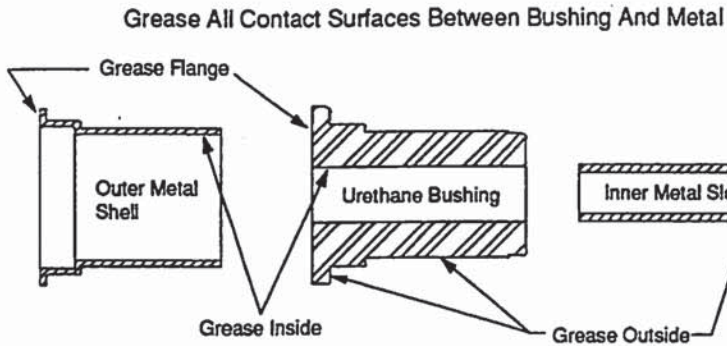


## CONTROL ARM BUSHING INSTALLATION INSTRUCTIONS FOR KIT #1-204

- 1) CONTROL ARM BUSHINGS ARE DESIGNED TO REPLACE THE RUBBER PORTION OF THE ORIGINAL BUSHING (AND INNER SLEEVE WHEN SUPPLIED). THEREFORE THE ORIGINAL OUTER METAL SHELLS, WASHERS, SPACERS AND SPECIAL WASHERS AND SLEEVES THAT ARE USED WITH CAM BOLT TYPE BUSHINGS MUST BE REUSED. ALSO IF INNER METAL SLEEVE IS NOT INCLUDED IN KIT, THEN THE ORIGINAL INNER SLEEVE MUST BE REUSED.
- 2) DISASSEMBLE CONTROL ARM, BEING CAREFUL NOT TO DAMAGE ANY PARTS THAT ARE TO BE REUSED. REMOVAL OF THE ORIGINAL RUBBER BUSHING IS BEST ACCOMPLISHED BY BURNING AWAY THE ORIGINAL RUBBER. PAY CAREFUL ATTENTION TO OTHER ADJOINING PARTS THAT COULD BE DAMAGED BY HEAT. CAUTION-THIS SHOULD BE DONE BY A QUALIFIED SPECIALIST AS IT IS EXTREMELY DANGEROUS.
- 3) REMOVE ALL OF THE ORIGINAL RUBBER BUSHING MATERIAL AND CLEAN CONTACT SURFACES. THIS CAN BE DONE BY WIRE BRUSHING, SANDING OR SIMILAR PROCESS.
- 4) DISASSEMBLE NEW URETHANE BUSHINGS. LIGHTLY GREASE BUSHINGS AS DIAGRAM INDICATES WITH SPECIAL TEFLON GREASE INCLUDED IN KIT. IF MORE GREASE IS NEEDED, OBTAIN TEFLON GREASE FROM YOUR DEALER (PART #19-1750). USE ONLY OUR SPECIAL TEFLON GREASE.
- 5) INSTALL NEW URETHANE BUSHINGS AND ALL NECESSARY WASHERS, SPACERS AND SLEEVES. TORQUE TO FACTORY SPECIFICATIONS.
- 6) RE-ALIGN VEHICLE.
- 7) AFTER DRIVING VEHICLE FOR APPROXIMATELY 50 MILES, RE TORQUE BUSHING RETAINING NUTS AND OR BOLTS TO BE SURE THEY HAVE NOT LOOSENEED DUE TO THE BUSHINGS SETTLING IN. REPEAT THIS PROCEDURE AFTER VEHICLE IS RACED, DRIVEN OFFROAD OR DRIVEN IN ABUSIVE CONDITIONS.

### CONTROL ARM BUSHING DIAGRAM



### PARTS LIST FOR KIT # 1-204

PART #	DESCRIPTION	QTY
#64127	LOWER C-ARM BUSH	4
#64128	UPPER C-ARM BUSH	4
#64014	THRUST WASHER	4
#64130	THRUST WASHER	4
#64131	THRUST WASHER	1
#64132	THRUST WASHER	1
SLV-60698	7/8 X .685 X 2.6" SLEEVE	4
SLV-60713	3/4 X .406 X 2.0" SLEEVE	4
19-1750-001	SUPER GREASE	2

## THRUST WASHER INSTALLATION INSTRUCTIONS

- 1) THRUST WASHERS PREVENT THE SIDEWARD MOVEMENT OF THE CONTROL ARM THAT MAY OCCUR DURING CORNERING. INSTALL THEM AS THE BUSHING LOCATION LIST AND DIAGRAMS FOR YOUR FRONT AND/OR REAR KIT INDICATES.
- 2) LIGHTLY GREASE EDGES OF THRUST WASHERS THAT CONTACT METAL.

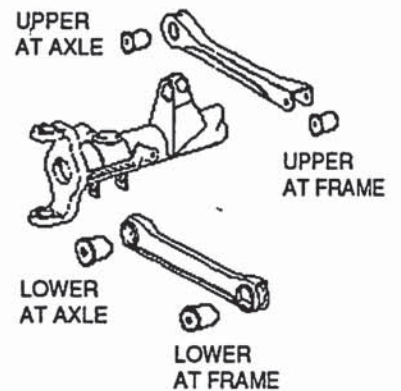
### FRONT C-ARM BUSHING LOCATION      C-ARM BUSHING / THRUST WASHER

UPPER AT AXLE, DRIVER SIDE	#64128 / #64132 (SEE FIG. 2)
UPPER AT AXLE, PASSENGER SIDE	#64128 / #64131 (SEE FIG. 2)
UPPER AT FRAME, DRIVER SIDE	#64128 / #64130 (SEE FIG. 1)
UPPER AT FRAME, PASSENGER SIDE	#64128 / #64130 (SEE FIG. 1)
LOWER AT ALL LOCATIONS	#64127 / #64014 (SEE FIG. 1)

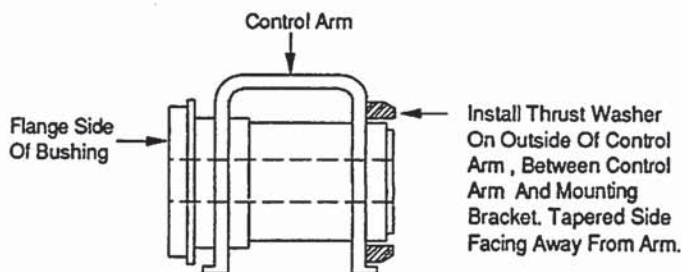
### REAR C-ARM BUSHING LOCATION      C-ARM BUSHING / THRUST WASHER

UPPER AT ALL LOCATIONS	#64128 / #64130 (SEE FIG. 1)
LOWER AT ALL LOCATIONS	#64127 / #64014 (SEE FIG. 1)

### BUSHING LOCATION DIAGRAM



**FIG. 1** POSITIONING DIAGRAM FOR THRUST WASHER



**FIG. 2** POSITIONING DIAGRAM FOR THRUST WASHER

