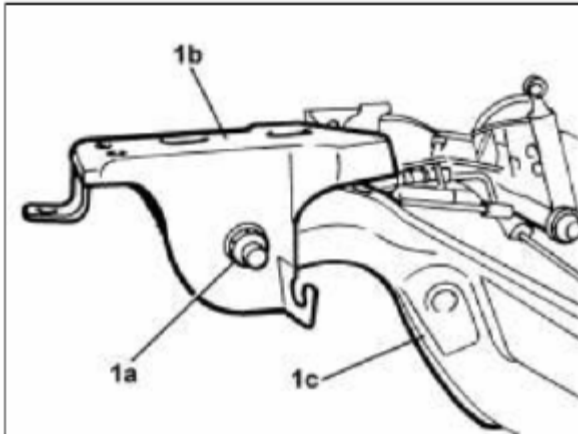


STILO 1.9 JTD REAR AXLE SUSPENSION BUSH – REPLACE WITH CROSSBEAM/AXLE REMOVED 4420D24

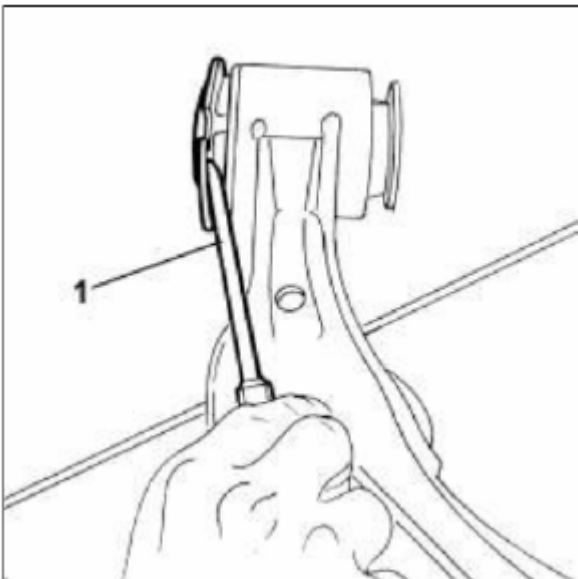
APPLIES TO MODELS: Station Wagon, 5-door

REMOVING:



In case of replacement of the hydraulic bushes it is imperative to mark, in a clear and permanent way (e.g. with indelible white paint) the seat of the replaced bushes and the axle housings. This is because it is **STRICTLY FORBIDDEN** to replace the bushes more than once on the same axle.

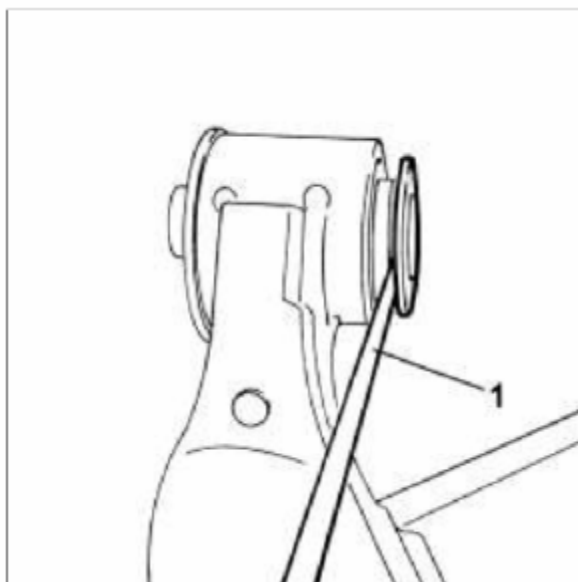
1. Unscrew the bolt (1a) and detach the bracket fixing (1b) from the axle (1c)



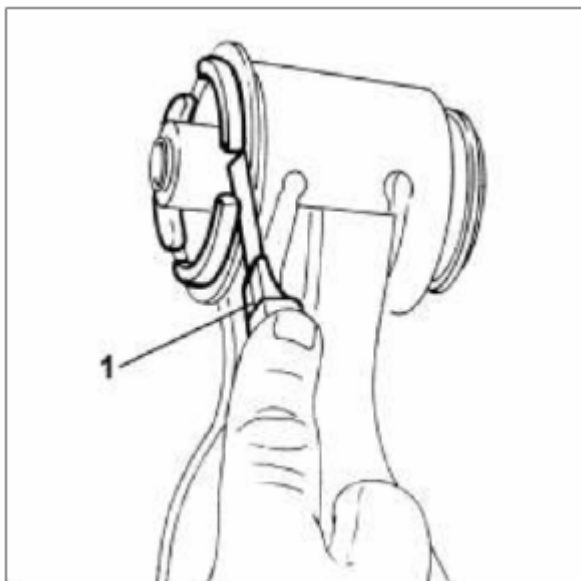
The bush is hydraulic, it contains an oily substance inside so be careful during removal as leakage could occur. The area involved has lots of structural welds, so the positioning of the tools could be difficult because of access. **DO NOT MODIFY OR REPAIR THE WELDING.** The axle is painted to be resistant to corrosion and rust, therefore, pay attention as the equipment could cause damage to the paint.

Place the axle in a vice protected by rubber pads.

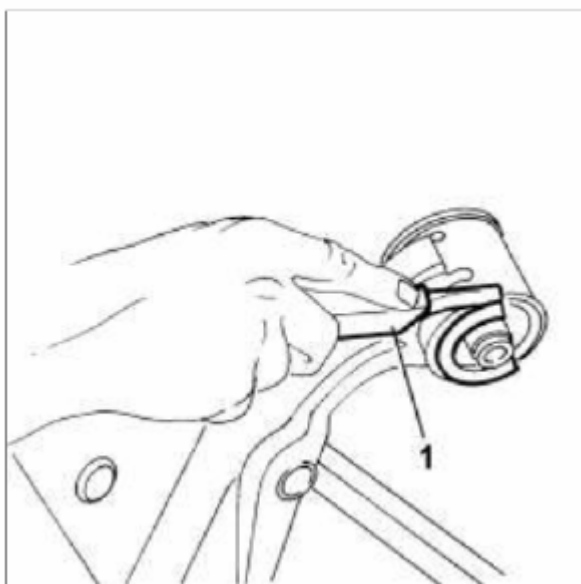
1. Using a large flat screwdriver, remove the metal spacer plate.



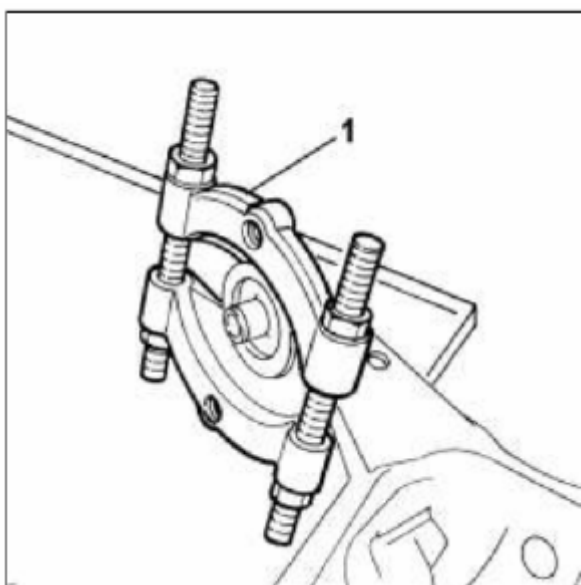
1. Using a large flat screwdriver, remove the rubber covered spacer pad.



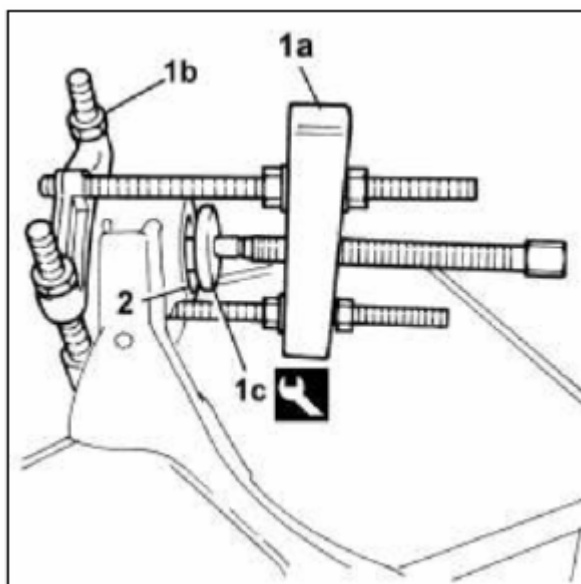
1. Use a sharp knife to remove the rubber buffers from the end of the bush.



1. Use a sharp knife to cut around the internal rubber filling of the bush.



1. Assemble the extractor portion of the reaction ring between the free end of the stroke of the driving bushing and welds.



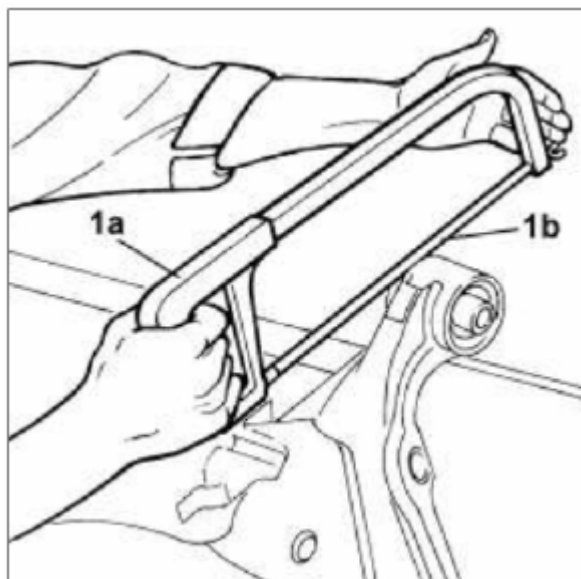
1. Fit extractor (1a) coupled to extractor reaction clamp (1b) and use the tool (1c) as the contact surface between the bush and puller.

	Title	Code	Function
1c	Spacer	2000000500	Bush extractor

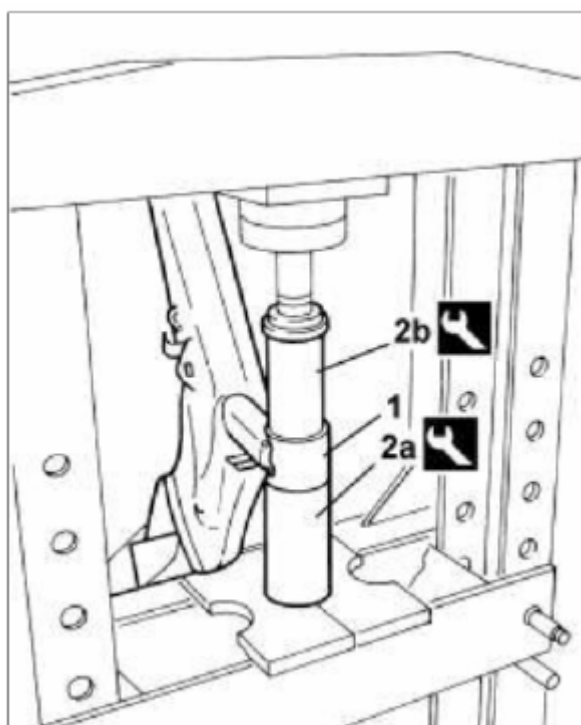
2. Acting on the extractor as shown in the diagram, move the bush about 2mm.

During this operation, an oily substance can leak from the bush.

Avoid damaging the metal housing of the axle.



1. Using a hacksaw, completely remove the inner face of the bush.

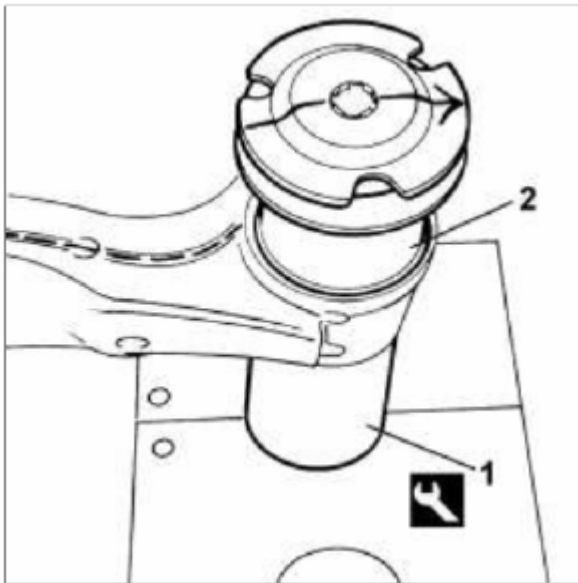


The bush must be removed from the centre of the axle towards the outside of the car.

1. Position the axle to the press.

2. Use the tool (2a) on the press base plate and the tool (2b) to press out the old bush.

	Title	Code	Function
2a	Support	2000000200	Axle support
2b	Extractor	2000000300	Press piece

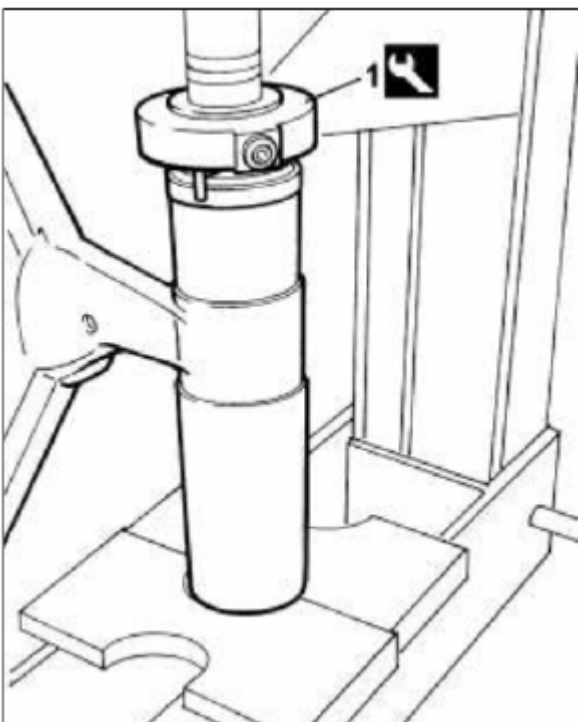
REFITTING:

The inside of the bush housing must be thoroughly cleaned, then smear the outside of the new bush with grease (Molykote PG21)

1. Use the tool (1) as a support for pressing the new bush.

2. The bush must be orientated correctly as shown in the diagram. The arrow on both left and right bushes must be aligned with the welded axle seam and both must point towards the front of the car.

	Title	Code	Function
1	Support	2000000200	Axle support



The press force **MUST NOT** be applied to the washer located on the end of the bush.

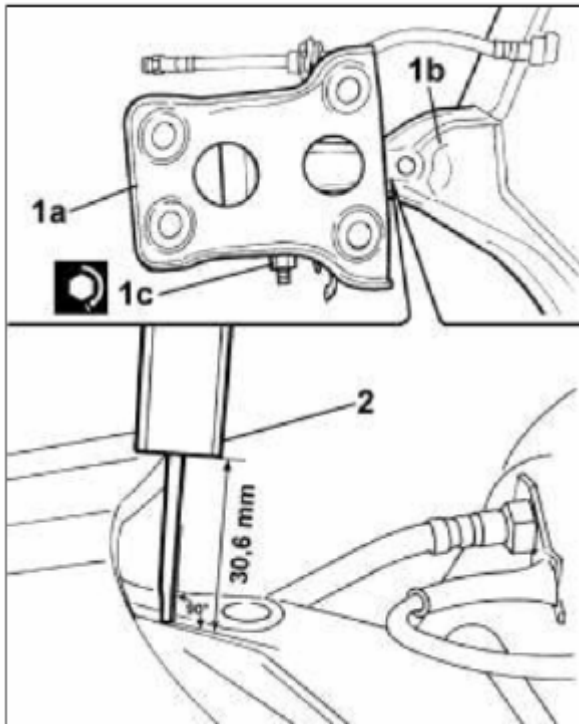
The minimum pressing force should not be less than 1500 KG

1. Locate the three pronged press piece in the three cut-outs of the washer and then proceed to press in the new bush.

	Title	Code	Function
1	Insertor	2000000400	Press piece

This operation is complete when the lip around the end of the bush is in contact with the end of the axle housing.

During this procedure, the contact points between the tools and the axle housing may have damaged the protective paint on the axle. It is therefore necessary to restore the damaged areas with suitable anti-rust paint.



1. Place the fixing brackets (1a) in position on the axle (1b) using the bolts and nuts (1c) WITHOUT tightening them.

Rotate the mounting bracket until the distance between the top of the bracket and the axle is a distance of 30.6 mm as shown in the diagram with a tolerance of ± 0.2 mm. Ensuring that the angle between the measurement plane of the axle and the gauge is 90° .

Tighten to torque the fixing bolt (1c).

	daNm	Dia.	Component
1c	9.5	12 mm	Axle bush bolt