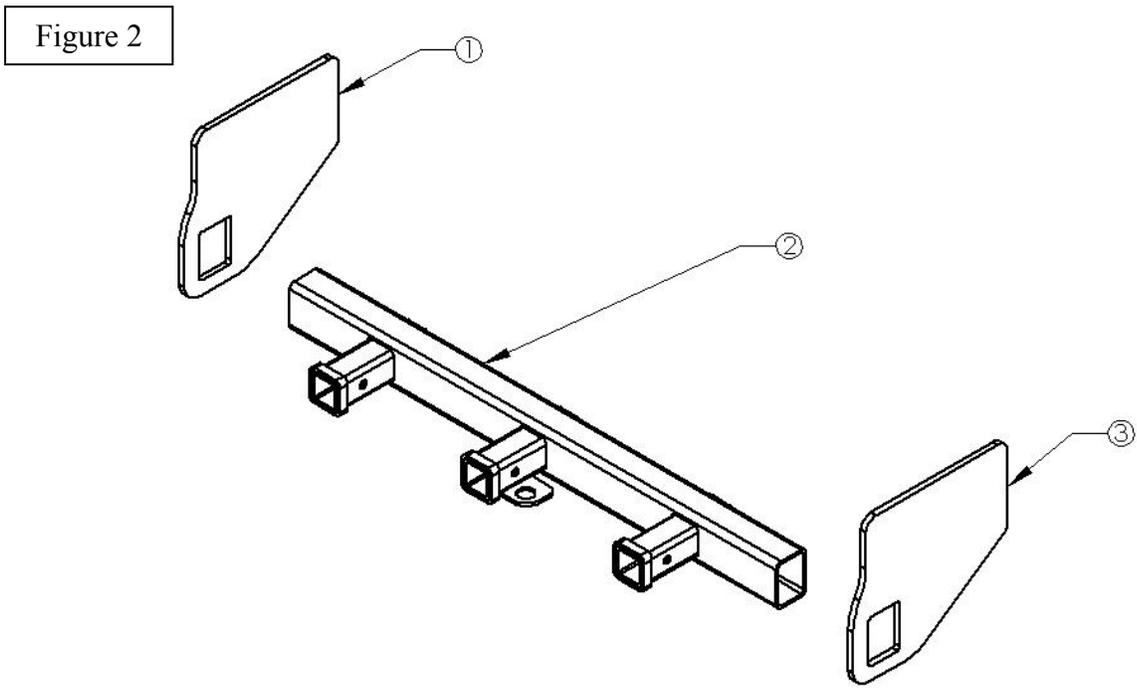
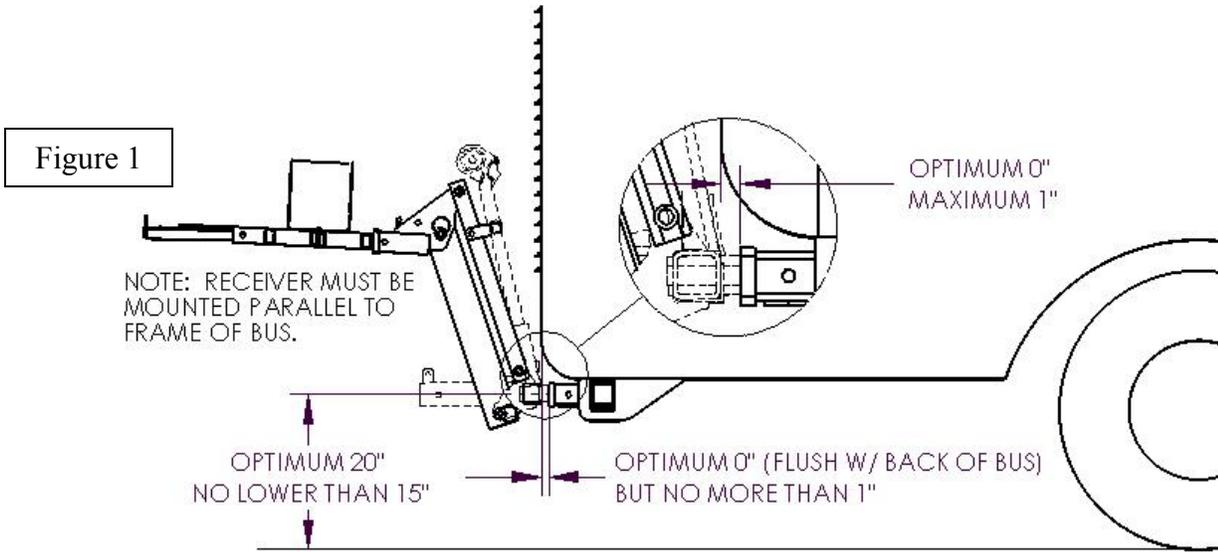


## Installation Instructions for Receiver Weldment



**Table 1**

| Item | Description                   |
|------|-------------------------------|
| 1    | Driver Side Weldment Plate    |
| 2    | Receiver Bar                  |
| 3    | Passenger Side Weldment Plate |

**Step 1)** Park coach on level ground such that rear bumper is same height from ground as during travel.

**Step 2)** Disconnect Battery Cables from all batteries on coach.

**Step 3)** Weld item 1, Driver Side Weldment Plate, to frame of coach. Weldment Plate may be trimmed to eliminate interferences in order to fit against the frame of the coach. A minimum of 30 linear inches of at least a 3/8" fillet weld **must** be used to attach Weldment Plate to frame of coach. Refer to figure 1 for dimensions to determine location of Weldment Plate to frame of coach.

**Step 4)** Slide Receiver Bar, into opening in Driver Side Weldment Plate. Use jack stands or appropriate means to hold Receiver Bar level and centered on the coach. The dimensions shown in Figure 1 should be checked to insure proper location of Receiver Bar. Tack weld Receiver Bar to Driver Side Weldment Plate.

**Step 5)** If item 3, Passenger Side Weldment Plate, needs modification do so at this time.

**Step 6)** Weld item 3, Passenger Side Weldment Plate to the frame of the coach. A minimum of 30 linear inches of at least a 3/8" fillet weld **must** be used to attach Weldment Plate to frame of coach.

**Step 7)** Tack weld Receiver Bar to Passenger Side Weldment Plate.

**Step 8)** Weld Receiver bar to Weldment Plates using a 3/8" fillet weld in the following order:

- a) Bottom of driver side
- b) Bottom of passenger side
- c) Top of driver side
- d) Top of passenger side
- e) Front of driver side
- f) Front of passenger side
- g) Back of driver side
- h) Back of passenger side

**NOTE:** It is not necessary to weld both sides of each Welding Plate. However there must be a minimum of 14 linear inches of at least a 3/8" fillet weld between **each** Welding Plate and the Receiver Bar.

**NOTE:** Warping of the Receiver Bar may occur if weld order is not followed.

**NOTE:** Over-heating of Receiver Bar may cause tubing to draw

***WARNING: BOLTING WELDING PLATE TO FRAME OF COACH IS NOT AN ACCEPTABLE MEANS OF ATTACHMENT. THE NECESSARY WELD FOR EACH SIDE IS LISTED ABOVE!***

***UNIT IS DESIGNED FOR USE ON COACHES WITH FRAMES THAT EXTEND FAR ENOUGH TOWARDS THE REAR SUCH THAT WELDMENT PLATES CAN BE ATTACHED WITHOUT EXTENSIONS. FOR RV'S WITH EXTENSIONS, FASTMASTER PRODUCTS WILL NOT WARRANTY THE UNIT.***