

**xAxis™ Retrofit Kit For #25455 and #25460**

*This part should only be installed by personnel who have the necessary skill, training and tools to do the job correctly and safely. Incorrect installation can result in personal injury, vehicle damage and / or loss of vehicle control.*

Check out how to install this part at:  
<http://www.spc-tv.com>



1. Remove control arms from vehicle. Removal can be achieved by reversing installation instructions. Latest instructions can be found at [www.spcalignment.com](http://www.spcalignment.com) under your kit's part number.

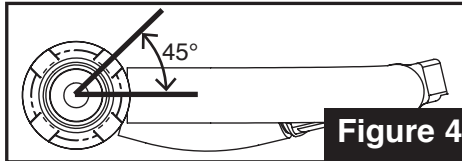


**Tech Tip:** To preserve alignment settings, disconnect ball joint at knuckle. Take care not to damage threads on ball joint shaft. Use PN 37985 separator or equivalent.

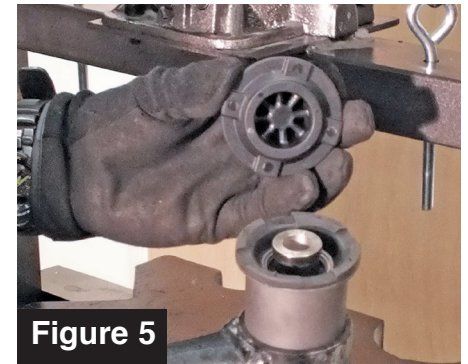
2. For each bushing, remove steel center sleeves with a hammer and drift.
3. Clamp one leg of arm into vice and then use a scraper or sharp chisel to cut outer lip off SpecRide™ bushing. See **Figure 1**.
4. Use hammer to tap SpecRide™ bushing out.
5. Repeat steps 2 through 4 on second leg.
6. Clean both end rings thoroughly and remove any sharp edges. See **Figure 2**.
7. Place one of provided spacers over each xAxis™ bushing. See **Figure 3**, NOTE: Your spacer thickness may vary depending on application.

**Figure 1****Figure 2**

8. Align castellation's on xAxis™ flange per **Figure 4**. (25455 arms only).

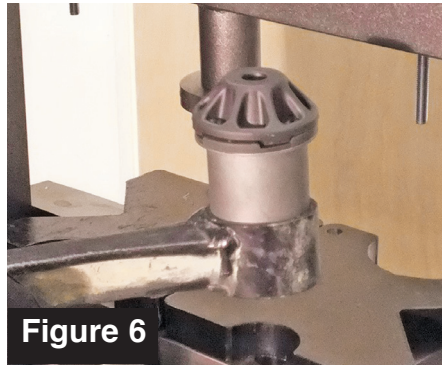
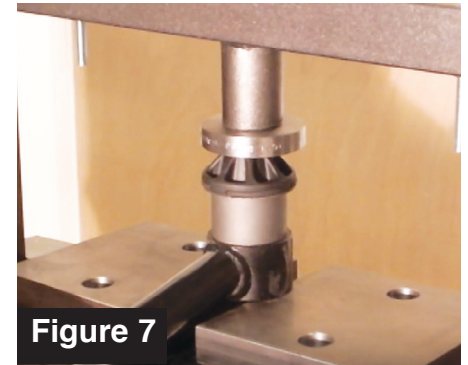
**Figure 4**

9. Using provided press tool, install xAxis™ bushing with spacer from outside. Be sure to align square tabs of press tool with square tabs of xAxis™ bushing. See **Figure 5, 6, and 7**.

**Figure 3****Figure 5**

10. Using a manual press, press until xAxis™ flange seats against spacer. A receiver or arbor plate with an opening large enough to accept protruding part of bushing must be used under arm.

**CAUTION: DO NOT USE EXCESSIVE FORCE. DO NOT USE A PRESS EQUIPPED WITH A MOTORIZED OR AIR-OVER-HYDRUALIC RAM! Press must be manual pump, or arbor press.**

**Figure 6****Figure 7**

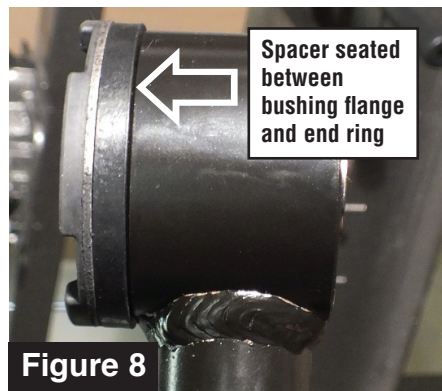
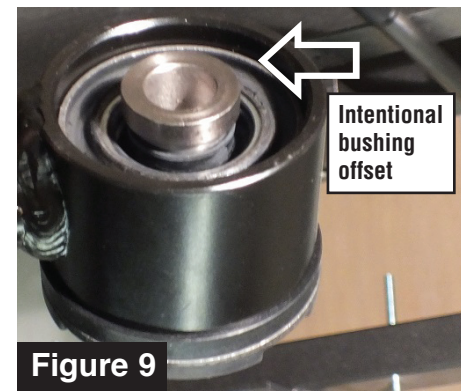
11. Stop pressing as soon as xAxis™ bushing lip and spacer are tight against end ring. See **Figure 8 & 9**.

12. Repeat step 2 through 11 on second arm.

13. Re-install arms on vehicle using most up to date instructions for your application. Current instructions can be found at [www.spcalignment.com](http://www.spcalignment.com) under your kit's part number.

Videos of this installation can be found at [www.spcalignment.com](http://www.spcalignment.com)

Always check for proper clearance between suspension components and other components of vehicle.

**Figure 8****Figure 9****Specialty Products Company®**

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