



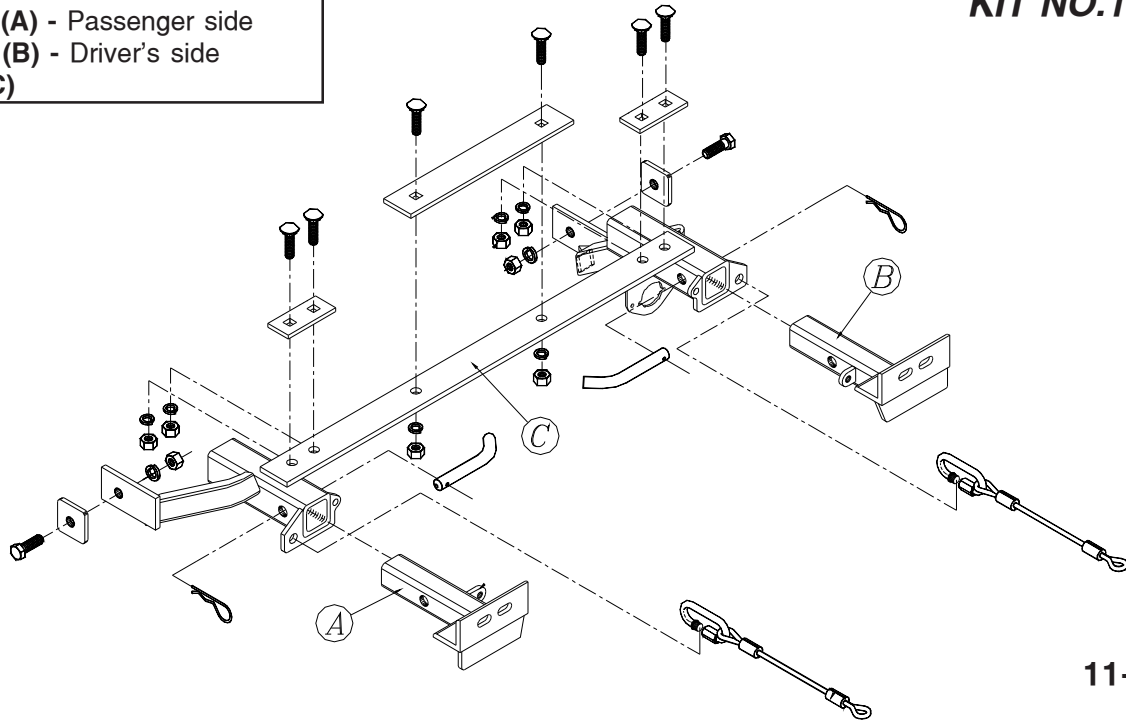
# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

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

## 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 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

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

- Installation of most mounting brackets requires moderate mechanical aptitude and skills. We strongly recommend professional installation by an experienced installer.
- The installer must read the instructions and use all bolts and parts supplied. Failure to do so could result in loss of the towed vehicle.
- Use Loctite® Red on all bolts used for mounting this bracket.
- 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.
- Every 3,000 miles, the owner must inspect the fasteners for proper torque, according to the bolt torque requirements chart on the last page of these instructions. The owner must also inspect all mounts and brackets for cracks or other signs of fatigue every 3,000 miles. Failure to do so could result in loss of the towed vehicle.
- The owner must check the vehicle 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.
- If running changes were made by the vehicle manufacturer after this bracket was designed, some bolts or other fasteners in the 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 could 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.



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## KIT NO. 1527-1

- Important:** please use all supplied bolts and parts and read all instructions carefully before beginning this installation. The majority of questions you may have can be answered within the text, and proper installation will ensure safe and secure travel. Now, begin the installation. 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.
- Hold the brace between the lower tie downs and under the steel bumper core.
- 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.
- 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.
- 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.
- 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.
- 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.
- 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.
- Torque all bolts to the specifications below.
- If the wiring holder on the brace is to be utilized, now is the time to wire and install a receiver receptacle.
- 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.
- Insert the front braces into the receivers and pin using 5/8" draw pins and 1/8" spring pins.
- Install the bar according to the manufacturer's instructions, torque all bolts to the specifications below.
- Install the included 10" safety cables on the receiver brace using the included cable connectors then connect the tow bar and the tow vehicle's safety cables.

### HARDWARE LIST

6-1/2" X 1 1/2" CARRIAGE BOLTS

2-1/2" X 1 1/2" BOLTS

8-1/2" NUTS

8-1/2" LOCK WASHERS

2-1/4" X 2" X 2" BACKING PLATES

2-1/4" X 1 1/2" X 3 1/2" SQ. HOLED BACKING PLATES

1-1/4" X 2" X 12" SQ. HOLED BACKING PLATE

2-5/8" DRAW PINS

2-1/8" SPRING PINS

2-CABLE CONNECTORS

2-10" SAFETY CABLES

11-7-01

### 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.