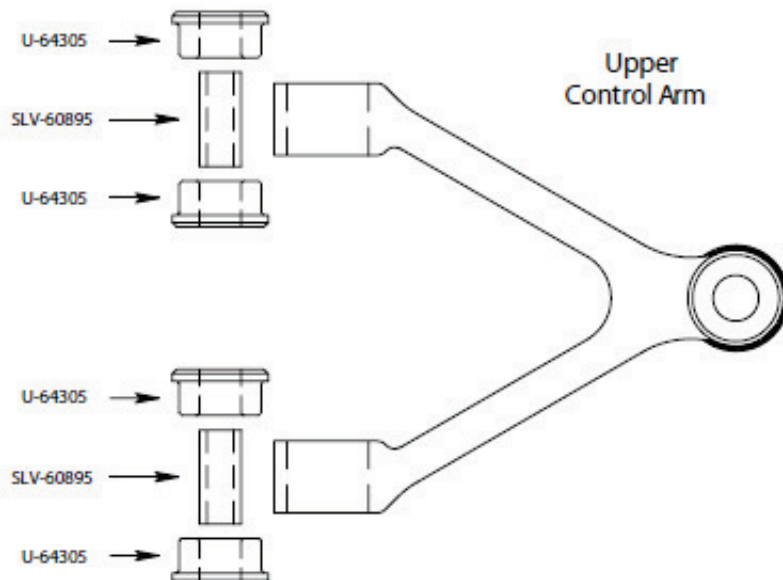


INSTALLATION INSTRUCTIONS FOR LEXUS SC300/400 KIT #18-207

UPPER

- 1) Remove the upper control arms from the vehicle.
- 2) Remove the original bushings from the control arms.
These bushings need to be pressed out. CAUTION- be very careful not to damage the control arms.
- 3) Thoroughly grease bushings #64305 and install into the arm.
- 4) Now grease the 7/8x1.96" sleeves and press into bushings.
- 5) Grease outer face of bushings and reinstall arms.
- 6) Torque to factory specifications.



PARTS LIST FOR KIT #18-207

Part #	Description	Qty
U-64305	Upper Bushing	8
U-64306	Lower Bushing	2
U-64307	Lower Bushing	2
SLV-60895	7/8x9/16IDx1.96"	4
SLV-61049	1 x .657ID x 2.813"	2
SLV-61050	1.188 x .657ID x 2.61"	2
19-1750-001	Super Grease	5

LOWER

- 1) Remove the lower control arms from the vehicle.
- 2) Please take note before attempting to remove the original bushings: Both bushings consist of a steel outer shell and a steel or aluminum inner sleeve. The outer shell must be left in the control arms for the new bushings to fit properly.
- 3) Remove the original rubber bushings from the shells. This can be done by burning out the old rubber with a torch. CAUTION-this procedure can be very dangerous and is best performed by a professional mechanic. Be careful not to damage the control arms in the process.
- 4) Thoroughly clean and deburr the inside of the bushing shells.
- 5) Grease the outside of bushing number #64306 with the grease provided and press it into the FRONT location of the control arm by hand(see drawing). Be sure that the flange of the bushing is seated against the flange of the original outer steel shell and not against the casting of the arm.
- 6) Grease the outside of the aluminum sleeve that measures 1-3/16x5/8IDx2-11/16" and the inside of the new bushing. Press the sleeve into the new bushing by hand.
- 7) Grease the outside of bushing number #64307 with the grease provided and press it into the REAR location of the control arm by hand(see drawing).
- 8) Grease the outside of the steel sleeve that measures 1x5/8IDx2-13/16" and the inside of the new bushing. Press the sleeve into the new bushing by hand.
- 9) Grease the outer face of the bushings and reinstall the control arms.
- 10) Torque to factory specifications.

Lower Control Arm

