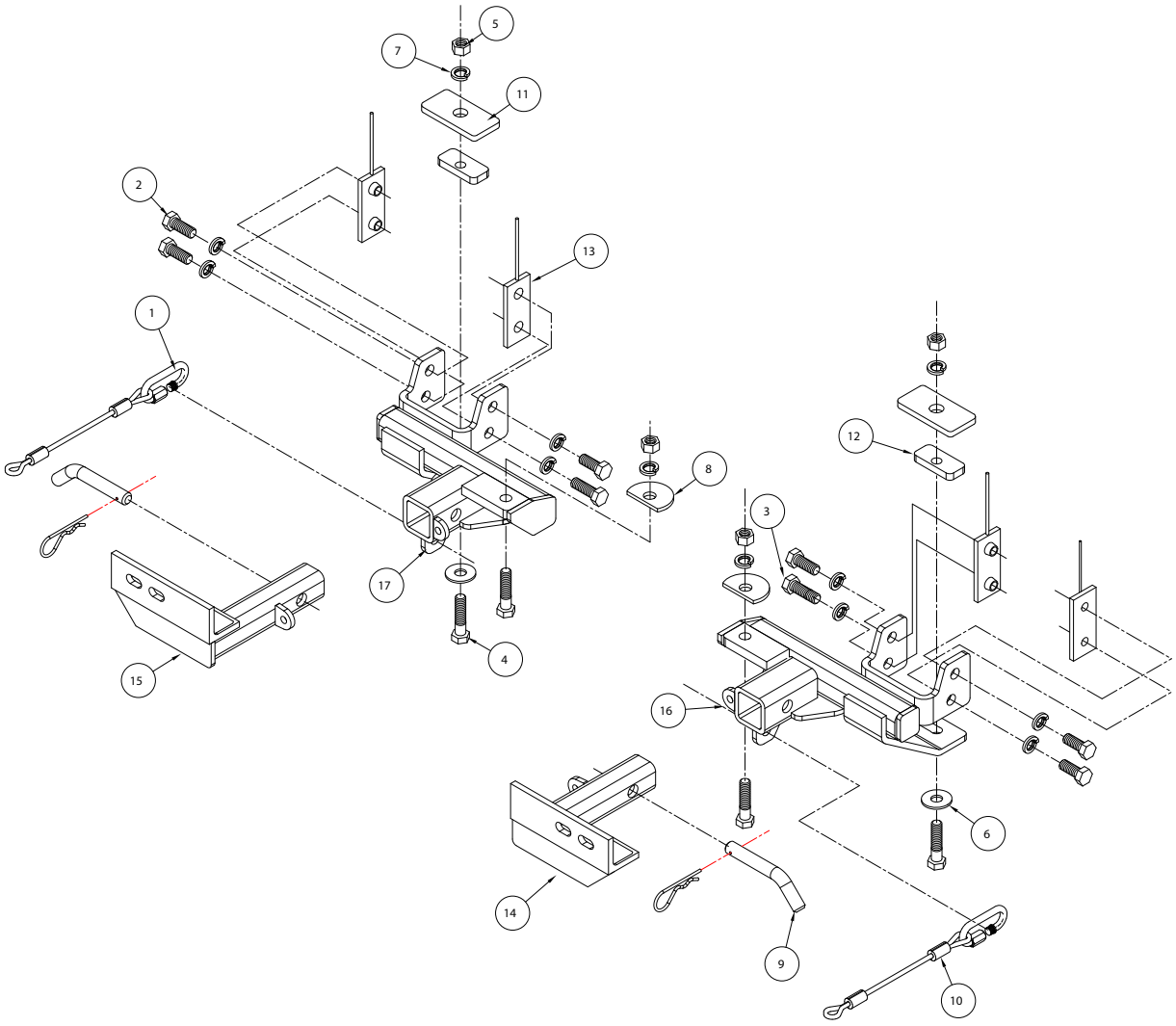
ROADMASTER, INC.

MOUNTING BRACKET KIT
INSTALLATION INSTRUCTIONS



ITEM	QTY	NAME	MATERIAL
1	2	QUICK LINK	200008-00
2	6	1/2" x 1 1/4" BOLT	350094-00
3	2	1/2" X 1 1/2" BOLT	350095-00
4	4	1/2" x 2" BOLT	350097-00
5	4	1/2" NUT	350258-00
6	6	1/2" FLAT WASHER	350308-00
7	12	1/2" LOCK WASHER	350309-00
8	2	1/2" PLATE WASHER	A-002687
9	2	DRAW PIN W/ CLIP	357035-00
10	2	8" SAFETY CABLE	650646-08
11	2	1 1/2" x 3" BACKING PLATE	A-000185
12	2	3/8" x 1 1/8" x 2 1/2" SPACER PLATE	A-003068
13	4	1 1/2" x 3 1/2" THREADED BACKING PLATE W/ ROD	C-001835
14	1	DRIVER SIDE ARM	C-001897
15	1	PASSENGER SIDE ARM	C-001898
16	1	DRIVER SIDE RECEIVER	C-001950
17	1	PASSENGER SIDE RECEIVER	C-001951
18	1	INSERT	85-4195-09

MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

KIT# 1438-1
09/23/14

This bracket kit is one of our XL series, which allows the visible front portion of the brackets to be easily removed (Fig.A and Fig.B). The kit consists of two main receiver braces, removable front braces and a hardware pack.

The main receiver brace mounts to the frame rails and bumper support on each side. The removable front braces insert into the receivers on each side and are secured with draw pins.

Before starting the installation, lay out the kit components in order, as they will be used. This will give you a visual idea of how the components work, and will also confirm that everything is present and accounted for.


Fig.A


Fig.B

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.
- **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**
- Roadmaster manufactures many styles of brackets. **If your bracket has removable arms, they must be removed before driving the vehicle, unless the arms can be pinned or padlocked in place.** If not secured, the arms could vibrate out, resulting in non-warranty damage or personal injury.
- 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.**
- **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.
- 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 warranteed for the original installation.** Installing

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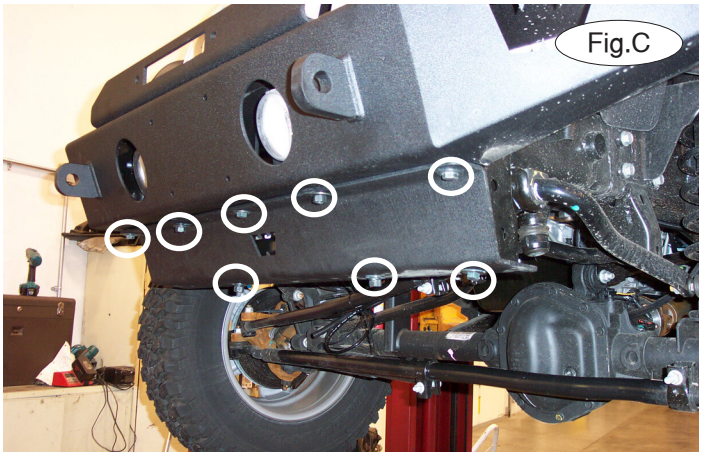
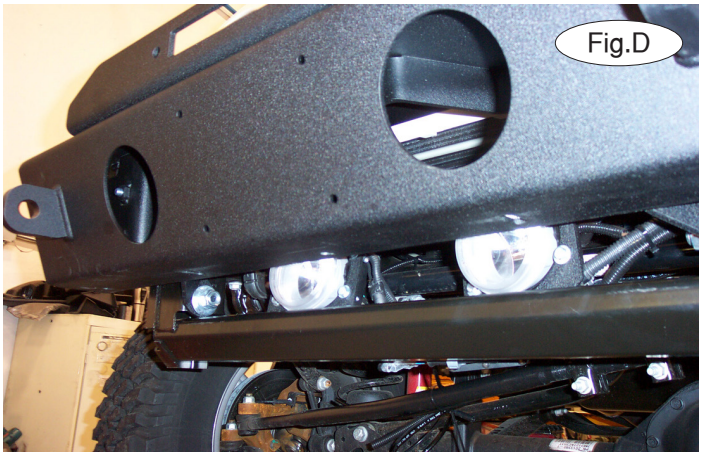
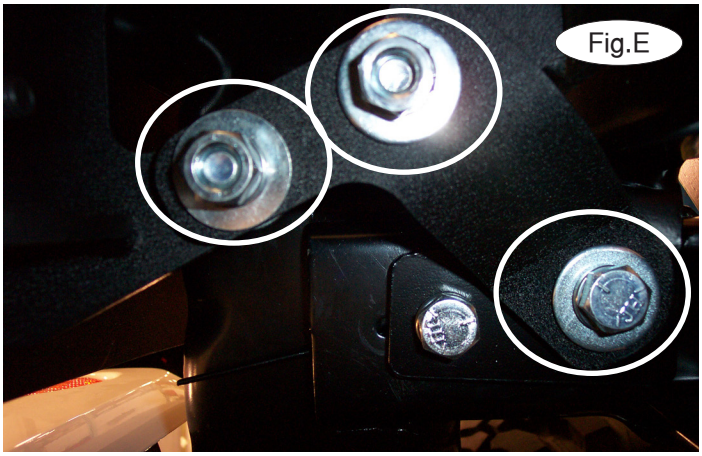
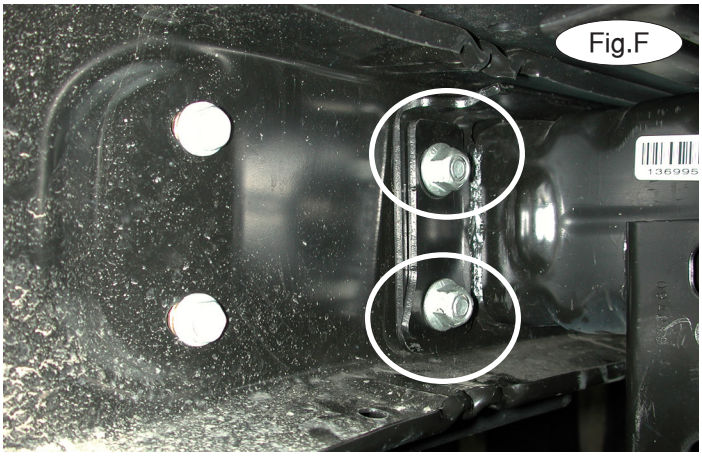




1. ***Important:*** **please use all supplied bolts and parts and read all instructions carefully before beginning this installation. The majority of questions you may have can be answered within the text, and proper installation will ensure safe and secure travel.** Now, begin the installation by removing eight 5/8" (head) bolts attaching the skid plate to the bumper and lower frame support (Fig.C).
2. Pull the fog lights back and set them on top of the subframe (Fig.D).





3. On each side, remove the bumper support bracket by removing one 15/16" nut and two 11/16" nuts (Fig.E – driver's side). *Note:* these parts will be used in steps 9 and 10.
4. On each side, remove four 5/8" (head) bolts attaching the bumper to the end of the frame rail. *Note:* Figure F only shows two of the four bolts. The remaining two bolts are located to the inside of the frame support.

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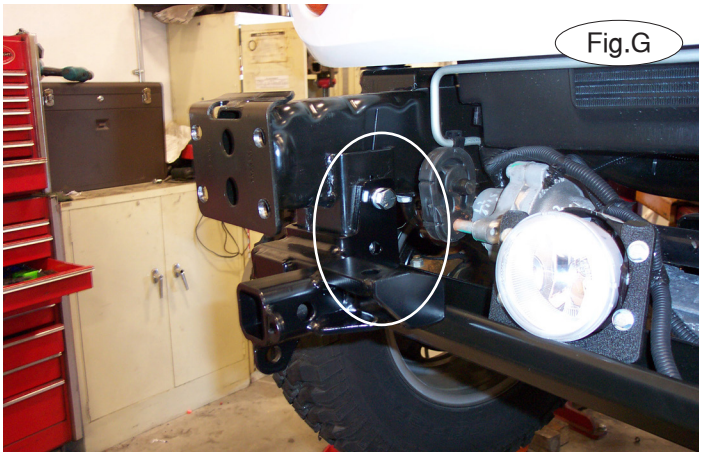
Fig.G


Fig.H

5. Working on the driver's side, place the main receiver brace over the end of the frame rail. Place one of the supplied 3/16" x 1½" x 3½" threaded backing plates with wire through the opening to the inside edge of the frame rail. Using one of the four supplied ½" x 1¼" bolts and ½" lock washer, bolt through the top inside bolt hole in driver's side main receiver brace, frame rail and into the threaded backing plate with wire.

6. Repeat step 5 for the passenger side (Fig.G).

7. Replace the bumper and the eight 5/8" (head) bolts that you removed in step 4 (Fig.H).

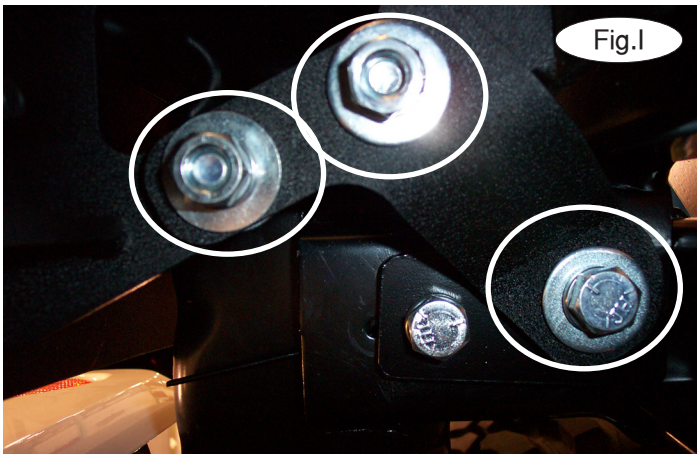
Fig.I

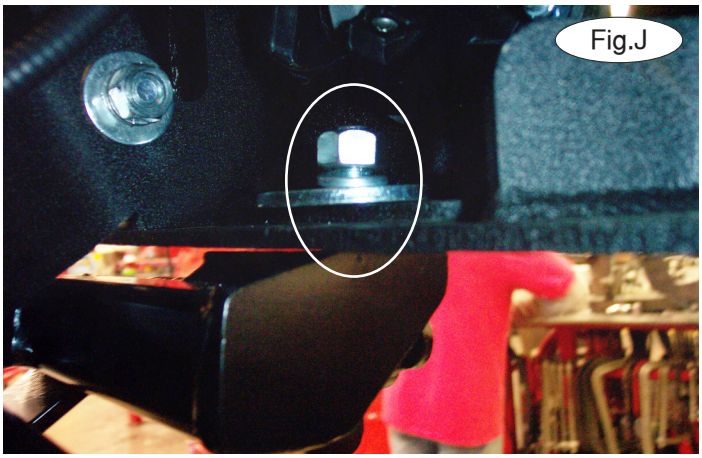
Fig.J

8. Working on the driver's side, and using one of the supplied ½" x 1½" bolts, and ½" flat washer and lock washer, bolt through the bumper support bracket and the lower mounting point of the main receiver brace, the frame rail and into the backing plate. *Note:* the bumper support bracket must be mounted to the INSIDE of the bumper mount, which is opposite from how you removed it in step 3.

9. Repeat step 8 for the passenger side of the vehicle.

10. Using the hardware you removed in step 3, bolt the bumper support bracket to the bumper (Fig.I).

11. Now, torque the bolts attaching the main receiver brace to the bumper to the bolt torque requirements found at the end of these instructions.

12. Working on the driver's side, and using one of the supplied ½" x 2" bolts, bolt up through the front mounting point of the brace, bumper, and fog light bracket. Place a ½" clipped plate washer over the top of the bolt, and finish with a ½" lock washer and nut (Fig.J). Torque these bolts to the bolt torque requirements found at the end of these instructions.

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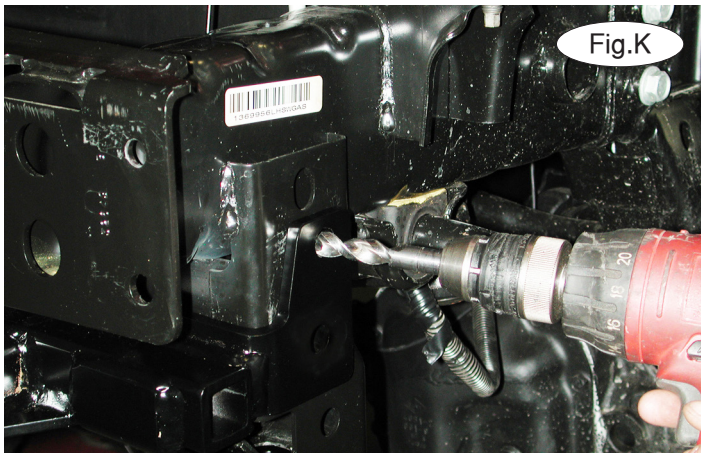
Fig.K

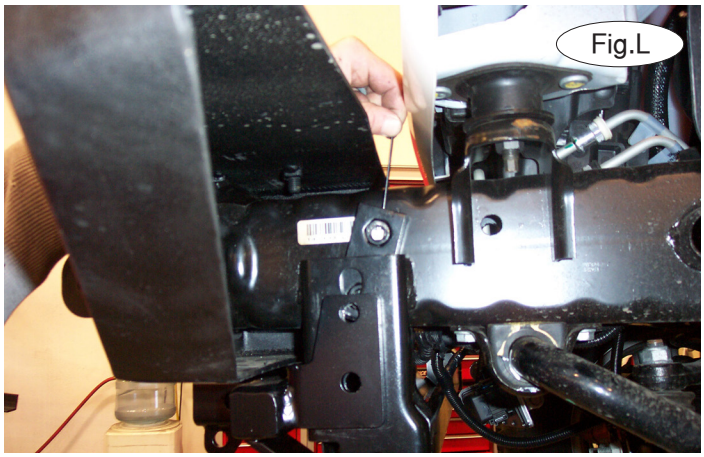
Fig.L

13. Using the upper outside mounting point of the main receiver brace as a template, drill a ½" hole through the side of the frame support (Fig.K).

14. Insert one of the supplied 3/16" x 1½" x 3½" threaded backing plates with wire in the opening to the inside of the frame (Fig.L) and bolt it into place using the two supplied ½" x 1¼" bolts and two ½" lock washers (Fig.M). *Note:* due to manufacturing variances, there may be a slight gap between the outside mounting point and the frame. If this is the case, use an additional ½" lock washer as a shim for each hole.

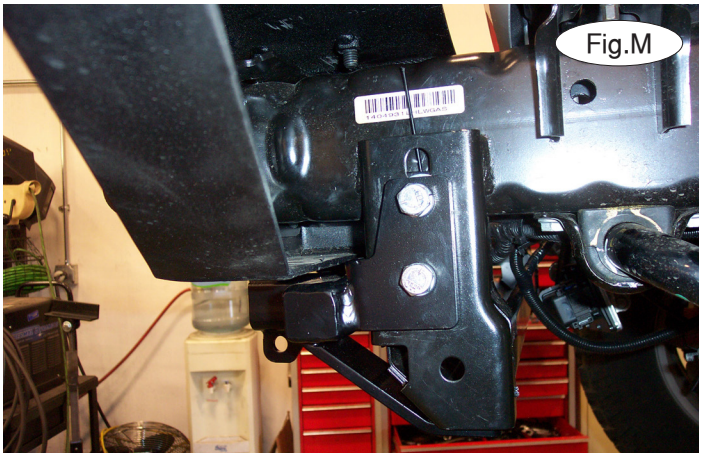
Fig.M


Fig.N

15. Repeat steps 12 through 14 for the passenger side.

16. Using the lower mounting point of the main receiver brace as a template, drill a ½" hole through the frame support on the passenger side only (Fig.N).

17. Working on the driver's side, place a 3/8" x 1-1/8" x 2½" spacer between the brace and the frame. Place one of the supplied ½" flat washers over one of the ½" x 2" bolts and bolt up through the main receiver brace, spacer, and frame support. Now, place one of the 3/16" x 1½" x 3" backing plates over the top of the bolt and finish with a ½" lock washer and nut (Fig.O).

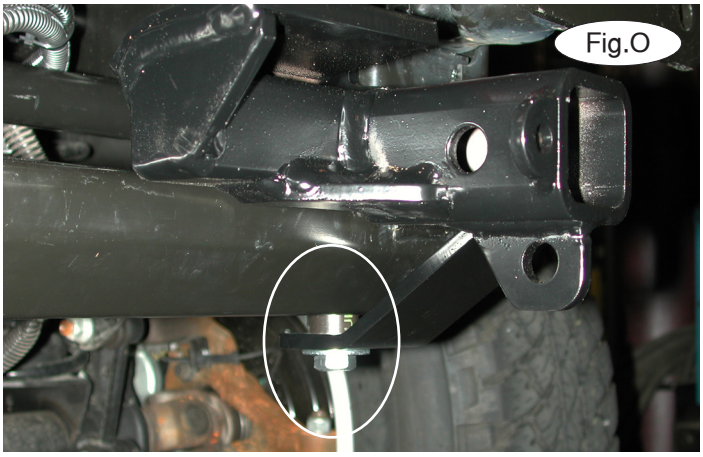
Fig.O

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18. Repeat step 17 for the passenger side.

19. Now, tighten all bolts to the bolt torque requirements found at the end of this document. *Note:* the skid plate can either be trimmed, or left off.

20. Use a pair of pliers to snap the wires off the four backing plates you installed in steps 5 and 14.

21. Insert the removable front bracket arms into the front receiver braces (Fig.P), and secure them in place with the supplied 5/8" draw pins and spring pins.

22. Attach the 8" safety cables with the cable connectors (Q-Links) to the front of the receiver braces.

23. Attach the ends of the safety cables to the tow vehicle's safety cables.

24. Install the tow bar to the mounting bracket according to the manufacturer's instructions.

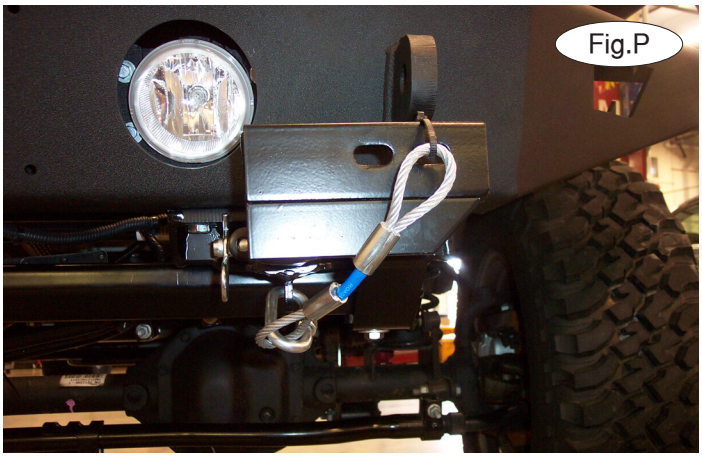
Fig.P

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.