

Revised Front Bushings –
Revised Special Tools –
Replacement Procedure

MODEL
1997 MY-ON XK8 Range
1998 MY-ON V8 XJ Series
VIN
001001-ON
812256-ON

Remove and destroy Bulletin 204-11, dated 02/00.
Replace with this Bulletin.
Revisions are marked with a bar and in **bold text**.

Issue:

The design of the bushings in the front suspension lower wishbones on the above vehicles was changed, requiring a change in the procedure for replacing the bushings. The change also requires the use of different Special Tools. Since replacement bushing for earlier vehicles have been superseded to the latest condition, **the revised procedure also applies to earlier vehicles**. Up to VINs 034425 and 862294, the original bushings had a nylon casing. From VINs 034426 and 862295, the bushings have a steel casing. The latest type bushings, which are now used for service replacement, have been used in production starting with VINs A06104 (XK) and F11235 (XJ).

Action:

When replacing lower wishbone bushings on the above vehicles, observe the following procedures.

- In all cases, disassemble the front suspension as necessary, as detailed in JTIS, Section 204, SRO 60.35.32.

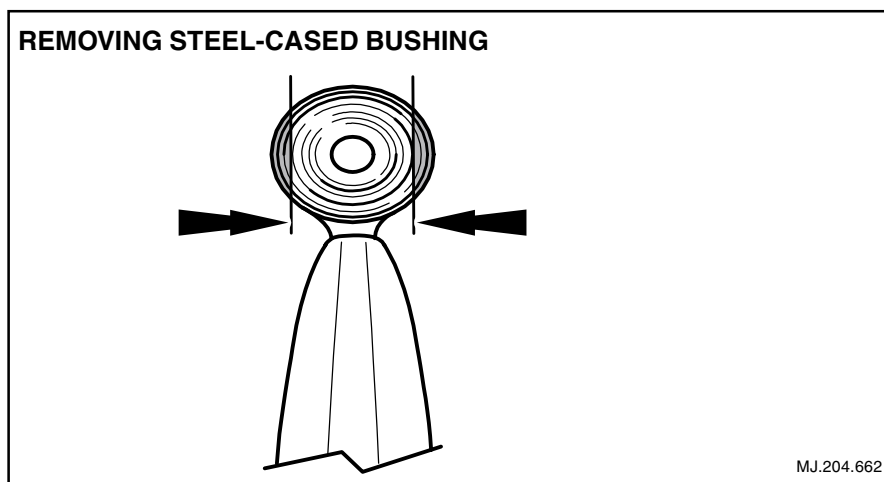


ILLUSTRATION 1

REMOVAL OF NYLON-CASED BUSHINGS (EARLY DESIGN)

- Using a hydraulic press and with Special Tool 204-214 Bush Remover positioned at the flanged end of the bush, press the bush through the wishbone arm. The casing will fracture, and the outer shell of the bush will pass through the bore in the wishbone arm.

REMOVAL OF STEEL-CASED BUSHINGS (LATER DESIGN)

1. Make 2 sawcuts through the rubber and **partly** into the flange of the steel casing, at the locations shown in Illustration 1, in line with the casing of the bush.

⚠ Caution: Do **not** cut **fully** through the steel flange. The sawcuts should penetrate through only 75 - 80 % of the thickness of the steel flange, so that the wishbone arm is **not** touched by the saw blade.

2. Use a hammer and chisel, or similar hand-tool, to bend the 'half-moons' of the flange away from the wishbone arm.

⚠ Caution: Ensure that the wishbone arm is **not nicked by hand tools used in this operation. If using a vise to hold the arm, use soft jaws.**

Use pliers or grips to repeatedly bend the 'half-moons' back and forth until the 'half-moons' break off along the line of the saw cuts.

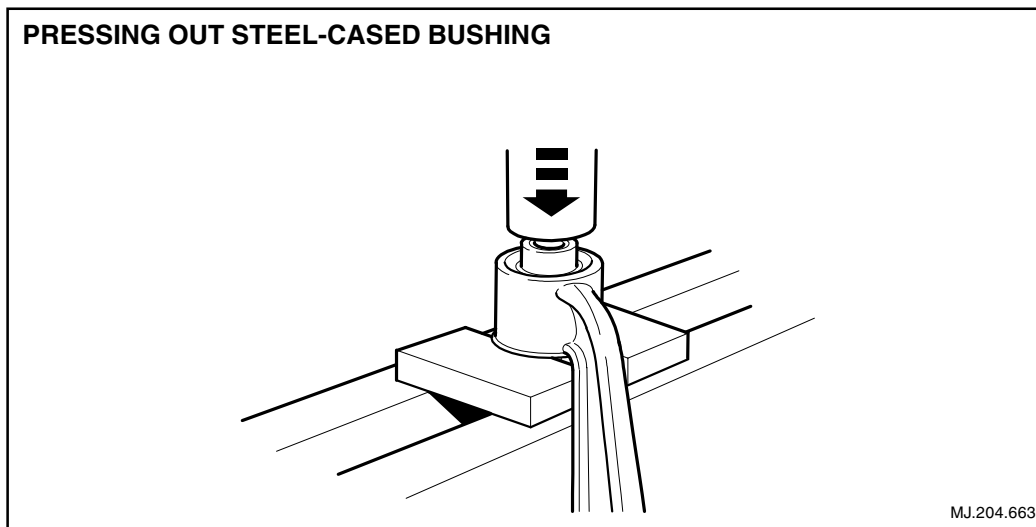


ILLUSTRATION 2

3. Position the wishbone arm on the support plates of the hydraulic press, so that the bushed end is supported by the plates where the 'half-moons' have been removed, allowing the casing of the displaced bush to pass between the support plates. See Illustration 2. (Front arm illustrated - rear arm similar).
4. Using Special Tool 204-214, press the bush from the bore in the wishbone arm.

INSTALLATION OF STEEL-CASED BUSHINGS

1. Follow the existing procedures shown in JTIS, **with the following changes:**
 - Use Special Tool **204-279** when pressing in the bush for the **rear** lower wishbone
 - Use Special Tool **204-280** when pressing in the bush for the **front** lower wishbone
2. Refer to JTIS for reassembly.

REPAIR AND INSPECTION GUIDELINES - LOWER WISHBONE BUSHINGS

XK8 1997-2000 MY		FRONT BUSHING		Repair/Action
VIN Range	Original	Replacement		
001036-034425	MJA 1360AF	MNE 1360AB		If a bushing fails on one side of the vehicle - both front lower bushings must be replaced and the rear bushings examined for splitting. Replace rear bushings only if required.
034426-042775	MJC 1360AA	MNE 1360AB		
A00083-ON	MNE 1360AB	MNE 1360AB		If a front bushing fails on one side of the vehicle - replace the failed bushing only; examine the remainder of the bushings for splitting and replace only if required.
		REAR BUSHING		
VIN Range	Original	Replacement		Repair/Action
001036-042775	MJC 1360BA	MNE 1360BB		During replacement of front lower bushings the rear bushings must be examined for splitting. Replace rear bushings only if required
A00083-ON	MNE 1360BB	MNE 1360BB		

V8 XJ 1998-2000 MY		FRONT BUSHING		Repair/Action
VIN Range	Original	Replacement		
812256-862294	MNC 1360AB	MNE 1360AB		If a bushing fails on one side of the vehicle - both front lower bushings must be replaced and the rear bushings examined for splitting. Replace rear bushings only if required.
862295-878717	MNE 1360AA	MNE 1360AB		
F00103-ON	MNE 1360AB	MNE 1360AB		If a front bushing fails on one side of the vehicle - replace the failed bushing only and examine the remainder of the bushings for splitting and replace if required.
		REAR BUSHING		
VIN Range	Original	Replacement		Repair/Action
812256-862294	MNC 1360BA	MNE 1360BB		During repair/replacement of front lower bushings the rear bushings must be examined for splitting. Replace rear bushings only if required.
862295-878717	MNE 1360BA	MNE 1360BB		
F00103-ON	MNE 1360BB	MNE 1360BB		

Parts Information:

<u>DESCRIPTION</u>	<u>MODEL</u>	<u>VIN RANGE</u>	<u>OLD PART NO.</u>	<u>USE PART NO.</u>	<u>QTY/VEH.</u>
Front Bushing, Lower Wishbone	V8 XJ Series	812256 - 862294 862295 - 878717 F00103 on	MNC 1360AB MNE 1360AA MNE 1360AB	MNE 1360AB MNE 1360AB MNE 1360AB	2 As required
	XK8	001036 - 034425 034426 - 042775 A00083 on	MJA 1360AF MJC 1360AA MNE 1360AB	MNE 1360AB MNE 1360AB MNE 1360AB	2 As required
Rear Bushing, Lower Wishbone	V8 XJ Series	812256 - 862294 862295 - 878717 F00103 on	MNC 1360BA MNE 1360BA MNE 1360BB	MNE 1360BB MNE 1360BB MNE 1360BB	2 As required
	XK8	001036 - 042775 A00083 on	MJC 1360BA MNE 1360BB	MNE 1360BB MNE 1360BB	2 As required

Warranty Information:

<u>FAULT CODE</u>	<u>R.O. NUMBER</u>	<u>DESCRIPTION</u>	<u>TIME ALLOWANCE</u>
GH DD **	60.35.45	Replace front bushing, one lower wishbone - XK series V8 XJ Series	2.25 3.75
	60.35.46	Replace rear bushing, one lower wishbone -XK series V8 XJ Series	2.25 3.75
	60.35.47	Replace front bushings, both lower wishbones -XK series V8 XJ Series	2.65 4.15
	60.35.48	Replace rear bushings, both lower wishbones -XK series V8 XJ Series	2.65 4.15
	60.35.32	Replace both bushings, one lower wishbone -XK series V8 XJ Series	2.65 4.15
	60.35.33	Replace both bushings, both lower wishbones Vehicle Set - XK series	3.40
	60.35.49	Replace both front and 1 rear - XK series V8 XJ Series	4.90 3.00 4.50

Note: All R. O. Number Labor Times include the necessary alignment adjustments.