INSTALLATION INSTRUCTIONS

Unitronic Dogbone Mount Upgrade (Race) for DQ381
UH010-DRA

Unitronic recommends that you read through the entire installation instructions prior to beginning the installation to familiarize yourself with the included components, tools required, and procedures involved with the installation.

DISCLAIMER: Unitronic recommends that a Unitronic Authorized Dealer or other qualified and trained professional should perform the installation of this product.

Unitronic Installation Instructions are also available in digital format, if you prefer. Please visit the corresponding product page for a link to download the digital Installation Instructions. www.getunitronic.com

It is recommended to confirm all parts are present prior to beginning the installation.

PACKING LIST:

PART NUMBER	DESCRIPTION	QUANTITY INCLUDED
UH007-DR6	Unitronic Dogbone Arm for DQ381	1
UH002-DR6	Unitronic Yellow Poly Bushings	2
UH003-DR6	Unitronic Dogbone Insert	2
UH010-DR6	Unitronic Dogbone Mount Top Cap	1
UH011-DR6	Unitronic Dogbone Mount Bottom Cap	1
UH001-DR0	Hardware Kit for Dogbone Mount	1

RECOMMENDED TOOLS NEEDED:

- T25 Torx
- T45 Torx
- 18mm Socket
- 21mm Socket
- 22mm Socket
- 18mm Wrench
- 3/8 or 1/2 Drive Ratchet (optional)
- 3/8 or 1/2 Drive Torque Wrench
- Impact gun (Optional)
- Sawzall with blade appropriate for cutting metal & plastics
- Rubber Mallet
- Pry Bar/Screwdriver
- 3 in PVC Pipe x 4 to 6 inches long (optional insertion tool)
- Silicone Spray (optional)
- Extra Light source, if required
- Emery Cloth/Scotch pad

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1. Secure your vehicle on hoist to gain access to the underside of the vehicle
2. Using the T25 Torx, remove the seven (7) screws fastening the underbody front cover. (See Fig. 1)
3. Using the T45 Torx, remove the last three (3) screws fastening the back end of the belly pan. Remove the belly pan from the vehicle. (See Fig. 2) ****If applicable to your model.**
4. Using the 18mm socket, remove the two (2) bolts fastening the yoke to the engine and transmission. (See Fig. 3)
5. Using the 21mm Socket, remove the bolt fastening the original dogbone arm to the original rubber mount. Proceed with removing the dogbone arm out from the mount. (See Fig. 3)
6. Place the dogbone arm and yoke assembly on a table; using the 18mm socket and wrench, remove the bolt fastening the yoke to the OEM dogbone arm. The original yoke will be used with the installation of the new Unitronic dogbone mount assembly. (See Fig. 4)
7. Using the sawzall, locate the front section of the lower bushing where there is the least material to cut through. With caution, cut the bushing until through. To make it easier to remove lower bushing, add another cut to the opposite side. (See Fig. 5 & 6)
8. Using the pry bar or large screwdriver, remove the lower bushing from the subframe. (See Fig. 7)
9. Again, using the sawzall, locate the front section of the upper bushing where there is the least material and cut with caution until through. (See Fig. 5 & 6)

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FIG. 1

FIG. 2

FIG. 3

FIG. 4

FIG. 5

FIG. 6

FIG. 7

QUESTIONS OR CONCERNS? CALL US TOLL-FREE AT **1.866.341.2447** OR EMAIL US AT **INFO@GETUNITRONIC.COM**

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10 Again, using the pry bar or large screwdriver, remove the upper bushing from the subframe. (See Fig. 8)

11 Inspect the bore in case there were any burrs made during the removal of the upper and lower bushings. Using the emery cloth or scotch pad, smoothen the affected areas as best as possible. Remove debris from the bore.

12 Locate the Unitronic Top cap (UH010-DR6), 1x Unitronic Yellow Poly Bushings (UH002-DR6) and 1x Unitronic Dogbone Insert (UH003-DR6). Insert the Top Cap in the Poly Bushing and then the Poly Bushing into the Dogbone Insert. Make sure to align the Poly Bushing alignment tab to correspond with the alignment notch on the Dogbone Insert.

13 With the top cap facing up and the recess aligned to the front of the car (Unitronic logo towards the back), locate and align the rectangular notch of the Unitronic Dogbone Insert (UH003-DR6) with the corresponding rectangular opening on the subframe. (See Fig. 9)

14 With a rubber mallet, press in the subframe the Dogbone insert bushing. Once it is recessed enough, use the 3 inch PVC pipe to continue inserting until halfway to the top end of the bore. (See Fig. 10 & 11)

15 Once inserted, inspect through rectangular opening in the subframe, the Dogbone Insert is seen to sit approximately 2 mm below the top edge of the subframe hole. During this operation, be sure to maintain the alignment of the Dogbone Insert with the subframe rectangular opening. (See Fig. 12 & 13)

16 Locate and align the rectangular notch of the 2nd Unitronic Dogbone Insert (UH003-DR6) with the subframe opening. As was done previously (step 14); carefully tap the Dogbone Insert, axially centered, until the upper edge contacts with the upper Dogbone Insert. Inspect both Dogbone Inserts for alignment with the corresponding rectangular opening in the subframe.

FIG. 8

FIG. 9

FIG.10

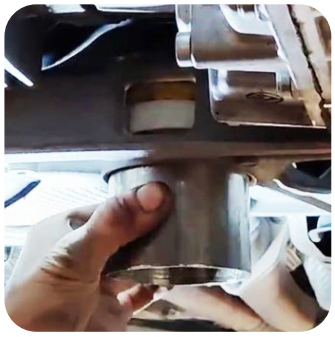
FIG.11

FIG.12

FIG.13

17 Using the 18 mm Socket and 18mm Wrench, assemble the original yoke to the Unitronic Dogbone Arm (UH007-DR6). (See Fig. 14)

18 Lightly apply silicone spray to the recessed areas of the upper and lower Poly Bushings.

19 Insert the Unitronic Yellow Poly Bushing (UH002-DR6) into the lower Unitronic Dogbone Insert (UH003-DR6) aligning the Poly Bushing alignment tab to correspond with the alignment notch on the Dogbone Insert.

20 Insert the Unitronic Dogbone Arm (UH007-DR6) into the subframe opening to interface and engage the upper and lower Poly Bushing. (See Fig. 15)

21 Insert the Unitronic Bottom Cap (UH011-DR6) with the supplied 22 mm Bolt and Lock Washer (UH001-DR0) into the lower Poly Bushing with the Unitronic Logo toward the back and the recess towards the front of the car. Configure the lock washer, so the conical side is facing up, in contact with the Bottom Cap. Hand tighten the bolt until snug. (Fig. 16)

22 Using the 18 mm socket, align and hand tighten the yoke using the two original 18mm bolts for the engine and transmission. The OEM recommends replacing these bolts after removing, to always install by hand for the first few turns, and cautions that there is a risk of damaging the threads on the transmission threaded connection of the body. Torque accordingly to 37 ft-lbs + 90° (50 Nm + 90°). (See Fig. 17)

23 Using the 18 mm Socket and 18mm Wrench, torque the original yoke to the Unitronic Dogbone Arm (UH007-DR6) accordingly to 75 ft-lbs (100 Nm). (See Fig. 14)

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FIG. 14

FIG. 15

FIG. 16

FIG. 17

24 Using the 22mm socket and torque wrench, torque the 22mm bolt (UH001-DR0) to 75 ft-lbs.

25 Reassemble your underbody front cover.

26 Safely lower the car and proceed to take it for a test drive

CONGRATULATIONS! You have successfully installed Unitronic's Dogbone Mount!

NOTE: At temperatures below zero° degree Celcius (32° degree Fahrenheit) NVH will most likely increase.

When engine and mount temperatures are back to normal levels, NVH will decrease back to normal as well

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