

**ATTENTION:**GENERAL MANAGER ☐  
CLAIMS PERSONNEL ☐PARTS MANAGER ☐  
SERVICE MANAGER ☐

IMPORTANT - All Service Personnel Should Read and Initial

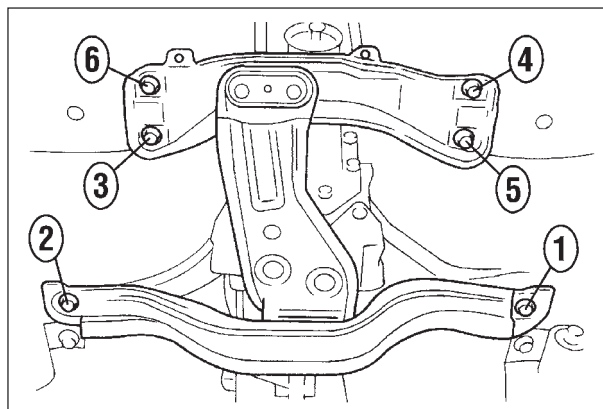

**SUBARU** **SERVICE BULLETIN****APPLICABILITY:** All A/T and M/T Vehicles  
**SUBJECT:** Transmission Rear Cross-Member**NUMBER:** 03-53-04  
16-54-04  
**DATE:** 08/20/04**INTRODUCTION**

The purpose of this bulletin is to prevent the possibility of damaging the bolts and/or threads that secure the transmission rear cross member.

**REPAIR PROCEDURES/INFORMATION**

When performing service work or installing SOA's accessory short throw shifter, it is extremely important that the transmission is supported properly when removing or reinstalling the cross member. If not, damage to the bolts and/or threads will occur. Support the transmission using a transmission jack, regardless if the vehicle is supported by a lift or car ramps (**Figure 1**). It is recommended that hand tools be used for the removal and installation of the bolts. Inspect for bolt thread damage and replace as necessary. Be sure to clean any protective wax from the mating surfaces and be sure to start all bolts several threads by hand before using tightening tools. **Note: If severe damage is evident to the threads, the use of a Heli-coil® type kit is an approved repair method.**

During reinstallation, follow the torque sequence, below (**Figure 2**) and the torque specifications (**Figure 3; next page**).

**Figure 1****Figure 2***continued on next page...***CAUTION: VEHICLE SERVICING PERFORMED BY UNTRAINED PERSONS COULD RESULT IN SERIOUS INJURY TO THOSE PERSONS OR TO OTHERS.**

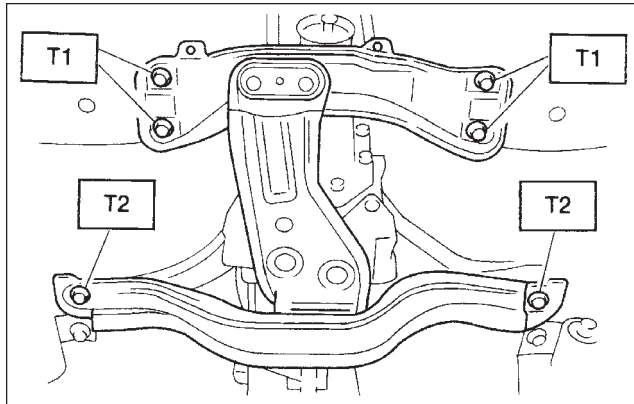
Subaru Service Bulletins are intended for use by professional technicians ONLY. They are written to inform those technicians of conditions that may occur in some vehicles, or to provide information that could assist in the proper servicing of the vehicle. Properly trained technicians have the equipment, tools, safety instructions, and know-how to do the job correctly and safely. If a condition is described, DO NOT assume that this Service Bulletin applies to your vehicle, or that your vehicle will have that condition.



Bolts must be torqued to the proper specifications (**Figure 3**).

**T1: 70 N·m (7.1 kgf-m, 51 ft-lb)**

**T2: 140 N·m (14.3 kgf-m, 103 ft-lb)**



**Figure 3**