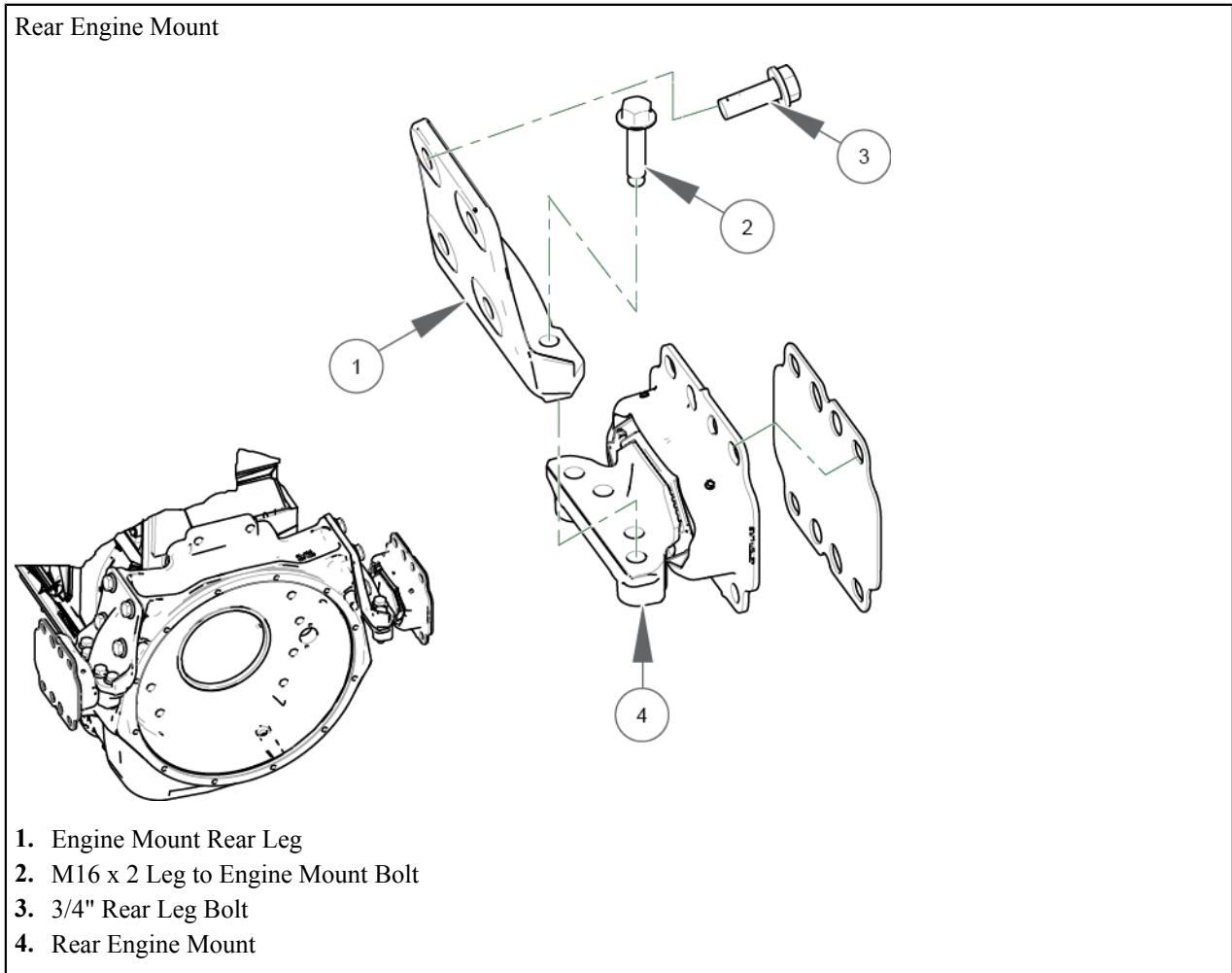


How to Replace Trelleborg Rear Engine Mount

This procedure replaces the rear engine mounts.

Fasteners found to be loose upon inspection must be replaced, NOT re-torqued. If replacing an engine mount, and the engine is out of position, BOTH mounts and legs must be replaced. The opposite side mount should be considered over-stressed and damaged.

If the leg to mount joint fails on a mount in the field always replace BOTH mounts and legs. With this joint apart, the engine falls to a certain extent and stresses the opposite side mount enough that it may be damaged.



1. Park the vehicle on level ground and engage the parking brake and block the wheels.
2. Support engine with hoist crane or engine jack throughout procedure.
3. Use blocks or engine stands as a backup safety device.
4. Remove the masking strip from the mating surface of the two new rear engine mounts.
5. Install mount to the left-hand (driver's side) rail. Tighten 12 mm bolts to 55-75 Lb-Ft (75-102 Nm). Tighten 16 mm bolts to 120-160 Lb-Ft (163-217 Nm).
6. Install mount to the right-hand (passenger's side) rail. Tighten 12 mm bolts to 55-75 Lb-Ft (75-102 Nm). Tighten 16 mm bolts to 120-160 Lb-Ft (163-217 Nm).
7. Install engine leg to the right-hand flywheel housing mounting pad. Tighten 3/4" bolts to 243-297 Lb-Ft (329-402 Nm).

- 8.** Install engine leg to the left-hand flywheel housing mounting pad. Tighten 3/4" bolts to 243-297 Lb-Ft (329-402 Nm).
- 9.** If necessary, slightly lower the engine down to minimize the gap between the engine mounts and engine legs.
- 10.** Install the leg to engine mount bolts.
- 11.** Once all leg to engine mount bolts have been started, tighten bolts to 140-160Lb-Ft (190-217Nm).
- 12.** The mounts will now support the engine weight. Remove the safety blocks or stands.
- 13.** Lower the engine to set the engine completely on the mounts. Release all tension from the engine hoist. If the chassis was lifted to aid removal, place the vehicle back on the ground to ensure that the chassis is square with the engine.
- 14.** Tighten leg to engine mount bolts a second time to 210-230 Lb-Ft (284-311 Nm).