

## Lower Arm Bushing (60.35.33)

### Special Service Tools

**204-536/1**

E55144

Receiver front lower arm front bush  
204-536/1

**204-536/2**

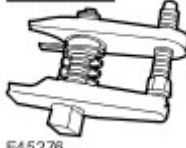
E55145

Remover front lower arm front bush  
204-536/2

**204-536/3**

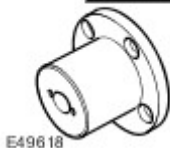
E55146

Installer front lower arm front bush  
204-536/3

**205-754A**

E45278

Ball joint separator  
205-754(LRT-54-027)

**204-506/1**

E49618

Halfshaft remover/replacer  
204-506/1(LRT-60-030/1)

**204-506/3**

E49620

Halfshaft remover/replacer  
204-506/3(LRT-60-030/3)

**204-506/5**

E49621

Retainers - halfshaft remover/replacer  
204-506/5(LRT-60-030/5)

**204-535/1**

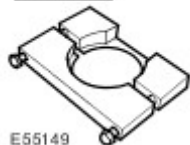
E55147

Receiver lower arm rear bush  
204-535/1

**204-535/2**

E55148

Remover lower arm rear bush  
204-535/2

**204-535/4**

E55149

Remover plate lower arm rear bush  
204-535/4

**204-535/3**

E55150

Installer lower arm rear bush  
204-535/3

204-535/5



E55151

Installer/depth setter lower arm rear bush  
204-535/5

## Removal

### NOTE :

The bushings must be replaced in pairs, LH and RH sides.

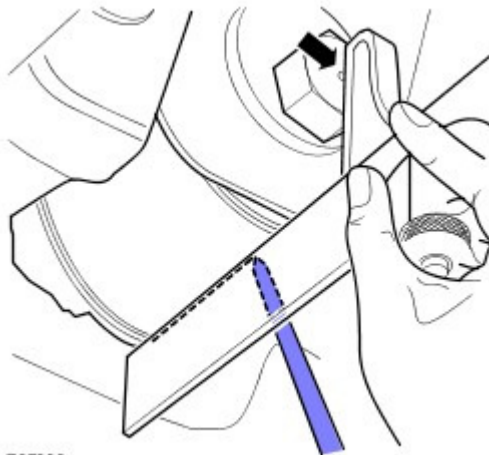
### NOTE :

Take note of the fitted position of the bush.

- 1 . Make sure that the tire pressures are correct and that the vehicle is at the correct ride height.

For additional information, refer to Wheels and tires, 204-04.

- 2 . Mark the position of the bushing in relation to the lower arm.
  - 1) Using a spirit level type engineers square, align through the center of the bolt head retaining the lower arm rear bush with a perpendicular drop.
  - 2) Align the rule of the engineers square along the lowest point on the circumference of the lower arm rear bush boss.
  - 3) Apply a piece of tape to the arm and mark a horizontal line along the underside of the lower arm rear bush boss (parallel with the bush axis).
  - 4) Make sure that the process is carried out on both right-hand side and left-hand side.



E97998

- 3 .

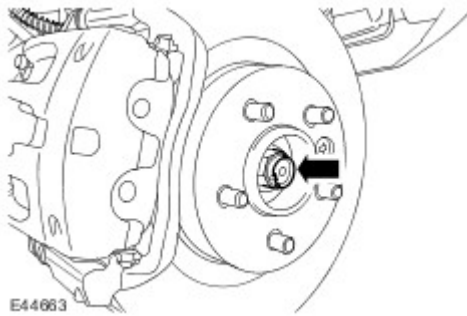


**WARNING : Do not work on or under a vehicle supported only by a jack. Always support the vehicle on safety stands.**

Raise and support the vehicle.

- 4 . Remove the wheels and tires.
- 5 . Remove the RH lower arm.  
For additional information, refer to Front suspension, 204-01.
- 6 . Remove the halfshaft retaining nut.

▶ Discard the nut.



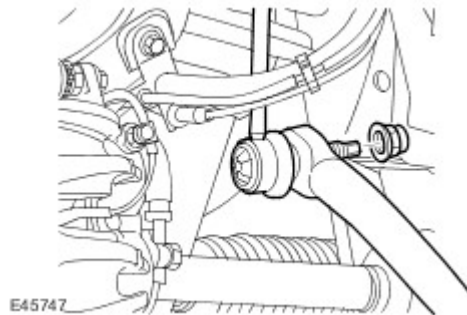
7.



**CAUTION : Use a wrench on the hexagon provided to prevent the ball joint rotating.**

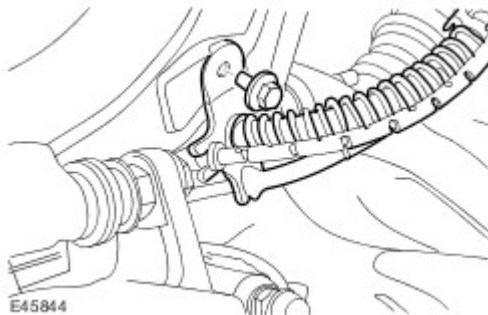
Disconnect the LH stabilizer bar link.

▶ Remove and discard the nut.



8 . Release the brake hose bracket from the wheel knuckle.

▶ Remove the bolt.



9 . Loosen the tie-rod end ball joint retaining nut.

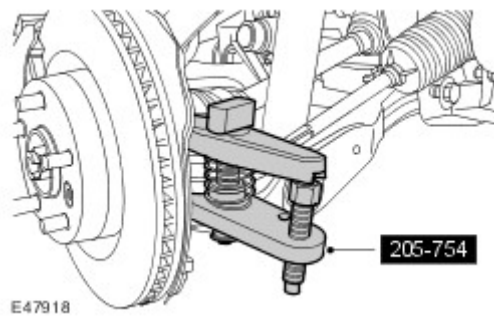
10.



**CAUTION : Make sure the ball joint seal is not damaged. A damaged seal will lead to the premature failure of the joint.**

Using the special tool, release the tie-rod end ball joint from the wheel knuckle.

▶ Discard the nut.



11 .



**CAUTION : To prevent the wheel knuckle falling outwards and disconnection of the halfshaft inner joint, support the wheel knuckle.**

Loosen the upper arm retaining nut.

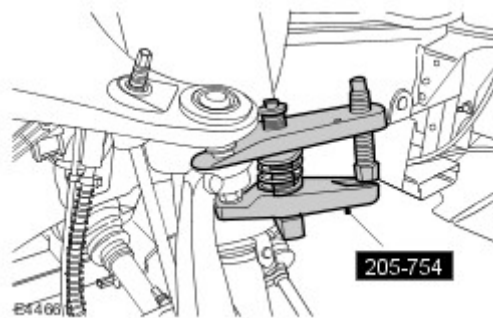
12 .



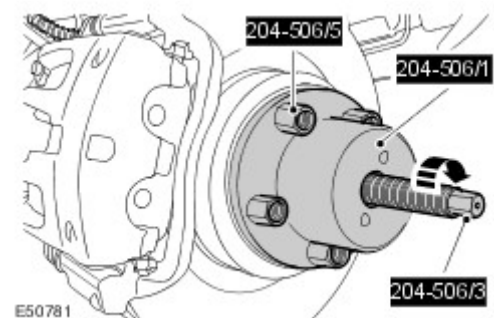
**CAUTION : Make sure the ball joint seal is not damaged. A damaged seal will lead to the premature failure of the joint.**

Using the special tool, release the upper arm ball joint.

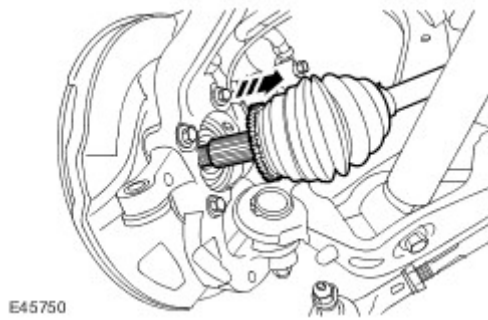
▶ Remove and discard the retaining nut.



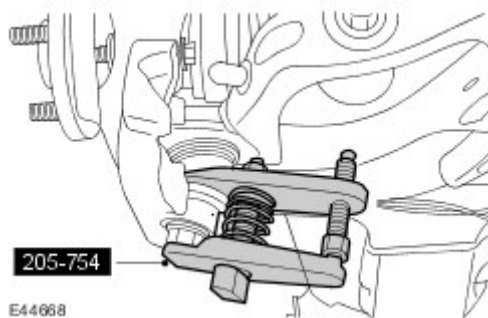
13 . Using the special tools, release the halfshaft from the wheel hub.



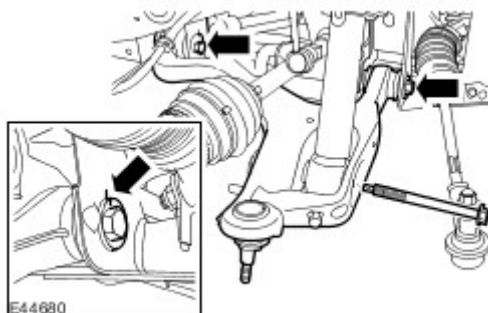
14 . Release the halfshaft from the wheel knuckle.



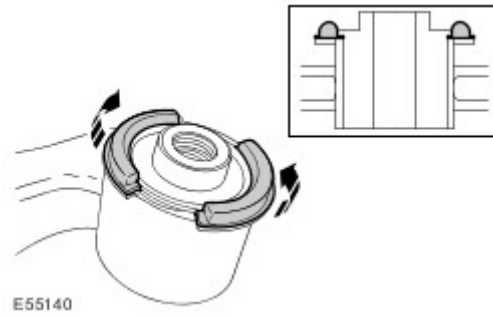
- 15 . Secure the halfshaft clear of the lower arm.
- 16 . Remove the lower ball joint retaining nut.
- 17 . Using the special tool, release the lower ball joint from the steering knuckle.



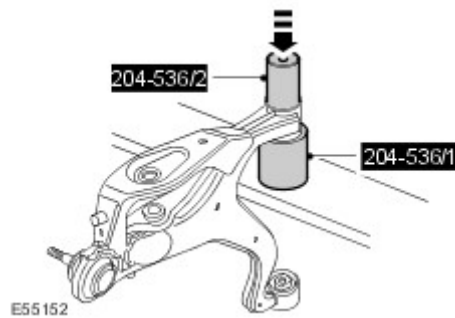
- 18 . Loosen the 2 lower arm bolts.
  - ▶ Mark the position of the bolts in relation to the chassis brackets.
- 19 . Disconnect the shock absorber and spring assembly from the lower arm.
  - ▶ Remove the LH retaining bolt.
- 20 . Remove the LH lower arm.



- 21 . Note the position of the bushing in relation to the lower arm.
- 22 .
  - ⚠ **CAUTION : The bush flanges need to be removed to allow bush removal.**
  - Remove the lower arm front bushing flanges.

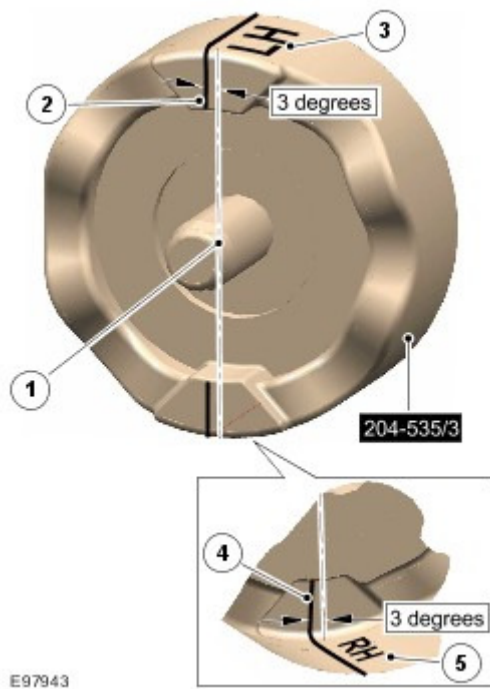


23 . Using the special tools, remove and discard the lower arm front bushings.

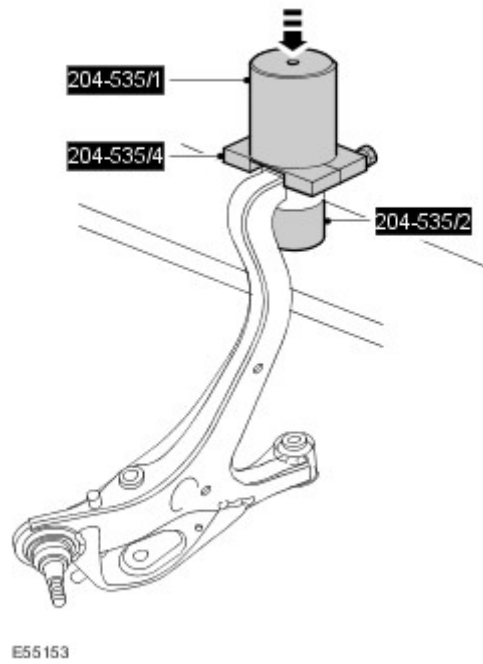


24 . Apply alignment guide lines to installer tool (204-535/3).

- 1) Mark center line on installer tool.
- 2) Mark line across top surface 3 degrees to the left of center line.
- 3) Mark 'LH' on top surface.
- 4) Mark line across bottom surface 3 degrees to the left of the center line.
- 5) Mark 'RH' on bottom surface.



25 . Using the special tools, remove and discard the lower arm rear bushings.



## Installation

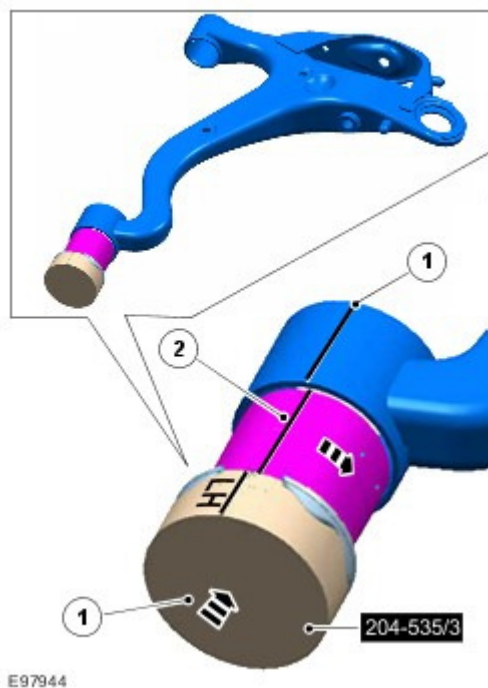
1.



**CAUTION : Make sure the bush is correctly aligned.**

Mark the position of the bushing in relation to the lower arm.

- 1) Make sure the correct marked side line 'RH' or 'LH' on the special tool (204-535/3) is aligned with the scribed line on the RH or LH bush to be installed.
- 2) Extend the line from the installer tool onto the bush using a marker pen. Using the marked line, align the bush to the lower arm before installing the bush.



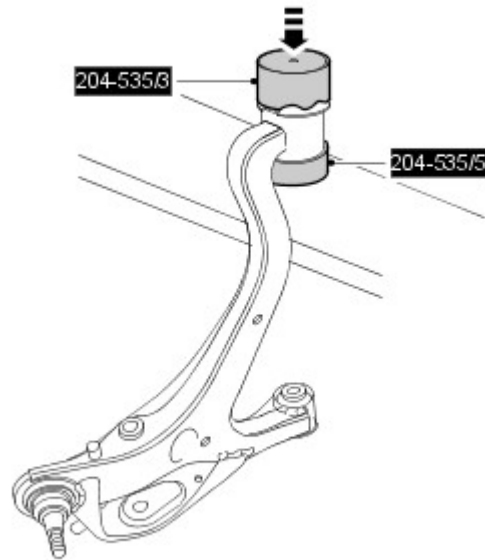


2.



**CAUTION : Make sure the correct special tool is used to install the bushings to the correct depth.**

Using the special tools, install the lower arm rear bushings.



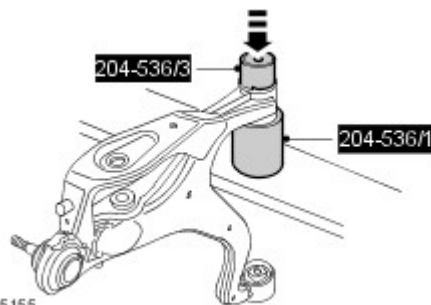
E55154

3.



**CAUTION : Make sure the bush is correctly aligned.**

Using the special tools, install the lower arm front bushings



E55155

4 . Install the LH lower arm.

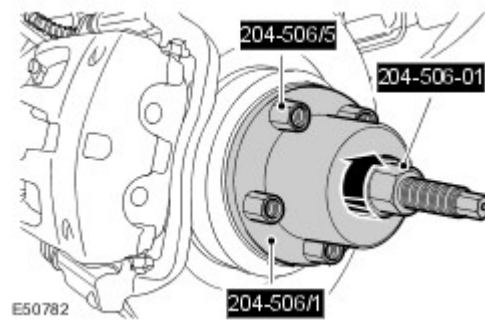
▶ Fit the bolts but do not fully tighten at this stage.

5 . Connect the shock absorber and spring assembly to the lower arm.

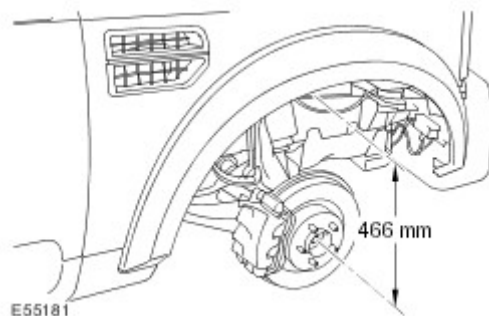
▶ Tighten the nut and bolt to 300 Nm (221 lb.ft).

6 . Release the halfshaft.

7 . Using the special tools, install the halfshaft in the wheel hub.



- 8 . Connect the upper arm and wheel knuckle.
  - ▶ Install a new nut and tighten to 70 Nm (52 lb.ft).
- 9 . Secure the stabilizer bar link.
  - ▶ Tighten the nut to 115 Nm (85 lb.ft).
- 10 . Connect the tie-rod end ball joint.
  - ▶ Install a new nut and tighten to 76 Nm (56 lb.ft).
- 11 . Install a new halfshaft retaining nut and lightly tighten.
- 12 . Secure the brake hose retaining bracket to the wheel knuckle.
  - ▶ Tighten the bolt to 25 Nm (18 lb.ft).
- 13 . Secure the LH stabilizer link.
  - ▶ Tighten the nut to 115 Nm (85 lb.ft).
- 14 . Tighten the halfshaft retaining nut to 350 Nm (258 lb.ft).
  - ▶ Stake the nut to the halfshaft.
- 15 . Set the height distance between the centre of the halfshaft end and the edge of the fender trim to 466 mm (18.34").



- 16 . Tighten the lower arm bolts to 275 Nm (203 lb.ft).
  - ▶ Align the bolts to the marks made previously.
- 17 . Install the RH lower arm.
  - For additional information, refer to Front suspension, 204-01.
- 18 . Install the wheels and tires.
  - ▶ Tighten the wheel nuts to 140 Nm (103 lb.ft).
- 19 . Carry out the wheel alignment procedure.

