

# Installation instructions

## 2004-06 Scion xA & xB

## 2000-05 Toyota Echo

### Set # 8.1103



1131 VIA CALLEJON, SAN CLEMENTE, CA 92673

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It is recommended that this set be professionally installed if you are unfamiliar with this type of work, and a factory service manual be acquired prior to performing any work on your vehicle for proper disassembly, reassembly and torque specs. These instructions are intended for bushing removal and install of Energy Suspension polyurethane bushings, once you have removed the factory component from your vehicle. Energy Suspension recommends that you read over all the installation instructions and check all P/N's and quantities in the parts list before you start. Call our customer service at (949)361-3935 if the parts in your kit do not match this parts list or if you have any other questions regarding the installation of these motor mounts. Always make sure the vehicle is properly supported before removing the original parts and when reinstalling the new parts. It is recommended to remove and reinstall one mount at a time to help maintain engine alignment. Make sure all nuts and bolts that were removed are installed and tightened to their correct torque specs according to the factory service manual.

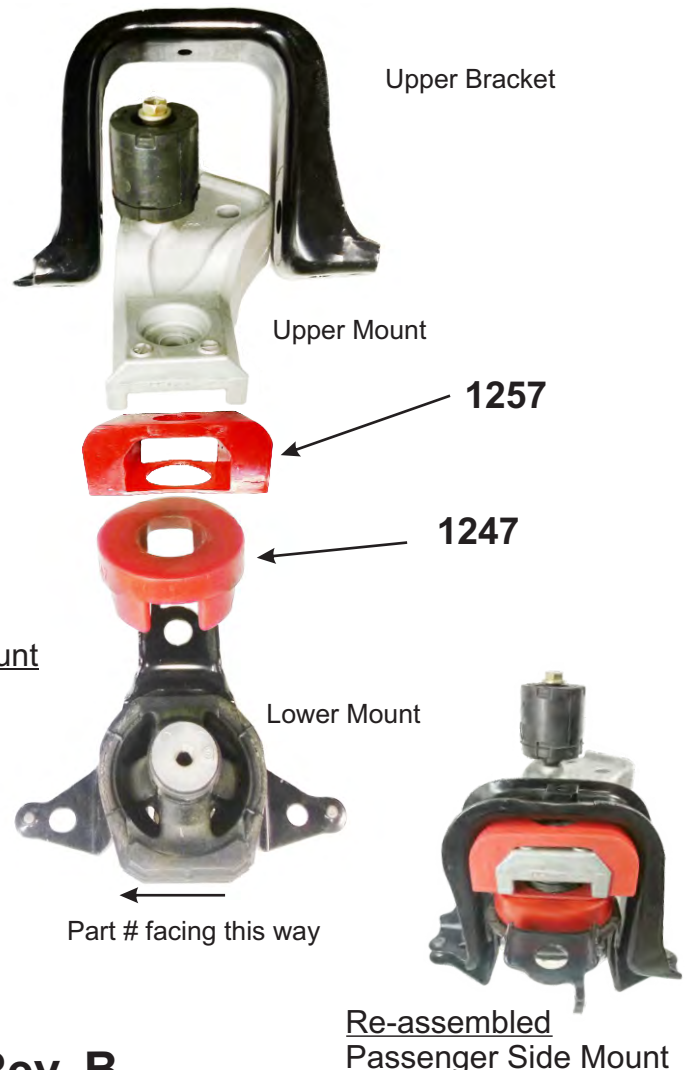
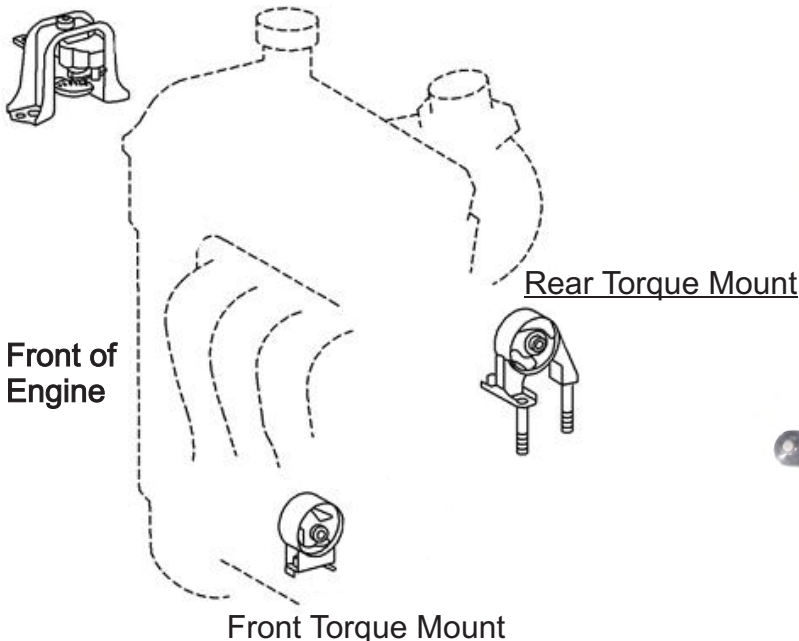
#### Passenger Side Motor Mount:

- After the mount has been removed, drill the 2 rivets out from each side of the steel bracket and remove the upper bracket from the mount
- Mark the direction of the upper bracket when separating from the lower mount
- Remove the center bolt from the top of the mount and separate the upper mount from the lower mount
- Remove the OEM rubber slip-on bushing from the upper mount
- Bushing 1247 inserts into the lower mount, note direction of the part number
- Slide the upper insert 1257 onto the upper mount
- Bolt the upper mount back to the lower mount
- Place the upper bracket back on the engine mount
- Hold the upper bracket in place as you bolt the re-assembled mount back into the car

#### Parts List:

- 1241 – Front Torque Mount
- 1242 – Rear Torque Mount
- 1247 – Motor Mount Insert, Lower
- 1257 – Motor Mount Insert, Upper
- 15.10.324.39 – .875" x .500" x 2.140" Sleeve
- 15.10.576.39 – .875" x .406" x 2.200" Sleeve
- 17517 – Installation Instructions

#### Passenger Side Motor Mount



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**SUSPENSION** 

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#### Front and Rear Engine Torque Mounts:

- Only remove and replace one torque mount at a time
- The OEM rubber mount and bonded metal shell must be removed before installing the new polyurethane mount
- Clean and deburr any rough edges from the surface of the bracket that will contact the new bushing
- Use some grease on the leading edge of the bushing and press in the new mount with an arbor press
- Press the correct length sleeve into the bushing
- Reinstall the mount onto the car
- Repeat this process for the remaining torque mount
- Removal Using Shop Press (Recommended):
  - Use a piece of tubing with an Inside Diameter  $+0.025"$  larger than the Outside Diameter of the metal shell to be pressed out in order to support the bracket on the press
  - Use another piece of tubing with an O.D.  $-0.025"$  smaller than the O.D. of the metal shell to press the OEM bushing and bonded shell out
- Removal Using Hacksaw or Reciprocating Saw
  - Carefully cut through **only** the inner bonded metal shell of the OEM mount from one of the holes inside in the rubber
  - With the inner shell cut through, use a hammer and metal chisel to drive the OEM bushing and bonded shell out of the bracket

#### Shop press method

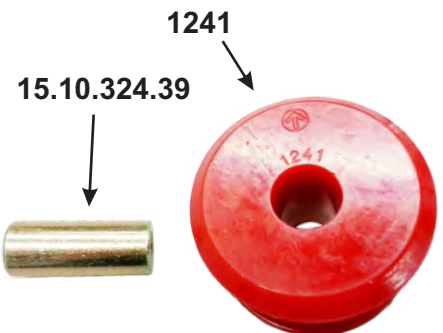


#### Shell cutting method



Cut only through this metal shell that is bonded to the rubber mount

#### Rear Torque Mount



#### Front Torque Mount