

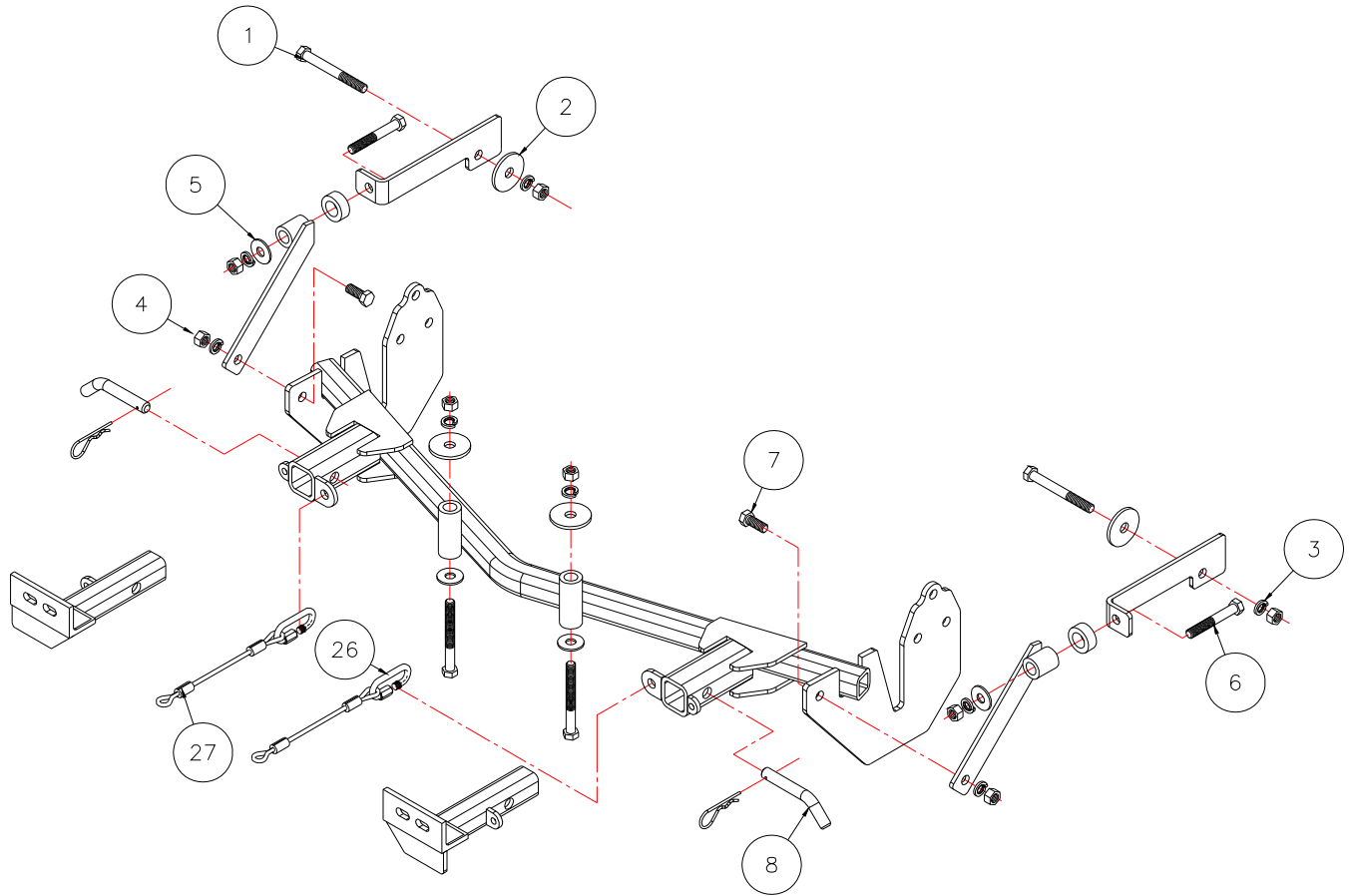


# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

**KIT# 1552-1**

01/12/04

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



Item	Qty	Length	Width	Hardware	Part No.
1	4	4 1/2"	1/2"	BOLT	350106-00
2	4		1/2"	PLATE WASHER	350351-00
3	8		1/2"	LOCK WASHER	350309-00
4	8		1/2"	NUT	350258-00
5	4		1/2"	FLAT WASHER	350350-00
6	2	3 1/2"	1/2"	BOLT	350103-00
7	2	1 1/4"	1/2"	BOLT	350094-10
8	2			DRAW PIN/SPRING PIN	357035-00
27	2	8"		SAFETY CABLE	200008-00
28	2			CABLE CONNECTOR	500646-08

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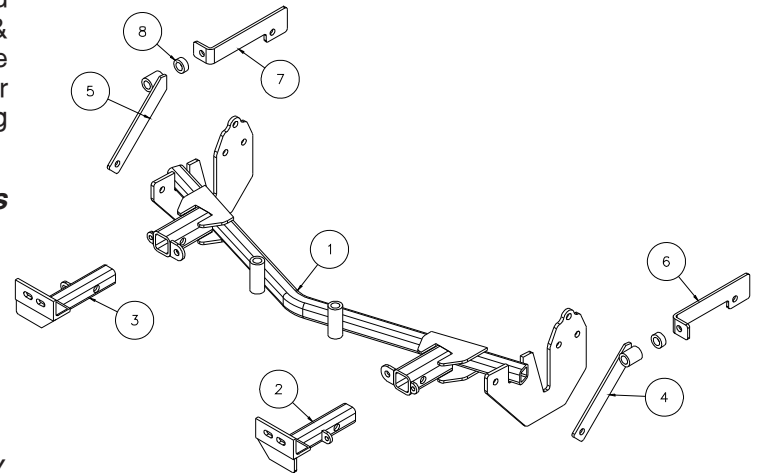
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**IMPORTANT:** All brackets **must** be assembled with all the bolts left loose for final adjustment & positioning (before tightening) unless otherwise instructed. All bolts **must** be torqued for proper strength. If more than one bolt is used per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

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



ITEM	QTY	PART NO.	ASSEMBLY
1	1	C-000740	MAIN RECEIVER BRACE WELDMENT
2	1	C-000741	DRIVER SIDE ARM BRACE WELDMENT
3	1	C-000742	PASSENGER SIDE ARM BRACE WELDMENT
4	1	C-000743	DRIVER SIDE REAR BRACE WELDMENT
5	1	C-000744	PASSENGER SIDE REAR BRACE WELDMENT
6	1	B-000513	DRIVER SIDE REAR MOUNTING BRACE
7	1	B-000514	PASSENGER SIDE REAR MOUNTING BRACE
8	2	A-000783	1 1/4" O.D. x 3/4" I.D. x 1/2" SPACER

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 securely fasten the bracket could result in loss of the towed vehicle.
- 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 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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This bracket kit is one of our XL series, which is designed to be partly removable. The kit consists of the main receiver brace, front braces, rear side braces and a hardware pack. The main receiver brace replaces the bumper core behind the front bumper fascia and mounts to the front frame and radiator support area on each side. The front 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 the kit components are present and accounted for (Fig.A).



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. Start by opening the hood and removing five plastic fasteners in the top of the fascia (Fig.B).
2. Moving to the sides and underneath the front fascia, remove a plastic fastener on each side of the air dam (Fig.C).
3. Remove two screws (10mm head) on each side under the air dam (Fig.D), then remove four more (10mm head) fasteners and two plastic fasteners under the fascia behind the air dam (Fig.E,F).



4. Move to the fender fascia junctions and remove one (8mm head) screw from each side (Fig.G).



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Fig.H



Fig.I

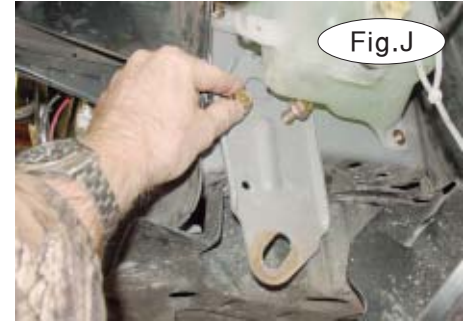


Fig.J

5. Disconnect the fog lights (Fig.H), then pull the fascia out on the sides and forward to remove (Fig.I).
6. Remove the front tie down plates on each side (three 17mm head bolts) and save the bolts(Fig.J).



Fig.K



Fig.L



Fig.M

7. Working on the driver's side, unplug the washer pump electrical connection (Fig.K), then remove the washer bottle (three 10mm head bolts) (Fig.L).
8. Remove the intake air box on the passenger side (two 10mm head bolts) (Fig.M).



Fig.N



Fig.O

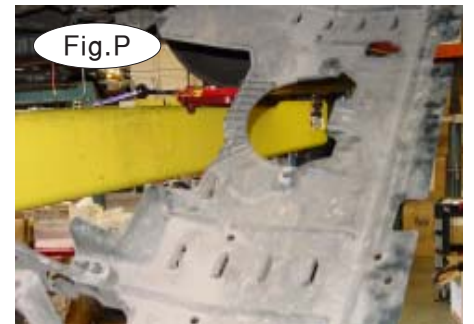


Fig.P

9. Remove the bottom splash panel, (four 10mm head bolts and 10 plastic fasteners) (Fig.N,O,P).
10. Hold the main receiver brace under the bumper core and over the tie down plate mounting holes, then bolt in place on each side with the stock bolts removed in step 6 (Fig.Q).



Fig.Q

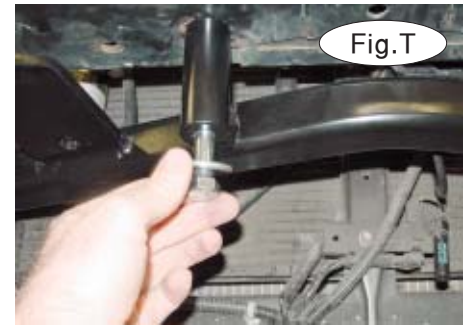


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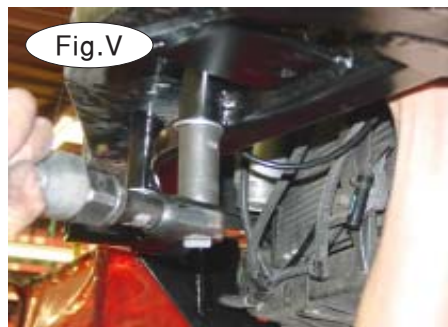
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11. Align the brace then tighten all the mounting bolts to hold in position (Fig.R).
12. Using the main receiver brace as a drill template, drill two 17/32" holes through the bumper core (Fig.S).
13. Bolt through the receiver brace and the bumper core with two 1/2" x 4 1/2" bolts, plate washers, lock washers and nuts (Fig.T,U). Tighten these bolts to hold in position (Fig.V).



14. Mount the side braces on the main brace with 1/2" x 1 1/4" bolts, nuts and lock washers then tighten with the rear of the braces aligned against the front of the frame as shown (Fig.W).



15. Drill through the front of the frame on each side using the brace as a guide (Fig.X).
16. Take the rear braces and insert a 1/2" spacer between the front of the rear brace and frame over the holes drilled in step 6 then bolt through the rear braces, spacers, frame and the main receiver brace on each side with 1/2" x 3 1/2" bolts, lock washers and nuts. Tighten the bolts to hold in position over the rear mounting holes in the frame (Fig.Y). Front and side brace installed (Fig.Z).

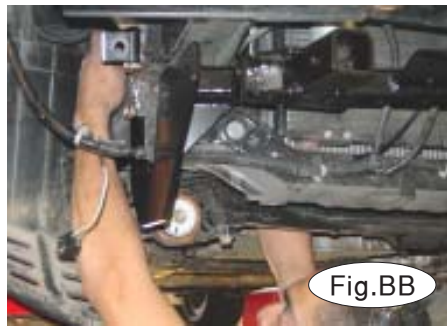


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17. Bolt the rear braces to the frame on each side using two 1/2" x 4 1/2" bolts and plate washers, lock washers and nuts. Insert these bolts through existing holes in the frame on each side (Fig.AA, BB, CC, DD). On the drivers side the hole is located under the battery and on the passenger side under the air plenum. They can be accessed from under the vehicle and the fender well. or if you have small hands , from the top, either way insert the bolts through the existing frame holes with the 1/2" plate washers on the engine compartment side of the frames.



- 18. Tighten all mounting bolts to the torque specifications below (Fig.DD).
- 19. Replace the bumper foam then trim one rib on each side from grille (Fig.EE).
- 20. Replace the lower splash panel, air box and fascia reversing steps 1 through 9.
- 21. Install the front braces in the receivers and pin with 5/8" draw pins and 3/16" spring pins (Fig.FF).
- 22. Connect the 8" safety cables to the receiver brace with the included cable connectors. Connect the other end to the tow vehicle's safety cables .

## 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.

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