

INSTALLATION OF REAR MOUNTING KIT 1999-2007 FORD F-250/350 4X2/4X4

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 Industries 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

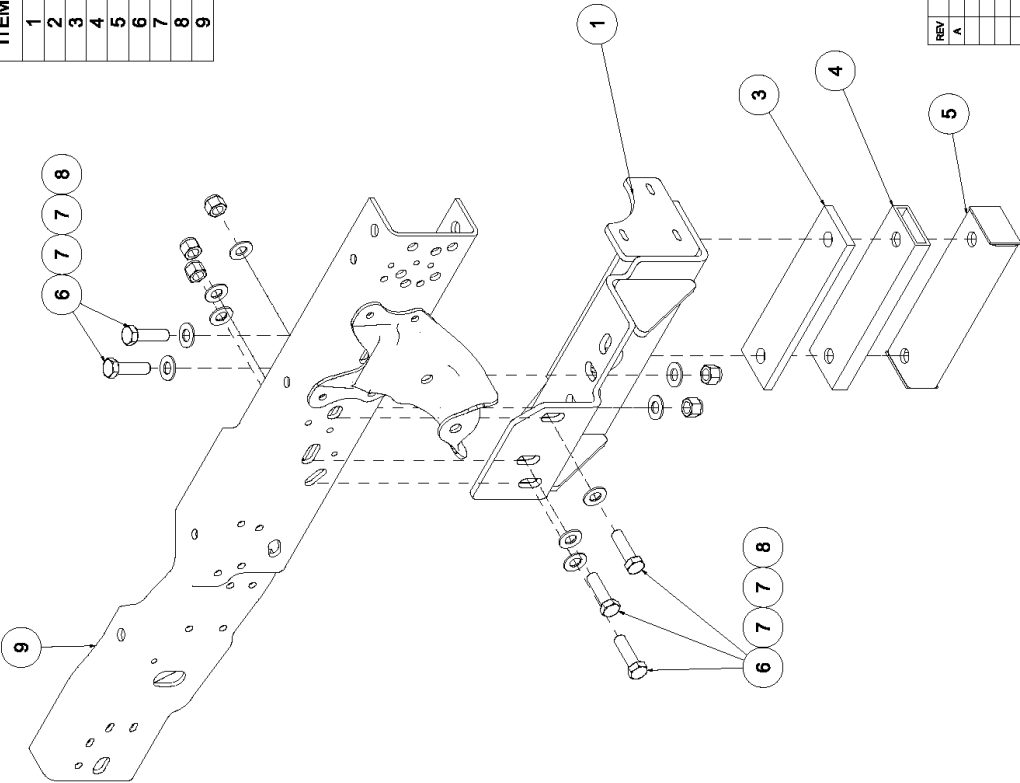
The following procedure details the installation of the rear mounting kit. The hardware required for this installation is listed in the table below.

Rear Mounting Kit Installation Parts

Part Number	Description	Qty
R-2951D	Rear Mounting Plate Left Side	1
R-2951P	Rear Mounting Plate Right Side	1
R-2960	Railgear Mounting Shim - ½" Thick	4
R-2960A	Railgear Mounting Shim - 1" Thick	2
R-2631	Railgear Mounting Shim - 2" Thick	2
R-990KIT-003	⁵ / ₈ " UNC Gr. 8 Bolt x 2.25" Long	10
	⁵ / ₈ " Gr. 8 Washer	20
	⁵ / ₈ " UNC Gr. 8 Nylon Insert Lock Nut	10

1. Remove the original spare tire and spare tire heat shield from under the vehicle's cargo box if so equipped. The original spare tire will not be re-installed.
2. Remove the tow hitch from the rear of the frame if so equipped. The tow hitch will not be re-installed.
3. Place each rear mounting plate against the underside and outside of the frame rails as shown, just ahead of the rear spring hangers. The three slots in the side of each rear mounting plate should align with the three slots in the side of the frame. The two slots in the bottom of each rear mounting plate should align with the two slots in the lower flange of the frame for the OEM tow hitch.
4. Fasten each rear mounting plate to the side of the frame with three ⁵/₈" x 2.25" long bolts, six ⁵/₈" washers, and three ⁵/₈" nuts.
5. Fasten each rear mounting plate to the underside of the frame with two ⁵/₈" x 2.25" long bolts, four ⁵/₈" washers, and two ⁵/₈" nuts.
6. Ensure the mounting plates are tight to the underside and outside of the frame and are aligned with each other. Torque the ⁵/₈" fasteners to 150 ft-lb dry. Do not over torque.
7. The supplied railgear mounting shims are to be used as required when mounting the railgear to the rear mounting plates.


BILL OF MATERIALS/PARTS LIST			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	R-2951D	REAR MOUNTING PLATE - LEFT SIDE	1
2	R-2951P	REAR MOUNTING PLATE - RIGHT SIDE (NOT SHOWN)	1
3	R-2960	RAILGEAR MOUNTING SHIM - 1/2" THICK (USE AS REQUIRED)	4
4	R-2960A	RAILGEAR MOUNTING SHIM - 1" THICK (USE AS REQUIRED)	2
5	R-2631	RAILGEAR MOUNTING SHIM - 2" THICK (USE AS REQUIRED)	2
6		5/8" UNC GR.8 BOLT X 2.25" LONG	10
7	R-990KIT-003	5/8" GR.8 WASHER	20
8		5/8" UNC GR.8 NYLOCK NUT	10
9		VEHICLE FRAME	N/A



NOTES:

- LEFT SIDE SHOWN, RIGHT SIDE IS MIRROR IMAGE

REV	DESCRIPTION OF CHANGES	DATE	BY	APPRVD	ECN #	DRAWN	MER
A	UPDATE TITLE BLOCK AND BORDER	5/24/18	AB				

 G & B SPECIALTIES INC. MANUFACTURER OF QUALITY RAILROAD PRODUCTS BERWICK, PENNSYLVANIA (717) 752-5901, FAX (717) 752-6397	DESIGN - ENGINEERING - MANUFACTURING <small>G & B SPECIALTIES, INC. IS THE OWNER OF THIS DOCUMENT AND ALL RIGHTS ARE RESERVED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF G & B SPECIALTIES, INC.</small> REAR MOUNTING KIT PART NUMBER: K-M29XRFR001
1 K-M29XRFR001 11/22/04 K-M29XRFR001 A	REVISION 1 K-M29XRFR001 11/22/04 K-M29XRFR001 A

**OPERATION, SERVICE AND PARTS
OF REAR MOUNTING KIT
1999-2007 FORD F-250/350 4X2/4X4**

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 Industries 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

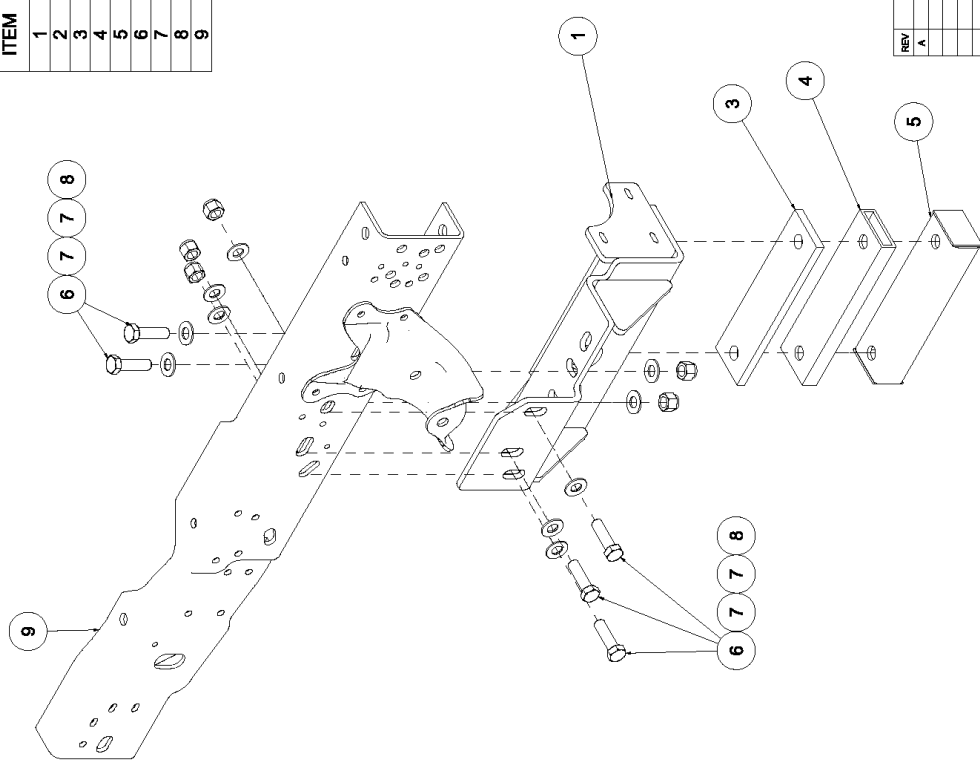
Service Required	Initial 100 km (62 Miles) of road and/or rail use	Daily	Weekly	Monthly
Inspect rear mounting kit fasteners (re-torque if required)		✓	✓	✓

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


PARTS OF REAR MOUNTING KIT

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8		5/8" UNC GR.8 NYLOCK NUT	10
9		VEHICLE FRAME	N/A



NOTES:
 . LEFT SIDE SHOWN. RIGHT SIDE IS MIRROR IMAGE

REV	DESCRIPTION OF CHANGES	DATE	BY	APPROVD	EDN #	MR
A	UPDATE TITLE BLOCK AND BORDER	06/10	AS			DRAWN
						CHECKED
						APPROVED

 G & B SPECIALTIES INC. 535 WEST 3 RD STREET, BERWICK, PA 17601 TEL: (570) 752-5901 FAX: (570) 752-6397		DESIGN - ENGINEERING - MANUFACTURING REAR MOUNTING KIT PART NUMBER: K-M29XRFR001 REVISION: A
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