

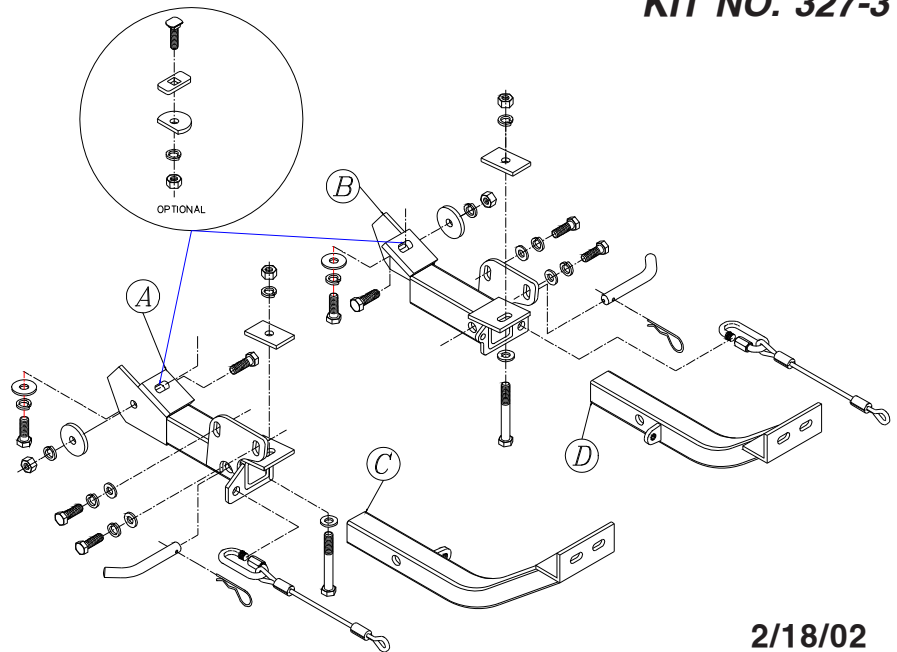
MOUNTING BRACKET KIT

INSTALLATION INSTRUCTIONS

PARTS LIST:

- 1- REAR BRACE (A) - Passenger side
- 1- REAR BRACE (B) - Driver's side
- 1- FRONT BRACE (C) - Passenger side
- 1- FRONT BRACE (D) - Driver's side

KIT NO. 327-3



2/18/02

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. 327-3

- 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. This bracket kit is one of our XL series which is designed to be partly removable. The main receiver braces bolt to the side and bottom of the frame and tie down plates on each side. It utilizes existing frame nuts and holes in the frame. Work on one side at a time and start by removing two bumper bracket bolts in the side of the frame behind the bumper. These bolts will not be replaced, but should be kept for reinstallation in case the bracket is ever removed. The bumper may drop slightly; just push up slightly when retightening.
- Hold a receiver brace to the bottom of the frame and check the rear most hole in the bottom of the frame. Note: Sometimes the frame nut in this hole is not exactly centered over the frame hole, in this case the hole in the frame must be relieved to allow its use. On some later vehicles, the frame nuts maybe missing. If this is the case, fishwire a 1/2" x 1 3/4" clipped carriage bolt and 1/4" x 1" x 2" backing plate into the bottom hole though the side of the frame. Bolt through the hole into the existing frame nut with 12mm x 1.25 x 40mm bolt, lock washer and fender washer. Note: if a tow hook is present, remove it.
- Bolt through the side of the brace and bumper bracket into the frame with two supplied 10mm x 1.25 x 35mm bolts, lock washers and fender washers.
- Bolt through the top of the frame with a 3/8" x 4 1/4" bolt, flat washer, lock washer, 1/4" backing plate, and nut. Note: later models may need a hole drilled through the frame.
- Finish with a 1/2" x 1 1/2" bolt, plate washer, lock washer and nut through the side of the bracket and tie down plate.
- Repeat steps one through five for the remaining receiver brace.
- Align the braces and tighten all bolts to the torque specifications below.
- Insert the front braces into the receiver braces and secure with 5/8" draw pins and 1/8" spring pins.
- Install the tow bar according to the manufacturer's instructions.
- Attach one end of the included 10" safety cables to the front of the receiver brace with the included cable connectors. Connect the other end to the tow vehicle's safety cables and the tow bar.

Hardware

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| 2- 12mm lock washers | 2- 1/2" x 1 3/4" clipped carriage bolts |
| 2- 12mm x 1.25 x 40mm bolts | 2- 1/4" x 1" x 2" sq. hole backing plate |
| 4- 10mm x 1.25 x 35mm bolts | 2- 1/4" x 1 1/2" x 2 1/2" backing plate |
| 2- 3/8" X 4 1/4" bolts | 2- 1/2" clipped plate washers |
| 2- 1/2" flat washers | 2- 3/8" nuts |
| 4- 10mm fender washers | 2- 3/8" lock washers |
| 4- 10mm lock washers | 2- 3/8" flat washers |
| 2- 1/2" x 1-1/2" bolts | 2- 1/8" spring pins |
| 2- 1/2" plate washers | 2- 5/8" draw pins |
| 4- 1/2" lock washers | 2- cable connectors |
| 4- 1/2" nuts | 2- 10" safety cables |

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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			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.						