

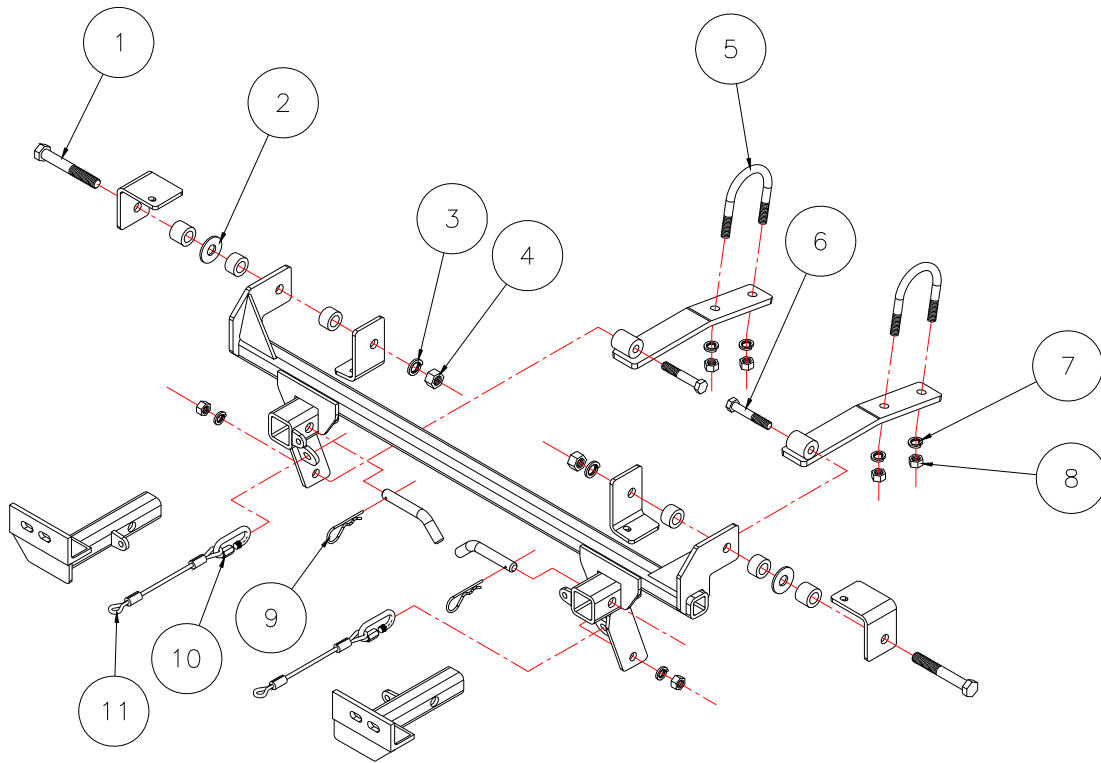


# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

**KIT# 1547-1**

10/29/03

ROADMASTER, Inc. 6110 N.E. 127th Ave. Vancouver, WA 98682 800-669-9690 Fax 360-735-9300 www.roadmasterinc.com



## Hardware List

Item	Qty.	Length	Width	Part	Part No.
1	2	4 1/2"	5/8"	BOLT	350159-00
2	2		5/8"	FLAT WASHER	350312-00
3	2		5/8"	LOCK WASHER	350313-00
4	2		5/8"	NUT	350262-00
5	2			1/2" x 3 1/4" O.C. x 3 7/8" U-BOLT	357302-00
6	2	3"	1/2"	BOLT	350101-00
7	6		1/2"	LOCK WASHER	350309-00
8	6		1/2"	NUT	350258-00
9	2			DRAW PIN / SPRING PIN	357035-00
10	2			CONNECTORS	200008-00
11	2	8"		8" SAFETY CABLES	357035-00

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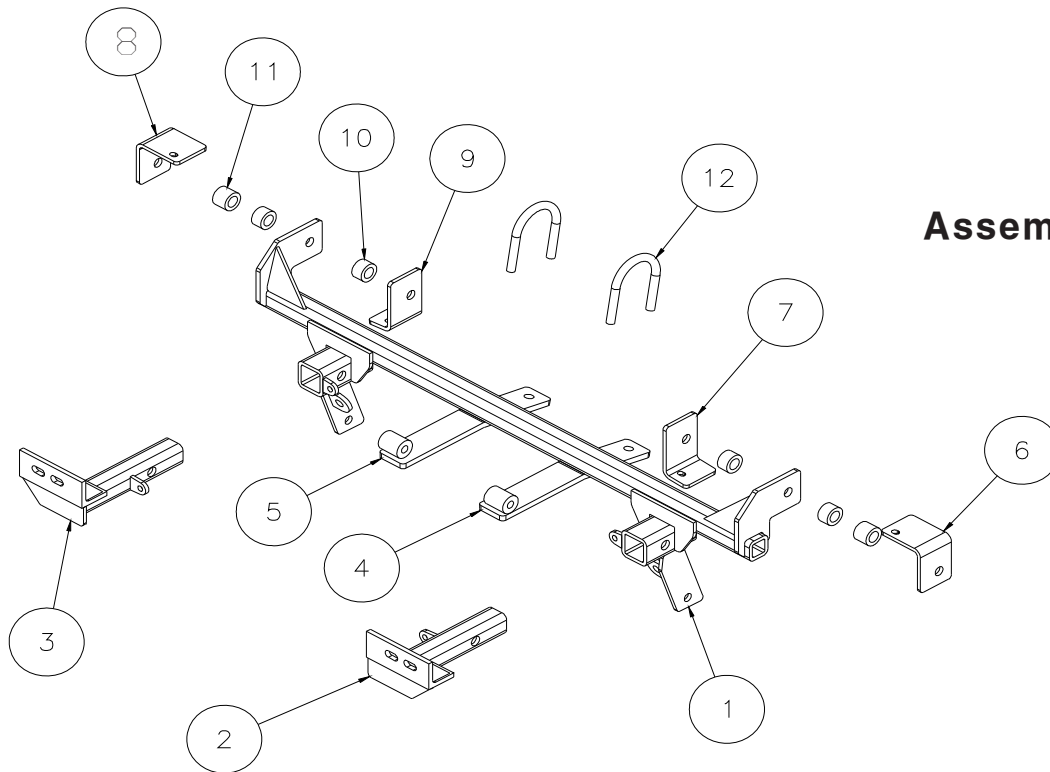


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## Assemblies

**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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## Assembly List

Item	Qty.	Name	Material
1 .....	1 .....	C-000539 .....	MAIN BRACE WELDMENT
2 .....	1 .....	C-000540 .....	DRIVER SIDE ARM WELDMENT
3 .....	1 .....	C-000541 .....	PASSENGER SIDE ARM WELDMENT
4 .....	1 .....	C-000542 .....	DRIVER SIDE REAR BRACE WELDMENT
5 .....	1 .....	C-000543 .....	PASSENGER SIDE REAR BRACE
6 .....	1 .....	B-000380 .....	DRIVER SIDE UPPER FRAME PLATE
7 .....	1 .....	B-000381 .....	DRIVER SIDE LOWER FRAME PLATE
8 .....	1 .....	B-000382 .....	PASSENGER SIDE UPPER FRAME PLATE
9 .....	1 .....	B-000383 .....	PASSENGER SIDE LOWER FRAME PLATE
10 .....	4 .....	A-000559 .....	3/4" SPACER TUBE
11 .....	2 .....	A-000943 .....	1" SPACER TUBE
12 .....	2 .....	357302-00 .....	U-BOLT

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R O A D M A S T E R, I N C.

1. This bracket kit is one of our XL series, (Fig.A) which is designed to be partly removable. The kit consists of the main receiver brace, two front arm braces, two lower braces and a hardware pack. The main receiver brace mounts behind the front bumper fascia to the inside of the frame. The lower braces attach to the front of the radiator support on each side. The front arm braces insert into the receivers 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 all the components are present and accounted for.

2. **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 Start by removing eight plastic fasteners in the top of the front bumper fascia (Fig.A).



3. Remove one phillips screw and top fastener in each fender well (Fig.B).



4. Remove the splash panel fasteners ( two phillips screws) and plastic fastener on the both sides and the bottom (Fig.C,D,E).



5. Pull the fascia out on each side then forward to remove, set aside and remove energy absorption foam (Fig.F).





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R O A D M A S T E R, I N C.

- Remove the headlights (four 10mm head) bolts per headlight (Fig.G,H).



- Remove the bumper core (two 12mm head bolts on each side) (Fig.J). *Note: the main receiver brace will replace the steel bumper core and foam.*



- Mount the lower braces on the tubular cross bar with included U-bolts (Fig.K). Leave loose for now.
- Fit the top brace on the front of the frame on each side using the stock bumper core mounting bolts (Fig.N).
- Fit the lower brace to the bottom of the frame on each side and bolt in place with a stock bumper core bolts (Fig.O).
- Find the 5/8" x 4 1/2" bolts and 1" spacers. Insert the bolts through the top braces on each side with a 1" spacer between the frame and side brace as shown in (Fig.O). Leave the bolts inserted with the ends of the bolts flush with the inside of the frame wall.





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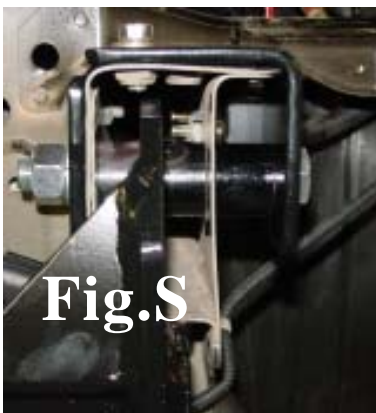
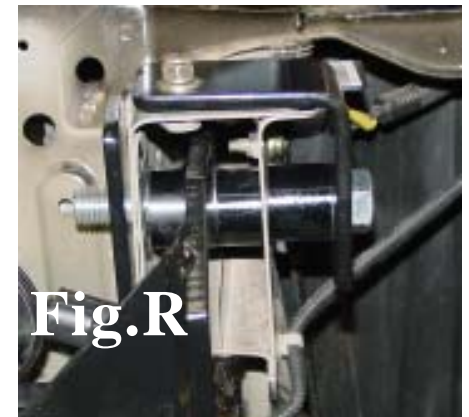
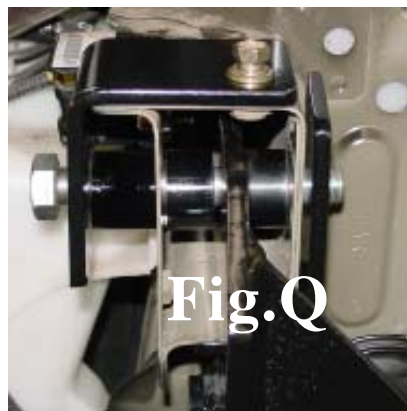
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R O A D M A S T E R, I N C.

13. Hold the receiver brace so that the upper mounts are lined up with the previously inserted bolts and bolt in place with  $\frac{3}{4}$ " spacers on each side of the brace (Fig.P,Q,R). Finish with lock washers and nuts on the  $\frac{5}{8}$ " bolts (Fig.S).



14. Bolt through the lower braces installed in step 9, and the main receiver brace with  $\frac{1}{2}$ " x  $2\frac{1}{2}$ " bolts, lock washers and nuts (Fig.T,U).
15. Align the receiver brace and torque all mounting bolts to the torque specifications below.
16. Replace the headlights removed in step 6.
17. Remount the bumper fascia and mark where the lower braces contact the fascia (Fig.V), then the grille ribs where the receiver pins will be located then remove and trim (Fig.W).





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- 18. Reinstall the bumper fascia without the bumper core and shock absorption foam reversing steps 2 and 3. The receiver brace assembly will replace these components (Fig.X).
- 23. Insert the front braces into the receiver tubes and pin with 5/8" draw pins and spring pins (Fig.Y).
- 24. Install the tow bar according to the manufacturer's instructions and torque all mounting bolts to the specifications below.
- 25. Attach the ends of the 8" safety cables to front holes on each side of the receiver braces with the included cable connectors. Connect the other end to the tow vehicle's safety cables and tow bar.



**Fig.X**



**Fig.Y**

### **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.