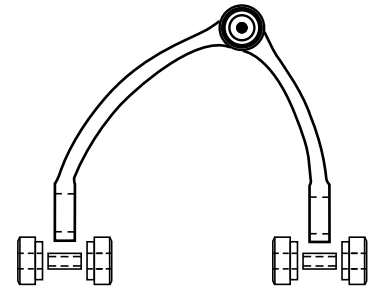


**INSTRUCTION SHEET**  
**FRONT POLYURETHANE CONTROL ARM BUSHING KIT**  
**G2-2002 1998-1999 GS300/GS400 (JZS160/UZS160)**  
**G2-2002A 2000-2005 GS300/GS400/GS430 (JZS160/UZS160/UZS161)**

**CAUTION! Due to the nature of the parts being installed, it is highly recommended that this installation be performed by a qualified mechanic or technician!**

**UPPER CONTROL ARMS**

1. Remove the upper control arms from the vehicle as per factory service manual instructions. Take extreme care not to damage the ball joints - especially the ball joint threads/nuts/boots.
2. The original rubber bushings along with the original outer steel shells will need to be removed from the arms. Removal can be accomplished with a hydraulic press. **CAUTION!** - Care must be taken not to damage the control arms.
3. Insert bushings into control arms. Wider bushing CA114 goes from the outside.
4. Thoroughly grease inner bushing surfaces and supplied metal sleeves and insert sleeves into bushings.
5. **Grease the faces of the bushings (IMPORTANT!)** and reinstall control arms. **Be sure that any areas that contact the bushing faces are free from any dirt or corrosion before installing the control arms.** These areas should also be greased prior to control arm installation.
6. Torque all hardware to factory service manual specifications. (Control arm 39 lb-ft, ball joint nuts 64 lb-ft)



Upper Control Arm

**#1 LOWER CONTROL ARMS**

1. If the vehicle will not be aligned immediately after installation, be sure to mark current alignment settings on adjusting cam bolts before any work is started.
2. Remove #1 lower control arms from the vehicle as per factory service manual instructions. Take extreme care not to damage the ball joints - especially the ball joint threads/nuts/boots. **CAUTION!** - Care must be taken not to damage the control arms.
3. Remove original rubber bushings along with the original outer steel bushing shells. Removal can be accomplished with a hydraulic press. **CAUTION!** - Care must be taken not to damage the control arms.
4. Grease new bushings and install them into control arms.
5. Thoroughly grease inner bushing surfaces and supplied metal sleeves and insert sleeves into bushings.
6. **Grease the faces of the bushings (IMPORTANT!)** and reinstall control arms. **Be sure that any areas that contact the bushing faces are free from any dirt or corrosion before installing the control arms.** These areas should also be greased prior to control arm installation.
7. Torque all hardware to factory service manual specifications. (Control arm bolts 127 lb-ft, ball joint nuts 119 lb-ft, shock absorber bolts 70 lb-ft, #2 to #1 control arm bolts 122 lb-ft)

**#2 LOWER CONTROL ARMS**

1. Remove #2 lower control arm as per factory service manual instructions.
2. Remove original rubber bushings along with the original outer steel bushing shells. Removal can be accomplished with a hydraulic press. **CAUTION!** - Care must be taken not to damage the control arms.
3. Debur and round/smooth the inside corners/edges where the bushings will be installed. **Failure to do this will cause damage to the bushing and will cause bushing failure!**
5. Lightly grease bushings and install them into arms. This must be done with a press - bushings must be pressed in squarely!
6. **Grease the top and bottom faces of the bushings (IMPORTANT!)** and reinstall control arms. **Be sure that any areas that contact the bushing faces are free from any dirt or corrosion before installing the control arms.** These areas should also be greased prior to control arm installation.  
Hint: Install the #2 sleeve after bolting #2 control arm to #1 control arm.
7. Torque all hardware to factory service manual specifications.  
(Control arm bolts 112 lb-ft, lower brace bracket bolts 43 lb-ft, #2 to #1 control arm bolts ball joint bolts 122 lb-ft)