



## BK063 – ALUMINUM LOCKOUT BUSHING INSTALLATION INSTRUCTIONS

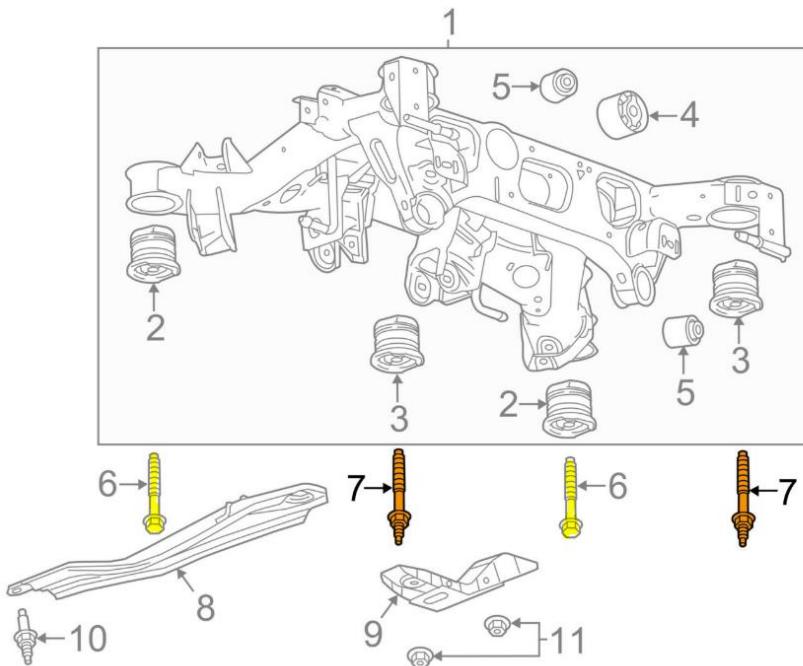
### RECOMMENDED TOOLS:

- Hydraulic jack and jack stands
- Ratchet with the following sockets: 15mm deep, 18mm deep
- Hammer



**NOTE:** General Motors requires that you replace the front and rear main cradle bolts as they are Torque to Yield bolts also known as T.A.Y. fasteners (Torque Angle Yield) or single use fasteners. During development and testing we have not replaced any of these bolts, your mileage may vary.

- Forward, Rear Cradle Bolts:  
Part # 11547921 (74ftlbs + 90-105 degrees) Shown as #6
- Rearward, Rear Cradle  
Bolts/Stud: Part # 11611819  
(74ftlbs + 90-105 degrees)  
Shown as #7





## BK063 – ALUMINUM LOCKOUT BUSHING INSTALLATION INSTRUCTIONS

### INSTALLATION:

1. Lift vehicle and safely support with jack stands under the rocker as shown. Leave room to remove the cradle braces on the front of the rear cradle. (**IMAGE 1**)
2. Begin with the front cradle bushings. Place the hydraulic jack under the front of the cradle. Using a 15mm socket, remove the two front bolts on the cradle braces as shown in **IMAGE 2**. Using an 18mm socket, remove the front main cradle bolts.
3. Once both front braces and main front bolts have been removed, lower the front of the cradle to allow access to the top of the front cradle bushings.
4. Insert the gold colored spacers into the factory bushings as shown in **IMAGE 3**. Also insert the appropriate black Delrin lockout onto the top bushing as shown in **IMAGE 4**.





## BK063 – ALUMINUM LOCKOUT BUSHING INSTALLATION INSTRUCTIONS

5. Raise the cradle back up flush with the body. Insert the appropriate black Delrin lockouts as shown in **IMAGE 5** and then the large stainless washer. Re-install the factory cradle braces (or BMR cradle braces) and insert and start the bolts finger tight.
6. Remove the rear cradle braces using a 15mm and 18mm socket. (**IMAGE 6**)
7. Remove the main rear cradle bolts using an 18mm socket then lower the rear of the cradle enough to allow access to the upper part of the cradle bushings.
8. Insert the appropriate lockout into the top of the bushing, rotating it until it locks into place. Lift the cradle back up into position.
9. Locate the 8 bullet shaped inserts in the kit. Apply grease to the pointed ends of the inserts and push them up into the voids of the bushings as shown in **IMAGE 7**.
10. Position the aluminum washer into the void of the bushing and re-install the factory bolt as shown in **IMAGE 8**. Tighten the main bolts to 74ftlbs on the first pass and then an additional 90-105 degrees.



**IMAGE 4**



**IMAGE 5**



**IMAGE 6**



**IMAGE 7**



## BK063 – ALUMINUM LOCKOUT BUSHING INSTALLATION INSTRUCTIONS

11. Re-install the rear factory cradle braces to the stud on the main rear cradle bolt and torque to 50 ftlbs.
12. Torque front main cradle bolts to 74ftlbs on the first pass and then an additional 90-105 degrees.
13. Then torque the front and rear cradle brace to chassis bolts to 43 ftlbs.
14. Lower vehicle



**IT IS ALSO RECOMMENDED THAT YOU HAVE YOUR VEHICLE PROFESSIONALLY  
REALIGNED AFTER YOUR INSTALLATION IS COMPLETE.**

***NOTE: To provide better visibility for photography, we removed the exhaust for these instructions, however this is not necessary for the installation. Additionally, for illustrative purposes, some pictures are taken with a cradle removed from the vehicle. All components in this kit can be installed without removing the cradle.***

**[WWW.BMRSUSPENSION.COM](http://WWW.BMRSUSPENSION.COM)**

*This product is an aftermarket accessory and not designed by the vehicles manufacturer for use on this vehicle. As such, Buyer assumes all risk of any damage caused to the vehicle/person during installation or use of this product.*