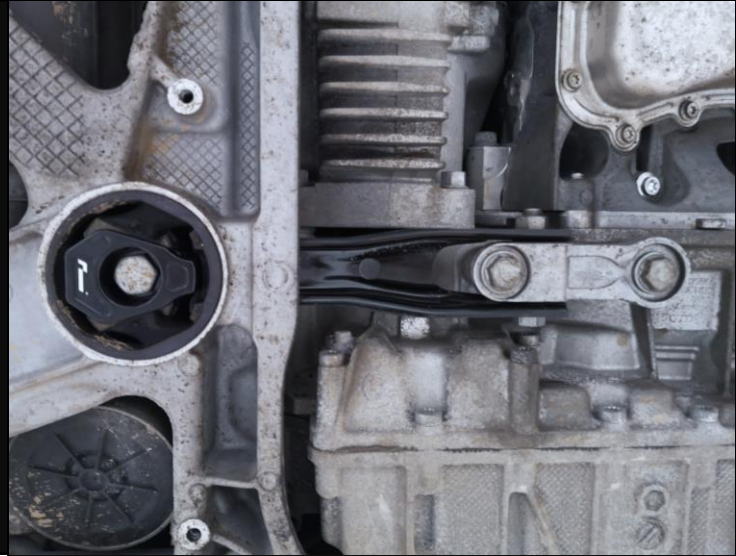


Twin Dogbone Inserts MQB/MQBE

VWR150003/4

FITTING INSTRUCTIONS



WHAT'S IN THE KIT?

- ▷ 1 x V1 or V2 Upper Dogbone Insert
- ▷ 1 x Lower Dogbone Insert

REQUIRED TOOLS AND PARTS

- ▷ 1 x 16mm Socket
- ▷ 1 x 21mm Socket
- ▷ 1 x Torque Wrench
- ▷ 1 x Ratchet

FITTING NOTES

Prior to installation an inspection of the OEM Dogbone mount bush is required, this is to ensure the correct version of the Dogbone insert has been purchased and can be installed.

Version 1 : OEM part No. – 5Q0 198 037 A

Version 2 : OEM part No. – 5Q0 198 037 F

See Figures 4a/b/c/d for further help to identify which version is required for your vehicle.



FITTING INSTRUCTIONS

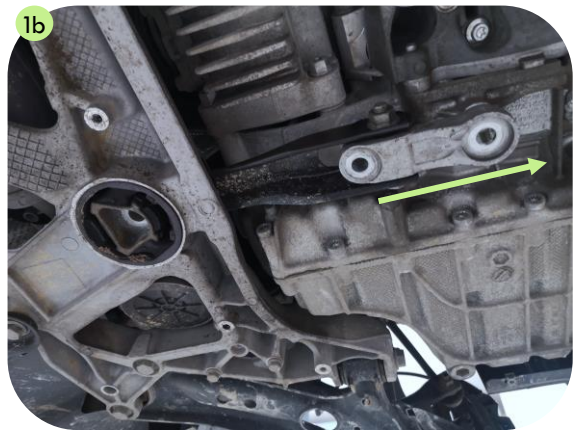
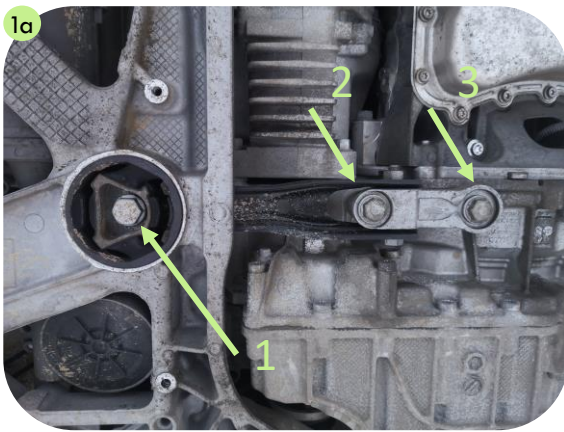
VWR150003/4

Step 1:

Removal of Dogbone Mount Arm:

In order to install the Dogbone insert kit the factory Dogbone arm needs removal. Using a 21mm socket, remove the transmission mount bolt labelled 1 and then using a 16mm socket removed the 2 x bolts labelled 2 & 3. set these bolts aside and keep on hand, they will be needed in Steps 3 of this install.

Once a 3 bolts are removed, pull the Dogbone mount arm from the OEM bush as shown in *Figure 1b*.



Step 2:

Install of Upper Dogbone Insert:

In order to make the install easier apply a small amount of silicone lubricant to the upper end of the upper insert, this is shown in *Figure 2a*. Once lubricated, push the insert into the engine side of the OEM transmission bush. Shown in *Figure 2b*. This may take a small amount of force. Once flush with the bush the insert will need pushing into its final position. This will require access through the Dogbone arm hole in the subframe, ensure the insert is as shown in *Figure 2c*. Which allows for correct refit of the OEM Dogbone arm.



Step 3:**Install of Lower Dogbone Insert:**

Now the Upper insert is in place, the lower insert can be installed. Same as Step 2, lubricate with silicone lubricant on the 2 x outer points as shown in Figure 3a.

Once lubricated insert the Lower insert in the orientation as shown in either Figure 3b.

Once the orientation is correct and the insert is in place, thread the 3 x bolts which were removed in Step 1. Once the bolts are in place torque the M14 with a 21mm socket to 130 Nm + 90 Degrees.

Finally using a 16mm socket torque the remaining 2 x M10 bolts to 50 Nm + 90 Degrees.

**Additional Information:**

Version 1 (4a & 4b) : OEM part No. – 5QO 198 037 A / Version 2 (4c & 4d) : OEM part No. – 5QO 198 037 F

