THE CENTER OF THE RIVET HOLES OF THE SECURITY CLIP AND THEN DRILL TO A 3/16 INCH DIAMETER.
- INSTALL SECURITY CLIP USING 3/16 INCH POP RIVETS PROVIDED.

IMPORTANT - Before tightening up the cover, make sure that the roll cover clip is locked into each RED side rail slot (and the security clip if you wish to have tailgate locked).

ASSEMBLY IS COMPLETE

Please see operation and maintenance.

NOTICE

FAILURE TO FOLLOW THE ENCLOSED INSTALLATION INSTRUCTIONS, INCLUDING OPERATING AND MAINTENANCE INSTRUCTIONS OR SEND IN THE WARRANTY CARD WILL VOID ALL WARRANTY.

WARRANTY

TREK INDUSTRIES (HUMBOLDT) WARRANTS OUR PRODUCTS FOR A PERIOD OF ONE YEAR FROM DATE OF PURCHASE.

ANY PARTS RETURNED TO TREK INDUSTRIES (HUMBOLDT) SHALL BE SHIPPED PREPAID, AND WILL BE RETURNED F.O.B. HUMBOLDT, SASKATCHEWAN, CANADA.

WE WILL NOT ASSUME RESPONSIBILITY FOR SHIPPING, LABOR, OR TRAVEL EXPENSES.

PLEASE NOTE: WE RESERVE THE RIGHT TO MAKE IMPROVEMENTS, THEREFORE SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE.