

# Fitting Instructions #5479IS

## GWM Cannon/GWM Tank

### Front Lower Control Arm Bushing Kit

Note: Polyurethane bushings MUST be fitted to both sides of the vehicle.

Note: SPF5479 and SPF5480 are different sizes, ensure that each bushing is pressed into the correct housing in the control arm. Refer to Figure 01.

- Raise the vehicle on a hoist/jack stands, then remove the front lower control arms from the vehicle.
- Remove original bushes including the shell from the front upper control arms with the use of an air chisel and suitable pressing tools.
- Clean the housings to ensure that the original bushings are completely removed, and the housings are ready for the new bushings.
- Using suitable press tools, press the polyurethane bushings into the housings until the under side of the shell flange contacts the control arm. Refer to Figure 02.

- Note: Bushings are pressed in with the shell flange towards the outside of the control arm without washers or tubes.
- Note: SPF5479 (smaller bushing) MUST be pressed into the front housing when in positioned within the vehicle.

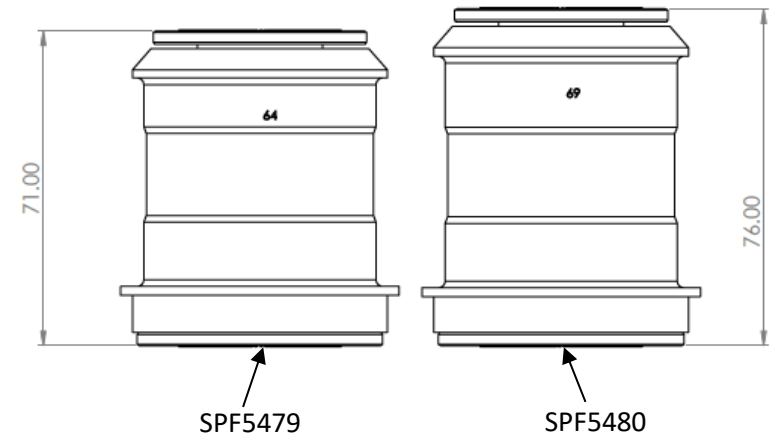


Figure 01 – SPF5479 and SPF5480

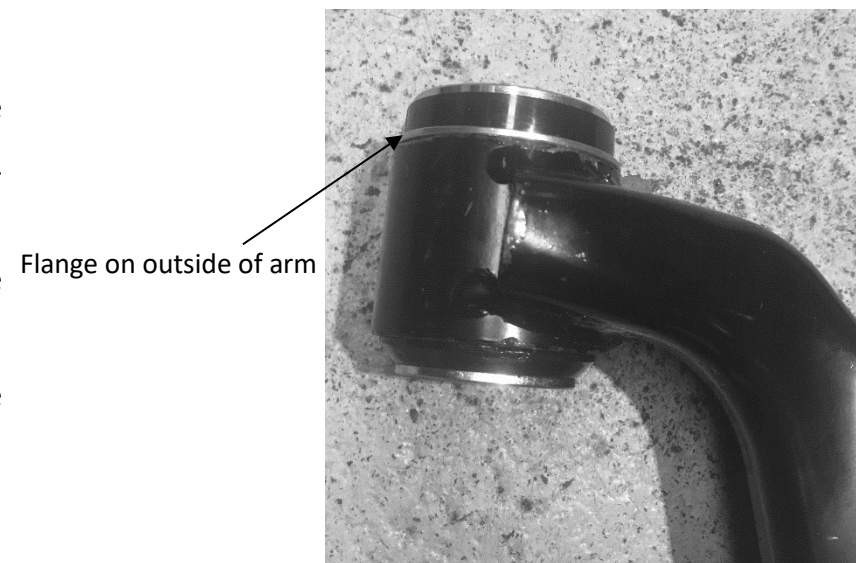


Figure 02 – Completed pressing of one bushing

- Using an arbour press, press one side of the crush tube into the larger washer until the washer contacts the tube flange.
- Using the grease provided, liberally grease the inner bore of the bushing and the outer face of the crush tube, then press the tube into the bushing until the washer contacts the bushing. Refer to Figure 03.
  - Note: The tube Must be pressed such that the washer sits on the outside of the control arm.
- Using an arbour press and suitable press tools press the smaller washer onto the other side of the crush tube until the washer contacts the tube flange.
- Complete for both bushings in control arm, completed arm should look as shown in Figure 04.
- Repeat for other side of vehicle.
- Re-install the lower control arms and tighten all bolts to manufacturer's torque settings.
- Carry out wheel alignment
- Check all bolts after 100km or 1 month

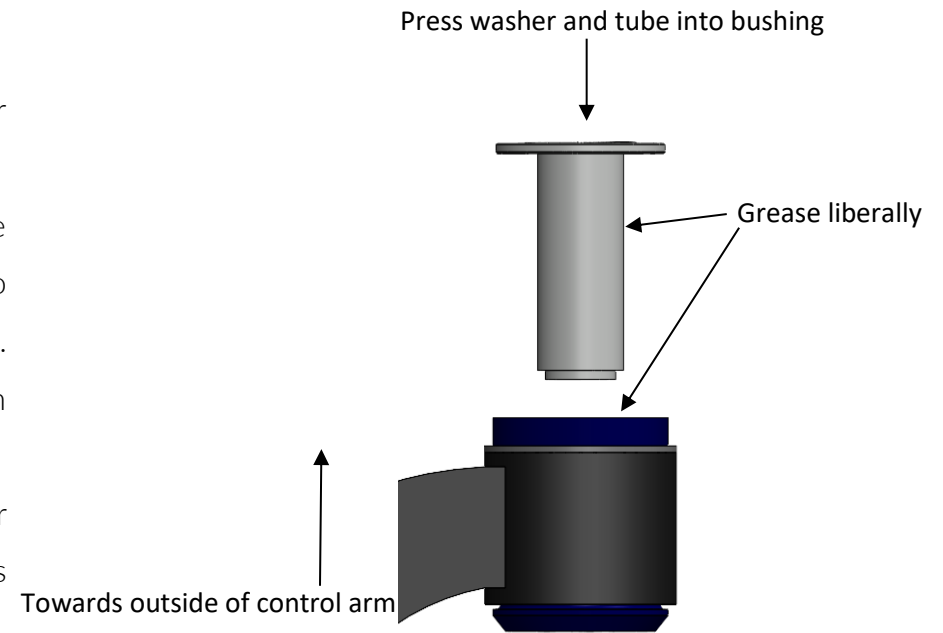


Figure 03 – Pressing crush tube into bushing

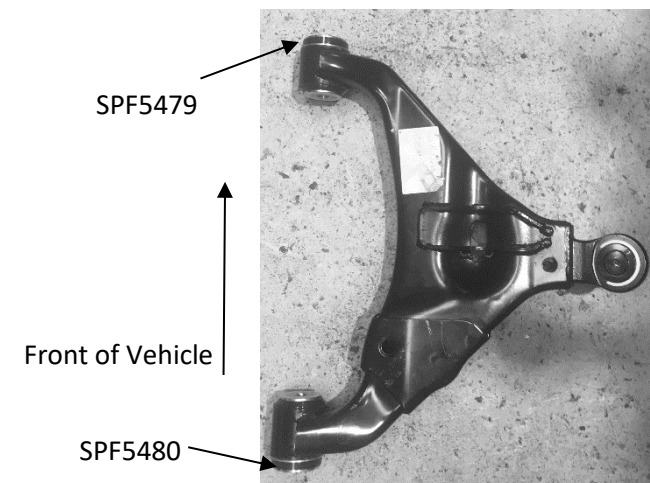


Figure 04 – Completed RHS control arm