

# Installation Instructions

For Set # 8.3138  
Rear Control Arm Bushings  
91-97 Toyota Land Cruiser



1131 VIA CALLEJON, SAN CLEMENTE, CA 92673

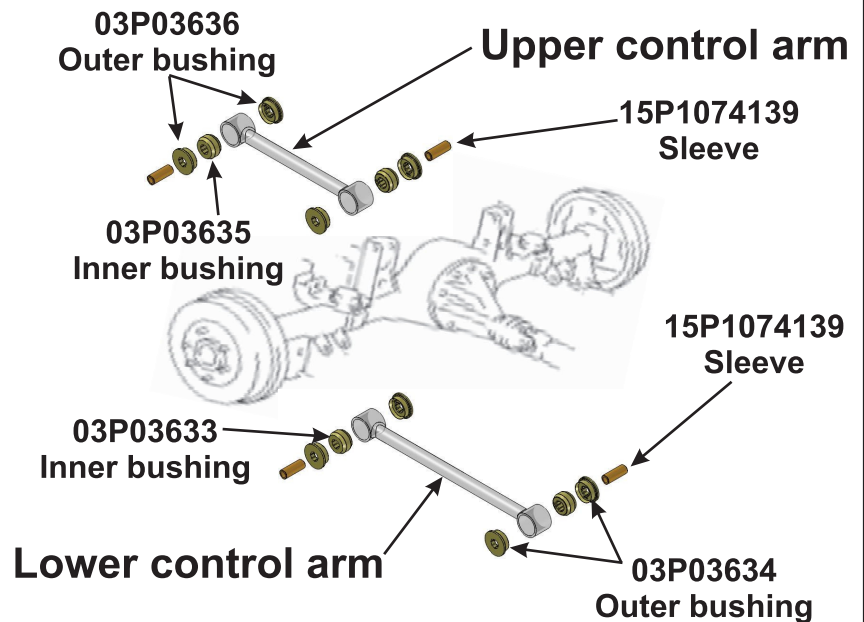
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It is recommended that if you are unfamiliar with this type of work that you refer to a qualified service center specializing in this type of work. It is also recommended that if you choose to do this work yourself that a factory service manual be obtained for the proper procedures pertaining to removal, replacement and proper torque specifications for your vehicle. This instruction set is intended as a guideline for the safe installation of Energy Suspension's polyurethane bushings, once you have removed the factory components from your vehicle. Wheel alignment is almost always disturbed when suspension components are removed or replaced. It is recommended that you have the alignment checked on your vehicle at a qualified alignment shop. Energy Suspension recommends that you read over all the installation instructions and check all P/N's and quantities in the parts list before you start. Call customer service at 949-361-3935 if the parts in your kit do not match this parts list. Prior to installation, make sure that your vehicle is in top mechanical condition and that there are no suspension or steering related problems. This part has been designed to work only with a vehicle that is in good state of repair. No matter how carefully we design our parts, this is one area we have no control over and cannot be held responsible.

## Parts list:

- 4 - 03P03633 (Rear lower inner bushing).
- 8 - 03P03634 (Rear lower outer bushing).
- 4 - 03P03635 (Rear upper inner bushing).
- 8 - 03P03636 (Rear upper outer bushing).
- 8 - 15P1074139  
(1.125"O.D. x .710"I.D. x 2.340"LG Sleeve).
- 1 - 17P17729 (this instruction sheet).

Apply grease to all metal parts that contact the polyurethane bushings. Manufacturer recommends using NEW self-locking nut during installation. Torque upper control arm nut & bolts to 130 ft. Lbs. Torque lower control arm nut & bolts to 130 ft.



UPPER AND LOWER O.E. CONTROL ARMS HAVE METAL SHELLS THAT MUST BE PRESSED OUT. When pressing out the outer metal shell of the original bushing, you need to push it with something smaller than the inside diameter of the control arm. And the receiver end needs to be bigger than the outside diameter of the old metal shell being pushed out. AFTER the metal shells have been pressed out of the lower control arms you will see a hole in each eye. This hole must be filled shut by welding the eye shut or if you don't have access to a welder you can use the supplied plug with a 2-part epoxy like JB-Weld (not supplied). (See page 2 & 3).

## Rear upper & lower control arms

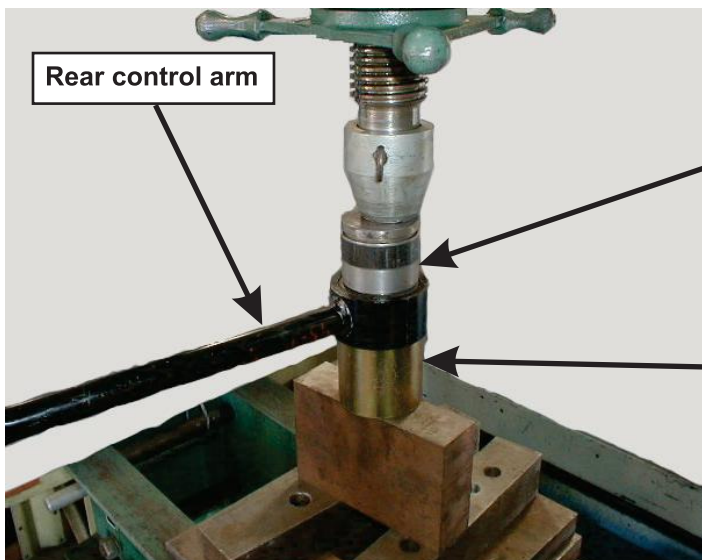
Inside Diameter of upper control arm is 1.960" (50mm). Push out old bushing with something smaller than 1.960". Inside Diameter of lower control arm is 2.165" (55mm). Push out old bushing with something smaller than 2.165".

The inside of receiver for upper control arm needs to be bigger than 1.960" (50mm)". The inside of receiver for lower control arm needs to be bigger than 2.165" (55mm)".

17P17729

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NOTE: After the factory metal shells have been pressed out of the lower control arms you will see a hole at both ends. Welding is the preferred way to close the hole but if you do not have access to a welder you can use a half moon file or die grinder to simply remove the sharp edge of the hole (Fig. 1). A remaining sharp edge may be detrimental to the life of the bushing. If you do have access to a welder then weld the holes shut and then ground flush and smooth as shown (Fig. 2,3 & 4).

Fig.1

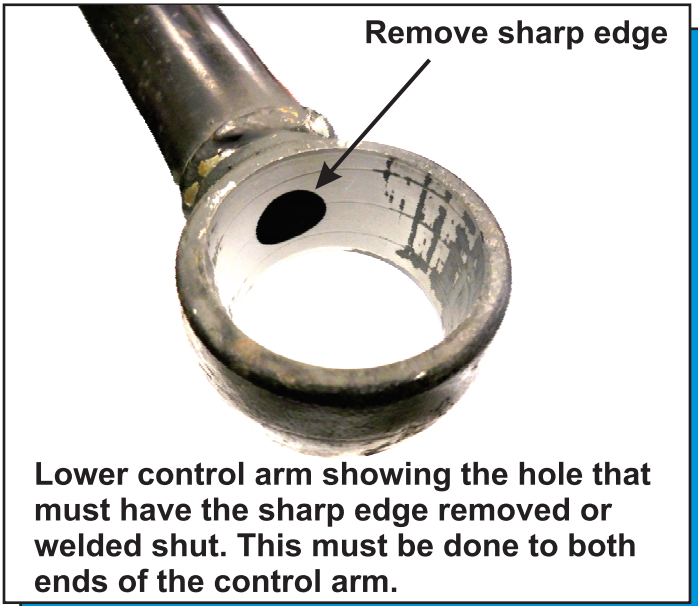


Fig. 2

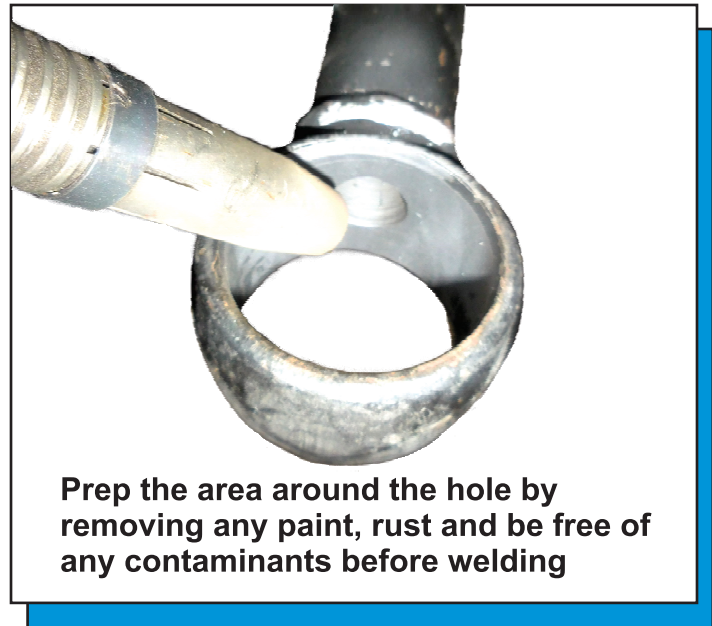


Fig. 3



Fig.4

