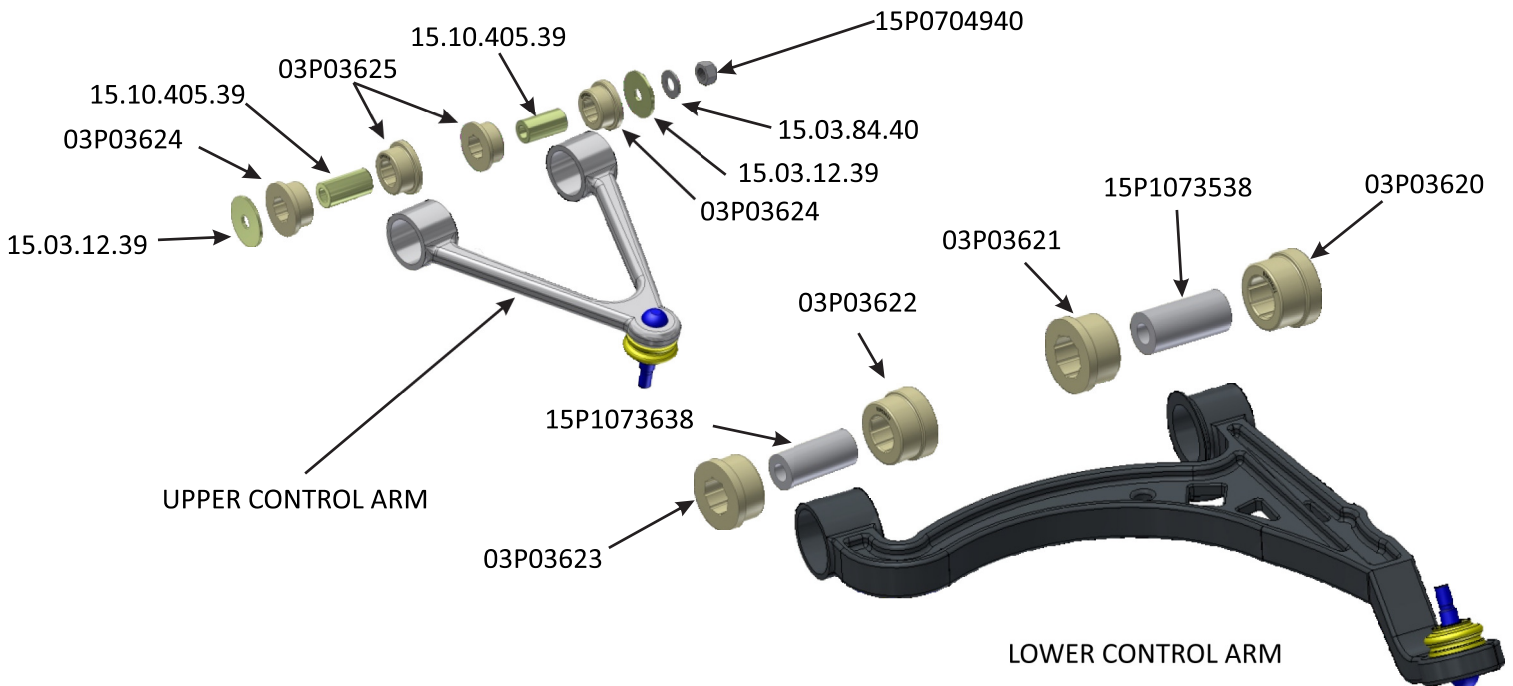


This instruction is intended as a guideline for the safe installation of Energy Suspension polyurethane bushings after original equipment has been removed from the vehicle. If you are unfamiliar with vehicle chassis and suspension repair work, it is recommended that you utilize a qualified service center for the replacement of these components. Reference vehicle manufacturer's service manual for component removal and replacement procedures and torque specifications. Before beginning work, read these instructions thoroughly and verify parts received match part numbers and quantities in parts list. In the case of discrepancy, contact Energy Suspension Customer Service (949-361-3935). Because wheel alignment is altered when suspension components are removed and replaced, it is highly recommended that your vehicle be checked and adjusted by a qualified alignment shop prior to use. Energy Suspension parts are designed to work with vehicles in good state of repair. We cannot be held responsible for suspension or steering related problems occurring due to poor vehicle maintenance.

PARTS LIST

QTY:	P/N:	DESCRIPTION:
2	03P03620	FRONT LOWER CONTROL ARM BUSHING FRONT POS. FRT
2	03P03621	FRONT LOWER CONTROL ARM BUSHING FRONT POS. RR
2	03P03622	FRONT LOWER CONTROL ARM BUSHING REAR POS. FRT
2	03P03623	FRONT LOWER CONTROL ARM BUSHING REAR POS. RR
4	03P03624	UPPER CAB OUTER
4	03P03625	UPPER CAB INNER
2	15.03.12.39	2.00" X .563" X .120" WASHER
2	15.03.84.40	1.187" X .594" X .094" WASHER
2	15P0704940	M14 X 1.5mm NYLOCK NUT
4	15.10.405.39	1.00" X .563" 1.960" SLEEVE
2	15P1073539	1.250" X .640" X 2.680" SLEEVE
2	15P1073639	1.250" X .640" X 2.800" SLEEVE



Be sure to place matchmarks on the front and rear adjusting cams before you start. You will need to use these matchmarks to reinstall the lower control arms back in the same position after the new polyurethane bushings are installed. **See Image 1.** Then have the vehicle's alignment checked by a certified technician. The alignment must be within factory specifications.

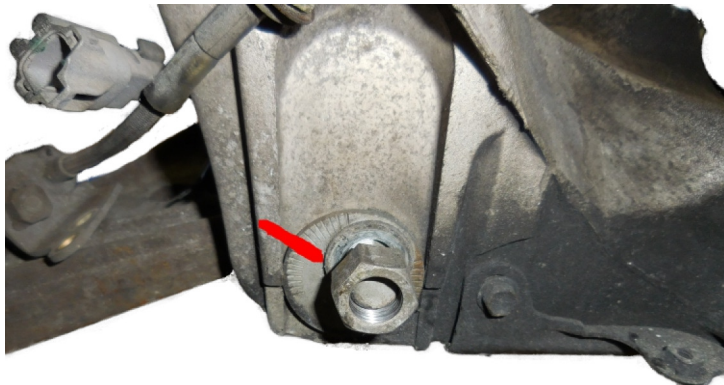


Image 1

Upper control arm:

The old rubber bushing is bonded to the inner metal sleeve and cap washer. The old rubber bushing is not bonded to the inside diameter of the control arm. The outside diameter of the cap washer is $\text{Ø}1.842$ ". Using a hydraulic press, properly support the control arm with metal tubing which has an inside diameter slightly bigger than $\text{Ø}1.842$ ". Slowly press down on the inner metal sleeve of the old rubber bushing to remove. **See Image 2.**

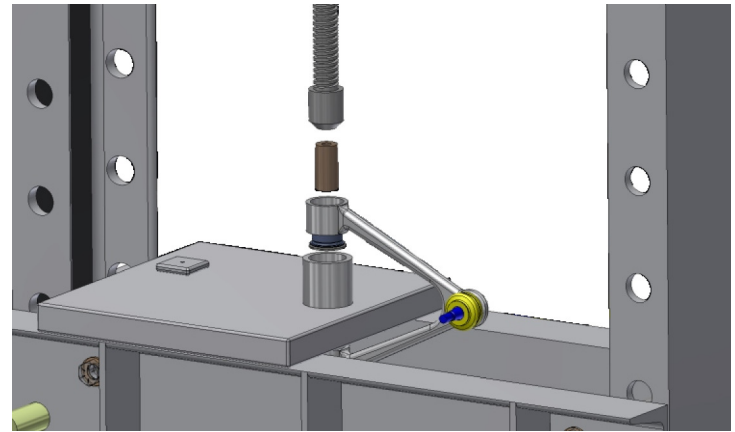


Image 2

Upper control arm:

To remove the old rubber bushing from the other end of the control arm you will need to support the inner metal sleeve bonded to the old rubber bushing. Use the metal tubing with the inside diameter slightly bigger than $\text{Ø}1.842$ " and slowly press down on the control arm. **See Image 3.**

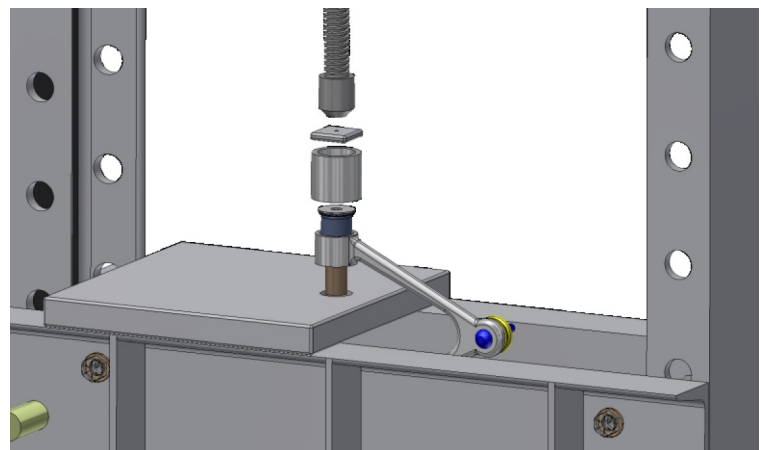


Image 3

Upper control arm continued:

Remove all sharp edges from inside diameter. Apply grease to all metal parts that will contact the new polyurethane bushings. Use an arbor press to install the new polyurethane bushings into the control arm. Bushing 03P03625 installs on the inside and 03P03624 installs on the outside of the control arm. Sleeve 15.10.405.39 installs after the bushings. See image 4.

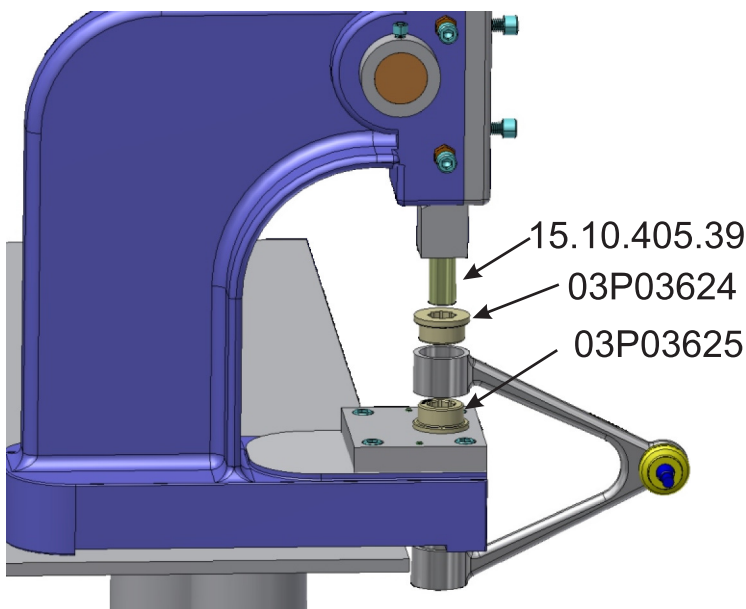


Image 4

Lower Control Arm:

The old rubber bushing is bonded to an outer metal shell and to the inner metal sleeve and cap washer. The old rubber bushing and metal shell will need to be pressed out of the inside diameter of the control arm. The inside diameter of the front position is $\text{Ø}1.970$ ". Using a hydraulic press, properly support the metal shell with metal tubing which has an outside diameter slightly smaller than $\text{Ø}1.970$ ".

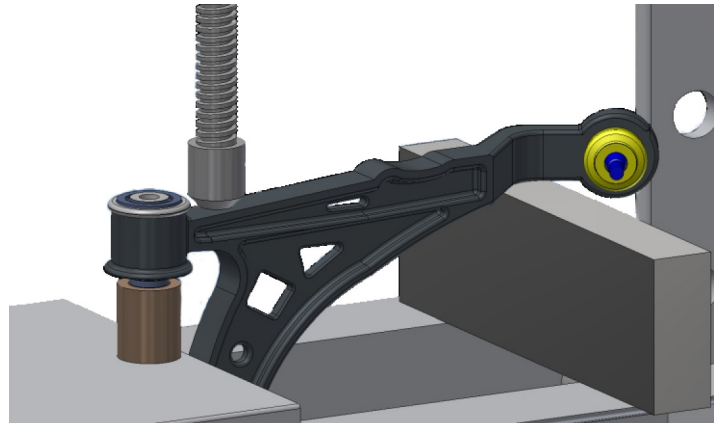


Image 5

Position the hydraulic ram close to the eye with the old rubber bushing. See Image 5. Slowly press down on the control arm, the metal shell will come out. Be careful not to bend or brake the cast-iron control arm. See Image 6.

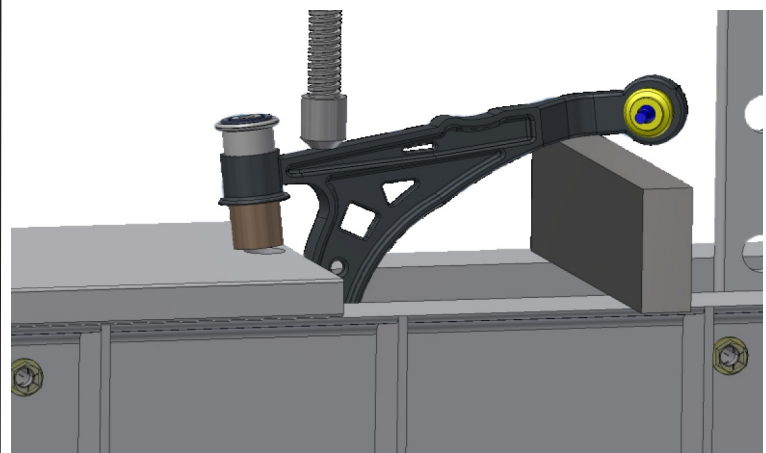


Image 6

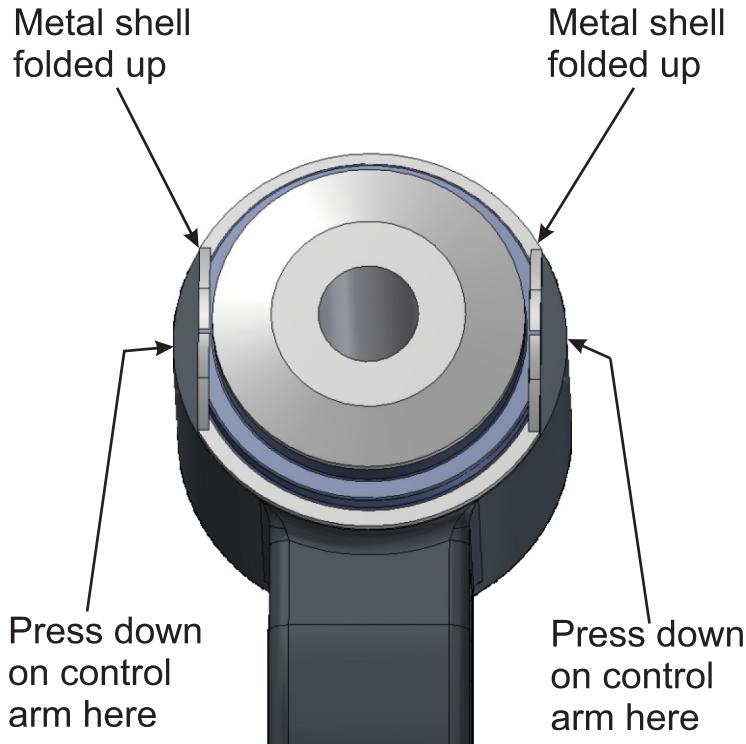


Image 7

Lower Control Arm Continued:

The old rubber bushing is bonded to an outer metal shell and to the inner metal sleeve and cap washer. The rubber bushing and metal shell will need to be pressed out of the inside diameter of the control arm. First the flanges of the metal shell will need to be folded up to expose the eye and give you something to press down on. **See Image 7.** The inside diameter of the rear position is $\text{Ø}2.167''$. Using a hydraulic press, properly support the metal shell with metal tubing which has an outside diameter slightly smaller than $\text{Ø}2.167''$.

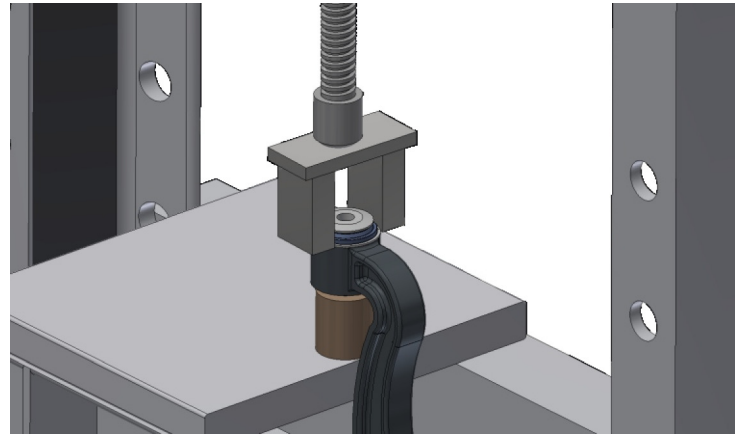


Image 8

Place metal blocks on both sides where the flanges are bent up and a thick plate on top for the hydraulic ram to press down on. **See Image 8.** Slowly press down on the control arm. Be careful and make sure the setup is stable on the control arm. the metal shell will come out. **See Image 9.**

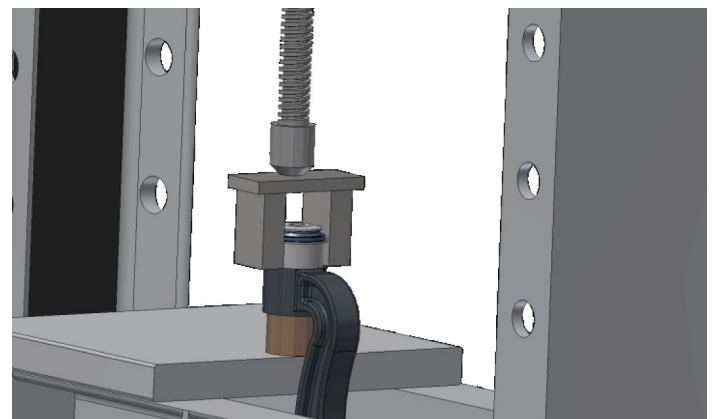


Image 9

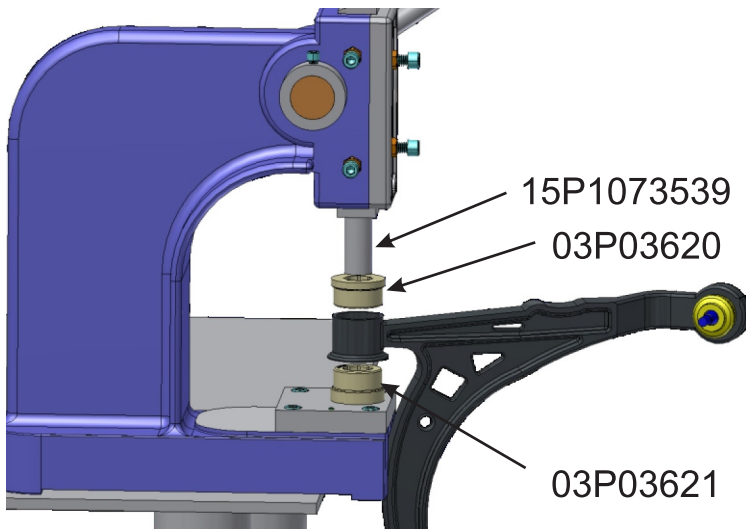


Image 10

Lower control arm continued:

Remove all sharp edges from inside diameter. Apply grease to all metal parts that will contact the new polyurethane bushings. Use an arbor press to install the new polyurethane bushings into the front position of the control arm. Bushing 03P03621 installs on the inside and 03P03620 installs on the outside of the control arm. Sleeve 15P1073539 installs after the bushings. **See Image 10.**

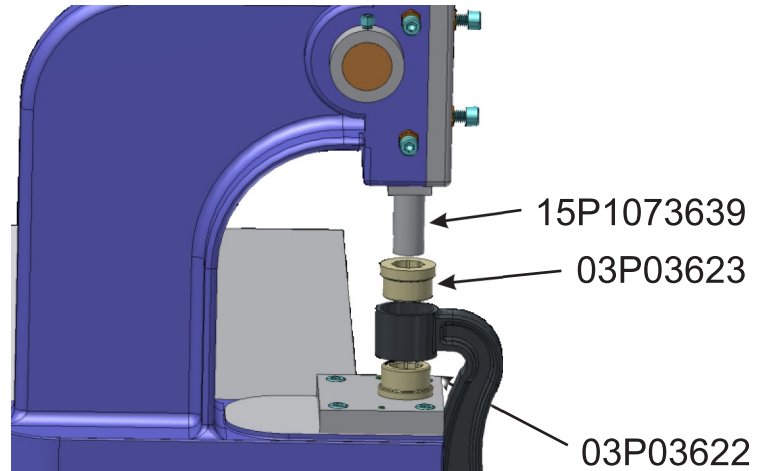


Image 11

Remove all sharp edges from inside diameter. Apply grease to all metal parts that will contact the new polyurethane bushings. Use an arbor press to install the new polyurethane bushings into the rear position of the control arm. Bushing 03P03622 installs on the inside and 03P03623 installs on the outside of the control arm. Sleeve 15P1073639 installs after the bushings. **See Image 11.** Tighten all fasteners to factory specs. After installation is complete, Energy Suspension recommends an alignment be performed at a qualified alignment shop.

Safety Warning and Liability Waiver

Installation of suspension lift kits (or devices) raises the center of gravity of a vehicle. This may create or increase the risk of vehicle instability and can result in vehicle rollover or other mishaps. Such incidents could lead to vehicle damage as well as injury or death to the vehicle driver, occupants and bystanders. Caution should be used when operating the vehicle by reducing speed and avoiding sharp turns and abrupt maneuvers. Driver and vehicle occupants should wear seat belts at all times. Do not add any parts or alter the Energy Suspension components to increase vehicle height over the intended height of the Energy Suspension lift set. Mixing component brands is not recommended. Consumer agrees to indemnify and hold Energy Suspension harmless for any and all injuries, damages or claims resulting directly or indirectly from the purchase, ownership, installation or use of Energy Suspension products.