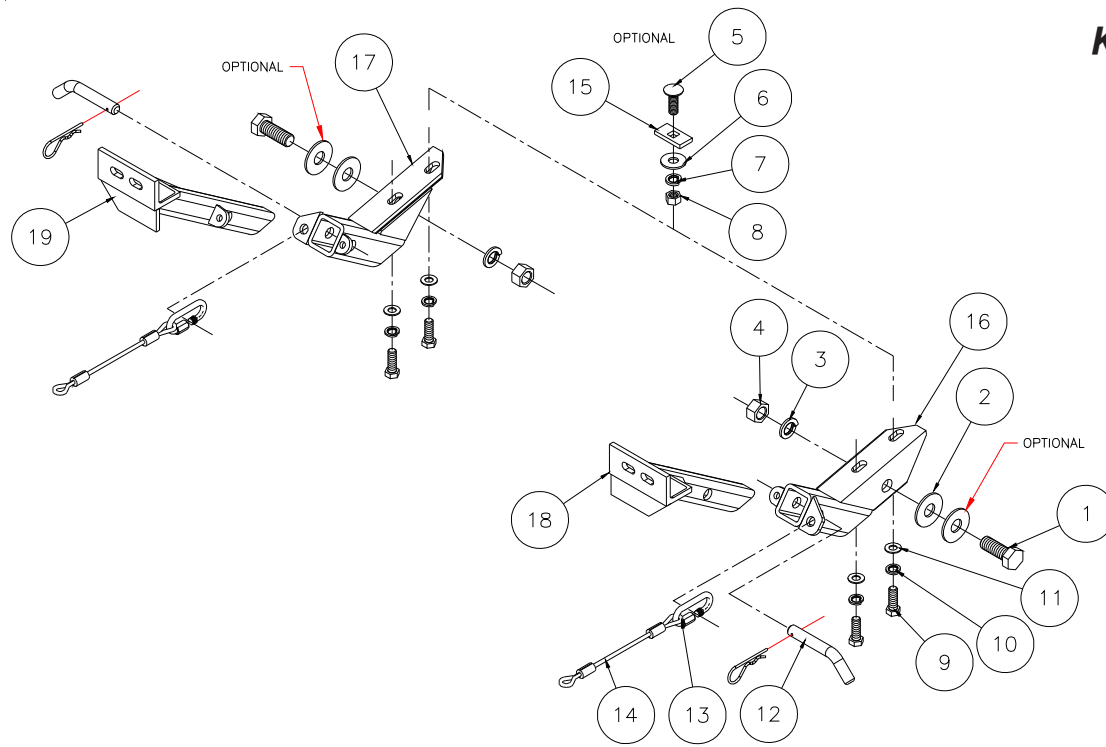


MOUNTING BRACKET KIT

INSTALLATION INSTRUCTIONS

KIT NO. 317-1



09/18/09

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.

MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

KIT NO. 317-1

1. This XL bracket kit consists of two receiver braces, two front braces and a hardware pack. It utilizes existing threaded holes in the front frame bottom and the tie down loops as main anchor points. *Note:* some vehicles may have mounted tow hooks utilizing these holes. Remove the tow hooks on these vehicles.
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. Beginning with the passenger side brace, insert a 3/4" x 2" bolt through the side hole of the receiver brace. Mount the brace to the inside of the tie down plate underneath the frame. Secure with a 3/4" flat washer, lock washer and nut on the outside of the plate. Now, check the hole line up underneath the frame, some vehicles may have to be shimmed with a 3/4" flat washer to match.
3. Bolt through the slotted holes into the frame bottom using the 12mm x 1.25 x 30mm bolts, lock washers and flat washers provided. *Note:* some vehicles may have a weld nut in the frame missing or misaligned. If this is this case, 1/2" x 1 1/2" carriage bolts and 1/2" x 1" x 2" backing plates have been provided to be fish wired through the front or side of the frame into the mounting hole. You may have to enlarge an existing access hole. Finish with a 1/2" flat washer, lock washer and nut. Repeat for the driver's side.
4. Insert the front braces into the receiver braces and secure with 5/8" draw pins and spring pins.
5. Mount and align the tow bar according to the manufacturer's instructions.

Hardware

ITEM	QTY	NAME	MATERIAL
1	2	3/4" x 2" BOLT	350386-00
2	4	3/4" FLAT WASHER	350314-20
3	2	3/4" LOCK WASHER	350315-00
4	2	3/4" HEX NUT	350264-00
5	2	1/2" x 1 1/2" CARRIAGE BOLT	350362-00
6	2	1/2" FLAT WASHER	350308-00
7	2	1/2" LOCK WASHER	350309-00
8	2	1/2" HEX NUT	350258-00
9	4	12mm x 1.25 x 35 mm BOLT	357002-00
10	4	12mm LOCK WASHER	355725-00
11	4	7/16" FLAT WASHER	350306-00
12	2	5/8" DRAW PIN W/ CLIP	357035-00
13	2	QUICK LINK	200008-00
14	2	SAFETY CABLE 10"	650646-10
15	2	1/4" x 1" x 2" SQ. HOLE BACKING PLATE	A-000040
16	1	DRIVER SIDE RECEIVER	C-001891
17	1	PASSENGER SIDE RECEIVER	C-001892
18	1	DRIVER SIDE ARM	C-001893
19	1	PASSENGER SIDE ARM	C-001894

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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.
3/8	5	270 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.