



Chevrolet Camaro Gen 6 Solid Rear Cradle Mount Kit REMOVAL & INSTALLATION INSTRUCTIONS

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It is not the intent of these specifications to replace the comprehensive and detailed service practices explained in the GM service manuals. For detailed installation instructions please look to the service manual for your specific vehicle.

GM service manuals are available from:
Helm Incorporated
PO Box 07130
Detroit, MI 48207

For information about warranty coverage, please contact your local Chevrolet Performance parts dealer.

Observe all safety precautions and warnings in the service manuals when installing this kit in any vehicle. Wear eye protection and appropriate protective clothing. Support the vehicle securely with jack stands when working under or around it. Use only the proper tools. Exercise extreme caution when working with flammable, corrosive, and hazardous liquids and materials. Some procedures require special equipment and skills. If you do not have the appropriate training, expertise, and tools to perform any part of this conversion safely, this work should be done by a professional.

The information contained in this publication is presented without any warranty. All the risk for its use is entirely assumed by the user. Specific component design, mechanical procedures, and the qualifications of individual readers are beyond control of the publisher, and therefore the publisher disclaims all liability incurred in connection with the use of the information provided in this publication.

Note: Installation of the solid inserts for the rear suspension cradle may only be performed ONCE. If removal of the solid inserts from the rear suspension cradle is required for any reason, a NEW rear suspension cradle must be used.

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TITLE	Chevrolet Camaro Gen 6 Solid Rear Cradle Kit	IR 18AU17	PART NO.	84376493	SHEET	1	OF	57
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ALL INFORMATION WITHIN ABOVE BORDER TO BE PRINTED EXACTLY AS SHOWN ON 8 1/2 x 11 WHITE 16 POUND BOND PAPER. PRINT ON BOTH SIDES, EXCLUDING TEMPLATES. TO BE UNITIZED IN ACCORDANCE WITH GM SPECIFICATIONS.	DATE	REVISION	AUTH
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<u>Part Number</u>	<u>Component Description</u>	<u>Quantity</u>
84013288	Rear Suspension Cradle - Front Upper Solid Insert	2
84013289	Rear Suspension Cradle - Front Lower Solid Insert	2
84013290	Rear Suspension Cradle - Rear Upper Solid Insert	2
84013291	Rear Suspension Cradle - Rear Lower Solid Insert	2
84376493	Instruction Sheet	1
11611819	Rear Suspension Cradle - Rear Mount Bolt	2
11547921	Rear Suspension Cradle - Front Mount Bolt	2
11609598	Rear Lower Shock Absorber - Bolt	2
11547215	Rear Lower Control Arm - Cam Bolt	2
11516382	Rear Lower Control Arm - Nut	2
11547262	Rear Lower Control Arm - Cam Washer	2
11611276	Rear Adjustable Link - Cam Bolt	2
11611277	Rear Adjustable Link - Cam Washer	2
11516078	Rear Adjustable Link - Nut	2
22942442	Performance Emblem	1

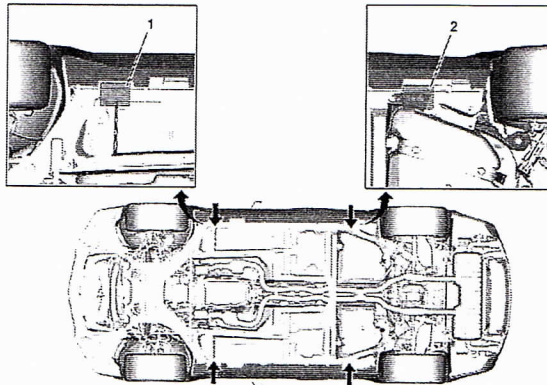
Required Tools:

- GM Service Tool Kit *DT-50806*
- CH-51034* Cradle Alignment Pin or suitable wooden dowel
- Two (2) ton adjustable jack stand (Qty 2 required)

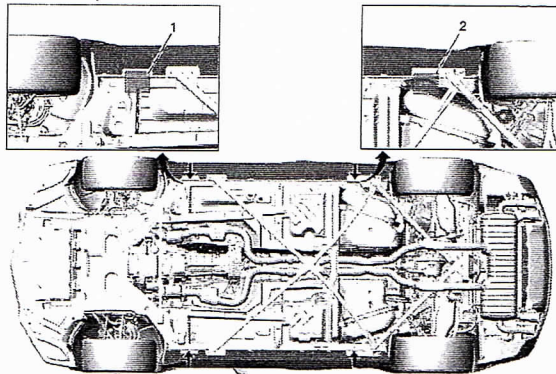
Lifting and Jacking the Vehicle

Note: The use of a LOW PROFILE LIFT ARMS SYSTEM may be required to avoid unwanted contact with the vehicle's body and structure depending on lifting equipment used. Refer to the manufacture's recommendation for their applications of low profile lift arms system for their lifting equipment.

Vehicle Lift Points (ZL1 Applications)



Vehicle Lift Points (Convertible Applications)

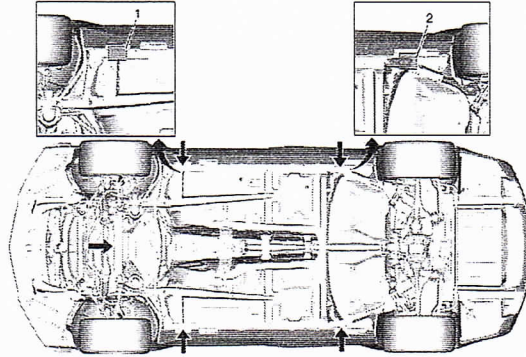


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Vehicle Lift Points (Base Vehicle Applications)



Danger: To avoid any vehicle damage, serious personal injury or death:

- When major components are removed from the vehicle and the vehicle is supported by a hoist, support the vehicle with jack stands at the opposite end from which the components are being removed and strap the vehicle to the hoist.
- When performing work in the engine compartment or under the vehicle, ensure that the hood is fully open, or opened to its secondary latch. When the hood is opened to the secondary latch, the vehicle will disable the remote start features from the key fob and OnStar mobile app. Failure to open the hood, or open the hood to the secondary latch while doing a repair in the engine compartment or under the vehicle can result in inadvertent vehicle starting which could result in personal injury or damage to a vehicle.

Danger: To avoid any vehicle damage, serious personal injury or death, always use the jackstands to support the vehicle when lifting the vehicle with a jack.

Caution: Perform the following steps before beginning any vehicle lifting or jacking procedure:

- Remove or secure all of the vehicle contents in order to avoid any shifting or any movement that may occur during the vehicle lifting or jacking procedure.
- The lifting equipment or the jacking equipment weight rating must meet or exceed the weight of the vehicle and any vehicle contents.
- The lifting equipment or the jacking equipment must meet the operational standards of the lifting equipment or jacking equipment manufacturer.
- Perform the vehicle lifting or jacking procedure on a clean, hard, dry, level surface.
- Perform the vehicle lifting or jacking procedure only at the identified lift points. DO NOT allow the lifting equipment or jacking equipment to contact any other vehicle components

Failure to perform the previous steps could result in damage to the lifting equipment or the jacking equipment, the vehicle, and/or the vehicle contents.

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Vehicle Lifting – Frame Contact Lift

Note: The vehicle should be lifted so that the hoist pads and or lift arms do not contact the rocker panel molding. The hoist pad must be located in the designated area. In the front location, place the lift pads on the rocker outer panel weld flange. In the rear location, place the lift pads on the rocker outer panel rear cradle brace. Care should be taken to ensure the hoist pad is inside the rocker panel molding cut out area (notch) to prevent damage to the vehicle.

Front Lift Pads

When lifting the vehicle with a frame-contact lift, place the front lift pads on the rocker outer panel weld flange as close to the rocker cut out as possible (1), as shown

Rear Lift Pads

When lifting the vehicle with a frame-contact lift, place the rear lift pads on the chassis brace so it covers both edges of the brace (2), as shown.

Vehicle Jacking

Caution: When you are jacking the vehicle at the front locations, be certain that the jack or the jack lift pad does not contact the front fascia, front fascia air dam, or the front fenders. If such contact occurs, vehicle damage may result. When jacking at selected front locations additional clearance may be required for the jacking points.

Note: When you are lifting a vehicle with a service jack, block the wheels at the opposite end from which you are lifting. Use jack stands to provide additional support.

Front of Vehicle

When using a service jack under the front of the vehicle use one of the following locations:

Place the service jack pad in the same location as shown for the front lift pads or on the front center jack pad.

Rear of Vehicle

Note: Place jackstands ONLY under strong and stable vehicle structures.

Place the service jack pad in the same location as shown for the rear lift pads.

Fastener Caution

Caution: Use the correct fastener in the correct location. Replacement fasteners must be the correct part number for that application. Do not use paints, lubricants, or corrosion inhibitors on fasteners, or fastener joint surfaces, unless specified. These coatings affect fastener torque and joint clamping force and may damage the fastener. Use the correct tightening sequence and specifications when installing fasteners in order to avoid damage to parts and systems. When using fasteners that are threaded directly into plastic, use extreme care not to strip the mating plastic part(s). Use hand tools only, and do not use any kind of impact or power tools. Fastener should be hand tightened, fully seated, and not stripped.

Torque-to-Yield Fastener Warning

Warning: This vehicle is equipped with torque-to-yield or single use fasteners. Install a NEW torque-to-yield or single use fastener when installing this component. Failure to replace the torque-to-yield or single use fasteners could cause damage to the vehicle, component, or bodily injury.

Kit Installation Instructions

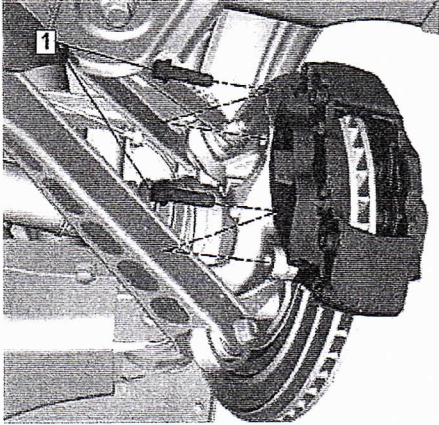
1. Put vehicle in Neutral
Note: If vehicle will be left for an extended period of time, disconnect battery.
2. For LS/LT vehicles, release electronic park brake
3. Raise and support vehicle per GM Lift and Jacking Guidelines
4. Remove rear tire and wheel assemblies

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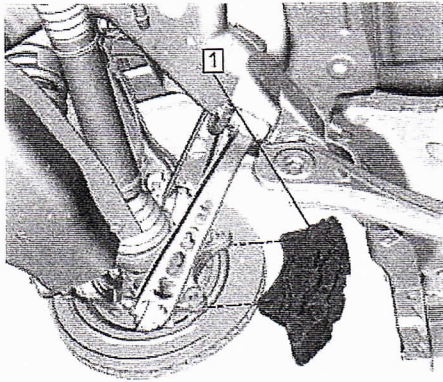
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Rear Brake Caliper Removal (SS and ZL1 Applications)



5. Brake Caliper Bolt (1) » Remove [2x]



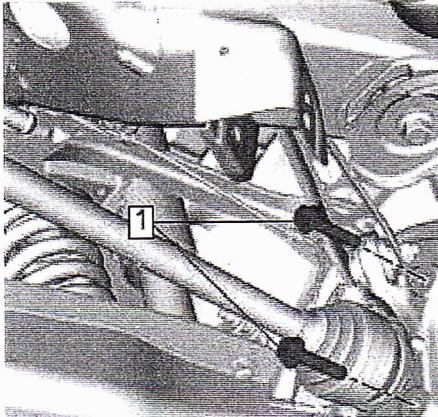
6. Brake Caliper Assembly (1) » Remove

Caution: Support the brake caliper with heavy mechanic wire, or equivalent, whenever it is separated from its mount and the hydraulic flexible brake hose is still connected. Failure to support the caliper in this manner will cause the flexible brake hose to bear the weight of the caliper, which may cause damage to the brake hose and in turn may cause a brake fluid leak.

7. Support the brake caliper assembly with heavy mechanics wire.

Rear Brake Caliper Removal (LS and LT Applications)

8. Release the electronic parking brake.



9. Brake Caliper Bracket Bolt (1) » Remove [2x]

10. Brake Caliper and Bracket Assembly (1) » Remove

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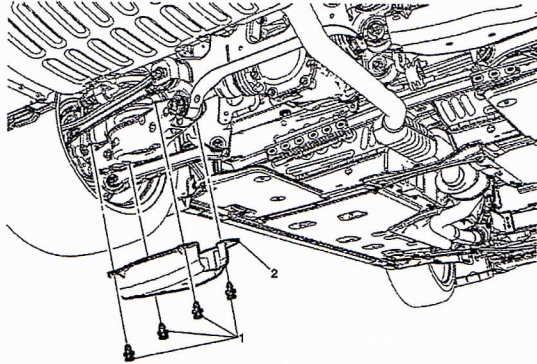
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Caution: Support the brake caliper with heavy mechanic wire, or equivalent, whenever it is separated from its mount and the hydraulic flexible brake hose is still connected. Failure to support the caliper in this manner will cause the flexible brake hose to bear the weight of the caliper, which may cause damage to the brake hose and in turn may cause a brake fluid leak.

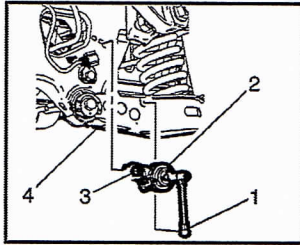
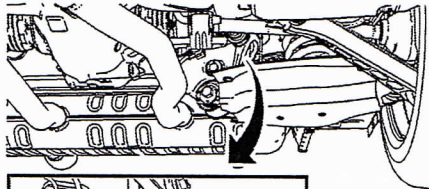
11. Support the brake caliper and bracket assembly with heavy mechanics wire.

Rear Damper Bolt Removal (All Applications)



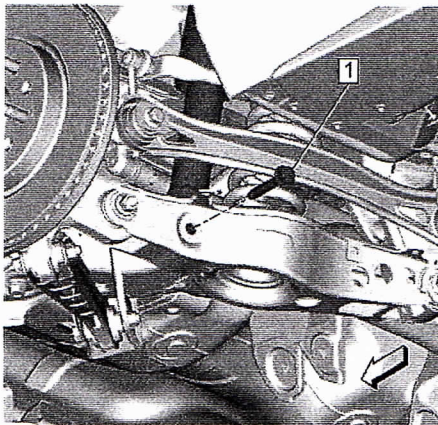
12. Rear suspension lower control arm cover push pins (1) » Remove [4x]

13. Rear suspension lower control arm cover (2) » Remove



14. {If equipped} Level sensor link (1) from the lower control arm (4) » Disconnect

15. Using a hydraulic jack or adjustable jack stand, support the rear lower control arm.



16. Lower rear shock absorber bolt (1) » Remove and DISCARD the bolt

17. Lower hydraulic jack or adjustable jack stand

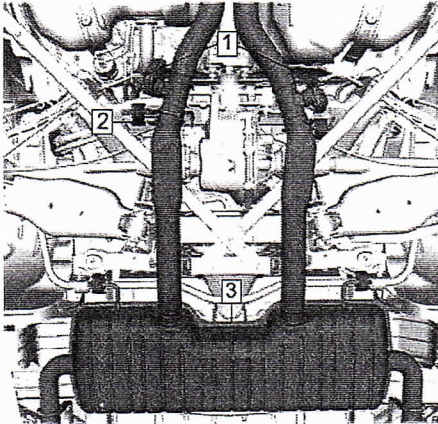
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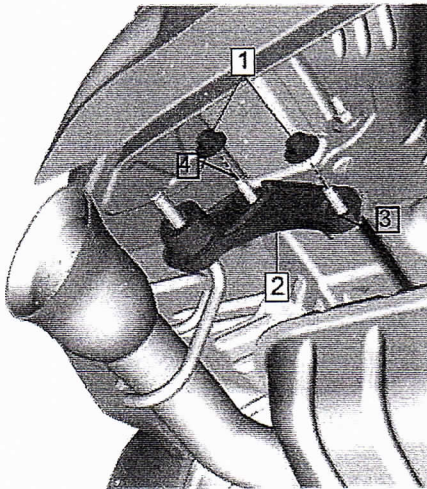


Exhaust Removal (All Applications)

18. {If equipped} Disconnect the rear exhaust control valve actuator electrical wiring harness connectors associated with the performance exhaust option.

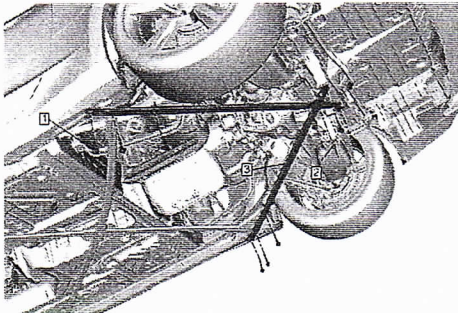


19. {If equipped} Exhaust Control Valve Actuator (1) » Disconnect [2x]
20. Exhaust Isolator (2) » Separate [4x]



21. Exhaust Rear Muffler Insulator Nut (1) » Remove [2x]
22. Hang exhaust bracket hole (3) on stud (4) for support during kit installation.
23. Loosely install nut to ensure exhaust does not fall.

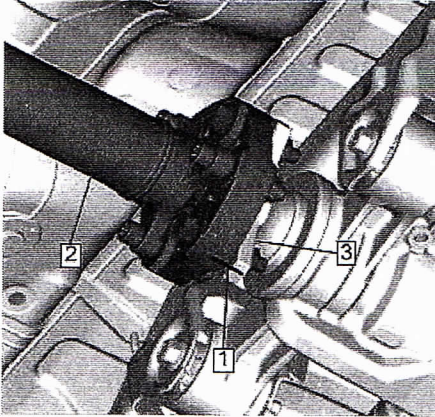
Floor Panel Tunnel Rear Brace Removal (Convertible Only)



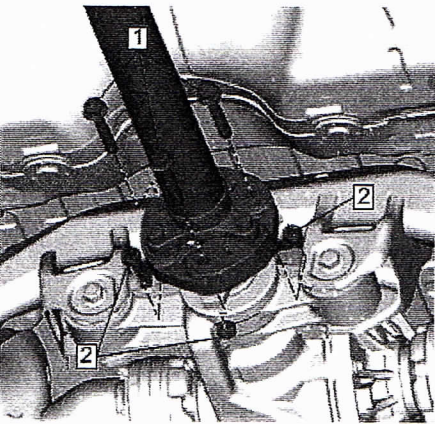
24. Floor panel tunnel rear brace bolts (1) » Remove [8x]
25. Floor panel tunnel rear brace nut (2) » Remove
26. Floor panel tunnel rear brace (3) » Remove

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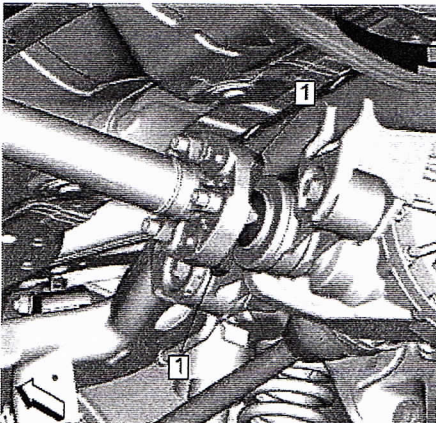
Prop Shaft Separation (All applications)



27. Mark (1) the relationship of the propeller shaft flange (2) and the rear axle pinion flange (3).



28. Rear propeller shaft bolts (1) and the nuts (2) » Remove [3x]



Caution: Care should be taken not to use sharp or pry tools when separating the propeller shaft coupler from the drive flange. Damage to the coupler could result and replacement of the entire propeller shaft would be required.

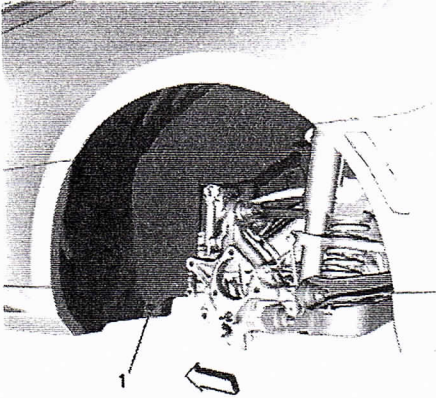
Note: It may be necessary to apply a small amount of penetrating lubricant or WD-40® to the area shown (1) to aid in separation of the propeller shaft coupling.

29. If the propeller shaft does not easily separate from the differential, use a rubber mallet to gently tap the locations (1) on the rubber coupling shown above to separate.

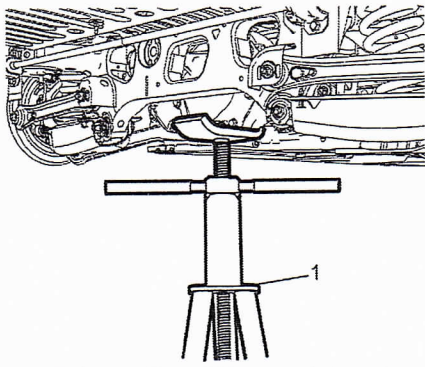


Front Body Bracket Removal (All Applications)

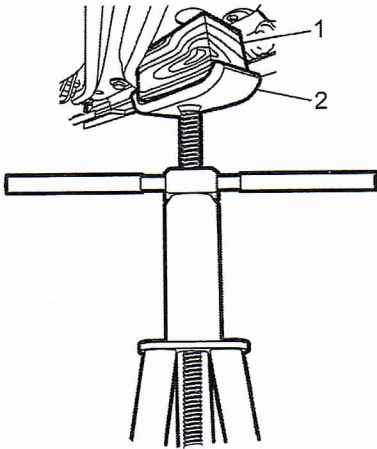
Note: The front body bracket removal and hoist pad relocation process must be done one side at a time.



30. Rear Wheelhouse Liner Screw(1) » Remove



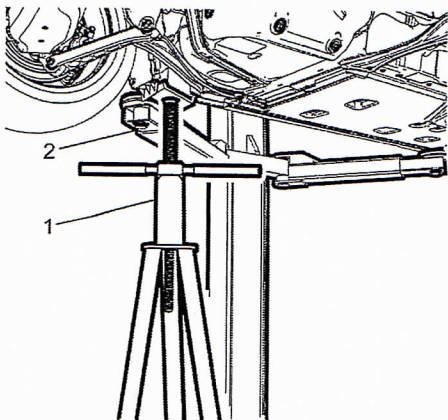
31. Using an adjustable 2 ton tripod jack stand (1), support the rear drive axle.



32. Position a block of wood (1) and an adjustable 2 ton tripod jack stand (2) between the frame of the vehicle and the suspension bracket

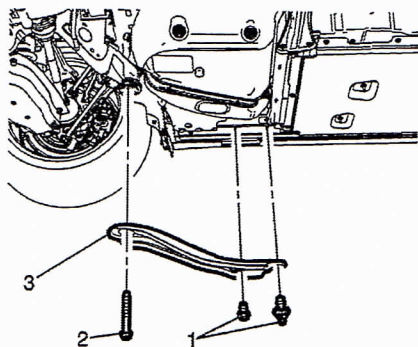
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Note: DO NOT raise the vehicle higher than necessary.

33. Using the block of wood and the adjustable 2 ton tripod jack stand (1), raise the vehicle just enough to reposition the hoist pad (2) from under the vehicle.



34. Front mounting bolts (1) for the rear suspension bracket (3) » Remove [2x]
35. Rear mount bolt (2) for the rear suspension bracket » Remove

Note: SAVE the bolt (2) to aid in installation but do NOT USE for final assembly.

36. Rear suspension bracket (3) » Remove
37. Loosely reinstall rear mount bolt (2) to secure cradle during hoist repositioning.
38. Position the hoist pad under the body flange
39. Slowly lower the 2 ton jack stand until the vehicle sits on the hoist pad
40. Repeat the front body bracket removal and hoist pad relocation process for the other side of the vehicle.
41. Reposition the adjustable 2 ton jack stand supporting the rear drive axle to support the front end of the rear suspension cradle towards the center of the vehicle. Ensure the jack stand is not resting on wiring or fluid lines.
42. Remove the loosely installed rear mount bolts (2) [2x]

Note: SAVE the bolt (2) to aid in installation but do NOT USE for final assembly.

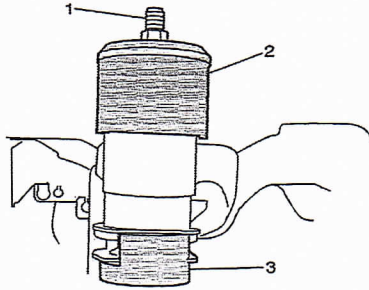
43. Slowly lower the adjustable 2 ton jack stand supporting the rear suspension cradle to provide clearance to remove the existing mounts and install the solid inserts

Note: While lowering the rear suspension cradle, ensure there are no wiring harnesses, connectors or fluid hoses being stretched or twisted.

Rear Cradle Isolator Removal and Installation (All applications)

44. Remove the front side support bushings from the rear suspension cradle. It may be necessary to cut the rubber to make removal easier.

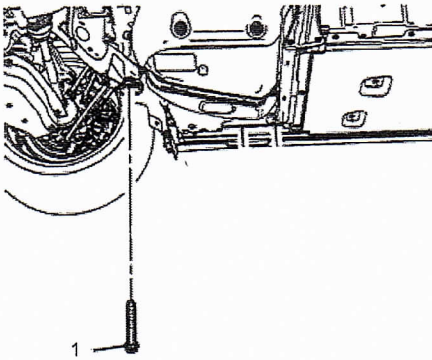
Note: When cutting out the mount, some hydraulic fluid will flow out of the mount.



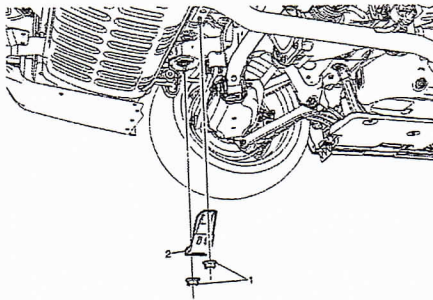
45. Using the DT-50806 kit (1), (2), and (3), install the rear suspension cradle solid inserts. Install the lower insert first followed by the upper insert taking care to keep the inserts square to the rear suspension cradle during press in.

Note: Refer to kit component list on Page 2 for explanation of solid mount insert installation location.

46. Using the adjustable 2 ton jack stand, raise the front of the rear suspension cradle.



47. Using the rear mount bolt (1) removed previously, loosely install the bolt ensuring proper thread engagement to support cradle but allow pivoting for rear mount installation.



48. Loosen lower stabilizer shaft clamp bolt but do not remove.

49. Rear Suspension Rear Bracket Nut (1) » Remove [2x]

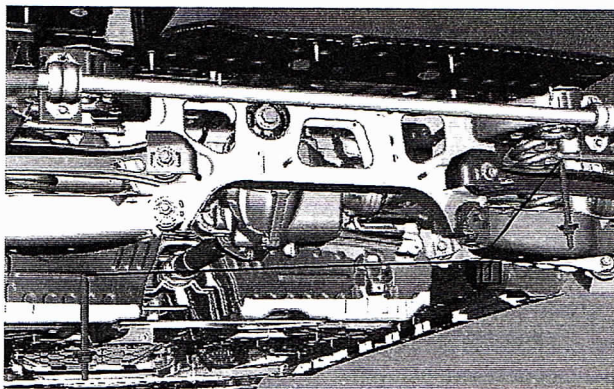
50. Rear Suspension Rear Bracket (2) » Remove

Note: Coupe style rear suspension bracket is show above. Convertible bracket form varies.

51. Reposition the 2 ton adjustable jack stand to support the rear side of the rear suspension cradle assembly. Support the cradle towards the center of the vehicle.

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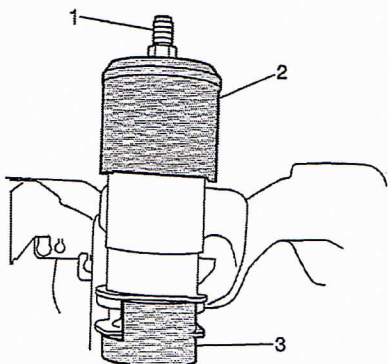


52. Rear Suspension Rear Mount Bolts (1) » Remove and DISCARD the bolts [2x]
 53. Using the adjustable 2 ton jack stand, slowly lower the rear side of the rear suspension cradle to allow adequate clearance to remove the rubber mounts and install the solid inserts.

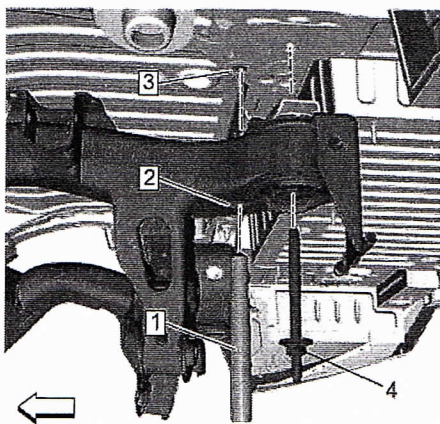
Note: While lowering the rear suspension cradle, ensure there are no wiring harnesses, connectors or fluid hoses being stretched or twisted.

54. Remove the rear side support bushings from the rear suspension cradle. It may be necessary to cut the rubber to make removal easier.

Note: When cutting out the mount, some hydraulic fluid will flow out of the mount.



55. Using the DT-50806 kit (1), (2), and (3), install the rear suspension cradle solid inserts. Install the lower insert first followed by the upper insert taking care to keep the inserts square to the rear suspension cradle during press in. **Note:** Refer to kit component list on Page 2 for explanation of solid mount insert installation location.
 56. Using the adjustable 2 ton jack stand, raise the rear side of the rear suspension cradle. Ensure rear springs and isolators are properly oriented and seated as cradle is raised.



Caution: This vehicle is equipped with torque-to-yield or single use fasteners. Install a NEW torque-to-yield or single use fastener when installing this component. Failure to replace the torque-to-yield or single use fastener could cause damage to the vehicle or component.

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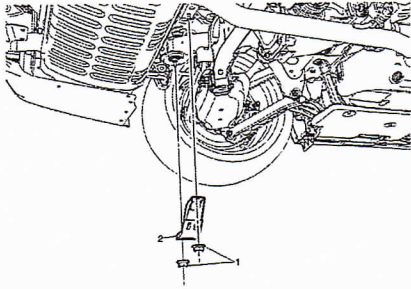


- 57. Insert the CH-51034 Cradle Alignment Pin (1), or suitable wooden dowel, into the rear cradle alignment hole (2) and body opening (3).
- 58. Hand tighten the NEW rear cradle mounting bolt (4).
- 59. Repeat for the other side.
- 60. Rear Suspension Cradle NEW Bolt (4) » Install and tighten [2x]

Tighten:

First Pass: **100 N•m (74 lb ft)**

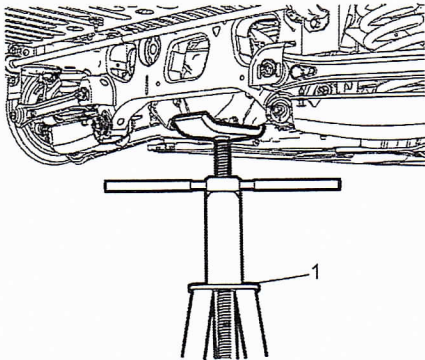
Final Pass: **Plus 90-105 Degrees**



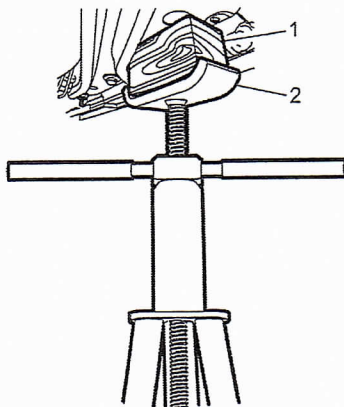
- 61. Rear suspension cradle bracket (2) » Install [2x]
- 62. Rear suspension cradle bracket nut (1) » Install and tighten to **58 N•m (43 lb ft) [4x]**
- 63. Lower stabilizer shaft clamp bolt, tighten to **58 N•m (43 lb ft)**.

Front Body Bracket Installation (All applications)

Note: The front body bracket installation and hoist pad relocation process must be done one side at a time.



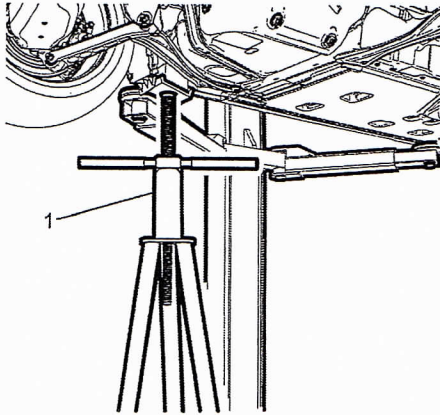
- 64. Using an adjustable 2 ton jack stand (1), support the rear drive axle.



- 65. Position a block of wood (1) and an adjustable 2 ton tripod jack stand (2) between the frame of the vehicle and the suspension bracket.

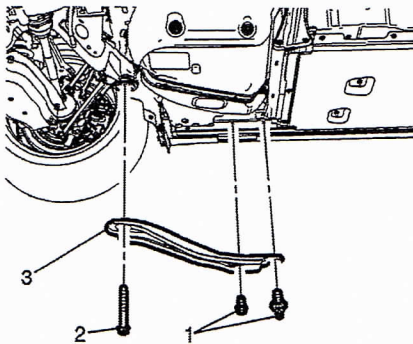
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Note: DO NOT raise the vehicle higher than necessary.

- 66. Using the adjustable 2 ton tripod jack stand jack stand (1) and the block of wood, slowly raise the vehicle in order to reinstall the body bracket.
- 67. Ensure the adjustable 2 ton jack stand is still supporting the rear drive axle.
- 68. Remove the loosely installed front mount bolt from the rear suspension cradle and DISCARD.

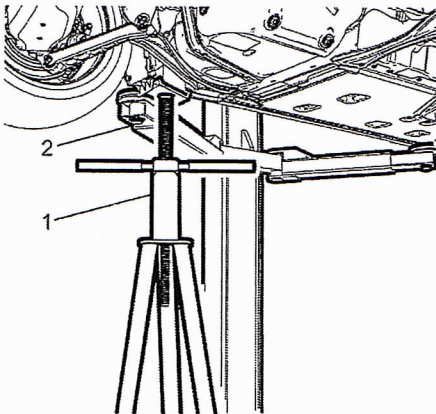


- 69. Rear suspension cradle front bracket (3) » Install
- 70. Rear suspension cradle front bracket bolt (1) » Install and tighten 58 N•m (43 lb ft) [2x]

Caution: This vehicle is equipped with torque-to-yield or single use fasteners. Install a NEW torque-to-yield or single use fastener when installing this component. Failure to replace the torque-to-yield or single use fastener could cause damage to the vehicle or component.

- 71. Rear suspension cradle NEW bolt (2) » Install and tighten

Tighten:
First Pass: 100 N•m (74 lb ft)
Final Pass: Plus 90-105 Degrees

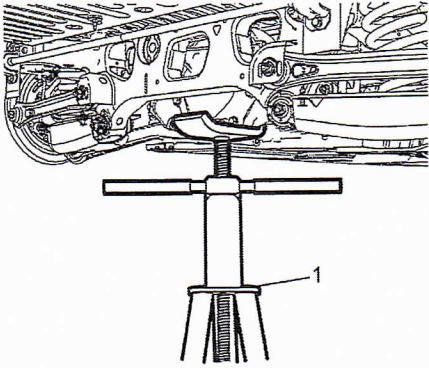


- 72. Reposition the hoist lift pad (2) back underneath the vehicle at the specified lift and jacking point.
- 73. Using the adjustable 2 ton tripod jack stand jack stand (1), slowly lower the vehicle back on the hoist pad (2).

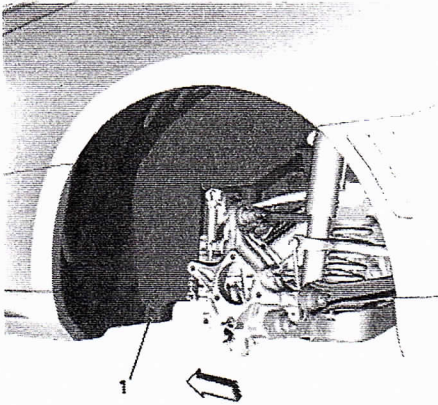
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74. Repeat the front body bracket installation and hoist pad relocation process for the other side of the vehicle.



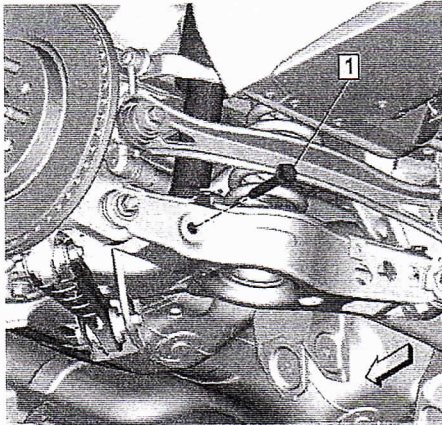
75. Remove the jack stand (1) supporting the rear drive axle.



76. Rear Wheelhouse Liner Screw(1) » Install and tighten 2.5 N•m(22 lb in)

Rear Damper Bolt Installation (All applications)

77. Using an adjustable jack stand or hydraulic jack, raise and support the rear suspension lower control arm.



Caution: This vehicle is equipped with torque-to-yield or single use fasteners. Install a NEW torque-to-yield or single use fastener when installing this component. Failure to replace the torque-to-yield or single use fastener could cause damage to the vehicle or component.

78. Lower rear shock absorber bolt (1) » Install the NEW bolt

Tighten

First Pass: 100 N•m (74 lb ft)

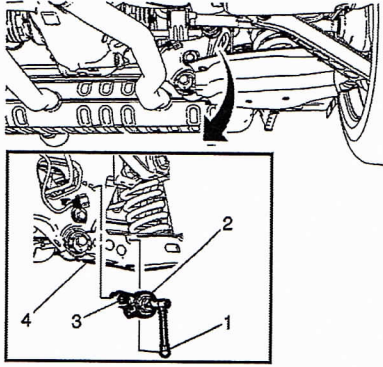
Final Pass: plus 90–105 degrees

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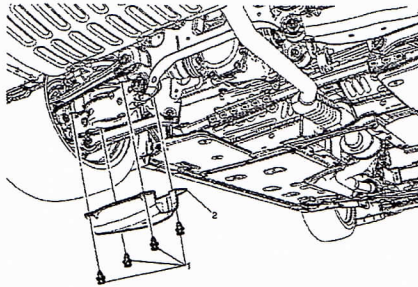
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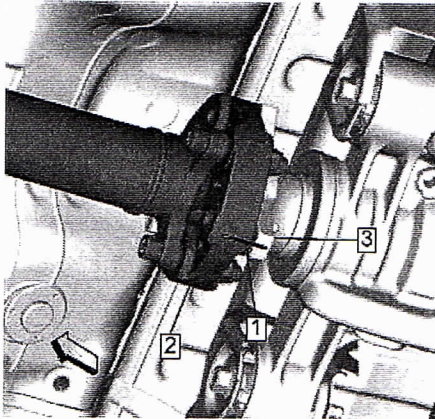


79. {If equipped} Install the level sensor link (1) on the lower control arm (4).



- 80. Rear suspension lower control arm cover (2) » Install
- 81. Rear suspension lower control arm cover push pins (1) » Install [4x]

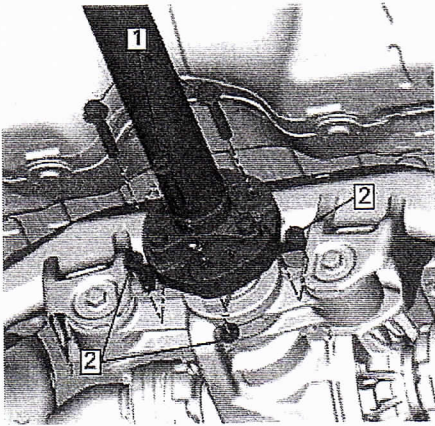
Prop Shaft Installation (All applications)



82. Align the reference mark (1) between the propeller shaft flange (2) and the rear axle pinion flange (3).

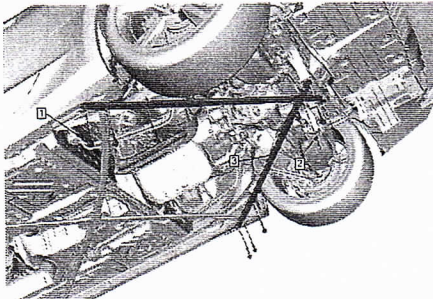
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83. Rear propeller shaft nuts (2) and the bolts (1) » Install and tighten bolt to **90 N•m (66 lb ft) [3x]**

Floor Panel Tunnel Rear Brace Installation (Convertible Only)

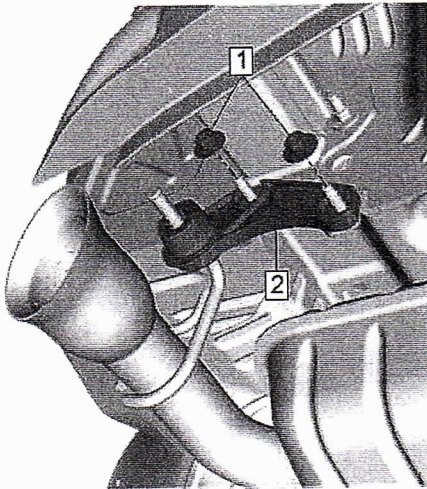


84. Floor panel tunnel rear brace (3) » Install

85. Floor panel tunnel rear brace bolts (1) » Install and tighten **58 N•m (43 lb ft) [8x]**

86. Floor panel tunnel rear brace nut (2) » Install and tighten **58 N•m (43 lb ft)**

Exhaust Installation (All applications)



87. Remove loosely installed exhaust rear muffler insulator nut.

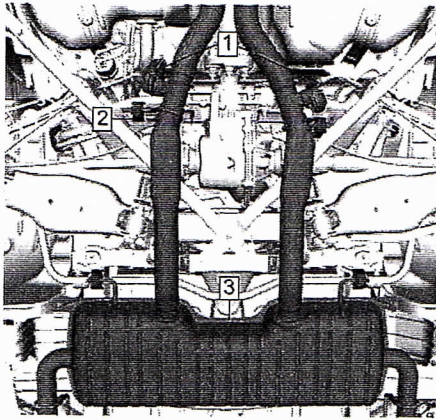
88. Raise exhaust and hang rear bracket (2) on studs.

89. Exhaust Rear Muffler Insulator Nut (1) » Install and tighten **40 N•m (30 lb ft) [2x]**

90. {If equipped} Connect the rear exhaust control valve actuator electrical wiring harness connectors associated with the performance exhaust option.

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91. {If equipped} Exhaust Control Valve Actuator(1) » Connect [2x]

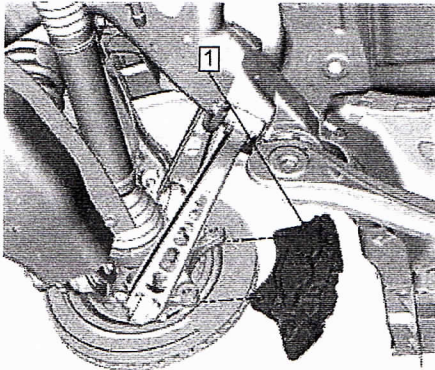
Note: Clean and lubricate the exhaust isolators for ease of installation.

92. Exhaust Isolator (2) » Connect [4x]

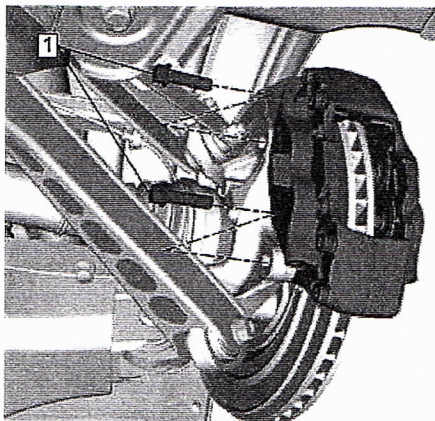
Rear Brake Caliper Installation (SS and ZL1 applications)

93. Prepare the brake caliper bracket bolts and the bracket threaded holes for assembly:

- Thoroughly clean the residue from the bolt threads with denatured alcohol or equivalent and allow to dry.
- Thoroughly clean the residue from the threaded holes with denatured alcohol or equivalent and allow to dry.
- Apply threadlocker to 2/3 of the threaded length of the bolts.
- Ensure there are no gaps in the threadlocker along the length of the filled area of the bolts.
- Allow the threadlocker to cure approximately 10 minutes before installation.



94. Brake Caliper Assembly (1) » Install



95. Brake Caliper Bolt (1) » Install and tighten **125 N•m (92 lb ft)** [2x]

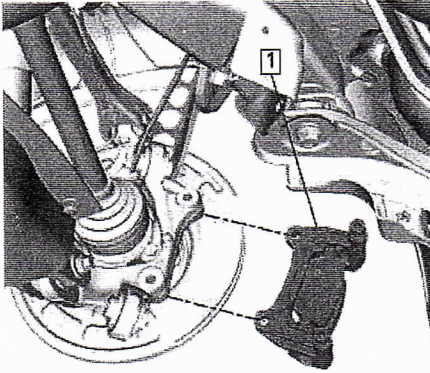
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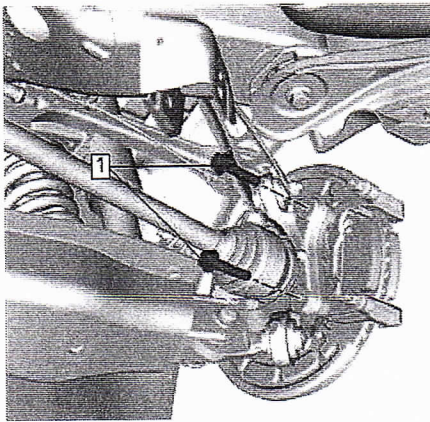
Rear Brake Caliper Installation (LS and LT applications)

96. Prepare the brake caliper bracket bolts and the bracket threaded holes for assembly:

- Thoroughly clean the residue from the bolt threads with denatured alcohol or equivalent and allow to dry.
- Thoroughly clean the residue from the threaded holes with denatured alcohol or equivalent and allow to dry.
- Apply threadlocker to 2/3 of the threaded length of the bolts.
- Ensure there are no gaps in the threadlocker along the length of the filled area of the bolts.
- Allow the threadlocker to cure approximately 10 minutes before installation.



97. Brake Caliper and Bracket Assembly (1) » Install



98. Brake Caliper Bracket Bolt (1) » Install and tighten [2x]

Tighten

First Pass: **100 N•m (74 lb ft)**

Final Pass: **plus 15-30 degrees**

99. Install rear tire and wheel assemblies.

100. Lower vehicle to ground

Vehicle Alignment

Following installation of this suspension kit, the vehicle will require a wheel alignment to OEM specifications. Use the SUPPLIED CAM BOLTS, CAM WASHERS and NUTS for the rear wheel alignment joints.

Caution: This vehicle is equipped with torque-to-yield or single use fasteners. Install a NEW torque-to-yield or single use fastener when installing this component. Failure to replace the torque-to-yield or single use fastener could cause damage to the vehicle or component.



Trousse de montage de berceau arrière plein de Chevrolet Camaro Gen 6

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Remarque : l'installation des garniture pleines pour le berceau de suspension arrière peut uniquement être réalisée UNE FOIS. Si le retrait des garnitures pleines de berceau de suspension arrière est requis pour une raison ou une autre, il faut alors utiliser un berceau de suspension arrière NEUF.

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