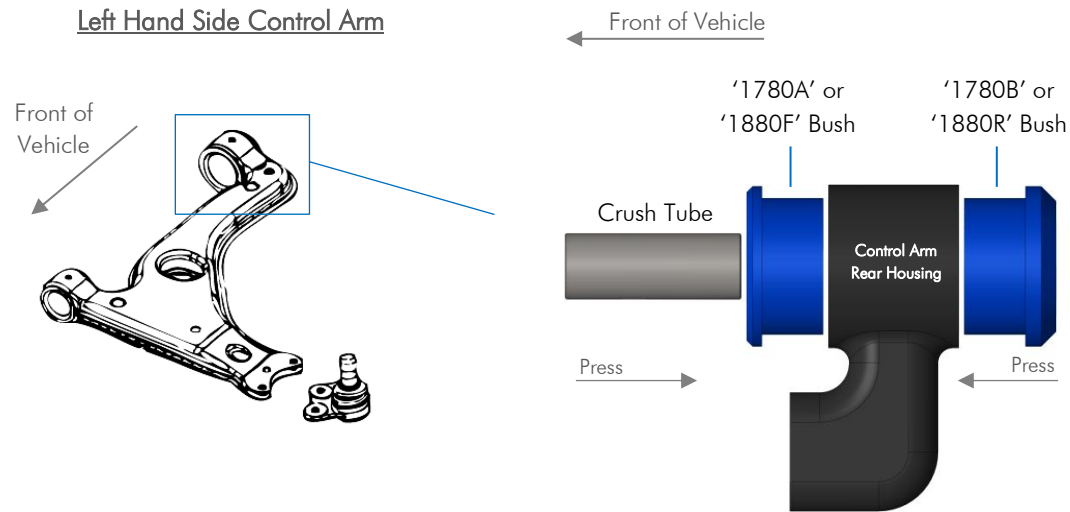


Fitting Instructions #1780IS

Holden Vectra / Astra / Calibra

Front Control Arm Lower Rear Bushing

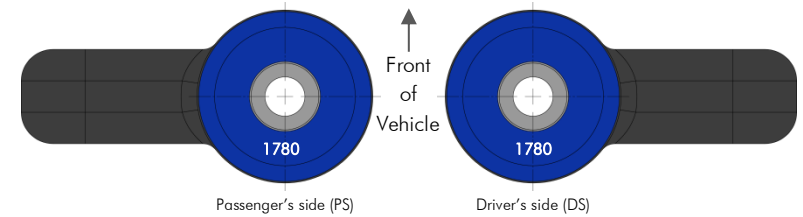


Note: Polyurethane bushings must be fitted to both sides of the vehicle.

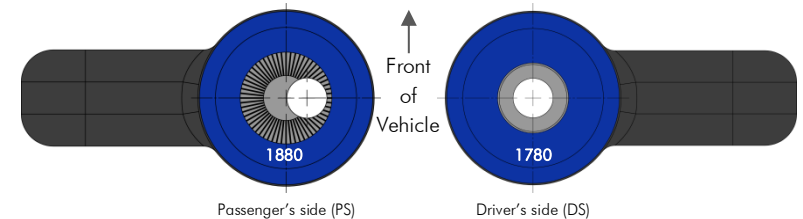
- Wheel-align the vehicle before the job is started and note settings;
- Jack the vehicle up and support on jack stands/hoist;
- Remove the lower control arms;
- Remove original shell part from the control arm rear housing with the use of a hydraulic press and suitable pressing tools;
- Using the grease supplied, lubricate the housing and outside surfaces of the new bushes and push them into the control arm rear housing;
- With reference to the diagrams and the settings required, align the crush tube with the housing so that the hole in the tube is positioned to give the desired result;

As viewed from the rear of the control arm

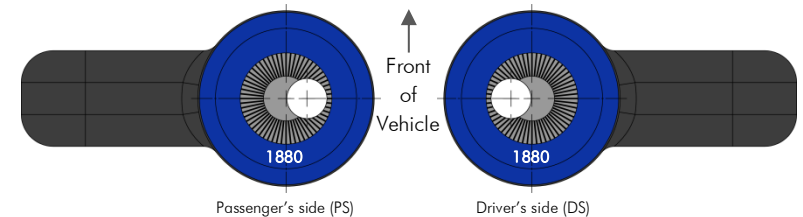
Kit #1780K – Standard Replacement
No caster change



Kit #1880K – Single Offset
Passenger's side caster increase (+0.5 degree)



Kit #1880AK – Performance Settings
Increase caster both sides (+0.5 degree each side)



- Generously lubricate the outside of the crush tube and inside of the bush, then push the tube into the installed bushes.
- Refit the control arms to the vehicle and tighten all bolts to manufacture's torque settings and carry out wheel alignment.