Assembly of Deluxe and Ultimate Trays supplied as flat packs

This instruction is for assembling the Bocar Deluxe and Ultimate Ute trays supplied as flat packs. In general, the assembling trays is very easy for a handyman as the majority of parts are already assembled and only the headboard need to be bolted to the tray deck.

Bocar Ute flat packs are supplied in a secured pack properly tied or shrink wrapped with individual sub assemblies bubble wrapped. Up on receipt, unpack and check for any transit damage. If the pack is transported interstate or country areas, some minor scratching may have occurred during transit but this does not affect the functionality of the Tray body.

1. Separate individual sub assemblies. Put away the dropsides and tailgate as you need them only at the end (after installation of the tray on the vehicle).
2. Open the plastic bag containing nuts & bolts and parts needed for the assembly. This bag also contains a “Part Description” sheet that lists fasteners included and a basic assembly sketch (see below). Review this sheet to get an overall idea of parts required and “how to assemble” the Bocar Ute Tray.

3. Place the tray deck on a table or support stands ready for assembling. Sit the headboard subassembly on cabin end of the tray deck, drill 6mm holes on both sides and secure it to the deck by 6mm bolts (as shown below).
4. Mark and cut the meshed headboard tube legs (ends) to desired height. File the tube cut ends to smooth surface for easy sliding. The headboard tube slides into the headboard assembly corners. The total height (above the deck) depends on the vehicle type and the tube top surface should be minimum of 2” (50mm) above the cabin level.

5. Slide the tube into the headboard corners until the tube ends reaches all the way down to deck level and or to required total height. In some cases, light force may be required to push the tube into the corners. Use Rubber mallet and hammer on top of each side of the tube (preferably with a wood barrier to protect the tube). Note the mesh should be facing outside, i.e, towards the cabin.
6. Now the headboard is to be attached to the tray deck. For this, 8mm holes are predrilled in the headboard corners and deck side coaming, but they may or may not fully align due to manufacturing tolerance. Just run a 8mm drill through the aligned assembly (as shown below) so that it is easier to insert the 8mm bolts.
7. Using 8mm bolts and nuts supplied, attach headboard corners to tray deck. Just before tightening make sure the headboard is vertical (90 degrees) using a set square. Washers are not mandatory with 8mm bolts, but if they are supplied included in the pack use them.

7. Now secure the headboard tube which is sitting into the headboard corners. Drill 5mm pilot holes into headboard tube at predrilled holes of the corner section (shown below).
8. Using 6mm taptites (self tapping screws) supplied, screw the headboard tube to the headboard corners.

9. The rope rail is to be secured to the head board Corner. Drill 6mm hole right through the headboard corner and rope rail. Use 6mmx50mm roofing bolt and nut supplied to secure it. Alternatively you can rivet using the rivet supplied. Note for some dual cab vehicles the fuel filler comes between the headboard corner and the first rope rail bracket and you may have to cut the rope rail to accommodate this. In such cases you don’t have to attach the rope rail to the corners as this portion of the rope rail will be cut off anyway.
Drill 6mm hole right through the rope rail and then secure it with 6mm roofing bolt and nut supplied. Alternatively you can rivet it, rivet supplied.
10. Use the inner verticals supplied to attach the headboard tube, headboard plank, tray deck and tray main runners as shown below. First mark and cut the inner verticals to the required height. Their length should be long enough to connect from the bottom of the runners (C sections) to just below the top of the headbord tube. Drill and attach the angles using 6mm bolts and 6mm taptite as shown below.

11. Attach the load holding flippers using 10mm bolts and nylock nuts supplied. You can unwrap the dropsides and simply matter of sliding the them into the hinge pins of the tray deck to complete the installation. That completes the assembly of tray which is now ready for installation on the vehicle. However, it is advisable to delay putting the drop sides until the tray is fully installed on the vehicle.