

## Billet Aluminum Rear Subframe Mount Insert Kit, E9X

### BMW



The 034Motorsport Billet Aluminum Rear Subframe Mount Insert Kit for E9X BMW models is designed to limit movement in the factory rear subframe mounts to maintain proper suspension geometry when cornering and improve the responsiveness of the rear suspension and differential.

### Installation Spiciness Rating: MEDIUM



Installation of your 034Motorsport Rear Subframe Insert Kit is a straightforward process, however we recommend professional installation by an experienced BMW specialist.

#### Supplied Parts:

- (2x) 034 Rear Subframe Mount Insert – Front Upper
- (2x) 034 Rear Subframe Mount Insert – Front Lower
- (2x) 034 Rear Subframe Mount Insert – Rear Upper
- (2x) 034 Rear Subframe Mount Insert – Rear Lower

#### Tools Needed:

- E18 Torx Socket
- Socket Set
- Torx Bit
- Torque Wrench
- Pry Bar

#### Optional Factory Replacement Parts:

- (4x) Rear Subframe Bolts (**Factory Part#:** 3326760340)

#### About This Guide

This Install Guide documents the installation process on a 2006 BMW 325XI. The actual installation process for your vehicle may vary by model, due to factory options, or because of existing aftermarket modifications you have installed.

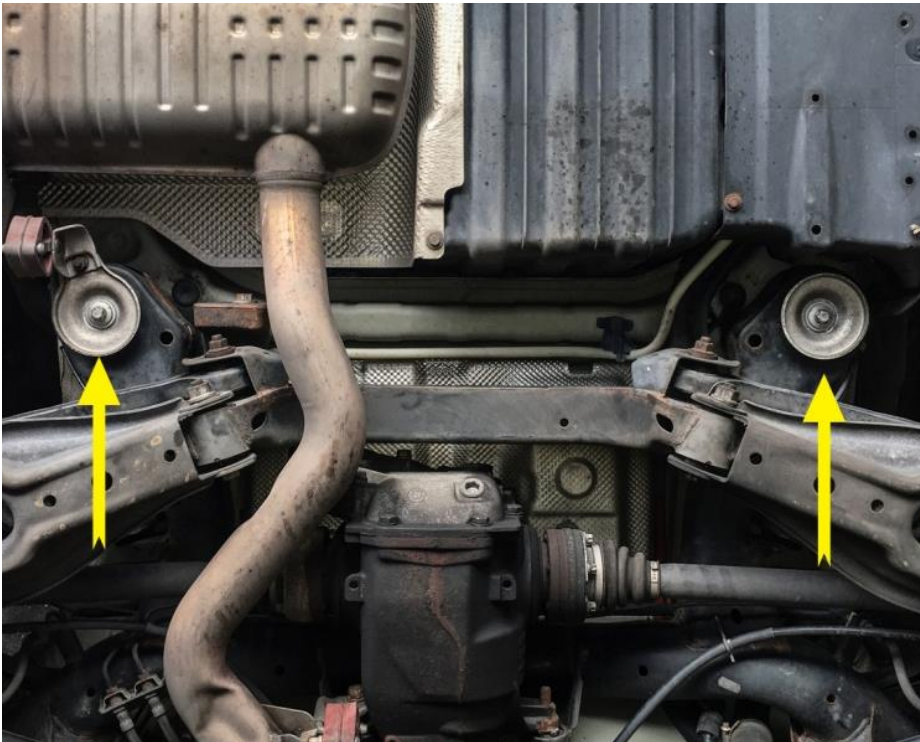
## Getting Started

Confirm you have received all the parts included with your purchase by reading the complete guide, if there are missing components, please contact:

## Install Steps

### **Step 1**

Identify the location of the rear mounts on the rear subframe. These are located behind the springs and struts on either side of the vehicle.



### **Step 2**

Using an E18 Torx Socket, remove the rear subframe bolt securing the right rear portion of the subframe to the chassis.



### **Step 3**

Keep the factory washer and bolt to the side as these will be needed to reinstall.





**Please Note:** We recommend replacing these bolts after removing. The part number for factory bolts is 33326760340.

#### Step 4

Using an E18 Torx Socket, remove the rear subframe bolt securing the left rear portion of the subframe to the chassis.



#### Step 5

There should now be an inch or two inch gap between the top of the subframe and the chassis on either side.



#### Step 6

For the rear portion of the rear subframe, ensure you have the right inserts selected. The part numbers needed are 601-0050 (Rear Upper) and 601-0051 (Rear Lower).



#### Step 7

Position the insert so that the 034 logo faces toward the front of the car and press the upper insert (601-0050) into the top of the rear subframe mount on both sides of the vehicle.



## Step 8

Insert the rear lower insert into the lower portion of the factory rear subframe bushing and reinstall the factory washer and E18 Torx bolt. Leave rear subframe bolts loose to allow enough movement for the front of the subframe to drop down enough to install front inserts.



## Step 9

Remove the plastic underbody shield from the front of each wheel well on the car to expose the front mounts for the rear subframe.



## Step 10

Using an E18 Torx Socket, remove the two bolts securing the front of the rear subframe to the chassis. Use a 6-point socket to remove the 2 bolts securing the arm to the chassis.



## Step 11

Ensure you have the correct inserts for the front portion of the rear subframe. The part numbers required are 601-0048 (Front Upper) and 601-0049 (Front Lower).





### Step 12

With the brackets removed, the front bushings of the rear subframe should now be exposed.



### Step 13

Position the upper insert on top of the front bushing for the rear subframe on both sides of the vehicle.



### Step 14

Position the lower insert on the arms and prepare to reinstall to the chassis.



**Please Note:** We recommend replacing these bolts after removing. The part number for factory bolts is 33326760340.

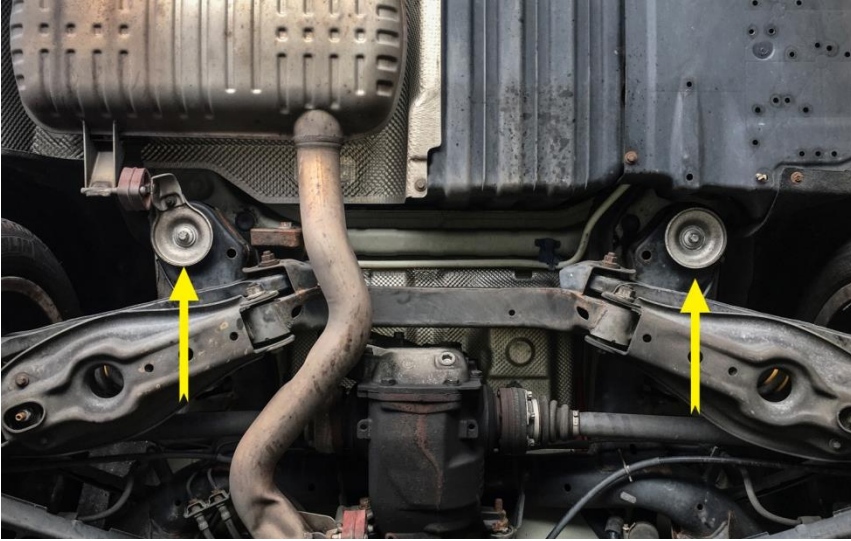
### Step 15

Carefully place the bracket back into position and install with using 1 subframe bolt and 2 hex bolts per side.



**Step 16**

Using an E18 Torx Socket, torque all rear subframe bolts to **100 Nm.**

**Step 17**

Using a 6-Point Socket, torque the 4 hex-head bolts to **47 Nm + 90°.**

**Step 18**

Reinstall the factory plastic underbody shields.

**Step 19**

Ensure all connections are secure

**Step 20**

Lower your vehicle from the lift.

**Important:** To ensure you get the best performance from your newest upgrade, we recommend a 4-wheel alignment after installing 034Motorsport Billet Aluminum Rear Subframe Inserts.

**Step 21**

Enjoy the Upgrade!