

Fitting Instructions #2902IS

Toyota Aurion GSV40R, Camry XV40, Kluger (ACU25, MCU25, MCU28, GSU40R, GSU45R, Tarago, Previa, Estima, Lucida & Emina
Front Lower Control Arm Front and Rear Bushing (To suit Right-hand drive vehicles)



Note: Polyurethane bushes must be fitted to both sides of the vehicle.

- Wheel align the vehicle before the job is started and note settings;
- Following manufacturer's recommendation, remove the front lower control arms from the vehicle.

Front Bush

- With Control Arms out of the vehicle the Front Inner Bush and Pivot Pin can be removed from the arm, taking care not to damage the pivot pin and cleaning it prior to re-use;
- Apply the grease provided to the rear end of the pivot pin and the mating flange face, also to the inside of the new polyurethane bushing (4099). The bushing should now be fitted on the pin;
- The pivot pin with the new bushing (4099) fitted should now be pressed into the control arm, the outside of the polyurethane bushing and the eye of the arm it is to be pressed into should be suitably lubricated to assist ease of assembly. 2663R should now be greased and assembled to the rear of the pin;
- Grease the rear end of the bushing and the mating face of the "Bush Stopper" and assemble the Stopper correctly on the pin.

Rear Bush

- Remove original shell part from the control arms with the use of a hydraulic press and suitable pressing tools;
- Clean housing areas to remove any old original bushing materials before installing new bushes;
- With reference to Table 1, the kit number that you have purchased and the settings required, adjust the offset of the new bushings, so that the hole is positioned to give the desired castor result. After that, by using the appropriate pressing tools support the control arm and press in the new bushes;
- Using the grease supplied, generously lubricate the outside of the steel crush tube and the inside of the new polyurethane shell parts and then, push the steel crush tubes into the new bushings, a hand press may be required to insert the steel tube, as there can be significant crush;
- Grease the faces of the spacer washers, and push them onto the tubes. The spacers are to be arranged as depicted in the diagram below (Larger face of spacers must face the new bushing);
- Lubricate the side faces of the new bushings and the areas on the chassis that contact the new bushings and refit the front lower control arm. Tighten all fasteners to manufacturer's specifications, get the vehicle wheel align and check new settings.

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Left Hand Side Shown

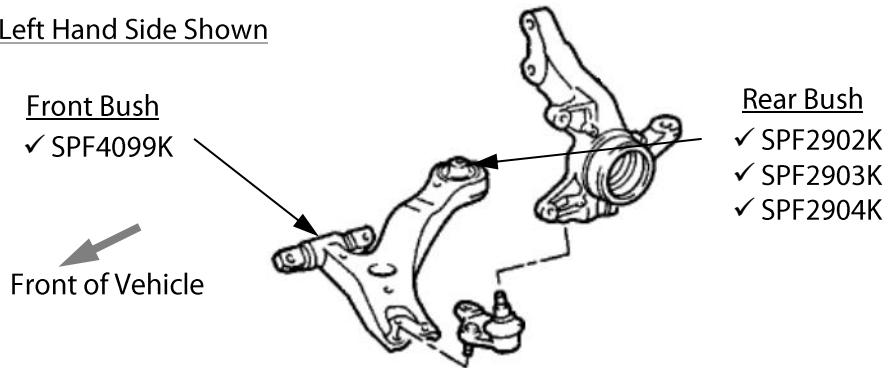
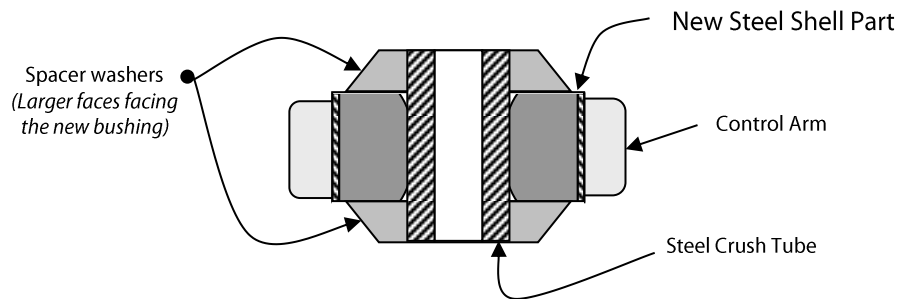


Figure 1: 4099 polyurethane bush assembly with factory tube (left), and then press into arm (right). After that, slide 2663R polyurethane bush through the pin and then, assemble the stopper on the pin.

Side view of assembled new part in control arm

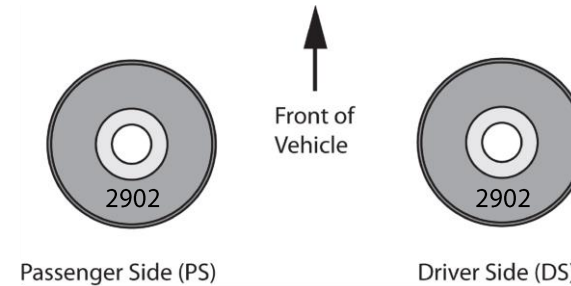


Note the orientation of the Spacer Washers.

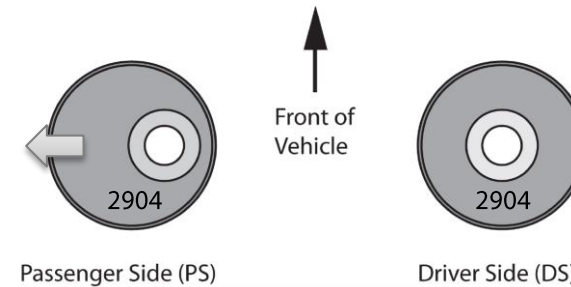
Figure 2: Spacers Arrangement.

As viewed from the top of the control arm, looking down on rear bushing.

Kit #2902K – Standard Replacement. No castor change.



Kit #2903K – To counteract a slight pull to the left
Single Offset, Passenger side castor Increase.



Kit #2904K – To Counteract a Strong pull left
Double Offset, passenger side increase, driver side decrease castor.

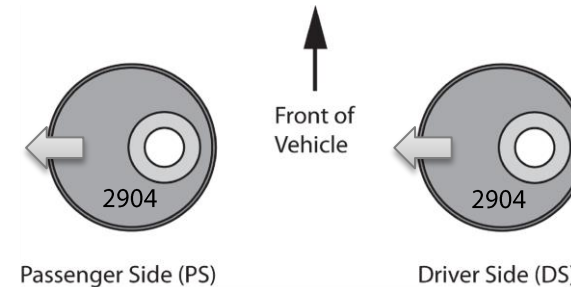


Table 1: Illustration of Castor Settings