

Fitting Instructions #4010IS

Mercedes M-Class W164, Mercedes GL-Class X164

Control Arm Lower Rear Bushing (Front)

- Wheel-align the vehicle before the job is started and note settings.
- Jack the vehicle up and support on jack stands, then remove the lower control arms.
- Mark the arm before removing the rear bracket from the arm. After that, remove original shell parts from the bracket with the use of a hydraulic press and suitable pressing tools.
- Alternatively, you may remove the original shell part by burning the rubber bushing and cutting the shell out. Care must be taken to not damage the bracket while performing the cut.
- Clean bracket's housing areas to remove any old original bushing materials.
- **With reference to the diagram alongside**, note the position of the new bushes in the bracket, then push the new polyurethane bushing with the shell into the bracket.
- Next, use Loctite 7471 primer, spray the spigot shaft on the end of the arm and the inner surface of the crush tube. Following Loctite instructions, wait for primer to dry – 5 minutes approximately. After that, drop Loctite 680 high strength retaining compound around the diameter of the spigot ensuring an even coverage. Slide the crush tube onto spigot until it comes up against shoulder on arm. Wipe excess Loctite off the arm and leave to cure as per instructions on Loctite bottle.
- After that, lubricate the outside of the steel tube, the polyurethane bore and slide the bracket into the steel crush tubes.
- **Note:** the bracket and the arm should be aligned as original arrangement.
- Refit the control arm to the vehicle. Tighten all bolts to manufactures torque settings and carry out wheel alignment.



Left Hand Arm Shown-Complete with SuperPro Bushes Installed



Make sure that the rear bush sits flush on the bracket side with wording