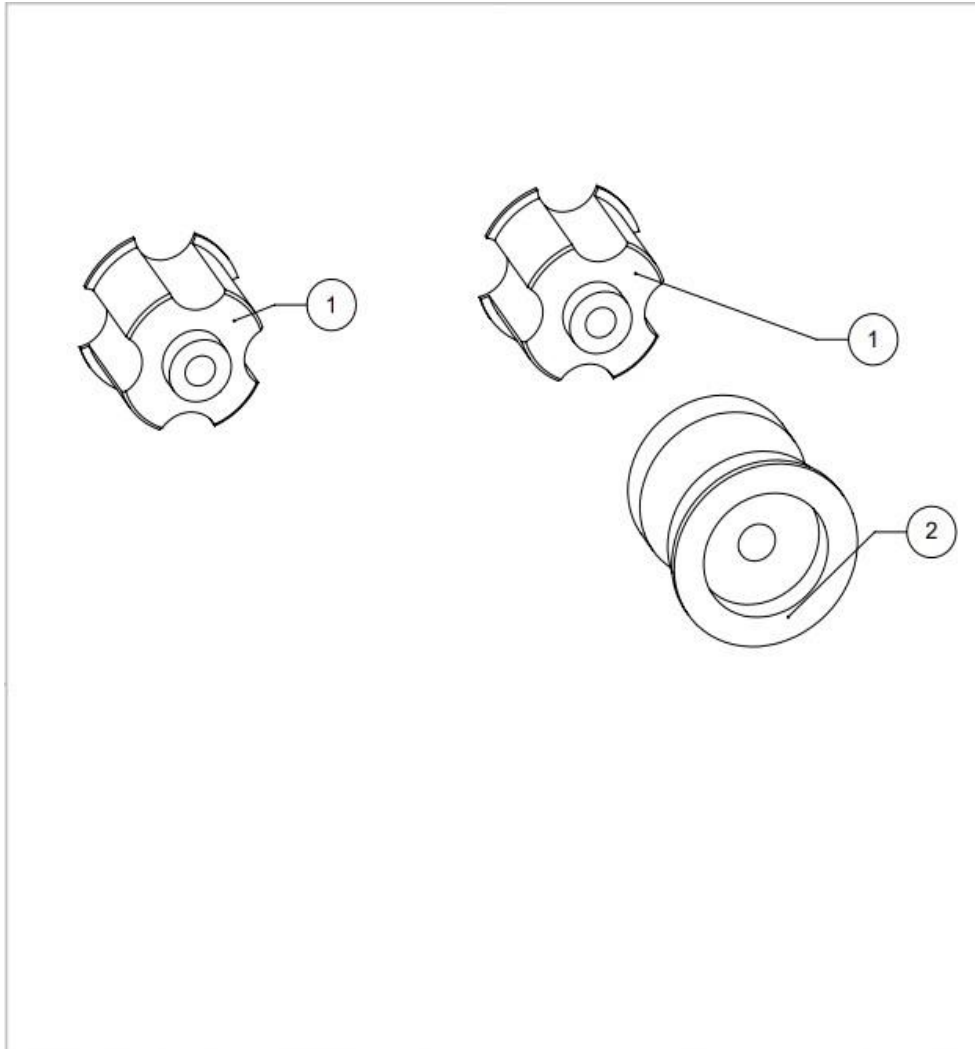


# Subframe Differential Bushings Kit Installation Instructions G29 Supra SPL SDBS G29



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	10140	SOLID DIFFERENTIAL BUSHING FORWARD	2
2	10141	SOLID DIFFERENTIAL BUSHING REAR	1

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**SPLPARTS INC.**

SIZE	PART NO.	REV.
A	SDBS G29	
FILE	SCALE	SHEET
	1:8	1 OF 1

Thank you for your purchase of this SPL performance product. Please follow these instructions exactly to ensure that the product is able to function to the best of its ability, and you can achieve the most performance out of your vehicle.

1. Place the bushings in the freezer the night before working on the vehicle which will make pressing in the bushing far easier.
2. Make sure your car is in neutral, as you will need to be able to rotate the rear axle.
3. Jack up the rear of your vehicle so that the rear tires are no longer touching the ground. Place jack stands in factory recommended locations to ensure that both the vehicle and yourself are safe from harm.
4. Remove the rear wheels off of the vehicle and place them to the side.
5. Begin removing the exhaust past the downpipe. This will give you more space to lower the subframe.
6. Remove all sensors from the differential and both axles.
7. Remove the brakes and hang them up so that the brake lines are not stretched in any way.
8. Remove the 3 bolts that are holding the shocks in place on both sides of the vehicle.
9. Place a table or other device that can support the weight of the rear subframe and all suspension.
10. Remove the braces from the 4 corners of the suspension and lower the subframe onto the table.
11. Remove the two bolts from the front portion of the differential, then remove the bolts in the rear, making sure the differential is fully supported.
12. Disconnect the swaybar endlinks. You may also have to loosen the suspension links so that the bushings can rotate. Make sure to support the axles so that they do not pull out of the differential.

13. Lift the subframe up so that the bushings are clear of the differential.
14. Use a hole saw to cut the front bushings out of the subframe, as the subframe is squeezed into the shell of these to prevent it from moving. Be careful not to damage the subframe when removing the bushing. Pry the remaining pieces out of the edges.
15. Remove the rear differential bushing. Be very careful when removing this to not take any material from the surface that the bearing will be pressed into. Using a threaded rod is advised to pull this out.
16. Press the two Forward Bushings (1) into the subframe, pressing from the front of the subframe to the rear, making sure to line up the pockets of the bushing with the raised portions in the subframe to prevent any issues while pressing the bushing in. The bushing should be able to press in until the flange at the end touches.
17. Press in the Rear Bushing (2), pressing from the rear of the subframe to the front. The bushing should be able to press in until the flange at the end touches. Make sure to take care while pressing the bushing in to watch as it passes the middle portion of the subframe that is split to make sure it passes through this portion without taking a lot of material. Having the bushing frozen beforehand helps with this.
18. Reinstall the differential into the subframe, torqueing the front differential bolts to 100Nm and the rear differential bolt to **165Nm**.
19. Reinstall the axles into the differential, torqueing each bolt to **52 ft.-lbs**.
20. Reinstall the driveshaft into the differential, torqueing all bolts to **55Nm+90° (it is suggested to replace these)**.
21. Retorque the subframe to **108Nm** and the subframe brace bolts to **47Nm+45°**
22. Reinstall exhaust that was removed to make room for differential.
23. Reinstall your wheels and lower the car.

24. Be safe, and enjoy your new upgrade!

**ONE-YEAR LIMITED WARRANTY AND DISCLAIMER**

*All SPL brand products are intended for **Off Road Use Only** and carry a one year limited warranty. See below for details. All other branded products carry their respective manufacturer warranty.*

*SPL PRO suspension products warranted to be free of defects in material and workmanship for one (1) year from the date of purchase.*

*If a product fails to meet specifications, SPL PARTS INC will, at its election, repair, replace, or make appropriate adjustment, if SPL PARTS INC determines to its satisfaction that the product is defective in material or workmanship, i.e. contains a defect arising out of the manufacture of the product and not a defect caused by other circumstances, including, but not limited to accident, misuse, abuse, unforeseeable use, neglect, alteration, improper installation, improper adjustment, improper repair, or failure caused by other equipment or interaction with other equipment. SPL PARTS INC is not responsible for labor charges, removal charges, installation, or other incidental or consequential costs. In no event shall the liability of SPL PARTS INC exceed the purchase price of the product.*

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**Using any SPL arm as a tie/strap down point for a dyno session or transport will void the warranty.**