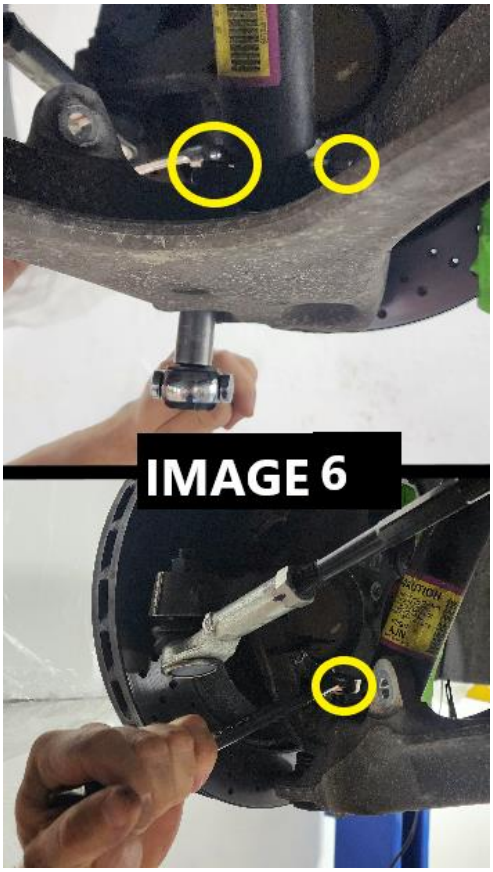
C5/C6 Corvette Control Arm Bearing Kit Install Instructions

Tools Required:

- Jack and Jack Stands
- Metric Socket and Wrench set
- Pick
- Flathead Screwdriver
- Balljoint/Tie Rod Separator
- External Snap ring Pliers
- Press
- Mallet
- Torque Wrench
- Dial/Digital Calipers
- Sawzall
- Drill and Drill Bit Set



Disassembly:

1. Lift the front of the vehicle and safely support on jackstands. Remove both front wheels.

2. Support the bottom of the lower control arm with a floor jack or a screw jack.

3. Using a **13mm** socket and wrench, remove the two shock mount bolts on the lower control arm.

4. Slowly let the jack or screw jack down.

5. Remove the sway bar link from the lower control arm and the sway bar.

6. Remove the upper ball joint nut. After, a ball joint separator is used to disconnect the upper control arm from the hub.

7. Remove the upper control arm by removing the (4) **13mm** bolts holding the upper control arm to the chassis.

8. Remove the lower ball joint nut and use a ball joint separator to disconnect the lower control arm from the hub.

9. Lastly, loosen and remove the lower control arm chassis bolts and remove the lower control arm.

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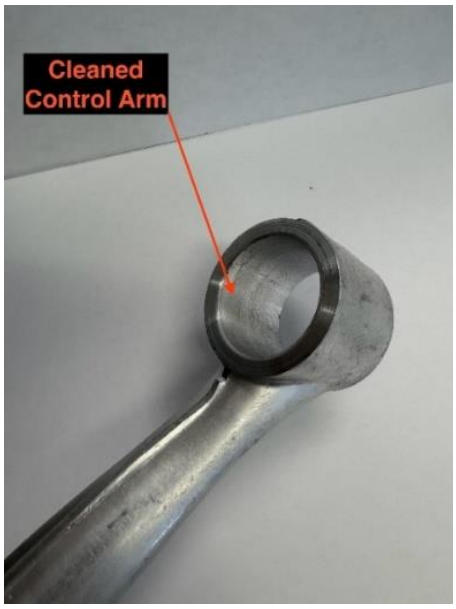


10. Now that all of the control arms are removed, you will need to remove the stock bushings.

11. To begin, start by drilling multiple holes in the bushing to remove the rubber from the bushing.

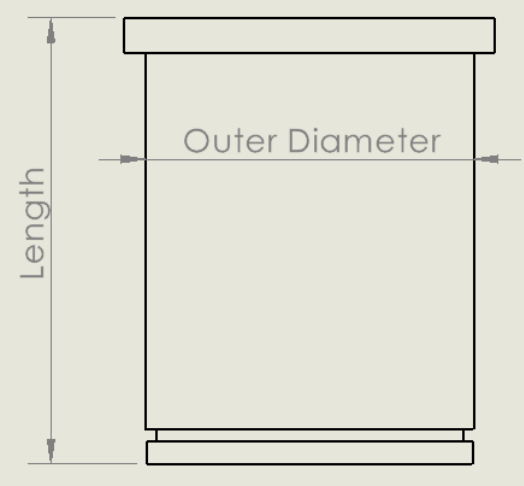
12. Once enough rubber is removed, fit a jab saw into the bushing and cut through the bushing sleeve (being careful not to damage the control arm).

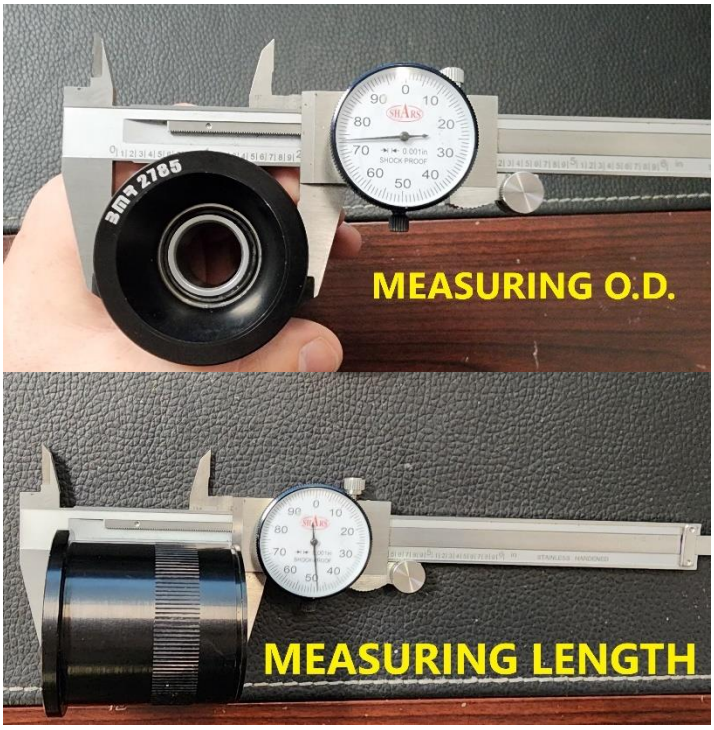
13. Once you cut through the bushing sleeve, remove the old bushing by tapping it out of the control arm.

14. Repeat this step until all the old bushings are removed.

15. Before installing the new control arm bearings, clean the control arm with brake parts cleaner to remove any remaining debris from the old bushings.

16. Each control arm takes a different bearing. The table below lists where each part number goes as well as the diameter and length of each bearing cup for reference.





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Qty:	Part Description:	Part #:	OD:	Length:	Snap Ring ID:
4	Upper Control Arm Bearing Cup	BMR2749	1.413”	1.801”	1-7/16”
2	Lower Control Arm Front Bearing Cup	BMR2784	1.459”	2.177”	1-7/16”
2	Lower Control Arm Rear Bearing Cup	BMR2785	1.972”	2.221”	1.969"
4	Upper Control Arm Cross-Shaft	BMR2754	0.740”	5.450”	5/8”
8	Lower Control Arm Rear Bearing Spacer	BMR2773	1.240”	1.330”	-
4	Lower Control Arm Front Bearing Spacer	BMR2778	0.987”	1.172”	-

17. To install the bearings, you **will need a hydraulic press** to press in the new bearing cups.

18. According to the figure, press the bearing cups from the outside of the control arm inward.

C5/C6 Corvette Control Arm Bearing Kit Install Instructions

NOTE: When installing the cross-shaft, it is recommended to use a green retaining compound installed on the upper control arm bearings before sliding the cross-shaft in.

19. To assemble the upper control arms, slide the cross-shaft into the control arm from the outside inward, according to the figure, and secure it using the supplied cross-shaft external snap ring

20. To assemble the lower control arms, insert the (4) bearing spacers into each lower control arm as shown

21. Install the control arms back into the car and assemble all other components taken off during installation.

NOTE: These fasteners are listed as T.A.Y (Torque-Angle-Yield Fasteners), also known as single-use or Torque-to-Yield fasteners.

Although GM recommends that you replace these fasteners, we have not replaced ours at any point during our design and testing process. Re-use these fasteners at your own risk.

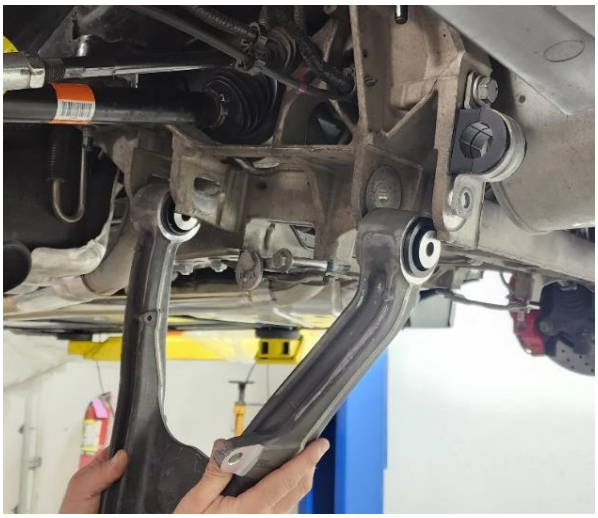
Torque Specs:

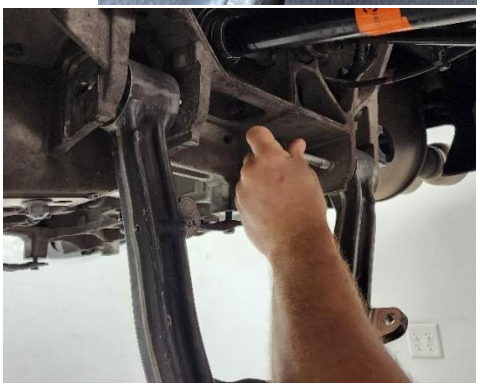
Lower Control Arm Cam Nuts - **125 ft lbs**

Upper Control Arm Mounting Bolts - **48 ft lbs**

Front Upper Ball joint - **22 ft lbs + 225°**

Lower Ball joint - **22 ft lbs + 180°**





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