

**INSTALLATION OF R-290 REAR MOUNTING KIT  
2017-PRESENT FORD F-350 4X2/4X4 CHASSIS CAB, SRW, MID-SHIP  
FUEL TANK ONLY, GAS**

**INSTALLATION SAFETY PRECAUTIONS**

If any installation problems are encountered, please call G&B Specialties 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.
- Do not start the vehicle with the power steering hoses disconnected. Reconnect all hoses and secure the power steering cooler if the vehicle is started.
- 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 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 rear mounting kit. The hardware required for this installation is listed in below table.

Part Number	Description	# Req.	Remarks
R-33351D	Rear Mounting Bracket, Drivers Side	1	
R-33351P	Rear Mounting Bracket, Passengers Side	1	
R-2960	Railgear Mounting Shim, ½"	4	
R-2960A	Railgear Mounting Shim, 1"	3	
R-33262	Machined Bolt	2	
990316-100-22	1" UNC Gr. 8 Nylon Insert Lock Nut	2	R-99KIT-425 Rear Mounting Bracket Install
990600-100-002	1" Gr. 8 Washer	4	
990727-225-22	1/2" UNC Gr. 8 Bolt x 2.250" Long	2	
990316-050-22	1/2" UNC Gr. 8 Nylon Insert Lock Nut	2	
900600-050-002	1/2" Gr. 8 Washer	4	
990729-225-22	5/8" UNC Gr. 8 Bolt x 2.25" Long	4	
990600-062-002	5/8" Gr. 8 Washer	8	
990316-062-22	5/8" UNC Gr. 8 Nylon Insert Lock nut	4	
990731-350-22	3/4" UNC Gr. 8 Bolt x 3.50" Long	4	R-990KIT-426 Railgear Mounting
990731-550-22	3/4" UNC Gr. 8 Bolt x 5.50" Long	4	
990731-600-22	3/4" UNC Gr. 8 Bolt x 6.00" Long	4	
990600-075-002	3/4" Gr. 8 Washer	8	
990316-075-22	3/4" UNC Gr. 8 Nylon Insert Lock Nut	4	

1. Place each rear mounting bracket against the underside and outside of the frame rails as shown, just over the rear spring hangers. The slot in the side of each rear mounting plate should align with the slot in the side of the frame. Attach bracket using location slot in frame.
2. A. Drill as shown on lower leg of frame rail on driver's side.  
 B. Drill two slots into the side of the frame, using the location slots on passenger side bottom of the mounting bracket to pressed up against bottom of the frame
3. Fasten each rear mounting bracket to the bottom of the frame as shown.

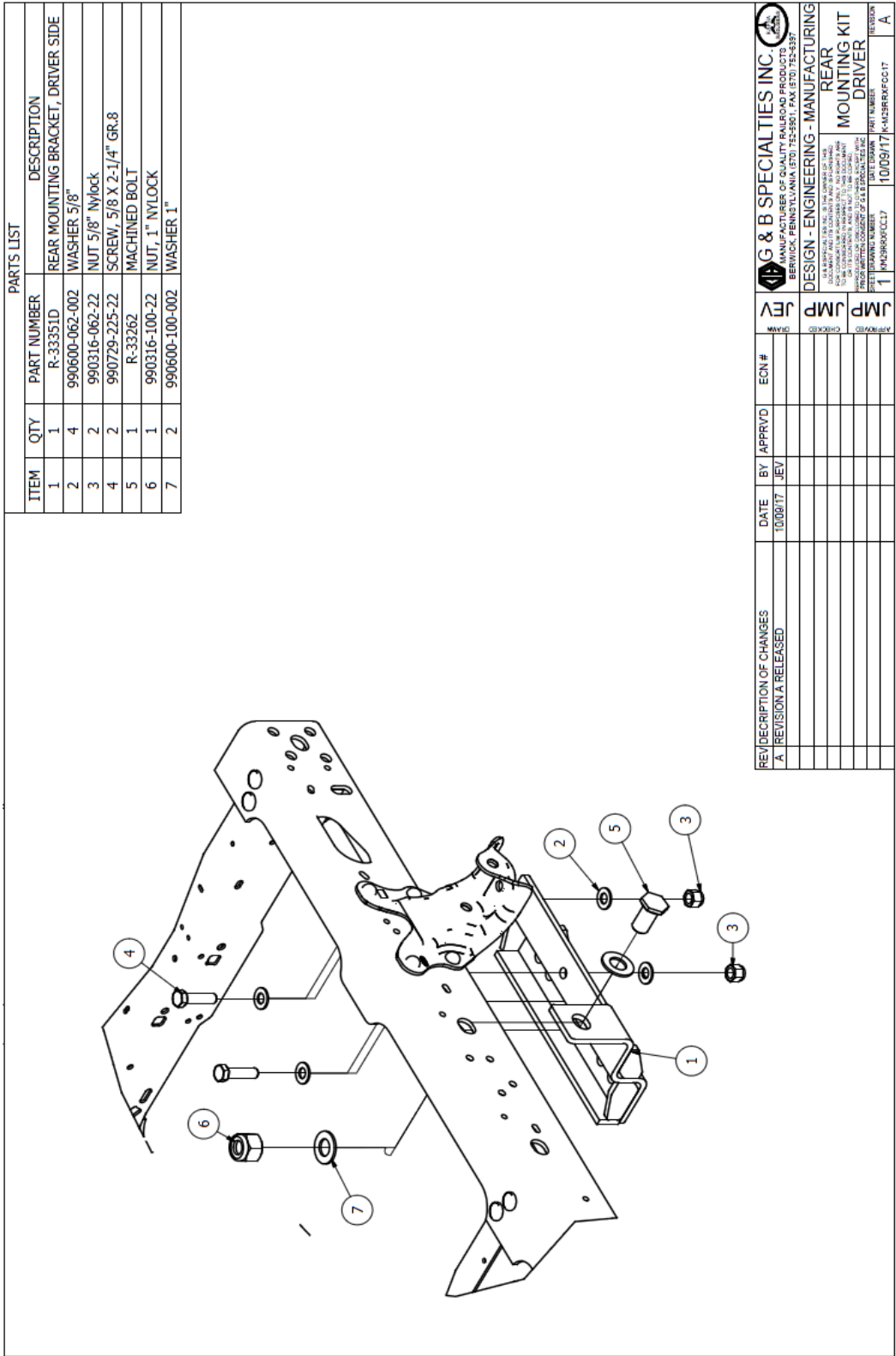


Figure 1

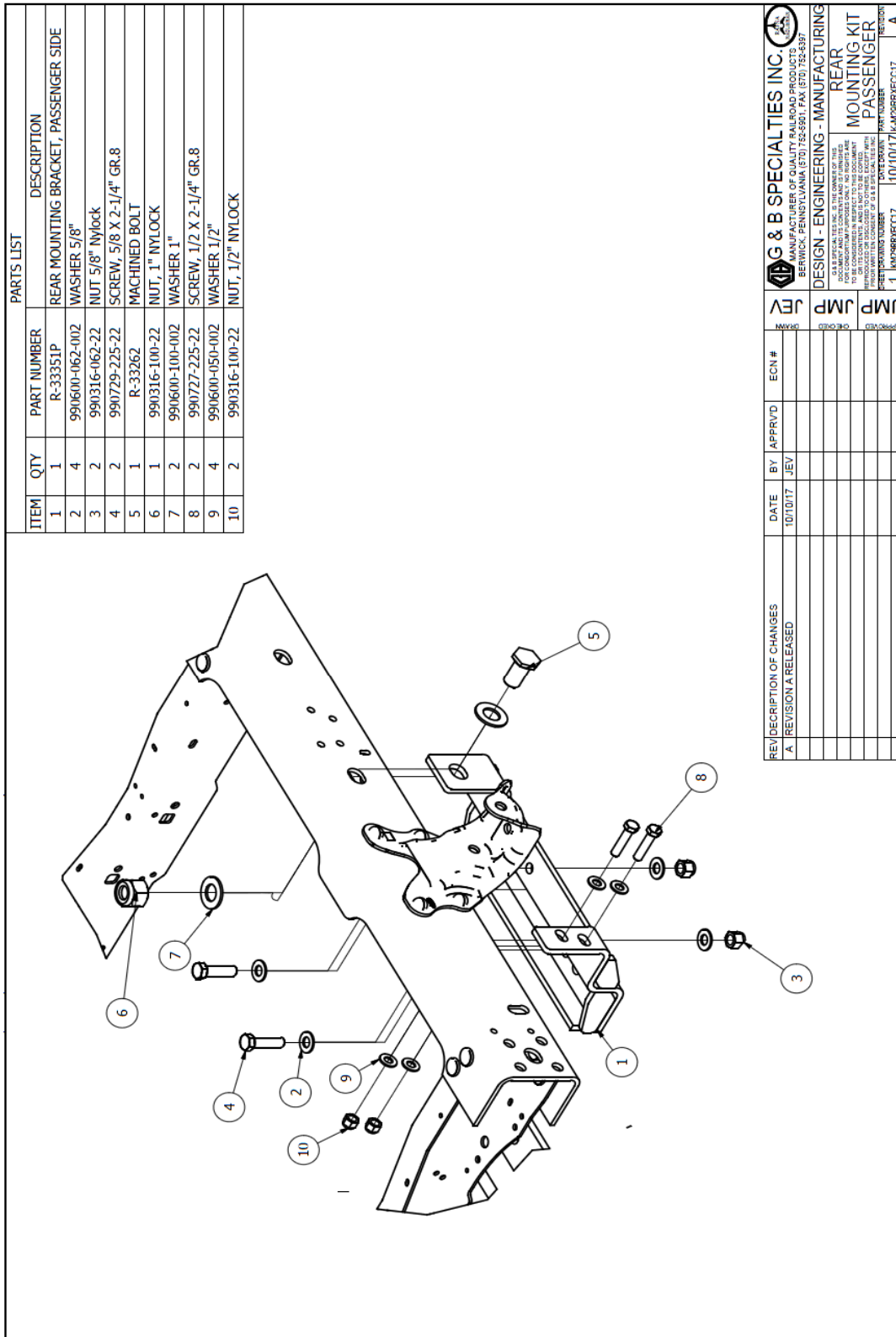


Figure 2

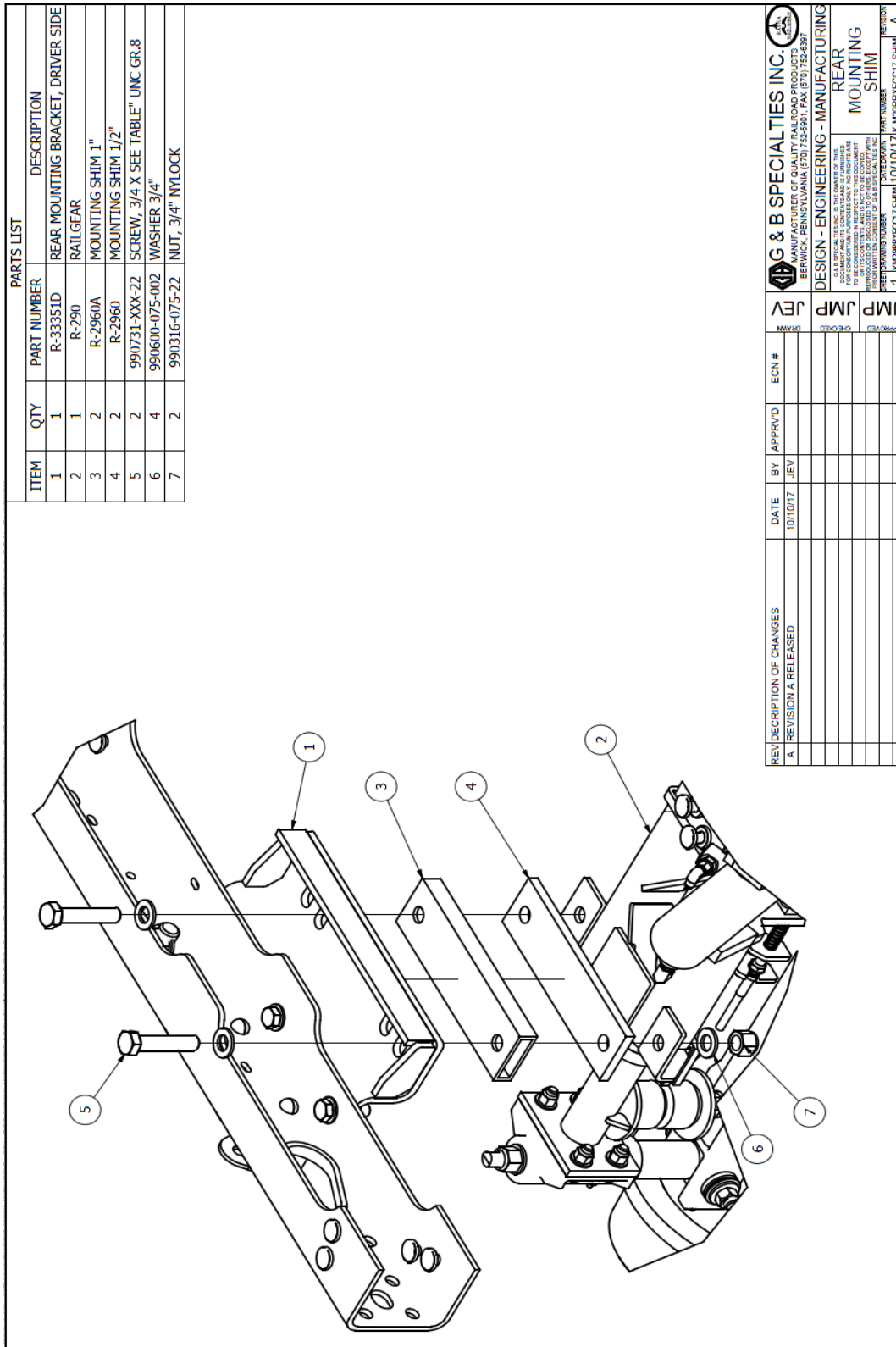


Figure 3

Table 1: F-350 to Shims and Bolt Relation

Model	Wheel Base (in)	Standard GVWR	Shims 1"	Shims 1/2"	Bolt Length
F-350 SuperCab 4x2	167.9	9800 SRW	1	1	3-1/2"
F-350 SuperCab 4x4	167.9	9800 SRW	3	1	5-1/2"
F-350 RegularCab 4x2	145.3	9800 SRW	1	1	3-1/2"
F-350 RegularCab 4x4	145.3	9800 SRW	3	1	6"
F-350 Crew Cab 4x2	179.7	9800 SRW	1	1	3-1/2"
F-350 Crew Cab 4x4	179.7	9800 SRW	3	1	5-1/2"

**OPERATION, SERVICE AND PARTS OF R-290 REAR MOUNTING KIT  
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**OPERATION 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.

<b>OPERATION AND SERVICE OF REAR MOUNTING KIT</b>
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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 2: Recommended Service Schedule**

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

**Table 3: 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