

# Installation Instructions:

**KIT NO. 8-319**

**'06-'11 HONDA CIVIC**

## Rear Control Arm & Knuckle Bushings



714.979.4990

3560 Cadillac Ave., Costa Mesa, CA 92626

Parts List:	Description:	QTY:
19-1750-001	Super Grease	4
SLV-60873	1.00" x .250" x 1.850" (inner)	2
SLV-60874	1.00" x .250" x 1.960" (inner)	2
SLV-60876	1.58" X 1.310" I.D. X 1.180" (outer)	2
SLV-61030	.875" x .156" x 2.000" (inner)	2
SLV-61031	1.00" x .219" x 1.815" (inner)	2
SHAFT-104	Center Shaft (U-64275)	2
SNAP-92	Snap Ring (SHAFT-104)	4
U-64274	Rear Upper C-arm Outer Bushing	4
U-64275	Rear Upper C-arm Inner Bushing	4
U-64276	Rear Lower Knuckle Bushing (FRONT)	4
U-64277	Rear Lower C-arm Bushing (REAR)	4
U-64318	Rear Lower Knuckle Bushing (REAR)	4
**FORM 8-319	Instruction Sheet	1



Please refer to a factory service manual before any disassembly or reassembling of your vehicle for proper instructions. Check service manual to ensure proper torque specs during installation. **NOTE:** The Prothane Bushings generally do NOT meet in the center. The "crush" or amount the bolt can be tightened is determined by the length of the sleeve.

**\*\*Prothane Motion Control highly recommends this and all our polyurethane suspension kits be installed by a qualified technician.\*\***

### INSTALLATION:

- Using your vehicle shop manual, uninstall rear control arms and rear knuckle (NOTE: Do not apply heat to the knuckle as it can damage the cast aluminum piece).
- Remove bushings from upper c-arm and lower c-arm (REAR only) using a hydraulic press (CAUTION: Take care not to damage the control arm).
  - Remove both the rubber and bonded metal shells.
  - Clean the I.D. of the control arms and remove any sharp edge.
- Due to factory design, OEM knuckle bushings cannot be pressed out conventionally/easily without special tools. To remove bushing from knuckle, we recommend the following method to be performed by a qualified technician.



- Drill Star pattern around rubber part of bushing with 3/16" drill bit.
- Press/punch center out of bushing.
- With center removed, cut a slit in remaining outer sleeve with sawzall/hacksaw. NOTE: Take care not to cut too deep as outer sleeve of factory bushing is only ~0.070" thick.
- Using small punch/chisel, tap out remaining part of sleeve. NOTE: Larger bushing (REAR) is a 2pc design and best removed by tapping each half out from the inside of the bore outward. Smaller bushing (FRONT) can be tapped out in the direction of the flanged side.
- Repeat steps 1 through 4 with removal of second bushing.
- Clean and hand file/sand smooth any knicks, cuts, or marring in I.D. bore of knuckle after bushing removal.

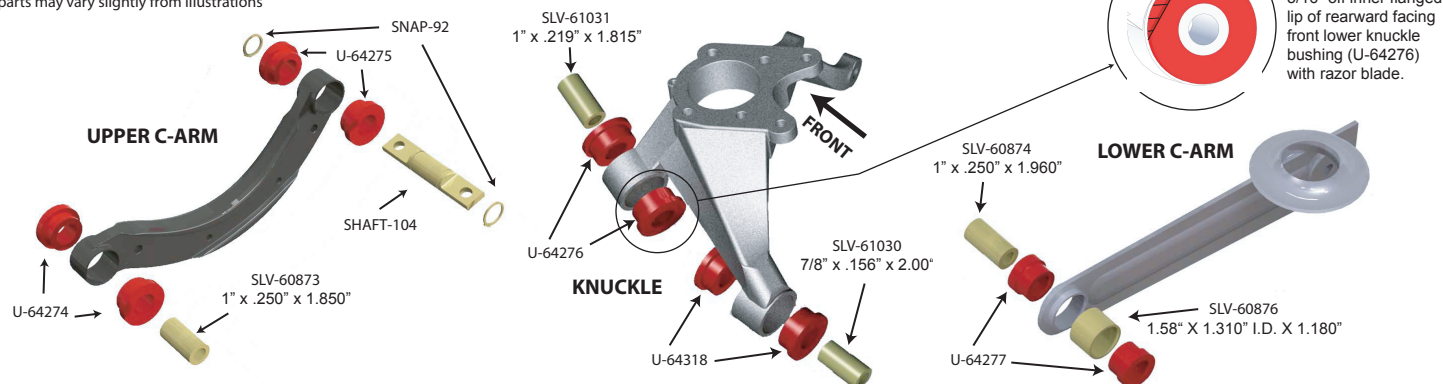
- With factory bushings removed, apply Super Grease to I.D. and O.D. of urethane bushings (**U-64274, U-64275, U-64276, U-64318**) and insert into upper control arm and knuckle by hand. Apply Super Grease to O.D. of inner sleeves/shaft (**SLV-60873, SLV-61030, SLV-61031, SHAFT-104**) and insert into bushings (use of arbor press may be required). Install snap rings (**SNAP-92**) in the groove on both sides of new shaft (**SHAFT-104**) making sure they are properly seated in grooves. SEE ILLUSTRATION BELOW.

- For the lower control arm, press in new outer shell (**SLV-60876**) using a hydraulic press until it is centered in the arm (NOTE: DO NOT grease the O.D. of new shell before installation). Apply Super Grease to I.D. of the shell and insert urethane bushings (**U-64277**) and inner sleeve (**SLV-60874**) following previous steps. SEE ILLUSTRATION BELOW.

- Apply Super Grease to outer flanged surfaces of bushings and reinstall rear suspension using your vehicle shop manual.

\*Vehicle parts may vary slightly from illustrations

### Assembly View:



**\*\*After installation of Prothane polyurethane bushings, it is recommended to have the rear wheels re-aligned at a qualified service center. DO NOT HESITATE TO GET THIS DONE, AS PREMATURE TIRE WEAR CAN RESULT.\*\***

**\*\*FORM 8-319**

**FOR TECHNICAL ASSISTANCE CALL 1-888-PROTHANE**