

# Installation Guide

## REAR FRAME INSERTS

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(Always refer to the current catalogue for complete application listings)

#### Component List:

-  **80017 - Rear Lower Insert - Quantity x 2**
-  **80018 - Front Lower Insert - Quantity x 2**
-  **80019 - Rear Upper Insert - Quantity x 2**
-  **80020 - Front Upper Insert - Quantity x 2**
-  **NG-8 - Grease - Quantity x 2**

## REAR



## FRONT



#### Outcome:

The supplied kit is designed to be easily installed and reduce the amount of associated rear frame movement during high loading vehicle manoeuvres whilst maintaining a high degree of cabin comfort from eliminating excessive cabin noise associated with full frame bushing installation.

The insert kit is designed to fill the OEM rubber voiding cavity and restrict movement of the frame and also aid in providing longevity to the rubber OEM frame bushings by aiding in the load carrying capability of the bushing.

**Note: The front & rear inserts are similar in design (see image above) and may be confused with one another. Please make sure the part number is noted before installation to eliminate any failure of the inserts from incorrect installation.**

**Please ensure all bolts are re-torqued after fitment of the inserts and are re-checked after a settling in period of 100 Km's or 62 Miles.**

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*(Always refer to the current catalogue for complete application listings)*

**N.B:** This installation guide should be used in conjunction with the workshop manual.

#### **FIGURE 1**

Support rear of frame using a suitable stand or jack.



#### **FIGURE 2**

Completely remove the right rear frame retaining bolt from the frame. Ensure the frame is fully supported by the stand or jack.

**Note:** Do Not remove the bolts without the frame supported.



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**FIGURE 3**

✎✎✎ Completely remove the Left hand rear frame retaining bolt.



**FIGURE 4**

Apply supplied grease to the face of the bushings and insert the supplied 80019 insert onto the top of the frame on both sides. You may need to rotate the bushing until the voiding matches the OEM bushing.  
**Note: Part number can be located on the outside face of the inserts.**



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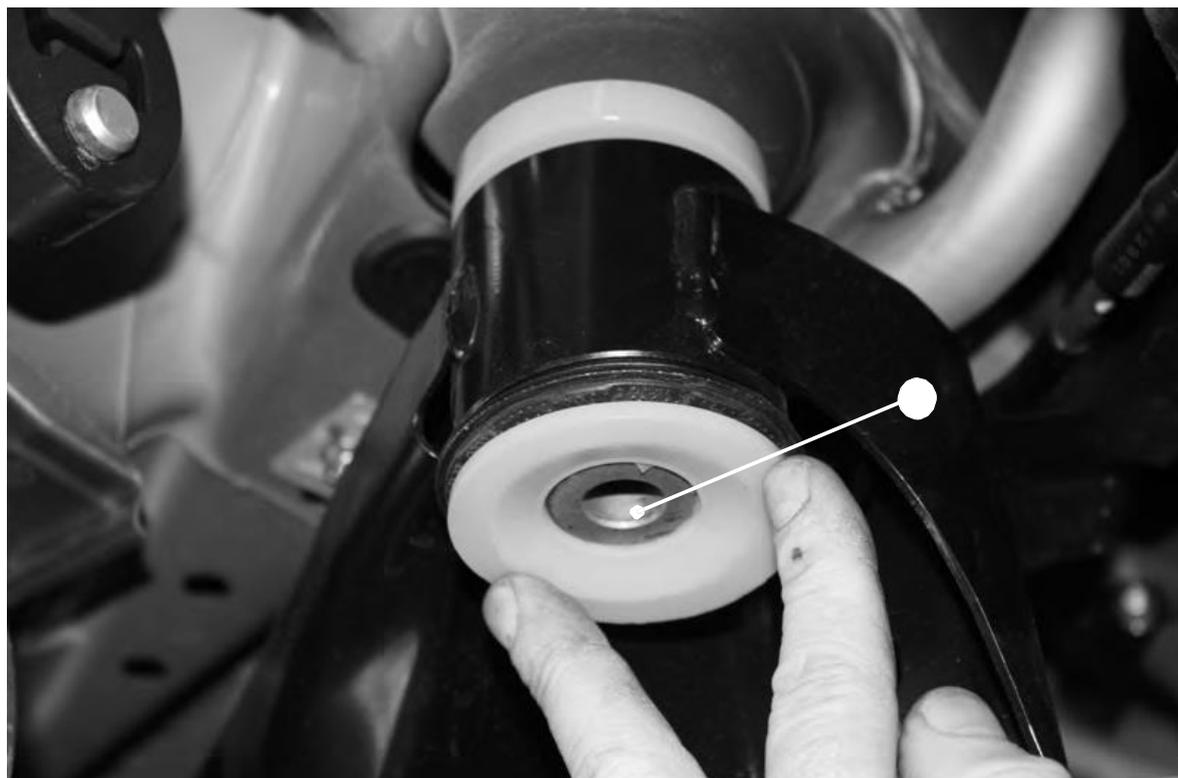
**FIGURE 5**

🔧🔩🔑 Install Supplied 80017 inserts to the lower frame bushings ensuring adequate greasing of insert faces.



**FIGURE 6**

🔧🔩🔑 Re-fit the OEM washer and bolt and hand tighten sufficiently to support weight of the frame.



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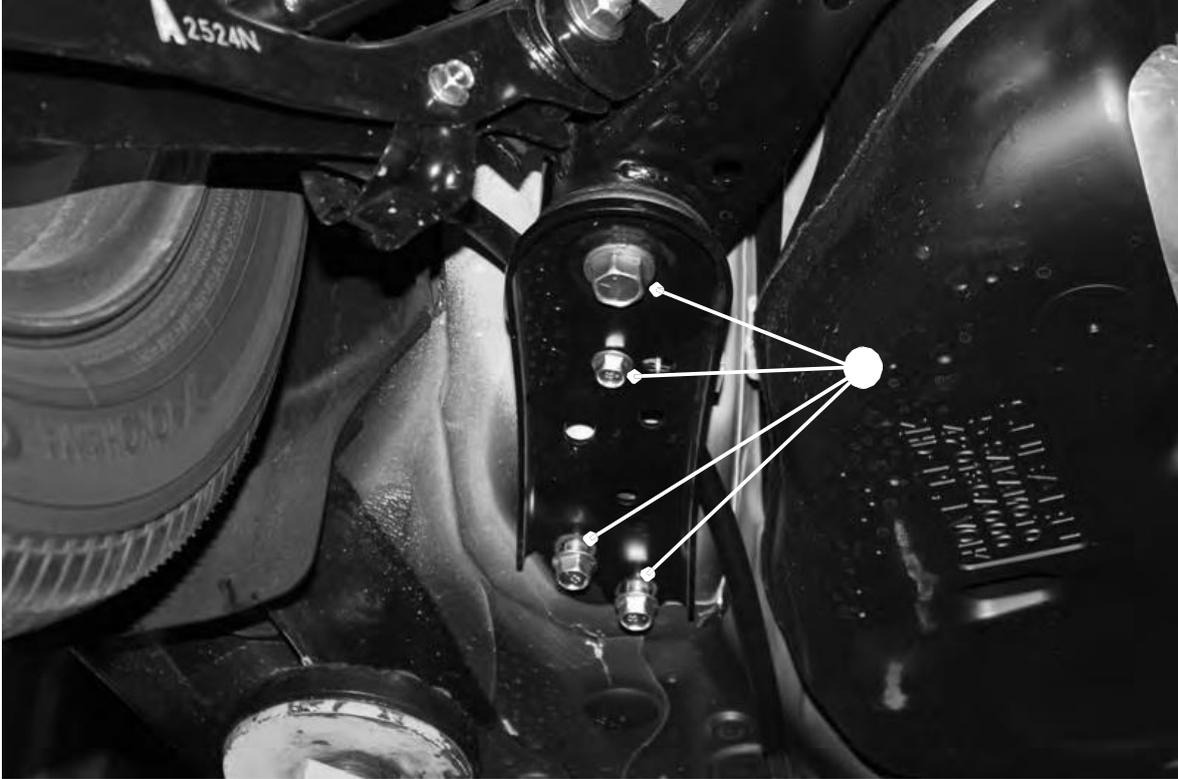
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**FIGURE 7**

Support the front of the frame and remove the bolts indicated below. Once removed place the brackets aside and lower the frame enough to gain access to the steel OEM washer on the top of the OEM bushing.



**FIGURE 8**

Locate the bushing 80020 and grease both faces of the bushing. Install the insert into the OEM rubber bushing. You may need to flatten the “tang” on the OEM washer. You may need to rotate the bushing until the voiding lines up with the OEM bushing.



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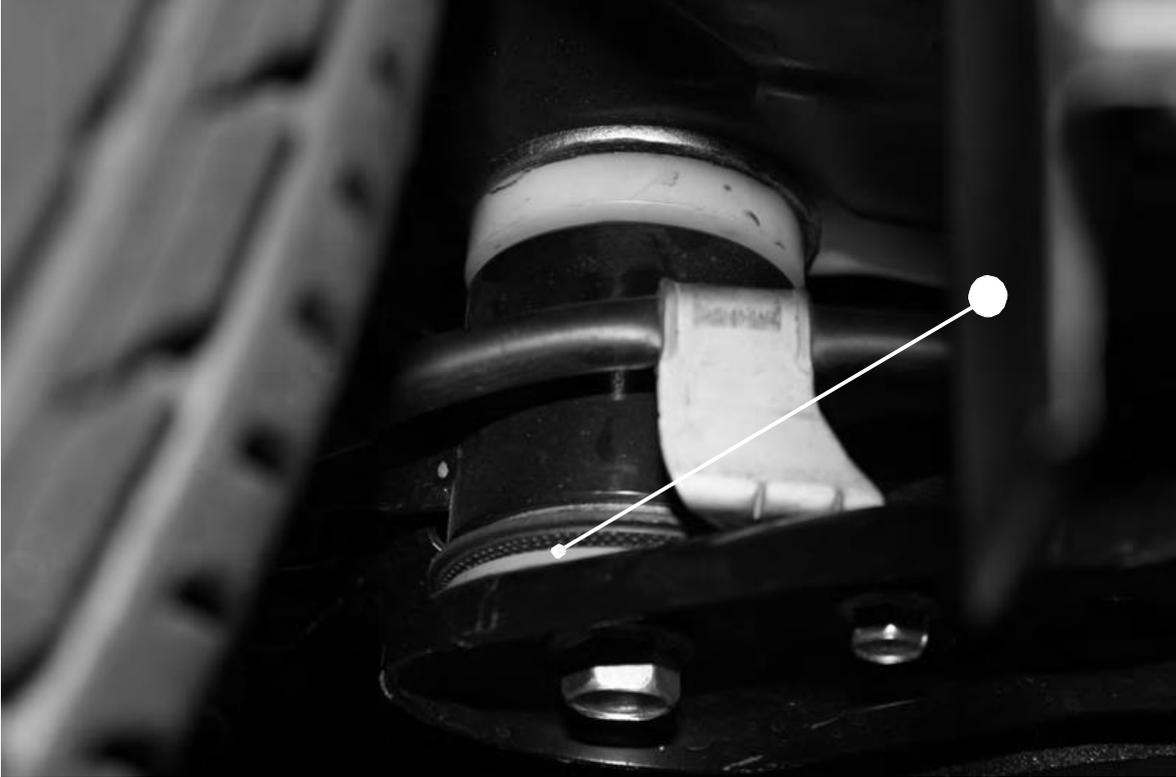
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#### **FIGURE 9**

Locate insert 80018 & grease both faces of the bushing and re-install the brackets and bolts. Tighten all bolts front and rear.

**Note:** Bushings are designed to be of interference fit so some level of crush will be noted during installation.



#### **FIGURE 10**

 Torque all bolts to manufacturers specifications or alternatively use the torque guide provided within this installation procedure.

