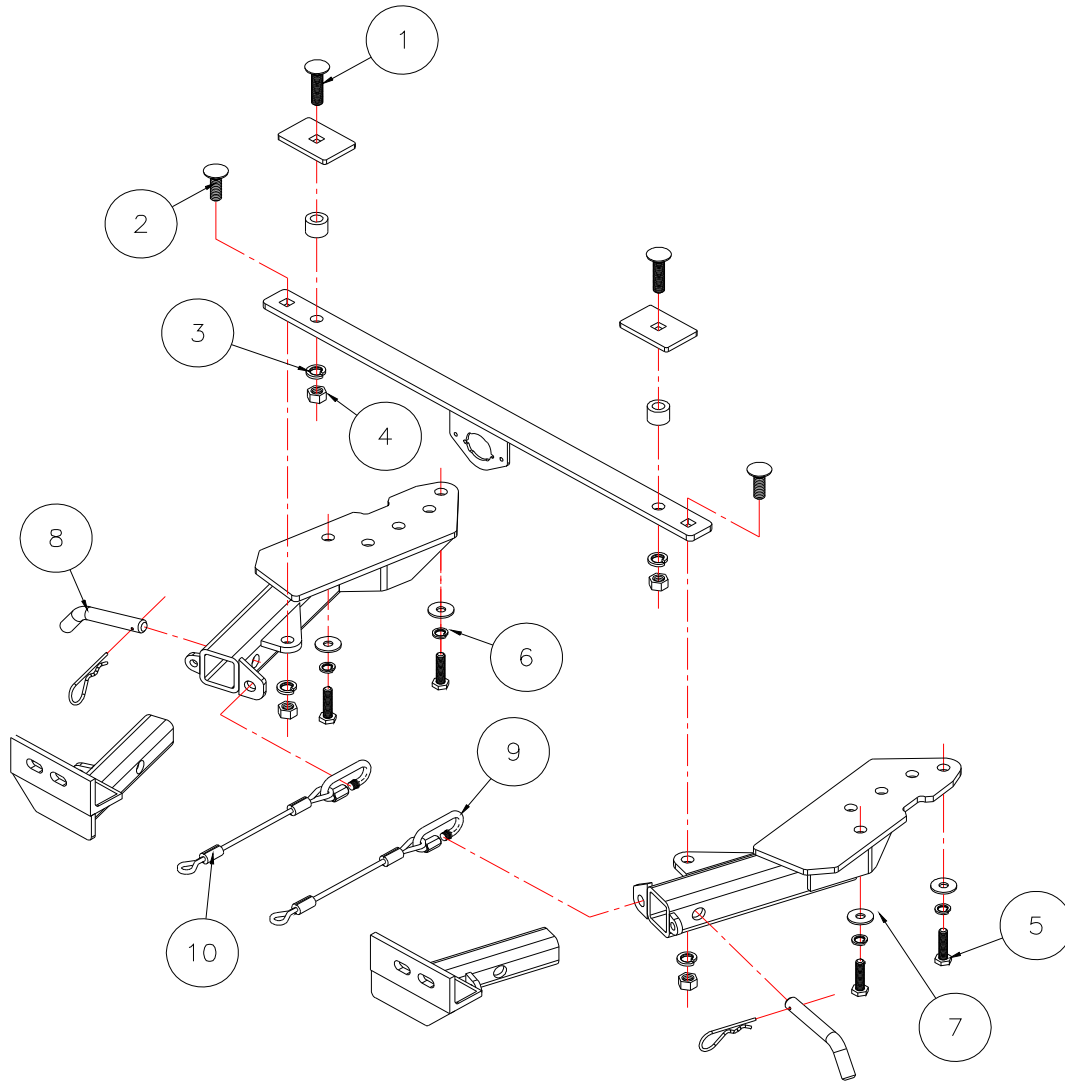




# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

**KIT# 1425-1**



Item	Qty	Length	Width	Hardware	Material
1	2	2"	1/2"	1/2" X 2" CARRIAGE BOLT	350373-00
2	2	1 1/2"	1/2"	1/2" X 1 1/2" CARRIAGE BOLT	350362-00
3	4		1/2"	1/2" LOCK WASHER	350309-00
4	4		1/2"	1/2" NUT	350266-00
5	4	40mm	10mm	10mm X 1.5 X 40mm BOLTS	356103-00
6	4		10mm	10mm LOCK WASHER	355715-00
7	4		10mm	10mm FENDER WASHER	355716-00
8	2			DRAW PIN / SPRING PIN	357035-00
9	2			QUICK LINKS	200008-00
10	2	8"		CABLES	500646-08

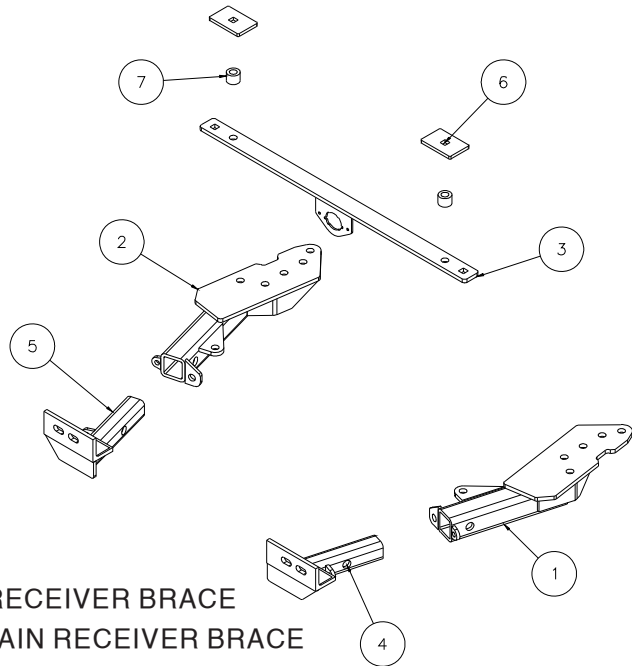


# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

## KIT# 1425-1

**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.	Assemblies
1	1	C-000584	DRIVER SIDE MAIN RECEIVER BRACE
2	1	C-000585	PASSENGER SIDE MAIN RECEIVER BRACE
3	1	C-000586	CENTER BRACE WELDMENT
4	1	C-000587	DRIVER SIDE ARM WELDMENT
5	1	C-000588	PASSENGER SIDE ARM WELDMENT
6	2	A-000050	2" x 3" SQ. HOLE BACKING PLATE
7	2	A-000558	1" X 3/4" X .219 WALL PIPE 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.

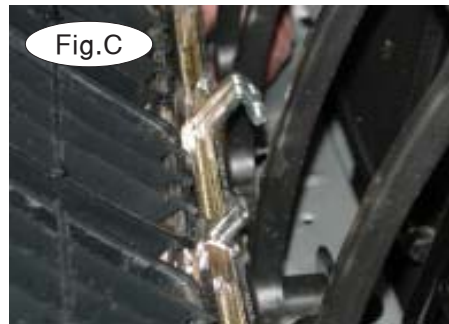
- **Installation of most mounting brackets requires moderate mechanical aptitude and skills.** We strongly recommend professional installation by an experienced installer.
- **The installer must read the instructions and use all bolts and parts supplied.** When the instructions require the reuse of factory bolts, thread lock and/or lock washers must also be used. 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.
- **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.



# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

**KIT# 1425-1**

1. This bracket kit is one of our XL series which is designed to be partly removable. The kit consists of the two main receiver braces, two front braces, a center brace and a hardware pack. The main receiver brace mounts behind the front bumper facia and protrudes through the lower bumper fascia. The center brace bolts to the bottom of the bumper core between the receiver braces. The front braces install in the receiver braces (Fig.A). 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.



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 by snapping loose the top of the chrome grille (Fig.B), then pulling forward then up and out ( Fig.C). This will allow easy access for the steps that follow.

3. If the vehicle is equipped with front tow hooks, they will have to be removed now (two 18mm head bolts per hook) (Fig.D).

4. Now remove the tow hook brackets ( 3- 15mm head bolts)(Fig.E). Install one of the stock bolts in the outside hole in the internal nut plate and tighten (Fig.F). This will keep the nut plate from rattling and secure it so that you can twist and break off the locator clips (Fig. G).





# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

**KIT# 1425-1**



Fig.H

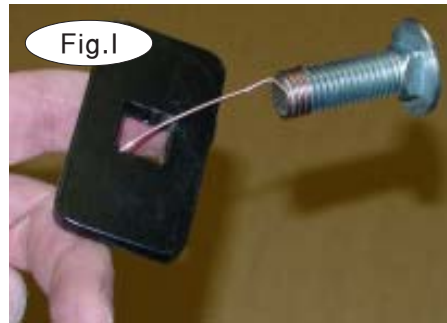


Fig.I



Fig.J

5. Remove the spring nut clips from the bottom of the bumper core (Fig.H).

6. Now, locate two existing round holes in the bottom of the steel bumper core. Fishwire the long  $\frac{1}{2}$ " x 2" carriage bolts and the 2" x 3" sq. hole backing plates through the large access holes in the back of the bumper core into the two holes (Fig.I,J). The passenger side will have limited clearance but it will fit.



Fig.K



Fig.L



Fig.M

7. Put  $\frac{1}{2}$ " x  $1\frac{1}{2}$ " carriage bolts in the ends of the center brace then bolt the center brace into position with  $\frac{1}{2}$ " nuts and lock washers using two  $\frac{1}{2}$ " spacers between the bumper core and the center brace (Fig.K). Trim the fascia corner slightly near each spacer for clearance.

8. Remove three plastic fasteners from the bottom of the fascia (Fig.L). This will allow you to pull the fascia forward later when installing the receiver braces on each side.

9. Remove the lower skid pan four 15mm head bolts) (Fig.M,N). This will not be refitted. *Note:* retain the lower skid pan and attachment hardware to replace if the bracket is ever removed.



Fig.N

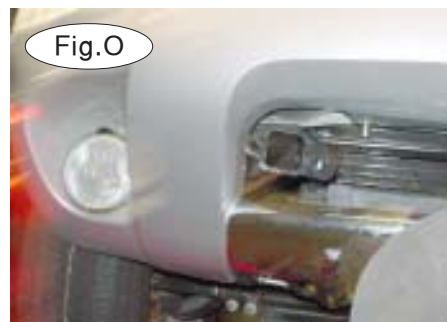


Fig.O



Fig.P

10. Remove four 18mm (head) bolts holding the sway bar to the frame on each side ( Fig.N,Q), then let the stabilizer bar fall out of the way.

11. Working on one side at a time, pull the lower fascia forward and insert the receiver braces through the lower fascia opening by the side of the radiator (Fig.O). Bolt through the rear of the receiver brace with a 10 mm x 1.25 x 35mm bolt, fender washer, and lock washers (Fig.Q). Now bolt through the front of the receiver brace and the center brace with the  $\frac{1}{2}$ " x  $1\frac{1}{2}$ " carriage bolt installed in step 7 and a  $\frac{1}{2}$ " nut and lock washer (Fig.P). Repeat for the remaining side.



# MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

**KIT# 1425-1**

12. Locate a threaded hole in the bottom of the frame just forward and to the outside of the front stabilizer bar bolt mounting hole. Bolt through into this hole on each side using a supplied 10mm x 1.5 x 40mm bolt lock washer and fender washer. Align the remaining two holes in the receiver plate to the stabilizer mounting holes.

13. Bolt the stabilizer bar in place over the receiver braces and align the braces (Fig.Q).

14. Tighten all the bolts to the torque specifications below.

15. Replace the three lower plastic fascia fasteners remove in step 8.

16. Insert the front braces in the receiver braces and secure using 5/8" draw pins and 1/8" spring pins (Fig.R).

17. Install the tow bar according to the manufacturer's instructions and torque all mounting bolts to the specifications below.

18. Attach one end of the safety cables to the receiver braces with the included cable connectors. Attach the other end of the cables to the tow vehicle's safety cables and the tow bar.



## 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.

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.