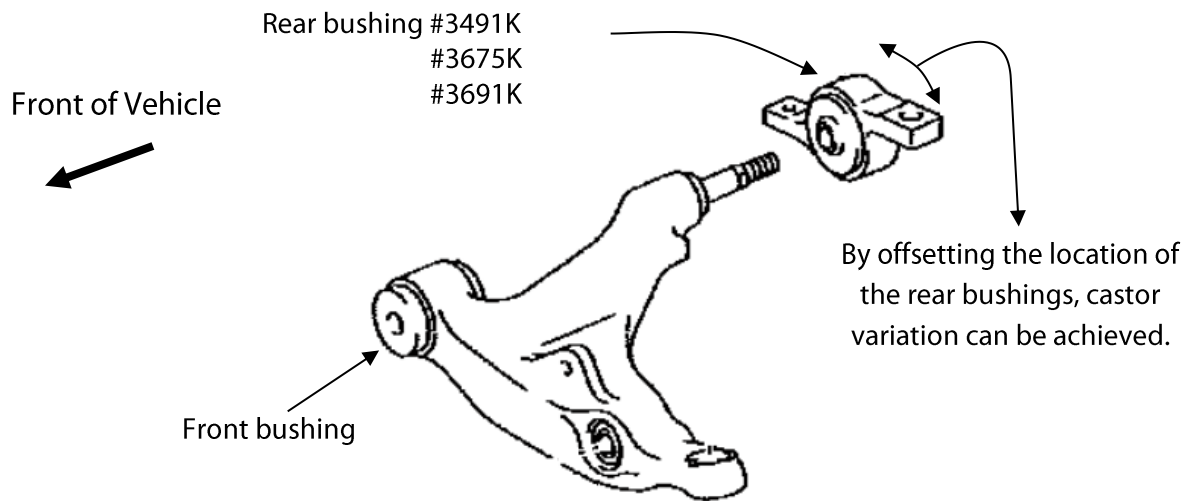


# Fitting Instructions #3491IS

Toyota Mark X (X120 Platform) / Lexus IS250, IS350, GSE20, GSE25

## Front Lower Control Arm Rear Bushing



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

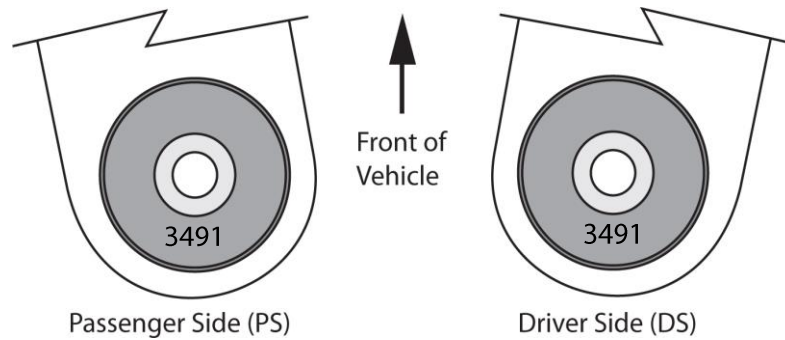
- Wheel align the vehicle before the job is started and note castor settings;
- Mark the control arms & bracket orientation then remove the bracket from the vehicle;
- Use a hydraulic press or similar to remove the OE bushing from the bracket;
- With reference to the diagrams, the kit number that you have purchased and the settings required, align the bushing and the brackets, so that the hole in the bushing is positioned to give the desired result. Then press the polyurethane bushing in;
- Lubricate the inside of the new polyurethane bushing and the outside of the steel crush tube. Use an arbour press to press the tube into the bushing.

**Note** the direction of the crush tube as per OE bush style. The chamfer end of the crush tube should fit against the shoulder of the arm.

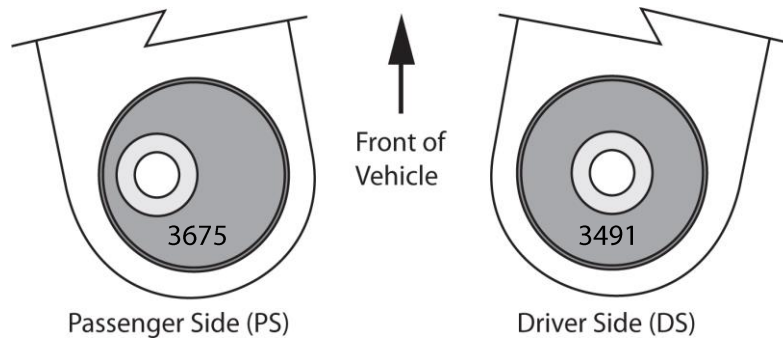
- Refit the brackets with the new bushes & tubes into the vehicle;
- Wheel align vehicle and check new settings;
- Torque all mounting bolts to manufactures specifications with the vehicle at ride height.

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

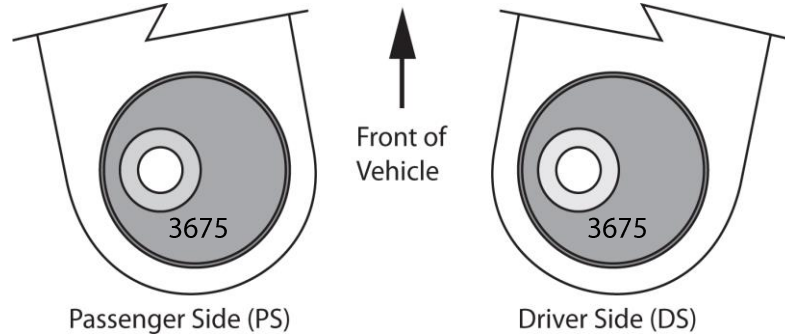
**Kit #3491K** – Standard Replacement (No caster change)



**Kit #3675K** – to counteract a slight pull to the left ( approx. 0.8 deg. change)  
Single Offset – (passenger side castor increase & drivers side no castor change)



**Kit #3692K** – to counteract a strong pull to the left (approx. 1.6 deg. change)  
Double Offset – (passenger side increase and driver side decrease castor)



**Kit #3692K** – Performance settings  
Double Offset – (passenger and driver side increase castor)

