

# POWERFLEX®

PART NUMBER  
**19-2230**

DESCRIPTION  
**Upper Gearbox Mount Insert**

## INSTALLATION GUIDE

### Contents (parts per pack):

1 x Polyurethane A Insert    1 x Polyurethane B Insert

Please read the complete fitting instructions and check package components before fitment. These fitting instructions are to be used as a guide and in conjunction with workshop manual.

It is recommended that:

- all work to be carried out by a licensed technician;
- all safety precautions adhered to;
- wheel alignment to be checked and adjusted as required after any suspension work.
- All fasteners must be tensioned to manufacturer's torque settings.

### Fitting Instructions:

1. Support the gearbox from underneath using a trolley jack or axle stand.
2. Remove the gearbox mount from the vehicle.
3. Once you have unbolted the mount and removed it from the vehicle, secure it in a vice and using a 13mm drill, drill the swaged pressing in the round hole on the underside of the bracket as shown in Fig 1.

Note: DO NOT drill into the brackets more than required.

4. Separate the top and bottom bracket by prising the two parts apart as shown in Fig 2.
5. Fit Bush A towards the front of the car and Bush B part towards the rear, as shown in Fig 3. The inserts are marked for identification.
6. Reassemble the mount with the top bracket fitting over the lower half of the bracket and mount, as shown in Fig 4.
7. Re-fit the fully assembled mount back to the vehicle and tension all hardware to the manufacturer's recommended torque settings.

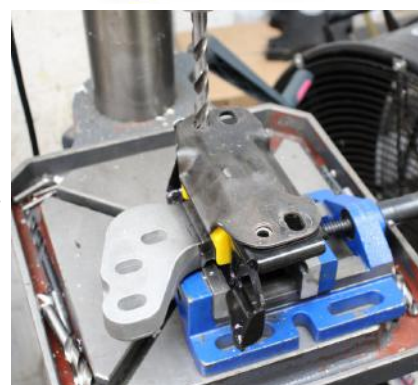


Figure 1



Figure 2



Figure 3



Figure 4

