

xAxis™ Retrofit Kit For #25470 and #25480

This part should only be installed by personnel who have the necessary skill, training and tools to do the job correctly and safely. Incorrect installation can result in personal injury, vehicle damage and / or loss of vehicle control.

Check out how to install this part at:
<http://www.spc-tv.com>



1. Remove control arms from vehicle.
Removal can be achieved by reversing installation instructions. Latest instructions can be found at www.spcalignment.com.



TECH TIP: To preserve alignment settings, disconnect ball joint at knuckle. Take care not to damage threads on ball joint shaft. Use PN 37985 or equivalent.

2. For each bushing, remove steel center sleeves with a hammer and drift.
3. Clamp one leg of arm into vice and then use a scraper or sharp chisel to cut outer lip off SpecRide bushing. **See Figure 1.**
4. Use a hammer to tap SpecRide bushing out.
5. Repeat steps 2 through 4 on second leg.
6. Clean both end rings thoroughly and remove any sharp edges. **See Figure 2.**
7. Using provided press tool, install xAxis bushings from outside. Be sure to align square tabs of press tool with square tabs of xAxis bushing. **See Figures 3, 4 and 5.**
8. Using a manual press, press until xAxis outer shell is flush with inside of inner end ring. A receiver, or arbor plate with an opening large enough to accept protruding part of bushing must be used under arm.



Figure 1

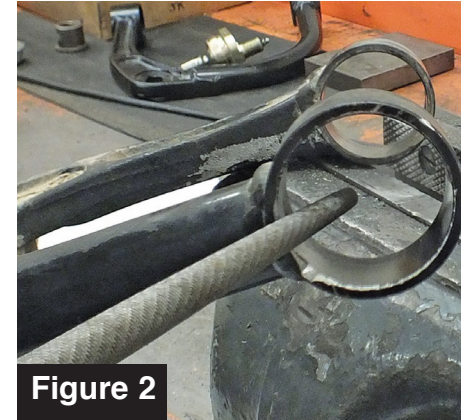


Figure 2

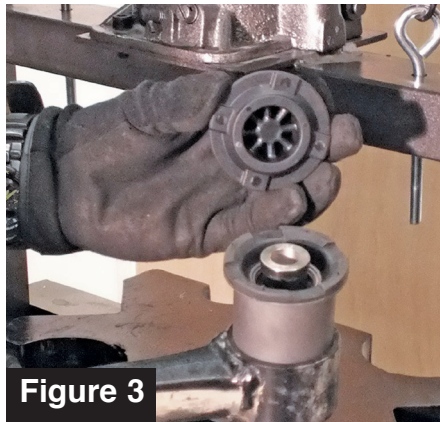


Figure 3

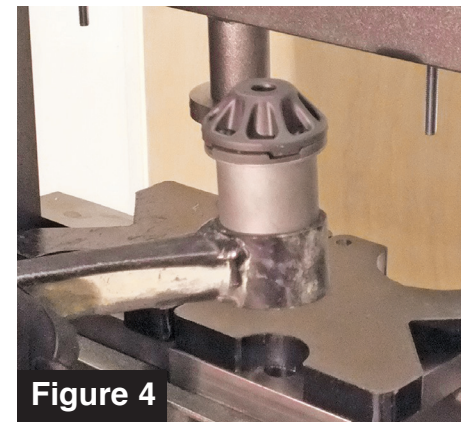


Figure 4

CAUTION: DO NOT USE EXCESS FORCE. DO NOT USE A PRESS EQUIPED WITH AN AUTOMATIC RAM! Press must be a manual pump, or arbor press.

9. Stop pressing as soon as bushing outer shell is flush with inside of end ring. An intentional gap will remain between outside face of end ring and underside of flange in bushing casing. **See Figure 6.**
10. Repeat step 2 thru 8 on second arm.
11. Re-install arms on vehicle using most up to date instructions for your application.
Current instructions can be found at www.spcalignment.com.

Videos of this installation can be found at www.spcalignment.com.

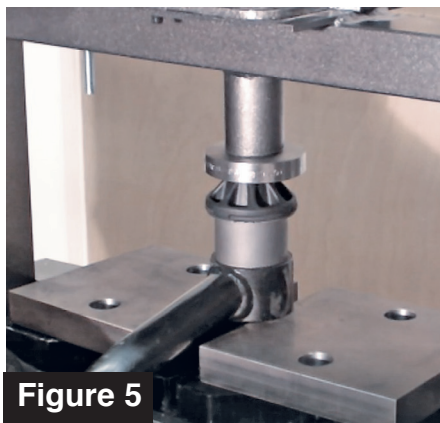


Figure 5

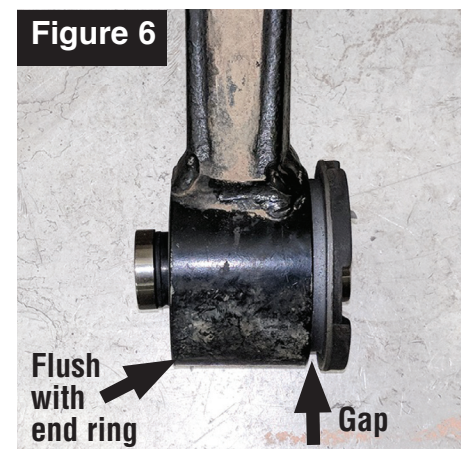


Figure 6

Flush with end ring
Gap



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