



## INSTALLATION OF REAR MOUNTING KIT

### SAFETY PRECAUTIONS

**If any installation problems are encountered, please call G&B Specialties, Inc. for technical assistance before continuing with the installation process.**



- Failure to heed to any of the following warnings could result in severe bodily injury and/or equipment damage.
- Read and understand this manual completely before attempting installation of the equipment.
- Installation instructions provided below only address the Rafna railgear equipment. Applicable railway company procedures and policies must be adhered to.
- Before performing any work under the vehicle or railgear, ensure the engine is turned off and the parking brake is set.
- Ensure all removed components are given to the vehicle owner after the installation of the railgear. These components must be re-installed if the railgear is removed from the vehicle.
- Always disconnect the vehicle's battery when welding on the vehicle or railgear in order to protect the vehicle's electrical system.



**INSTALLATION OF REAR MOUNTING KIT**

The following procedure details the installation of the rear mounting kit. The hardware required for this installation is listed in table 1.

Table 1: Rear Mounting Kit Installation Parts

<b>Part Number</b>	<b>Description</b>	<b>Qty</b>
R-1832L	Rear Mounting Bracket (Left Side)	1
R-1832R	Rear Mounting Bracket (Right Side)	1
R-1828	Bumper Extension	2
R-1794-1	Railgear Mounting Shim – 0.25” Thick	4
R-1794-2	Railgear Mounting Shim – 0.375” Thick	4
R-1794-3	Railgear Mounting Shim – 0.5” Thick	4
	½” UNC Gr.8 Bolt x 4.5” Long	6
	½” Gr.8 Washer	12
	½” UNC Gr. 8 Nylon Insert Lock Nut	6

1. Remove the original spare tire from under the vehicle’s cargo box if so equipped. The original spare tire will not be re-installed.
2. Remove the rear bumper and rear bumper brackets from the frame. Retain the rear bumper and related hardware for re-installation.
3. Slide each rear-mounting bracket onto the frame, from the underside as shown. The ½” hole in the side of each rear mounting bracket should align with the hole in the side of the frame inside the cross member. The “U” shape of the rear-mounting bracket should fit tightly against the bottom, inside and outside of the frame. Clamp the brackets in place.
4. Fasten each rear mounting bracket to the side of the frame, using the provided hole in each mounting bracket, with one ½” x 4.5” long bolt, two ½” washers, and one ½” nut.
5. Drill two holes through each rear mounting bracket and frame as shown, in order to accommodate two ½” x 4.5” long bolts. The holes should be positioned at the center of each frame rail height wise. The most forward hole should be 3.75” from the most forward edge of each rear mounting bracket and the holes should be drilled 3” apart.
6. Fasten each rear mounting bracket to the frame with two ½” x 4.5” long bolts, four ½” washers, and two ½” nuts. Remove the clamps.
7. Torque the ½” fasteners to 100 ft-lbs dry. Do not over torque.



8. The supplied railgear mounting shims are to be used as required when mounting the railgear to the rear mounting brackets.

Following the Railgear installation, the rear bumper will not fit in its original position. Rafna supplies rear bumper extensions to move the rear bumper further out, in order for it to fit over the railgear with minimal trimming required as described in the following steps.

9. Position the rear bumper extensions in line with the end of the frame, as shown. The portion of the rear bumper extension with one hole should be closest to the frame.
10. Weld the rear bumper extensions onto the vehicle frame.
11. Re-install the vehicle rear bumper on the rear bumper extensions with the original fasteners.
12. Torque the original fasteners to OEM specifications.
13. The installer may have to trim the bumper to avoid any interference between the railgear and the bumper.
14. The installer may fabricate a cover plate made of aluminium tread plate to cover the gap between the bumper and the vehicle body.



**NOTES:**

1. LEFT SIDE SHOWN

**WEIGHT (LBS):**

  
  

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TOLERANCE UNLESS SPECIFIED: PAPER: ±0.005"  
MATERIAL: ±0.007"  
DECIMAL PLACES: 0.001"  
DIMENSIONS: ±0.001"  
ALL DIMENSIONS SHEET IS IN INCHES

  
  

ITEM	PART No.	DESCRIPTION	QTY
1	R-1832L	REAR MOUNTING BRACKET - LEFT SIDE	1
2	R-1832R	REAR MOUNTING BRACKET - RIGHT SIDE (NOT SHOWN)	1
3	R-1828	BUMPER EXTENSION	2
4	R-1794-1	RAILGEAR MOUNTING SHIM - 0.25" THICK (USE AS REQUIRED)	4
5	R-1794-2	RAILGEAR MOUNTING SHIM - 0.375" THICK (USE AS REQUIRED)	4
6	R-1794-3	RAILGEAR MOUNTING SHIM - 0.5" THICK (USE AS REQUIRED)	4
7	-	1/2" UNC GR.8 BOLT X 4.5" LONG	6
8	-	1/2" GR.8 WASHER	12
9	-	1/2" UNC GR.8 NYLON INSERT LOCK NUT	6
10	-	VEHICLE FRAME	N/A

  
  

**REF:**

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**CHANGE BY DATE**

**DESCRIPTION:**

**REAR MOUNTING KIT**

**REVISION:** MER DATE: NOV/19/04  
**PART NUMBER:** K-M15XRDR003 10