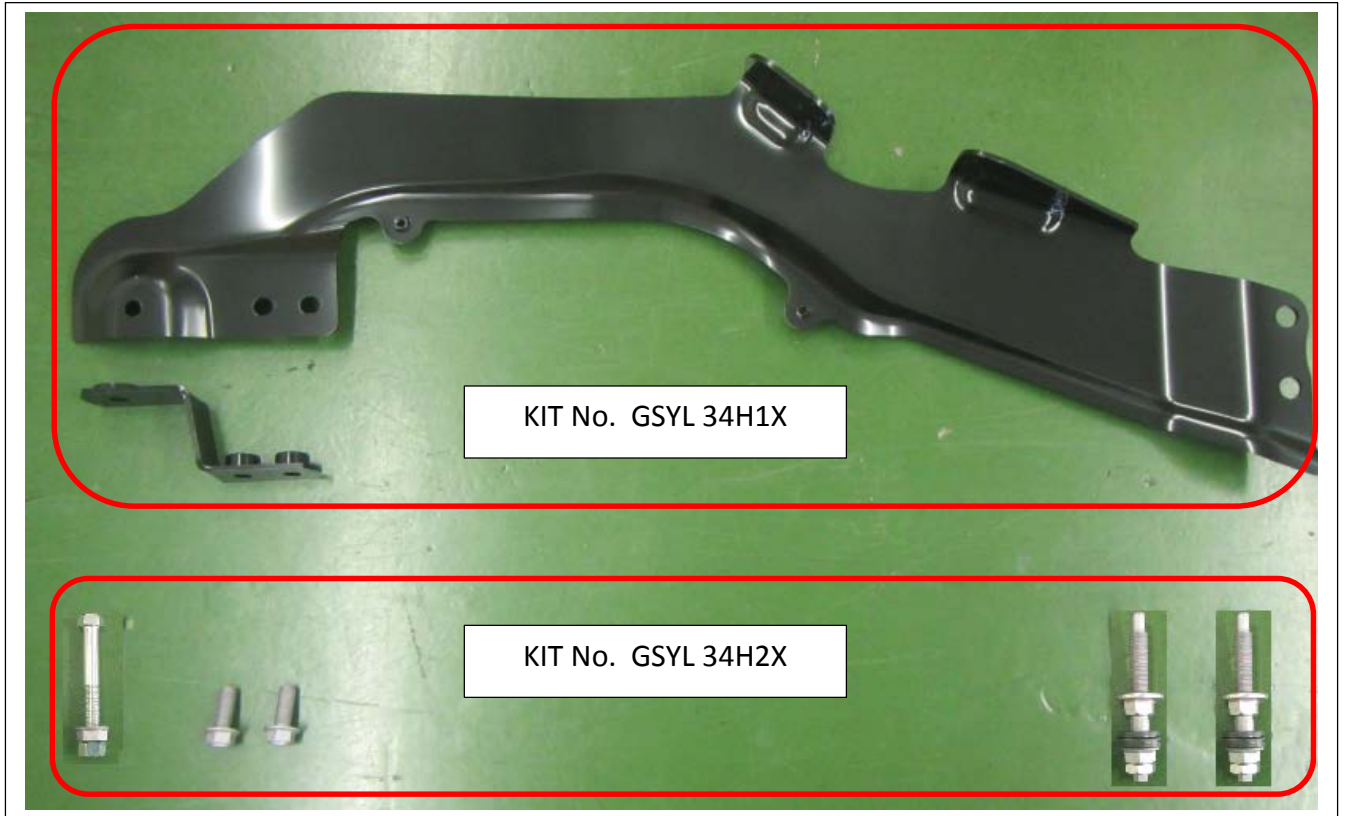
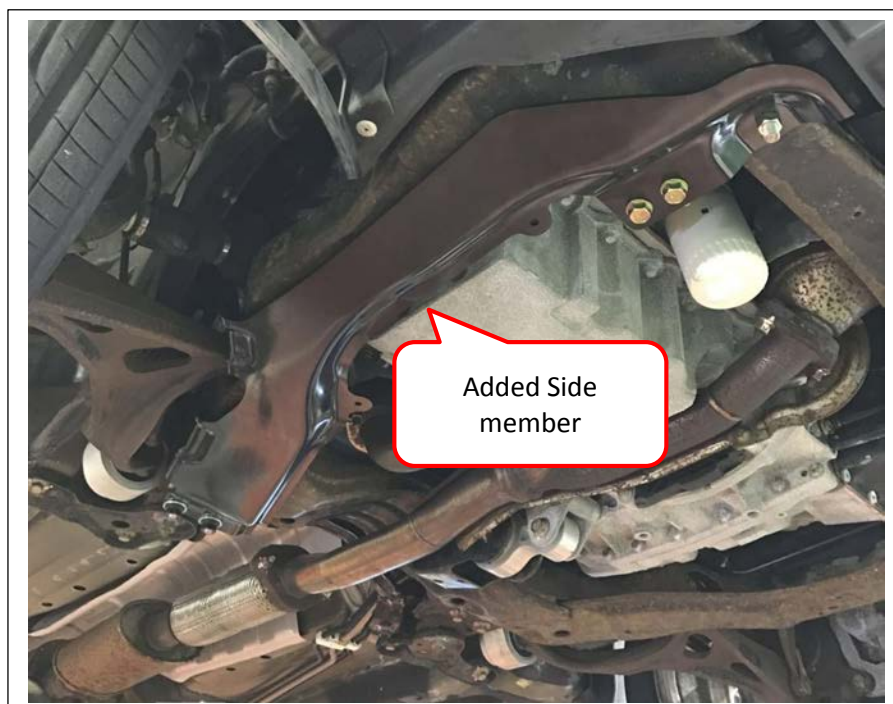


Mazda6 09, 10 MY: Side member bracket attachment procedure.

Component parts



After attachment in the vehicle

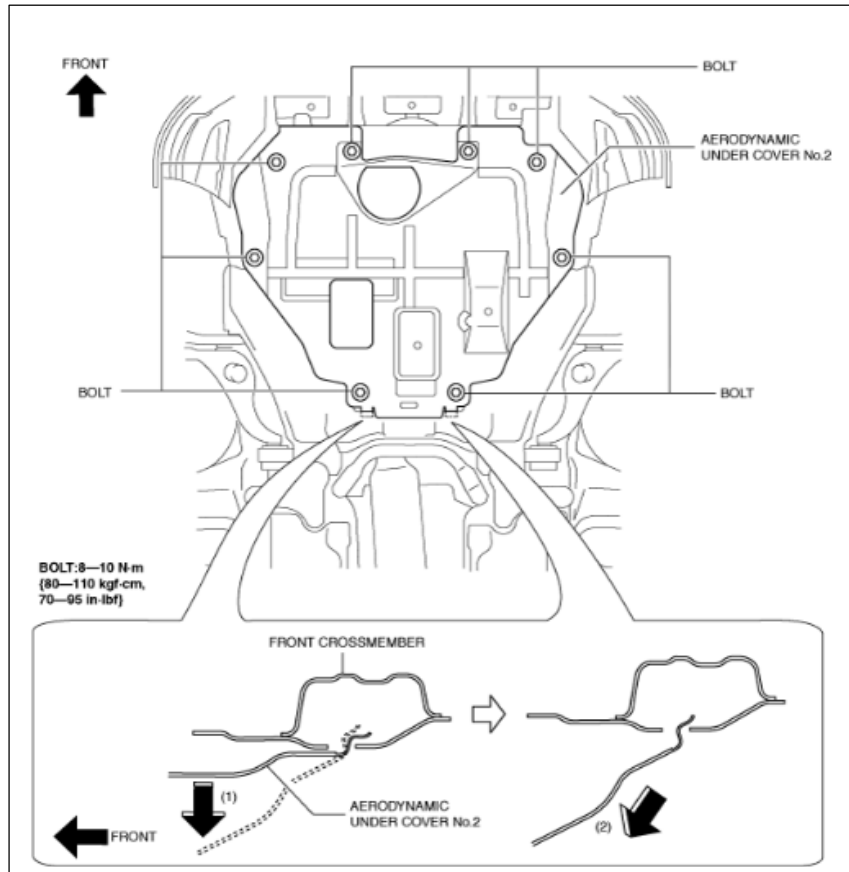


This procedure is after the front cross member has been cleaned, passed inspection, and wax applied.

1. Cut the under-cover* (Only L5 Engine-2.5L: 4 cylinder engine)

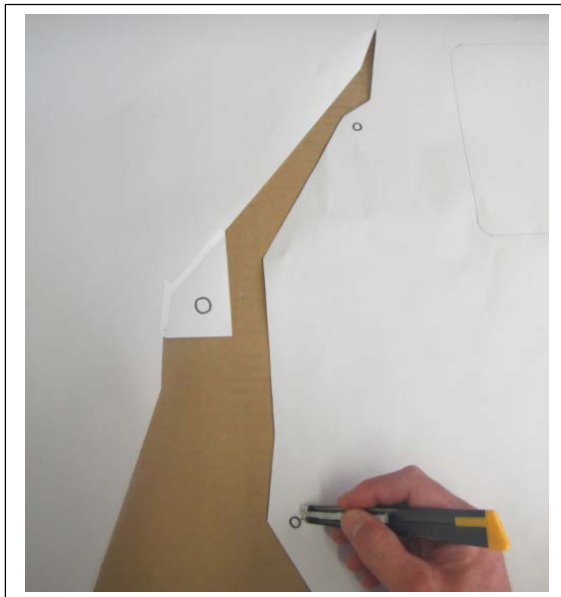
*Under cover means Aerodynamic under cover No.2

(1) Remove the under-cover if reinstalled.

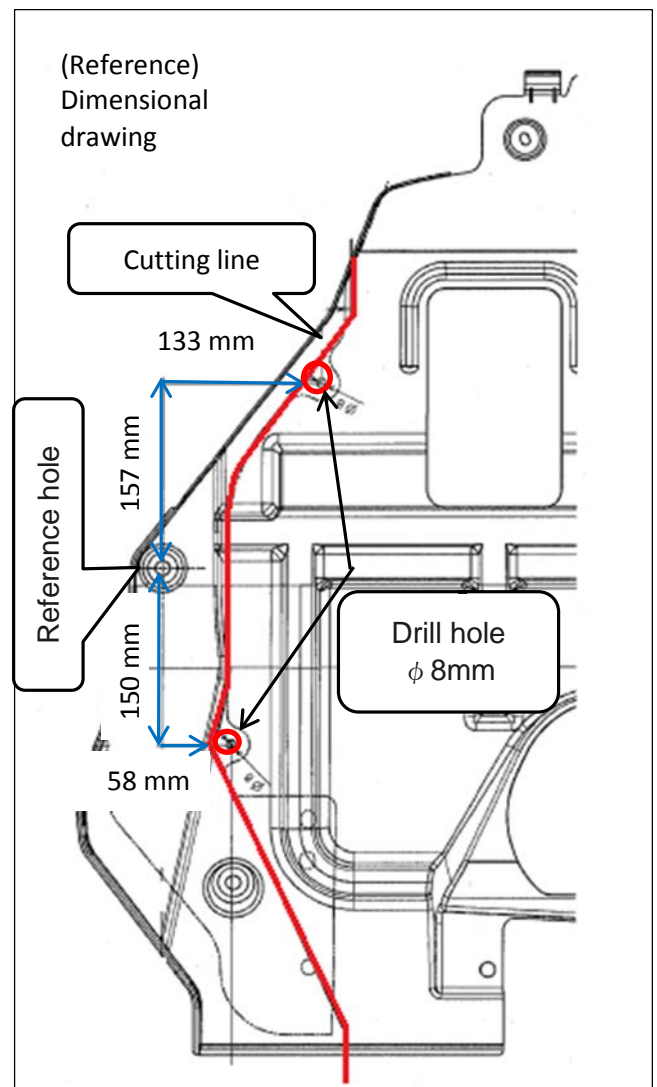
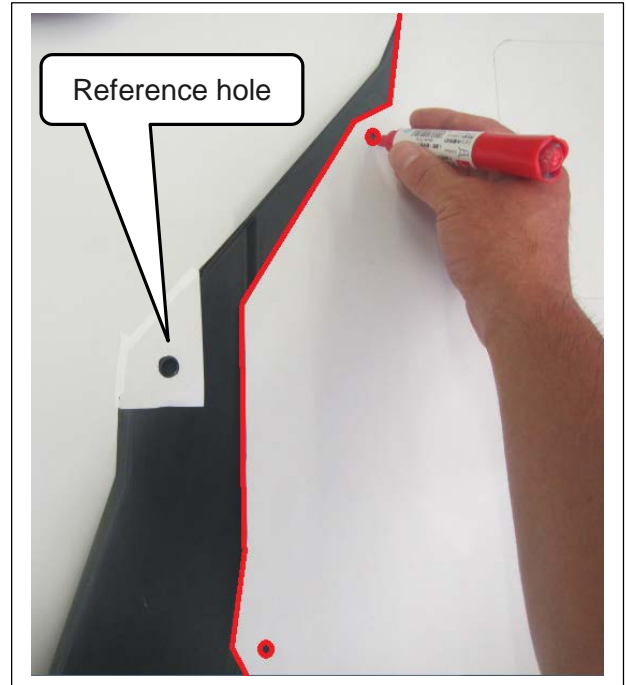
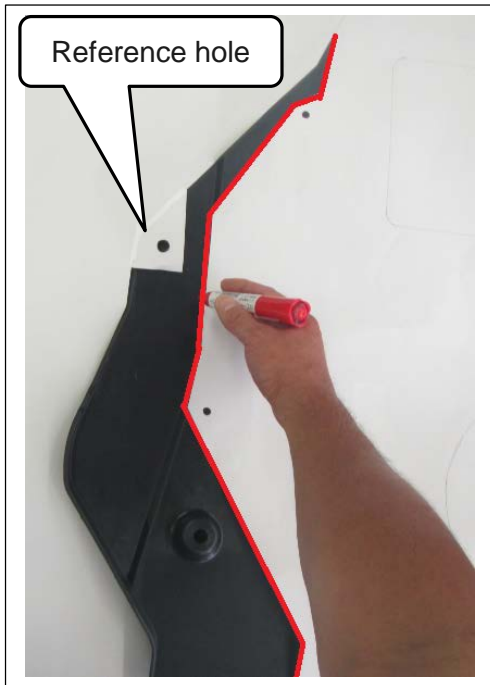


(2) Cut the under-cover to prevent interference with the Side member bracket.

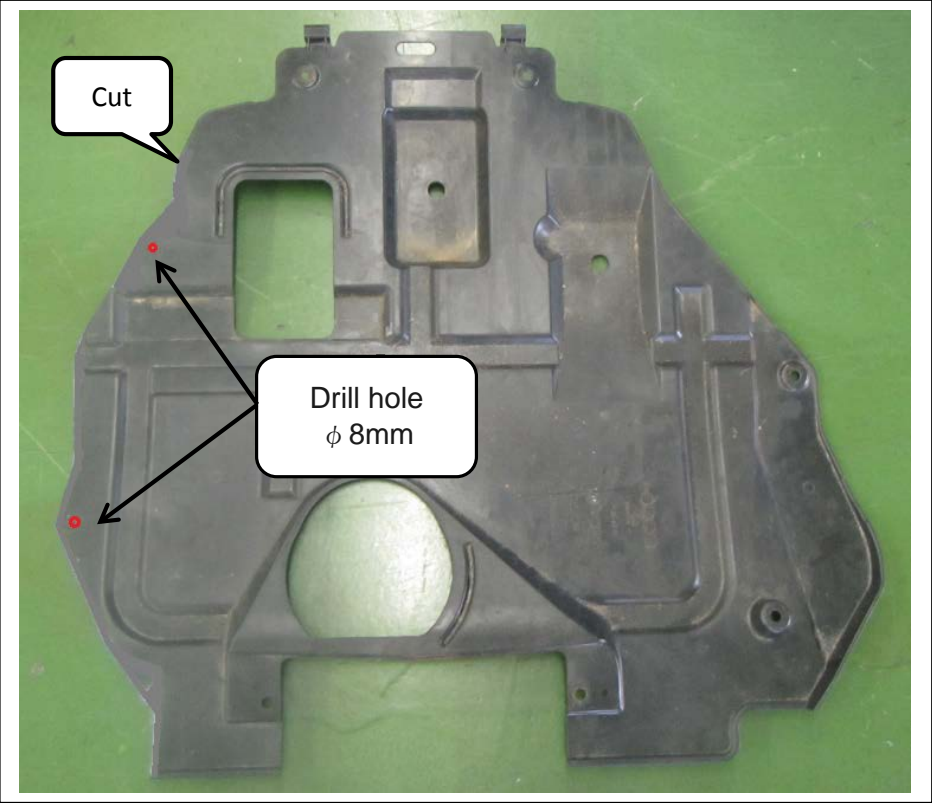
1) Cut bold line that includes hole of "Under cover cutting sheet" provided to dealers. Do not throw away the template. There are 3 copies in case one gets damaged.



- 2) Align the reference hole and place the full size template "Under-cover cutting sheet" provided by MNAO on the under-cover.
- 3) Draw a line for trimming the under-cover and drilling holes.



- 4) Along the drawn line, trim the under cover using Lasha scissor , electric cutter, etc.
And drill 2 8mm holes.

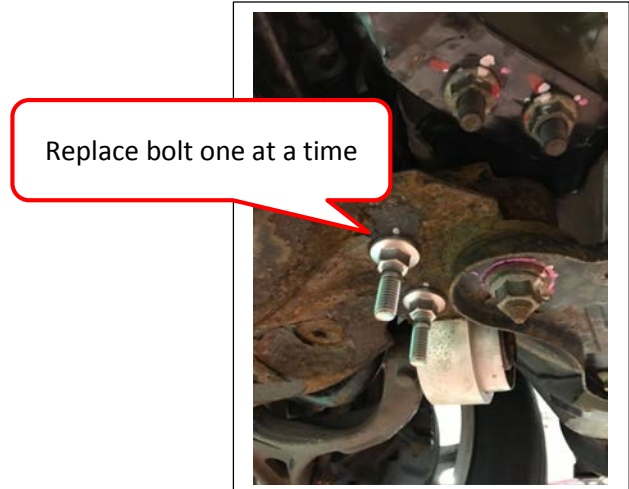
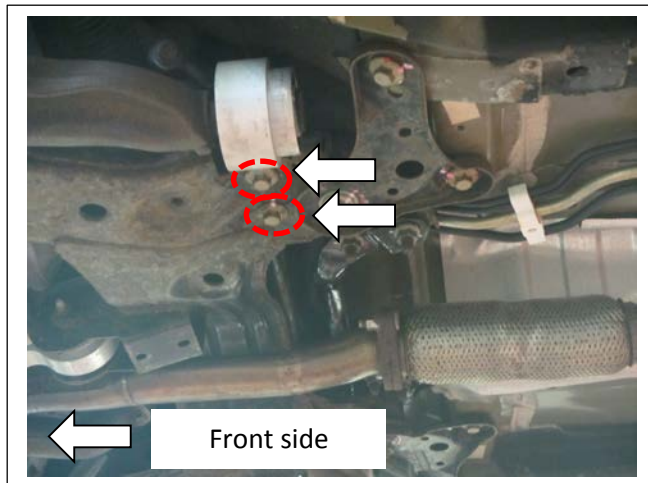


2. Attachment of Side member (Both L5 Engine-2.5L and DURATEC Engine 3.7L)

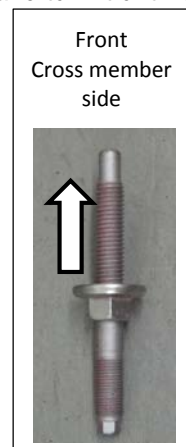
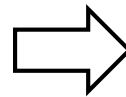
(1) Replace Front Cross member installation bolts to modified ones one at a time.

CAUTION:

- Do not replace two bolts at the same time. Replace bolts one at a time.
Vehicle alignment will change if you remove both original bolts at the same time.



1) Before installing the modified bolt, turn the nut counterclockwise and turn it until it does not turn.



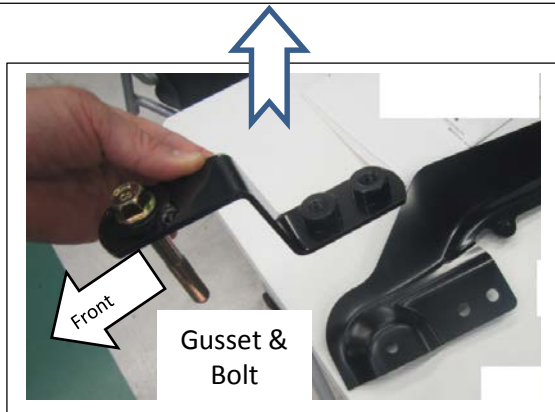
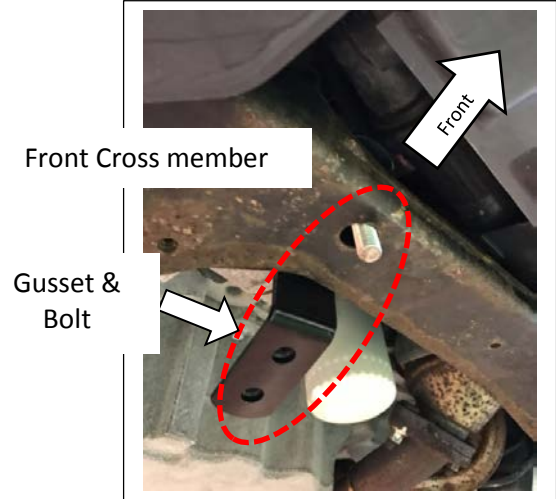
CAUTION:

- Do not replace two bolts at the same time. Replace one by one. Alignment will be misaligned if you replace two at the same time.
- Tighten bolt by hand until it is flush with frame (if tightened by impact gun the nut with spin and bolt will be installed incorrectly).

2) Tighten modified bolt by following torque.

Tightening torque: 69 – 93 ft-lb

(2) Insert Gusset and insert the bolt from the upward direction in the Front Cross member.



(3) Attach the washer and bolt as shown in the figure and tighten Side member with the specified torque.

CAUTION 1:

- Be sure to work with two persons, because the side member is heavy.

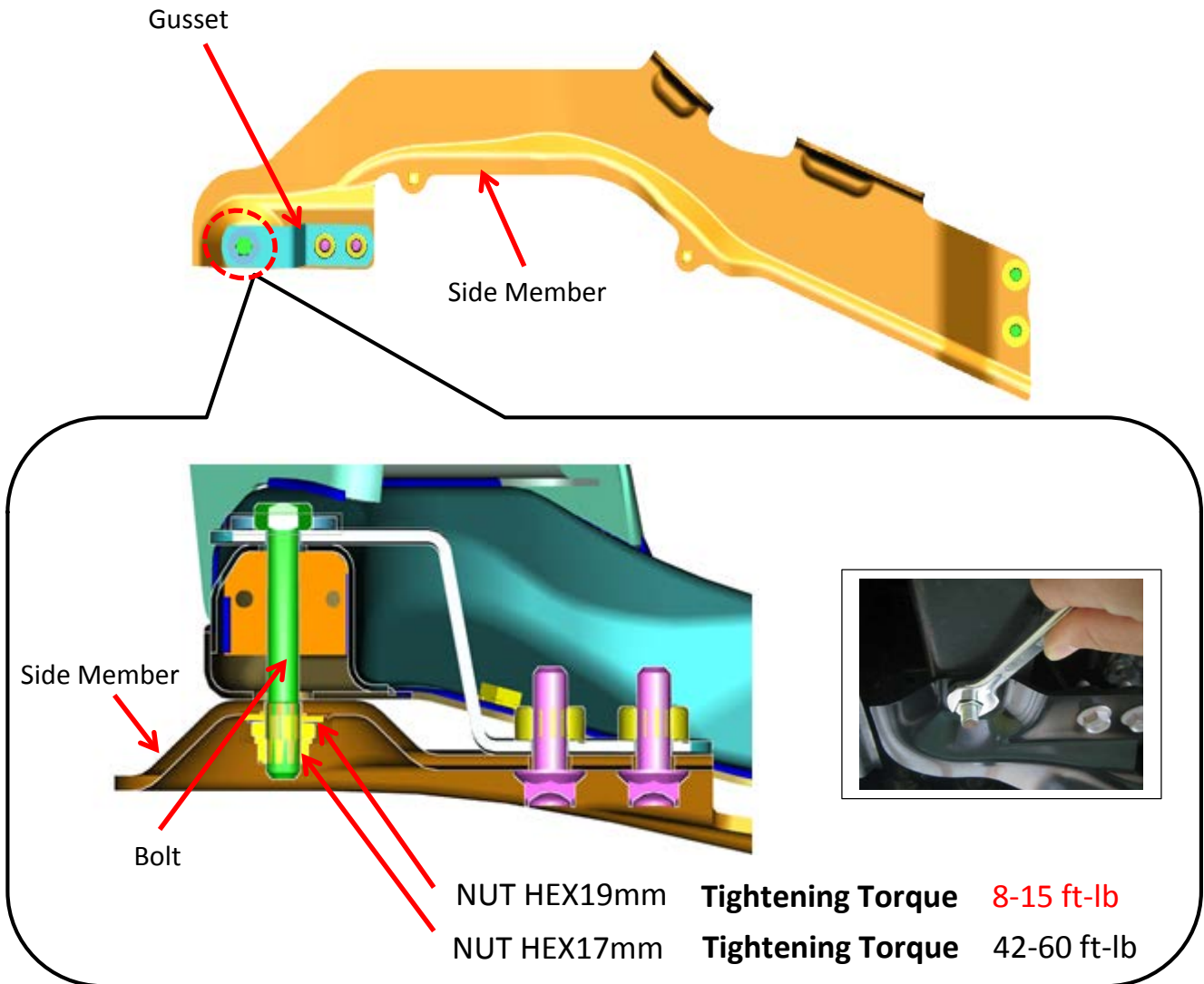
CAUTION 2:

- Do not forget to insert three washers.



CAUTION 3:

- The tightening torque of the double nut 19 mm nut on the front side of the cross member is lower than the other nuts due to the low rigidity of the cross member to be tightened.

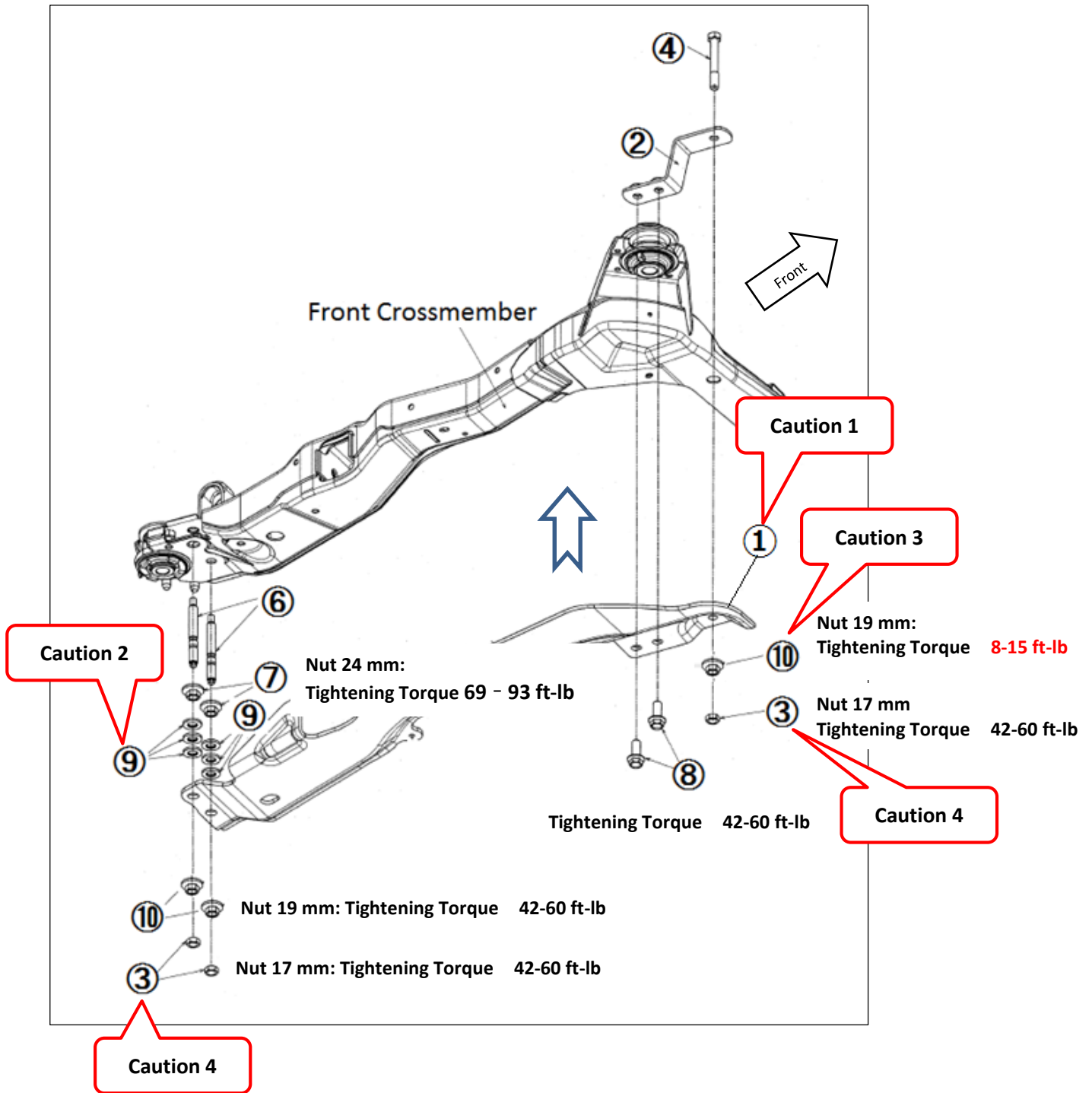


CAUTION 4:

- When tightening the double nut, hold one side with a wrench to prevent it from turning



Attach washers and bolts and tighten bolts by following torque.



1	Side member	6	Stud bolt
2	Gusset	7	Nut 24mm
3	Nut 17mm	8	Bolt
4	Bolt	9	Washer
5		10	Nut 19mm

3. Attachment of the under-cover (Only L5 Engine-2.5L)

(After attaching the Side member, attach the already cut/trimmed under-cover)

Tighten modified bolt by following torque.

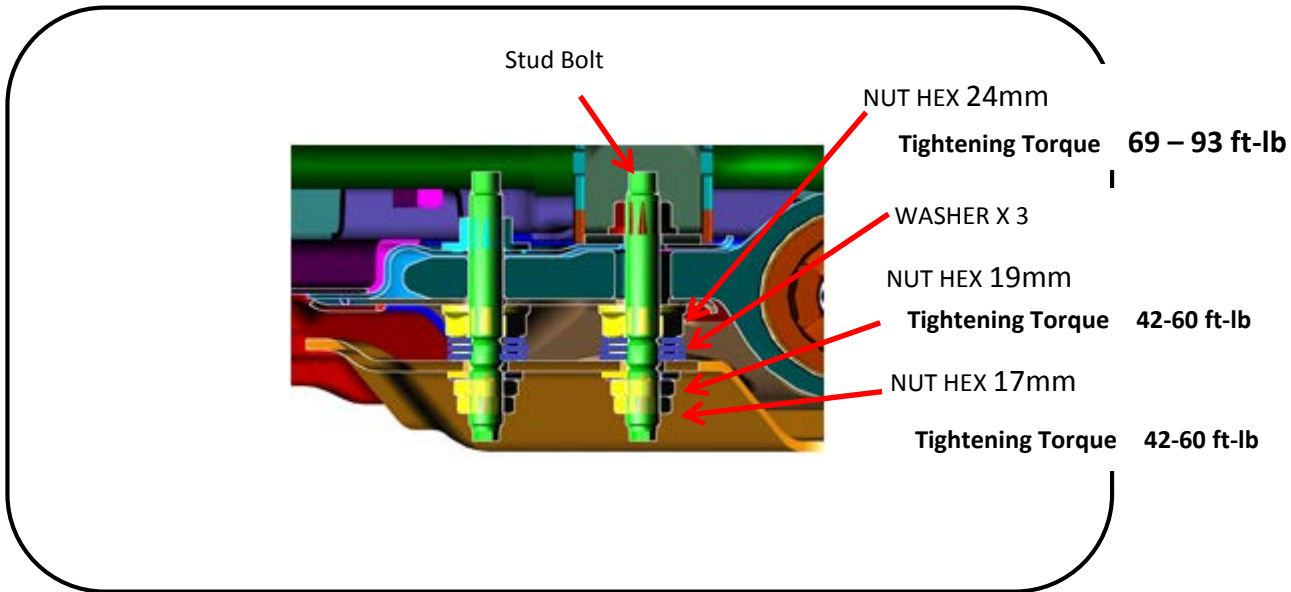
Tightening torque: 8 ft-lb



Added Side member

Cut the under cover

Side member Assy Parts diagram



Gusset

