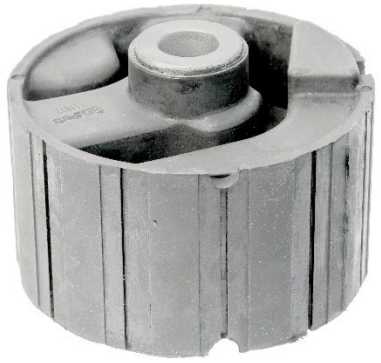
Installation Guide

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Front Engine Mount Bushing 13 191 539

WARNING: Installing bushing incorrectly will cause premature failure & poor NVH performance!



Step 1
Remove old mount assembly per factory repair manual.

Step 2
Take photo of both sides of old mount assembly, taking note of the alignment marks on both sides of bushing. With paint pen, make match marks on both sides of the metal bracket.

Step 3
Press old bushing from bracket and press-in new bushing, being sure to **orient the new bushing correctly** per your match marks and photos of original assembly.

Step 4
Install refurbished mount assembly per factory repair manual.



Notes
Voids in the rubber run front-to-back, not side-to-side. If you look at the bushing end-on, you'll see the rubber isn't a solid ring, there are hollow voids molded into it. These voids must be oriented along the vehicle's longitudinal axis (front-to-rear). This is what allows the mount to absorb engine rocking under acceleration and deceleration while staying stiff laterally.

The bracket has machined mating surfaces which must sit flush with the block. Any gap means a bolt is misaligned, or there's debris on the mating face.

Before tightening the through-bolt, make sure the inner metal sleeve of the bushing is centered in the subframe bracket, so the bolt slides through without forcing the rubber sideways.

Installation by a professional technician is recommended. Refer to the factory repair manual for vehicle-specific service procedures for this part. Tighten all hardware to factory torque specifications and observe all repair manual cautions and warnings. Use safety stands whenever beneath a vehicle and always wear protective eyewear.

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