

INSTALLATION, OPERATION, AND SERVICE, OF REAR MOUNTING KIT 2017 AND UP FORD F-250/350

INSTALLATION, OPERATION, AND SERVICE 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, or operation of the equipment.
- Installation instructions provided below only address the RAFNA railgear equipment. Applicable railway company procedures and policies must also 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.
- Operating instructions provided below only address the RAFNA railgear equipment. Applicable railway company procedures and policies must be adhered to.
- Railway Company rules governing rail travel must be observed at all times.
- Never operate the vehicle if the Gross Vehicle Weight Rating (GVWR), Gross Axle Weight Rating Front or Rear (GAWR), or the wheel or tire load ratings are exceeded.

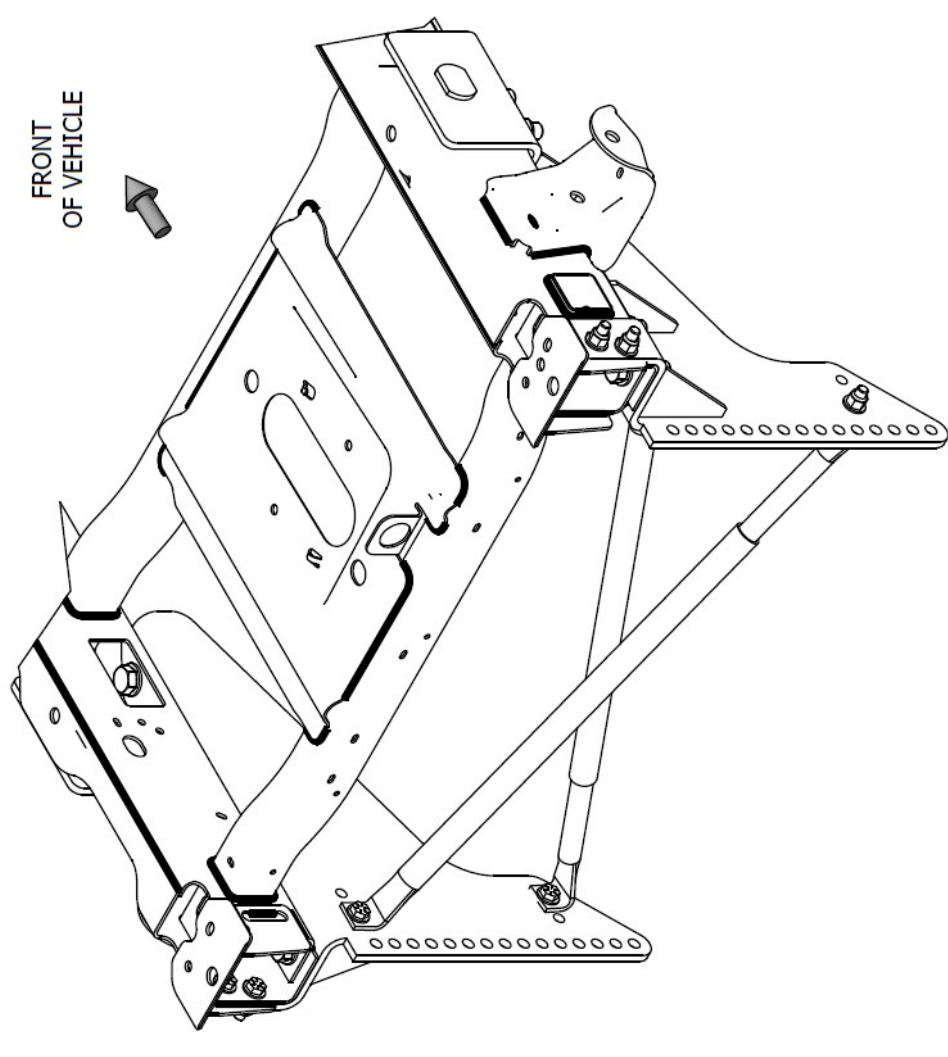
INSTALLATION OF REAR MOUNTING KIT

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

Rafna Industries Ltd.				29-Oct-18
HR K-M37XRFR17 Rear Mounting Kit FORD 2017 & Up				Rev. C
Vehicle Application Chart				
Year	Make	Model #	Model	
2017 & Up	Ford		F250/F350 Pick Up Trucks	
Part Number	Description	# Req.	Remarks	Check
R-30180DA	Rear Mounting Bracket Drivers Side	1		
R-30180PA	Rear Mounting Bracket Passengers Side	1		
R-31918	Outer Brace	2		
R-31919	Inner Brace	2		
R-33568	Screw, 7/8" X 2" Hex Machined Head	2		
R-990KIT-391	1/2" UNC Gr. 8 Bolt x 1.75" Long	6	RAILGEAR	
	1/2" Gr. 8 Washer	12		
	1/2" UNC Gr. 8 Nylon Insert Lock Nut	6		
R-990KIT-299D	1/2" UNC Gr. 8 Bolt x 1.75" Long	8	MOUNTING BRACKETS AND CROSS BRACE	
	1/2" Gr. 8 Washer	16		
	1/2" UNC Gr. 8 Nylon Insert Lock Nut	8		
	3/4" UNC Gr. 8 Bolt x 2.50" Long	8		
	3/4" Gr. 8 Washer	16		
	3/4" UNC Gr. 8 Nylon Insert Lock Nut	8		
	7/8" UNC Gr. 8 Nylon Insert Lock Nut	2		
	7/8" Gr. 8 Washer	2		
MIO-M37XRFR17	Mounting Kit Installation/Operations Manual	1		

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 tow hitch. The tow hitch will not be re-installed.
3. Place each rear mounting bracket against the underside and outside of the frame rails as shown.
4. Secure each mounting bracket to the bottom side of the frame rail as shown using the supplied 3/4" hardware.
5. Secure the mounting bracket to the outer frame rail using the supplied 1/2" hardware and 7/8" hardware.
6. Assemble the outer and inner braces by inserting the inner brace into the outer brace.

7. Using the supplied 1/2" hardware, attach the braces to the mounting brackets as shown. The upper half of the mounting bracket may be mounted to the frame for increased rigidity (not shown).
8. Use appropriate welding procedures and welding electrodes for mild steel. Weld diagonal cross braces together at their telescoping intersection using 3/16" fillet weld. At the cross braces intersection point weld all around using 3/16" fillet weld.



FRONT
OF VEHICLE

BILL OF MATERIAL/PARTS LIST			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	R-30180DA	REAR MOUNTING BRACKET DRIVERS SIDE	1
2	R-30180PA	REAR MOUNTING BRACKET PASSENGERS SIDE	1
3	R-31918	OUTER BRACE	2
4	R-31919	INNER BRACE	2
5	R-33568	SCREW, 7/8" x 2" HEX MACHINED HEAD	2
6	-	1/2" UNC GR. 8 BOLT x 1.75" LONG	14
7	-	1/2" GR. 8 WASHER	28
8	-	1/2" UNC GR. 8 NYLON INSERT LOCK NUT	14
9	-	3/4" UNC GR. 8 BOLT x 2.5" LONG	8
10	-	3/4" GR. 8 WASHER	16
11	-	3/4" UNC GR. 8 NYLON INSERT LOCK NUT	8
12	-	7/8" GR. 8 NYLON INSERT LOCK NUT	2
13	-	7/8" GR. 8 WASHER	2



HARDWARE KIT: R-990KIT-391
HARDWARE KIT: R-990KIT-391


G&B SPECIALTIES INC.
MANUFACTURER OF QUALITY RAILROAD PRODUCTS
BERWICK, PENNSYLVANIA (570) 752-5901 FAX (570) 752-6397

DESIGN - ENGINEERING - MANUFACTURING

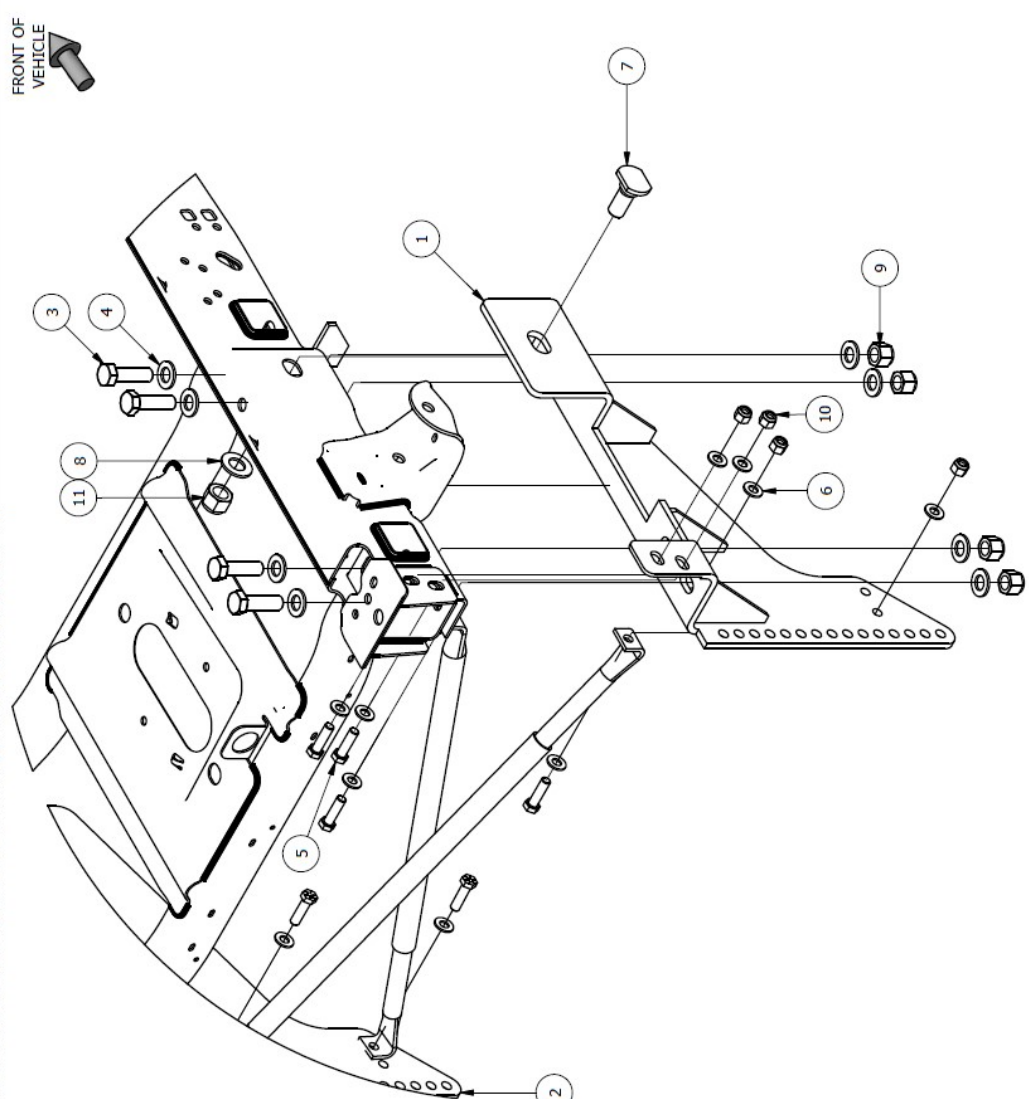
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DATE: 08/19/16
PART NUMBER: R3071 MECHANICAL
REV: 1
K: MIO-M37XRFR17-1
B

APPROVED:  JL
DRAWN:  JL

CHECKED:  JL

FRONT OF VEHICLE



ITEM	PART NUMBER	DESCRIPTION	QTY
1	R-30180P	REAR MOUNTING BRACKET P.S.	1
2	R-30180D	REAR MOUNTING BRACKET D.S.	1
3	-	3/4" UNC. GR. 8 HHCS X 2.5" LG	8
4	-	3/4" GR.8 FLAT WASHERS	16
5	-	1/2" UNC GR. 8 HHCS X 1.75" LG	4
6	-	1/2" GR.8 FLAT WASHERS	8
7	R-33261	SCREW, 7/8" X 2" MACHINED HEAD	2
8	-	7/8" GR. 8 FLAT WASHERS	2
9	-	3/4" UNC GR. 8 NYLON INSERT LOCK NUT	8
10	-	1/2" UNC GR. 8 NYLON INSERT LOCK NUT	4
11	-	7/8" UNC GR. 8 NYLON INSERT LOCK NUT	2

HARDWARE KIT: R-990KIT-299D

CURRENT VIEW IS OF REAR OF VEHICLE, PASSENGERS SIDE. DRIVERS SIDE BRACKET IS A MIRROR IMAGE OF PASSENGERS SIDE BRACKET.

DESIGN - ENGINEERING - MANUFACTURING

DATE: 08/19/16

REV: 2

REVISED: 08/19/16

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REAR MOUNTING
R307A MECHANICAL

REVISIONS

REV	DATE	DESCRIPTION
1	08/19/16	REVISED FOR PASSENGER SIDE

OPERATION AND SERVICE OF REAR MOUNTING KIT

With the rear mounting kit installed on this vehicle, it may be operated as normal.

Never operate the vehicle if the Gross Vehicle Weight Rating (GVWR), Gross Axle Weight Rating Front or Rear (GAWR), or the wheel or tire load ratings are exceeded.

The rear mounting kit must be serviced regularly to avoid damage to the equipment. Table 1 below provides the Recommended Service Schedule and Table 2 provides Standard Fastener Torque Values.

Table 1: Recommended Service Schedule

Service Required	Initial 100 km (62 Miles) of road and/or rail use	6 Months
Inspect rear mounting kit fasteners (re-torque if required)		✓

Table 2: Standard Fastener Torque Values

Fastener Size	Fastener Torque Value (ft-lbs) Dry
1" UNC Gr. 8 Fasteners	250
¾" UNC Gr. 8 Fasteners	175
⅝" UNC Gr. 8 Fasteners	150
½" UNC Gr. 8 Fasteners	100
⅜" UNC Gr. 8 Fasteners	40
¼" UNC Gr. 8 Fasteners	12