

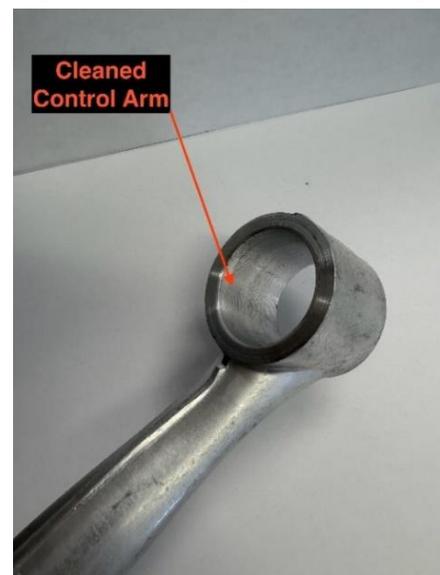
C7 Corvette Upper Rear Control Arm Bearing Kit Install Instructions

Tools Required:

- Jack and jackstands or service lift
- Metric wrenches and sockets
- Tie Rod Separator
- Internal/External Snap Ring Pliers
- Hydraulic press
- Reciprocating saw
- Drill and drill bits
- Torque Wrench
- Dial or Digital Calipers

Installation:

1. Lift the rear of the vehicle and safely support it with jack stands under the cradle. Make sure the parking brake is released.
2. Loosen the nut on the upper control arm ball joint using an **18mm** socket or wrench. Unseat the ball joint and disconnect the upper ball joint from the spindle
3. Remove the rear upper control arm by loosening the (4) **13mm** bolts.
4. To remove the bushings from the control arms, start by drilling multiple holes in the bushing to remove rubber from the bushing.
5. 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).
6. Once you cut through the bushing sleeve, remove the old bushing by tapping the sleeve out of the control arm.
7. Repeat this step until all the old bushings are removed.
8. Before installing the new control arm bearings, clean the control arm with brake cleaner to remove any remaining debris from the old bushings.



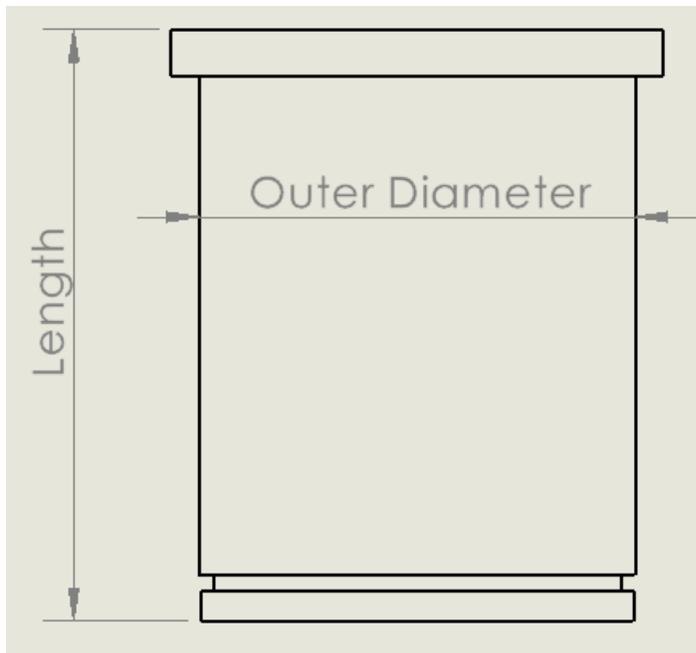
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Qty:	Part Description:	Part #:	OD:	Length:	Snap Ring ID:
2	Rear Upper Front Control Arm Bearing Cup	BMR2750	1.571"	1.663"	1-9/16"
2	Rear Upper Rear Control Arm Bearing Cup	BMR2751	1.730"	1.663"	1-11/16"
4	Rear Upper Control Arm Cross-shaft	BMR2755	.740"	4.5"	5/8"

- Before proceeding, verify that all the parts are correct by referencing the table, measuring the outer diameter and length of every bearing cup with calipers, and organizing all parts.
- Keep track of which snap ring goes with which bearing cup



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

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

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.

13. 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.

14. 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:

Upper Control Arm Mounting Bolts - 48 ft lbs

Upper Ball joint (if using new ball joints) - 22 ft lbs + 140°

Upper Ball joint (if using the same ball joints) – 88 ft lbs

