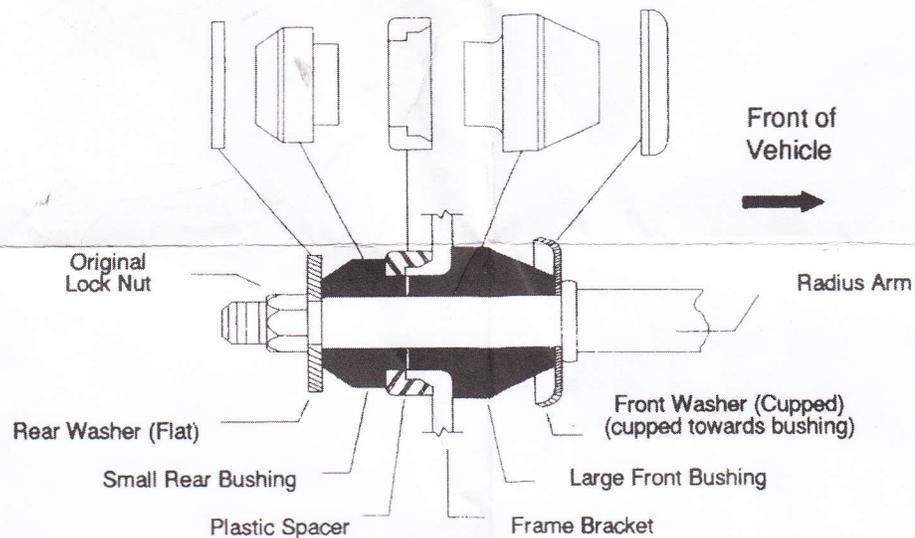


# INSTALLATION INSTRUCTIONS FOR RADIUS ARM BUSHING ASSEMBLY

**CAUTION:** Proper service and repair procedures are essential for safe and reliable installation of chassis parts and require experience and tools specially designed for the purpose. These parts **MUST** be installed by a qualified mechanic, otherwise an unsafe vehicle and/or personal injury could result.



**IMPORTANT: FRAME BRACKET MUST BE REPLACED IF WORN OR BENT AT LIP.**

## For Riveted-On Type Radius Arm Bushing Bracket:

1. Raise the front-end of vehicle and disconnect shock absorber from bracket on radius arm.
2. Remove the spring upper retainer attaching bolt from top of spring upper seat and remove retainer.
3. ~~Remove the nut attaching spring lower retainer to lower seat and axle retainer. Spring can now be removed.~~
4. Remove the spring lower seat from radius arm, then remove bolt and nut attaching arm to axle and shim if equipped.
5. Disconnect tie rods from steering knuckles, being careful not to damage rubber dust boots.
6. Remove lock nut, rear bushing, washer and spacer ring from frame bracket end of radius arm. Arm can now be removed by moving axle forward so the radius arm can be pulled out through hole in frame bracket. Remove front bushing and washer still on the radius arm.
7. Install new bushings, washers and spacer ring supplied as illustrated. Install front washer (cupped towards bushing), and large front bushing onto radius arm and position through hole in frame bracket. Place new spacer ring on rear side of bracket and install rear bushing on arm. Use large flat washer supplied next to rear bushing and install the original lock nut on end of radius arm, but do not tighten nut at this time. **Note: On vehicles equipped with a heat shield over the rear insulator, the heat shield must be reused.**
8. Attach tie rods to steering knuckles and torque original slotted nuts to 80 ft. lbs. Lock with cotter pins.
9. Position shim, if equipped, on radius arm and torque radius arm axle attaching bolts and nuts to 200 ft. lbs. for 1/2 and 3/4 ton vehicles, or to 250 ft. lbs. for 1 ton vehicles. Install the spring lower seat and place spring and insulator in correct position on seat. Position spring lower retainer seat and torque original nut to 55 ft. lbs.
10. Install spring upper retainer and torque original attaching bolts to 20 ft. lbs.
11. Torque lock nut on frame bracket end of radius arm to 100 ft. lbs. Install shocks to radius arm bracket and torque bolt and nut to 50 ft. lbs.
12. Lower vehicle to floor and check front-end alignment.

## For Bolted-On Type Radius Arm Bushing Bracket:

1. Remove lock nut, rear bushing, washer and spacer ring from bracket end of radius arm.
2. Remove bracket to frame attaching bolts and remove bracket, front bushing and front washer from radius arm.
3. Install new bushings, washer and spacer ring supplied as illustrated and discussed in Step # 7 above.
4. Attach bracket to frame using original bolts and nuts. Torque to 70 ft. lbs.
5. Torque original lock nut on frame bracket end of radius arm to 100 ft. lbs.
6. Check front-end alignment.

**NOTE:** The parts contained in this kit are designed to replace the worn or non-functional original equipment parts in the vehicles as produced by the car factory. These parts are not designed for installation on vehicles where the suspension and/or steering systems have been modified for racing, competition or any other purpose.