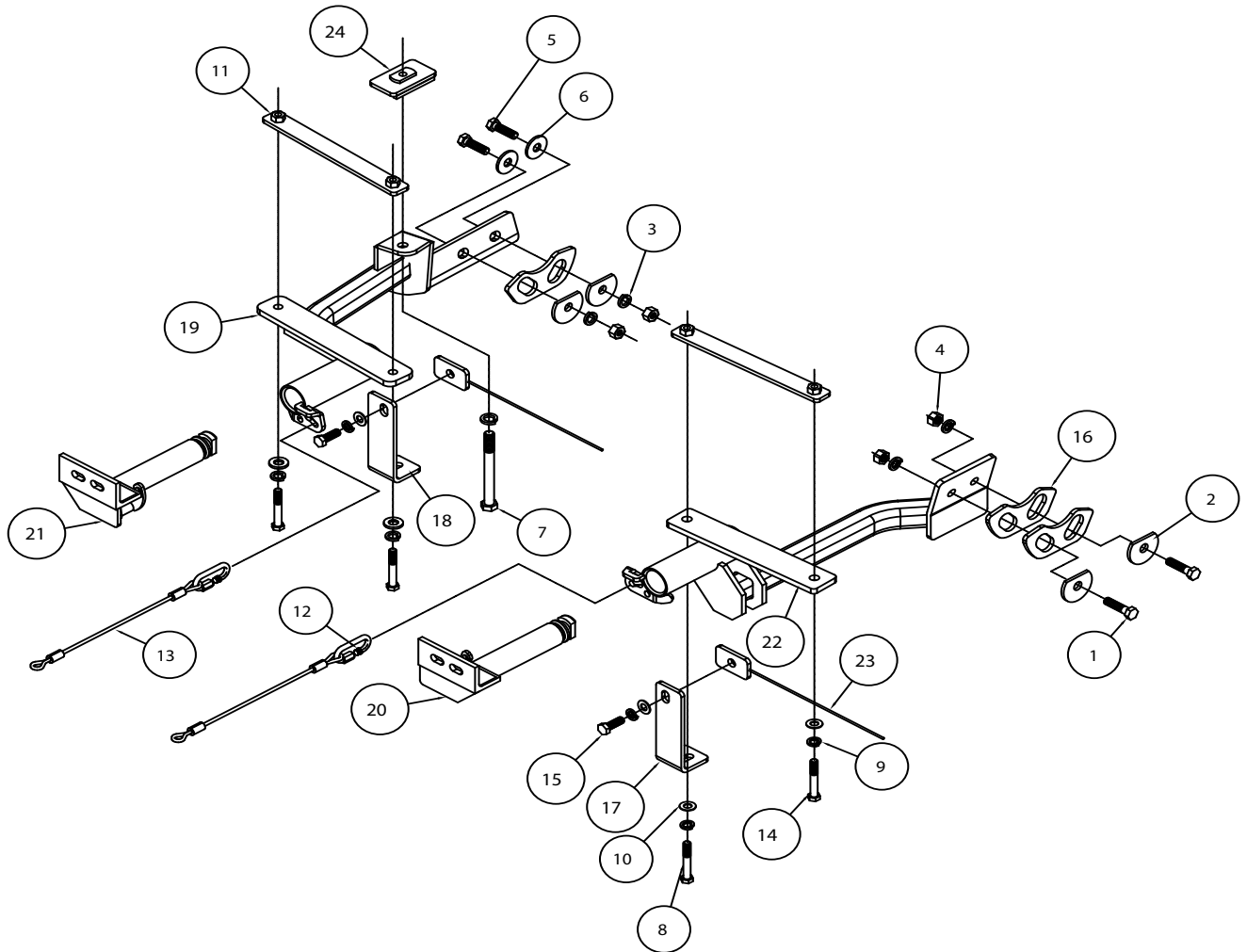




MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS



ITEM	QTY	NAME	PART #
1	2	1/2" x 2" BOLT	350097-00
2	4	1/2" x 2 1/4" PLATE	A-003086
3	9	1/2" LOCK WASHER	350309-00
4	4	1/2" HEX NUT	350258-00
5	2	1/2" X 1 3/4" BOLT	350096-00
6	4	1/2" FLAT WASHER	350308-00
7	1	1/2" X 5" BOLT	350107-00
8	2	7/16" X 2" BOLT	350076-00
9	4	7/16" LOCK WASHER	350306-00
10	4	7/16" FLAT WASHER	350307-00
11	2	THREADED BACKING PLATE 7/16" NUT	C-000096
12	2	QUICK LINK	200008-00
13	2	8" SAFETY CABLES	650646-08
14	2	7/16" x 1 1/2" BOLT	350074-00
15	2	1/2" x 1 1/4" BOLT	350094-00
16	3	FORMED BACKING PLATE	A-000166
17	1	DRIVER SIDE FRONT BRACE	B-000472
18	1	PASSENGER SIDE FRONT BRACE	B-000473

continued on next page



MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

KIT# 52491-1
10/06/14

continued from previous page

19..... 1	PASSENGER SIDE RECEIVER WELDMENT.....	C-000091A
20..... 1	DRIVER SIDE ARM WELDMENT	C-000092
21..... 1	PASSENGER SIDE ARM WELDMENT	C-000093
22..... 1	DRIVER SIDE RECEIVER WELDMENT	C-000681
23..... 2	THREADED BACKING PLATE WELDMENT W/ HANDLE	C-000687
24..... 1	THREADED BACKING PLATE W/TAB NUT WELDMENT	C-000688

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.



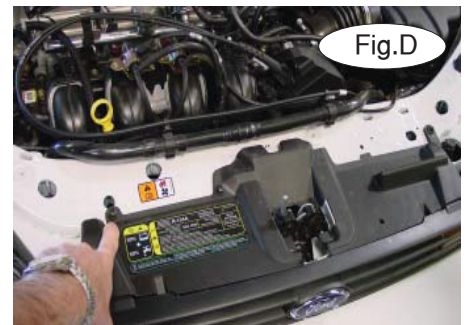
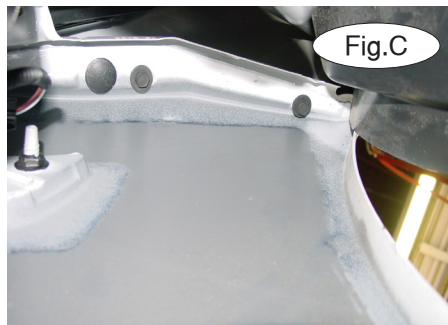
WARNING Failure to follow these instructions can result in property damage, personal injury or even death.

- **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 structural frame damage is found.** Failure to repair the damage could result in the loss of the towed vehicle.
- 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 warranted for the original installation.** Installing a used bracket on another vehicle is not recommended and will void the warranty.

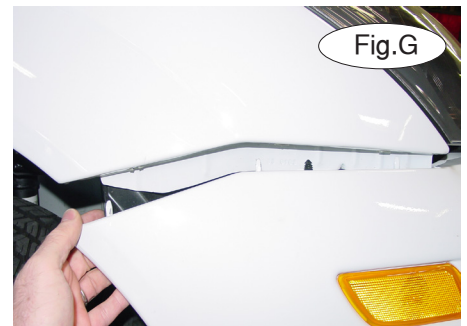
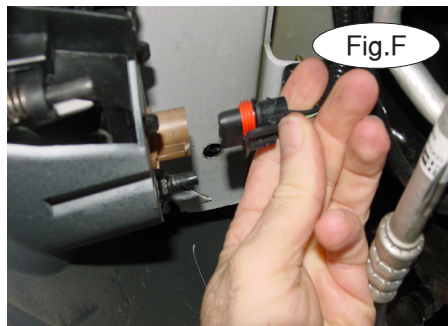
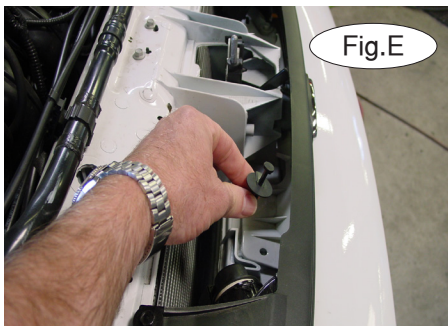


MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

1. This bracket kit is one of our EZ lock series, which is designed to be partly removable. The kit consists of the main receiver braces, two tubular front braces, and a hardware pack. The main receiver braces mount to the frame and bumper behind the front bumper fascia on each side (Fig.A). The tubular main braces insert through the front lower bumper fascia and rotate 90 degrees to lock in place. Lay the kit components out as they are illustrated before the installation. This will give you a visual idea of how the kit installs and also confirm that the kit components are present and accounted for.



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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. Starting on the driver's side remove one torx bolt and two 10mm (head) bolts from the fascia and the splash panel (Fig.B) then pull the splash panel back and remove three 10mm (head) bolts holding the fascia at the fascia bumper junction (Fig.C). Repeat for the passenger side.

3. Remove three plastic fasteners on top the plastic cover for the hood latch and remove the top cover (Fig.D). This will expose two plastic fascia fasteners on the top of the fascia (Fig.E). Remove these also.

4. Disconnect the marker lights and fog lights (Fig.F) on each side, if the vehicle is so equipped, then pull the bumper fascia forward off three lower clips (Fig.G,H). Set the fascia aside.





MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

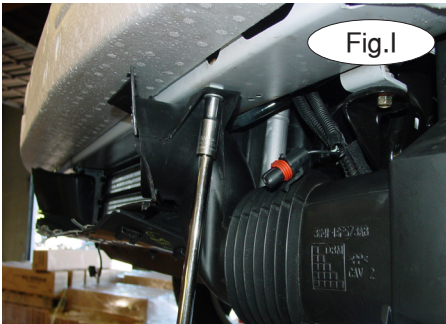


Fig.I



Fig.J



Fig.K

5. Locate the front air plenum on the drivers side and remove the front of the plenum (one 10mm head bolt) (Fig.I). Remove two more 10mm (head) bolts and remove the main air plenum (Fig.J).

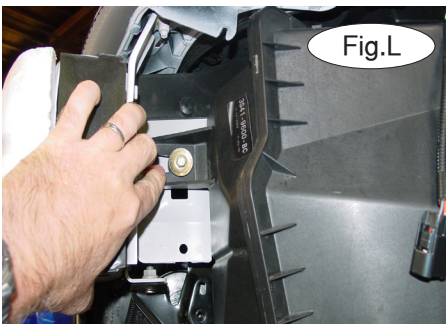


Fig.L



Fig.M

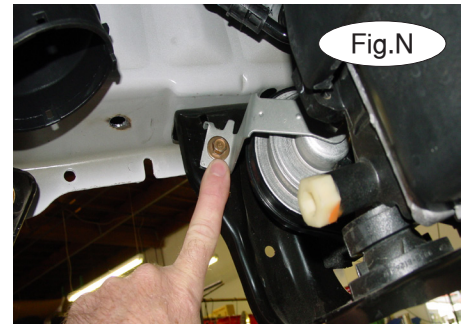


Fig.N

6. Loosen the air intake clamp (Fig.K) then remove the main air filter (three 10mm bolts)(Fig.L,M).

7. Remove the horn (10mm head bolt), bend the locator tab flat and reinstall as shown to clear the main brace which will be installed (Fig.N,O).

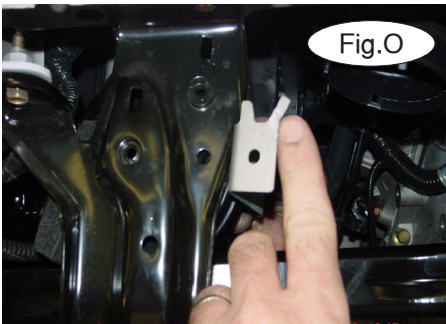


Fig.O

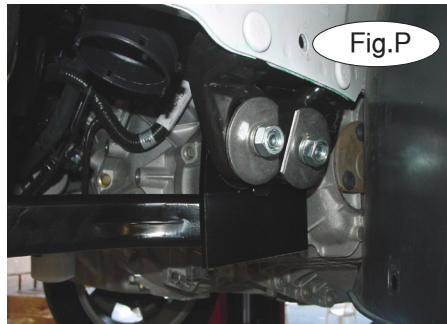


Fig.P

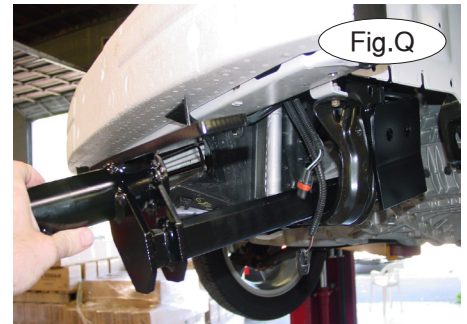


Fig.Q

8. Locate the existing tie down plates, which are bolted to the bottom of the frame on each side (Fig.P). The ends of the receiver brackets will bolt through these plates utilizing special shaped plates. Starting on the driver's side, hold the driver side receiver brace in position with the front mounting plate under the bumper and the back of the brace against the tie down plate (Fig.Q). Insert two shaped plates

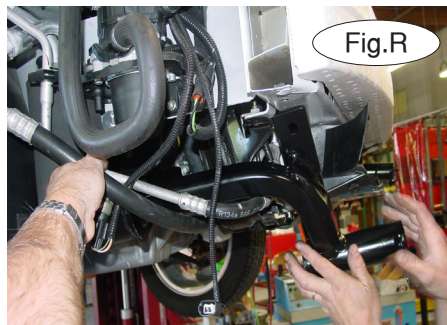


Fig.R



Fig.S

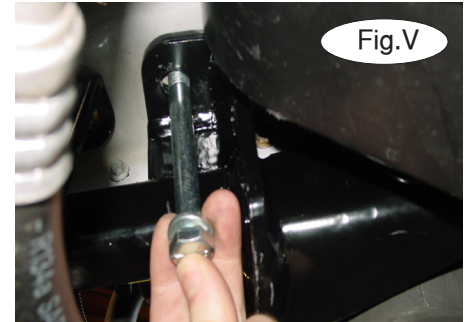
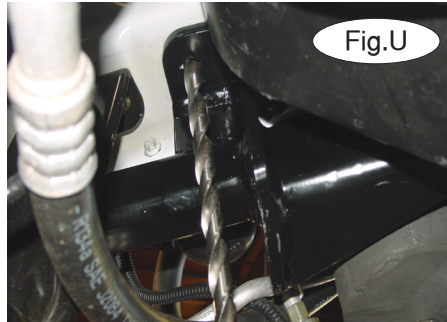
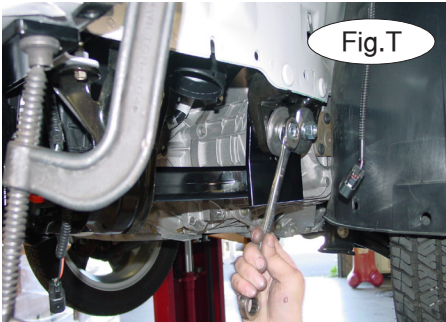
between the tie down plate and the rear mounting plate then bolt through the tie down plate with two 1/2" x 2" bolts, clipped plate washers, lock washers and nuts. Be sure the formed backing plate is behind the tie down plate before bolting.

9. Clamp the front of the brace to the bottom of the bumper.

10. Repeat steps 8 and 9 on the passenger side (Fig.R) with the exception of bolting behind the tie down plate and using the formed plate as a backing plate which fits in the tie down plate (Fig.S).



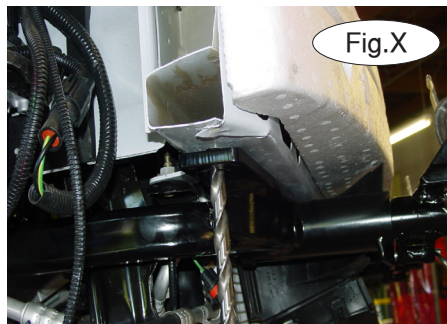
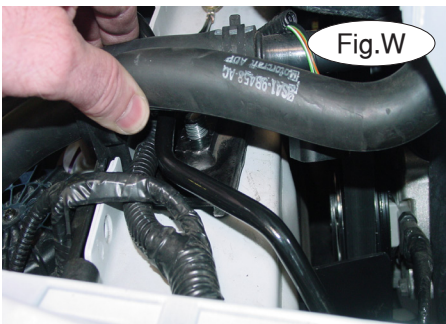
MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS



11. Insert the front braces into the rear braces and lock into position. Measure across the front mounting holes and align to 30" O.C for the outer holes and 27" O.C on the inner holes. Also check for the center. Once aligned, clamp the receiver braces in position (Fig.T).

12. On the passenger side use the receiver brace as a template and drill through the frame from bottom to top with a long 1/2" drill bit (Fig.U). Check the top of the frame for lines and use a protective plate when drilling.

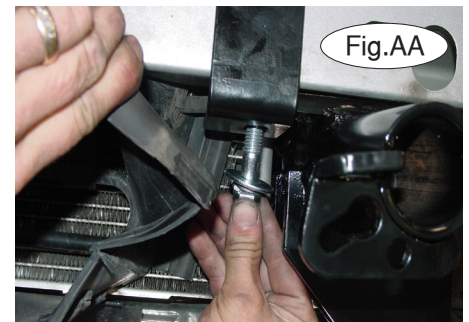
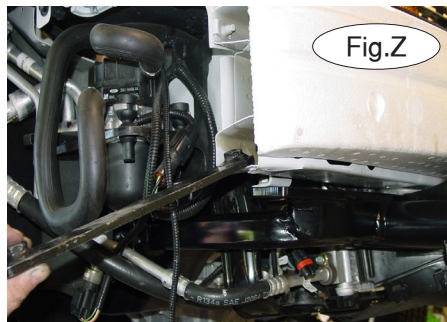
13. Bolt through the brace and the frame with a 1/2" x 5/4" bolt, lock washer and a threaded 1/4" x 2" x 3 1/2" backing plate on top of the frame (Fig.V). Tighten until the lock washer is flat, about 40-ft./lb. *Note:* check and be sure none of the tubing and wiring will chafe against the backing plate or bolt (Fig.W).



14. Drill two more 1/2" holes through the bottom of the bumper core on each side using the front of the braces as drill templates (Fig.X).

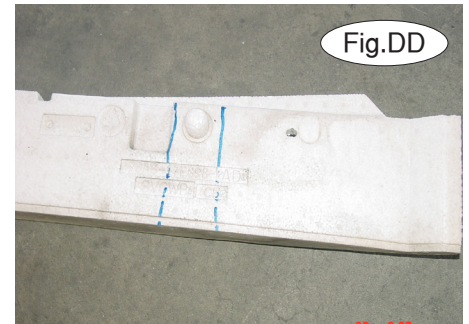
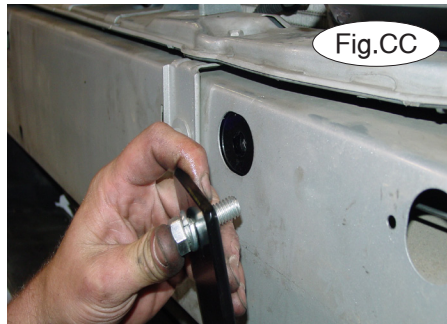
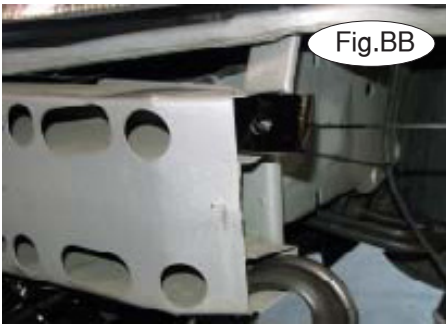
15. Remove the bumper core end plates if present (10mm head screws) (Fig.Y) then insert 1/4" x 1 1/4" x 11 1/8" threaded backing plates into each end of the bumper core over the drilled holes (Fig.Z).

16. Bolt through the outside mounting holes to the bumper core with 7/16" x 2" bolts, flat washers and lock washers then hold the L shaped upper brace over the inner mounting hole and bolt through it, the receiver brace and the bumper core with 7/16" x 2" bolts (Fig.AA).





MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS



17. Insert a 3/16" x 1½" x 2½" threaded backing plate into the bumper core (Fig.BB) and bolt through the top of the upper brace with a ½" x 1¼" bolt and lock washer into the threaded backing plate (Fig.CC).
18. Tighten all mounting bolts to the torque specifications below then remove the front braces.
19. The radiator air duct sides will be bent between the braces at this point. You may leave it this way or trim the side flaps to fit around the braces; if you choose to trim them, do so now .
20. Trim the energy absorption foam to fit around the upper braces (Fig.DD).



21. Replace the air filter box and plenum reversing steps 5 through 6 with exception of the front of the plenum, which will be left off (Fig.EE).
22. Trial fit the fascia, then mark and cut the grille to clear the braces.
23. Refit the fascia, reversing steps 2 through 8 (Fig.FF).
24. Install the tubular front braces by holding them with the front mounting angles pointing up, push in until engaged, then twist 90 degrees to the outside of the vehicle. Lock in place with the provided safety pins (Fig.GG).
25. Mount the tow bar following the manufacturer's instructions.
26. Attach the safety 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.