



MOUNTING BRACKET KIT INSTALLATION INSTRUCTIONS

ROADMASTER, INC.

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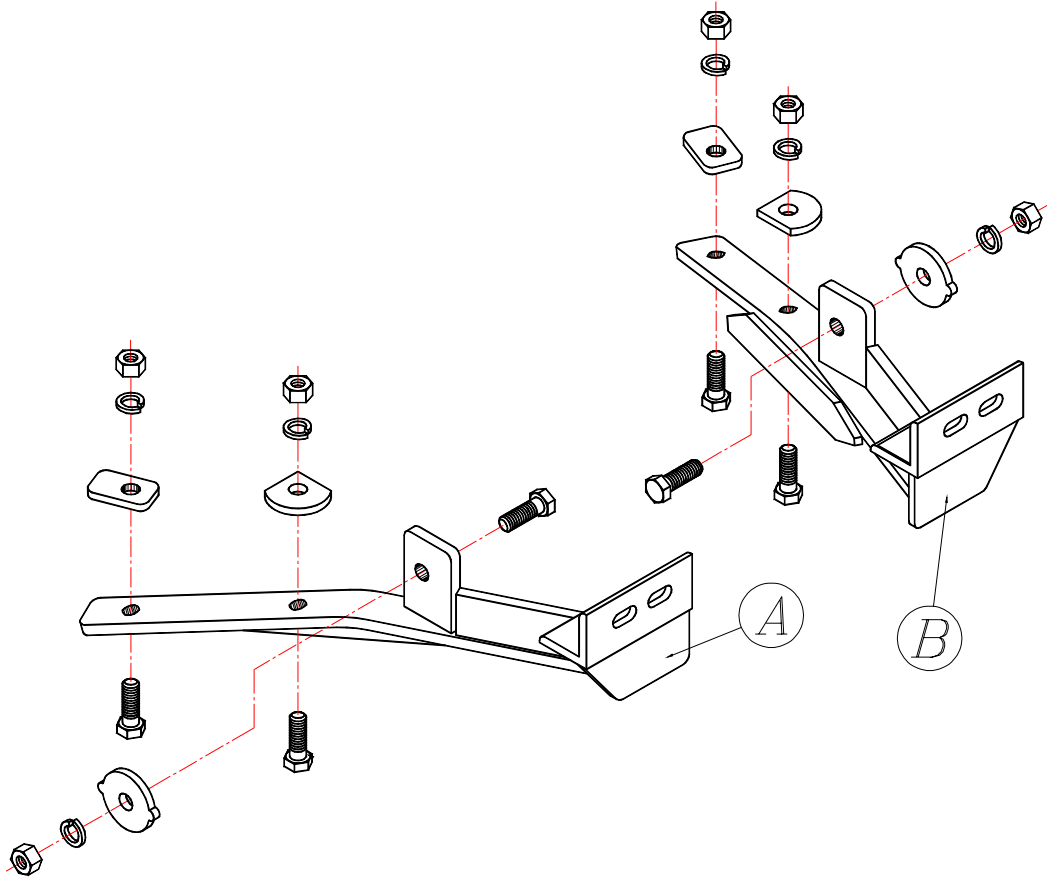
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PARTS LIST:

1- MAIN BRACE (A) - Passenger side

1- MAIN BRACE (B) - Driver's side

KIT NO. 2502-2



12-11-97

CAUTION

SAFETY CABLES MUST CONNECT THE TOWING VEHICLE TO THE TOWED VEHICLE FRAME TO FRAME. FOLLOW SAFETY INFORMATION IN WARRANTY PACKET

WARNING:

- **DO NOT** USE THIS DOCUMENT FOR CUSTOM FABRICATION AS THIS ILLUSTRATION MAY NOT SHOW ALL PARTS OR STRUCTURAL COMPONENTS.
- **ROADMASTER WILL NOT BE RESPONSIBLE** FOR ANY DAMAGE OR INJURY RESULTING FROM ANY MODIFICATION OR ALTERATION.
- **OWNER MUST INSPECT ALL MOUNTS AND BRACKETS BEFORE EACH USE** FOR CRACKS OR OTHER SIGNS OF FATIGUE. ALSO INSPECT FASTENERS FOR PROPER TORQUE.

CAUTION: FAILURE TO FOLLOW THESE INSTRUCTIONS CAN RESULT IN DEATH, PERSONAL INJURY OR PROPERTY DAMAGE

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



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Congratulations! You have just purchased another fine Roadmaster product. Thank you.

1. This bracket uses the existing tie down plates on each side and the lower frame as mounting points. The lower plastic grill may have to be trimmed for the braces. Remove the two outer bolts on each side from the lower plastic grill.
2. Bolt the braces to the tie downs on each side using 1/2" x 2" bolts, plate washers, lock washers and nuts.
3. Align the braces, making sure the front of the braces are parallel and the outer mounting holes measure 30" center to center and the inner holes measure 27" center to center. Tighten at this time to hold the position. The front lower holes in the braces should line up with the bolt holes that were removed in step 1.
4. Trim the plastic to fit the braces at this time, then using the braces as templates, drill through the two lower mounting holes on each brace with a 1/2" bit. This will enlarge the front frame holes and create one new hole for each brace.
5. Bolt through the front brace mounting holes on each side using a 1/2" x 1 1/2" bolt, 1/2" clipped plate washer, lock washer and nut. Use the clipped plate washers as backup washers in the frame.
6. Bolt through the rear brace mounting holes on each side using a 1/2" x 1 1/2" bolt, 1/2" x 1 1/4" x 2" backing plate, lock washer and nut.
7. Mount the tow bar according to the manufacturers instructions, then tighten all bolts to the specifications below.

12-11-97

HARDWARE LIST:

- 4-1/2" X 1 1/2" BOLTS
- 2-1/2" X 2" BOLTS
- 6-1/2" NUTS
- 6-1/2" LOCK WASHERS
- 2-1/2" PLATE WASHERS
- 2-1/2" CLIPPED PLATE WASHERS
- 2-1/4" X 1 1/4" X 2" BACKING PLATES

CAUTION:

Installer must read instructions and use all bolts and parts supplied.

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BOLT TORQUE REQUIREMENTS

STANDARD BOLTS			METRIC BOLTS			METRIC BOLTS		
SIZE	GRADE	TORQUE	SIZE	GRADE	PLATED / UNPLATED	SIZE	GRADE	PLATED / UNPLATED
5/16	5	13 ft./lb.	M 8-1.0	8.8	20 ft./lb. 18ft./lb.	M 12-1.25	8.8	70 ft./lb. 65ft./lb.
3/8	5	23 ft./lb.	M 8-1.25	8.8	19 ft./lb. 18ft./lb.	M 12-1.5	8.8	66 ft./lb. 61ft./lb.
7/16	5	37 ft./lb.	M 10-1.25	8.8	38 ft./lb. 36ft./lb.	M 12-1.75	8.8	65 ft./lb. 60ft./lb.
1/2	5	56 ft./lb.	M 10-1.5	8.8	37 ft./lb. 35ft./lb.	M 12-2.0	8.8	104 ft./lb. 97ft./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.