



Fitting Instructions

TOWBAR G77
for VAUXHALL COMBO VAN
2001 -

MATERIALS

A	1	Towbar Mainframe with European facing 94/20/EC – A50-1
C	1	Right Sidearm
D	1	Left Sidearm
E	4	Angle Cleat
F	4	Bushes (19mm O.D. – 55mm long)
G	2	Spreader Plate
J	4	M10 x 100 x 1.5mm Bolts, Nuts and Lock Washers and Large Flat Washers (25mm O.D)
K	4	M10 x 30 x 1.5mm Bolts, Nuts and Lock Washers
L	2	M10 x 30 x 1.5mm Bolts and Lock Washers
M	2	M10 x 30 x 1.5mm Bolts, Nuts, Lock Washers and Large Flat Washers (40mm O.D)
CB	2	M16 x 40mm Coupling Bolts, Nuts and Lock Washers

FITTING

1. Temporarily disconnect rearmost three rubber hangers and lower exhaust, remove three plastic fasteners holding lower edge of bumper to underside of rear valance, and lower spare wheel.
2. Identify dimples in rear valance (at 71mm centres) corresponding to holes for Bolts (J) in Towbar Mainframe (A). From forward side of rear valance, reverse the dimples with a centre punch and drill through for Bolts (J).
Note: These forward facing holes may be covered in mastic. If so, scrape mastic off to reveal dimples and provide a smooth surface for Sidearms (C and D). Open up holes for Bushes (F).
3. Cut bumper as shown. Insert Towbar Mainframe (A) between valance and rear bumper, locate using Bolts (J). Insert Bushes (F) from the other side, and loosely attach Sidearms (C and D) using Bolts (J).
4. Insert Spreader Plates (G) and Washers (M) into chassis rails and loosely attach Angle Cleats (E) to Spreader Plates (G), Washers (M) and Sidearms (C and D) using Bolts (K, L and M). Note: Ensure Angle Cleats (E) are positioned as shown, and appropriate holes in Angle Cleats (E) are used as shown.
5. Finally, **tighten all Bolts**, relocate spare wheel, reconnect bumper and exhaust.

Note: This towbar must be used with either a Witter Towball (part number Z1) or Class A50-1 or A50-X towball dimensionally conforming to A50-1 with a 'D' and 'S' value greater than or equal to that of the towbar.

Please refer to the vehicle specification for the trailer weight and nose limits, which **must be observed**.

Recommended torque settings: M8 - 27Nm, M10 - 53 Nm, M12 - 95 Nm, M14 - 150 Nm, M16 - 214 Nm

