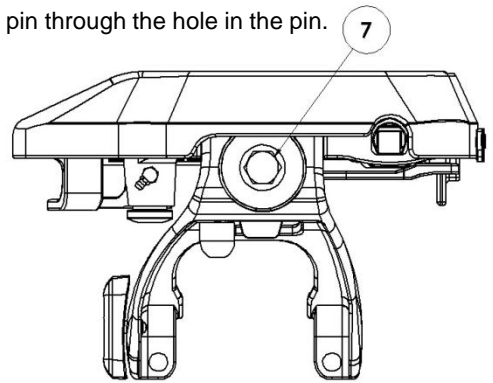
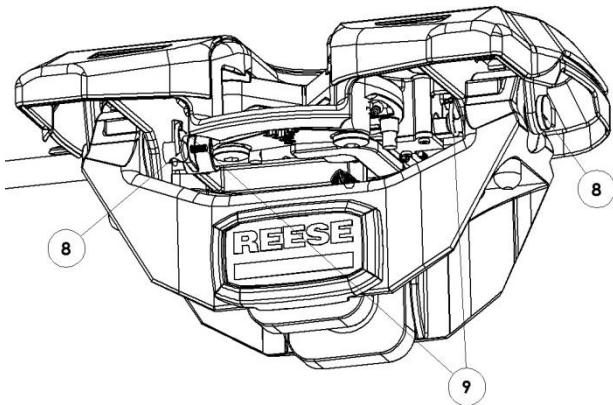


# ASSEMBLY INSTRUCTIONS

## R16/R20 LINKAGE AND LINKAGE BUSHING REPLACEMENT

### FIFTH WHEEL HITCH

1. Remove the head assembly from the pivot beam
  1. R16 – remove the two 5/8" hex bolts (7 )
  2. R20 – remove the two pins and klik pins (8,9 )
2. Unhook the jaw spring(2) from the right hand jaw and head pan assembly and set aside.
3. Using a 1/4" center punch and drive the coil pin (3) out of the handle, save this to use for reinstallation. Remove the handle (6) out of the head assembly.
4. Use a 1/2" allen wrench remove the right hand jaw bolt (1).
5. Slide the jaw with the linkage and linkage bushing off of the square shaft.
6. Use a 1/8" center punch and remove the coil pin (5) from the jaw.
7. Using the 1/8" coil pin that is supplied put the linkage over the boss on the jaw and drive the pin in place.
8. Slide the jaw, linkage and linkage bushing back over the square shaft and place the jaw back on the head assembly.
9. Reinstall the jaw bolt(1) and torque to 165 ft./lbs.
10. Reinstall the spring (2) to the jaws and spring post
11. Reinstall the pivot beam to the head pan
  1. R16 – Torque the 5/8" bolts to 65 ft./lbs.
  2. R20 – Slide pins through holes in head assembly and put the klik pin through the hole in the pin. 7



**R16 HEAD ASSY.**

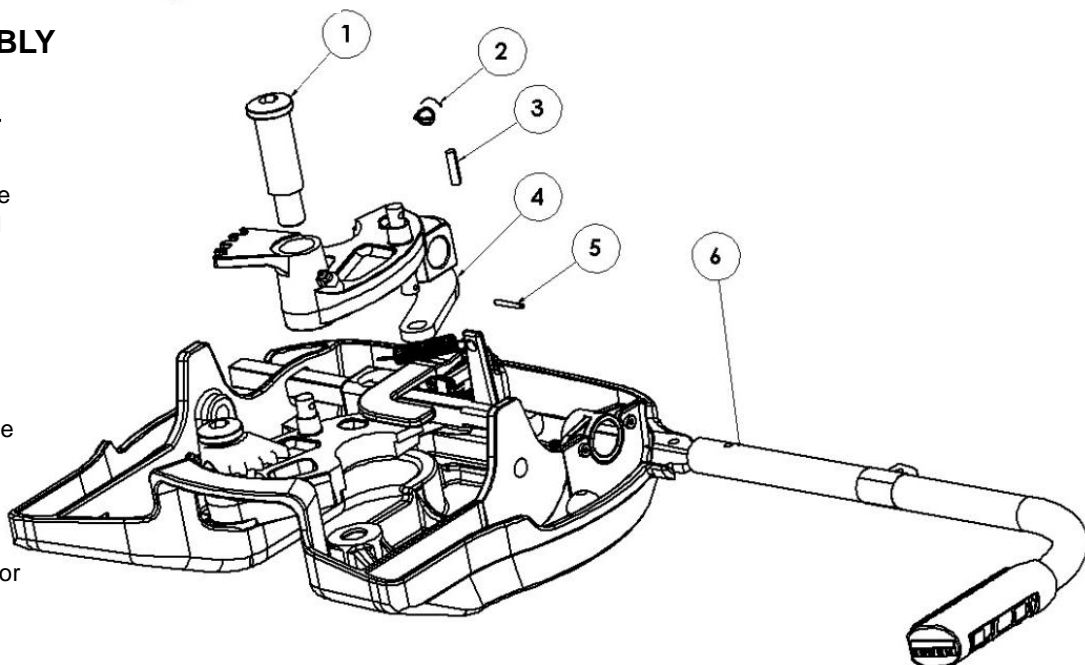
### R20 HEAD ASSEMBLY

#### **DEALER/INSTALLER:**

- (1) Provide this Manual to end user.
- (2) Physically demonstrate procedures in this Manual to end user.
- (3) Have end user demonstrate that he/she understands procedures.

#### **END USER:**

- (1) Read and follow this Manual every time you use Hitch.
- (2) Save this Manual for future reference.
- (3) Pass on copies of Manual to any other user or owner of Hitch.



**For Installation Assistance or Technical Help, Call 1-888-521-0510**