



# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

ROADMASTER, INC.

5602 N.E. SKYPORT WAY

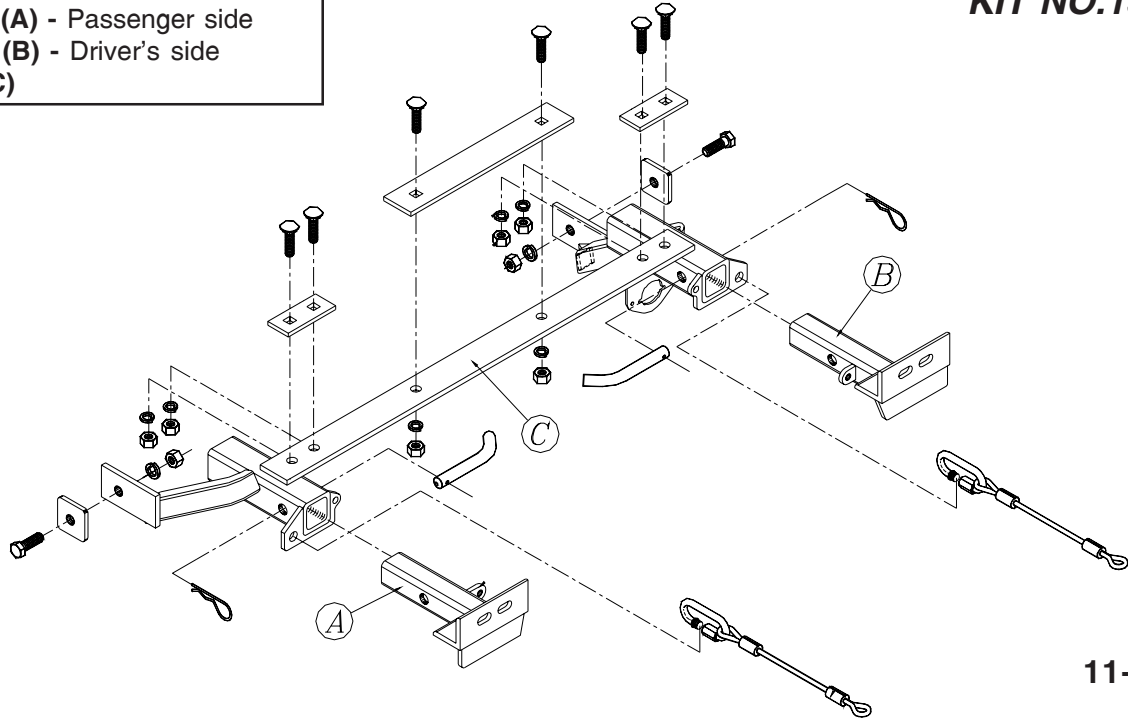
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**PARTS LIST:**

- 1- FRONT BRACE (A) - Passenger side
- 1- FRONT BRACE (B) - Driver's side
- 1- MAIN BRACE (C)

**KIT NO.1527-1****11-7-01**

**IMPORTANT:** All brackets **must** be assembled with all the bolts left loose for final adjustment & 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.
- ROADMASTER will not be responsible for any damage or injury resulting from any modification or alteration.
- 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 torque chart.
- 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.
- If the towed vehicle has been in an accident, it must be properly repaired before attaching the brackets. Do not install the brackets if any structural frame damage is found. Failure to repair the damage may result in loss of your towed vehicle.
- Some motorhome chassis have such a tight turning radius that you can damage your motorhome, towed vehicle or tow bar while turn-

ing sharply. Before getting on the road, test your turning radius in an empty parking lot. Damage that results from turning too sharply is not covered by warranty.

- The driver must not back up the motorhome with the towed vehicle attached or non-warranty damage will occur to your towing system or towed vehicle.
- The safety cables must connect the towing vehicle to the towed vehicle frame to frame, with the cables crossed. Refer to the cable instructions for proper routing.
- Make sure there is enough slack in the safety cables at the motorhome to allow for sharp turns.
- Use caution when handling the tow bar — if your hands, fingers or any part of your body are caught between moving components, they can be pinched, cut or otherwise injured.
- This bracket is designed for use with ROADMASTER tow bars and ROADMASTER adaptors. Using this bracket with other brands, without an approved ROADMASTER adaptor, may result in non-warranty damage or injury.
- Important! This bracket is only warranted for the original installation. Installing a used bracket on another vehicle is not recommended and will void the warranty.
- Upon final installation, the installer must inspect the bracket to ensure adequate clearance, particularly around hoses, AC lines, radiators, etc., or non-warranty damage will result.



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



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**KIT NO. 1527-1**

1. This is one of our XL Series which is designed to be partially removable. The front bumper skin will have to be removed to mount the receiver braces. This is accomplished by removing two 8mm bolts in the top corners on each side, five plastic pop fasteners on top of the bumper, four 10mm bolts on the bottom of the bumper and plastic fasteners holding the splash panels on each side. Once the fasteners are removed, pull the ends free then forward and off.
2. Hold the brace between the lower tie downs and under the steel bumper core.
3. Bolt through both tie down plates using 1/2" x 1 1/2" bolts, 1/4" x 2" x 2" backing plates, lock washers and nuts.
4. Align the receiver brace to the bottom of the steel bumper and tighten the bolts in the tie downs. This will hold the brace in position for the next step.
5. Notice that six holes are in the receiver brace under the bumper. Two outer holes should be close to lining up with existing holes in the bumper. If they are a little off, ream the holes with a 17/32" drill bit.
6. Using the same drill bit, drill four additional holes in the bottom of the bumper using the brace as a hole template.  
NOTE: This is high tensile steel and may require a smaller starter hole.
7. Insert 1/2" x 1 1/2" carriage bolts into the two outer 1/4" x 1 1/2" x 3 1/2" backing plates and the larger 1/4" x 2" x 12" center backing plate.
8. Insert the backing plates and bolts into the drilled holes from the back of the bumper and bolt through the receiver braces using 1/2" lock washers and nuts.
9. Torque all bolts to the specifications below.
10. If the wiring holder on the brace is to be utilized, now is the time to wire and install a receiver receptacle.
11. Trial fit the bumper skin and check where it will have to be trimmed to fit around the receivers. Trim to fit then reinstall, reversing the order in step one.
12. Insert the front braces into the receivers and pin using 5/8" draw pins and 1/8" spring pins.
13. Install the bar according to the manufacturers instructions, torque all bolts to the specifications below.
14. Install the included 10" safety cables on the receiver brace using the included cable connectors then connect the tow bar and the TOW BEHICLES safety cables.

### HARDWARE LIST

- |                                 |   |
|---------------------------------|---|
| 6-1/2" X 1 1/2" CARRIAGE BOLTS  | 2-1/4" X 1 1/2" X 3 1/2" SQ. HOLED BACKING PLATES |
| 2-1/2" X 1 1/2" BOLTS           | 1-1/4" X 2" X 12" SQ. HOLED BACKING PLATE         |
| 8-1/2" NUTS                     | 2-5/8" DRAW PINS                                  |
| 8-1/2" LOCK WASHERS             | 2-1/8" SPRING PINS                                |
| 2-1/4" X 2" X 2" BACKING PLATES | 2-CABLE CONNECTORS                                |
|                                 | 2-10" SAFETY CABLES                               |

**11-7-01**

**CAUTION:** Installer must read instructions and use all bolts and parts supplied.

FAILURE TO FOLLOW THESE INSTRUCTIONS CAN RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE

### 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			METRIC BOLTS			METRIC BOLTS		
Thread Size	Grade	Torque	Thread Size	Grade	Plated/Unplated	Thread Size	Grade	Plated/Unplated
5/16	5	13 ft./lb.	8mm-1.0	8.8	20 ft./lb. 18 ft./lb.	12mm-1.25	8.8	70 ft./lb. 65 ft./lb.
3/8	5	23 ft./lb.	8mm-1.25	8.8	19 ft./lb. 18 ft./lb.	12mm-1.5	8.8	66 ft./lb. 61 ft./lb.
7/16	5	37 ft./lb.	10mm-1.25	8.8	38 ft./lb. 36 ft./lb.	12mm-1.75	8.8	65 ft./lb. 60 ft./lb.
1/2	5	56 ft./lb.	10mm-1.5	8.8	37 ft./lb. 35 ft./lb.	14mm-2.0	8.8	104 ft./lb. 97 ft./lb.
5/8	5	150 ft./lb.						

All illustrations and specifications contained herein are based on the latest information available at the time of publication approval. ROADMASTER, INC. reserves the right to make changes at any time without notice in material, specification and models or to discontinue models.