

INSTALLATION OF REAR MOUNTING KIT 2011-2019 GM HD LONG BED W/O TOW HITCH

INSTALLATION 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.
- 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

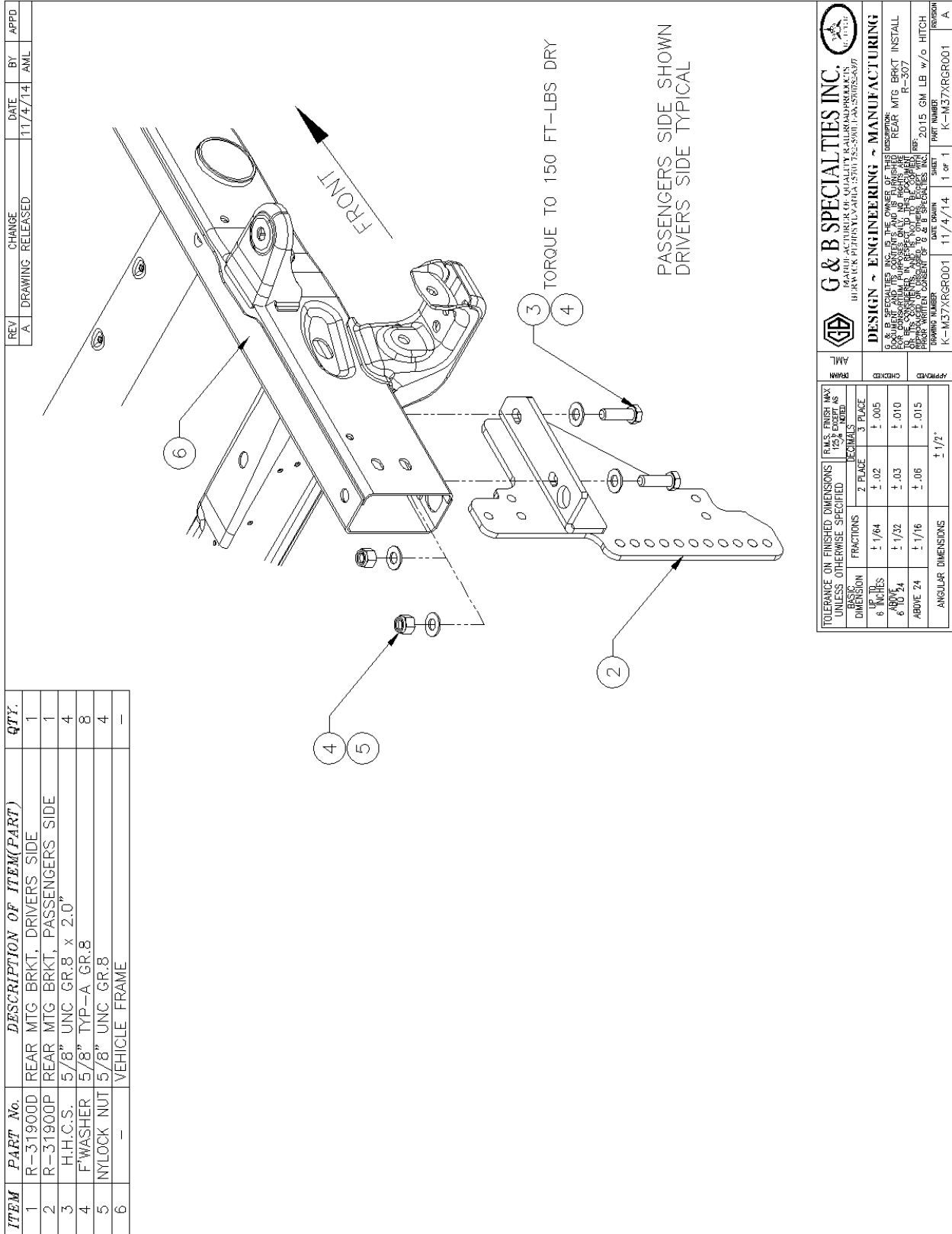
The following procedure details the installation of the front mounting kit. The hardware required for this installation is listed in the table below.

Rear Mounting Kit Installation Parts

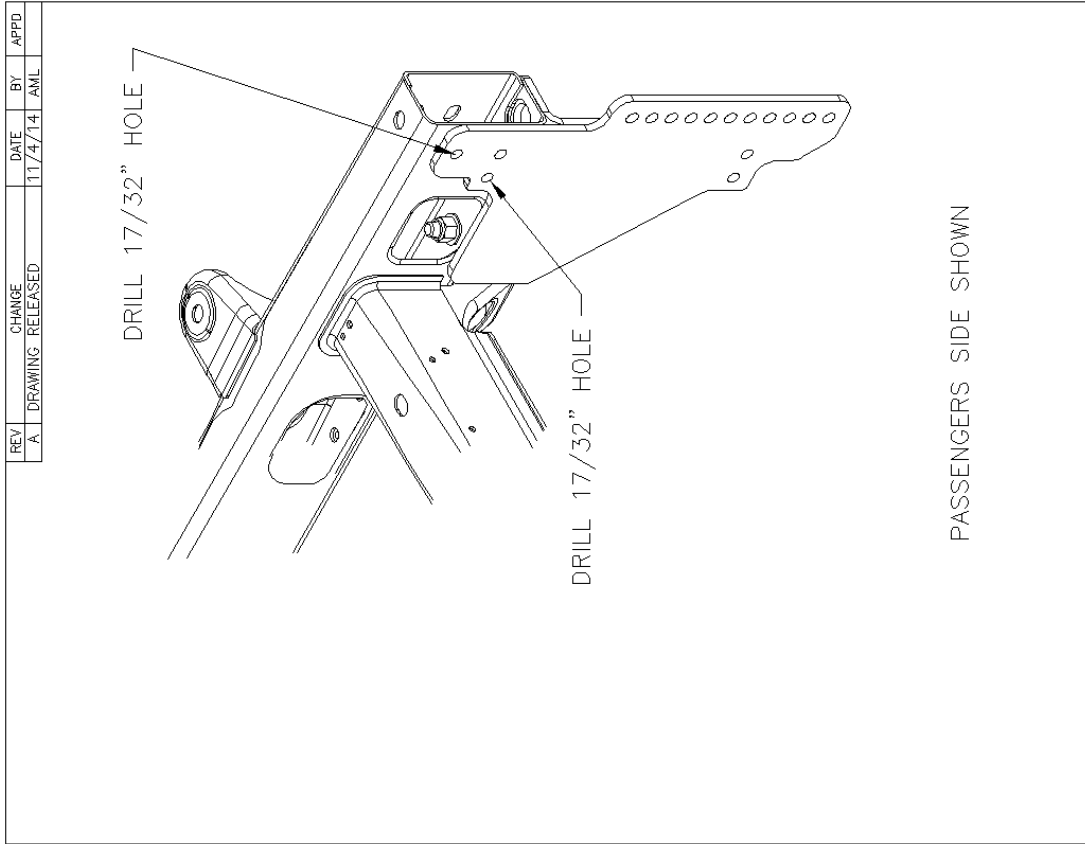
Part Number	Description	Qty
R-31900D	Rear Mounting Bracket, Drivers Side	1
R-31900P	Rear Mounting Bracket, Passengers Side	1
R-31908	Outer Brace	2
R-31909	Inner Brace	2
R-990KIT-391 (Railgear Mtg)	1/2" UNC Gr. 8 Bolt x 1.75" Long	6
	1/2" Gr. 8 Type-A Flat Washer	12
	1/2" UNC Gr. 8 Nylon Insert Lock Nut	6
R-990KIT-392 (Mtg Brkts)	1/2" UNC Gr. 8 Bolt x 1.75" Long	6
	1/2" Gr. 8 Type-A Flat Washer	12
	1/2" UNC Gr. 8 Nylon Insert Lock Nut	6
	5/8" UNC Gr. 8 Bolt x 1.75" Long	4
	5/8" Gr. 8 Type-A Flat Washer	8
	5/8" UNC Gr. 8 Nylon Insert Lock Nut	4

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 inside of the frame rails as shown.
4. Secure each mounting bracket to the bottom side of the frame rail as shown using the supplied 5/8" hardware.
5. Using the mounting brackets as a guide, drill 17/32" diameter holes thru the inner frame rail as shown. The hole location is different for the passenger and driver's side.
6. Secure the mounting bracket to the inner frame rail, at the top most hole location, using the supplied 1/2" hardware.
7. Assemble the outer and inner braces by inserting the inner brace into the outer brace.
8. Using the supplied 1/2" hardware, attach the braces to the mounting brackets and frame rail as shown.
9. The cross braces are to be welded to each other at the point where cross and at the point where the inner brace is inserted into the outer brace.

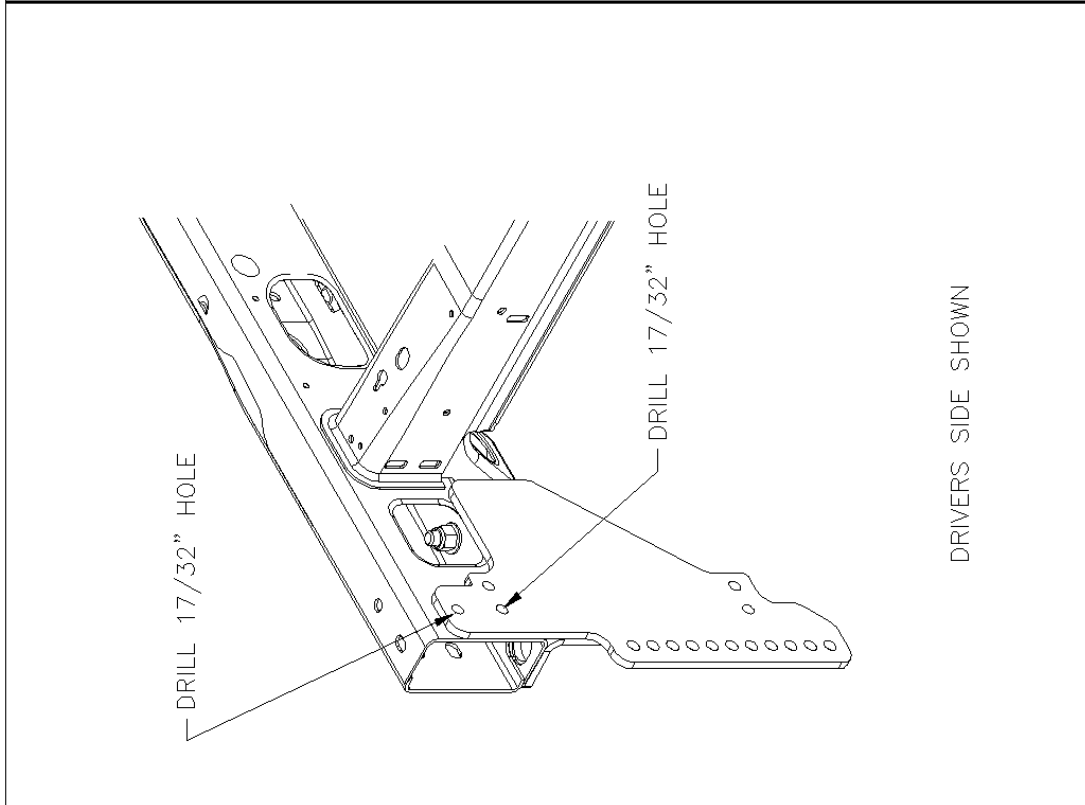
10. Re-install rear bumper. It may be necessary to remove, then re-install, the rear most 5/8" bolt to reinstall the rear bumper mounting bracket.



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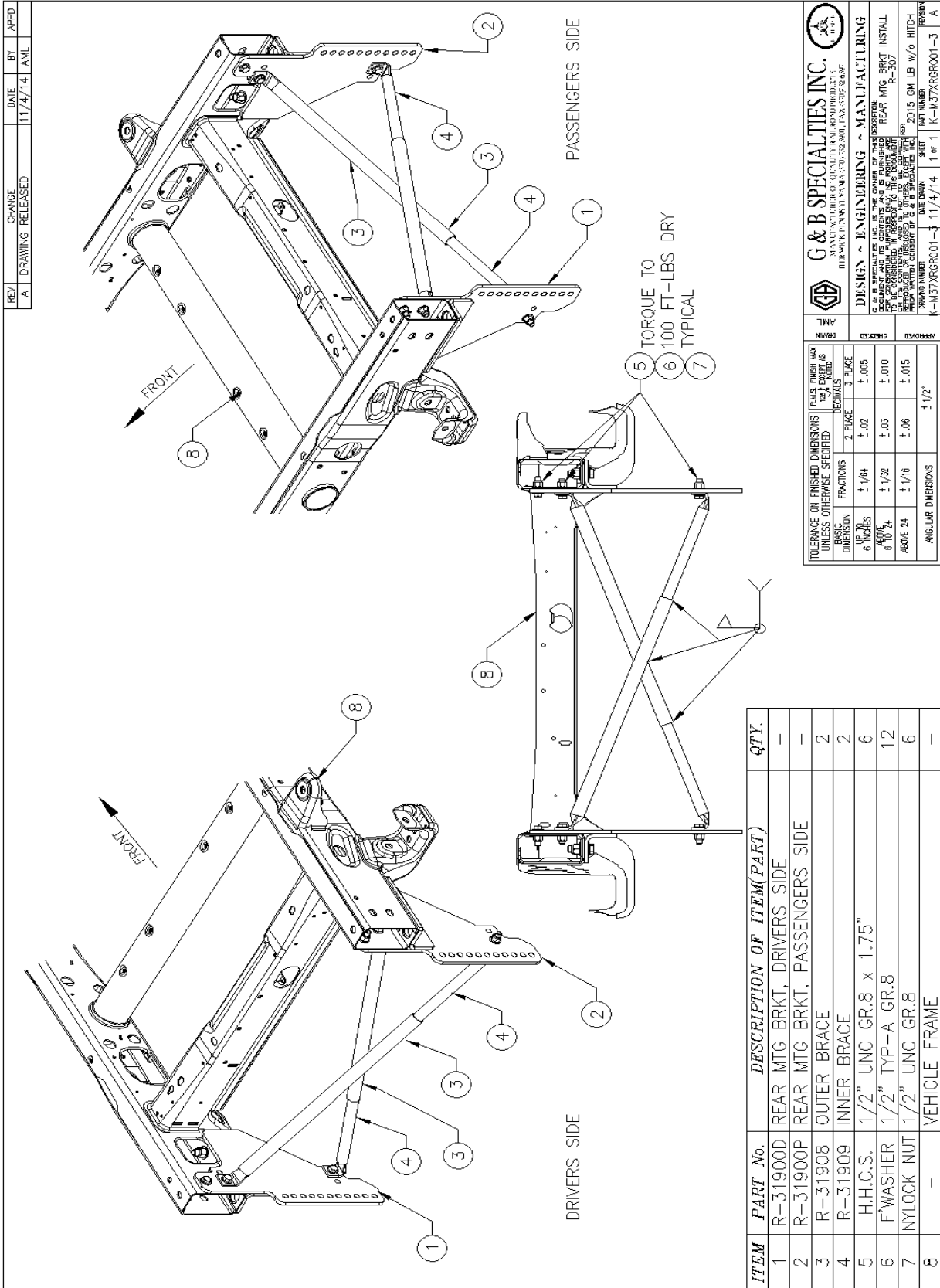


PASSENGERS SIDE SHOWN



DRIVERS SIDE SHOWN

G & B SPECIALTIES INC. MANUFACTURER OF QUALITY RAILROAD BRACKET BERWICK, PENNSYLVANIA 17701-7525-5901 FAX: 570-752-6397	
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TOLERANCE ON FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED DIMENSION 6 INCHES & ABOVE 6 TO 24 ABOVE 24 ANGULAR DIMENSIONS	FRACTIONS ± 1/64 ± 1/32 ± 1/16 ± 1/2°
DECIMALS 2 PLACE ± .02 ± .03 ± .06	3 PLACE ± .005 ± .010 ± .015
CHECKED DATE DRAWN 11/7/14	APPROVED 1 of 1
DRAWING NUMBER K-M37XRGR002	PART NUMBER K-M37XRGR002
SHEET 1 of 1	REVISION A



REV	CHANGE	DATE	BY
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<p>REAR MTG BRKT INSTALL R-307</p>	
<p>2015. GM LB #/G HITCH</p>	
<p>FORWARD NUMBER DATE DRAWN SHEET 11/4/14 1 of 1 K-M37XRGR001-3 A</p>	

TOLERANCE ON FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED		FRAC TIONS	UP TO 6 INCHES	ABOVE 6 TO 24	ABOVE 24	ANGULAR DIMENSIONS
1 PLACE	± .02	± .005	± .010	± .015	± 1/2°	
2 PLACE	± .02	± .005	± .010	± .015		
3 PLACE	± .02	± .005	± .010	± .015		

OPERATION & SERVICE OF REAR MOUNTING KIT 2015-2019 GM HD LONG BED W/O TOW HITCH

OPERATION & SERVICE SAFETY PRECAUTIONS

If any operating, services or parts problems are encountered, please call G&B Specialties, Inc. for technical assistance.



- 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 operation of the railgear equipped 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.
- Before performing any work under the vehicle or railgear, ensure the engine is turned off and the parking brake is set.
- 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.

OPERATION & 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
3/4" UNC Gr. 8 Fasteners	175
5/8" UNC Gr. 8 Fasteners	150
1/2" UNC Gr. 8 Fasteners	100
3/8" UNC Gr. 8 Fasteners	40
1/4" UNC Gr. 8 Fasteners	12