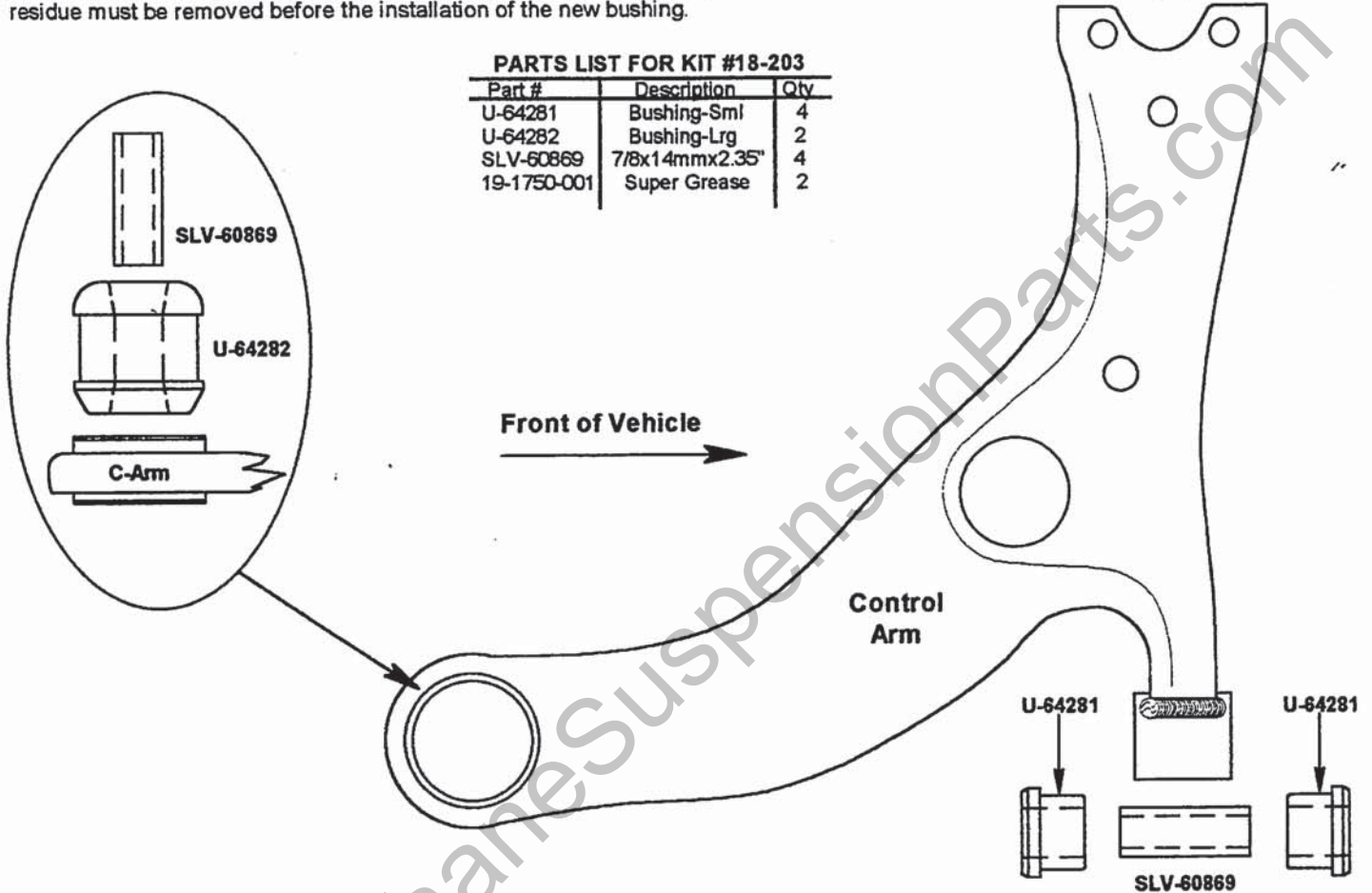


INSTALLATION INSTRUCTIONS FOR TOYOTA CELICA KIT#18-203

- 1) Remove the front Lower Control Arm from the vehicle.
- 2) Remove the rubber bushing located at the front of the control arm. This can be accomplished by pressing the bushing out using an arbor press or similar device. Be very careful not to damage the control arm while pressing the rubber out. The inside diameter of the arm needs to be in good condition for the new polyurethane bushing to work and fit properly.
- 3) Remove the rubber bushing located at the rear of the control arm. This can be accomplished by burning out the rubber. The use of an acetylene or propane torch for this procedure works very well. CAUTION-this should be done by a qualified specialist as it is extremely dangerous. Do not remove the outer steel shell from the control arm. It is press fit in the control arm and needs to remain in the arm for the new bushing to fit and work properly. Once the rubber is removed, clean the outer shell and control arm thoroughly. All debris and residue must be removed before the installation of the new bushing.



- 4) Prepare the control arm for installation of the new parts by thoroughly cleaning and deburring all of the mating surfaces.
- 5) To help prevent rust, now is a good time to repaint any of the control arm surfaces that were damaged during the disassembly process.
- 6) Install the new Prothane control arm bushings in the front location. Using the grease provided in the kit, grease the inside diameter of the control arm and the outside diameter of bushings #64281. Press the bushings into the arm by hand. Now grease the inside diameter of the bushings and the outside diameter of the new 7/8 x 2.35" sleeve and press it into the bushings. Be sure to thoroughly grease the sleeve upon installation. Now apply grease to the outer surfaces of both bushings before reinstalling.
- 7) Install the new Prothane control arm bushing in the rear location. Using the grease provided in the kit, grease the beveled edge of bushing #64282. Press the new bushing into the original control arm shell using an arbor press or similar device. Make sure bushing is fully seated in control arm shell. Now apply grease to the outside of the new 7/8 x 2.35" sleeve and the inside of the bushing and press the sleeve into the bushing by hand. Be sure to thoroughly grease the sleeve upon installation. Apply grease to the outer surfaces of the bushing before reinstalling.
- 8) Install control arms on vehicle per service manual. Have wheel alignment performed immediately to prevent premature/incorrect tire wear.

