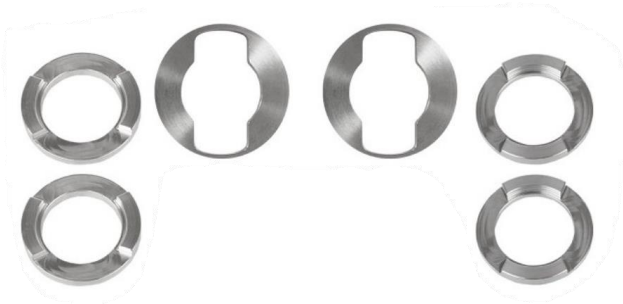
S550/S650 IRS Sub Frame Bushing Support System for GT350/Mach I

Instructions for 555-4449

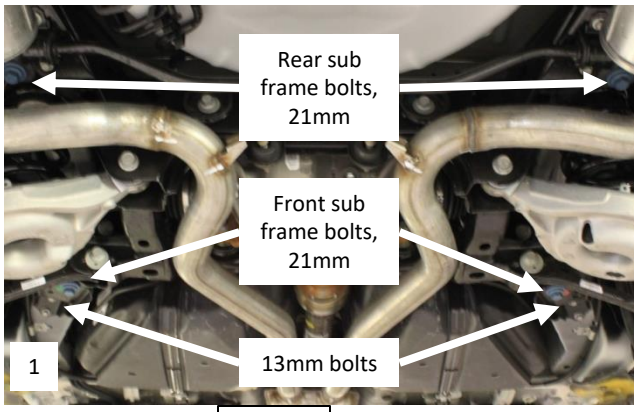


Tools Needed:

1. 13mm socket and ratchet
2. 21mm socket

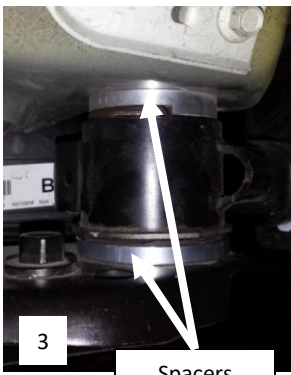
Installation

1. Lift and support the car, by the chassis on a vehicle lift, or on jack stands. Do not place the jack stands underneath the rear sub frame.
2. Locate the main sub frame bolts. They are blue, hex head 21mm head bolts. **Note: In some cases, it might be beneficial to work on one side of the sub frame at a time, so that an alignment is not completely necessary.** Loosen, but do not remove both rear sub frame bolts. The bolts need to be loosened enough, to give the sub frame about one inch of drop in the rear. See figure 1.
3. Loosen, but do not remove, the 4-13mm head bolts (2 on each side), securing the front sub frame mount to the chassis.
4. Remove the 2 front main sub frame bolts. Install the thicker spacers above the front sub frame bushings. See figure 2. The flat side of the spacers will go up, so that when tightened, they contact the body. The steps on the spacers, will sit on top of the oem sub frame bushing. Install both front spacers at the same time. See figure 3 for correct orientation.
5. Install the front lower spacers below the front sub frame bushings, above the front sub frame mount support bracket. See figure 2 & 3.
6. Once the spacers are installed and oriented correctly, torque the front 21mm sub frame bolts to 129ft-lbs. Torque the 4-13mm bolts to 41ft-lbs.
7. Remove the 2 rear sub frame bolts. Install the thinner spacers above the rear sub frame bushings. See figure 2. The flat side of the spacers will go up, so that when tightened, they contact the body. The steps on the spacers, will sit on top of the oem sub frame bushing. Install both rear spacers at the same time. See figure 3 & 4 for correct orientation.
8. Once all of the spacers are installed and oriented correctly, torque the rear sub frame bolts to 129ft-lbs.
9. Verify all hardware has been tightened, and lower the car. Enjoy! **Note: An alignment may not be necessary, but is recommended.**











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Patent Pending
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