



# Fitting Instructions

TOWBAR R23A  
For ROVER 45 SALOON  
ROVER 400 SALOON  
1996-

## MATERIALS

A	1	Towbar Main Frame
C	1	Centre Tube with European facing to 94/20/EC – A50-1
C1	2	Side Arms (Left Hand - Right Hand)
D	4	M10 x 100mm Bolts, Nuts, Lock Washers and Large Flat Washers (40mm O.D.)
D1	2	Spreader Plates (Left Hand – Right Hand)
D2	4	Bushes (17mm O.D. – 65mm long)
E	4	M10 x 30mm Bolts, 2 Nuts and Lock Washers
F	8	M10 x 35mm Bolts, Nuts, Lock Washers and Large Flat Washers (30mm O.D.)
G	1	M16 x 50mm Bolt, Nut and Lock Washer
G1	1	Spreader Plate
G2	1	Bush (34mm O.D. 12 thick)
H	1	Spacer Plate (2 Hole)
J	2	M8 x 30mm Bolts, Nuts, Lock Washers and Large Flat Washers (25mm O.D.)
K	2	M12 x 90mm Bolts and Nyloc Nuts
CB	2	M16 x 40mm Coupling Bolts, Nuts and Lock Washers
BC	12	M10 Bolt Caps

## FITTING

1. Remove the floor covering. Remove bumper (5 plastic plugs on top edge of bumper, 2 tip screws and 2 plastic plugs on the lower edge). Remove and discard pressings covering open ends of vehicle frame and temporarily lower the rear exhaust silencer.
2. Insert Side Arms (C1) into chassis and loosely attach using Bolts (J) and drill up for Bolts (D). Temporarily position Spreader Plate (D1), mark around it and remove all mastic compound. Enlarge top-hole (D), insert Bushes (D2) and loosely attach Spreader Plate (D1) with bolts (D). Using Spreader Plate (D1) as a guide drill for Bolts (F) with Large Flat Washers on the underside of the floor.
3. Loosely attach Main Cross Bar (A) to Side Arms (C1) using Bolts (E), and to the towing eye using Bolt (G) with Spreader Plate (G1) Tighten all bolts.
4. Refit bumper and exhaust
5. Loosely attach Centre Tube (C) to Cross Bar A) using Bolts (K) and Spacer Plate (H). **NOTE:** (H) fits on the LH side. Finally tighten all bolts.

**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

