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**Installation Instructions**  
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## 1965-1972 GM A-body 1978-1988 GM G-body Axle Housing Roto-Joint Bushings Item # 2999

UMI GM Axle Housing Roto-Joint Bushings are designed to be a direct replacement for your OEM rubber bushing supplied by GM. The dimensions were designed around OEM GM Axle housing technical drawings. \*\*If your rear has been modified from the original dimensions in this particular area, some modifications may be required\*\* Please read all instructions before installing your new bushing.

1. Lift the rear of the vehicle, with the rear end supported. Place jack stands under vehicle to prevent injury. Remove the bushing side of your Upper Control arm, one side at a time. With your control arm secured out of place, remove your existing bushing from the Axle Housing. Removal of your stock bushings may require a control arm bushing removal tool. If this item is not available you have (2) other options.

- Using a large size drill bit begin by drilling numerous holes in the OEM rubber bushing removing as much rubber as possible. Once a good amount of rubber has been removed use a punch or similar device to remove the steel sleeve which sits inside the rear end housing ear. Repeat this step on both sides.
- If a torch is available this is the most effective way for removal. Using the torch burn all rubber material from inside the sleeve, once rubber is hot it will continue to burn. Once a good amount of rubber has been removed use a punch or similar device to remove the steel sleeve which sits inside the rear end housing ear. Repeat this step on both sides. **USE EXTREME CAUTION WITH FLAME, KEEP AWAY FROM GAS LINES!**

2. After removing your existing bushings, and the metal sleeve housing the bushing, clean and prep the surface to install the Roto-Joint Bushing. It is important the area is clean to prevent damage to the Roto-Joint housing. The use of a file or de-burring tool may be required to knock down the material at this area. Install the Roto-Joint housing from the outside in, with the set screw towards the rear of the vehicle.

-If a press-fit is required, utilize a large socket that will fit around the Roto-Ball, and contact the Roto-Joint housing. Refer to image (a) below. Using a mallet or hammer, tap on the socket to press the new housing into place. The bevel step should be seated against the housing for proper fitment, refer to image (b). **DO NOT TAP ON THE ROTO-BALL DURING INSTALLATION, THIS WILL DAMAGE THE DELRIN RACE AND CAUSE PREMATURE FAILURE.**

-If the bushing simply slides into place with some play, apply Blue Loctite® to the Roto-Joint housing to lock the piece into place, and reinstall the part.

P/N 2999 is pre-greased and ready for use. Re-grease after disassembly and/or maintenance with a premium synthetic.

3. Once the new Roto-Joint Bushing is installed into place and fully seated, install the supplied Spiral Retaining Ring to the groove of the bushing. This will ensure the Roto-Joint bushing is properly secured. The ring should install by hand with no tools by placing the tip in the groove and working the ring into the slot.

4. Once the bushing is installed some grease may be required on the end of the Roto-Joint Ball to allow the control arm to be easily reinstalled. Swing the control arm back into place and install your existing hardware.

5. Repeat steps (1-4) for opposing side. It may be necessary to adjust your pinion angle after installation to your desired pinion angle to optimize your vehicles performance.

Note: As the bushing ages and wears, tighten the cap on the set screw side of the bushing to maintain pressure between the Roto-Ball and Delrin races. This will ensure proper performance of the Roto-Joint. This part is fully re-buildable; replacement parts may be purchased through UMI Performance. Refer to the exploded view for proper orientation of all the incorporated pieces of the bushing.

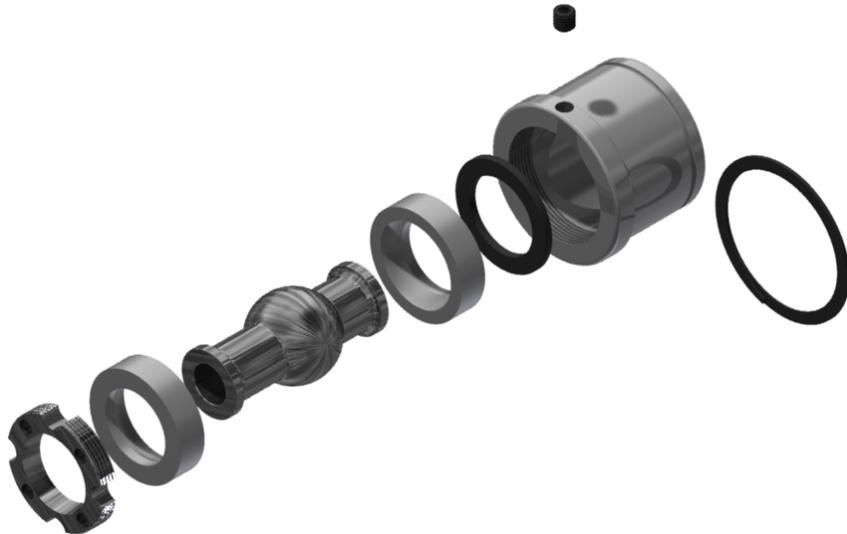
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Image (A)-32mm socket



Image (B)



Exploded view for rebuilding purposes. Part is a sealed unit, greased during assembly. Regrease part while disassembled to prolong the life of the the bushing.

**Item # 2999**

65-72 GM A-body 78-88 GM G-body  
Axle Housing Roto Joint bushing

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