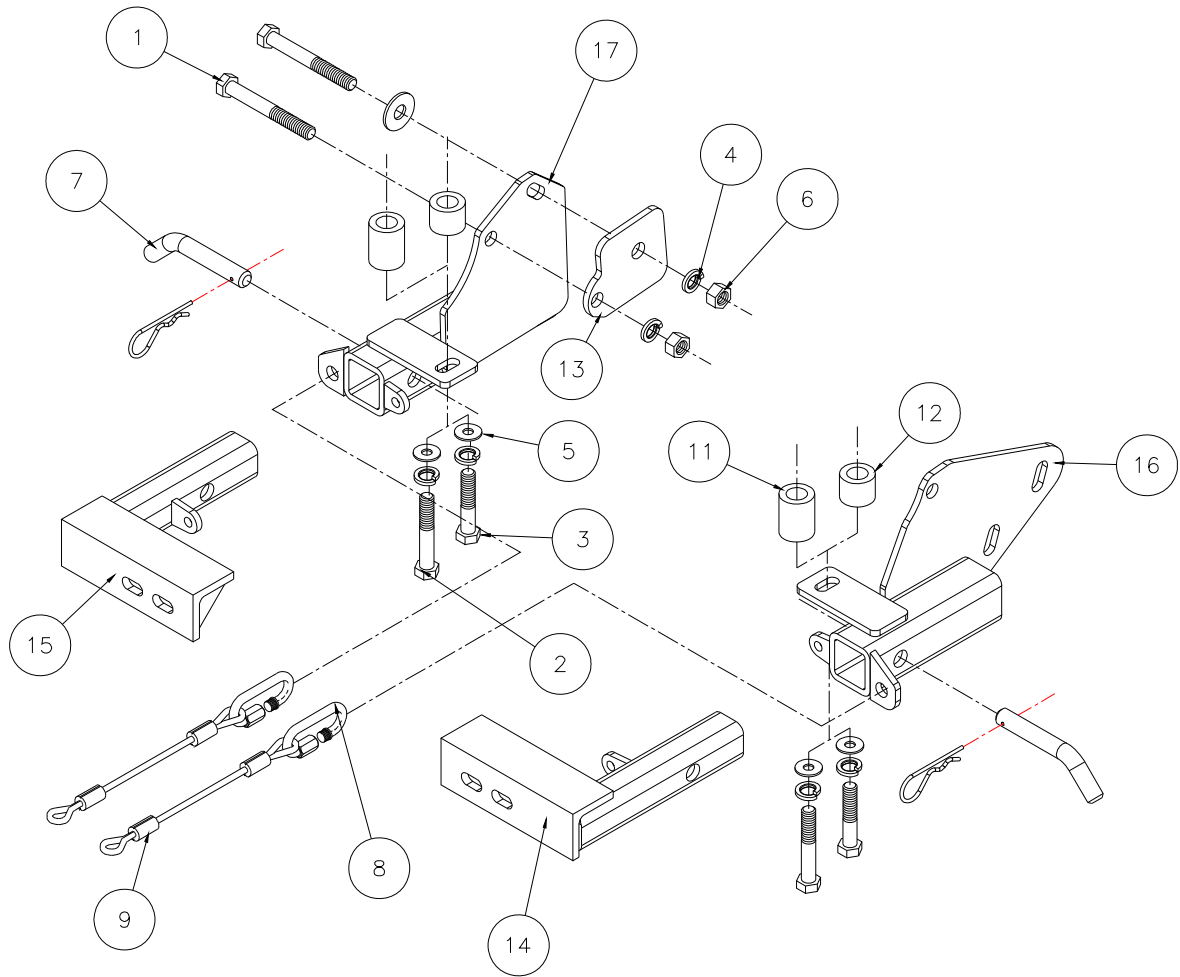




MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

KIT# 1424-1
02/25/09
KS

ROADMASTER, Inc. 6110 NE 127th Ave. Vancouver, WA 98682 1-800-669-9690 fax 360-735-9300 www.roadmasterinc.com



ITEM	QTY	NAME	MATERIAL
1	2	1/2" x 4" BOLT	350105-00
2	2	1/2" x 3" BOLT	350101-00
3	2	1/2" x 2 1/2" BOLT	350099-00
4	4	1/2" LOCK WASHER	350309-00
5	3	1/2" FLAT WASHER	350308-00
6	2	1/2" HEX NUT	350258-00
7	2	DRAW PIN W/ CLIP	357035-00
8	2	QUICK LINK	200008-00
9	2	SAFETY CABLES	650646-10
10	1	LOCTITE #262 .5ml TUBE	200544-00
11	2	1 1/4" O.D. x 1 5/8" TUBE	A-001067
12	2	1 1/4" O.D. x 1" TUBE	A-000945
13	1	BACKING PLATE	A-000583
14	1	DRIVER SIDE ARM WELDMENT	C-000478
15	1	PASSENGER SIDE ARM WELDMENT	C-000479
16	1	DRIVER SIDE RECEIVER BRACE WELDMENT	C-000451
17	1	PASSENGER SIDE RECEIVER BRACE WELDMENT	C-000452



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This bracket kit is one of our XL series, which is designed to be partly removable (Fig.A and Fig.B). The kit consists of two main receiver braces, two front braces and a hardware pack. The main receiver braces mount below the front bumper fascia to the front frame tubes. The front braces insert into the receiver brace on each side.

Start by laying the kit out according to the illustration. This will give you a visual idea of how the kit installs and also confirm that the kit components are present and accounted for.



IMPORTANT: All brackets **must** be assembled with all the bolts left loose for final adjustment and positioning (before tightening) unless otherwise instructed. All bolts **must** be torqued for proper strength. If more than one bolt is used per fastening point, the diagram may only show one.

- Use flat washers over all slotted holes
- Use lock washers on all fasteners

ROADMASTER Limited Warranty, including One-Year Conditional Warranty Text and Product Registration Card, in Carton.

WARNING

- Do not use this document for custom fabrication, as it may not show all parts or structural components. Custom fabrication or an attempt to copy this bracket design could result in loss of the towed vehicle.
- The owner must inspect all mounts and brackets before each use for cracks or other signs of fatigue. Also, inspect the fasteners for proper torque, according to the bolt torque requirements chart on the last page. Failure to do so could result in loss of the towed vehicle.
- The owner must check the manufacturer's instructions for the proper procedure(s) to prepare the vehicle for towing. Some vehicles must be equipped with a transmission lube pump, an axle disconnect, driveline disconnect or free-wheeling hubs before they can be towed. Failure to properly equip the vehicle will cause severe damage to the transmission.
- The installer must read the instructions and use all bolts and parts supplied. Failure to securely fasten the bracket could result in loss of the towed vehicle.
- If running changes were made by the vehicle manufacturer after this bracket was designed, some bolts or other fasteners in the included hardware pack may no longer be the correct size. It is the installer's responsibility to verify that the bracket is securely fastened to the vehicle, and fitted with the correct hardware, to account for these changes. Failure to securely fasten the bracket could result in loss of the towed vehicle.
- If the towed vehicle has been in an accident, it must be properly repaired before attaching the bracket. Do not install the bracket if any structural frame damage is found. Failure to repair the damage may result in the loss of the towed vehicle.
- Some motorhome chassis have such a tight turning radius that you can damage your motorhome, towed vehicle, tow bar or bracket while turning sharply. Before getting on the road, test your turning radius in an empty parking lot. Turning too sharply could result in non-warranty damage to towing system, motorhome and/or towed vehicle.
- Do not back up with the towed vehicle attached or non-warranty damage will occur to your towing system, motorhome and/or towed vehicle.
- The safety cables must connect the towing vehicle to the towed vehicle frame to frame, with the cables crossed, with enough slack for sharp turns. Refer to the cable instructions for proper routing. Failure to leave enough slack in the safety cables, or failure to connect the safety cables frame to frame, will result in the loss of the towed vehicle.
- This bracket is designed for use with ROADMASTER tow bars and ROADMASTER adaptors only. Using this bracket with other brands, without an approved ROADMASTER adaptor, may result in non-warranty damage or injury.
- Upon final installation, the installer must inspect the bracket to ensure adequate clearance, particularly around hoses, air conditioner lines, radiators, etc., or non-warranty damage to the towed vehicle will result.
- This bracket is only warranted for the original installation. Installing a used bracket on another vehicle is not recommended and will void the warranty.

WARNING

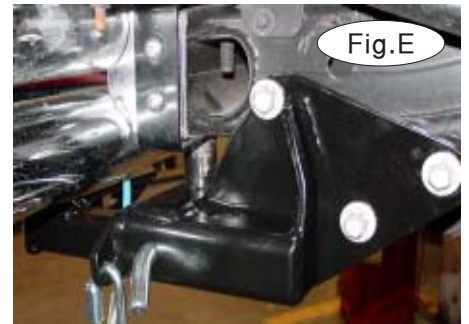
Failure to follow these instructions can result in property damage, personal injury or even death.



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1. Starting with the driver's side, remove lower #55 Torx head bolt from the bottom of the bumper (Fig.C).
2. Remove the lower rear steering box bolt (Fig.D). Bolt through the rear mounting hole on the driver's side receiver brace with the steering box bolt. Tighten to hold in place (Fig.E). *Note:* use Loctite 262 on the steering box bolt when reinstalling.
3. Now, remove the top steering bolts.
4. Push brace up into position, bolt through the two remaining steering box holes with the original bolts. Leave all three steering box bolts loose until the front bolt is in place. *Note:* use Loctite 262 on the steering box bolts when reinstalling (Fig.F).
5. This kit includes two sizes of spacers (1" and 1-5/8") and bolts (1/2" x 2 1/2" or 3") to clear the different styles of front bumpers available (Fig.F,G). Check the spacing below the bumper and use the appropriate spacer, 1/2" bolt, lock washer and flat washer to replace the Torx bolt removed in step 2.
6. Move to the passenger side and remove the passenger side bumper #55 Torx bolt (Fig.F).
7. Bolt through the lower receiver side mounting hole and frame hole. Fit the backing plate with a 1/2" x 4" bolt, lock washer, and nut (Fig.G).
8. Push brace up to bottom of bumper and bolt through mounting tab with the same bolt and spacer used on the driver's side. Tighten to hold in position (Fig.H).
9. Using the receiver brace's top side mounting hole as a drilling template, drill a hole through the frame into the inner backing plate with a 1/2" drill bit.
10. Bolt through with a 1/2" x 4" bolt, lock washer, and nut.
11. Install the front braces and pin with 5/8" draw pins and 1/8" spring pins.
12. Torque all mounting bolts to the specifications at the end of these instructions. Install the tow bar according to the manufacturer's instructions.
13. Attach one end of the included 10" safety cables to the front hole in the side mounting plate on each side of the receiver brace with the included cable connectors. Connect the other end to the tow vehicle's safety cables and tow bar.





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BOLT TORQUE REQUIREMENTS

Note: The torque values represented below are intended as general guidelines. Torque requirements for specific applications may vary. Roadmaster does not warrant this information to be accurate for all applications and disclaims all liability for any claims or damages which may result from its use.

STANDARD BOLTS

Thread Size	Grade	Torque
5/16	5	13 ft./lb.
3/8	5	23 ft./lb.
7/16	5	37 ft./lb.
1/2	5	56 ft./lb.
5/8	5	150 ft./lb.

METRIC BOLTS

Thread Size	Grade	Plated/Unplated
8mm-1.0	8.8	20 ft./lb. 18 ft./lb.
8mm-1.25	8.8	19 ft./lb. 18 ft./lb.
10mm-1.25	8.8	38 ft./lb. 36 ft./lb.
10mm-1.5	8.8	37 ft./lb. 35 ft./lb.

METRIC BOLTS

Thread Size	Grade	Plated/Unplated
12mm-1.25	8.8	70 ft./lb. 65 ft./lb.
12mm-1.5	8.8	66 ft./lb. 61 ft./lb.
12mm-1.75	8.8	65 ft./lb. 60 ft./lb.
14mm-2.0	8.8	104 ft./lb. 97 ft./lb.